

SHORT MACHINE TAPS

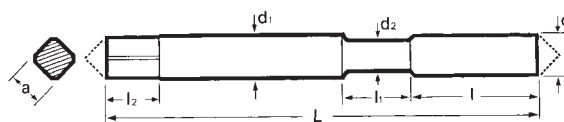
Metric Coarse

BS 949 ISO 529



| | Range | Tap Tolerance | Finish |
|---------------------------------|--------|--------------------|---------|
| Straight Flute | | | |
| 60 000 | M1-M60 | Class 2 for 6H fit | Bright |
| 60 007 | M1-M60 | Class 2 for 6H fit | P1 Blue |
| 60 005 | M3-M16 | Class 2 for 6H fit | TiN |
| Straight Flute Left Hand | | | |
| 60 030 | M3-M24 | Class 2 for 6H fit | Bright |

Straight Flute Taps are available with – Taper, Second, and Bottoming leads.



| Nominal dia | Pitch | Thread length max | Overall length | Shank dia | Square a/f | Recess | Tap drill size | 60 000 | 60 007 | 60 005 | 60 030 | | |
|-------------|-------|-------------------|----------------|-------------------|------------|-------------------|---------------------------|---|-------------------------------|---|--|---|---|
| mm d | mm | mm l | mm L | mm d ₁ | mm a | mm l ₂ | 75% to 80% full thread mm | 60 000 Straight Flute Number of Flutes Bright | 60 007 Straight Flute P1 Blue | 60 005 Straight Flute TiN No. of Flutes | 60 030 Straight Flute Left H'nd Bright | | |
| M1 | 0.25 | 5.5 | 38.5 | 2.5 | 2.0 | 4 | - | 4.5 | 0.75 | 3 | 3 | * | - |
| M1.2 | 0.25 | 5.5 | 38.5 | 2.5 | 2.0 | 4 | - | 4.5 | 0.95 | 3 | 3 | * | - |
| M1.4 | 0.3 | 7 | 40 | 2.5 | 2.0 | 4 | - | 5 | 1.10 | 3 | 3 | * | - |
| M1.6 | 0.35 | 8 | 41 | 2.5 | 2.0 | 4 | - | 5 | 1.25 | 3 | 3 | * | - |
| M2 | 0.4 | 8 | 41 | 2.5 | 2.0 | 4 | - | 5.5 | 1.60 | 3 | 3 | * | - |
| M2.5 | 0.45 | 9.5 | 44.5 | 2.8 | 2.24 | 5 | - | 6 | 2.05 | 3 | 3 | * | - |
| M3 | 0.5 | 16 | 48 | 3.15 | 2.5 | 5 | - | - | 2.50 | 3 | 3 | 3 | 3 |
| M3.5 | 0.6 | 19 | 50 | 3.55 | 2.8 | 5 | - | - | 2.90 | 3 | 3 | 3 | - |
| M4 | 0.7 | 13 | 53 | 4.0 | 3.15 | 6 | 2.80 | 8 | 3.30 | 3 | 3 | 3 | 3 |
| M4.5 | 0.75 | 13 | 53 | 4.5 | 3.55 | 6 | 3.15 | 8 | 3.70 | 3 | 3 | 3 | - |
| M5 | 0.8 | 16 | 58 | 5.0 | 4.0 | 7 | 3.55 | 9 | 4.20 | 3 | 3 | 3 | 3 |
| M6 | 1.0 | 19 | 66 | 6.3 | 5.0 | 8 | 4.50 | 11 | 5.00 | 3 | 3 | 3 | 3 |
| M7 | 1.0 | 19 | 66 | 7.1 | 5.6 | 8 | 5.30 | 11 | 6.00 | 3 | 3 | 3 | - |
| M8 | 1.25 | 22 | 72 | 8.0 | 6.3 | 9 | 6.00 | 13 | 6.80 | 3 | 3 | 3 | 3 |
| M9 | 1.25 | 22 | 72 | 9.0 | 7.1 | 10 | 7.10 | 14 | 7.80 | 3 | 3 | 3 | - |
| M10 | 1.5 | 24 | 80 | 10.0 | 8.0 | 11 | 7.50 | 15 | 8.50 | 4 | 4 | 4 | 4 |
| M11 | 1.5 | 25 | 85 | 8.0 | 6.3 | 9 | | | 9.50 | 4 | 4 | 4 | - |
| M12 | 1.75 | 29 | 89 | 9.0 | 7.1 | 10 | | | 10.20 | 4 | 4 | 4 | 4 |
| M14 | 2.0 | 30 | 95 | 11.2 | 9.0 | 12 | | | 12.00 | 4 | 4 | 4 | 4 |
| M16 | 2.0 | 32 | 102 | 12.5 | 10.0 | 13 | | | 14.00 | 4 | 4 | 4 | 4 |
| M18 | 2.5 | 37 | 112 | 14.0 | 11.2 | 14 | | | 15.50 | 4 | 4 | * | 4 |
| M20 | 2.5 | 37 | 112 | 14.0 | 11.2 | 14 | | | 17.50 | 4 | 4 | * | 4 |
| M22 | 2.5 | 38 | 118 | 16.0 | 12.5 | 16 | | | 19.50 | 4 | 4 | * | 4 |
| M24 | 3.0 | 45 | 130 | 18.0 | 14.0 | 18 | | | 21.00 | 4 | 4 | * | 4 |
| M27 | 3.0 | 45 | 135 | 20.0 | 16.0 | 20 | | | 24.00 | 4 | 4 | * | - |
| M30 | 3.5 | 48 | 138 | 20.0 | 16.0 | 20 | | | 26.50 | 4 | 4 | * | - |
| M33 | 3.5 | 51 | 151 | 22.4 | 18.0 | 22 | | | 29.50 | 4 | 4 | * | - |
| M36 | 4.0 | 57 | 162 | 25.0 | 20.0 | 24 | | | 32.00 | 4 | 4 | * | - |
| M39 | 4.0 | 60 | 170 | 28.0 | 22.4 | 26 | | | 35.00 | 6 | 6 | * | - |
| M42 | 4.5 | 60 | 170 | 28.0 | 22.4 | 26 | | | 37.50 | 6 | 6 | * | - |
| M45 | 4.5 | 67 | 187 | 31.5 | 25.0 | 28 | | | 40.50 | 6 | 6 | * | - |
| M48 | 5.0 | 67 | 187 | 31.5 | 25.0 | 28 | | | 43.00 | 6 | 6 | * | - |
| M52 | 5.0 | 70 | 200 | 35.5 | 28.0 | 31 | | | 47.00 | 6 | 6 | * | - |
| M56 | 5.5 | 70 | 200 | 35.5 | 28.0 | 31 | | | 50.50 | 6 | 6 | * | - |
| M60 | 5.5 | 76 | 221 | 40.0 | 31.5 | 34 | | | 54.50 | 6 | 6 | * | - |

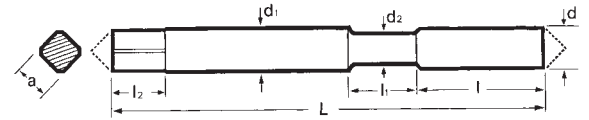
* Available to Special Order
Minimum quantities apply

SHORT MACHINE TAPS

Metric Coarse

BS 949 ISO 529

| | Range | Tap Tolerance | Finish |
|---------------------|--------|--------------------|---------|
| Spiral Point | | | |
| 60 010 | M1-M30 | Class 2 for 6H fit | P1 Blue |
| 60 018 | M3-M16 | Class 2 for 6H fit | Bright |
| 60 015 | M3-M16 | Class 2 for 6H fit | TiN |
| Spiral Flute | | | |
| 60 020 | M2-M30 | Class 2 for 6H fit | Bright |
| 60 027 | M2-M30 | Class 2 for 6H fit | P1 Blue |
| 60 025 | M3-M16 | Class 2 for 6H fit | TiN |



| Nom dia | Pitch | Thread length max | Overall length | Shank dia | Square a/f length | Recess dia | Recess length | Tap drill sizes 75% to 80% full thread | 60 010 | 60 018 | 60 015 | 60 020 | 60 027 | 60 025 | |
|---------|-------|-------------------|----------------|-------------------|-------------------|-------------------|-------------------|--|-------------------------------|-------------------------------|-------------------------------|-------------------------------|-------------------------------|---------------------------|---|
| mm d | mm d | mm l | mm L | mm d ₁ | mm a | mm l ₂ | mm d ₂ | mm l ₁ | Spiral point Number of Flutes | Spiral Point Number of Flutes | Spiral Point Number of Flutes | Spiral Flute Number of Flutes | Spiral Flute Number of Flutes | Sp Flute Number of Flutes | |
| | | | | | | | | | P1 Blue | Bright | TiN | Bright | P1 Blue | TiN | |
| M1 | 0.25 | 5.5 | 38.5 | 2.5 | 2.0 | 4 | - | 4.5 | 0.75 | 2 | * | * | - | - | - |
| M1.2 | 0.25 | 5.5 | 38.5 | 2.5 | 2.0 | 4 | - | 4.5 | 0.95 | 2 | * | * | - | - | - |
| M1.4 | 0.3 | 7 | 40 | 2.5 | 2.0 | 4 | - | 5 | 1.10 | 2 | * | * | - | - | - |
| M1.6 | 0.35 | 8 | 41 | 2.5 | 2.0 | 4 | - | 5 | 1.25 | 2 | * | * | - | - | - |
| M2 | 0.4 | 8 | 41 | 2.5 | 2.0 | 4 | - | 5.5 | 1.60 | 2 | * | * | 2 | 2 | * |
| M2.5 | 0.45 | 9.5 | 44.5 | 2.8 | 2.24 | 5 | - | 6 | 2.05 | 2 | * | * | 2 | 2 | * |
| M3 | 0.5 | 16 | 48 | 3.15 | 2.5 | 5 | - | - | 2.50 | 3 | 3 | 3 | 3 | 3 | 3 |
| M3.5 | 0.6 | 19 | 50 | 3.55 | 2.8 | 5 | - | - | 2.90 | 3 | 3 | 3 | 3 | 3 | * |
| M4 | 0.7 | 13 | 53 | 4.0 | 3.15 | 6 | 2.80 | 8 | 3.30 | 3 | 3 | 3 | 3 | 3 | 3 |
| M5 | 0.8 | 16 | 58 | 5.0 | 4.0 | 7 | 3.55 | 9 | 4.20 | 3 | 3 | 3 | 3 | 3 | 3 |
| M6 | 1.0 | 19 | 66 | 6.3 | 5.0 | 8 | 4.50 | 11 | 5.00 | 3 | 3 | 3 | 3 | 3 | 3 |
| M7 | 1.0 | 19 | 66 | 7.1 | 5.6 | 8 | 5.30 | 11 | 6.00 | 3 | 3 | 3 | 3 | 3 | 3 |
| M8 | 1.25 | 22 | 72 | 8.0 | 6.3 | 9 | 6.00 | 13 | 6.80 | 3 | 3 | 3 | 3 | 3 | 3 |
| M10 | 1.5 | 24 | 80 | 10.0 | 8.0 | 11 | 7.50 | 15 | 8.50 | 3 | 3 | 3 | 3 | 3 | 3 |
| M12 | 1.75 | 29 | 89 | 9.0 | 7.1 | 10 | | | 10.20 | 3 | 3 | 3 | 3 | 3 | 3 |
| M14 | 2.0 | 30 | 95 | 11.2 | 9.0 | 12 | | | 12.00 | 3 | 3 | 3 | 3 | 3 | 3 |
| M16 | 2.0 | 32 | 102 | 12.5 | 10.0 | 13 | | | 14.00 | 3 | 3 | 3 | 4 | 4 | 4 |
| M18 | 2.5 | 37 | 112 | 14.0 | 11.2 | 14 | | | 15.50 | 4 | * | * | 4 | 4 | * |
| M20 | 2.5 | 37 | 112 | 14.0 | 11.2 | 14 | | | 17.50 | 4 | * | * | 4 | 4 | * |
| M22 | 2.5 | 38 | 118 | 16.0 | 12.5 | 16 | | | 19.50 | 4 | * | * | 4 | 4 | * |
| M24 | 3.0 | 45 | 130 | 18.0 | 14.0 | 18 | | | 21.00 | 4 | * | * | 4 | 4 | * |
| M27 | 3.0 | 45 | 135 | 20.0 | 16.0 | 20 | | | 24.00 | 4 | * | * | 4 | 4 | * |
| M30 | 3.5 | 48 | 138 | 20.0 | 16.0 | 20 | | | 26.50 | 4 | * | * | 4 | 4 | * |

* Available to Special Order
Minimum quantities apply