

HIGH SPEED STEEL TAPS

TAP BLANK STYLE I

TAP BLANK STYLE II

CHAMFER LEAD FOR APPLICATION

MACHINE TAPS

FORM A
LONG : FOR SHORT THROUGH HOLES

FORM B
MEDIUM: WITH SPIRAL POINT FOR ALL TROUGH HOLES AND DEEP TAPPING HOLES

FORM C
SHORT: FOR BLIND HOLES AND GENERALLY FOR ALUMINIUM AND BRASS

FORM D
MEDIUM: FOR SHORT THROUGH HOLES

FORM E
VERY SHORT: FOR SHORT BLIND HOLES

HAND TAPS

SET OF 3 (COARSE) : TAPER , SECOND, BOTTOMING

SET OF 2 (FINE PITCH) : TAPER AND BOTTOMING

METRIC : 6H, OTHER OPTIONS: 4H, 6G, 7G
INCHES : 2B, OTHER OPTIONS: 3B, 1B

GENERAL DIMENSIONS: AS IS STANDARDS

TAP SPECIFICATION			OVERALL LENGTH	THREAD LENGTH	LENGTH UPTO NECK	SHANK DIAMETER	LENGTH OF SQUARE	SQUARE	BLANK STYLE
METRIC	UNC/UNF	BSW/BSF	L1	L2	L3	d2	L4	SW	
STANDARD: AS PER IS 6175 PART II, SHORT SHANK TAPS									
M3 X 0.50	No.4	1/8"	48	11	18	3.15	5	2.5	I
	No.5								I
M3.5 X 0.60	No.6		50	13	20	3.55	5	2.8	I
M4 X 0.70			53	13	21	4.0	6	3.15	I
	No.8		53	13	21	4.5	6	3.55	I
M5 X 0.80	No.10	3/16"	58	16	25	5.0	7	4.0	I
M6 X 1.0	1/4"	1/4"	66	19	30	6.3	8	5.0	I
M8 X 1.25	5/16"	5/16"	72	22	35	8.0	9	6.3	I
M10 X 1.5	3/8"	3/8"	80	24	39	10.0	11	8.0	I
	3/8" UNF	3/8" BSF	76	20	34	10.0	11	8.0	I
STANDARD: AS PER IS 6175 PART III, SHORT SHANK TAPS									
M4 X 0.70			53	13		3.15	5	2.5	II
M5 X 0.80	No.10		58	16		4.0	6	3.15	II
M6 X 1.0	1/4"		66	19		4.5	6	3.55	II
M8 X 1.25	5/16"	5/16"	72	22		6.3	8	5.0	II
M10 X 1.5	3/8"	3/8"	80	24		8.0	9	6.3	II
M12 X 1.5	1/2 "	1/2"	89	29		9.0	10	7.1	II
M14 X 1.5	9/16"	9/16"	95	30		11.2	12	9.0	II
M16 X 2	5/8"	5/8"	102	32		12.5	13	10.0	II

HIGH SPEED STEEL TAPS

STANDARD: AS PER IS 7821 / ISO 2283, LONG SHANK TAPS

M6 X 1.0	1 / 4"	1 / 4"	89	19		4.5	6	3.55	II
M8 X 1.25	5/16"	5/16"	97	22		6.3	8	5.0	II
M10 X 1.5	3/8"	3/8"	108	24		8.0	9	6.3	II
M12 X 1.5	1 / 2 "	1 / 2 "	119	29		9.0	10	7.1	II
M14 X 1.5	9/16"		127	30		11.2	12	9.0	II
M16 X 2	5/8"		137	32		12.5	13	10	II

GENERAL DIMENSIONS: AS DIN 371 STANDARDS

TAP SPECIFICATION			OVERALL LENGTH	THREAD LENGTH	LENGTH UPTO NECK	SHANK DIAMETER	LENGTH OF SQUARE	SQUARE	BLANK STYLE
METRIC	UNC/UNF	BSW/BSF	L1	L2	L3	d2	L4	SW	
STANDARD: AS PER DIN 371 SHORT SHANK TAPS									
M3 X 0.50	No.5	1/8"	56	11	18	3.5	6	2.7	I
	No.6		56	12	18	3.5	6	3.0	I
M4 X 0.7	No.8	5/32"	63	13	21	4.0	6	3.4	I
M5 X 0.8	No.12		70	16	25	4.5	8	4.9	I
	No.10	3/16"	70	15	25	6.0	8	4.9	I
M6 X 1			80	19	30	6.0	8	4.9	I
	1 / 4"	1 / 4"	80	17	30	6.0	8	5.5	I
M8 X 1.25			90	22	35	7.0	9	6.2	I
	5/16"	5/16"	90	20	35	8.0	9	6.2	I
M10 X 1.5			100	24	39	10.0	11	8	I
	3/8"	3/8"	100	22	39	9.0	11	7.0	I
STANDARD: AS PER DIN 376 LONG SHANK TAPS									
M3 X 0.50			56	11		2.2			II
M4 X 0.70			63	13		2.8	5.0	2.1	II
M5 X 0.80			70	16		3.5	6.0	2.7	II
M6 X 1.0			80	19		4.5	6.0	3.4	II
M8 X 1.25			90	22		6.0	8.0	4.9	II
M10 X 1.25			100	24		7.0	8.0	5.5	II
M12 X 1.75			110	29		9.0	10.0	7.0	II
M14 X 2			110	30		11.0	12.0	9.0	II
M16 X 2			110	32		12.0	12.0	9.0	II

TAP ORDERING FORMAT

TYPE	APPLICATION	SPEC	FLUTE	FORM	TOLERANCE	COATING	MATERIAL
IS 6175PART II <i>OR</i> IS 6175PART III	HAND TAP (COARSE) SET OF 3 <i>OR</i>	REFER TABLES ABOVE	STANDARD <i>OR</i>	FOR SINGLE	FOR METRIC	BRIGHT TiN TiCN TiAIN	M2 M35 M42 PM
IS 7821 <i>OR</i> DIN 371 <i>OR</i> DIN 376	HAND TAP (FINE) SET OF 2 <i>OR</i> SERIAL TAP <i>OR</i> SINGLE TAP		SPIRAL POINT <i>OR</i>	TAP ONLY	4H 6H 6G 7G		
			SPIRAL FLUTE <i>OR</i>	FORM A <i>OR</i>			
			SPIRAL FLUTE WITH SPIRAL POINT	FORM B <i>OR</i> FORM C <i>OR</i> FORM D	FOR INCHES 3B 2B 1B		