

Taps, Dies and Threading

Yellow Colour Band Taps

Spiral Point Plug Style



CUTTING CONDITIONS

Material	Material Sub-Group	Condition	Hardness (HRC)	Cutting Speed (FPM)
Stainless Steel	200 Series	annealed	<28	20-35
	300 Series	annealed	<28	20-35
	17-4, 15-5	annealed	<25	15-25
	AM286	annealed	<25	15-25
Tool Steel	400 Series	annealed	<29	20-35
	01, A-2, D-2, H-13, P-20	annealed	<35	15-25
Medium Carbon Steel	1030, 1035, 1038, 1040, 1045, 1050	normalized	<28	20-40
Alloyed High Carbon Steel	1065, 1070, 1080, 1090, 1095, 1561, 1572	normalized	<32	20-30
High Strength Steel	4140, 4340	normalized	<32	20-30
Titanium	commercially pure	annealed	<32	15-30
Aluminum	cast, wrought	-	-	30-90

Machine Screw Sizes

Spiral Point Plug Style

Size	Threads Per Inch UNC	Threads Per Inch UNF	No. of Flutes	Thread Limit	Overall Length (Inch)	Thread Length (Inch)	Code
4	40	-	2	GH2	1-7/8	0.335	915060
6	32	-	3	GH3	2	0.413	915062
8	32	-	3	GH3	2-1/8	0.453	915066
10	24	-	3	GH3	2-3/8	0.531	915068
12	24	-	3	GH3	2-3/8	0.531	915072
6	-	40	3	GH3	2	0.413	915064
10	-	32	3	GH3	2-3/8	0.531	915070

Fractional Sizes

Spiral Point Plug Style

Size (Inch)	Threads Per Inch UNC	Threads Per Inch UNF	No. of Flutes	Thread Limit	Overall Length (Inch)	Thread Length (Inch)	Code
1/4	20	-	3	GH3	2-1/2	0.591	915074
5/16	18	-	3	GH3	2-23/32	0.669	915078
3/8	16	-	3	GH3	2-15/16	0.748	915082
7/16	14	-	3	GH3	3-5/32	0.866	915086
1/2	13	-	3	GH3	3-3/8	0.984	915090
5/8	11	-	3	GH3	3-13/16	1.083	915094
3/4	10	-	3	GH3	4-1/4	1.201	915098
7/8	9	-	3	GH4	4-11/16	1.339	915102
1	8	-	3	GH4	5-1/8	1.496	915106
1-1/8	7	-	4	GH4	5-7/16	1.610	915110
1-1/4	7	-	4	GH4	5-3/4	1.610	915114
1-3/8	6	-	4	GH4	6-1/16	1.900	915118
1-1/2	6	-	4	GH4	6-3/8	2.000	915122
1/4	-	28	3	GH3	2-1/2	0.591	915076
5/16	-	24	3	GH3	2-23/32	0.669	915080
3/8	-	24	3	GH3	2-15/16	0.748	915084
7/16	-	20	3	GH3	3-5/32	0.866	915088
1/2	-	20	3	GH3	3-3/8	0.984	915092
5/8	-	18	3	GH3	3-13/16	1.083	915096