



2017 Master Catalog

WIDIA  TM



Solutions for Through Hole Applications •

WIDIA-GTD™

Spiral-Point and Left-Hand Spiral-Flute



WIDIA-GTD™ offers a wide range of options for tapping through holes in:

- Steel and steel alloys.
- Stainless steel.
- Cast iron.
- Wrought and cast aluminum.
- Nickel-based alloys.
- Titanium alloys.

High-Performance Victory™ HSS-E-PM Taps

- Left-hand spiral flutes to push chips ahead in through holes.
- Offer performance advantages over conventional high-speed steel taps.
- Long tap life at up to 50% higher tapping speed than HSS taps.

Multipurpose VariTap™

- Unique spiral-point geometry provides low tapping torque while pushing chips ahead of the tap in through holes.
- Manufactured from high-vanadium HSS-E to provide long and consistent tool life.
- Ideal for customers who have a variety of materials to machine.

General Purpose Production Taps

- Spiral point GUN™ taps shoot chips ahead of the cutting action to reduce overloading and clogging in flutes, protecting the workpiece.
- Extended life in ductile materials.
- Advanced steam oxide finish and PVD coatings available.

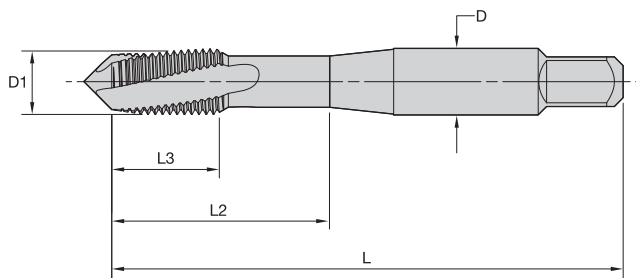
**WIDIA**
VICTORY

High-Performance Taps

Victory™ Left-Hand Spiral-Flute HSS-E-PM Taps • Through Holes

WIDIA
GTD™

- GM6515 TiN + CrC/C for stainless steel.
- GP6520 TiCN for steel.

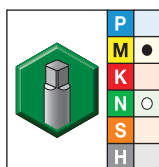
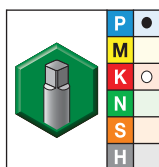


Shank Tolerance

D inch	tolerance h6
.118-.236	+0, -.0003
.236-.394	+0, -.0004
.394-.709	+0, -.0004
.709-1.181	+0, -.0005
1.181-1.969	+0, -.0006

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VICTORY

■ GT20 • Machine Screw and Fractional • Form D Plug Chamfer • ANSI • For Steel and Stainless Steel



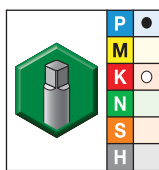
- first choice
- alternate choice

grade GP6520 TiCN		grade GM6515 TiN+CrC/C		inch dimensions					number of flutes	class of fit
order #	catalog #	order #	catalog #	D1 size	L	L3	L2	D		
3954966	GT205031	3955273	GT205001	2 - 56	1.75	.44	.49	.141	2	2BX
3954967	GT205032	3955274	GT205002	2 - 56	1.75	.44	.49	.141	2	3BX
3954968	GT205033	3955275	GT205003	4 - 40	1.88	.56	.68	.141	2	2BX
3954969	GT205034	3955276	GT205004	4 - 40	1.88	.56	.68	.141	2	3BX
-	-	3955277	GT205005	5 - 40	1.94	.63	.75	.141	2	3BX
3954970	GT205035	-	-	5 - 40	2.37	.63	.75	.141	2	3BX
3954983	GT205037	3955279	GT205007	6 - 32	2.00	.36	.71	.141	2	3BX
3954971	GT205036	3955278	GT205006	6 - 32	2.00	.36	.71	.141	2	2BX
3954985	GT205039	3955281	GT205009	8 - 32	2.13	.31	.76	.168	2	3BX
3954984	GT205038	3955280	GT205008	8 - 32	2.13	.31	.76	.168	2	2BX
3954998	GT205052	3955294	GT205022	8 - 36	2.13	.31	.76	.168	2	3BX
3954986	GT205040	3955282	GT205010	10 - 24	2.38	.47	.91	.194	3	3BX
3954999	GT205053	3955295	GT205023	10 - 32	2.38	.47	.91	.194	3	2BX
3955000	GT205054	3955296	GT205024	10 - 32	2.38	.47	.91	.194	3	3BX
3954987	GT205041	3955283	GT205011	12 - 24	2.38	.42	.96	.220	3	3BX
3954989	GT205043	3955285	GT205013	1/4 - 20	2.50	.44	1.00	.255	3	3BX
3954988	GT205042	3955284	GT205012	1/4 - 20	2.50	.44	1.00	.255	3	2BX
3955001	GT205055	3955297	GT205025	1/4 - 28	2.50	.44	1.00	.255	3	2BX
3955002	GT205056	3955298	GT205026	1/4 - 28	2.50	.44	1.00	.255	3	3BX
3954991	GT205045	3955287	GT205015	5/16 - 18	2.72	.49	1.13	.318	3	3BX
3954990	GT205044	3955286	GT205014	5/16 - 18	2.72	.49	1.13	.318	3	2BX
3955003	GT205057	3955299	GT205027	5/16 - 24	2.72	.49	1.13	.318	3	3BX
3954992	GT205046	3955288	GT205016	3/8 - 16	2.94	.60	1.27	.381	3	2BX
3954993	GT205047	3955289	GT205017	3/8 - 16	2.94	.60	1.27	.381	3	3BX

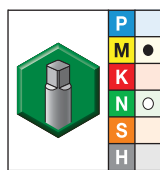
(continued)

WIDIA

(GT20 • Machine Screw and Fractional • Form D Plug Chamfer • ANSI • For Steel and Stainless Steel — continued)



grade GP6520
TiCN



grade GM6515
TiN+CrC/C

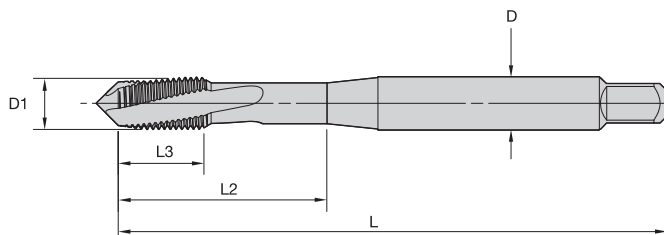
● first choice
○ alternate choice

				inch dimensions					number of flutes	class of fit
order #	catalog #	order #	catalog #	D1 size	L	L3	L2	D		
3955004	GT205058	3955300	GT205028	3/8 - 24	2.94	.60	1.27	.381	3	3BX
3954994	GT205048	3955290	GT205018	7/16 - 14	3.16	.71	1.49	.323	3	3BX
3955005	GT205059	3955301	GT205029	7/16 - 20	3.16	.71	1.49	.323	3	3BX
3954995	GT205049	3955291	GT205019	1/2 - 13	3.38	.77	1.74	.367	3	3BX
3955006	GT205060	3955302	GT205030	1/2 - 20	3.38	.77	1.74	.367	3	3BX
3954996	GT205050	3955292	GT205020	5/8 - 11	3.81	.91	1.89	.480	4	3BX
3954997	GT205051	3955293	GT205021	3/4 - 10	4.25	1.00	2.08	.590	4	3BX

High-Performance Taps

Victory™ Left-Hand Spiral-Flute HSS-E-PM Taps • Through Holes

- GP6520 TiCN for steel.

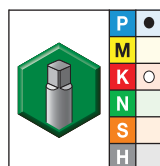


Shank Tolerance

D inch	tolerance h6
.118-.236	+0, -.0003
.236-.394	+0, -.0004
.394-.709	+0, -.0004
.709-1.181	+0, -.0005
1.181-1.969	+0, -.0006



■ GT20 • Machine Screw and Fractional • Form D Plug Chamfer • DIN Length ANSI Shank • For Steel



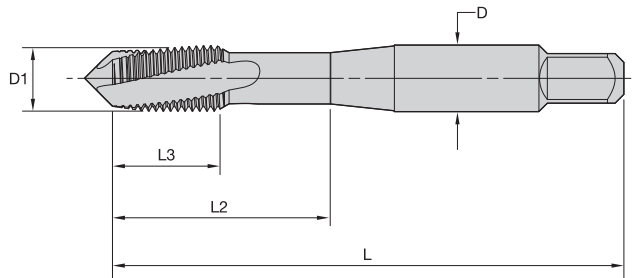
- first choice
- alternate choice

grade GP6520
TiCN

inch dimensions

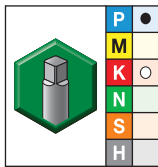
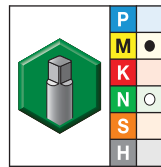
order #	catalog #	D1 TPI	L	L3	L2	D	number of flutes	class of fit
4176835	GT205131	6 - 32	2.20	.40	.79	.141	2	2BX
4176854	GT205140	6 - 40	2.20	.39	.79	.141	2	2BX
4176836	GT205132	8 - 32	2.48	.39	.83	.168	2	2BX
4176837	GT205133	10 - 24	2.76	.39	.98	.194	3	2BX
4176856	GT205142	10 - 32	2.76	.40	.98	.194	3	2BX
4176839	GT205135	1/4 - 20	3.15	.51	1.18	.255	3	3BX
4176858	GT205144	1/4 - 28	3.15	.51	1.18	.255	3	3BX
4176840	GT205136	5/16 - 18	3.54	.55	1.38	.318	3	3BX
4176859	GT205145	5/16 - 24	3.54	.55	1.38	.318	3	3BX
4176841	GT205137	3/8 - 16	3.94	.63	1.53	.381	3	3BX
4176860	GT205146	3/8 - 24	3.94	.63	1.53	.381	3	3BX
4176842	GT205138	7/16 - 14	3.94	.71	1.61	.323	3	3BX
4176861	GT205147	7/16 - 20	3.94	.71	1.61	.323	3	3BX
4176853	GT205139	1/2 - 13	4.33	.79	1.85	.367	3	3BX
4176862	GT205148	1/2 - 20	4.33	.79	1.85	.367	3	3BX

- GM6515 TiN + CrC/C for stainless steel.
- GP6520 TiCN for steel.



Shank Tolerance

D inch	tolerance h6
0.118–0.236	+0, -.0003
>0.236–0.394	+0, -.0004
>0.394–0.709	+0, -.0004
>0.709–1.181	+0, -.0005
>1.181–1.969	+0, -.0006


■ GT20 • Form D Plug Chamfer • Metric ANSI • For Steel and Stainless Steel

 grade GP6520
TiCN

 grade GM6515
TiN+CrC/C

- first choice
- alternate choice

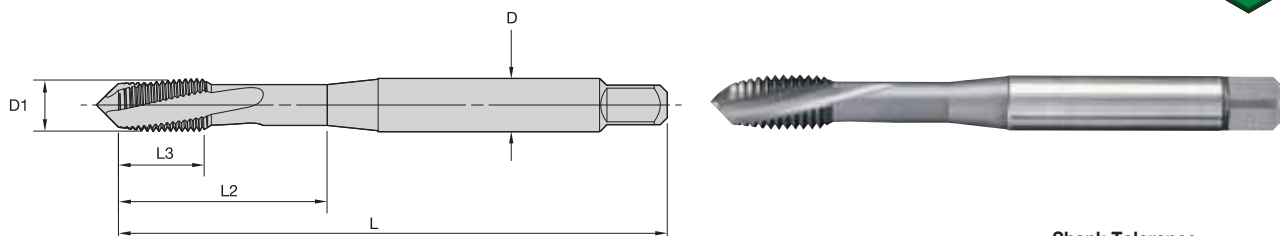
				inch dimensions					number of flutes	class of fit
order #	catalog #	order #	catalog #	D1 TPI	L	L3	L2	D		
3955018	GT205069	3955010	GT205061	M3 X 0,5	1.94	.63	.75	.141	2	6HX
3955019	GT205070	3955011	GT205062	M4 X 0,7	2.13	.32	.76	.168	2	6HX
3955020	GT205071	3955012	GT205063	M5 X 0,8	2.38	.47	.91	.194	2	6HX
3955021	GT205072	3955013	GT205064	M6 X 1	2.50	.46	1.01	.255	3	6HX
3955043	GT205073	3955014	GT205065	M8 X 1	2.72	.48	1.12	.318	3	6HX
3955044	GT205074	3955015	GT205066	M8 X 1,25	2.72	.48	1.12	.318	3	6HX
3955045	GT205075	3955016	GT205067	M10 X 1,5	2.94	.53	1.26	.381	3	6HX
3955046	GT205076	3955017	GT205068	M12 X 1,75	3.38	.77	1.74	.367	3	6HX

High-Performance Taps

Victory™ Left-Hand Spiral-Flute HSS-E-PM Taps • Through Holes

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- GM6515 TiN + CrC/C for stainless steel.
- GP6520 TiCN for steel.

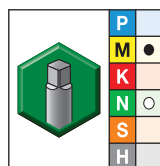
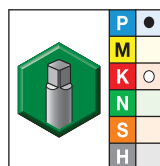


Shank Tolerance

D mm	tolerance h6
>3-6	+0, -0,008
>6-10	+0, -0,009
>10-18	+0, -0,011
>18-30	+0, -0,013
>30-50	+0, -0,016

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■ GT20 • Form D Plug Chamfer • Metric DIN 371, 374, and 376 • For Steel and Stainless Steel

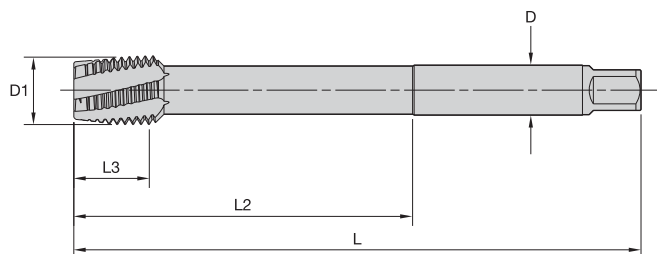


- first choice
- alternate choice

grade GP6520 TiCN		grade GM6515 TiN+CrC/C		metric dimensions					number of flutes	dimension standard	class of fit
order #	catalog #	order #	catalog #	D1 size	L	L3	L2	D			
3955084	GT205094	3955047	GT205077	M3 X 0,5	56	8	18	3,5	2	DIN 371	6HX
3955085	GT205095	3955048	GT205078	M4 X 0,7	63	10	21	4,5	2	DIN 371	6HX
3955086	GT205096	3955049	GT205079	M5 X 0,8	70	10	25	6,0	2	DIN 371	6HX
3955087	GT205097	3955050	GT205080	M6 X 1	80	10	30	6,0	3	DIN 371	6HX
3955124	GT205104	3955077	GT205087	M8 X 1	90	13	35	6,0	3	DIN 374	6HX
3955088	GT205098	3955051	GT205081	M8 X 1,25	90	13	35	8,0	3	DIN 371	6HX
3955125	GT205105	3955078	GT205088	M10 X 1	90	10	35	7,0	3	DIN 374	6HX
3955126	GT205106	3955079	GT205089	M10 X 1,25	100	15	39	7,0	3	DIN 374	6HX
3955089	GT205099	3955052	GT205082	M10 X 1,5	100	15	39	10,0	3	DIN 371	6HX
3955127	GT205107	3955080	GT205090	M12 X 1,5	100	15	39	9,0	3	DIN 374	6HX
3955090	GT205100	3955073	GT205083	M12 X 1,75	110	18	44	9,0	3	DIN 376	6HX
3955128	GT205108	3955081	GT205091	M14 X 1,5	100	15	47	11,0	4	DIN 374	6HX
3955091	GT205101	3955074	GT205084	M14 X 2	110	20	52	11,0	4	DIN 376	6HX
3955129	GT205109	3955082	GT205092	M16 X 1,5	100	15	46	12,0	4	DIN 374	6HX
3955092	GT205102	3955075	GT205085	M16 X 2	110	20	51	12,0	4	DIN 376	6HX
3955130	GT205110	3955083	GT205093	M18 X 1,5	110	15	50	14,0	4	DIN 374	6HX
3955123	GT205103	3955076	GT205086	M20 X 2,5	140	25	64	16,0	4	DIN 376	6HX
4033723	GT205111	-	-	M24 X 3	160	30	77	18,0	5	DIN 376	6HX
4033725	GT205113	-	-	M30 X 3,5	180	35	91	22,0	5	DIN 376	6HX
4033726	GT205114	-	-	M33 X 3,5	180	35	100	25,0	5	DIN 376	6HX
4033728	GT205116	-	-	M36 X 4	200	40	110	28,0	6	DIN 376	6HX
4033730	GT205118	-	-	M42 X 4,5	200	45	120	32,0	6	DIN 376	6HX

High-Performance Taps

- GP6520 TiCN for steel and cast iron.

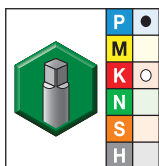


Shank Tolerance

D mm	tolerance h6
12-18	+0, -0,011
20-30	+0, -0,013
32-36	+0, -0,016



- GT20 • Form D Plug Chamfer • Larger Sizes • Metric Extra Long • For Steel and Cast Iron



- first choice
- alternate choice

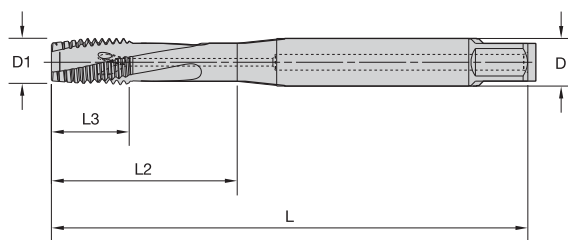
grade GP6520 TiCN		metric dimensions					number of flutes	class of fit
order #	catalog #	D1 size	L	L3	L2	D		
4033765	GT205122	M24 X 3	200	30	120	18,0	5	6HX
4033767	GT205124	M30 X 3,5	250	35	150	22,0	5	6HX
4033768	GT205125	M33 X 3,5	250	35	150	25,0	5	6HX
4033770	GT205127	M36 X 4	250	40	150	28,0	6	6HX
4033772	GT205129	M42 X 4,5	300	45	180	32,0	6	6HX

High-Performance Taps

Victory™ Left-Hand Spiral-Flute HSS-E-PM Taps • Through Holes

WIDIA
GTD™

- GM6515 TiN + CrC/C for stainless steel.
- GP6520 TiCN for steel.

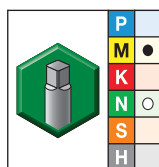
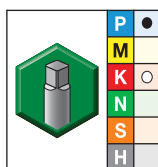


Shank Tolerance

D mm	tolerance h6
>3-6	+0, -0,008
>6-10	+0, -0,009
>10-18	+0, -0,011
>18-30	+0, -0,013
>30-50	+0, -0,016

WIDIA
VICTORY

■ GT21 • Form D Plug Chamfer • Through Coolant • Metric DIN 371 and 376 • For Steel and Stainless Steel

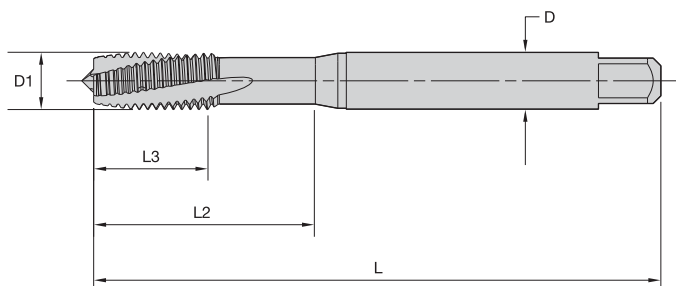


- first choice
- alternate choice

grade GP6520 TiCN		grade GM6515 TiN+CrC/C		metric dimensions					number of flutes	dimension standard	class of fit
order #	catalog #	order #	catalog #	D1 size	L	L3	L2	D			
3955054	GT215007	3955038	GT215001	M5 X 0,8	70	10	25	6,0	2	DIN 371	6HX
3955055	GT215008	3955039	GT215002	M6 X 1	80	10	30	6,0	3	DIN 371	6HX
3955056	GT215009	3955040	GT215003	M8 X 1,25	90	13	35	8,0	3	DIN 371	6HX
3955057	GT215010	3955041	GT215004	M10 X 1,5	100	15	39	10,0	3	DIN 371	6HX
3955058	GT215011	3955042	GT215005	M12 X 1,75	110	18	44	9,0	3	DIN 376	6HX
3955059	GT215012	3955053	GT215006	M14 X 2	110	20	52	11,0	4	DIN 376	6HX

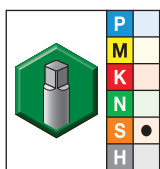
High-Performance Taps

- WS32MG TiCN for nickel and nickel alloys.



Shank Tolerance

D mm	tolerance h9
1-3	+0, -0,025
>3-6	+0, -0,030
>6-10	+0, -0,036
>10-18	+0, -0,043
>18-30	+0, -0,052


GT10 • Form D Plug Chamfer • Metric DIN 371 and 376 • For Nickel and Nickel Alloys


- first choice
- alternate choice

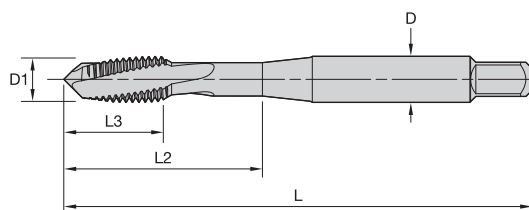
grade WS32MG TiCN		metric dimensions					number of flutes	dimension standard	class of fit
order #	catalog #	D1 size	L	L3	L2	D			
4160100	GT105001	M3 X 0,5	56	11	18	3,5	2	DIN 371	6HX
4160101	GT105002	M4 X 0,7	63	13	21	4,5	3	DIN 371	6HX
4160102	GT105003	M5 X 0,8	70	15	25	6,0	3	DIN 371	6HX
4160103	GT105004	M6 X 1	80	17	30	6,0	3	DIN 371	6HX
4160104	GT105005	M8 X 1,25	90	20	35	8,0	3	DIN 371	6HX
4160105	GT105006	M10 X 1,5	100	22	39	10,0	3	DIN 371	6HX
4160106	GT105007	M12 X 1,75	110	24	—	9,0	3	DIN 376	6HX
4160107	GT105008	M14 X 2	110	26	—	11,0	3	DIN 376	6HX
4160108	GT105009	M16 X 2	110	27	—	12,0	3	DIN 376	6HX
4160109	GT105010	M20 X 2,5	140	32	—	16,0	3	DIN 376	6HX

High-Performance Taps

Victory™ Left-Hand Spiral-Flute HSS-E-PM • Through Holes

WIDIA
GTD™

- WS39MG oxide/nitride for nickel- and cobalt-based alloys.
- WU32MG TiCN for nickel- and cobalt-based alloys.

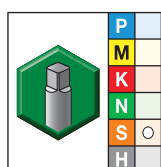
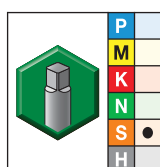


Shank Tolerance

D inch	tolerance h6
.118-.236	+0, -.0003
.236-.394	+0, -.0004
.394-.709	+0, -.0004
.709-1.181	+0, -.0005
1.181-1.969	+0, -.0006

WIDIA
VICTORY

■ GT90 • Machine Screw and Fractional • Form D Plug Chamfer • For Nickel- and Cobalt-Based Alloys



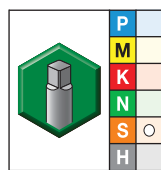
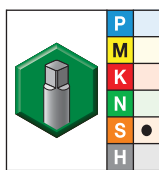
- first choice
- alternate choice

grade WU32MG TiCN		grade WS39MG Nitride/Oxide		inch dimensions					number of flutes	pitch diameter limit
order #	catalog #	order #	catalog #	D1 TPI	L	L3	L2	D		
5705547	GT905067	5705546	GT905001	2 - 56	1.75	.44	.50	.141	2	H2
5705055	GT905068	5705548	GT905002	4 - 40	1.88	.56	.69	.141	2	H2
5705550	GT905069	5705549	GT905003	4 - 40	1.88	.56	.69	.141	2	H3
5705552	GT905070	5705551	GT905004	4 - 40	1.88	.56	.69	.141	2	H4
5705554	GT905071	5705553	GT905005	4 - 48	1.88	.56	.69	.141	2	H2
5705556	GT905072	5705555	GT905006	5 - 40	1.94	.63	.75	.141	3	H2
5705558	GT905073	5705557	GT905007	6 - 32	2.00	.36	.72	.141	3	H2
5705025	GT905074	5705559	GT905008	6 - 32	2.00	.36	.72	.141	3	H3
-		5705560	GT905009	6 - 32	2.00	.36	.72	.141	3	H4
5705562	GT905076	5705561	GT905010	6 - 32	2.00	.36	.72	.141	3	H5
-		5705563	GT905011	6 - 32	2.00	.36	.72	.141	3	H7
5705565	GT905078	5705564	GT905012	6 - 40	2.00	.36	.72	.141	3	H2
5705567	GT905079	5705566	GT905013	8 - 32	2.13	.31	.77	.168	3	H2
5705024	GT905080	5705568	GT905014	8 - 32	2.13	.31	.77	.168	3	H3
5705570	GT905081	5705569	GT905015	8 - 32	2.13	.31	.77	.168	3	H4
5705572	GT905082	5705571	GT905016	8 - 32	2.13	.31	.77	.168	3	H5
-		5705573	GT905017	8 - 32	2.13	.31	.77	.168	3	H6
-		5705574	GT905018	8 - 32	2.13	.31	.77	.168	3	H7
5705501	GT905085	5705059	GT905019	10 - 24	2.38	.47	.92	.194	3	H3
5705503	GT905086	5705502	GT905020	10 - 24	2.38	.47	.92	.194	3	H5
-		5705504	GT905021	10 - 24	2.38	.47	.92	.194	3	H7
5705506	GT905088	5705505	GT905022	10 - 32	2.38	.47	.92	.194	3	H2
5705058	GT905089	5705507	GT905023	10 - 32	2.38	.47	.92	.194	3	H3
5705509	GT905090	5705508	GT905024	10 - 32	2.38	.47	.92	.194	3	H4

(continued)

WIDIA

(GT90 • Machine Screw and Fractional • Form D Plug Chamfer • For Nickel- and Cobalt-Based Alloys — continued)



- first choice
- alternate choice

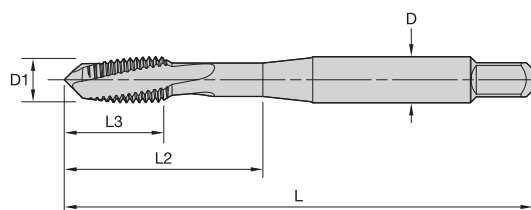
grade WU32MG TiCN		grade WS39MG Nitride/Oxide		inch dimensions					number of flutes	pitch diameter limit
order #	catalog #	order #	catalog #	D1 TPI	L	L3	L2	D		
5705541	GT905091	5705540	GT905025	10 - 32	2.38	.47	.92	.194	3	H5
5705543	GT905092	5705542	GT905026	10 - 32	2.38	.47	.92	.194	3	H6
5705545	GT905093	5705544	GT905027	10 - 32	2.38	.47	.92	.194	3	H7
5705062	GT905094	5705584	GT905028	1/4 - 20	2.51	.44	1.02	.255	3	H3
5705586	GT905095	5705585	GT905029	1/4 - 20	2.51	.44	1.02	.255	3	H5
5705588	GT905096	5705587	GT905030	1/4 - 20	2.51	.44	1.02	.255	3	H7
5705061	GT905097	5705060	GT905031	1/4 - 28	2.51	.44	1.02	.255	3	H3
5705591	GT905098	5705589	GT905032	1/4 - 28	2.51	.44	1.02	.255	3	H4
5705594	GT905099	5705593	GT905033	1/4 - 28	2.49	.44	1.02	.255	3	H5
5705596	GT905100	5705595	GT905034	1/4 - 28	2.51	.44	1.02	.255	3	H6
5705598	GT905101	5705597	GT905035	1/4 - 28	2.51	.44	1.02	.255	3	H7
5705054	GT905102	5705629	GT905036	5/16 - 18	2.73	.49	1.15	.318	3	H3
5705631	GT905103	5705630	GT905037	5/16 - 18	2.73	.49	1.15	.318	3	H5
5705633	GT905104	5705632	GT905038	5/16 - 18	2.73	.49	1.15	.318	3	H7
5705053	GT905105	5705634	GT905039	5/16 - 24	2.73	.49	1.15	.318	3	H3
5705636	GT905106	5705635	GT905040	5/16 - 24	2.73	.49	1.15	.318	3	H4
5705638	GT905107	5705637	GT905041	5/16 - 24	2.73	.49	1.15	.318	3	H5
5705640	GT905108	5705639	GT905042	5/16 - 24	2.73	.49	1.15	.318	3	H6
5705642	GT905109	5705641	GT905043	5/16 - 24	2.73	.49	1.15	.318	3	H7
5705615	GT905110	5705057	GT905044	3/8 - 16	2.95	.60	1.28	.381	3	H3
5705617	GT905111	5705616	GT905045	3/8 - 16	2.95	.60	1.28	.381	3	H5
5705619	GT905112	5705618	GT905046	3/8 - 16	2.95	.60	1.28	.381	3	H7
5705056	GT905113	5705620	GT905047	3/8 - 24	2.95	.60	1.28	.381	3	H3
5705622	GT905114	5705621	GT905048	3/8 - 24	2.95	.60	1.28	.381	3	H4
5705624	GT905115	5705623	GT905049	3/8 - 24	2.95	.60	1.28	.381	3	H5
5705626	GT905116	5705625	GT905050	3/8 - 24	2.95	.60	1.28	.381	3	H6
5705628	GT905117	5705627	GT905051	3/8 - 24	2.95	.60	1.28	.381	3	H7
5705647	GT905118	5705646	GT905052	7/16 - 14	3.16	.71	1.49	.323	3	H3
—		5705648	GT905053	7/16 - 14	3.16	.71	1.49	.323	3	H5
5705650	GT905120	5705649	GT905054	7/16 - 20	3.16	.71	1.49	.323	3	H3
5705652	GT905121	5705651	GT905055	7/16 - 20	3.16	.71	1.49	.323	3	H5
5705065	GT905122	5705575	GT905056	1/2 - 13	3.38	.77	1.74	.367	3	H3
5705577	GT905123	5705576	GT905057	1/2 - 13	3.38	.77	1.74	.367	3	H5
5705579	GT905124	5705578	GT905058	1/2 - 13	3.38	.77	1.74	.367	3	H7
5705064	GT905125	5705580	GT905059	1/2 - 20	3.38	.77	1.74	.367	3	H3
5705581	GT905126	5705063	GT905060	1/2 - 20	3.38	.77	1.74	.367	3	H5
5705583	GT905127	5705582	GT905061	1/2 - 20	3.38	.77	1.74	.367	3	H7
5705643	GT905128	5705026	GT905062	5/8 - 11	3.81	.91	1.89	.480	3	H3
5705645	GT905129	5705644	GT905063	5/8 - 18	3.81	.91	1.89	.480	3	H3
5705610	GT905130	5705599	GT905064	3/4 - 10	4.25	1.00	2.08	.590	3	H3
5705612	GT905131	5705611	GT905065	3/4 - 10	4.25	1.00	2.08	.590	3	H5
5705614	GT905132	5705613	GT905066	3/4 - 16	4.25	1.00	2.08	.590	3	H3

High-Performance Taps

Victory™ Left-Hand Spiral-Flute HSS-E-PM • Through Holes

WIDIA
GTD™

- WS39MG oxide/nitride for nickel- and cobalt-based alloys.
- WU32MG TiCN for nickel- and cobalt-based alloys.

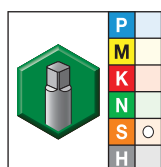
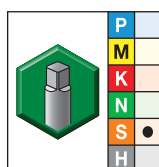


Shank Tolerance

D inch	tolerance h6
.118-.236	+0, -.0003
.236-.394	+0, -.0004
.394-.709	+0, -.0004
.709-1.181	+0, -.0005
1.181-1.969	+0, -.0006

WIDIA
VICTORY

■ GT90 • Form D Plug Chamfer • Metric ANSI • For Nickel- and Cobalt-Based Alloys

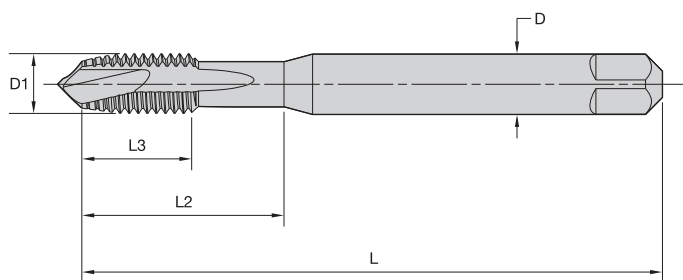


- first choice
- alternate choice

grade WU32MG TiCN		grade WS39MG Nitride/Oxide		inch dimensions					number of flutes	pitch diameter limit
order #	catalog #	order #	catalog #	D1 TPI	L	L3	L2	D		
5705660	GT905146	5705073	GT905133	M2,5 X 0,45	1.81	.50	.56	.141	2	D3
5705071	GT905147	5705662	GT905134	M3 X 0,5	1.94	.63	.75	.141	3	D3
5705661	GT905148	5705072	GT905135	M3,5 X 0,6	1.99	.36	.72	.141	3	D4
-		5705663	GT905136	M4 X 0,7	2.12	.32	.77	.168	3	D4
5705070	GT905149	-		M4 X 0,7	2.12	.36	.77	.168	3	D4
5705068	GT905150	5705069	GT905137	M5 X 0,8	2.38	.47	.92	.194	3	D4
5705067	GT905151	5705664	GT905138	M6 X 1	2.51	.46	1.01	.255	3	D5
-		5705665	GT905139	M7 X 1	2.73	.52	1.16	.318	3	D5
5705667	GT905153	5705666	GT905140	M8 X 1	2.72	.48	1.14	.318	3	D5
5705066	GT905154	5705668	GT905141	M8 X 1,25	2.72	.48	1.14	.318	3	D5
5705654	GT905155	5705653	GT905142	M10 X 1,25	2.94	.53	1.27	.381	3	D5
5705655	GT905156	5705656	GT905143	M10 X 1,5	2.94	.53	1.27	.381	3	D6
5705658	GT905157	5705657	GT905144	M12 X 1,25	3.38	.77	1.74	.367	3	D5
5705074	GT905158	5705659	GT905145	M12 X 1,75	3.38	.77	1.74	.367	3	D6

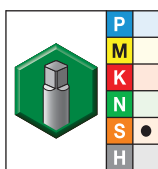
High-Performance Taps

- WN35MG TiN/DLC for titanium and titanium alloys.



Shank Tolerance

D mm	tolerance h9
1-3	+0, -0,025
>3-6	+0, -0,030
>6-10	+0, -0,036
>10-18	+0, -0,043
>18-30	+0, -0,052


■ GT14 • Form B Plug Chamfer • Metric DIN 371 and 376 • For Titanium and Titanium Alloys


- first choice
- alternate choice

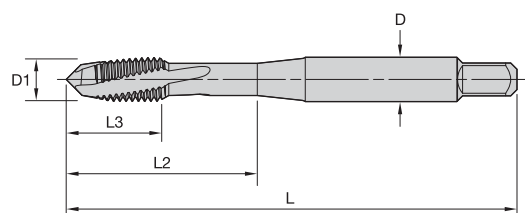
grade WN35MG TiN/DLC		metric dimensions					number of flutes	dimension standard	class of fit
order #	catalog #	D1 size	L	L3	L2	D			
4160093	GT145001	M3 X 0,5	56	11	18	3,5	3	DIN 371	6HX
4160094	GT145002	M4 X 0,7	63	13	21	4,5	3	DIN 371	6HX
4160095	GT145003	M5 X 0,8	70	15	25	6,0	3	DIN 371	6HX
4160096	GT145004	M6 X 1	80	17	30	6,0	3	DIN 371	6HX
4160097	GT145005	M8 X 1,25	90	20	35	8,0	3	DIN 371	6HX
4160098	GT145006	M10 X 1,5	100	22	39	10,0	3	DIN 371	6HX
4160099	GT145007	M12 X 1,75	110	24	—	9,0	3	DIN 376	6HX

High-Performance Taps

Victory™ Left-Hand Spiral-Flute HSS-E-PM Taps • Through Holes

WIDIA
GTD™

- WS30MG nitride for titanium and titanium alloys.
- WS34MG TiN + CrC/C for titanium and titanium alloys.

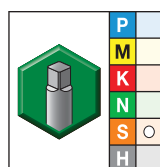
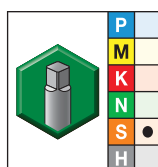


Shank Tolerance

D inch	tolerance h6
.118-.236	+0, -.0003
.236-.394	+0, -.0004
.394-.709	+0, -.0004
.709-1.181	+0, -.0005
1.181-1.969	+0, -.0006

WIDIA
VICTORY

■ GT60 • Machine Screw and Fractional • Form D Plug Chamfer • ANSI • For Titanium and Titanium Alloys



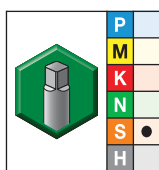
- first choice
- alternate choice

grade WS34MG TiN+CrC/C		grade WS30MG Nitride		inch dimensions					number of flutes	pitch diameter limit
order #	catalog #	order #	catalog #	D1 TPI	L	L3	L2	D		
5562739	GT605006	5562738	GT605005	2 - 56	1.75	.44	.50	.141	2	H2
5562941	GT605008	5562940	GT605007	4 - 40	1.88	.56	.69	.141	2	H2
5562943	GT605010	5562942	GT605009	6 - 32	1.99	.36	.71	.141	3	H2
5562945	GT605012	5562944	GT605011	6 - 32	1.99	.36	.71	.141	3	H3
5562947	GT605014	5562946	GT605013	6 - 40	1.99	.36	.71	.141	3	H2
5562949	GT605016	5562948	GT605015	8 - 32	2.12	.31	.76	.168	3	H2
5562951	GT605018	5562950	GT605017	8 - 32	2.12	.31	.76	.168	3	H3
5562953	GT605020	5562952	GT605019	8 - 36	2.12	.31	.76	.168	3	H2
5562955	GT605022	5562954	GT605021	10 - 24	2.37	.47	.91	.194	3	H3
5562957	GT605024	5562956	GT605023	10 - 32	2.37	.47	.91	.194	3	H2
5562959	GT605026	5562958	GT605025	10 - 32	2.37	.47	.91	.194	3	H3
5562961	GT605028	5562960	GT605027	1/4 - 20	2.50	.44	1.00	.255	3	H3
5562963	GT605030	5562962	GT605029	1/4 - 20	2.50	.44	1.00	.255	3	H5
5562965	GT605032	5562964	GT605031	1/4 - 28	2.50	.44	1.00	.255	3	H3
5562967	GT605034	5562966	GT605033	1/4 - 28	2.50	.44	1.00	.255	3	H4
5562969	GT605036	5562968	GT605035	5/16 - 18	2.72	.49	1.13	.318	3	H3
5562981	GT605038	5562980	GT605037	5/16 - 18	2.72	.49	1.13	.318	3	H5
5562983	GT605040	5562982	GT605039	5/16 - 24	2.72	.49	1.13	.318	3	H3
5562985	GT605042	5562984	GT605041	5/16 - 24	2.72	.49	1.13	.318	3	H4
5562987	GT605044	5562986	GT605043	3/8 - 16	2.93	.59	1.26	.381	3	H3
5562989	GT605046	5562988	GT605045	3/8 - 16	2.93	.59	1.26	.381	3	H5
5562991	GT605048	5562990	GT605047	3/8 - 24	2.93	.59	1.26	.381	3	H3
5562993	GT605050	5562992	GT605049	3/8 - 24	2.93	.59	1.26	.381	3	H4
5562995	GT605052	5562994	GT605051	7/16 - 14	3.16	.71	1.49	.323	3	H3

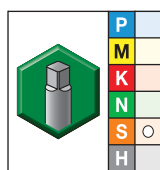
(continued)

WIDIA

(GT60 • Machinge Screw and Fractional • Form D Plug Chamfer • ANSI • For Titanium and Titanium Alloys — continued)



grade WS34MG
TiN+CrC/C



grade WS30MG
Nitride

- first choice
- alternate choice

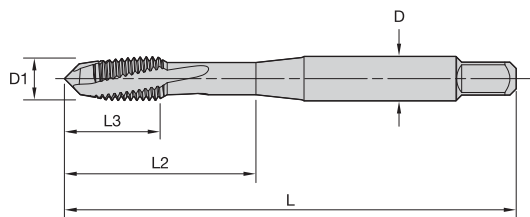
				inch dimensions					number of flutes	pitch diameter limit
order #	catalog #	order #	catalog #	D1 TPI	L	L3	L2	D		
5562997	GT605054	5562996	GT605053	7/16 - 20	3.16	.71	1.49	.323	3	H3
5562999	GT605056	5562998	GT605055	1/2 - 13	3.38	.77	1.74	.367	3	H3
5563011	GT605058	5563010	GT605057	1/2 - 20	3.38	.77	1.74	.367	3	H3
5563012	GT605059	—	—	9/16 - 18	3.59	.83	1.74	.429	4	H3
5563013	GT605060	—	—	9/16 - 18	3.59	.83	1.74	.429	4	H5
5563014	GT605061	—	—	5/8 - 11	3.81	.91	1.89	.480	4	H3
5563015	GT605062	—	—	5/8 - 18	3.81	.91	1.89	.480	4	H3
5563016	GT605063	—	—	5/8 - 18	3.81	.91	1.89	.480	4	H5
5563017	GT605064	—	—	3/4 - 10	4.25	1.00	2.08	.590	4	H5
5563018	GT605065	—	—	3/4 - 16	4.25	1.00	2.08	.590	4	H3
5563019	GT605066	—	—	3/4 - 16	4.25	1.00	2.08	.590	4	H5
5563020	GT605067	—	—	1 - 8	5.13	1.25	2.58	.800	5	H5

High-Performance Taps

Victory™ Left-Hand Spiral-Flute HSS-E-PM Taps • Through Holes

WIDIA
GTD™

- WS30MG nitride for titanium and titanium alloys.
- WS34MG TiN + CrC/C for titanium and titanium alloys.

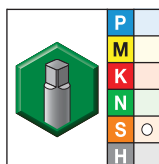
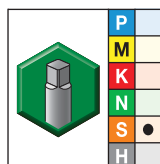


Shank Tolerance

D inch	tolerance h6
.118-.236	+0, -.0003
.236-.394	+0, -.0004
.394-.709	+0, -.0004
.709-1.181	+0, -.0005
1.181-1.969	+0, -.0006

WIDIA
VICTORY

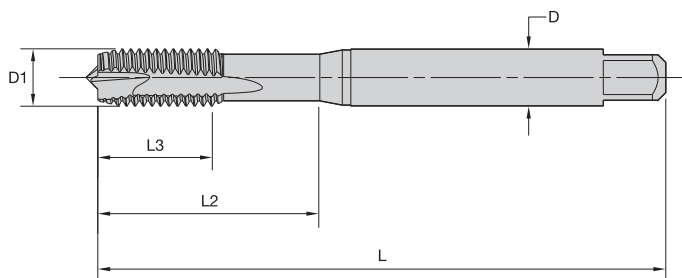
■ GT60 • Form D Plug Chamfer • Metric ANSI • For Titanium and Titanium Alloys



- first choice
- alternate choice

grade WS34MG TiN+CrC/C		grade WS30MG Nitride		inch dimensions					number of flutes	pitch diameter limit
order #	catalog #	order #	catalog #	D1 TPI	L	L3	L2	D		
5563022	GT605504	5563021	GT605503	M2,5 X 0,45	1.81	.49	.56	.141	3	D3
5563024	GT605506	5563023	GT605505	M3 X 0,5	1.94	.63	.75	.141	3	D3
5563026	GT605508	5563025	GT605507	M4 X 0,7	2.12	.32	.76	.168	3	D4
5563028	GT605510	5563027	GT605509	M5 X 0,8	2.37	.47	.91	.194	3	D4
5563040	GT605512	5563029	GT605511	M6 X 1	2.50	.16	1.00	.255	3	D5
5563042	GT605514	5563041	GT605513	M7 X 1	2.73	.52	1.15	.318	3	D5
5563044	GT605516	5563043	GT605515	M8 X 1,25	2.71	.48	1.12	.318	3	D5
5563046	GT605518	5563045	GT605517	M10 X 1,25	2.92	.53	1.26	.381	3	D5
5583927	GT605520	5583926	GT605519	M10 X 1,5	2.92	.53	1.26	.381	3	D6
5583929	GT605522	5583928	GT605521	M12 X 1,75	3.38	.77	1.74	.367	3	D6

- WN48EG DLC for aluminum.

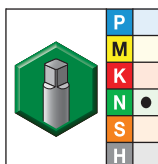


Shank Tolerance

D mm	tolerance h9
1-3	+0, -0,025
3,5-6	+0, -0,030
7-10	+0, -0,036
11-18	+0, -0,043



- GT70 • Form B Plug Chamfer • Metric DIN 371 and 376 • For Aluminum



- first choice
- alternate choice

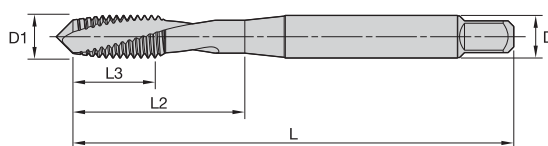
grade WN48EG DLC		metric dimensions					number of flutes	dimension standard	class of fit
order #	catalog #	D1 size	L	L3	L2	D			
4160036	GT705001	M3 X 0,5	56	11	18	3,5	2	DIN 371	6H
4160037	GT705002	M4 X 0,7	63	13	21	4,5	2	DIN 371	6H
4160038	GT705003	M5 X 0,8	70	15	25	6,0	2	DIN 371	6H
4160039	GT705004	M6 X 1	80	17	30	6,0	2	DIN 371	6H
4160040	GT705005	M8 X 1,25	90	20	35	8,0	2	DIN 371	6H
4160041	GT705006	M10 X 1,5	100	22	39	10,0	2	DIN 371	6H
4160042	GT705007	M12 X 1,75	110	24	—	9,0	3	DIN 376	6H
4160063	GT705008	M16 X 2	110	27	—	12,0	3	DIN 376	6H

High-Performance Taps

Victory™ Left-Hand Spiral-Flute HSS-E Taps • Through Holes

WIDIA
GTD™

- WN44EG TiN + CrC/C for aluminum.

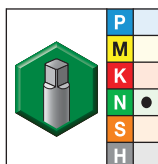


Shank Tolerance

D inch	tolerance h6
.118-.236	+0, -.0003
.236-.394	+0, -.0004
.394-.709	+0, -.0004
.709-1.181	+0, -.0005
1.181-1.969	+0, -.0006

WIDIA
VICTORY

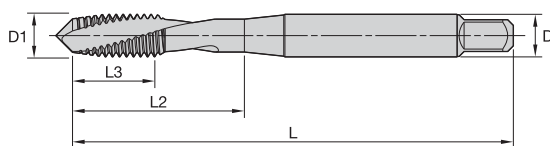
■ GT72 • Machine Screw and Fractional • Form D Plug Chamfer • DIN Length ANSI Shank • For Aluminum



- first choice
- alternate choice

grade WN44EG TiN+CrC/C		inch dimensions					number of flutes	pitch diameter limit
order #	catalog #	D1 TPI	L	L3	L2	D		
5690893	GT725010	2 - 56	1.77	.31	.71	.141	2	H2
5690894	GT725011	4 - 40	2.20	.31	.71	.141	2	H2
5690896	GT725012	5 - 40	2.20	.31	.71	.141	2	H2
5690897	GT725013	6 - 32	2.20	.35	.79	.141	2	H3
5690898	GT725014	8 - 32	2.48	.43	.83	.168	2	H3
5690899	GT725015	10 - 24	2.76	.47	.98	.194	2	H3
5690910	GT725016	10 - 32	2.76	.47	.98	.194	2	H3
5690911	GT725017	1/4 - 20	3.15	.59	1.18	.255	2	H3
5690912	GT725018	1/4 - 20	3.15	.59	1.18	.255	2	H5
5690913	GT725019	1/4 - 28	3.15	.59	1.18	.255	2	H3
5690914	GT725020	1/4 - 28	3.15	.59	1.18	.255	2	H4
5690915	GT725021	5/16 - 18	3.54	.59	1.38	.318	2	H3
5690917	GT725022	5/16 - 18	3.54	.59	1.38	.318	2	H5
5690918	GT725023	5/16 - 24	3.54	.59	1.38	.318	2	H3
5690919	GT725024	5/16 - 24	3.54	.59	1.38	.318	2	H4
5690920	GT725025	3/8 - 16	3.94	.75	1.54	.381	2	H3
5690921	GT725026	3/8 - 16	3.94	.75	1.54	.381	2	H5
5690922	GT725027	3/8 - 24	3.94	.75	1.54	.381	2	H3
5690923	GT725028	3/8 - 24	3.94	.75	1.54	.381	2	H4
5690924	GT725029	7/16 - 14	3.94	.71	1.61	.323	3	H3
5690925	GT725030	7/16 - 14	3.94	.71	1.61	.323	3	H5
5690926	GT725031	7/16 - 20	3.94	.71	1.61	.323	3	H3
5690927	GT725032	7/16 - 20	3.94	.71	1.61	.323	3	H5
5690928	GT725033	1/2 - 13	4.33	.91	1.85	.367	3	H4
5690929	GT725034	1/2 - 13	4.33	.91	1.85	.367	3	H5
5690930	GT725035	1/2 - 20	4.33	.91	1.85	.367	3	H3
5690931	GT725036	1/2 - 20	4.33	.91	1.85	.367	3	H5

- WN44EG TiN + CrC/C for aluminum.

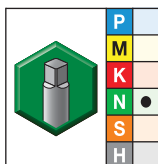


Shank Tolerance

D inch	tolerance h6
.118-.236	+0, -.0003
.236-.394	+0, -.0004
.394-.709	+0, -.0004
.709-1.181	+0, -.0005
1.181-1.969	+0, -.0006



- GT72 • Form D Plug Chamfer • Metric • DIN Length ANSI Shank • For Aluminum



- first choice
- alternate choice

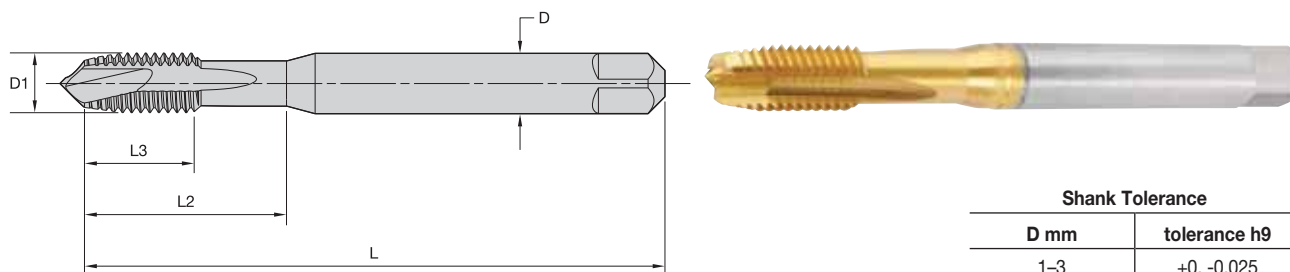
grade WN44EG TiN+CrC/C		inch dimensions					number of flutes	pitch diameter limit
order #	catalog #	D1 TPI	L	L3	L2	D		
5690933	GT725037	M3 X 0,5	2.20	.31	.71	.141	2	D3
5690934	GT725038	M3,5 X 0,6	2.20	.35	.79	.141	2	D4
5690935	GT725039	M4 X 0,7	2.48	.43	.83	.168	2	D4
5690936	GT725040	M5 X 0,8	2.76	.47	.98	.194	2	D4
5690937	GT725041	M6 X 1	3.15	.47	1.18	.255	2	D5
5690938	GT725042	M7 X 1	3.54	.59	1.38	.318	2	D5
5690939	GT725043	M8 X 1	3.54	.59	1.38	.318	2	D5
5690940	GT725044	M8 X 1,25	3.54	.59	1.38	.318	2	D5
5690941	GT725045	M10 X 1,25	3.94	.71	1.54	.381	2	D5
5690942	GT725046	M10 X 1,5	3.94	.71	1.54	.381	2	D6
5690943	GT725047	M12 X 1,25	4.33	.83	1.73	.367	3	D6
5690944	GT725048	M12 X 1,5	4.33	.83	1.73	.367	3	D6
5690945	GT725049	M12 X 1,75	4.33	.83	1.73	.367	3	D6

High-Performance Taps

Victory™ Spiral-Point Plug HSS-E-PM Taps • Through Holes

WIDIA
GTD™

- WP31MG TiN for steel
32–44 HRC.

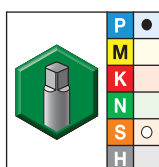


Shank Tolerance

D mm	tolerance h9
1–3	+0, -0,025
>3–6	+0, -0,030
>6–10	+0, -0,036
>10–18	+0, -0,043
>18–30	+0, -0,052

WIDIA
VICTORY

■ GT00 • Form B Plug Chamfer • Metric DIN 371, 374, and 376 • For Hard Steel

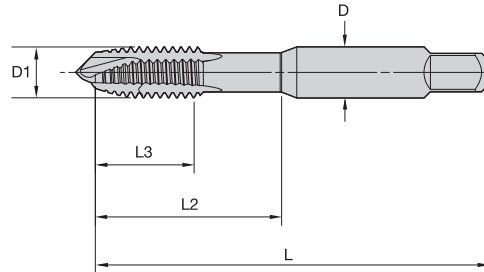


- first choice
- alternate choice

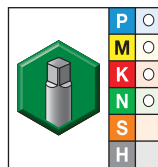
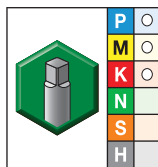
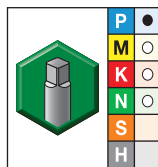
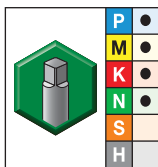
grade WP31MG TiN		metric dimensions					number of flutes	dimension standard	class of fit
order #	catalog #	D1 size	L	L3	L2	D			
4153679	GT005001	M3 X 0,5	56	11	18	3,5	2	DIN 371	6HX
4153680	GT005002	M4 X 0,7	63	13	21	4,5	2	DIN 371	6HX
4153681	GT005003	M5 X 0,8	70	15	25	6,0	2	DIN 371	6HX
4153682	GT005004	M6 X 1	80	17	30	6,0	3	DIN 371	6HX
4153760	GT005012	M8 X 1	90	17	—	6,0	3	DIN 374	6HX
4153753	GT005005	M8 X 1,25	90	20	35	8,0	3	DIN 371	6HX
4153761	GT005013	M10 X 1	90	18	—	7,0	3	DIN 374	6HX
4153762	GT005014	M10 X 1,25	100	22	—	7,0	3	DIN 374	6HX
4153754	GT005006	M10 X 1,5	100	22	39	10,0	3	DIN 371	6HX
4153763	GT005015	M12 X 1,25	100	22	—	9,0	3	DIN 374	6HX
4153764	GT005016	M12 X 1,5	100	22	—	9,0	3	DIN 374	6HX
4153755	GT005007	M12 X 1,75	110	24	—	9,0	3	DIN 376	6HX
4153765	GT005017	M14 X 1,5	100	22	—	11,0	3	DIN 374	6HX
4153756	GT005008	M14 X 2	110	26	—	11,0	3	DIN 376	6HX
4153766	GT005018	M16 X 1,5	100	22	—	12,0	4	DIN 374	6HX
4153757	GT005009	M16 X 2	110	27	—	12,0	4	DIN 376	6HX
4153758	GT005010	M18 X 2	125	30	—	14,0	4	DIN 376	6HX
4153759	GT005011	M20 X 2,5	140	32	—	16,0	4	DIN 376	6HX

High-Performance Taps

- WP42EG TiCN
- WU41EG TiN
- WP49EG oxide
- WU40EG bright



Shank Tolerance	
D inch	tolerance
.141-.635	+0, -.0015
>.635-1.51	+0, -.0020
>1.51-2.01	+0, -.0030

■ VT-SPO • Form B Plug Chamfer • Machine Screw and Fractional • ANSI


- first choice
- alternate choice

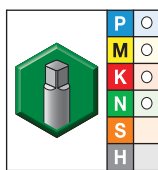
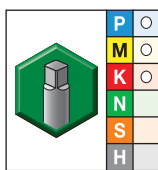
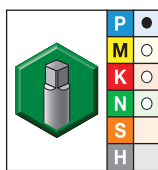
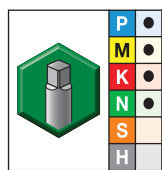
grade WP42EG TiCN		grade WU41EG TiN		grade WP49EG Oxide		grade WU40EG Bright		inch dimensions					number of flutes	pitch diameter limit
order #	catalog #	order #	catalog #	order #	catalog #	order #	catalog #	D1	TPI	L	L3	L2	D	
5357242	VTSP05001	-	-	5357241	VTSP05001	5357243	VTSP05001	2 - 56	1.75	.39	.50	.141	2	H2
-	-	-	-	5357244	VTSP05002	-	-	2 - 56	1.75	.39	.50	.141	2	H3
-	-	-	-	5357245	VTSP05003	-	-	2 - 56	1.75	.39	.50	.141	2	H4
5357247	VTSP05004	-	-	5357246	VTSP05004	5357248	VTSP05004	3 - 48	1.82	.45	.57	.141	2	H2
5357260	VTSP05005	5357261	VTSP05005	5357249	VTSP05005	5357262	VTSP05005	4 - 40	1.88	.51	.69	.141	2	H2
5357264	VTSP05006	-	-	5357263	VTSP05006	5357265	VTSP05006	4 - 40	1.88	.51	.69	.141	2	H3
5357267	VTSP05007	-	-	5357266	VTSP05007	5357268	VTSP05007	4 - 40	1.88	.51	.69	.141	2	H4
5357272	VTSP05008	-	-	5357271	VTSP05008	5357273	VTSP05008	4 - 40	1.88	.51	.69	.141	2	H5
-	-	-	-	5357274	VTSP05009	-	-	4 - 40	1.88	.51	.69	.141	2	H6
5357276	VTSP05010	-	-	5357275	VTSP05010	5357277	VTSP05010	4 - 48	1.88	.51	.69	.141	2	H2
-	-	-	-	5357278	VTSP05011	-	-	4 - 48	1.88	.51	.69	.141	2	H4
5357280	VTSP05012	-	-	5357279	VTSP05012	5357281	VTSP05012	5 - 40	1.94	.58	.75	.141	2	H2
5357283	VTSP05013	-	-	5357282	VTSP05013	5357284	VTSP05013	6 - 32	1.99	.38	.71	.141	2	H2
5357286	VTSP05014	5357287	VTSP05014	5357285	VTSP05014	5357288	VTSP05014	6 - 32	1.99	.38	.71	.141	2	H3
5357290	VTSP05015	-	-	5357289	VTSP05015	5357291	VTSP05015	6 - 32	1.99	.38	.71	.141	2	H4
5357293	VTSP05016	-	-	5357292	VTSP05016	5357294	VTSP05016	6 - 32	1.99	.38	.71	.141	2	H5
5357296	VTSP05017	-	-	5357295	VTSP05017	5357297	VTSP05017	6 - 32	1.99	.38	.71	.141	2	H6
5357299	VTSP05018	-	-	5357298	VTSP05018	5357300	VTSP05018	6 - 32	1.99	.38	.71	.141	2	H7
5365704	VTSP05019	-	-	5365703	VTSP05019	5365705	VTSP05019	6 - 32	1.99	.38	.71	.141	2	H11
5365707	VTSP05020	-	-	5365706	VTSP05020	5365708	VTSP05020	6 - 40	1.99	.38	.71	.141	2	H2
-	-	-	-	5365709	VTSP05021	-	-	6 - 40	1.99	.38	.71	.141	2	H3
5365741	VTSP05022	-	-	5365740	VTSP05022	5365742	VTSP05022	8 - 32	2.12	.38	.76	.168	2	H2
5365744	VTSP05023	5365745	VTSP05023	5365743	VTSP05023	5365746	VTSP05023	8 - 32	2.12	.38	.76	.168	2	H3
5365748	VTSP05024	-	-	5365747	VTSP05024	5365749	VTSP05024	8 - 32	2.12	.38	.76	.168	2	H4

(continued)

Multipurpose Taps

VariTap™ Spiral-Point HSS-E Taps • Through Holes

(VT-SPO • Form B Plug Chamfer • Machine Screw and Fractional • ANSI — continued)

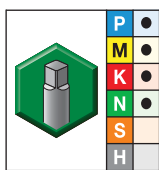
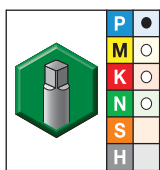
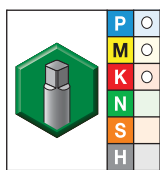
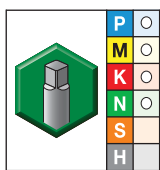


● first choice
○ alternate choice

grade WP42EG TiCN		grade WU41EG TiN		grade WP49EG Oxide		grade WU40EG Bright		inch dimensions					number of flutes	pitch diameter limit
order #	catalog #	order #	catalog #	order #	catalog #	order #	catalog #	D1 TPI	L	L3	L2	D		
5365751	VTSP05025	—	—	5365750	VTSP05025	5365752	VTSP05025	8 - 32	2.12	.38	.76	.168	2	H5
5365754	VTSP05026	—	—	5365753	VTSP05026	5365755	VTSP05026	8 - 32	2.12	.38	.76	.168	2	H6
5365758	VTSP05027	—	—	5365757	VTSP05027	5365760	VTSP05027	8 - 32	2.12	.38	.76	.168	2	H7
5365765	VTSP05028	—	—	5365762	VTSP05028	5365767	VTSP05028	8 - 32	2.12	.38	.76	.168	2	H11
5365771	VTSP05029	—	—	5365769	VTSP05029	5365773	VTSP05029	8 - 36	2.11	.38	.76	.168	2	H2
5365776	VTSP05030	5365778	VTSP05030	5365774	VTSP05030	5365780	VTSP05030	10 - 24	2.37	.50	.91	.194	2	H3
—	—	—	—	5365782	VTSP05031	—	—	10 - 24	2.37	.50	.91	.194	2	H4
5365786	VTSP05032	—	—	5365784	VTSP05032	5365788	VTSP05032	10 - 24	2.37	.50	.91	.194	2	H5
—	—	—	—	5365790	VTSP05033	—	—	10 - 24	2.37	.50	.91	.194	2	H6
—	—	—	—	5365792	VTSP05034	—	—	10 - 24	2.37	.50	.91	.194	2	H7
5365796	VTSP05035	—	—	5365794	VTSP05035	5365798	VTSP05035	10 - 24	2.37	.50	.91	.194	2	H11
5365759	VTSP05036	—	—	5365756	VTSP05036	5365761	VTSP05036	10 - 32	2.36	.50	.91	.194	2	H2
5365764	VTSP05037	5365766	VTSP05037	5365763	VTSP05037	5365768	VTSP05037	10 - 32	2.36	.50	.91	.194	2	H3
5365772	VTSP05038	—	—	5365770	VTSP05038	5365775	VTSP05038	10 - 32	2.36	.50	.91	.194	2	H4
5365779	VTSP05039	—	—	5365777	VTSP05039	5365781	VTSP05039	10 - 32	2.36	.50	.91	.194	2	H5
5365785	VTSP05040	—	—	5365783	VTSP05040	5365787	VTSP05040	10 - 32	2.36	.50	.91	.194	2	H6
5365791	VTSP05041	—	—	5365789	VTSP05041	5365793	VTSP05041	10 - 32	2.36	.50	.91	.194	2	H7
5365797	VTSP05042	—	—	5365795	VTSP05042	5365799	VTSP05042	10 - 32	2.36	.50	.91	.194	2	H11
5365801	VTSP05043	—	—	5365800	VTSP05043	5365802	VTSP05043	12 - 24	2.37	.50	.96	.220	2	H3
5365804	VTSP05044	—	—	5365803	VTSP05044	5365805	VTSP05044	12 - 28	2.37	.50	.96	.220	2	H3
5365807	VTSP05045	5365808	VTSP05045	5365806	VTSP05045	5365809	VTSP05045	1/4 - 20	2.50	.63	1.00	.255	3	H3
5365821	VTSP05046	—	—	5365820	VTSP05046	5365822	VTSP05046	1/4 - 20	2.50	.63	1.00	.255	3	H5
5365825	VTSP05047	—	—	5365823	VTSP05047	5365824	VTSP05047	1/4 - 20	2.50	.63	1.00	.255	3	H7
5365827	VTSP05048	—	—	5365826	VTSP05048	5365828	VTSP05048	1/4 - 20	2.50	.63	1.00	.255	3	H11
5365840	VTSP05049	5365841	VTSP05049	5365829	VTSP05049	5365842	VTSP05049	1/4 - 28	2.50	.63	1.00	.255	3	H3
5365844	VTSP05050	—	—	5365843	VTSP05050	5365845	VTSP05050	1/4 - 28	2.50	.63	1.00	.255	3	H4
5365849	VTSP05051	—	—	5365848	VTSP05051	5365920	VTSP05051	1/4 - 28	2.50	.63	1.01	.255	3	H5
5365922	VTSP05052	—	—	5365921	VTSP05052	5365923	VTSP05052	1/4 - 28	2.50	.63	1.01	.255	3	H6
5365925	VTSP05053	—	—	5365924	VTSP05053	5365927	VTSP05053	1/4 - 28	2.50	.63	1.01	.255	3	H7
5365929	VTSP05054	—	—	5365928	VTSP05054	5365930	VTSP05054	1/4 - 28	2.50	.63	1.01	.255	3	H11
5365932	VTSP05055	5365933	VTSP05055	5365931	VTSP05055	5365934	VTSP05055	5/16 - 18	2.72	.69	1.14	.318	3	H3
5365936	VTSP05056	—	—	5365935	VTSP05056	5365937	VTSP05056	5/16 - 18	2.72	.69	1.14	.318	3	H5
5365939	VTSP05057	—	—	5365938	VTSP05057	5365940	VTSP05057	5/16 - 18	2.72	.69	1.14	.318	3	H7
5365942	VTSP05058	—	—	5365941	VTSP05058	5365943	VTSP05058	5/16 - 18	2.72	.69	1.14	.318	3	H11
5365946	VTSP05059	5365947	VTSP05059	5365945	VTSP05059	5365948	VTSP05059	5/16 - 24	2.72	.69	1.14	.318	3	H3
5365960	VTSP05060	—	—	5365949	VTSP05060	5365961	VTSP05060	5/16 - 24	2.72	.69	1.14	.318	3	H4
5365963	VTSP05061	—	—	5365962	VTSP05061	5365964	VTSP05061	5/16 - 24	2.72	.69	1.14	.318	3	H5
5365966	VTSP05062	—	—	5365965	VTSP05062	5365967	VTSP05062	5/16 - 24	2.72	.69	1.14	.318	3	H6
5365969	VTSP05063	—	—	5365968	VTSP05063	5365970	VTSP05063	5/16 - 24	2.72	.69	1.14	.318	3	H7
5365972	VTSP05064	—	—	5365971	VTSP05064	5365973	VTSP05064	5/16 - 24	2.72	.69	1.14	.318	3	H11

(continued)

(VT-SPO • Form B Plug Chamfer • Machine Screw and Fractional • ANSI — continued)


 grade WP42EG
TiCN

 grade WU41EG
TiN

 grade WP49EG
Oxide

 grade WU40EG
Bright

 ● first choice
 ○ alternate choice

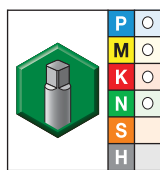
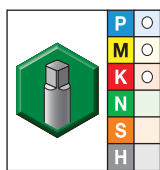
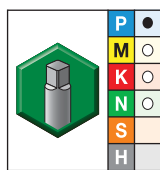
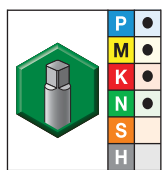
								inch dimensions					number of flutes	pitch diameter limit
order #	catalog #	order #	catalog #	order #	catalog #	order #	catalog #	D1 TPI	L	L3	L2	D		
5365975	VTSP05065	5365976	VTSP05065	5365974	VTSP05065	5365977	VTSP05065	3/8 - 16	2.94	.75	1.27	.381	3	H3
5366898	VTSP05066	—	—	5366897	VTSP05066	5366899	VTSP05066	3/8 - 16	2.94	.75	1.27	.381	3	H5
5366941	VTSP05067	—	—	5366940	VTSP05067	5366942	VTSP05067	3/8 - 16	2.94	.75	1.27	.381	3	H7
5366944	VTSP05068	—	—	5366943	VTSP05068	5366945	VTSP05068	3/8 - 16	2.94	.75	1.27	.381	3	H11
5366947	VTSP05069	5366948	VTSP05069	5366946	VTSP05069	5366949	VTSP05069	3/8 - 24	2.94	.75	1.27	.381	3	H3
5366951	VTSP05070	—	—	5366950	VTSP05070	5366952	VTSP05070	3/8 - 24	2.94	.75	1.27	.381	3	H4
5366954	VTSP05071	—	—	5366953	VTSP05071	5366955	VTSP05071	3/8 - 24	2.94	.75	1.27	.381	3	H5
5366957	VTSP05072	—	—	5366956	VTSP05072	5366958	VTSP05072	3/8 - 24	2.94	.75	1.27	.381	3	H6
5366960	VTSP05073	—	—	5366959	VTSP05073	5366961	VTSP05073	3/8 - 24	2.94	.75	1.27	.381	3	H7
5366963	VTSP05074	—	—	5366962	VTSP05074	5366964	VTSP05074	3/8 - 24	2.94	.75	1.27	.381	3	H11
5366966	VTSP05075	5366967	VTSP05075	5366965	VTSP05075	5366968	VTSP05075	7/16 - 14	3.16	.88	1.49	.323	3	H3
5366970	VTSP05076	—	—	5366969	VTSP05076	5366971	VTSP05076	7/16 - 14	3.16	.88	1.49	.323	3	H5
5366973	VTSP05077	—	—	5366972	VTSP05077	5366974	VTSP05077	7/16 - 14	3.16	.88	1.49	.323	3	H7
5366976	VTSP05078	—	—	5366975	VTSP05078	5366977	VTSP05078	7/16 - 14	3.16	.88	1.49	.323	3	H11
5366979	VTSP05079	5366980	VTSP05079	5366978	VTSP05079	5366981	VTSP05079	7/16 - 20	3.16	.88	1.49	.323	3	H3
5366983	VTSP05080	—	—	5366982	VTSP05080	5366984	VTSP05080	7/16 - 20	3.16	.88	1.49	.323	3	H5
—	—	—	—	5366036	VTSP05081	—	—	7/16 - 20	3.16	.88	1.49	.323	3	H6
5366038	VTSP05082	—	—	5366037	VTSP05082	5366039	VTSP05082	7/16 - 20	3.16	.88	1.49	.323	3	H7
5366071	VTSP05083	—	—	5366070	VTSP05083	5366073	VTSP05083	7/16 - 20	3.16	.88	1.49	.323	3	H11
5366075	VTSP05084	5366076	VTSP05084	5366074	VTSP05084	5366077	VTSP05084	1/2 - 13	3.38	.94	1.74	.367	3	H3
5366079	VTSP05085	—	—	5366078	VTSP05085	5366080	VTSP05085	1/2 - 13	3.38	.94	1.74	.367	3	H5
5366083	VTSP05086	—	—	5366081	VTSP05086	5366084	VTSP05086	1/2 - 13	3.38	.94	1.74	.367	3	H7
5366086	VTSP05087	—	—	5366085	VTSP05087	5366087	VTSP05087	1/2 - 13	3.38	.94	1.74	.367	3	H11
5366089	VTSP05088	5366110	VTSP05088	5366088	VTSP05088	5366111	VTSP05088	1/2 - 20	3.38	.94	1.74	.367	3	H3
5366113	VTSP05089	—	—	5366112	VTSP05089	5366114	VTSP05089	1/2 - 20	3.38	.94	1.74	.367	3	H5
—	—	—	—	5366115	VTSP05090	—	—	1/2 - 20	3.38	.94	1.74	.367	3	H6
5366117	VTSP05091	—	—	5366116	VTSP05091	5366118	VTSP05091	1/2 - 20	3.38	.94	1.74	.367	3	H7
5366130	VTSP05092	—	—	5366119	VTSP05092	5366131	VTSP05092	1/2 - 20	3.38	.94	1.74	.367	3	H11
5366133	VTSP05093	5366134	VTSP05093	5366132	VTSP05093	5366135	VTSP05093	9/16 - 12	3.59	1.00	1.74	.429	3	H3
5366137	VTSP05094	5366138	VTSP05094	5366136	VTSP05094	5366139	VTSP05094	9/16 - 18	3.59	1.00	1.74	.429	3	H3
5366141	VTSP05095	5366142	VTSP05095	5366140	VTSP05095	5366143	VTSP05095	5/8 - 11	3.81	1.09	1.89	.480	3	H3
5366145	VTSP05096	—	—	5366144	VTSP05096	5366146	VTSP05096	5/8 - 11	3.81	1.09	1.89	.480	3	H5
—	—	—	—	5367003	VTSP05097	—	—	5/8 - 11	3.81	1.09	1.89	.480	3	H7
5367005	VTSP05098	—	—	5367004	VTSP05098	5367006	VTSP05098	5/8 - 18	3.81	1.09	1.89	.480	3	H3
5367008	VTSP05099	—	—	5367007	VTSP05099	5367009	VTSP05099	5/8 - 18	3.81	1.09	1.89	.480	3	H5
—	—	—	—	5367030	VTSP05100	—	—	5/8 - 18	3.81	1.09	1.89	.480	3	H6
5367032	VTSP05101	—	—	5367031	VTSP05101	5367033	VTSP05101	5/8 - 18	3.81	1.09	1.89	.480	3	H7
5367035	VTSP05102	5367036	VTSP05102	5367034	VTSP05102	5367037	VTSP05102	3/4 - 10	4.25	1.22	2.08	.590	3	H3
5367039	VTSP05103	—	—	5367038	VTSP05103	5367060	VTSP05103	3/4 - 10	4.25	1.22	2.08	.590	3	H5
5367062	VTSP05104	5367063	VTSP05104	5367061	VTSP05104	5367064	VTSP05104	3/4 - 16	4.25	1.22	2.08	.590	3	H3

(continued)

Multipurpose Taps

VariTap™ Spiral-Point HSS-E Taps • Through Holes

(VT-SPO • Form B Plug Chamfer • Machine Screw and Fractional • ANSI — continued)

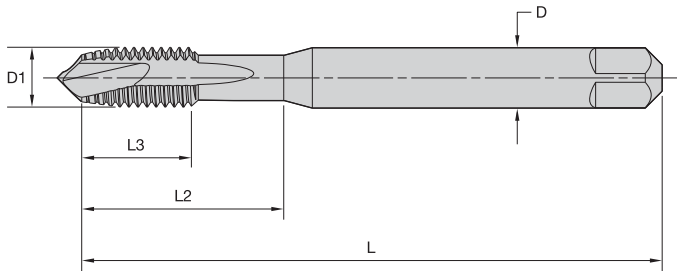


● first choice
○ alternate choice

grade WP42EG TiCN		grade WU41EG TiN		grade WP49EG Oxide		grade WU40EG Bright		inch dimensions					number of flutes	pitch diameter limit
order #	catalog #	order #	catalog #	order #	catalog #	order #	catalog #	D1 TPI	L	L3	L2	D		
5367066	VTSP05105	—	—	5367065	VTSP05105	5367067	VTSP05105	3/4 - 16	4.25	1.22	2.08	.590	3	H5
5367069	VTSP05106	5367070	VTSP05106	5367068	VTSP05106	5367071	VTSP05106	7/8 - 9	4.69	1.34	2.30	.697	3	H4
5367073	VTSP05107	—	—	5367072	VTSP05107	5367074	VTSP05107	7/8 - 9	4.69	1.34	2.30	.697	3	H5
5367076	VTSP05108	—	—	5367075	VTSP05108	5367078	VTSP05108	7/8 - 14	4.69	1.34	2.30	.697	3	H4
5366406	VTSP05109	5366407	VTSP05109	5366404	VTSP05109	5366408	VTSP05109	1 - 8	5.13	1.50	2.58	.800	3	H5
5366440	VTSP05110	—	—	5366409	VTSP05110	5366441	VTSP05110	1 - 12	5.13	1.50	2.58	.800	3	H4
—	—	—	—	5366442	VTSP05111	—	—	1 1/8 - 7	5.44	1.71	2.56	.896	4	H6
—	—	—	—	5366443	VTSP05112	—	—	1 1/8 - 8	5.44	1.71	2.56	.896	4	H6
—	—	—	—	5366444	VTSP05113	—	—	1 1/8 - 12	5.44	1.71	2.56	.896	4	H5
—	—	—	—	5366445	VTSP05114	—	—	1 1/4 - 7	5.75	1.71	2.56	1.021	4	H6
—	—	—	—	5366446	VTSP05115	—	—	1 1/4 - 8	5.75	1.71	2.56	1.020	4	H6
—	—	—	—	5366447	VTSP05116	—	—	1 1/4 - 12	5.75	1.71	2.56	1.021	4	H5
—	—	—	—	5366448	VTSP05117	—	—	1 3/8 - 6	6.07	2.00	3.00	1.108	4	H6
—	—	—	—	5366449	VTSP05118	—	—	1 3/8 - 8	6.07	2.00	3.00	1.108	4	H6
—	—	—	—	5366450	VTSP05119	—	—	1 3/8 - 12	6.07	2.00	3.00	1.108	4	H5
—	—	—	—	5366451	VTSP05120	—	—	1 1/2 - 6	6.38	2.00	3.00	1.233	4	H6
—	—	—	—	5366452	VTSP05121	—	—	1 1/2 - 8	6.38	2.00	3.00	1.233	4	H6
—	—	—	—	5366453	VTSP05122	—	—	1 1/2 - 12	6.38	2.00	3.00	1.233	4	H5
—	—	—	—	5366454	VTSP05123	—	—	2 - 4 1/2	7.63	2.67	3.56	1.643	4	H7

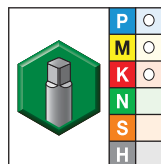
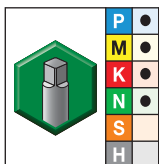
NOTE: Refer to tables on pages W231–W232 for the recommended pitch diameter limit for 2B or 3B class of fit.
VariTap™ for 3B class of fit is suitable for UNJ aerospace internal threading applications.

- WP42EG TiCN
- WP49EG oxide



Shank Tolerance	
D inch	tolerance
.141-.635	+0, -.0015
>.635-1.51	+0, -.0020
>1.51-2.01	+0, -.0030

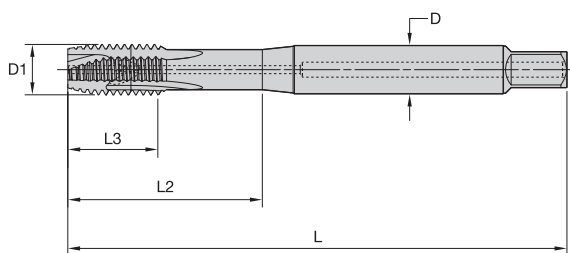
■ VT-SPO • Form B Plug Chamfer • Machine Screw and Fractional • DIN Length ANSI Shank



- first choice
- alternate choice

grade WP42EG TiCN		grade WP49EG Oxide		inch dimensions					number of flutes	dimension standard	class of fit
order #	catalog #	order #	catalog #	D1 TPI	L	L3	L2	D			
5366572	VTSP09004	5366571	VTSP09004	4 - 40	2.20	.31	.71	.141	2	DIN-ANSI	2B
5366574	VTSP09005	5366573	VTSP09005	6 - 32	2.20	.35	.79	.141	2	DIN-ANSI	2B
5366576	VTSP09006	5366575	VTSP09006	8 - 32	2.48	.43	.83	.168	2	DIN-ANSI	2B
5366578	VTSP09007	5366577	VTSP09007	10 - 24	2.76	.47	.98	.194	2	DIN-ANSI	2B
5366580	VTSP09008	5366579	VTSP09008	10 - 32	2.75	.47	.98	.194	2	DIN-ANSI	2B
5366582	VTSP09009	5366581	VTSP09009	1/4 - 20	3.15	.59	1.18	.255	3	DIN-ANSI	2B
5366584	VTSP09010	5366583	VTSP09010	1/4 - 28	3.14	.58	1.17	.255	3	DIN-ANSI	2B
5366586	VTSP09011	5366585	VTSP09011	5/16 - 18	3.54	.59	1.38	.318	3	DIN-ANSI	2B
5366588	VTSP09012	5366587	VTSP09012	5/16 - 24	3.54	.59	1.38	.318	3	DIN-ANSI	2B
5366590	VTSP09013	5366589	VTSP09013	3/8 - 16	3.94	.75	1.54	.381	3	DIN-ANSI	2B
5366592	VTSP09014	5366591	VTSP09014	3/8 - 24	3.94	.75	1.54	.381	3	DIN-ANSI	2B
5366594	VTSP09015	5366593	VTSP09015	7/16 - 14	3.94	.71	1.61	.323	3	DIN-ANSI	2B
5366596	VTSP09016	5366595	VTSP09016	7/16 - 20	3.94	.71	1.61	.323	3	DIN-ANSI	2B
5366598	VTSP09017	5366597	VTSP09017	1/2 - 13	4.33	.91	1.85	.367	3	DIN-ANSI	2B
5366600	VTSP09018	5366599	VTSP09018	1/2 - 20	4.33	.91	1.85	.367	3	DIN-ANSI	2B
5366602	VTSP09019	5366601	VTSP09019	5/8 - 11	4.33	.94	2.01	.480	3	DIN-ANSI	2B
5366604	VTSP09020	5366603	VTSP09020	5/8 - 18	4.33	.94	2.01	.480	3	DIN-ANSI	2B
5366606	VTSP09021	5366605	VTSP09021	3/4 - 10	4.92	1.18	2.52	.590	3	DIN-ANSI	2B
5366608	VTSP09022	5366607	VTSP09022	3/4 - 16	4.92	1.18	2.52	.590	3	DIN-ANSI	2B

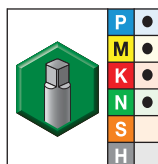
- WP42EG TiCN



Shank Tolerance

D inch	tolerance
.141-.635	+0, -.0015
>.635-1.51	+0, -.0020
>1.51-2.01	+0, -.0030

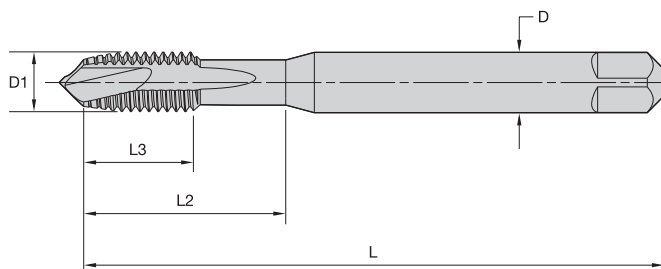
■ VT-SPO • Form B Plug Chamfer • Through Coolant • Fractional • DIN Length ANSI Shank



- first choice
- alternate choice

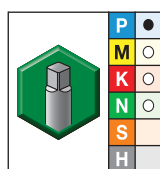
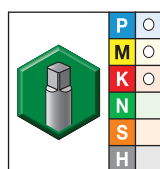
grade WP42EG TiCN		inch dimensions					number of flutes	dimension standard	class of fit
order #	catalog #	D1 TPI	L	L3	L2	D			
5368492	VTSP09705	1/4 - 20	3.15	.59	1.18	.255	3	DIN-ANSI	2B
5368493	VTSP09706	1/4 - 28	3.15	.59	1.18	.255	3	DIN-ANSI	2B
5368494	VTSP09707	5/16 - 18	3.54	.59	1.38	.318	3	DIN-ANSI	2B
5368495	VTSP09708	5/16 - 24	3.54	.59	1.38	.318	3	DIN-ANSI	2B
5368496	VTSP09709	3/8 - 16	3.94	.75	1.54	.381	3	DIN-ANSI	2B
5368497	VTSP09710	3/8 - 24	3.94	.75	1.54	.381	3	DIN-ANSI	2B
5368499	VTSP09711	7/16 - 14	3.94	.71	1.61	.323	3	DIN-ANSI	2B
5368500	VTSP09712	7/16 - 20	3.94	.71	1.61	.323	3	DIN-ANSI	2B
5368501	VTSP09713	1/2 - 13	4.33	.91	1.85	.367	3	DIN-ANSI	2B
5368502	VTSP09714	1/2 - 20	4.33	.91	1.85	.367	3	DIN-ANSI	2B
5368503	VTSP09715	9/16 - 18	4.33	.98	2.09	.429	3	DIN-ANSI	2B
5368504	VTSP09716	5/8 - 11	4.33	.94	2.01	.480	3	DIN-ANSI	2B
5368505	VTSP09717	5/8 - 18	4.33	.94	2.01	.480	3	DIN-ANSI	2B
5368506	VTSP09718	3/4 - 10	4.92	1.18	2.52	.590	3	DIN-ANSI	2B
5368508	VTSP09719	3/4 - 16	4.92	1.18	2.52	.590	3	DIN-ANSI	2B
5368509	VTSP09720	7/8 - 9	5.51	1.34	2.80	.697	3	DIN-ANSI	2B
5368510	VTSP09721	7/8 - 14	5.51	1.34	2.80	.697	3	DIN-ANSI	2B
5368511	VTSP09722	1 - 8	6.30	1.50	3.19	.800	3	DIN-ANSI	2B

- WU41EG TiN
- WP49EG oxide



Shank Tolerance

D mm	tolerance h9
1-3	+0, -0,025
>3-6	+0, -0,030
>6-10	+0, -0,036
>10-18	+0, -0,043
>18-30	+0, -0,052

■ VT-SPO • Form B Plug Chamfer • Machine Screw and Fractional • DIN 371 and 376

 grade WU41EG
TiN

 grade WP49EG
Oxide

- first choice
- alternate choice

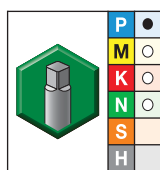
				metric dimensions					number of flutes	dimension standard	class of fit
order #	catalog #	order #	catalog #	D1 size	L	L3	L2	D			
5472633	VTSP06005	5387704	VTSP06005	4 - 40	56	8	18	3,5	2	DIN 371	2B
5472635	VTSP06007	5387707	VTSP06007	5 - 40	56	9	20	4,0	2	DIN 371	2B
5472636	VTSP06008	5387708	VTSP06008	6 - 32	56	9	20	4,0	2	DIN 371	2B
5472638	VTSP06010	5387760	VTSP06010	6 - 40	56	9	20	4,0	2	DIN 371	2B
5472639	VTSP06011	5387761	VTSP06011	8 - 32	63	11	21	4,5	2	DIN 371	2B
5472641	VTSP06013	5387763	VTSP06013	10 - 24	70	12	25	6,0	2	DIN 371	2B
5472644	VTSP06014	5387764	VTSP06014	10 - 32	70	12	25	6,0	2	DIN 371	2B
5472646	VTSP06016	5387766	VTSP06016	1/4 - 20	80	15	30	7,0	3	DIN 371	2B
5472647	VTSP06017	5387767	VTSP06017	1/4 - 28	80	15	30	7,0	3	DIN 371	2B
5472649	VTSP06019	5387769	VTSP06019	5/16 - 18	90	15	35	8,0	3	DIN 371	2B
5472650	VTSP06020	5387770	VTSP06020	5/16 - 24	90	15	35	8,0	3	DIN 371	2B
5472652	VTSP06022	5387772	VTSP06022	3/8 - 16	100	19	39	10,0	3	DIN 371	2B
5472653	VTSP06023	5387773	VTSP06023	3/8 - 24	100	19	39	10,0	3	DIN 371	2B
5472655	VTSP06025	5387776	VTSP06025	7/16 - 14	100	18	41	8,0	3	DIN 376	2B
5472656	VTSP06026	5387777	VTSP06026	7/16 - 20	100	18	41	8,0	3	DIN 376	2B
5472658	VTSP06028	5387779	VTSP06028	1/2 - 13	110	23	47	9,0	3	DIN 376	2B
5472659	VTSP06029	5387780	VTSP06029	1/2 - 20	110	23	47	9,0	3	DIN 376	2B
5472661	VTSP06031	5387782	VTSP06031	9/16 - 12	110	25	53	11,0	3	DIN 376	2B
5472662	VTSP06032	5387783	VTSP06032	9/16 - 18	110	25	53	11,0	3	DIN 376	2B
5472663	VTSP06033	5387784	VTSP06033	5/8 - 11	110	24	51	12,0	3	DIN 376	2B

(continued)

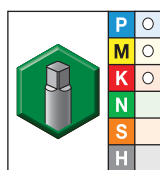
Multipurpose Taps

VariTap™ Spiral-Point HSS-E Taps • Through Holes

(VT-SPO • Form B Plug Chamfer • Machine Screw and Fractional • DIN 371 and 376 — continued)



grade WU41EG
TiN

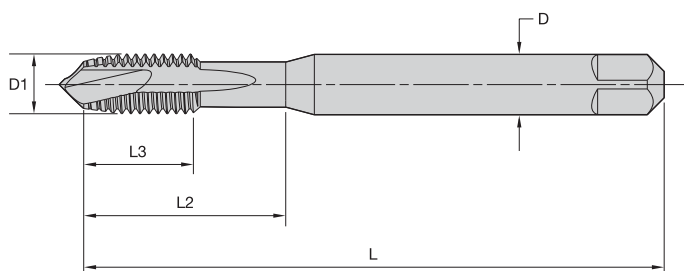


grade WP49EG
Oxide

- first choice
- alternate choice

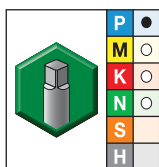
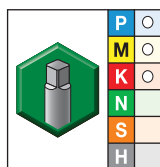
				metric dimensions					number of flutes	dimension standard	class of fit
order #	catalog #	order #	catalog #	D1 size	L	L3	L2	D			
5472664	VTSP06034	5387785	VTSP06034	5/8 - 18	110	24	51	12,0	3	DIN 376	2B
5472665	VTSP06035	5387786	VTSP06035	3/4 - 10	140	30	64	16,0	3	DIN 376	2B
5472666	VTSP06036	5387787	VTSP06036	3/4 - 16	140	30	64	16,0	3	DIN 376	2B
5472667	VTSP06037	5387788	VTSP06037	7/8 - 9	140	34	71	18,0	3	DIN 376	2B
5472668	VTSP06038	5387789	VTSP06038	7/8 - 14	140	34	71	18,0	3	DIN 376	2B
5472669	VTSP06039	5387790	VTSP06039	1 - 8	160	38	81	18,0	3	DIN 376	2B
5472670	VTSP06040	5387791	VTSP06040	1 - 12	160	38	81	18,0	3	DIN 376	2B

- WU41EG TiN
- WP49EG oxide



Shank Tolerance

D mm	tolerance h9
1-3	+0, -0,025
>3-6	+0, -0,030
>6-10	+0, -0,036
>10-18	+0, -0,043
>18-30	+0, -0,052

■ VT-SPO • Form B Plug Chamfer • UNJC/UNJF • Inch DIN 371 and 376

 grade WU41EG
TiN

 grade WP49EG
Oxide

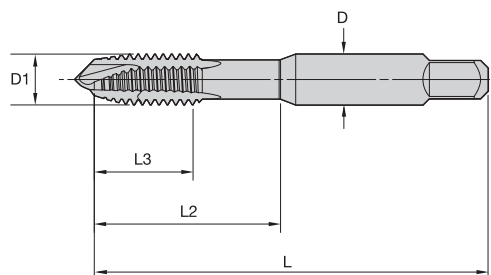
- first choice
- alternate choice

				metric dimensions					number of flutes	dimension standard	class of fit
order #	catalog #	order #	catalog #	D1 size	L	L3	L2	D			
5472634	VTSP06006	5387705	VTSP06006	4 - 40	56	8	18	3,5	2	DIN 371	3B
5472637	VTSP06009	5387709	VTSP06009	6 - 32	56	9	20	4,0	2	DIN 371	3B
5472640	VTSP06012	5387762	VTSP06012	8 - 32	63	11	21	4,5	2	DIN 371	3B
5472645	VTSP06015	5387765	VTSP06015	10 - 32	70	12	25	6,0	2	DIN 371	3B
5472648	VTSP06018	5387768	VTSP06018	1/4 - 28	80	15	30	7,0	3	DIN 371	3B
5472651	VTSP06021	5387771	VTSP06021	5/16 - 24	90	15	35	8,0	3	DIN 371	3B
5472654	VTSP06024	5387774	VTSP06024	3/8 - 24	100	19	39	10,0	3	DIN 371	3B
5472657	VTSP06027	5387778	VTSP06027	7/16 - 20	100	18	41	8,0	3	DIN 376	3B
5472660	VTSP06030	5387781	VTSP06030	1/2 - 20	110	23	47	9,0	3	DIN 376	3B

Multipurpose Taps

VariTap™ Spiral-Point HSS-E Taps • Through Holes

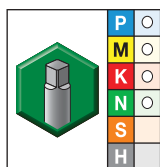
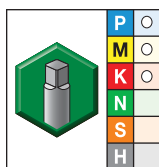
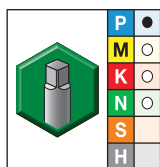
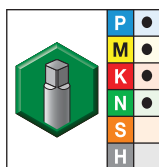
- WP42EG TiCN
- WU41EG TiN
- WP49EG oxide
- WU40EG bright



Shank Tolerance

D inch	tolerance
0.141–0.635	+0, -.0015
>0.635–1.51	+0, -.0020
>1.51–2.01	+0, -.0030

■ VT-SPO • Form B Plug Chamfer • Metric • ANSI

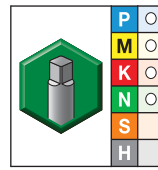
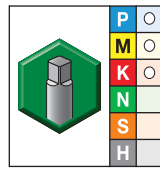
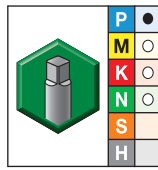
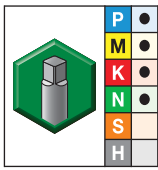


- first choice
- alternate choice

grade WP42EG TiCN		grade WU41EG TiN		grade WP49EG Oxide		grade WU40EG Bright		inch dimensions					number of flutes	pitch diameter limit
order #	catalog #	order #	catalog #	order #	catalog #	order #	catalog #	D1 size	L	L3	L2	D		
5362670	VTSP05505	5362671	VTSP05505	5362589	VTSP05505	5362672	VTSP05505	M3 X 0,5	1.94	.58	.75	.141	2	D3
5362674	VTSP05506	–	–	5362673	VTSP05506	–	–	M3 X 0,5	1.94	.58	.75	.141	2	D11
5631641	VTSP05613	5631642	VTSP05613	5631640	VTSP05613	5631643	VTSP05613	M3 X 0,5	1.94	.58	.75	.141	3	D3
5631645	VTSP05614	–	–	5631644	VTSP05614	–	–	M3 X 0,5	1.94	.58	.75	.141	3	D11
5362677	VTSP05507	–	–	5362676	VTSP05507	5362678	VTSP05507	M3,5 X 0,6	1.99	.38	.71	.141	2	D4
5362690	VTSP05508	–	–	5362679	VTSP05508	–	–	M3,5 X 0,6	1.99	.38	.71	.141	2	D11
5631647	VTSP05615	–	–	5631646	VTSP05615	5631648	VTSP05615	M3,5 X 0,6	1.99	.38	.71	.141	3	D4
5631650	VTSP05616	–	–	5631649	VTSP05616	–	–	M3,5 X 0,6	1.99	.38	.71	.141	3	D11
5362692	VTSP05509	5362693	VTSP05509	5362691	VTSP05509	5362694	VTSP05509	M4 X 0,7	2.12	.38	.76	.168	2	D4
5362696	VTSP05510	–	–	5362695	VTSP05510	–	–	M4 X 0,7	2.12	.38	.76	.168	2	D11
5631652	VTSP05617	5631653	VTSP05617	5631651	VTSP05617	5631654	VTSP05617	M4 X 0,7	2.12	.38	.76	.168	3	D4
5631656	VTSP05618	–	–	5631655	VTSP05618	–	–	M4 X 0,7	2.12	.38	.76	.168	3	D11
5362698	VTSP05511	5362699	VTSP05511	5362697	VTSP05511	5362700	VTSP05511	M5 X 0,8	2.37	.50	.91	.194	2	D4
5362702	VTSP05512	–	–	5362701	VTSP05512	–	–	M5 X 0,8	2.37	.50	.91	.194	2	D11
5631659	VTSP05619	5631670	VTSP05619	5631658	VTSP05619	5631671	VTSP05619	M5 X 0,8	2.37	.50	.91	.194	3	D4
5631673	VTSP05620	–	–	5631672	VTSP05620	–	–	M5 X 0,8	2.37	.50	.91	.194	3	D11
5362704	VTSP05513	5362705	VTSP05513	5362703	VTSP05513	5362706	VTSP05513	M6 X 1	2.50	.63	1.00	.255	3	D5
5362708	VTSP05514	–	–	5362707	VTSP05514	–	–	M6 X 1	2.50	.63	1.00	.255	3	D11
5362710	VTSP05515	–	–	5362709	VTSP05515	5362711	VTSP05515	M7 X 1	2.72	.69	1.15	.318	3	D5
5362713	VTSP05516	–	–	5362712	VTSP05516	–	–	M7 X 1	2.72	.69	1.15	.318	3	D11
5362715	VTSP05517	–	–	5362714	VTSP05517	5362716	VTSP05517	M8 X 1	2.71	.69	1.12	.318	3	D5
5362718	VTSP05518	–	–	5362717	VTSP05518	–	–	M8 X 1	2.71	.69	1.12	.318	3	D11
5362722	VTSP05519	5362723	VTSP05519	5362720	VTSP05519	5362724	VTSP05519	M8 X 1,25	2.71	.69	1.13	.318	3	D5
5362728	VTSP05520	–	–	5362727	VTSP05520	–	–	M8 X 1,25	2.71	.69	1.13	.318	3	D11

(continued)

(VT-SPO • Form B Plug Chamfer • Metric • ANSI — continued)

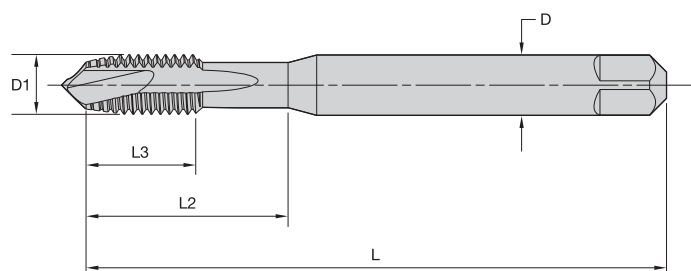

 ● first choice
 ○ alternate choice

grade WP42EG TiCN		grade WU41EG TiN		grade WP49EG Oxide		grade WU40EG Bright		inch dimensions					number of flutes	pitch diameter limit
order #	catalog #	order #	catalog #	order #	catalog #	order #	catalog #	D1 size	L	L3	L2	D		
5362730	VTSP05521	—	—	5362729	VTSP05521	5362731	VTSP05521	M10 X 1	2.91	.75	1.24	.381	3	D5
5362733	VTSP05522	—	—	5362732	VTSP05522	—	—	M10 X 1	2.91	.75	1.24	.381	3	D11
5367305	VTSP05523	—	—	5367304	VTSP05523	5367306	VTSP05523	M10 X 1,25	2.92	.74	1.25	.381	3	D5
5367308	VTSP05524	—	—	5367307	VTSP05524	—	—	M10 X 1,25	2.92	.74	1.25	.381	3	D11
5367340	VTSP05525	5367341	VTSP05525	5367309	VTSP05525	5367342	VTSP05525	M10 X 1,5	2.92	.75	1.26	.381	3	D6
5367344	VTSP05526	—	—	5367343	VTSP05526	—	—	M10 X 1,5	2.92	.75	1.26	.381	3	D11
5367346	VTSP05527	—	—	5367345	VTSP05527	5367347	VTSP05527	M12 X 1,25	3.38	.94	1.74	.367	3	D6
5367349	VTSP05528	—	—	5367348	VTSP05528	—	—	M12 X 1,25	3.38	.94	1.74	.367	3	D11
5367351	VTSP05529	—	—	5367350	VTSP05529	5367352	VTSP05529	M12 X 1,5	3.38	.94	1.74	.367	3	D6
5367354	VTSP05530	—	—	5367353	VTSP05530	—	—	M12 X 1,5	3.38	.94	1.74	.367	3	D11
5367356	VTSP05531	5367357	VTSP05531	5367355	VTSP05531	5367358	VTSP05531	M12 X 1,75	3.38	.94	1.74	.367	3	D6
5367360	VTSP05532	—	—	5367359	VTSP05532	—	—	M12 X 1,75	3.38	.94	1.74	.367	3	D11
5367362	VTSP05533	—	—	5367361	VTSP05533	5367363	VTSP05533	M14 X 1,5	3.59	1.00	1.74	.429	3	D6
5367365	VTSP05534	—	—	5367364	VTSP05534	5367366	VTSP05534	M14 X 2	3.59	1.00	1.74	.429	3	D7
5366476	VTSP05535	5366477	VTSP05535	5366475	VTSP05535	5366478	VTSP05535	M16 X 1,5	3.81	1.09	1.89	.480	3	D6
5366480	VTSP05536	5366481	VTSP05536	5366479	VTSP05536	5366482	VTSP05536	M16 X 2	3.81	1.09	1.89	.480	3	D7
5366485	VTSP05537	—	—	5366483	VTSP05537	5366486	VTSP05537	M18 X 1,5	4.03	1.09	1.89	.542	3	D6
5366488	VTSP05538	—	—	5366487	VTSP05538	5366489	VTSP05538	M18 X 2,5	4.03	1.22	1.89	.542	3	D7
5366491	VTSP05539	—	—	5366490	VTSP05539	—	—	M20 X 1,5	4.47	1.22	2.08	.652	3	D6
5366493	VTSP05540	—	—	5366492	VTSP05540	—	—	M20 X 2,5	4.47	1.22	2.08	.652	3	D7
—	—	—	—	5366494	VTSP05541	—	—	M22 X 1,5	4.69	1.22	2.30	.697	3	D6
—	—	—	—	5366495	VTSP05542	—	—	M22 X 2,5	4.69	1.22	2.30	.697	3	D7
—	—	—	—	5366496	VTSP05543	—	—	M24 X 2	4.91	1.22	2.30	.760	3	D7
—	—	—	—	5366497	VTSP05544	—	—	M24 X 3	4.91	1.22	2.30	.760	3	D8
—	—	—	—	5366498	VTSP05545	—	—	M27 X 1,5	5.13	1.22	2.50	.896	4	D7
—	—	—	—	5366499	VTSP05546	—	—	M27 X 3	5.13	1.22	2.50	.896	4	0
—	—	—	—	5366510	VTSP05547	—	—	M30 X 1,5	5.44	1.22	2.56	1.021	4	D6
—	—	—	—	5366511	VTSP05548	—	—	M30 X 3,5	5.44	1.22	2.56	1.021	4	D9

Multipurpose Taps

VariTap™ Spiral-Point HSS-E Taps • Through Holes

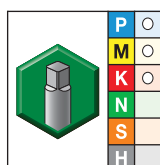
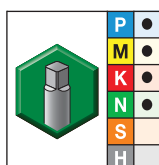
- WP42EG TiCN
- WP49EG oxide



Shank Tolerance

D inch	tolerance
.141-.635	+0, -.0015
>.635-1.51	+0, -.0020
>1.51-2.01	+0, -.0030

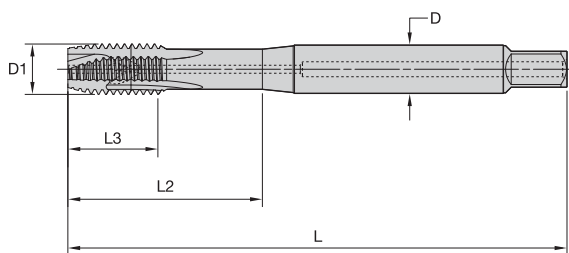
■ VT-SPO • Form B Plug Chamfer • Metric • DIN Length ANSI Shank



- first choice
- alternate choice

grade WP42EG TiCN		grade WP49EG Oxide		inch dimensions					number of flutes	dimension standard	class of fit
order #	catalog #	order #	catalog #	D1 size	L	L3	L2	D			
5368172	VTSP09506	5368171	VTSP09506	M3 X 0,5	2.20	.31	.71	.141	2	DIN-ANSI	6H
5368174	VTSP09507	5368173	VTSP09507	M4 X 0,7	2.48	.43	.83	.168	2	DIN-ANSI	6H
5368176	VTSP09508	5368175	VTSP09508	M5 X 0,8	2.75	.47	.97	.194	2	DIN-ANSI	6H
5368178	VTSP09509	5368177	VTSP09509	M6 X 1	3.15	.47	1.18	.255	3	DIN-ANSI	6H
5368180	VTSP09510	5368179	VTSP09510	M8 X 1,25	3.54	.59	1.37	.318	3	DIN-ANSI	6H
5368182	VTSP09511	5368181	VTSP09511	M10 X 1,25	3.93	.71	1.53	.381	3	DIN-ANSI	6H
5368184	VTSP09512	5368183	VTSP09512	M10 X 1,5	3.94	.71	1.53	.381	3	DIN-ANSI	6H
5368186	VTSP09513	5368185	VTSP09513	M12 X 1,25	4.33	.83	1.73	.367	3	DIN-ANSI	6H
5368188	VTSP09514	5368187	VTSP09514	M12 X 1,5	4.33	.83	1.73	.367	3	DIN-ANSI	6H
5368190	VTSP09515	5368189	VTSP09515	M12 X 1,75	4.33	.83	1.73	.367	3	DIN-ANSI	6H
5368192	VTSP09516	5368191	VTSP09516	M14 X 1,5	4.33	.94	2.05	.429	3	DIN-ANSI	6H
5368195	VTSP09517	5368193	VTSP09517	M14 X 2	4.33	.94	2.05	.429	3	DIN-ANSI	6H
5368197	VTSP09518	5368196	VTSP09518	M16 X 1,5	4.33	.94	2.01	.480	3	DIN-ANSI	6H
5368199	VTSP09519	5368198	VTSP09519	M16 X 2	4.33	.94	2.01	.480	3	DIN-ANSI	6H
5368201	VTSP09520	5368200	VTSP09520	M18 X 1,5	4.92	1.18	2.28	.542	3	DIN-ANSI	6H
5368203	VTSP09521	5368202	VTSP09521	M18 X 2,5	4.92	1.18	2.28	.542	3	DIN-ANSI	6H
5368205	VTSP09522	5368204	VTSP09522	M20 X 1,5	5.51	1.18	2.52	.652	3	DIN-ANSI	6H
5368207	VTSP09523	5368206	VTSP09523	M20 X 2,5	5.51	1.18	2.52	.652	3	DIN-ANSI	6H

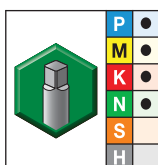
• WP42EG TiCN



Shank Tolerance

D inch	tolerance
.141-.635	+0, -.0015
>.635-1.51	+0, -.0020
>1.51-2.01	+0, -.0030

■ VT-SPO • Form B Plug Chamfer • Through Coolant • Metric • DIN Length ANSI Shank


 ● first choice
 ○ alternate choice

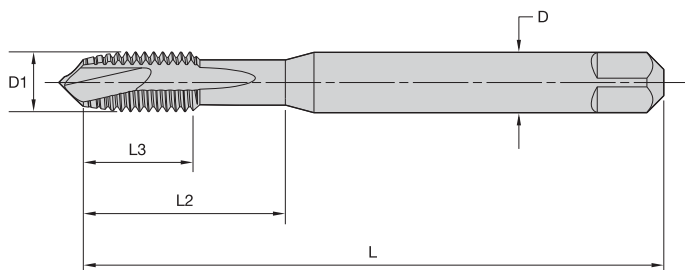
grade WP42EG TiCN		inch dimensions					number of flutes	dimension standard	class of fit
order #	catalog #	D1 size	L	L3	L2	D			
5368457	VTSP09905	M6 X 1	3.15	.47	1.18	.255	3	DIN-ANSI	6H
5368458	VTSP09906	M8 X 1,25	3.54	.59	1.38	.318	3	DIN-ANSI	6H
5368459	VTSP09907	M10 X 1,25	3.94	.71	1.54	.381	3	DIN-ANSI	6H
5368480	VTSP09908	M10 X 1,5	3.94	.71	1.54	.381	3	DIN-ANSI	6H
5368481	VTSP09909	M12 X 1,25	4.33	.83	1.73	.367	3	DIN-ANSI	6H
5368482	VTSP09910	M12 X 1,5	4.33	.83	1.73	.367	3	DIN-ANSI	6H
5368483	VTSP09911	M12 X 1,75	4.33	.83	1.73	.367	3	DIN-ANSI	6H
5368484	VTSP09912	M14 X 1,5	4.33	.94	2.05	.429	3	DIN-ANSI	6H
5368485	VTSP09913	M14 X 2	4.33	.94	2.05	.429	3	DIN-ANSI	6H
5368486	VTSP09914	M16 X 1,5	4.33	.94	2.01	.480	3	DIN-ANSI	6H
5368487	VTSP09915	M16 X 2	4.33	.94	2.01	.480	3	DIN-ANSI	6H
5368488	VTSP09916	M18 X 1,5	4.92	1.18	2.28	.542	3	DIN-ANSI	6H
5368489	VTSP09917	M18 X 2,5	4.92	1.18	2.28	.542	3	DIN-ANSI	6H
5368490	VTSP09918	M20 X 1,5	5.51	1.18	2.52	.652	3	DIN-ANSI	6H
5368491	VTSP09919	M20 X 2,5	5.51	1.18	2.52	.652	3	DIN-ANSI	6H

Multipurpose Taps

Multipurpose Taps

VariTap™ Spiral-Point HSS-E Taps • Through Holes

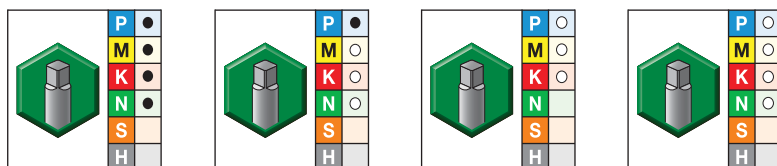
- WU40EG bright
- WU41EG TiN
- WP42EG TiCN
- WP49EG oxide



Shank Tolerance

D mm	tolerance h9
1-3	+0, -0,025
>3-6	+0, -0,030
>6-10	+0, -0,036
>10-18	+0, -0,043
>18-30	+0, -0,052

■ VT-SPO • Form B Plug Chamfer • Metric DIN 371, 374, and 376

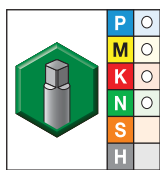
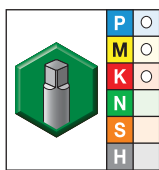
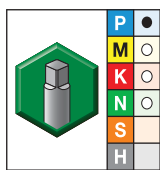
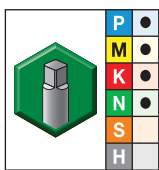


- first choice
- alternate choice

grade WP42EG TiCN		grade WU41EG TiN		grade WP49EG Oxide		grade WU40EG Bright		metric dimensions					number of flutes	dimension standard	class of fit
order #	catalog #	order #	catalog #	order #	catalog #	order #	catalog #	D1 size	L	L3	L2	D			
5366647	VTSP06505	5366646	VTSP06505	5366648	VTSP06505	5366649	VTSP06505	M2 X 0,4	45	7	13	2,8	2	DIN 371	6H
-	-	-	-	5366660	VTSP06506	-	-	M2 X 0,4	45	7	13	2,8	2	DIN 371	6G
-	-	-	-	5366661	VTSP06507	-	-	M2,2 X 0,45	45	7	13	2,8	2	DIN 371	6H
-	-	5366662	VTSP06508	5366663	VTSP06508	5366664	VTSP06508	M2,5 X 0,45	50	7	15	2,8	2	DIN 371	6H
-	-	-	-	5366665	VTSP06509	-	-	M2,5 X 0,45	50	7	15	2,8	2	DIN 371	6G
-	-	-	-	5368602	VTSP06545	5368603	VTSP06545	M3 X 0,35	56	8	-	2,2	2	DIN 374	6H
-	-	5368514	VTSP06525	5368515	VTSP06525	5368516	VTSP06525	M3 X 0,5	56	8	-	2,2	2	DIN 376	6H
-	-	-	-	5366670	VTSP06511	-	-	M3 X 0,5	56	8	18	3,5	2	DIN 371	6G
5366667	VTSP06510	5366666	VTSP06510	5366668	VTSP06510	5366669	VTSP06510	M3 X 0,5	56	8	18	3,5	2	DIN 371	6H
-	-	5366671	VTSP06512	5366673	VTSP06512	5366674	VTSP06512	M3,5 X 0,6	56	9	20	4,0	2	DIN 371	6H
-	-	-	-	5368604	VTSP06546	5368605	VTSP06546	M4 X 0,5	63	10	21	2,8	2	DIN 374	6H
-	-	5368517	VTSP06526	5368518	VTSP06526	5368519	VTSP06526	M4 X 0,7	63	10	21	2,8	2	DIN 376	6H
-	-	-	-	5366679	VTSP06514	-	-	M4 X 0,7	63	11	21	4,5	2	DIN 371	6G
5366676	VTSP06513	5366675	VTSP06513	5366677	VTSP06513	5366678	VTSP06513	M4 X 0,7	63	11	21	4,5	2	DIN 371	6H
-	-	-	-	5368606	VTSP06547	5368607	VTSP06547	M5 X 0,5	70	12	25	3,5	2	DIN 374	6H
-	-	5368540	VTSP06527	5368541	VTSP06527	5368542	VTSP06527	M5 X 0,8	70	12	25	3,5	2	DIN 376	6H
-	-	-	-	5366685	VTSP06516	-	-	M5 X 0,8	70	12	25	6,0	2	DIN 371	6G
5366681	VTSP06515	5366680	VTSP06515	5366682	VTSP06515	5366684	VTSP06515	M5 X 0,8	70	12	25	6,0	2	DIN 371	6H
-	-	-	-	5368608	VTSP06548	5368609	VTSP06548	M6 X 0,5	80	12	30	4,5	3	DIN 374	6H
-	-	-	-	5368610	VTSP06549	5368611	VTSP06549	M6 X 0,75	80	12	30	4,5	3	DIN 374	6H
-	-	5368543	VTSP06528	5368544	VTSP06528	5368545	VTSP06528	M6 X 1	80	12	30	4,5	3	DIN 376	6H
5366687	VTSP06517	5366686	VTSP06517	5366688	VTSP06517	5366689	VTSP06517	M6 X 1	80	12	30	6,0	3	DIN 371	6H
-	-	-	-	5366690	VTSP06518	-	-	M6 X 1	80	12	30	6,0	3	DIN 371	6G
-	-	-	-	5368612	VTSP06550	5368613	VTSP06550	M7 X 0,75	80	12	30	5,5	3	DIN 374	6H

(continued)

(VT-SPO • Form B Plug Chamfer • Metric DIN 371, 374, and 376 — continued)


 ● first choice
 ○ alternate choice

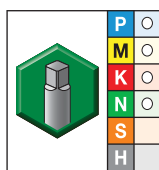
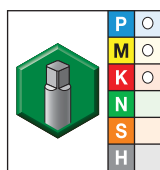
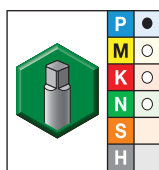
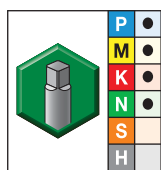
grade WP42EG TiCN		grade WU41EG TiN		grade WP49EG Oxide		grade WU40EG Bright		metric dimensions					number of flutes	dimension standard	class of fit
order #	catalog #	order #	catalog #	order #	catalog #	order #	catalog #	D1 size	L	L3	L2	D			
5366693	VTSP06519	5366692	VTSP06519	5366695	VTSP06519	5366696	VTSP06519	M7 X 1	80	12	30	7,0	3	DIN 371	6H
-	-	-	-	5366697	VTSP06520	-	-	M7 X 1	80	12	30	7,0	3	DIN 371	6G
-	-	-	-	5368614	VTSP06551	5368615	VTSP06551	M8 X 0,75	80	12	30	6,0	3	DIN 374	6H
-	-	-	-	5368616	VTSP06552	5368617	VTSP06552	M8 X 1	90	15	35	6,0	3	DIN 374	6H
-	-	5368546	VTSP06529	5368547	VTSP06529	5368548	VTSP06529	M8 X 1,25	90	15	35	6,0	3	DIN 376	6H
5366700	VTSP06521	5366698	VTSP06521	5366701	VTSP06521	5366703	VTSP06521	M8 X 1,25	90	15	35	8,0	3	DIN 371	6H
-	-	-	-	5366704	VTSP06522	-	-	M8 X 1,25	90	15	35	8,0	3	DIN 371	6G
-	-	-	-	5368618	VTSP06553	5368619	VTSP06553	M10 X 0,75	90	15	35	7,0	3	DIN 374	6H
-	-	-	-	5368620	VTSP06554	5368621	VTSP06554	M10 X 1	90	15	35	7,0	3	DIN 374	6H
-	-	-	-	5368622	VTSP06555	5368623	VTSP06555	M10 X 1,25	100	18	39	7,0	3	DIN 374	6H
-	-	-	-	5366709	VTSP06524	-	-	M10 X 1,5	100	18	39	10,0	3	DIN 371	6G
5366706	VTSP06523	5366705	VTSP06523	5366707	VTSP06523	5366708	VTSP06523	M10 X 1,5	100	18	39	10,0	3	DIN 371	6H
-	-	5368549	VTSP06530	5368550	VTSP06530	5368551	VTSP06530	M10 X 1,5	100	18	39	7,0	3	DIN 376	6H
-	-	-	-	5368624	VTSP06556	5368625	VTSP06556	M11 X 1	90	15	36	8,0	3	DIN 374	6H
-	-	-	-	5368626	VTSP06557	5368627	VTSP06557	M12 X 1	100	21	39	9,0	3	DIN 374	6H
-	-	-	-	5368628	VTSP06558	5368629	VTSP06558	M12 X 1,25	100	21	39	9,0	3	DIN 374	6H
-	-	-	-	5368630	VTSP06559	5368631	VTSP06559	M12 X 1,5	100	21	39	9,0	3	DIN 374	6H
-	-	-	-	5368556	VTSP06532	-	-	M12 X 1,75	110	21	44	9,0	3	DIN 376	6G
5368553	VTSP06531	5368552	VTSP06531	5368554	VTSP06531	5368555	VTSP06531	M12 X 1,75	110	21	44	9,0	3	DIN 376	6H
-	-	-	-	5368632	VTSP06560	5368633	VTSP06560	M14 X 1	100	21	47	11,0	3	DIN 374	6H
-	-	-	-	5368634	VTSP06561	5368635	VTSP06561	M14 X 1,25	100	21	47	11,0	3	DIN 374	6H
-	-	-	-	5368636	VTSP06562	5368637	VTSP06562	M14 X 1,5	100	21	47	11,0	3	DIN 374	6H
5368558	VTSP06533	5368557	VTSP06533	5368559	VTSP06533	5368560	VTSP06533	M14 X 2	110	24	52	11,0	3	DIN 376	6H
-	-	-	-	5368561	VTSP06534	-	-	M14 X 2	110	24	52	11,0	3	DIN 376	6G
-	-	-	-	5368638	VTSP06563	5368639	VTSP06563	M16 X 1	100	21	46	12,0	3	DIN 374	6H
-	-	-	-	5368640	VTSP06564	5368641	VTSP06564	M16 X 1,5	100	21	46	12,0	3	DIN 374	6H
5368563	VTSP06535	5368562	VTSP06535	5368565	VTSP06535	5368566	VTSP06535	M16 X 2	110	24	51	12,0	3	DIN 376	6H
-	-	-	-	5368567	VTSP06536	-	-	M16 X 2	110	24	51	12,0	3	DIN 376	6G
-	-	-	-	5368642	VTSP06565	5368643	VTSP06565	M18 X 1	110	21	50	14,0	3	DIN 374	6H
-	-	-	-	5368683	VTSP06566	5368684	VTSP06566	M18 X 1,5	110	21	50	14,0	3	DIN 374	6H
-	-	-	-	5368685	VTSP06567	5368686	VTSP06567	M18 X 2	125	30	58	14,0	3	DIN 374	6H
5368569	VTSP06537	5368568	VTSP06537	5368570	VTSP06537	5368571	VTSP06537	M18 X 2,5	125	30	58	14,0	3	DIN 376	6H
-	-	-	-	5368687	VTSP06568	5368688	VTSP06568	M20 X 1	125	24	56	16,0	3	DIN 374	6H
-	-	-	-	5368689	VTSP06569	5368690	VTSP06569	M20 X 1,5	125	24	56	16,0	3	DIN 374	6H
-	-	-	-	5368691	VTSP06570	5368692	VTSP06570	M20 X 2	140	30	64	16,0	3	DIN 374	6H
5368573	VTSP06538	5368572	VTSP06538	5368574	VTSP06538	5368575	VTSP06538	M20 X 2,5	140	30	64	16,0	3	DIN 376	6H
-	-	-	-	5368693	VTSP06571	5368694	VTSP06571	M22 X 1,5	125	24	62	18,0	3	DIN 374	6H
-	-	-	-	-	-	5368695	VTSP06572	M22 X 2	140	30	70	18,0	3	DIN 374	6H
5368577	VTSP06539	5368576	VTSP06539	5368578	VTSP06539	5368579	VTSP06539	M22 X 2,5	140	30	70	18,0	3	DIN 376	6H
-	-	-	-	5368696	VTSP06573	5368697	VTSP06573	M24 X 1,5	140	28	67	18,0	3	DIN 374	6H

(continued)

Multipurpose Taps

VariTap™ Spiral-Point HSS-E Taps • Through Holes

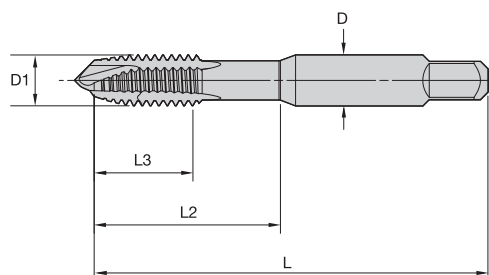
(VT-SPO • Form B Plug Chamfer • Metric DIN 371, 374, and 376 — continued)



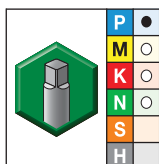
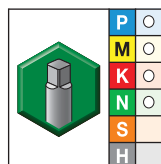
- first choice
- alternate choice

grade WP42EG TiCN		grade WU41EG TiN		grade WP49EG Oxide		grade WU40EG Bright		metric dimensions					number of flutes	dimension standard	class of fit
order #	catalog #	order #	catalog #	order #	catalog #	order #	catalog #	D1 size	L	L3	L2	D			
—	—	—	—	—	—	5368698	VTSP06574	M24 X 2	140	30	67	18,0	3	DIN 374	6H
5368581	VTSP06540	5368580	VTSP06540	5368582	VTSP06540	5368583	VTSP06540	M24 X 3	160	36	77	18,0	3	DIN 376	6H
—	—	5368584	VTSP06541	5368585	VTSP06541	5368586	VTSP06541	M27 X 3	160	36	82	20,0	4	DIN 376	6H
—	—	—	—	—	—	5368699	VTSP06575	M30 X 2	150	28	80	22,0	4	DIN 374	6H
—	—	5368587	VTSP06542	5368588	VTSP06542	5368589	VTSP06542	M30 X 3,5	180	42	91	22,0	4	DIN 376	6H
—	—	—	—	5368600	VTSP06543	—	—	M33 X 3,5	180	42	100	25,0	4	DIN 376	6H
—	—	—	—	5368601	VTSP06544	—	—	M36 X 4	200	48	110	28,0	4	DIN 376	6H

- WU40EG bright
- WU41EG TiN


Shank Tolerance

D mm	tolerance h9
1-3	+0, -0,025
>3-6	+0, -0,030
>6-10	+0, -0,036
>10-18	+0, -0,043
>18-30	+0, -0,052

■ VT-SPO • Form B Plug Chamfer • Metric • JIS

 grade WU41EG
TiN

 grade WU40EG
Bright

- first choice
- alternate choice

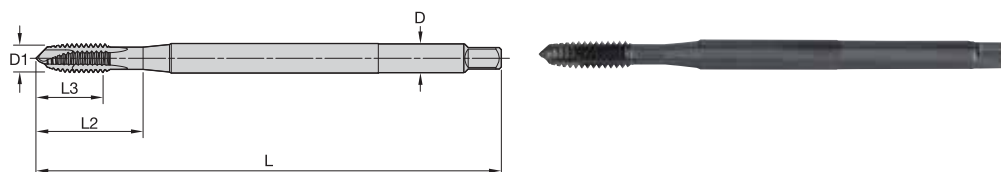
grade WU41EG TiN		grade WU40EG Bright		metric dimensions					number of flutes	dimension standard	tap class
order #	catalog #	order #	catalog #	D1 size	L	L3	L2	D			
5387861	VTSP07505	5387859	VTSP07505	M3 X 0,5	46	11	19	4,0	2	JIS	ISO 2
5387865	VTSP07506	5387863	VTSP07506	M4 X 0,7	52	13	21	5,0	2	JIS	ISO 2
5387869	VTSP07507	5387867	VTSP07507	M5 X 0,8	60	16	24	5,5	2	JIS	ISO 2
5387873	VTSP07508	5387871	VTSP07508	M6 X 1	62	19	29	6,0	3	JIS	ISO 2
5387877	VTSP07509	5387875	VTSP07509	M8 X 1,25	70	22	37	6,2	3	JIS	ISO 2
5387881	VTSP07510	5387879	VTSP07510	M10 X 1,5	75	24	41	7,0	3	JIS	ISO 2
-		5387883	VTSP07511	M12 X 1,25	82	29	48	8,5	3	JIS	ISO 2
-		5387887	VTSP07513	M12 X 1,5	82	29	48	8,5	3	JIS	ISO 2
-		5387885	VTSP07512	M12 X 1,75	82	29	48	8,5	3	JIS	ISO 2
-		5387891	VTSP07515	M14 X 1,5	88	30	48	10,5	3	JIS	ISO 2
-		5387889	VTSP07514	M14 X 2	88	30	48	10,5	3	JIS	ISO 2
-		5387895	VTSP07517	M16 X 1,5	95	32	52	12,5	3	JIS	ISO 2
-		5387893	VTSP07516	M16 X 2	95	32	52	12,5	3	JIS	ISO 2
-		5387898	VTSP07518	M18 X 2,5	100	37	55	14,0	3	JIS	ISO 2
-		5387900	VTSP07519	M20 X 2,5	105	37	60	15,0	3	JIS	ISO 2

Multipurpose Taps

VariTap™ Spiral-Point HSS-E Extension Taps • Through Holes • 4" Length

WIDIA
GTD™

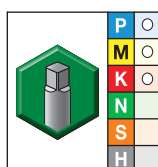
- WP49EG oxide



Shank Tolerance

D inch	tolerance
.141-.635	+0, -.0015
>.635-1.51	+0, -.0020
>1.51-2.01	+0, -.0030

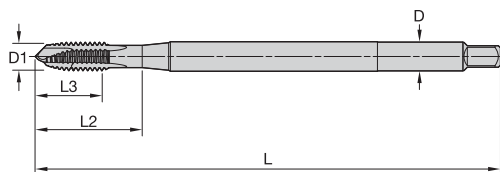
■ VT-SPO • Form B Plug Chamfer • Machine Screw and Fractional • 4" Length • ANSI



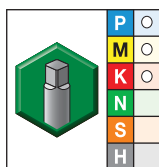
- first choice
- alternate choice

grade WP49EG Oxide		inch dimensions					number of flutes	pitch diameter limit
order #	catalog #	D1 TPI	L	L3	L2	D		
5608578	VTSP05419	4 - 40	4.00	.56	.87	.141	2	H2
5608579	VTSP05420	6 - 32	4.00	.38	.71	.141	2	H3
5608580	VTSP05421	8 - 32	4.00	.38	.76	.168	2	H3
5608582	VTSP05422	10 - 24	4.00	.50	.91	.194	2	H3
5608584	VTSP05423	10 - 32	4.00	.50	.91	.194	2	H3
5608585	VTSP05424	1/4 - 20	4.00	.63	1.01	.255	3	H3

- WP49EG oxide


Shank Tolerance

D inch	tolerance
.141-.635	+0, -.0015
>.635-1.51	+0, -.0020
>1.51-2.01	+0, -.0030

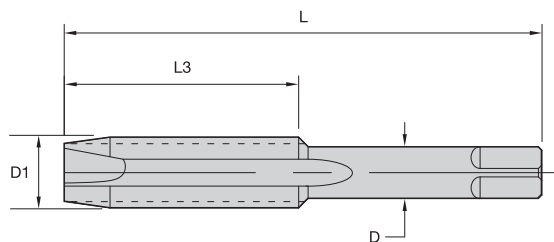
■ VT-SPO • Form B Plug Chamfer • Machine Screw and Fractional • 6" Length • ANSI


- first choice
- alternate choice

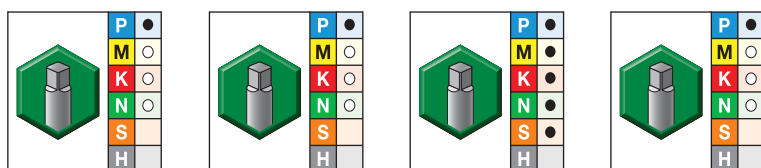
grade WP49EG Oxide		inch dimensions					number of flutes	pitch diameter limit
order #	catalog #	D1 TPI	L	L3	L2	D		
5608551	VTSP05403	4 - 40	6.00	.56	.87	.141	2	H2
5608552	VTSP05404	6 - 32	6.00	.38	.71	.168	2	H3
5608553	VTSP05405	8 - 32	6.00	.38	.76	.168	2	H3
5608554	VTSP05406	10 - 24	6.00	.50	.91	.194	2	H3
5608555	VTSP05407	10 - 32	6.00	.50	.91	.194	2	H3
5608556	VTSP05408	1/4 - 20	6.00	.63	1.01	.255	3	H3
5608557	VTSP05409	1/4 - 28	6.00	.63	1.01	.255	3	H3
5608558	VTSP05410	5/16 - 18	6.00	.69	1.13	.318	3	H3
5608559	VTSP05411	5/16 - 24	6.00	.69	1.13	.318	3	H3
5608570	VTSP05412	3/8 - 16	6.00	.75	1.27	.381	3	H3
5608571	VTSP05413	3/8 - 24	6.00	.75	1.27	.381	3	H3
5608572	VTSP05414	7/16 - 14	6.00	.88	1.49	.323	3	H3
5608573	VTSP05415	7/16 - 20	6.00	.88	1.49	.323	3	H3
5608575	VTSP05416	1/2 - 13	6.00	.94	1.74	.367	3	H3
5608576	VTSP05417	1/2 - 20	6.00	.94	1.74	.367	3	H3
5608577	VTSP05418	5/8 - 11	6.00	1.09	1.89	.480	3	H3

Multipurpose Taps

- Series 5301TC • TiCN Coated
- Series 2301 • TiN Coated
- Series 5301S • SH50 Steam Oxide
- Series 5301 • Uncoated



■ Series 5301/2301 • Machine Screw and Fractional Sizes • Plug Chamfer

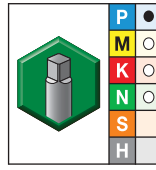
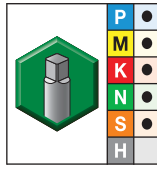
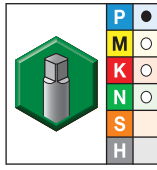
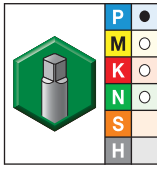


- first choice
- alternate choice

TiCN		TiN		oxide		uncoated		inch dimensions				number of flutes	pitch diameter limit
order #	catalog #	order #	catalog #	order #	catalog #	order #	catalog #	D1 size	L	L3	D		
2746991	19011	2747016	19001	2750325	13111	2750249	13202	0 - 80	1.63	.31	.141	2	H2
-	-	-	-	-	-	2750251	13201	0 - 80	1.63	.31	.141	2	H1
2972885	19442	-	-	-	-	2750246	13204	1 - 64	1.69	.38	.141	2	H2
3171104	19446	-	-	2750324	13115	2750241	13206	1 - 72	1.69	.38	.141	2	H2
-	-	-	-	-	-	2750243	13205	1 - 72	1.69	.38	.141	2	H1
2746990	19012	2747001	19006	2750321	13117	2867063	13208	2 - 56	1.75	.44	.141	2	H2
-	-	-	-	-	-	2867066	13207	2 - 56	1.75	.44	.141	2	H1
3171107	19449	-	-	-	-	2750238	13211	2 - 64	1.75	.44	.141	2	H2
3171109	19452	2746999	19007	2750319	13119	2750236	13213	3 - 48	1.81	.50	.141	2	H2
3171113	19459	-	-	-	-	2750231	13215	3 - 56	1.81	.50	.141	2	H2
-	-	-	-	2750313	13126	2750230	13217	4 - 36	1.88	.56	.141	2	H2
2746988	19013	2746982	19016	2750316	13123	2750228	13219	4 - 40	1.88	.56	.141	2	H2
3171115	19462	-	-	-	-	2750225	13223	4 - 48	1.88	.56	.141	2	H2
2746986	19014	2746972	19021	2750312	13128	2750220	13225	5 - 40	1.94	.63	.141	2	H2
3171117	19464	-	-	-	-	2750218	13229	5 - 44	1.94	.63	.141	2	H2
-	-	2746946	19036	2750306	13132	2750210	13232	6 - 32	2.00	.69	.141	2	H3
3171119	19467	2746954	19031	2750309	13131	2750212	13231	6 - 32	2.00	.69	.141	2	H2
-	-	-	-	-	-	2750209	13235	6 - 32	2.00	.69	.141	2	H7
2746944	19037	2746942	19038	-	-	2750206	13237	6 - 40	2.00	.69	.141	2	H2
-	-	2746928	19046	2750300	13137	2750199	13242	8 - 32	2.13	.75	.168	2	H3
-	-	2746941	19039	2750302	13136	2750202	13241	8 - 32	2.13	.75	.168	2	H2
-	-	-	-	-	-	2750204	13240	8 - 32	2.13	.75	.168	2	H1
-	-	-	-	-	-	2750195	13244	8 - 32	2.13	.75	.168	2	H7
-	-	-	-	3047408	13139	2750193	13246	8 - 36	2.13	.75	.168	2	H2
2746984	19015	2746913	19056	2750293	13142	2409831	13251	10 - 24	2.38	.88	.194	2	H3
-	-	-	-	2750294	13141	2750190	13250	10 - 24	2.38	.88	.194	2	H2
-	-	-	-	-	-	2750192	13249	10 - 24	2.38	.88	.194	2	H1
-	-	2746897	19071	2750290	13146	2750175	13257	10 - 32	2.38	.88	.194	2	H3

(continued)

(Series 5301/2301 • Machine Screw and Fractional Sizes • Plug Chamfer — continued)



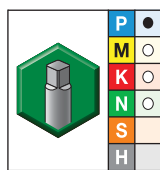
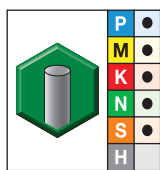
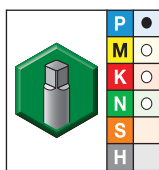
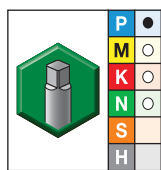
● first choice
○ alternate choice

TiCN		TiN		oxide		uncoated		inch dimensions				number of flutes	pitch diameter limit
order #	catalog #	order #	catalog #	order #	catalog #	order #	catalog #	D1 size	L	L3	D		
-	-	2746899	19069	2750291	13145	2750177	13256	10 - 32	2.38	.88	.194	2	H2
-	-	-	-	-	-	2750179	13255	10 - 32	2.38	.88	.194	2	H1
-	-	-	-	-	-	2750165	13260	10 - 32	2.38	.88	.194	2	H7
2746980	19017	2746889	19076	2750287	13148	2750160	13262	12 - 24	2.38	.94	.220	2	H3
3171130	19482	-	-	2750286	13149	2750159	13264	12 - 28	2.38	.94	.220	2	H3
3171133	19485	2746879	19086	2750282	13152	2750152	13270	1/4 - 20	2.50	1.00	.255	2	H3
-	-	2746877	19088	2750280	13154	2750148	13272	1/4 - 20	2.50	1.00	.255	3	H3
-	-	2863790	19079	2750284	13151	2750154	13269	1/4 - 20	2.50	1.00	.255	2	H2
3171132	19484	-	-	-	-	2750156	13268	1/4 - 20	2.50	1.00	.255	2	H1
-	-	2746869	19096	-	-	2750143	13273	1/4 - 20	2.50	1.00	.255	2	H5
-	-	-	-	-	-	2750141	13274	1/4 - 20	2.50	1.00	.255	3	H5
-	-	-	-	2750278	13157	2750132	13278	1/4 - 28	2.50	1.00	.255	2	H2
3171139	19492	2746865	19101	2750277	13158	2750128	13280	1/4 - 28	2.50	1.00	.255	2	H3
-	-	-	-	-	-	2750135	13277	1/4 - 28	2.50	1.00	.255	2	H1
2746978	19018	-	-	-	-	2750129	13279	1/4 - 28	2.50	1.00	.255	3	H2
-	-	-	-	-	-	2750119	13282	1/4 - 28	2.50	1.00	.255	2	H4
-	-	-	-	-	-	2750118	13283	1/4 - 28	2.50	1.00	.255	3	H4
3171138	19490	-	-	-	-	-	-	1/4 - 28	2.50	1.00	.255	3	H2
3171144	19498	1916977	19106	2750276	13164	2750111	13291	5/16 - 18	2.72	1.13	.318	2	H3
2746976	19019	3171095	19384	1830468	13166	2750109	13293	5/16 - 18	2.72	1.13	.318	3	H3
-	-	-	-	-	-	2750115	13289	5/16 - 18	2.72	1.13	.318	2	H1
-	-	-	-	-	-	2750112	13290	5/16 - 18	2.72	1.13	.318	2	H2
-	-	-	-	-	-	2750105	13294	5/16 - 18	2.72	1.13	.318	2	H5
-	-	-	-	-	-	2750103	13295	5/16 - 18	2.72	1.13	.318	3	H5
-	-	2746861	19103	-	-	-	-	5/16 - 18	2.72	1.13	.318	3	H2
3171148	19504	2746857	19108	2750271	13170	2750088	13300	5/16 - 24	2.72	1.13	.318	2	H3
-	-	-	-	-	-	2750094	13298	5/16 - 24	2.72	1.13	.318	2	H2
-	-	-	-	-	-	2750086	13302	5/16 - 24	2.72	1.13	.318	2	H4
2746974	19020	-	-	-	-	2750084	13303	5/16 - 24	2.72	1.13	.318	3	H4
-	-	-	-	-	-	2750082	13305	3/8 - 16	2.94	1.25	.381	3	H1
-	-	-	-	-	-	2750080	13306	3/8 - 16	2.94	1.25	.381	3	H2
3171152	19509	-	-	-	-	2750075	13309	3/8 - 16	2.94	1.25	.381	3	H5
2746970	19022	2746855	19111	2750268	13176	2750078	13307	3/8 - 16	2.94	1.25	.381	3	H3
2746968	19023	2746853	19112	2750266	13180	2750067	13313	3/8 - 24	2.94	1.25	.381	3	H3
-	-	-	-	-	-	2866897	13312	3/8 - 24	2.94	1.25	.381	3	H2
-	-	-	-	-	-	2750066	13315	3/8 - 24	2.94	1.25	.381	3	H4
2746966	19024	1893987	19113	2750264	13183	2750060	13319	7/16 - 14	3.16	1.44	.323	3	H3
-	-	-	-	-	-	2750062	13318	7/16 - 14	3.16	1.44	.323	3	H2
-	-	-	-	-	-	2750058	13320	7/16 - 14	3.16	1.44	.323	3	H5
2746964	19025	2746849	19114	2750262	13185	2750055	13324	7/16 - 20	3.16	1.44	.323	3	H3

Production Taps

GUN™ Taps • Through Holes in General Machining Applications

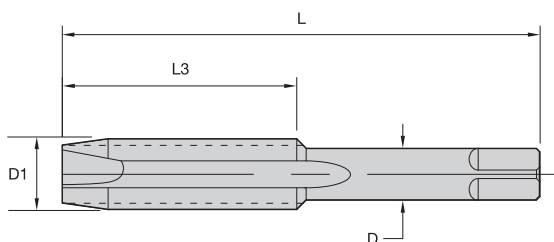
(Series 5301/2301 • Machine Screw and Fractional Sizes • Plug Chamfer — continued)



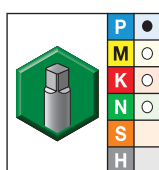
● first choice
○ alternate choice

TiCN		TiN		oxide		uncoated		inch dimensions				number of flutes	pitch diameter limit
order #	catalog #	order #	catalog #	order #	catalog #	order #	catalog #	D1 size	L	L3	D		
—	—	—	—	—	—	2750054	13325	7/16 - 20	3.16	1.44	.323	3	H5
2746962	19026	2746847	19116	2750261	13189	2750052	13328	1/2 - 13	3.38	1.66	.367	3	H3
—	—	—	—	—	—	2750053	13327	1/2 - 13	3.38	1.66	.367	3	H2
3171159	19520	—	—	—	—	2750047	13330	1/2 - 13	3.38	1.66	.367	3	H5
3171161	19524	—	—	—	—	2750041	13333	1/2 - 20	3.38	1.66	.367	3	H2
3171162	19525	—	—	—	—	2750039	13336	1/2 - 20	3.38	1.66	.367	3	H5
2746960	19027	2746845	19117	2750259	13193	2750040	13334	1/2 - 20	3.38	1.66	.367	3	H3
2746958	19028	2746843	19118	2750257	13195	2750036	13339	5/8 - 11	3.81	1.81	.480	3	H3
—	—	—	—	—	—	2750032	13340	5/8 - 11	3.81	1.81	.480	3	H5
—	—	—	—	2750255	13199	2750028	13342	5/8 - 18	3.81	1.81	.480	3	H3
—	—	—	—	—	—	2750023	13344	3/4 - 10	4.25	2.00	.590	3	H5
2746956	19029	2746841	19119	2750256	13197	2750024	13343	3/4 - 10	4.25	2.00	.590	3	H3

NOTE: GUN™ taps for 3B class of fit are suitable for UNJ aerospace internal threading applications.
Refer to tables on pages W231–W232 for the recommended pitch diameter limit for 2B or 3B class of fit.



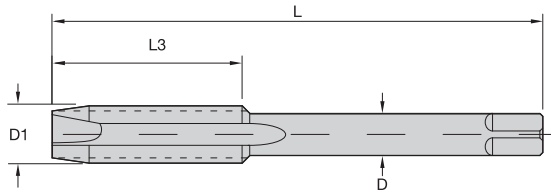
■ Series 5301F • Fractional Sizes • Spiral Point, Plug Chamfer



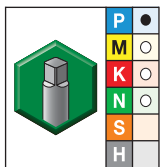
- first choice
- alternate choice

uncoated		inch dimensions				number of flutes	pitch diameter limit
order #	catalog #	D1 size	L	L3	D		
2750139	13275	1/4 - 20	2.50	1.00	.255	2	H11
2750101	13296	5/16 - 18	2.72	1.13	.318	2	H11
2750074	13310	3/8 - 16	2.94	1.25	.381	3	H11
2750046	13331	1/2 - 13	3.38	1.66	.367	3	H11
2750029	13341	5/8 - 11	3.81	1.81	.480	3	H11

NOTE: Refer to tables on pages W231–W232 for the recommended pitch diameter limit for 2B or 3B class of fit.



■ Series 5301 • Fractional Sizes • Spiral Point, Plug Chamfer



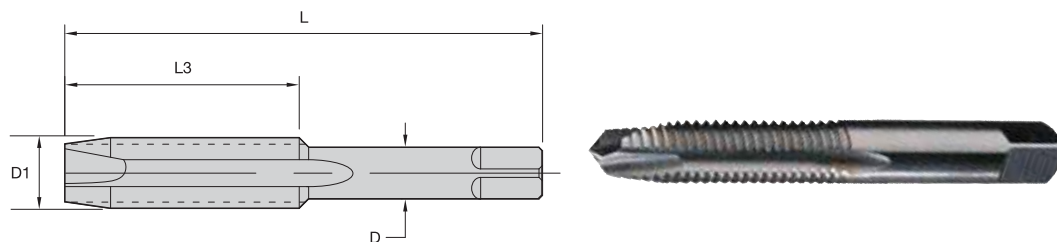
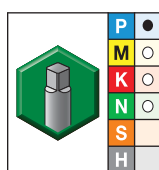
- first choice
- alternate choice

uncoated		inch dimensions				number of flutes	pitch diameter limit
order #	catalog #	D1 size	L	L3	D		
2747035	18930	6 - 32	6.00	.69	.141	2	H3
2747033	18932	8 - 32	6.00	.75	.168	2	H3
2747031	18934	10 - 24	6.00	.88	.194	2	H3
2747029	18935	10 - 32	6.00	.88	.194	2	H3
2747028	18936	1/4 - 20	6.00	1.00	.255	2	H3
2747026	18937	1/4 - 28	6.00	1.00	.255	2	H3
2747024	18938	5/16 - 18	6.00	1.13	.318	2	H3
2747022	18939	5/16 - 24	6.00	1.13	.318	2	H3
2747020	18940	3/8 - 16	6.00	1.25	.381	3	H3
2747018	18941	3/8 - 24	6.00	1.25	.381	3	H3

NOTE: Also available in Hand Tap Series 5305 and 5303.

GUN™ taps for 3B class of fit are suitable for UNJ aerospace internal threading applications.

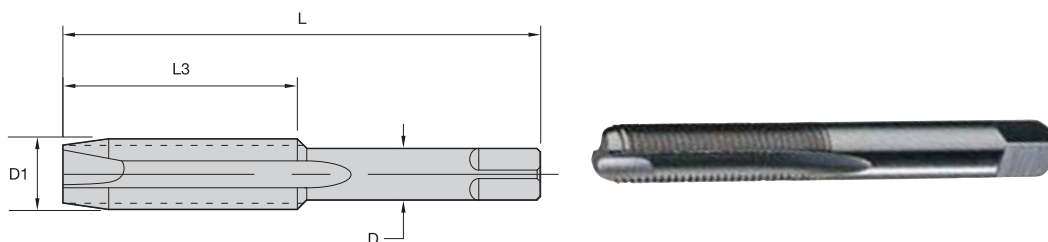
Refer to tables on pages W231–W232 for the recommended pitch diameter limit for 2B or 3B class of fit.


■ Series 5601 • Machine Screw and Fractional • Spiral Point, Plug Chamfer


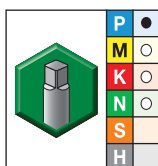
- first choice
- alternate choice

oxide/nitride		inch dimensions				number of flutes	pitch diameter limit
order #	catalog #	D1 size	L	L3	D		
2864368	16802	6 - 32	2.00	.69	.141	3	H3
2747975	16805	8 - 32	2.13	.75	.168	3	H3
2864362	16807	10 - 24	2.38	.88	.194	3	H3
2864359	16809	10 - 32	2.38	.88	.194	3	H3
2864356	16810	1/4 - 20	2.50	1.00	.255	3	H3
2747973	16812	1/4 - 28	2.50	1.00	.255	3	H3
2747971	16814	5/16 - 18	2.72	1.13	.318	3	H3
2747967	16818	3/8 - 16	2.94	1.25	.381	3	H3
2747965	16820	3/8 - 24	2.94	1.25	.381	3	H3
2747959	16826	1/2 - 13	3.38	1.66	.367	3	H3
2747955	16830	5/8 - 11	3.81	1.81	.480	3	H3
2747954	16832	3/4 - 10	4.25	2.00	.590	3	H3

NOTE: GUN™ taps for 3B class of fit are suitable for UNJ aerospace internal threading applications.
 Refer to tables on pages W231–W232 for the recommended pitch diameter limit for 2B or 3B class of fit.



■ Series 5302 • Machine Screw and Fractional • Spiral Point, Bottoming Chamfer

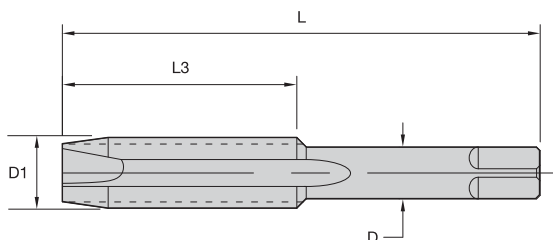


- first choice
- alternate choice

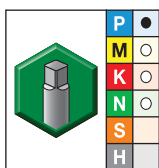
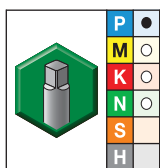
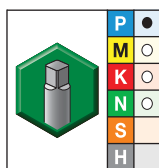
uncoated		inch dimensions				number of flutes	pitch diameter limit
order #	catalog #	D1 size	L	L3	D		
2749944	13602	0 - 80	1.63	.31	.141	2	H2
2749943	13606	2 - 56	1.75	.44	.141	2	H2
2749939	13614	4 - 40	1.88	.56	.141	2	H2
2749936	13617	5 - 40	1.94	.63	.141	2	H2
2749935	13619	6 - 32	2.00	.69	.141	2	H2
2749932	13620	6 - 32	2.00	.69	.141	2	H3
2749931	13623	6 - 40	2.00	.69	.141	2	H2
2749926	13625	8 - 32	2.13	.75	.168	2	H2
2749924	13626	8 - 32	2.13	.75	.168	2	H3
2866734	13629	10 - 24	2.38	.88	.194	2	H2
2749920	13630	10 - 24	2.38	.88	.194	2	H3
2749919	13633	10 - 32	2.38	.88	.194	2	H2
2866726	13634	10 - 32	2.38	.88	.194	2	H3
2749916	13636	12 - 24	2.38	.94	.220	2	H3
2749915	13638	1/4 - 20	2.50	1.00	.255	2	H3
2749914	13639	1/4 - 28	2.50	1.00	.255	2	H3
2749912	13641	5/16 - 18	2.72	1.13	.318	2	H3
2749909	13642	5/16 - 24	2.72	1.13	.318	2	H3

NOTE: Refer to tables on pages W231–W232 for the recommended pitch diameter limit for 2B or 3B class of fit.

- Series 5351TC • TiCN Coated
- Series 2351 • TiN Coated
- Series 5351 • Uncoated



■ Series 5351/2351 • Spiral Point, Plug Chamfer • Metric ANSI



- first choice
- alternate choice

TiCN		TiN		uncoated		inch dimensions				number of flutes	pitch diameter limit
order #	catalog #	order #	catalog #	order #	catalog #	D1 size	L	L3	D		
-		-		2750018	13367	M2 X 0,4	1.75	.44	.141	2	D3
-		-		2750017	13369	M2,5 X 0,45	1.81	.50	.141	2	D3
2747014	19002	2746278	19920	2750015	13371	M3 X 0,5	1.94	.63	.141	2	D3
-		-		2750013	13373	M3,5 X 0,6	2.00	.69	.141	2	D4
-		2746276	19921	2750012	13375	M4 X 0,7	2.13	.75	.168	2	D4
-		-		2750010	13377	M4,5 X 0,75	2.38	.88	.194	2	D4
2747010	19004	2746274	19922	2750009	13379	M5 X 0,8	2.38	.88	.194	2	D4
-		2746272	19923	2750005	13381	M6 X 1	2.50	1.00	.255	2	D5
-		-		2750002	13382	M6,3 X 1	2.50	1.00	.255	2	D5
-		-		2750000	13383	M7 X 1	2.72	1.13	.318	2	D5
2746997	19008	2746270	19924	2749995	13385	M8 X 1,25	2.72	1.13	.318	2	D5
2746995	19009	2746268	19925	2749991	13389	M10 X 1,5	2.94	1.25	.381	3	D6
-		-		2749977	13405	M18 X 2,5	4.03	1.81	.542	3	D7
2746993	19010	2746266	19926	-		M12 X 1,75	3.38	1.66	.367	3	D6

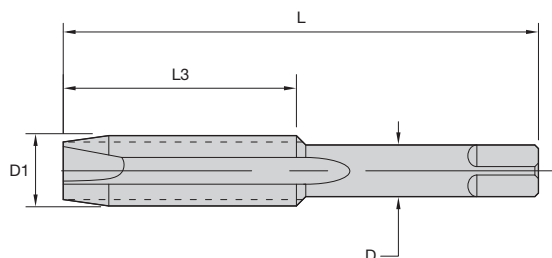
NOTE: Metric taps for 6H class of fit are suitable for MJ aerospace internal threading applications.

Metric taps are manufactured to USCTI specifications and dimensions.

Metric tap blank dimensions are equivalent to inch taps.

Metric D limits suitable for ISO 6H tolerance class.

Refer to tables on pages W231–W232 for the recommended pitch diameter limit for 6H class of fit.



■ Series 7301 • Plug Chamfer

uncoated		inch dimensions				class of fit
order #	catalog #	D1 size	L	L3	D	
2750393	12027	4 - 40	1.88	.56	.141	2B
2750391	12030	5 - 40	1.94	.63	.141	2B
2750387	12032	6 - 32	2.00	.69	.141	2B
2750384	12034	8 - 32	2.15	.75	.168	2B
2750381	12036	10 - 24	2.38	.88	.194	2B
2750379	12037	10 - 32	2.38	.88	.194	2B
2750377	12038	12 - 24	2.38	.94	.220	2B
2750375	12040	1/4 - 20	2.50	1.00	.255	2B
2750374	12041	1/4 - 28	2.50	1.00	.255	2B
2750373	12042	5/16 - 18	2.72	1.13	.318	2B
2750371	12043	5/16 - 24	2.72	1.13	.318	2B
2750370	12044	3/8 - 16	2.94	1.25	.381	2B
2750369	12045	3/8 - 24	2.94	1.25	.381	2B
2750367	12046	7/16 - 14	3.16	1.44	.323	2B
2750364	12047	7/16 - 20	3.16	1.44	.323	2B
2750363	12048	1/2 - 13	3.38	1.66	.367	2B
2750360	12049	1/2 - 20	3.38	1.66	.367	2B
2750359	12050	5/8 - 11	3.81	1.81	.480	2B
2750357	12051	5/8 - 18	3.81	1.81	.480	2B
2750356	12052	3/4 - 10	4.25	1.81	.590	2B