

221D

**HIGH SPEED STEEL**

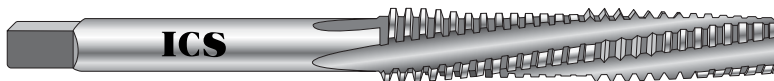
**TANDEM "ACME" THREAD (SPIRAL FLUTE) TAPS**

**ICS USA**

**SPECIAL PURPOSE**

**GROUND THREAD**

**ROUGHING AND FINISHING**



**CLASS 2G FIT**

High Speed Steel Tandem Acme Thread Spiral Flute Taps are designed with a roughing and finishing section to produce threads from a 10° to 30° included angle in a single pass without a leadscrew. The last few threads on the roughing section act as a guide for the finishing section, which corrects the thread angles and size. Spiral Fluted Tandem Acme Thread Taps have continuous spiral flutes to lift and discharge chips in deep holes. They have black steam oxidized flutes to improve finish and produce a class 2G thread fit.

**Right Hand Thread Sizes (1/2" to 2" Dia.)**

ITEM NO.	THREAD SIZE	THREAD LENGTH	OVERALL LENGTH
TATS032-10	1/2 - 10	2-9/16	5
TATS040-08	5/8 - 8	3-3/16	6-1/4
TATS048-06	3/4 - 6	4-5/16	7-15/16
TATS048-08	3/4 - 8	4-15/16	7-15/16
TATS056-06	7/8 - 6	4-3/8	8-5/8
TATS100-05	1 - 5	5-1/4	10-1/8

CALL FOR PRICING

ITEM NO.	THREAD SIZE	THREAD LENGTH	OVERALL LENGTH
TATS108-05	1-1/8 - 5	5-1/4	10-3/4
TATS116-05	1-1/4 - 5	5-1/4	11-1/8
TATS124-04	1-3/8 - 4	5-7/8	12-1/4
TATS132-04	1-1/2 - 4	5-7/8	12-5/8
TATS200-04	2 - 4	6-1/2	14-7/8

CALL FOR PRICING

**Left Hand Thread Sizes (1/2" to 2" Dia.)**

ITEM NO.	THREAD SIZE	THREAD LENGTH	OVERALL LENGTH
TATSL032-10	1/2 - 10	2-9/16	5
TATSL040-08	5/8 - 8	3-3/16	6-1/4
TATSL048-06	3/4 - 6	4-5/16	7-15/16
TATSL048-08	3/4 - 8	4-15/16	7-15/16
TATSL056-06	7/8 - 6	4-3/8	8-5/8
TATSL100-05	1 - 5	5-1/4	10-1/8

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ITEM NO.	THREAD SIZE	THREAD LENGTH	OVERALL LENGTH
TATSL108-05	1-1/8 - 5	5-1/4	10-3/4
TATSL116-05	1-1/4 - 5	5-1/4	11-1/8
TATSL124-04	1-3/8 - 4	5-7/8	12-1/4
TATSL132-04	1-1/2 - 4	5-7/8	12-5/8
TATSL200-04	2-4	6-1/2	14-7/8

CALL FOR PRICING

- Special Acme Taps and other translating thread taps can be made to your requirements. Consult factory for price and and delivery.
- Acme Hexagon Rethreading Dies are also available.

**TANDEM "ACME" TAP DRILL SIZES AND MAXIMUM DEPTH OF NUT**

ACME TAP THREAD SIZE	ACME TAP DRILL SIZE	MAX. DEPTH OF NUT	
		BRONZE AND STEEL	BRASS AND CAST IRON
1/4 - 16	#10	1	1-1/2
5/16 - 18	17/64	1	1-1/2
3/8 - 12	N	1	1-1/2
7/16 - 12	U	1	1-1/2
1/2 - 10	Z	1	1-1/2
5/8 - 8	13.00MM	1-1/4	1-7/8
3/4 - 6	39/64	1-1/2	2-1/4
3/4 - 8	41/64	1-1/2	2-1/4

ACME TAP THREAD SIZE	ACME TAP DRILL SIZE	MAX. DEPTH OF NUT	
		BRONZE AND STEEL	BRASS AND CAST IRON
7/8 - 6	47/64	1-3/4	2-5/8
1 - 5	49/64	2	3
1-1/8 - 5	24.00MM	2-1/4	3-5/8
1-1/4 - 5	1-1/64	2-1/2	3-3/4
1-3/8 - 5	1-3/32	2-3/4	4-1/8
1-1/2 - 5	32.50MM	3	4-1/2
2 - 4	45.00MM	3	4-1/2