



Blue Colour Band Taps

Spiral Point Plug & Spiral Flute Bottoming Styles



Metric Sizes (continued)

Size & Pitch	Thread Limit	Overall Length (Inch)	Thread Length (Inch)	Spiral Point		Spiral Flute	
				No. of Flutes	Code	No. of Flutes	Code
M8 x 1.25	D5	2-23/32	0.688	3	915481	3	915431
M10 x 1.25	D5	2-15/16	0.750	3	915487	3	915437
M10 x 1.5	D6	2-15/16	0.750	3	915485	3	915435
M12 x 1.25	D5	3-3/8	0.938	3	915491	3	915441
M12 x 1.75	D6	3-3/8	0.938	3	915489	3	915439
M14 x 1.5	D6	3-19/32	1.000	3	915495	3	915445
M14 x 2	D7	3-19/32	1.000	3	915493	3	915443
M16 x 1.5	D6	3-13/16	1.094	3	915499	4	915449
M16 x 2	D7	3-13/16	1.094	3	915497	3	915447
M18 x 1.5	D6	4-1/32	1.094	3	915503	4	915453
M18 x 2.5	D7	4-1/32	1.094	3	915501	4	915451
M20 x 1.5	D5	4-15/32	1.219	3	915507	4	915457
M20 x 2.5	D6	4-15/32	1.219	3	915505	4	915455
M22 x 1.5	D6	4-11/16	1.344	3	915511	4	915461
M22 x 2.5	D6	4-11/16	1.344	3	915509	4	915459
M24 x 1.5	D5	4-29/32	1.344	3	915515	-	-
M24 x 3	D7	4-29/32	1.344	3	915513	-	-

TAPS, DIES & THREADING

Yellow Colour Band Taps

Spiral Point Plug & Spiral Flute Bottoming Styles



Cutting Conditions

Material	Material Sub-Group	Condition	Hardness (HRC)	Cutting Speed (FPM)
Stainless Steel	200 Series	annealed	<28	20-35
	300 Series		<28	20-35
	17-4, 15-5		<25	15-25
	AM286		<25	15-25
	400 Series		<29	20-35
Tool Steel	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

Inch Sizes

Size	Spiral Point					Spiral Flute				
	Overall Length (Inch)	No. of Flutes	Thread Length (Inch)	Thread Limit	Code	Overall Length (Inch)	No. of Flutes	Thread Length (Inch)	Thread Limit	Code
4-40	1-7/8	2	0.335	GH2	915060	1-7/8	2	0.236	GH2	915000
6-32	2	3	0.413	GH3	915062	2	3	0.276	GH2	915002
6-40	2	3	0.413	GH3	915064	2	3	-	-	-
8-32	2-1/8	3	0.453	GH3	915066	2-1/8	3	0.276	GH2	915004