



High Performance Cutting Tools

## HSS TAPS

# PRICE LIST

EFFECTIVE 01.11.2021



Forbes & Company Limited

## TOTEM HSS HAND / SHORT MACHINE / LONG SHANK MACHINE TAPS



	BS - 949									ANSI
Size	BSW / BSF			UNF / UNC			BSP	BSPT	NPT	
Inch	Standard Each ₹	SF / RS * Each ₹	SPPT Each ₹	Standard Each ₹	SF / RS * Each ₹	SPPT Each ₹	Standard Each ₹	Standard Each ₹	Standard Each ₹	
1/8	356	370	429	-	-	-	586	798	820	
5/32	356	370	429	-	-	-	-	-	-	
3/16	356	391	453	-	-	-	-	-	-	
7/32	403	422	475	-	-	-	-	-	-	
1/4	370	391	446	370	391	453	893	1393	1428	
5/16	419	454	524	419	454	524	-	-	-	
3/8	511	550	627	511	550	627	1311	1790	1817	
7/16	653	710	810	653	710	810	-	-	-	
1/2	833	874	998	833	874	998	1982	2671	2723	
9/16	1207	1269	1453	1207	1264	1453	-	-	-	
5/8	1207	1264	1453	1207	1264	1453	2195	-	-	
3/4	1830	1923	2202	1830	1923	2202	2944	3956	4035	
7/8	2526	2645	3028	2526	2645	3028	3633	-	-	
1"	3164	3326	3802	3164	3326	3802	4592	6144	6294	
1.1/8" #	4251	4465	5101	4251	4465	5101	6320	-	-	
1.1/4"	5124	5379	6152	5124	5379	6152	6887	8789	8986	
1.3/8" #	6607	6948	7930	6607	6948	7930	-	-	-	
1.1/2"	7940	8341	9528	7940	8341	9528	8590	10747	11146	
1.5/8" ~	9310	9777	-	9310	9777	-	-	-	-	
1.3/4" ~	11234	11797	-	11234	12851	-	13159	-	-	
2" ~	15607	16387	-	15607	16387	-	15416	19671	20140	
2.1/4" ~	23310	24479	-	-	-	-	26643	-	-	
2.1/2" ~	30613	32144	-	-	-	-	38440	60802	63687	
2.3/4" ~	38192	40105	-	-	-	-	42893	-	-	
3" ~	51243	53811	-	-	-	-	51052	79563	83354	
3.1/2" ~	-	-	-	-	-	-	64357	104887	109829	
4" ~	-	-	-	-	-	-	80897	132096	138377	

# Only in BSW

\* RS - Sizes from 1/8" to 3/8"

Minimum Order Quantity - \* 100 nos / # 5 nos / ~ 2 nos

Number	BS - 949			
	BA			UNF / UNC
	Standard Each ₹	SPPT Each ₹	Standard Each ₹	SPPT Each ₹
0	442	526	832	-
1	442	526	832	-
2	391	477	589	716
3	391	477	589	716
4	391	477	403	482
5	391	477	403	482
6	429	512	403	491

Number	BS - 949			
	BA			UNF / UNC
	Standard Each ₹	SPPT Each ₹	Standard Each ₹	SPPT Each ₹
7	580	691	-	-
8	580	691	403	482
9	832	998	-	-
10	832	998	403	482
11	1323	1589	-	-
12	1323	1589	494	589

**TOTEM HSS HAND / SHORT MACHINE /  
LONG SHANK MACHINE TAPS**

Metric Coarse Pitch	IS-6175 - part I / II / III			IS-6175 - part IV	
Size X Pitch Standard (In Mm)	Standard EACH ₹	SF / RS* EACH ₹	SPPT EACH ₹	Long Shank 'A', 'C', OR 'D' EACH ₹	Long Shank TYPE 'B' (SPPT) EACH ₹
1.0 X 0.25 #	909	-	-	-	-
1.2 X 0.25 #	909	-	-	-	-
1.4 X 0.35 #	784	819	950	-	-
1.6 X 0.35 #	784	819	950	-	-
1.8 X 0.35 #	784	819	950	-	-
2.0 X 0.40	561	586	664	-	-
2.2 X 0.45 #	561	586	664	-	-
2.3 X 0.40 #	561	586	664	-	-
2.5 X 0.45	561	586	664	-	-
2.6 X 0.45	561	586	664	-	-
3.0 X 0.50	341	370	429	750	883
3.5 X 0.60	341	370	429	750	883
4.0 X 0.70	341	370	429	750	883
4.5 X 0.75 #	366	391	453	550	654
5.0 X 0.80	366	391	453	538	654
6.0 X 1.00	366	391	453	578	704
7.0 X 1.00 ~	467	485	553	653	767
8.0 X 1.25	441	454	524	627	767
9.0 X 1.25 ~	532	565	653	802	957
10.0 X 1.50	532	565	653	802	957
11.0 X 1.50 ~	827	874	998	1164	1374
12.0 X 1.75	827	874	998	1133	1340
14.0 X 2.00	1204	1269	1453	1644	1947
16.0 X 2.00	1204	1269	1453	1644	1947
18.0 X 2.50	1817	1905	2178	2415	2839
20.0 X 2.50	2317	2432	2776	2966	3492
22.0 X 2.50	2483	2601	2974	3319	3909
24.0 X 3.00	2766	2901	3319	3602	4243
25.0 X 3.00	3374	3542	4047	4509	5321
27.0 X 3.00	4189	4396	5026	5179	5979
30.0 X 3.50	4682	4923	5627	5949	7019
33.0 X 3.50	5706	5992	6846	6985	11666
36.0 X 4.00	7940	8341	9528	9888	-
39.0 X 4.00	9329	9791	11187	10986	-
42.0 X 4.50	10868	11411	13040	14167	-
45.0 X 4.50	14633	15368	17561	16805	-
48.0 X 5.00	15607	16387	18729	18917	-
52.0 X 5.00	19588	20565	23505	21894	-
56.0 X 5.50	27875	29270	33449	30654	-
60.0 X 5.50	29379	30848	35251	33241	-
64.0 X 6.00	30903	32449	37086	37517	-
68.0 X 6.00	38550	40463	46261	52269	-

\* RS - Sizes from 3MM to 10MM

# Minimum Order Quantity is 102 Nos.

~ Minimum Order Quantity is 51 Nos.

ALL RATES ARE IN RUPEES PER PIECE (EXCLUSIVE OF GST)

4

3

**GEETA TRADING COMPANY**

85, KABRA CHAMBERS, CENTRAL AVENUE ROAD, SEWA SADAN CHOWK, NAGPUR

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## TOTEM HSS HAND / SHORT MACHINE / LONG SHANK MACHINE TAPS



Metric Coarse Pitch	IS-6175 - part i / ii / iii			IS-6175 - part IV	
Size X Pitch Standard (In Mm)	Standard EACH ₹	SF / RS * EACH ₹	SPPT EACH ₹	Long Shank 'A', 'C', OR 'D' EACH ₹	Long Shank TYPE 'B' (SPPT) EACH ₹
4.0 X 0.35/0.50*	509	581	610	-	-
4.0 X 0.75	464	518	591	1021	1139
5.0 X 0.50/0.75*	498	550	596	653	768
6.0 X 0.75	498	550	596	653	768
8.0 X 1.00	522	577	624	691	820
9.0 X 1.00*	643	716	820	888	1044
10.0 X 1.00/1.25	592	664	716	863	962
11.0 X 1.00/1.25*	1044	1165	1333	1412	1671
12.0 X 1.00*/1.25/1.50	971	1023	1097	1240	1459
14.0 X 1.50	1207	1269	1453	1534	1813
14.0 X 1.25	1272	1344	1533	1632	1928
14.0 X 1.00*	1245	1310	1497	1602	1895
16.0 X 1.50	1207	1269	1453	1534	1947
16.0 X 1.00*	1245	1310	1497	1723	2035
18.0 X 1.50	2068	2173	2312	2581	3279
18.0 X 1.00/2.00*	2266	2380	2534	2811	3315
20.0 X 1.50	2617	2743	2917	3362	3971
20.0 X 1.00/2.00	2608	2944	3370	3707	4700
22.0 X 1.50	2851	2993	3184	3491	4121
22.0 X 1.00/2.00*	3072	3227	3687	3762	4768
24.0 X 1.50	3121	3279	3483	3894	4599
24.0 X 2.00	3105	3504	4010	4103	5206
25.0 X 1.00/1.50*	3305	3732	4267	4768	5632
27.0 X 1.50/2.00*	4663	4889	5592	6119	6717
30.0 X 1.50/2.00	5242	5504	6288	6881	8123
33.0 X 1.50/2.00/3.00	6401	6725	-	8318	9829
36.0 X 1.50/2.50*/3.00*	8881	9320	-	11456	13512
39.0 X 1.50/2.00*/3.00*	11069	11626	-	14391	-
42.0 X 1.50/2.50*/3.00*/4.00	12296	12906	-	15730	-
45.0 X 1.50/3.00	17038	17996	-	21929	-
48.0 X 1.50/2.00*/3.00*/4.00	17711	18599	-	22493	-
50.0 X 1.50/2.00*/3.00*	19574	20550	-	24859	-
52.0 X 1.50/2.00*	22057	23166	-	28012	-

# RS - Sizes from 3MM to 10MM

\* Minimum order quantity Upto M4 - 100 nos. / M4.5 to M7 - 75 nos. / M8 to M12 - 50 nos.

M13 to M25 - 25 nos. / M26 to M40 - 5 nos. / M41 and above - 2 nos.

**TOTEM HSS HAND / SHORT MACHINE /  
LONG SHANK MACHINE TAPS**

BS 949			
Size Inch	BSB	BSW LONG SHANK	
	Standard Each ₹	Long Shank 'A', 'C', Or 'D' Each ₹	Long Shank Type 'B' (SPPT) Each ₹
1/8	-	756	892
5/32	-	756	892
3/16	-	586	690
7/32	-	-	-
1/4	364	630	747
9/32	-	-	-
5/16	526	685	770
3/8	617	845	954
7/16	779	924	1090
1/2	845	1202	1415
9/16	1512	1737	2043
5/8	1512	1737	2043
3/4	1983	3105	3663
7/8	2483	3211	3785
1"	3126	3892	4595

BS 949		
SPECIAL PITCH TAPS		
Size	Pitch	Standard EACH ₹
11/64	40, 48	391
3/16	28	391
15/64	28, 40	391
1/4	32	391
9/32	28, 40	483
5/16	30, 40	454
3/8	28, 40	550
7/16	28, 32, 40	710
1/2	32, 40	874
9/16	20	1317

ALL RATES ARE IN RUPEES PER PIECE (EXCLUSIVE OF GST)

6

5

**GEETA TRADING COMPANY**

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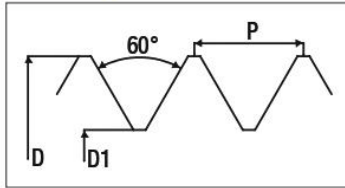
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High Performance Cutting Tools

# THREAD CHART

## ISO METRIC THREADS



ISO METRIC COARSE THREADS

Metric Coarse (M)		
Nominal Diameter	Pitch	Drill Size
ØD		
2	0.4	1.6
2.2	0.45	1.75
2.3	0.4	1.9
2.5	0.45	2.05
2.6	0.45	2.1
3	0.5	2.5
3.5	0.6	2.9
4	0.7	3.3
4.5	0.75	3.7
5	0.8	4.2
6	1	5
7	1	6
8	1.25	6.8
9	1.25	7.8
10	1.5	8.5
11	1.5	9.5
12	1.75	10.2
14	2	12
16	2	14
18	2.5	15.5
20	2.5	17.5
22	2.5	19.5
24	3	21
27	3	24
30	3.5	26.5
33	3.5	29.5
36	4	32
39	4	35
42	4.5	37.5
45	4.5	40.5
48	5	43
52	5	47
56	5.5	50.5
60	5.5	54.5
64	6	58
68	6	62

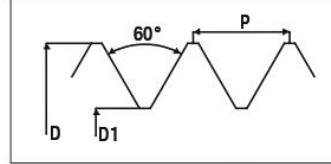
ISO METRIC FINE THREADS

Metric Fine (MF)		
Nominal Diameter	Pitch	Drill Size
ØD		
2.5	0.35	2.15
3	0.35	2.65
3.5	0.35	3.15
4	0.5	3.5
4.5	0.5	4
5	0.5	4.5
6	0.75	5.2
7	0.75	6.2
8	0.75	7.2
8	1	7
9	1	8
10	0.75	9.2
10	1	9
10	1.25	8.8
11	1	10
12	1	11
12	1.25	10.8
12	1.5	10.5
14	1	13
14	1.25	12.8
14	1.5	12.5
15	1	14
15	1.5	13.5
16	1	15
16	1.5	14.5
17	1	16
17	1.5	15.5
18	1.5	16.5
18	2	16
20	1	19
20	1.5	18.5
20	2	18
22	1	21
22	1.5	20.5
22	2	20
24	1	23
24	1.5	22.5
24	2	22
24	1	23
25	1.5	23.5

Metric Fine (MF)		
Nominal Diameter	Pitch	Drill Size
ØD		
26	1.5	24.5
27	1	26
27	1.5	25.5
27	2	25
28	1.5	26.5
28	2	26
30	1	29
30	1.5	28.5
30	2	28
32	1.5	30.5
32	2	30
33	1.5	31.5
33	2	31
33	3	30
35	1.5	33.5
36	1.5	34.5
36	2	34
36	3	33
38	1.5	36.5
39	1.5	37.5
39	2	37
39	3	36
40	1.5	38.5
40	2	38
40	3	37
42	1.5	40.5
42	2	40
42	3	39
45	1.5	43.5
45	2	43
45	3	42
48	1.5	46.5
48	2	46
48	3	45
50	1.5	48.5
50	2	48
50	3	47
52	1.5	50.5
52	2	50
52	3	49

## FORMING/ROLL TAP PRE - TAPPING DRILL HOLE

ISO METRIC THREADS



COARSE PITCH		
TAP SIZE	Pitch	Drill Size
M 2	0.4	1.8
M 2.5	0.45	2.3
M 3	0.5	2.8
M 3.5	0.6	3.25
M 4	0.7	3.7
M 4.5	0.75	4.15
M 5	0.8	4.6
M 6	1	5.55
M 7	1	6.55
M 8	1.25	7.5
M 10	1.5	9.3
M 11	1.5	10.3
M 12	1.75	11.2
M 14	2	13.1
M 16	2	15.1
M 18	2.5	16.9
M 20	2.5	18.9

FINE PITCH		
TAP SIZE	Pitch	Drill Size
M 3	0.35	2.85
M 4	0.5	3.8
M 5	0.5	4.8
M 6	0.75	5.65
M 8	1	7.55
M 10	1	9.55
M 10	1.25	9.45
M 12	1	11.55
M 12	1.25	11.45
M 12	1.5	11.3
M 14	1.25	13.45
M 14	1.5	13.3
M 16	1.5	15.3
M 18	1.5	17.3
M 20	1.5	19.3
M 18	2.5	16.9
M 20	2.5	18.9

UNC TAPS		
TAP SIZE	Pitch	Drill Size
NO. 1	64	1.7
NO. 2	56	2
NO. 3	48	2.3
NO. 4	40	2.6
NO. 5	40	2.9
NO. 6	32	3.2
NO. 8	32	3.8
NO. 10	24	4.4
NO. 12	24	5
1/4"	20	5.8
5/16"	18	7.3
3/8"	16	8.8
7/16"	14	10.3
1/2"	13	11.9

UNF TAPS		
TAP SIZE	Pitch	Drill Size
NO. 1	72	1.7
NO. 2	64	2
NO. 3	56	2.3
NO. 4	48	2.6
NO. 5	44	2.9
NO. 6	40	3.2
NO. 8	36	3.9
NO. 10	32	4.5
NO. 12	28	5.1
1/4"	28	6
5/16"	24	7.5
3/8"	24	9.1
7/16"	20	10.6
1/2"	20	12.1

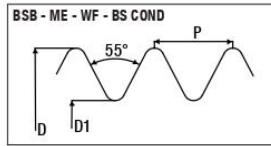
WHITWORTH PIPE THREADS		
TAP SIZE	Pitch	Drill Size
G 1/8"	28	9.25
G 1/4"	19	12.5
G 3/8"	19	16
G 1/2"	14	20
G 3/4"	14	25.5
G 1"	11	32



# THREAD CHART

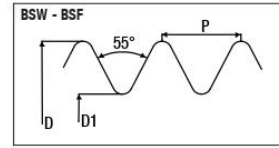
BSB		
Nominal Diameter ØD	TPI	Drill Size in mm
1/4"	26	5.3
5/16"	26	6.90
3/8"	26	8.40
7/16"	26	10.00
1/2"	26	11.50
9/16"	26	13.1
5/8"	26	14.70
11/16"	26	16.50
3/4"	26	17.80
7/8"	26	21.00
1"	26	24.20
1.1/8"	26	27.50
1.1/4"	26	30.50
1.3/8"	26	33.70
1.1/2"	26	36.90
2	26	49.60

## BRITISH STANDARD THREADS



BS COND.		
Nominal Diameter	TPI	Drill Size in mm
1/2"	18	11.50
5/8"	18	14.20
3/4"	16	17.50
7/8"	16	20.60
1"	16	23.80
1.1/4"	16	30.10
1.1/2"	14	36.10
2	14	48.80

ME		
Nominal Diameter ØD	TPI	Drill Size in mm
1/8"	40	2.55
5/32"	40	3.30
3/16"	40	4.00
7/32"	40	4.80
1/4"	40	5.50
9/32"	32	6.10
5/16"	32	7.00
3/8"	32	8.60
7/16"	26	10.50
1/2"	26	12.10



British Standard Whitworth Threads

BSW		
Nominal Diameter ØD	TPI	Drill Size in mm
1/16"	60	1.2
3/32"	48	1.9
1/8"	40	2.55
5/32"	32	3.2
3/16"	24	3.7
7/32"	24	4.5
1/4"	20	5.1
9/32"	20	5.8
5/16"	18	6.5
3/8"	16	7.9
7/16"	14	9.3
1/2"	12	10.5
9/16"	12	12.1
5/8"	11	13.5
11/16"	11	15.1
3/4"	10	16.3
7/8"	9	19.3
15/16"	9	20.6
1"	8	22.0
1.1/8"	7	24.75
1.1/4"	7	28.0
1.3/8"	6	30.5
1.1/2"	6	33.5
1.5/8"	5	36.0
1.3/4"	5	39.0
1.7/8"	4 1/2	41.3
2"	4 1/2	44.5

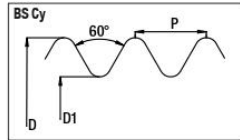
British Standard Fine Threads

BSF		
Nominal Diameter ØD	TPI	Drill Size in mm
3/16"	32	4
7/32"	28	4.6
1/4"	26	5.30
9/32"	26	6.00
5/16"	22	6.80
3/8"	20	8.30
7/16"	18	9.70
1/2"	16	11.10
9/16"	16	12.70
5/8"	14	14.00
11/16"	14	15.50
3/4"	12	16.75
7/8"	11	19.75
15/16"	11	21.50
1"	10	22.75
1.1/8"	9	25.50
1.1/4"	9	28.50
1.3/8"	8	31.50
1.1/2"	8	34.50
1.5/8"	8	37.70
1.3/4"	7	41.00
1.7/8"	7	43.70
2"	7	47.00

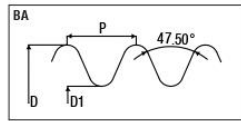
WHITWORTH FORM SPECIAL		
Nominal Diameter ØD	TPI	Drill Size in mm
1/4"	24/28/32	5.3, 5.4, 5.5
5/16"	24/40	6.75, 7.3
3/8"	24, 40	8.4, 8.9
7/16"	20/24/40	9.8/10, 10.5
1/2"	20/24/40	11.5, 11.9, 12
9/16"	20	13.1

WHITWORTH FORM SPECIAL		
Nominal Diameter ØD	TPI	Drill Size in mm
5/8"	20	14.5
11/16"	20	16.2
3/4"	14/20	17.1, 17.8
7/8"	14/16/20	20.2, 20.6, 21.0
1"	12/20	23.0, 24.0

BA		
Size	Diameter	Drill Size in mm
0	0.2362	25.4
1	0.2087	28.2
2	0.1850	31.4
3	0.1614	34.8
4	0.1417	38.5
5	0.1260	43
6	0.1102	47.9
7	0.0984	52.9
8	0.0866	59.1
9	0.0748	65.1
10	0.0669	72.6
11	0.0591	81.9
12	0.0512	90.9



BS Cy		
Size	TPI	Drill Size in mm
1/8"	40	2.65
5/32"	32	3.30
3/16"	32	4.10
7/32"	26	4.80
1/4"	26	5.60
5/16"	26	7.20
3/8"	26	8.70
7/16"	26	10.30
1/2"	26	11.90
9/16"	26	13.50
5/8"	26	15.00
3/4"	26	18.20
1"	24	24.50



## UNIFIED COARSE THREADS

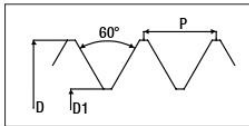
UNC		
Nominal Diameter ØD	Pitch	Drill Size
# 1	64	1.55
# 2	56	1.8
# 3	48	2.1
# 4	40	2.3
# 5	40	2.6
# 6	32	2.9
# 8	32	3.5
# 10	24	3.9
# 12	24	4.5
1/4"	20	5.2
5/16"	18	6.6
3/8"	16	8
7/16"	14	9.4

UNC		
Nominal Diameter ØD	Pitch	Drill Size
1/2"	13	10.9
9/16"	12	12.3
5/8"	11	13.6
3/4"	10	16.6
7/8"	9	19.5
1"	8	22.3
1.1/8"	7	25
1.1/4"	7	28.3
1.3/8"	6	30.8
1.1/2"	6	34
1.3/4"	5	39.5
2"	4.5	45.3

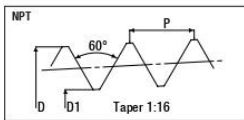
UNF		
Nominal Diameter ØD	Pitch	Drill Size
# 0	80	1.25
# 1	72	1.55
# 2	64	1.85
# 3	56	2.1
# 4	48	2.4
# 5	44	2.7
# 6	40	2.9
# 8	36	3.5
# 10	32	4.1
# 12	28	4.6
1/4"	28	5.5
5/16"	24	6.9
3/8"	24	8.5

UNF		
Nominal Diameter ØD	Pitch	Drill Size
7/16"	20	9.9
1/2"	20	11.5
9/16"	18	12.9
5/8"	18	14.5
3/4"	16	17.5
7/8"	14	20.5
1"	12	23.3
1.1/8"	12	26.5
1.1/4"	12	29.6
1.3/8"	12	32.8
1.1/2"	12	36
2"	12	48.6

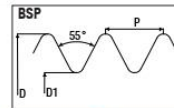
## AMERICAN STANDARD THREADS



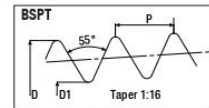
## STRAIGHT AND TAPER PIPE THREADS



Nominal Diameter ØD	TPI	Drill Size in mm		
		Tapping With Reamer	Tapping Without Reamer	NPS
1/16"	27	5.94	6.15	6.35
1/8"	27	8.33	8.43	8.75
1/4"	18	10.72	11.13	11.13
3/8"	18	14.27	14.68	14.68
1/2"	14	17.48	17.86	18.26
3/4"	14	22.63	23.01	23.42
1"	11.5	28.58	28.98	29.36
1.1/4"	11.5	37.31	37.69	38.1
1.1/2"	11.5	43.26	43.66	44.45
2"	11.5	55.17	55.58	56.36
2.1/2"	8	65.48	66.27	67.46



BSP		
Nominal Diameter ØD	TPI	Drill Size in mm
1/8"	28	8.8
1/4"	19	11.8
3/8"	19	15.3
1/2"	14	19
5/8"	14	21
3/4"	14	24.5
7/8"	14	28.3
1"	11	30.8
1.1/4"	11	39.5
1.1/2"	11	45
1.3/4"	11	51
2"	11	57



Nominal Diameter ØD	TPI	Drill Size in mm	
		Tapping With Reamer	Tapping Without Reamer
1/16"	28	6.1	6.2
1/8"	28	8.1	8.2
1/4"	19	10.7	11
3/8"	19	14.2	14.5
1/2"	14	17.6	18
3/4"	14	23	23.5
1"	11	29	29.5
1.1/4"	11	37.5	38
1.1/2"	11	43.5	44
2"	11	54.9	55.5

## TAP SELECTION GUIDE

DIN 371 / DIN 376 / DIN 374 / ISO 529 / JIS													
Page No./DIN / ISO / JIS	M	5 / 18 / 31	5 / 18	5 / 18 / 31	36 / 52 / 67	36 / 52	36 / 52 / 67	90	6 / 19	6 / 19	6 / 19	9 / 22	9 / 22
	MF	10 / 23 / 31	10 / 23	10 / 23 / 31	41 / 57 / 67	41 / 57	41 / 57 / 67	94	11 / 24	11 / 24	11 / 24	-	-
	UNC	14 / 27	14 / 27	14 / 27	46 / 61	46 / 61	-	-	-	-	-	-	-
	UNF	16 / 29	16 / 29	16 / 29	49 / 64	49 / 64	-	-	-	-	-	-	-
Series	SA1	SA3	SA4	SB1	SB3	SB4	SD4	SAF3	SAF5	SAF7	SAF5	SAF7	
Execution	Spiral Point	Spiral Point	Spiral Point	Spiral Flute	Spiral Flute	Spiral Flute	Forming	Spiral Point	Spiral Point	Spiral Point	Spiral Point	Spiral Point	
Tool Material	HSSE	HSSE	HSSE	HSSE	HSSE	HSSE	HSSE	HSSE	HSSE	HSSE	HSSE-PM	HSSE-PM	
Helix	-	-	-	35	35	35	-	-	-	-	-	-	
Coating	Bright	TiN	TiAlN	Bright	TiN	TiAlN	TiAlN	TiN	TiCN	AlCrN	TiCN	AlCrN	
Chamfer	B/ 4-4.5P	B/ 4-4.5P	B/ 4-4.5P	C/2-3P	C/2-3P	C/2-3P	C/ 2-3P	B/ 4-4.5P	B/ 4-4.5P	B/ 4-4.5P	B/ 4-4.5P	B/ 4-4.5P	
Hole Type	Through	Through	Through	Blind/ Through	Blind/ Through	Blind/ Through	Through /Blind	Through	Through	Through	Through	Through	
Coolant Feed	No	No	No	No	No	No	No	No	No	No	No	No	
Oil Groove	-	-	-	-	-	-	Yes	-	-	-	-	-	
Steel	P0	10-12	15-20	20-25	8-12								
	P1		15-20	15-20	8-12	10-15	15-20	15-20	15-20	15-25			
	P2			15-20		8-15	10-18	12-15	15-20	15-25	15-25	25-30	
	P3			8-12						15-20	15-20	20-25	
	P4											12-16	
	P5												
	P6												
Stainless Steel	M1												
	M2												
	M3												
Cast Iron	K1			30-35			10-20						
	K2		15-20	20-25		8-12	8-12						
	K3		12-15										
Non-Ferrous	N1	15-20			15-25								
	N2	15-20			15-25								
	N3					15-20							
	N4	25-30				20-25							
Special Alloys	S1												
	S2												
	S3												
	S4												



## TAP SELECTION GUIDE

DIN 371 / DIN 376 / DIN 374 / ISO 529 / JIS													
Page No. DIN / ISO / JIS	M	5 / 18 / 31	5 / 18	5 / 18 / 31	36 / 52 / 67	36 / 52	36 / 52 / 67	90	6 / 19	6 / 19	6 / 19	9 / 22	9 / 22
	MF	10 / 23 / 31	10 / 23	10 / 23 / 31	41 / 57 / 67	41 / 57	41 / 57 / 67	94	11 / 24	11 / 24	11 / 24	-	-
	UNC	14 / 27	14 / 27	14 / 27	46 / 61	46 / 61	-	-	-	-	-	-	-
	UNF	16 / 29	16 / 29	16 / 29	49 / 64	49 / 64	-	-	-	-	-	-	-
Series	SA1	SA3	SA4	SB1	SB3	SB4	SD4	SAF3	SAF5	SAF7	SAF5	SAF7	
Execution	Spiral Point	Spiral Point	Spiral Point	Spiral Flute	Spiral Flute	Spiral Flute	Forming	Spiral Point	Spiral Point	Spiral Point	Spiral Point	Spiral Point	
Tool Material	HSSE	HSSE	HSSE	HSSE	HSSE	HSSE	HSSE	HSSE	HSSE	HSSE	HSSE	HSSE-PM	HSSE-PM
Helix	-	-	-	35	35	35	-	-	-	-	-	-	-
Coating	Bright	TiN	TiAlN	Bright	TiN	TiAlN	TiAlN	TiN	TiCN	AlCrN	TiCN	AlCrN	
Chamfer	B/ 4-4.5P	B/ 4-4.5P	B/ 4-4.5P	C/2-3P	C/2-3P	C/2-3P	C/ 2-3P	B/ 4-4.5P	B/ 4-4.5P	B/ 4-4.5P	B/ 4-4.5P	B/ 4-4.5P	
Hole Type	Through	Through	Through	Blind/ Through	Blind/ Through	Blind/ Through	Through /Blind	Through	Through	Through	Through	Through	
Coolant Feed	No	No	No	No	No	No	No	No	No	No	No	No	
Oil Groove	-	-	-	-	-	-	Yes	-	-	-	-	-	
Steel	P0	10-12	15-20	20-25	8-12								
	P1		15-20	15-20	8-12	10-15	15-20	15-20	15-20	15-25			
	P2			15-20		8-15	10-18	12-15	15-20	15-25	15-25	25-30	25-30
	P3			8-12						15-20	15-20	20-25	20-25
	P4												12-16
	P5												
	P6												
Stainless Steel	M1												
	M2												
	M3												
Cast Iron	K1			30-35		10-20							
	K2		15-20	20-25		8-12	8-12						
	K3		12-15										
Non-Ferrous	N1	15-20			15-25								
	N2	15-20			15-25								
	N3					15-20							
	N4	25-30				20-25							
Special Alloys	S1												
	S2												
	S3												
	S4												

## TAP SELECTION GUIDE

DIN 371 / DIN 376 / DIN 374 / ISO 529 / JIS												
Page No./DIN / ISO / JIS	M	8 / 21	39 / 55	72 / 79 / 86	72 / 79 / 86	73 / 80	74 / 81	74 / 81	89 / 95 / 99	89 / 95 / 99	91	91
	MF	13 / 26	44 / -	75 / 82	75 / 82	76 / 83	-	-	93 / 97 / 99	93 / 97 / 99	-	-
	UNC	-	-	77 / 84	77 / 84	-	-	-	-	-	-	-
	UNF	-	-	78 / 85	78 / 85	-	-	-	-	-	-	-
Series	SAI6	SBI6	SC3	SC4	SC4TC	SC4	SC4TC	SD1	SD3	SD1	SD3	
Execution	Spiral Point	Spiral Flute	Straight Flute	Straight Flute	Straight Flute	Straight Flute	Straight Flute	Forming	Forming	Forming	Forming	
Tool Material	HSSE-PM	HSSE-PM	HSSE	HSSE	HSSE	HSSE-PM	HSSE-PM	HSSE	HSSE	HSSE	HSSE	
Helix	-	-	-	-	-	-	-	-	-	-	-	
Coating	TiAIN + WC/C	TiAIN + WC/C	TiN	TiAIN	TiAIN	TiAIN	TiAIN	Bright	TiN	Bright	TiN	
Chamfer	B/ 4-4.5P	C/2-3P	E/1 -1.5P	E/1 -1.5P	E/1 -1.5P	E/1 -1.5P	E/1 -1.5P	C/ 2-3P	C/ 2-3P	C/ 2-3P	C/ 2-3P	
Hole Type	Through	Blind/ Through	Through/Blind	Through/Blind	Blind	Through/Blind	Blind	Through /Blind	Through /Blind	Through /Blind	Through /Blind	
Coolant Feed	No	No	No	No	Yes	No	Yes	No	No	No	No	
Oil Groove	-	-	-	-	-	-	-	Yes	Yes	-	-	
Steel	P0								15-20		20-25	
	P1								15-20		25-20	
	P2								12-15		15-18	
	P3											
	P4											
	P5											
	P6											
Stainless Steel	M1											
	M2											
	M3											
Cast Iron	K1			25-30	30-40	30-40	40-50	40-50				
	K2			15-20	20-25	20-25	30-40	30-40				
	K3				12-15	15-20	25-30	25-30				
Non-Ferrous	N1								20-25	25-30	20-25	25-30
	N2			25-30					20-25	25-30	20-25	25-30
	N3			20-25						20-25		20-25
	N4											
Special Alloys	S1	10-15	6-10									
	S2	6-12	5-8									
	S3	8-12	6-8									
	S4	4-6	3-5									