



## Yellow Colour Band Taps

Spiral Point Plug & Spiral Flute Bottoming Styles



Metric Sizes (continued)

Size & Pitch	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
M12 x 1.75	3-3/8	3	0.937	D6	915383	3-3/8	3	0.591	D6	915321
M14 x 1.5	3-19/32	3	1.000	D6	915389	3-19/32	3	0.709	D6	915327
M14 x 2	3-19/32	3	1.000	D7	915387	3-19/32	3	0.709	D7	915325
M16 x 1.5	3-13/16	3	1.093	D6	915393	3-13/16	3	0.551	D6	915331
M16 x 2	3-13/16	3	1.093	D7	915391	3-13/16	3	0.709	D7	915329
M18 x 1.5	4-1/32	3	1.093	D6	915397	4-1/32	4	0.551	D6	915335
M18 x 2.5	4-1/32	3	1.093	D7	915395	4-1/32	4	0.787	D7	915333
M20 x 1.5	4-1/4	3	1.201	D5	915401	4-1/32	4	0.551	D5	915339
M20 x 2.5	4-1/4	3	1.201	D6	915399	4-1/32	4	0.701	D6	915337
M22 x 1.5	4-11/16	3	1.343	D6	915405	4-11/16	4	0.551	D6	915343
M22 x 2.5	4-11/16	3	1.343	D6	915403	4-11/16	4	0.787	D6	915341
M24 x 1.5	4-29/32	3	1.496	D5	915409	4-11/16	4	0.551	D5	915347
M24 x 3	4-29/32	3	1.496	D7	915407	4-11/16	4	0.787	D7	915345
M27 x 1.5	5-1/8	3	1.540	D7	915413	5-1/8	4	0.690	D7	915351
M27 x 3	5-1/8	3	1.540	D7	915411	5-1/8	4	1.105	D7	915349
M30 x 1.5	5-1/8	3	1.540	D7	915417	5-7/16	4	0.690	D7	915355
M30 x 3.5	5-1/8	3	1.540	D7	915415	5-7/16	4	1.250	D7	915353

TAPS, DIES & THREADING

## Red Colour Band Taps



Spiral Point Plug & Spiral Flute Bottoming Styles



P-HSS	UNC UNF	M	60° P	STEAM OXIDE
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Cutting Conditions

Material	Material Sub-Group	Condition	Hardness (HRC)	Cutting Speed (FPM)
Stainless Steel	17-4PH, 15-5, 17-7PH, AM350	hardened	<48	12-20
Tool Steel	O1, A-2, D-2, H-13, P-20	hardened	<48	10-20
High Strength Steel	4140, 4340, 50100	hardened	<48	15-20
Nickel Alloys	inconel, hastaloy, waspaloy, astraloy, rene, monel	annealed or hardened	<42	5-20
Titanium	6 AL 4	annealed or hardened	<42	8-15

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	H2	915258	1-7/8	2	0.236	H2	915220
5-40	1-15/16	3	0.374	H2	915260	1-15/16	3	-	-	-
6-32	2	3	0.413	H3	915262	2	3	0.276	H3	915222
8-32	2-1/8	3	0.453	H3	915264	2-1/8	3	0.276	H3	915224
10-24	2-3/8	3	0.531	H3	915266	2-3/8	3	0.354	H3	915226
10-32	2-3/8	3	0.531	H3	915268	2-3/8	3	0.276	H3	915228
1/4-20	2-1/2	3	0.591	H3	915270	2-1/2	3	0.433	H3	915230
1/4-28	2-1/2	3	0.591	H3	915272	2-1/2	3	0.354	H3	915232
5/16-18	2-23/32	3	0.669	H3	915274	2-23/32	3	0.472	H3	915234
5/16-24	2-23/32	3	0.669	H3	915276	2-23/32	3	0.394	H3	915236