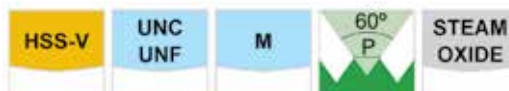


Blue Colour Band Taps

Spiral Point Plug & Spiral Flute Bottoming Styles



CUTTING CONDITIONS

Material	Material Sub-Group	Condition	Hardness (HRC)	Cutting Speed (FPM)
Low Carbon Steel	1018, 1010, 1035	normalized	<25	20-50
Medium Carbon Steel	1045, 1050, 1065	normalized	<25	20-40
Aluminum	unalloyed, cast	—	—	30-80
Brass/Bronze	—	—	—	30-80
Copper	—	—	—	25-60
Cast iron	—	as cast	<15	20-40

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	0.313	GH2	915170	1-7/8	2	0.313	GH2	915126
6-32	2	2	0.375	GH3	915172	2	3	0.375	GH3	915128
6-40	2	2	0.375	GH2	915174	2	—	0.375	GH2	—
8-32	2-1/8	2	0.375	GH3	915176	2-1/8	3	0.375	GH3	915130
10-24	2-3/8	2	0.500	GH3	915178	2-3/8	3	0.500	GH3	915132
10-32	2-3/8	2	0.500	GH3	915180	2-3/8	3	0.500	GH3	915134
12-24	2-3/8	2	0.500	GH3	915182	2-3/8	—	0.500	GH3	—
1/4-20	2-1/2	2	0.625	GH3	915184	2-1/2	3	0.625	GH3	915136
1/4-28	2-1/2	3	0.625	GH3	915186	2-1/2	3	0.625	GH3	915138
5/16-18	2-23/32	2	0.688	GH3	915188	2-23/32	3	0.688	GH3	915140
5/16-24	2-23/32	3	0.688	GH3	915190	2-23/32	3	0.688	GH3	915142
3/8-16	2-15/16	3	0.750	GH3	915192	2-15/16	3	0.750	GH3	915144
3/8-24	2-15/16	3	0.750	GH3	915194	2-15/16	3	0.750	GH3	915146
7/16-14	3-5/32	3	0.875	GH3	915196	3-5/32	3	0.875	GH3	915148
7/16-20	3-5/32	3	0.875	GH3	915198	3-5/32	3	0.875	GH3	—
1/2-13	3-3/8	3	0.938	GH3	915200	3-3/8	3	0.938	GH3	915150
1/2-20	3-3/8	3	0.938	GH3	915202	3-3/8	3	0.938	GH3	915152
5/8-11	3-13/16	3	1.094	GH3	915204	3-13/16	3	1.094	GH3	915154
5/8-18	3-13/16	3	1.094	GH3	915206	3-13/16	4	1.094	GH3	915156
3/4-10	4-1/4	3	1.219	GH3	915208	4-1/4	3	1.219	GH3	915158
3/4-16	4-1/4	3	1.219	GH3	915210	4-1/4	4	1.219	GH3	915160
7/8-9	4-11/16	3	1.344	GH4	915212	4-11/16	3	1.344	GH4	915162
7/8-14	4-11/16	3	1.344	GH4	915214	4-11/16	4	1.344	GH4	915164
1-8	5-1/8	3	1.500	GH4	915216	5-1/8	3	1.500	GH4	915166
1-12	5-1/8	3	1.500	GH4	915218	5-1/8	4	1.500	GH4	915168

Metric Sizes

Size & Pitch	Thread Limit	Overall Length (Inch)	Thread Length (Inch)	Spiral Point		Spiral Flute	
				No. of Flutes	Code	No. of Flutes	Code
M2 x 0.4	D3	1-15/16	0.313	2	915463	—	—
M2.5 x 0.45	D3	1-15/16	0.313	2	915465	—	—
M3 x 0.5	D3	1-15/16	0.313	2	915467	2	915419
M3.5 x 0.6	D4	2	0.375	2	915469	2	915421
M4 x 0.7	D4	2-1/8	0.375	2	915471	3	915423
M4.5 x 0.75	D4	2-3/8	0.500	2	915473	—	—
M5 x 0.8	D4	2-3/8	0.500	2	915475	3	915425
M6 x 1	D5	2-1/2	0.625	3	915477	3	915427
M7 x 1	D5	2-23/32	0.688	3	915479	3	915429
M8 x 1	D5	2-23/32	0.688	3	915483	3	915433