

## HIGH SPEED STEEL - TITANIUM NITRIDE COATED THREAD FORMING TAPS

**ICS**

**WIS**

**SPECIAL PURPOSE**

**GROUND THREAD**

**CLASS 2B  
FIT**



**PLUG & BOTTOMING  
CHAMFER**

Thread Forming Taps are designed for cold forming threads in ductile materials such as aluminum, copper, brass, zinc, low carbon steels, and 302, 303 stainless steels. They displace metal rather than remove it, therefore, countersinking before or after tapping is recommended.

SIZE	THREADS PER INCH		LIMIT NO.	PRICE EACH	
	NC	NF		HSS	TIN COATED
				TFT	TFTT
* 0	-	80	H2	\$18.94	\$21.18
* 1	64	72	H2	18.94	21.18
* 2	56	64	H2	18.94	21.18
* 3	48	56	H2	18.94	21.18
4	40	48	H3	17.36	19.60
5	40	-	H3	17.36	19.60
6	32	40	H3	14.40	16.64
8	32	36	H3	14.40	18.42
10	24	32	H4	14.40	18.42
12	24	28	H4	14.12	18.16
1/4	20	28	H4	14.12	18.16
5/16	18	24	H5	16.78	22.94
3/8	16	24	H5	18.94	25.10
7/16	14	20	H5	29.64	35.80
1/2	13	20	H5	33.50	39.66
9/16	12	18	H7	38.40	49.60
5/8	11	18	H7	47.22	58.42
3/4	10	16	H7	62.28	74.60

TAP DRILL SIZE APPROX. 75% THREAD	
NC	NF
-	M1.35
#52	M1.65
M1.95	5/64
M2.25	#43
#39	#38
#34	-
M3.10	1/8
M3.75	#25
M4.30	M4.40
#10	M5.00
M5.70	M5.80
M7.20	M7.40
M8.70	M9.00
"X"	"Z"
M11.70	M12.00
33/64	M13.50
37/64	19/32
M17.75	23/32

\* Available in Bottoming Chamfer only.