



2017 Master Catalog

WIDIA  TM



Solutions for Through and Blind Hole Applications •

WIDIA-GTD™

Straight Flute



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

- Steel and steel alloys.
- Stainless steel.
- Cast iron.
- Aluminum.

High-Performance Victory™ Solid Carbide Taps

- Straight flute designed for outstanding tool life in cast iron, aluminum, and hardened materials.
- Manufactured with fine-grain micrograin carbide for exceptional wear life.
- Ideal for long production runs where fewer tool changes mean greater productivity.
- Runs up to 4x faster and lasts up to 4x longer than conventional high-speed steel taps.
- Excellent thread quality and tap performance.

High-Performance Victory™ HSS-E-PM Taps

- Straight-flute taps store chips in hole or are flushed out with internal coolant.
- Manufactured from powdered metal high-speed steel coated for thread cutting in cast iron and aluminum.
- Offer performance advantages over conventional high-speed steel taps.
- Long tap life at up to 50% higher tapping speed than HSS taps.

General Purpose Production Taps

- Straight-flute taps manufactured with HSS for use in through and blind hole applications.
- Multiple chamfer options.
- Can be used in general machinery or CNC tapping applications.
- Store chips in their flutes during threading, which protects the workpiece.

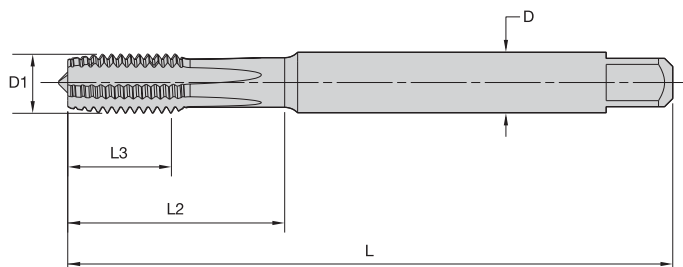


High-Performance Taps

Victory™ Straight-Flute Carbide Taps • Blind and Through Holes

WIDIA
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- WH16PG TiAlN/MoS₂
for steel 55–63 HRC.

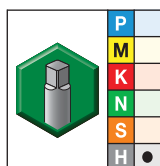


Shank Tolerance

D mm	tolerance h6
1–3	+0, -0,025
3,5–6	+0, -0,030
7–10	+0, -0,036
11–18	+0, -0,043

WIDIA
VICTORY

■ GX10 • Form C Semi-Bottoming Chamfer • Metric DIN 371, 374, and 376 • For Hard Steel

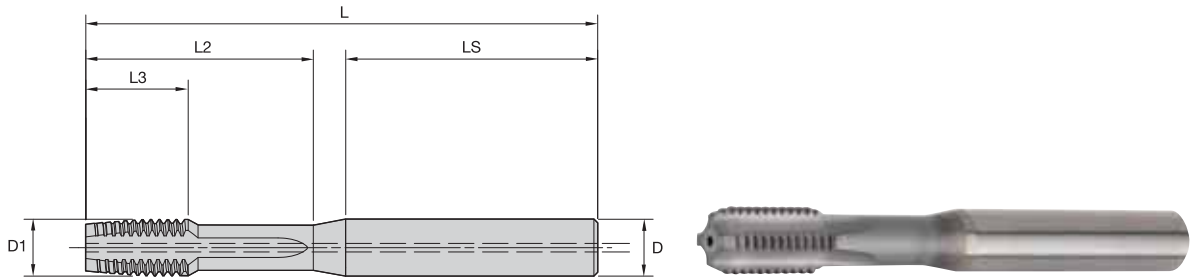


- first choice
- alternate choice

grade WH16PG TiAlN+MoS ₂		metric dimensions					number of flutes	dimension standard	class of fit
order #	catalog #	D1 size	L	L3	L2	D			
4158323	GX105001	M3 X 0,5	63	6	18	4,5	4	DIN 371	6HX
4158324	GX105002	M4 X 0,7	63	8	20	4,5	4	DIN 371	6HX
4158325	GX105003	M5 X 0,8	70	10	26	6,0	4	DIN 371	6HX
4158326	GX105004	M6 X 1	80	12	28	6,0	4	DIN 371	6HX
4158331	GX105009	M8 X 1	90	15	35	8,0	5	DIN 374	6HX
4158327	GX105005	M8 X 1,25	90	15	35	8,0	5	DIN 371	6HX
4158332	GX105010	M10 X 1	100	18	38	10,0	5	DIN 374	6HX
4158328	GX105006	M10 X 1,5	100	18	38	10,0	5	DIN 371	6HX
4158333	GX105011	M12 X 1,5	110	21	41	12,0	5	DIN 374	6HX
4158329	GX105007	M12 X 1,75	110	21	41	12,0	5	DIN 376	6HX
4158334	GX105012	M14 X 1,5	110	24	44	14,0	5	DIN 374	6HX
4158330	GX105008	M14 X 2	110	24	44	14,0	6	DIN 376	6HX
4158335	GX105013	M16 X 1,5	110	24	44	16,0	5	DIN 374	6HX

High-Performance Taps

- WK12PG TiCN for cast iron.

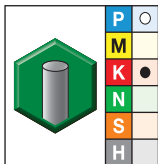


Shank Tolerance

D	tolerance h6
6	+0, -0,008
8-10	+0, -0,009
12-16	+0, -0,011



- GX35 • Form E Bottoming Chamfer • Through Coolant M6 and Larger • Metric • For Cast Iron



- first choice
- alternate choice

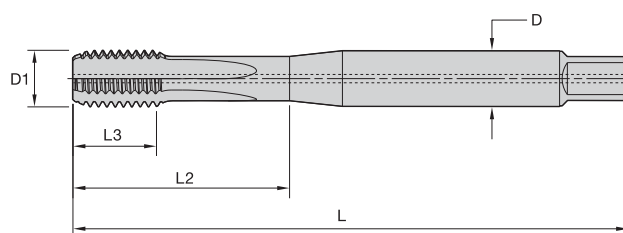
grade WK12PG TiCN		metric dimensions						number of flutes	class of fit
order #	catalog #	D1 size	L	L3	L2	L5	D		
5551152	GX352733	M6 X 1	70	12	24	42	6,0	4	6HX
5551153	GX352734	M8 X 1,25	80	15	32	43	8,0	4	6HX
5551154	GX352735	M10 X 1,5	90	18	40	44	10,0	4	6HX
5551156	GX352738	M12 X 1,5	100	21	48	46	12,0	4	6HX
5551155	GX352737	M12 X 1,75	100	21	48	46	12,0	4	6HX
5551159	GX352740	M14 X 1,5	110	24	56	52	12,0	4	6HX
5551157	GX352739	M14 X 2	110	24	56	52	12,0	4	6HX
5551160	GX352741	M16 X 2	110	24	64	44	14,0	4	6HX

High-Performance Taps

Victory™ Solid Carbide Straight-Flute Taps • Blind Holes

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- WK12PG TiCN for cast iron.

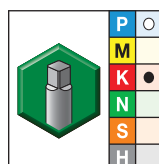


Shank Tolerance

D mm	tolerance h6
6	+0, -0,008
8-10	+0, -0,009
12-16	+0, -0,011

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VICTORY

■ GX35 • Form E Bottoming Chamfer • Through Coolant • Metric • For Cast Iron

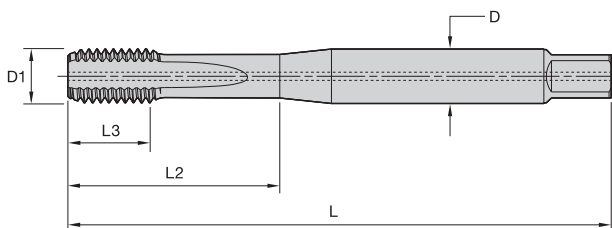


- first choice
- alternate choice

grade WK12PG TiCN		metric dimensions					number of flutes	class of fit
order #	catalog #	D1 size	L	L3	L2	D		
5520825	GX355006	M6 X 1	80	10	30	6,0	4	6HX
5520826	GX355007	M7 X 1	80	10	30	7,0	4	6HX
5520827	GX355008	M8 X 1,25	90	13	35	8,0	4	6HX
5520828	GX355009	M9 X 1,25	90	13	35	9,0	4	6HX
5520830	GX355101	M10 X 1	90	10	35	7,0	4	6HX
5520831	GX355102	M10 X 1,25	100	15	39	7,0	4	6HX
5520829	GX355010	M10 X 1,5	100	15	39	10,0	4	6HX
5520834	GX355121	M12 X 1,25	100	15	39	9,0	4	6HX
5520835	GX355122	M12 X 1,50	100	15	39	9,0	4	6HX
5520833	GX355012	M12 X 1,75	110	18	44	9,0	4	6HX
5520837	GX355141	M14 X 1,25	100	15	47	11,0	4	6HX
5520838	GX355142	M14 X 1,5	100	15	47	11,0	4	6HX
5520836	GX355014	M14 X 2	110	20	52	11,0	4	6HX

High-Performance Taps

- WN14PG TiN + CrC/C for aluminum.

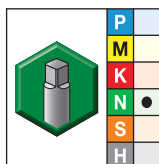


Shank Tolerance

D	tolerance h6
6	+0, -0,008
8-10	+0, -0,009
12-16	+0, -0,011



- GX47 • Form E Bottoming Chamfer • Through Coolant • Metric • For Aluminum



grade WN14PG
TiN+CrC/C

- first choice
- alternate choice

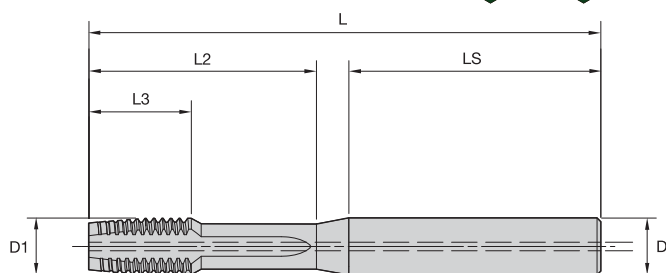
order #	catalog #	D1 size	metric dimensions				number of flutes	class of fit
			L	L3	L2	D		
5520839	GX475006	M6 X 1	80	10	30	6,0	3	6HX
5520840	GX475008	M8 X 1,25	90	10	35	8,0	3	6HX
5520841	GX475010	M10 X 1,5	100	15	39	10,0	3	6HX

High-Performance Taps

Victory™ Solid Carbide Straight-Flute Taps • Blind Holes

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- WN14PG TiN + CrC/C for aluminum.

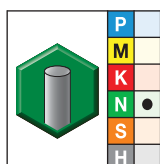


Shank Tolerance

D mm	tolerance h6
6	+0, -0,008
8-10	+0, -0,009
12-16	+0, -0,011

WIDIA
VICTORY

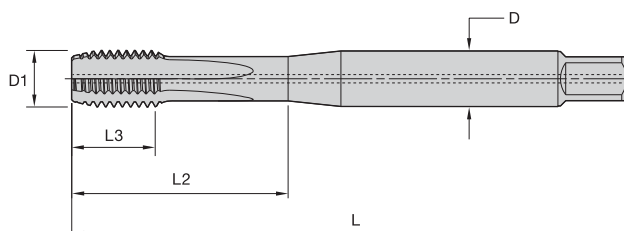
■ GX47 • Form E Bottoming Chamfer • Through Coolant • Metric • For Aluminum



- first choice
- alternate choice

grade WN14PG TiN+CrC/C		metric dimensions						number of flutes	class of fit
order #	catalog #	D1 size	L	L3	L2	LS	D		
5551161	GX472866	M6 X 1	70	12	24	42	6,0	3	6HX
5551162	GX472867	M8 X 1,25	80	15	32	43	8,0	3	6HX
5551163	GX472868	M10 X 1,5	90	18	40	44	10,0	3	6HX
5551164	GX472872	M12 X 1,5	100	21	48	46	12,0	3	6HX
5551165	GX472870	M12 X 1,75	100	21	48	46	12,0	3	6HX
5551166	GX472874	M14 X 1,5	110	24	56	52	12,0	4	6HX
5551167	GX472873	M14 X 2	110	24	56	52	12,0	4	6HX
5551168	GX472875	M16 X 2	110	24	64	44	14,0	4	6HX

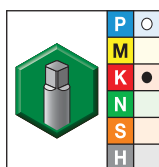
- WK12PG TiCN for cast iron.



Shank Tolerance	
D mm	tolerance h6
6	+0, -0,008
8-10	+0, -0,009
12-16	+0, -0,011



- GX50 • Form C Semi-Bottoming Chamfer • Through Coolant M6 and Larger • Metric • For Cast Iron



- first choice
- alternate choice

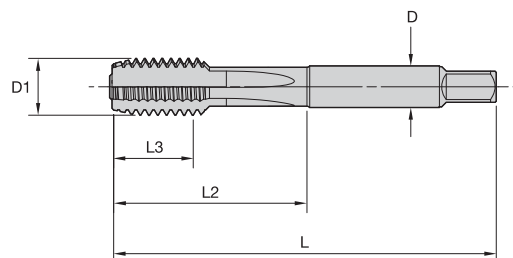
grade WK12PG TiCN		metric dimensions					number of flutes	class of fit
order #	catalog #	D1 size	L	L3	L2	D		
5520817	GX505004	M4 X 0,7	63	10	21	4,5	3	6HX
5520818	GX505005	M5 X 0,8	70	10	25	6,0	3	6HX
5520819	GX505006	M6 X 1	80	10	30	6,0	4	6HX
5520820	GX505008	M8 X 1,25	90	13	35	8,0	4	6HX
5520822	GX505010	M10 X 1,5	100	15	39	10,0	4	6HX
5520823	GX505012	M12 X 1,75	110	18	44	9,0	4	6HX
5520824	GX505014	M14 X 2	110	20	52	11,0	4	6HX

High-Performance Taps

Victory™ Straight-Flute HSS-E-PM Taps • Through and Blind Holes

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- GP6520 TiCN for cast iron and cast aluminum.

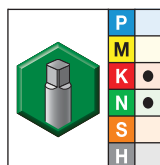


Shank Tolerance

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

■ GT40 • Machine Screw and Fractional • Form C Semi-Bottoming Chamfer • ANSI • For Cast Iron and Cast Aluminum

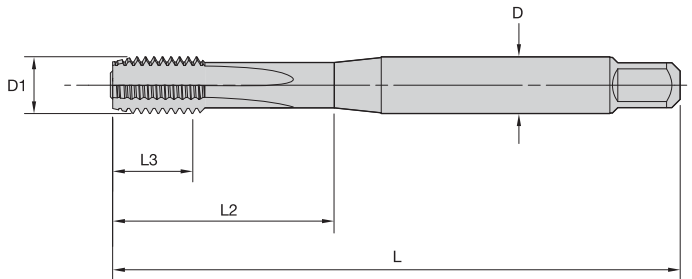


- first choice
- alternate choice

grade GP6520 TiCN		inch dimensions					number of flutes	class of fit
order #	catalog #	D1 size	L	L3	L2	D		
4035535	GT405012	10 - 24	2.37	.47	.91	.194	4	3BX
4035536	GT405013	10 - 32	2.36	.47	.91	.194	4	3BX
4035537	GT405014	1/4 - 20	2.50	.44	1.01	.255	4	2BX
4035538	GT405015	1/4 - 20	2.50	.44	1.01	.255	4	3BX
4035539	GT405016	1/4 - 28	2.49	.43	1.00	.255	4	2BX
4035540	GT405017	1/4 - 28	2.49	.43	1.00	.255	4	3BX
4035541	GT405018	5/16 - 18	2.72	.49	1.13	.318	4	2BX
4035542	GT405019	5/16 - 18	2.72	.49	1.13	.318	4	3BX
4035563	GT405020	5/16 - 24	2.71	.48	1.13	.318	4	3BX
4035564	GT405021	3/8 - 16	2.94	.60	1.27	.381	4	2BX
4035565	GT405022	3/8 - 16	2.94	.60	1.27	.381	4	3BX
4035566	GT405023	3/8 - 24	2.92	.58	1.25	.381	4	3BX
4035567	GT405024	7/16 - 14	3.16	.71	1.49	.323	4	3BX
4035568	GT405025	7/16 - 20	3.16	.71	1.49	.323	4	3BX
4035569	GT405026	1/2 - 13	3.38	.77	1.74	.367	4	3BX
4035570	GT405027	1/2 - 20	3.38	.77	1.74	.367	4	3BX
4035571	GT405028	5/8 - 11	3.81	.91	1.89	.480	4	3BX
4035572	GT405029	3/4 - 10	4.25	1.00	2.08	.590	4	3BX

High-Performance Taps

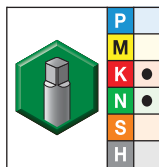
- GP6520 TiCN for cast iron and cast aluminum.


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



- GT40 • Machine Screw and Fractional • Form C Semi-Bottoming Chamfer • DIN Length ANSI Shank
- For Cast Iron and Cast Aluminum



- first choice
- alternate choice

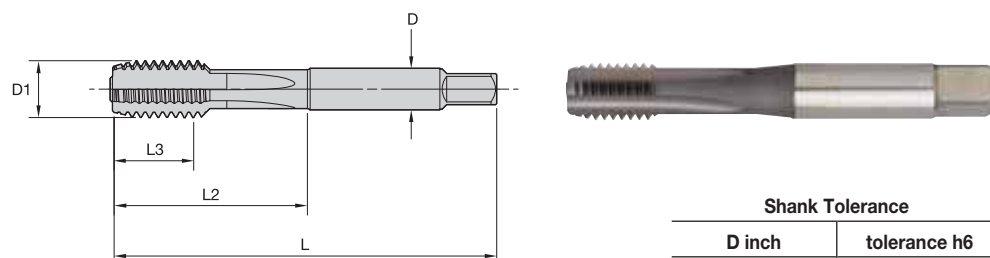
grade GP6520 TiCN		inch dimensions					number of flutes	class of fit
order #	catalog #	D1 TPI	L	L3	L2	D		
4157922	GT405039	6 - 32	2.20	.39	.79	.141	3	2BX
4157931	GT405048	6 - 40	2.20	.40	.79	.141	3	2BX
4157923	GT405040	8 - 32	2.48	.39	.83	.168	3	2BX
4157924	GT405041	10 - 24	2.76	.39	.98	.194	3	2BX
4157933	GT405050	10 - 32	2.76	.40	.98	.194	3	2BX
4157926	GT405043	1/4 - 20	3.15	.51	1.18	.255	3	3BX
4157935	GT405052	1/4 - 28	3.15	.51	1.18	.255	3	3BX
4157927	GT405044	5/16 - 18	3.54	.55	1.38	.318	4	3BX
4157936	GT405053	5/16 - 24	3.54	.55	1.38	.318	4	3BX
4157928	GT405045	3/8 - 16	3.94	.63	1.53	.381	4	3BX
4157937	GT405054	3/8 - 24	3.94	.63	1.53	.381	4	3BX
4157929	GT405046	7/16 - 14	3.94	.71	1.61	.323	4	3BX
4157938	GT405055	7/16 - 20	3.94	.71	1.61	.323	4	3BX
4157930	GT405047	1/2 - 13	4.33	.79	1.85	.367	4	3BX
4157939	GT405056	1/2 - 20	4.33	.79	1.85	.367	4	3BX

High-Performance Taps

Victory™ Straight-Flute HSS-E-PM Taps • Through and Blind Holes

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- GP6520 TiCN for cast iron and cast aluminum.

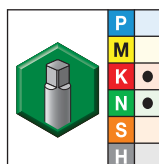


Shank Tolerance

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

■ GT40 • Form C Semi-Bottoming Chamfer • Metric ANSI • For Cast Iron and Cast Aluminum

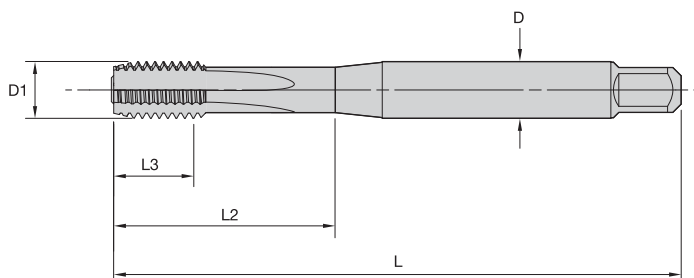


- first choice
- alternate choice

grade GP6520 TiCN		inch dimensions					number of flutes	class of fit
order #	catalog #	D1 size	L	L3	L2	D		
4035576	GT405030	M3 X 0,5	1.94	.63	.75	.141	3	6HX
4035577	GT405031	M4 X 0,7	2.12	.32	.76	.168	3	6HX
4035578	GT405032	M5 X 0,8	2.37	.47	.91	.194	3	6HX
4035579	GT405033	M6 X 1	2.50	.46	1.01	.255	4	6HX
4035580	GT405034	M8 X 1,25	2.71	.48	1.13	.318	4	6HX
4035581	GT405035	M10 X 1,5	2.92	.53	1.26	.381	4	6HX
4035582	GT405036	M12 X 1,75	3.38	.77	1.74	.367	4	6HX
4035583	GT405037	M14 X 2	3.59	.83	1.74	.429	4	6HX
4035584	GT405038	M16 X 2	3.81	.91	1.89	.480	4	6HX

High-Performance Taps

- GP6520 TiCN for cast iron and cast aluminum.

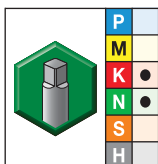


Shank Tolerance

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



- GT40 • Form C Semi-Bottoming Chamfer • Metric DIN 371, 374, and 376 • For Cast Iron and Cast Aluminum



● first choice

○ alternate choice

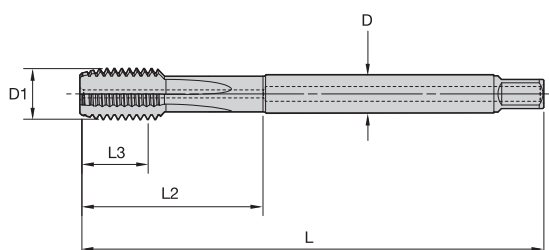
grade GP6520 TiCN		metric dimensions					number of flutes	dimension standard	class of fit
order #	catalog #	D1 size	L	L3	L2	D			
4033699	GT405001	M4 X 0,7	63	10	21	4,5	3	DIN 371	6HX
4033700	GT405002	M5 X 0,8	70	10	25	6,0	3	DIN 371	6HX
4033701	GT405003	M6 X 1	80	10	30	6,0	4	DIN 371	6HX
4033702	GT405004	M8 X 1,25	90	13	35	8,0	4	DIN 371	6HX
4033753	GT405005	M10 X 1,5	100	15	39	10,0	4	DIN 371	6HX
5408066	GT405057	M12 X 1,5	100	15	39	9,0	4	DIN 374	6HX
4033754	GT405006	M12 X 1,75	110	18	44	9,0	4	DIN 376	6HX
5408067	GT405058	M14 X 1,5	100	15	47	11,0	4	DIN 374	6HX
4033755	GT405007	M14 X 2	110	20	52	11,0	4	DIN 376	6HX
5408068	GT405059	M16 X 1,5	100	15	46	12,0	4	DIN 374	6HX
4033756	GT405008	M16 X 2	110	20	51	12,0	4	DIN 376	6HX
4033757	GT405009	M18 X 2,5	125	25	58	14,0	4	DIN 376	6HX
4033758	GT405010	M20 X 2,5	140	25	64	16,0	4	DIN 376	6HX
4033759	GT405011	M22 X 2,5	140	25	70	18,0	4	DIN 376	6HX

High-Performance Taps

Victory™ Straight-Flute HSS-E-PM Taps • Through and Blind Holes

WIDIA
GTD™

- GP6520 TiCN for cast iron and cast aluminum.

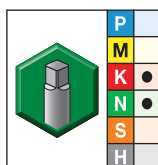


Shank Tolerance

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

- GT41 • Fractional • Form C Semi-Bottoming Chamfer • DIN Length ANSI Shank • Through Coolant
- For Cast Iron and Cast Aluminum

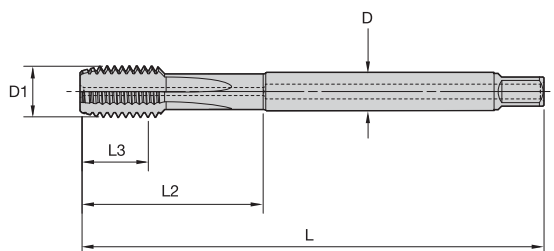


- first choice
- alternate choice

grade GP6520 TiCN		inch dimensions					number of flutes	class of fit
order #	catalog #	D1 TPI	L	L3	L2	D		
4157940	GT415011	1/4 - 20	3.15	.51	1.18	.255	4	3BX
4157945	GT415016	1/4 - 28	3.15	.51	1.18	.255	4	3BX
4157941	GT415012	5/16 - 18	3.54	.55	1.38	.318	4	3BX
4157946	GT415017	5/16 - 24	3.54	.55	1.38	.318	4	3BX
4157942	GT415013	3/8 - 16	3.94	.63	1.53	.381	4	3BX
4157947	GT415018	3/8 - 24	3.94	.63	1.53	.381	4	3BX
4157943	GT415014	7/16 - 14	3.94	.71	1.61	.323	4	3BX
4157948	GT415019	7/16 - 20	3.94	.71	1.61	.323	4	3BX
4157944	GT415015	1/2 - 13	4.33	.79	1.85	.367	4	3BX
4157949	GT415020	1/2 - 20	4.33	.79	1.85	.367	4	3BX

High-Performance Taps

- GP6520 TiCN for cast iron and cast aluminum.

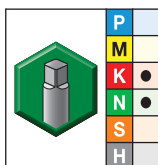


Shank Tolerance

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



- GT41 • Form C Semi-Bottoming Chamfer • Through Coolant • Metric DIN 371, 374, and 376 • For Cast Iron and Cast Aluminum



- first choice
- alternate choice

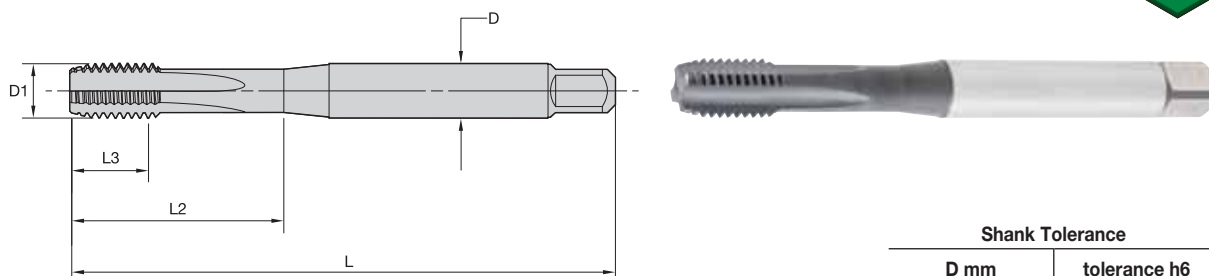
grade GP6520 TiCN		metric dimensions					number of flutes	dimension standard	class of fit
order #	catalog #	D1 size	L	L3	L2	D			
4033659	GT415001	M4 X 0,7	63	10	21	4,5	3	DIN 371	6HX
4033660	GT415002	M5 X 0,8	70	10	25	6,0	3	DIN 371	6HX
4033661	GT415003	M6 X 1	80	10	30	6,0	4	DIN 371	6HX
4033662	GT415004	M8 X 1,25	90	13	35	8,0	4	DIN 371	6HX
4033813	GT415005	M10 X 1,5	100	15	39	10,0	4	DIN 371	6HX
5408069	GT415021	M12 X 1,5	100	15	39	9,0	4	DIN 374	6HX
4033814	GT415006	M12 X 1,75	110	18	44	9,0	4	DIN 376	6HX
5408400	GT415022	M14 X 1,5	100	15	47	11,0	4	DIN 374	6HX
4033815	GT415007	M14 X 2	110	20	52	11,0	4	DIN 376	6HX
5408401	GT415023	M16 X 1,5	100	15	46	12,0	4	DIN 374	6HX
4033816	GT415008	M16 X 2	110	20	51	12,0	4	DIN 376	6HX
4033817	GT415009	M18 X 2,5	125	25	58	14,0	4	DIN 376	6HX
4033818	GT415010	M20 X 2,5	140	25	64	16,0	4	DIN 376	6HX

High-Performance Taps

Victory™ Straight-Flute HSS-E-PM Taps • Threading Close to the Bottom in Blind Holes

WIDIA
GTD™

- GP6520 TiCN for cast iron and cast aluminum.

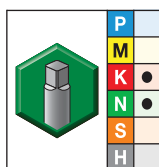


Shank Tolerance

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

■ GT42 • Form E Bottoming Chamfer • Metric DIN 371, 374, and 376 • For Cast Iron and Cast Aluminum

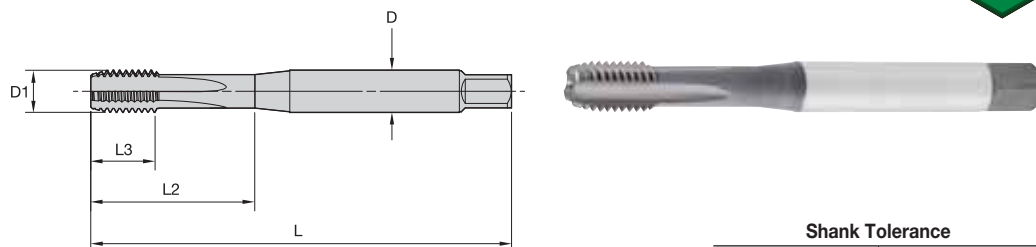


- first choice
- alternate choice

grade GP6520 TiCN		metric dimensions					number of flutes	dimension standard	class of fit
order #	catalog #	D1 size	L	L3	L2	D			
4154274	GT425001	M5 X 0,8	70	10	25	6,0	3	DIN 371	6HX
4154275	GT425002	M6 X 1	80	10	30	6,0	4	DIN 371	6HX
4154276	GT425003	M8 X 1,25	90	13	35	8,0	4	DIN 371	6HX
4154277	GT425004	M10 X 1,5	100	15	39	10,0	4	DIN 371	6HX
4154280	GT425007	M12 X 1,5	100	15	39	9,0	4	DIN 374	6HX
4154278	GT425005	M12 X 1,75	110	18	44	9,0	4	DIN 376	6HX
4154281	GT425008	M14 X 1,5	100	15	47	11,0	4	DIN 374	6HX
4154279	GT425006	M14 X 2	110	20	52	11,0	4	DIN 376	6HX
4154282	GT425009	M16 X 1,5	100	15	46	12,0	4	DIN 374	6HX
5408402	GT425010	M16 X 2	110	20	51	12,0	4	DIN 376	6HX
5408403	GT425011	M18 X 2,5	125	25	58	14,0	4	DIN 376	6HX
5408404	GT425012	M20 X 2,5	140	25	64	16,0	4	DIN 376	6HX

High-Performance Taps

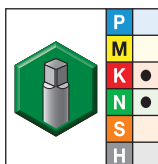
- GP6520 TiCN for cast iron and cast aluminum.


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



- GT43 • Form E Bottoming Chamfer • Through Coolant • Metric DIN 371, 374, and 376 • For Cast Iron and Cast Aluminum



grade GP6520
TiCN

- first choice
- alternate choice

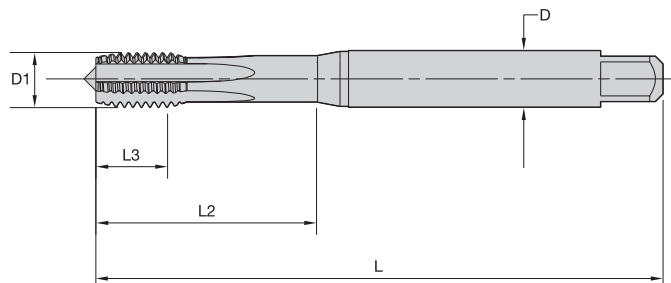
order #	catalog #	D1 size	metric dimensions				number of flutes	dimension standard	class of fit
			L	L3	L2	D			
4154283	GT435001	M5 X 0,8	70	10	25	6,0	3	DIN 371	6HX
4154284	GT435002	M6 X 1	80	10	30	6,0	4	DIN 371	6HX
4154285	GT435003	M8 X 1,25	90	13	35	8,0	4	DIN 371	6HX
4154286	GT435004	M10 X 1,5	100	15	39	10,0	4	DIN 371	6HX
4154289	GT435007	M12 X 1,5	100	15	39	9,0	4	DIN 374	6HX
4154287	GT435005	M12 X 1,75	110	18	44	9,0	4	DIN 376	6HX
4154290	GT435008	M14 X 1,5	100	15	47	11,0	4	DIN 374	6HX
4154288	GT435006	M14 X 2	110	20	52	11,0	4	DIN 376	6HX
4154291	GT435009	M16 X 1,5	100	15	46	12,0	4	DIN 374	6HX
5408405	GT435010	M16 X 2	110	20	51	12,0	4	DIN 376	6HX
5408406	GT435011	M18 X 2,5	125	25	58	14,0	4	DIN 376	6HX
5408407	GT435012	M20 X 2,5	140	25	64	16,0	4	DIN 376	6HX

High-Performance Taps

Victory™ Straight-Flute HSS-E-PM Taps • Blind and Through Holes

WIDIA
GTD™

- WS32MG TiCN for steel 44–55 HRC.

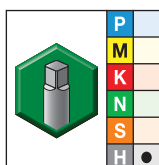


Shank Tolerance

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

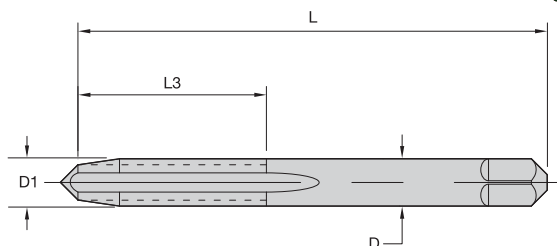
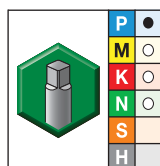
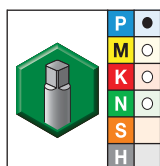
■ GT06 • Form C Semi-Bottoming Chamfer • Metric DIN 371, 374, and 376 • For Hard Steel



- 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			
4159915	GT065003	M6 X 1	80	10	30	6,0	4	DIN 371	6HX
4159918	GT065006	M8 X 1	90	10	35	8,0	5	DIN 374	6HX
4159913	GT065001	M8 X 1,25	90	14	35	8,0	5	DIN 371	6HX
4159919	GT065007	M10 X 1	90	10	35	10,0	5	DIN 374	6HX
4159914	GT065002	M10 X 1,5	100	16	39	10,0	5	DIN 371	6HX
4159920	GT065008	M12 X 1,5	100	15	—	9,0	5	DIN 374	6HX
4159916	GT065004	M12 X 1,75	110	18	—	9,0	5	DIN 376	6HX
4159921	GT065009	M14 X 1,5	100	15	—	11,0	6	DIN 374	6HX
4159922	GT065010	M16 X 1,5	100	15	—	12,0	6	DIN 374	6HX
4159917	GT065005	M16 X 2	110	22	—	12,0	6	DIN 376	6HX

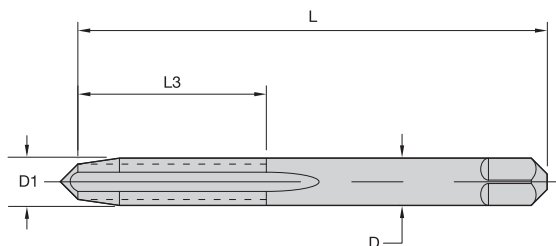
High-Performance Taps


Series 5305 • Machine Screw Sizes • Taper Chamfer


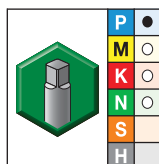
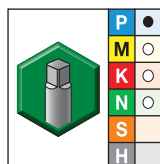
● first choice
 ○ alternate choice

oxide		uncoated		inch dimensions				number of flutes	pitch diameter limit
order #	catalog #	order #	catalog #	D1 size	L	L3	D		
-		2748991	15102	0 - 80	1.63	.31	.141	2	H1
-		2748975	15114	1 - 64	1.69	.38	.141	2	H1
-		2748964	15120	1 - 72	1.69	.38	.141	2	H1
-		2748956	15128	2 - 56	1.75	.44	.141	3	H1
-		2748951	15134	2 - 56	1.75	.44	.141	3	H2
-		2748935	15144	2 - 64	1.75	.44	.141	3	H2
-		2748925	15156	3 - 48	1.81	.50	.141	3	H2
-		2748913	15166	3 - 56	1.81	.50	.141	3	H2
2709836	19563	2748887	15184	4 - 40	1.88	.56	.141	3	H2
-		2748869	15196	4 - 48	1.88	.56	.141	3	H2
-		2865323	15209	5 - 40	1.94	.63	.141	3	H2
-		2748858	15220	5 - 44	1.94	.63	.141	3	H2
-		2865295	15225	6 - 32	2.00	.69	.141	3	H1
-		2748845	15231	6 - 32	2.00	.69	.141	3	H2
-		2748827	15257	6 - 40	2.00	.69	.141	3	H2
2709816	19573	2865268	15237	6 - 32	2.00	.69	.141	3	H3
-		2748806	15275	8 - 32	2.13	.75	.168	4	H2
-		2748764	15301	8 - 36	2.13	.75	.168	4	H2
2709810	19583	2748787	15283	8 - 32	2.13	.75	.168	4	H3
-		2748708	15344	10 - 32	2.38	.88	.194	4	H1
-		2748747	15320	10 - 24	2.38	.88	.194	4	H2
-		2748694	15352	10 - 32	2.38	.88	.194	4	H2
2709804	19597	2748738	15327	10 - 24	2.38	.88	.194	4	H3
2709796	19613	2748679	15360	10 - 32	2.38	.88	.194	4	H3
-		2748645	15383	12 - 24	2.38	.94	.220	4	H3
-		2748631	15390	12 - 28	2.38	.94	.220	4	H3

NOTE: Hand taps for 3B class of fit are suitable for UNJ aerospace internal threading applications.
 Refer to tables on pages W231-232 for the recommended pitch diameter limit for 2B or 3B class of fit.



■ Series 5303 • Fractional Sizes • Taper Chamfer

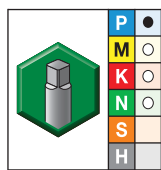
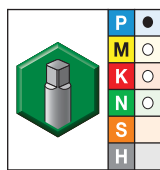


● first choice
○ alternate choice

oxide		uncoated		inch dimensions				number of flutes	pitch diameter limit
order #	catalog #	order #	catalog #	D1 size	L	L3	D		
–		2749838	14010	1/4 - 20	2.50	1.00	.255	4	H1
–		2749832	14015	1/4 - 20	2.50	1.00	.255	4	H2
2709949	19167	3139335	14022	1/4 - 20	2.50	1.00	.255	4	H3
2709942	19208	2749775	14055	1/4 - 28	2.50	1.00	.255	4	H3
2709937	19237	2749737	14092	5/16 - 18	2.72	1.13	.318	4	H3
–		2749689	14122	5/16 - 24	2.72	1.13	.318	4	H3
2709923	19278	2749651	14157	3/8 - 16	2.94	1.25	.381	4	H3
3177076	19304	2749611	14190	3/8 - 24	2.94	1.25	.381	4	H3
–		2749586	14221	7/16 - 14	3.16	1.44	.323	4	H3
–		2749568	14246	7/16 - 20	3.16	1.44	.323	4	H3
2709916	19354	2749543	14281	1/2 - 13	3.38	1.66	.367	4	H3
2709909	19377	2749514	14308	1/2 - 20	3.38	1.66	.367	4	H3
–		3139336	14338	9/16 - 12	3.59	1.66	.429	4	H3
–		2749476	14356	9/16 - 18	3.59	1.66	.429	4	H3
2709902	19407	2749460	14379	5/8 - 11	3.81	1.81	.480	4	H3
–		2749432	14402	5/8 - 18	3.81	1.81	.480	4	H3
–		2749406	14423	11/16 - 11	4.03	1.06	.542	4	H3
–		2749400	14427	11/16 - 16	4.03	1.06	.542	4	H3
2709895	19443	2749394	14448	3/4 - 10	4.25	2.00	.590	4	H3
–		2749374	14471	3/4 - 16	4.25	2.00	.590	4	H3
–		2749356	14499	7/8 - 9	4.69	2.22	.697	4	H4
–		2749340	14516	7/8 - 14	4.69	2.22	.697	4	H4
–		2749327	14544	1 - 8	5.13	2.50	.800	4	H4
–		2749308	14557	1 - 12	5.13	2.50	.800	4	H4

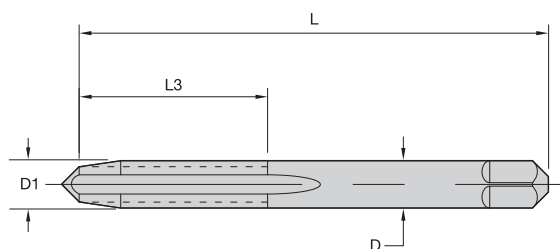
(continued)

(Series 5303 • Fractional Sizes • Taper Chamfer — continued)

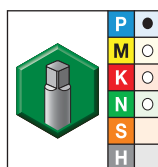

 ● first choice
 ○ alternate choice

oxide		uncoated		inch dimensions				number of flutes	pitch diameter limit
order #	catalog #	order #	catalog #	D1 size	L	L3	D		
—		2749294	14568	1 - 14	5.13	2.50	.800	4	H4
—		2749281	14594	1 1/8 - 7	5.44	2.56	.896	4	H4
—		2749274	14603	1 1/8 - 12	5.44	2.56	.896	4	H4
—		2749265	14612	1 1/4 - 7	5.75	2.56	1.021	4	H4
—		3171056	14620	1 1/4 - 12	5.75	2.56	1.021	6	H4
—		3012774	14632	1 3/8 - 6	6.06	3.00	1.108	4	H4
—		3171057	14640	1 3/8 - 12	6.06	3.00	1.108	6	H4
—		2749241	14645	1 1/2 - 6	6.38	3.00	1.233	4	H4
—		3012776	14653	1 1/2 - 12	6.38	3.00	1.233	6	H4

NOTE: Hand 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 5353 • Taper Chamfer • Metric ANSI

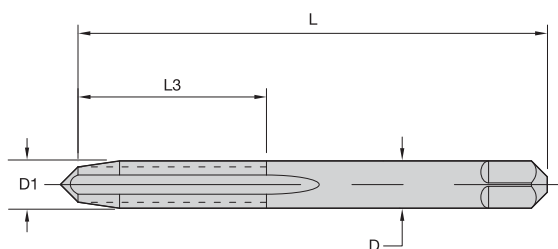


- first choice
- alternate choice

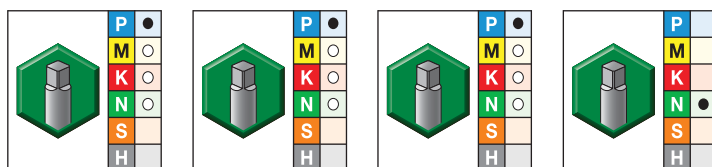
uncoated		inch dimensions				number of flutes	pitch diameter limit
order #	catalog #	D1 size	L	L3	D		
2749221	14725	M2 X 0,4	1.75	.44	.141	3	D3
2749207	14741	M3 X 0,5	1.94	.63	.141	3	D3
2749197	14757	M4 X 0,7	2.13	.75	.168	4	D4
2749189	14773	M5 X 0,8	2.38	.88	.194	4	D4
2749161	14797	M8 X 1,25	2.72	1.13	.318	4	D5
2749152	14813	M10 X 1,5	2.94	1.25	.381	4	D6
2749144	14829	M12 X 1,75	3.38	1.66	.367	4	D6
2749134	14845	M14 X 2	3.59	1.66	.429	4	D7
2749123	14861	M16 X 2	3.81	1.81	.480	4	D7
2749117	14877	M18 X 2,5	4.03	1.06	.542	4	D7
2749106	14893	M20 X 2,5	4.47	2.00	.652	4	D7
2749096	14909	M24 X 3	4.91	2.22	.760	4	D8
2749086	14925	M30 X 3,5	5.44	2.56	1.021	4	D9
2749077	14941	M36 X 4	6.06	3.00	1.233	4	D9

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

- Series 5305TC • TiCN Coated
- Series 2305 • TiN Coated
- Series 5305S • SH50 Steam Oxide
- Series 5305 • Uncoated



■ Series 5305/2305 • Machine Screw Sizes • Plug Chamfer



- first choice
- alternate choice

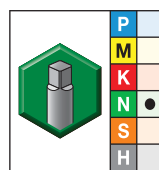
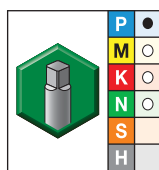
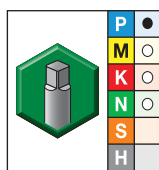
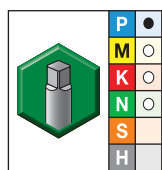
TiCN		TiN		oxide		uncoated		inch dimensions				number of flutes	pitch diameter limit
order #	catalog #	order #	catalog #	order #	catalog #	order #	catalog #	D1 size	L	L3	D		
-	-	-	-	-	-	2748988	15103	0 - 80	1.63	.31	.141	2	H1
2746839	19121	2746715	19202	-	-	2748979	15107	0 - 80	1.63	.31	.141	2	H2
-	-	-	-	-	-	2748972	15115	1 - 64	1.69	.38	.141	2	H1
-	-	-	-	-	-	2748966	15118	1 - 64	1.69	.38	.141	2	H2
-	-	-	-	-	-	2748963	15121	1 - 72	1.69	.38	.141	2	H1
-	-	-	-	-	-	2748959	15125	1 - 72	1.69	.38	.141	2	H2
-	-	-	-	-	-	2865450	15129	2 - 56	1.75	.44	.141	3	H1
2746837	19122	2040972	19207	-	-	2748950	15135	2 - 56	1.75	.44	.141	3	H2
-	-	-	-	-	-	2748943	15138	2 - 56	1.75	.44	.141	2	H2
-	-	-	-	-	-	2748933	15145	2 - 64	1.75	.44	.141	3	H2
-	-	-	-	-	-	2748924	15157	3 - 48	1.81	.50	.141	3	H2
-	-	2748614	15433	-	-	2748916	15160	3 - 48	1.81	.50	.141	2	H2
-	-	-	-	-	-	2748911	15167	3 - 56	1.81	.50	.141	3	H2
2746835	19123	2041049	19211	2709830	19565	2748885	15185	4 - 40	1.88	.56	.141	3	H2
-	-	-	-	-	-	2748878	15189	4 - 40	1.88	.56	.141	2	H2
-	-	-	-	-	-	2748867	15197	4 - 48	1.88	.56	.141	3	H2
2746833	19124	2746697	19216	-	-	2865319	15210	5 - 40	1.94	.63	.141	3	H2
-	-	2748606	15437	-	-	2865310	15214	5 - 40	1.94	.63	.141	2	H2
-	-	-	-	-	-	2748855	15221	5 - 44	1.94	.63	.141	3	H2
2748850	15224	-	-	2746500	19575	2748843	15238	6 - 32	2.00	.69	.141	3	H3
-	-	-	-	-	-	2865292	15226	6 - 32	2.00	.69	.141	3	H1
-	-	2041051	19221	-	-	2865279	15232	6 - 32	2.00	.69	.141	3	H2
-	-	-	-	-	-	2865271	15235	6 - 32	2.00	.69	.141	2	H2
-	-	-	-	-	-	2748836	15245	6 - 32	2.00	.69	.141	2	H3

(continued)

Production Taps

Hand Taps • Through or Blind Holes in General Machining Applications

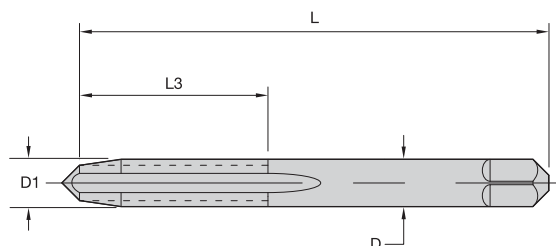
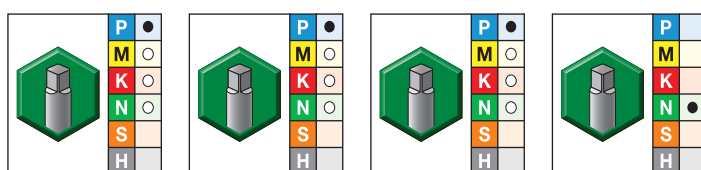
(Series 5305/2305 • Machine Screw Sizes • Plug Chamfer — continued)



● 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		
-	-	-	-	-	-	2748825	15258	6 - 40	2.00	.69	.141	3	H2
-	-	-	-	-	-	2748816	15262	6 - 40	2.00	.69	.141	2	H2
-	-	-	-	-	-	2748813	15268	8 - 32	2.13	.75	.168	4	H1
2748810	15270	-	-	2746492	19585	2748785	15284	8 - 32	2.13	.75	.168	4	H3
-	-	2463623	19226	-	-	2748804	15276	8 - 32	2.13	.75	.168	4	H2
-	-	-	-	-	-	2748800	15279	8 - 32	2.13	.75	.168	2	H2
-	-	-	-	-	-	2748792	15281	8 - 32	2.13	.75	.168	3	H2
-	-	-	-	-	-	2748774	15291	8 - 32	2.13	.75	.168	2	H3
-	-	2748598	15442	-	-	2748768	15293	8 - 32	2.13	.75	.168	3	H3
-	-	-	-	-	-	2748766	15295	8 - 32	2.13	.75	.168	4	H7
-	-	-	-	-	-	2748761	15302	8 - 36	2.13	.75	.168	4	H2
-	-	-	-	-	-	2748749	15314	10 - 24	2.38	.88	.194	4	H1
-	-	-	-	-	-	2748746	15321	10 - 24	2.38	.88	.194	4	H2
-	-	-	-	-	-	2748740	15324	10 - 24	2.38	.88	.194	2	H2
2746831	19126	2603956	19231	2746490	19600	2748736	15328	10 - 24	2.38	.88	.194	4	H3
-	-	-	-	-	-	2748730	15335	10 - 24	2.38	.88	.194	2	H3
-	-	2748595	15444	-	-	2748726	15337	10 - 24	2.38	.88	.194	3	H3
-	-	-	-	-	-	2748706	15345	10 - 32	2.38	.88	.194	4	H1
2748697	15348	2622811	19236	2746486	19615	2748678	15361	10 - 32	2.38	.88	.194	4	H3
-	-	-	-	-	-	2748692	15353	10 - 32	2.38	.88	.194	4	H2
-	-	-	-	-	-	2748684	15356	10 - 32	2.38	.88	.194	2	H2
-	-	-	-	-	-	2748681	15358	10 - 32	2.38	.88	.194	3	H2
-	-	-	-	-	-	2748666	15368	10 - 32	2.38	.88	.194	2	H3
-	-	2748585	15450	-	-	2748662	15370	10 - 32	2.38	.88	.194	3	H3
2746830	19127	2746663	19241	-	-	2748643	15384	12 - 24	2.38	.94	.220	4	H3
-	-	-	-	-	-	2748628	15391	12 - 28	2.38	.94	.220	4	H3

NOTE: Hand 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 5303/2303 • Fractional Sizes • Plug Chamfer


● first choice
 ○ alternate choice

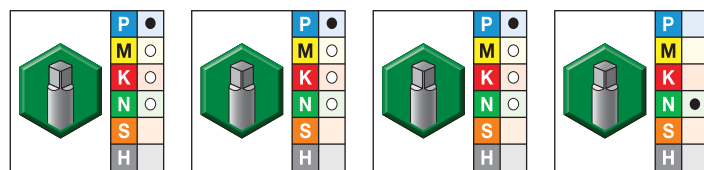
TiCN		TiN		oxide		uncoated		inch dimensions				number of flutes	pitch diameter limit
order #	catalog #	order #	catalog #	order #	catalog #	order #	catalog #	D1 size	L	L3	D		
2749839	14009	2463627	19247	2863727	19170	2957247	14023	1/4 - 20	2.50	1.00	.255	4	H3
-	-	-	-	-	-	2749837	14011	1/4 - 20	2.50	1.00	.255	4	H1
-	-	-	-	-	-	2749830	14016	1/4 - 20	2.50	1.00	.255	4	H2
-	-	-	-	-	-	3180806	14020	1/4 - 20	2.50	1.00	.255	3	H2
-	-	2748577	15453	-	-	3102009	14030	1/4 - 20	2.50	1.00	.255	2	H3
-	-	3171060	15454	-	-	2749802	14032	1/4 - 20	2.50	1.00	.255	3	H3
-	-	-	-	-	-	2749795	14036	1/4 - 20	2.50	1.00	.255	4	H5
-	-	-	-	-	-	2749791	14039	1/4 - 20	2.50	1.00	.255	3	H5
-	-	-	-	-	-	2749787	14041	1/4 - 20	2.50	1.00	.255	4	H11
-	-	-	-	-	-	2749780	14052	1/4 - 28	2.50	1.00	.255	4	H2
-	-	-	-	-	-	2749777	14053	1/4 - 28	2.50	1.00	.255	4	H2
-	-	-	-	-	-	2749772	14056	1/4 - 28	2.50	1.00	.255	4	H3
2746827	19128	2463629	19253	2746703	19210	-	-	1/4 - 28	2.50	1.00	.255	4	H3
-	-	-	-	-	-	2749759	14063	1/4 - 28	2.50	1.00	.255	2	H3
-	-	2748574	15456	-	-	2749757	14065	1/4 - 28	2.50	1.00	.255	3	H3
-	-	-	-	-	-	2749751	14067	1/4 - 28	2.50	1.00	.255	4	H4
-	-	-	-	-	-	2749744	14082	5/16 - 18	2.72	1.13	.318	4	H1
-	-	-	-	-	-	2435312	14087	5/16 - 18	2.72	1.13	.318	4	H2
2746826	19129	2746637	19258	2746665	19240	2749734	14093	5/16 - 18	2.72	1.13	.318	4	H3
-	-	-	-	-	-	3102021	14100	5/16 - 18	2.72	1.13	.318	2	H3
-	-	2748569	15459	-	-	-	-	5/16 - 18	2.72	1.13	.318	2	H3
-	-	2710689	15460	-	-	-	-	5/16 - 18	2.72	1.13	.318	3	H3
-	-	-	-	-	-	2749714	14102	5/16 - 18	2.72	1.13	.318	3	H3
-	-	-	-	-	-	2749709	14104	5/16 - 18	2.72	1.13	.318	4	H5
-	-	-	-	-	-	2749695	14109	5/16 - 18	2.72	1.13	.318	4	H11
-	-	-	-	-	-	2749694	14113	5/16 - 24	2.72	1.13	.318	4	H1
-	-	-	-	-	-	2749691	14118	5/16 - 24	2.72	1.13	.318	4	H2
2746824	19131	2746631	19263	2746635	19260	2749686	14123	5/16 - 24	2.72	1.13	.318	4	H3

(continued)

Production Taps

Hand Taps • Through or Blind Holes in General Machining Applications

(Series 5303/2303 • Fractional Sizes • Plug Chamfer — continued)

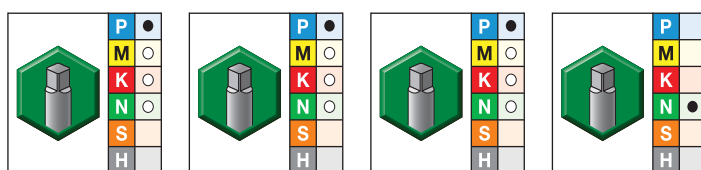


● first choice
○ alternate choice

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		
-	-	2748566	15462	-	-	1295391	14130	5/16 - 24	2.72	1.13	.318	3	H3
-	-	-	-	-	-	2749666	14133	5/16 - 24	2.72	1.13	.318	4	H4
-	-	2746625	19268	2746615	19280	2749649	14158	3/8 - 16	2.94	1.25	.381	4	H3
2746822	19132	-	-	-	-	-	-	3/8 - 16	2.94	1.25	.381	4	H3
-	-	2748563	15464	-	-	2749635	14165	3/8 - 16	2.94	1.25	.381	3	H3
-	-	-	-	-	-	2749629	14169	3/8 - 16	2.94	1.25	.381	4	H5
-	-	-	-	-	-	2749617	14174	3/8 - 16	2.94	1.25	.381	4	H11
-	-	-	-	-	-	2749659	14147	3/8 - 16	2.94	1.25	.381	4	H1
-	-	-	-	-	-	2749655	14152	3/8 - 16	2.94	1.25	.381	4	H2
-	-	2748560	15466	-	-	2749595	14198	3/8 - 24	2.94	1.25	.381	3	H3
-	-	-	-	-	-	2749591	14201	3/8 - 24	2.94	1.25	.381	4	H4
-	-	-	-	-	-	2749613	14185	3/8 - 24	2.94	1.25	.381	4	H2
-	-	2746621	19273	-	-	2749609	14191	3/8 - 24	2.94	1.25	.381	4	H3
2746820	19134	-	-	3177077	19305	-	-	3/8 - 24	2.94	1.25	.381	4	H3
-	-	-	-	-	-	2749572	14232	7/16 - 14	3.16	1.44	.323	4	H5
-	-	2746617	19277	-	-	2749584	14222	7/16 - 14	3.16	1.44	.323	4	H3
2746818	19135	-	-	-	-	-	-	7/16 - 14	3.16	1.44	.323	4	H3
-	-	2748558	15467	-	-	-	-	7/16 - 14	3.16	1.44	.323	3	H3
-	-	-	-	-	-	2749573	14229	7/16 - 14	3.16	1.44	.323	3	H3
-	-	2746611	19283	-	-	1951473	14247	7/16 - 20	3.16	1.44	.323	4	H3
2746816	19136	-	-	-	-	-	-	7/16 - 20	3.16	1.44	.323	4	H3
-	-	-	-	-	-	2749550	14256	7/16 - 20	3.16	1.44	.323	4	H5
-	-	2748552	15469	-	-	2749530	14289	1/2 - 13	3.38	1.66	.367	3	H3
-	-	-	-	-	-	2957246	14293	1/2 - 13	3.38	1.66	.367	4	H5
-	-	-	-	-	-	2749519	14297	1/2 - 13	3.38	1.66	.367	4	H11
-	-	-	-	-	-	2866262	14274	1/2 - 13	3.38	1.66	.367	4	H1
2746814	19137	2746605	19291	2746576	19360	2415661	14282	1/2 - 13	3.38	1.66	.367	4	H3
-	-	2748550	15470	-	-	2749493	14316	1/2 - 20	3.38	1.66	.367	3	H3
-	-	-	-	-	-	2749491	14319	1/2 - 20	3.38	1.66	.367	4	H5
-	-	-	-	-	-	2749517	14301	1/2 - 20	3.38	1.66	.367	4	H1
-	-	-	-	-	-	2749513	14309	1/2 - 20	3.38	1.66	.367	4	H3
2746812	19138	2746595	19297	2746568	19375	-	-	1/2 - 20	3.38	1.66	.367	4	H3
-	-	-	-	-	-	2866187	14339	9/16 - 12	3.59	1.66	.429	4	H3
-	-	-	-	-	-	2749481	14346	9/16 - 12	3.59	1.66	.429	4	H5
-	-	-	-	-	-	2749463	14364	9/16 - 18	3.59	1.66	.429	4	H5
-	-	-	-	-	-	2749478	14353	9/16 - 18	3.59	1.66	.429	4	H2
-	-	-	-	-	-	2749475	14357	9/16 - 18	3.59	1.66	.429	4	H3
-	-	-	-	-	-	2749444	14388	5/8 - 11	3.81	1.81	.480	4	H5
-	-	-	-	-	-	2749461	14378	5/8 - 11	3.81	1.81	.480	4	H2
2746810	19139	2863589	19307	2746564	19410	2749458	14380	5/8 - 11	3.81	1.81	.480	4	H3

(continued)

(Series 5303/2303 • Fractional Sizes • Plug Chamfer — continued)

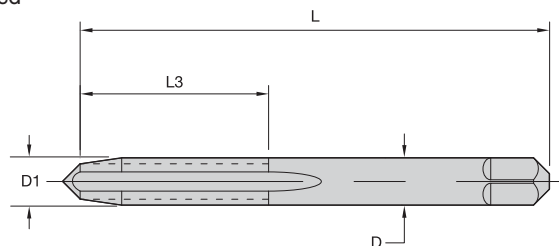

 ● first choice
 ○ alternate choice

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		
-	-	-	-	-	-	2749414	14411	5/8 - 18	3.81	1.81	.480	4	H5
-	-	-	-	-	-	2749434	14400	5/8 - 18	3.81	1.81	.480	4	H2
-	-	2746592	19317	-	-	2749431	14403	5/8 - 18	3.81	1.81	.480	4	H3
2746808	19140	-	-	-	-	-	-	5/8 - 18	3.81	1.81	.480	4	H3
-	-	-	-	-	-	2749405	14424	11/16 - 11	4.03	1.06	.542	4	H3
-	-	-	-	-	-	2749397	14428	11/16 - 16	4.03	1.06	.542	4	H3
-	-	-	-	2746560	19445	-	-	3/4 - 10	4.25	2.00	.590	4	H3
-	-	2746588	19327	-	-	-	-	3/4 - 10	4.25	2.00	.590	4	H3
2746806	19141	-	-	-	-	-	-	3/4 - 10	4.25	2.00	.590	4	H3
-	-	-	-	-	-	2749379	14457	3/4 - 10	4.25	2.00	.590	4	H5
-	-	-	-	-	-	2749392	14449	3/4 - 10	4.25	2.00	.590	4	H3
-	-	-	-	-	-	1825322	14472	3/4 - 16	4.25	2.00	.590	4	H3
-	-	-	-	-	-	2710849	14479	3/4 - 16	4.25	2.00	.590	4	H4
-	-	-	-	2746556	19455	-	-	3/4 - 16	4.25	2.00	.590	4	H3
-	-	2746584	19337	-	-	-	-	3/4 - 16	4.25	2.00	.590	4	H3
2746804	19142	-	-	-	-	-	-	3/4 - 16	4.25	2.00	.590	4	H3
-	-	-	-	-	-	2749359	14482	3/4 - 16	4.25	2.00	.590	4	H5
-	-	-	-	2709889	19465	-	-	7/8 - 9	4.69	2.22	.697	4	H4
-	-	-	-	-	-	2749342	14508	7/8 - 9	4.69	2.22	.697	4	H6
-	-	-	-	-	-	2749354	14500	7/8 - 9	4.69	2.22	.697	4	H4
-	-	2863567	19347	-	-	-	-	7/8 - 9	4.69	2.22	.697	4	H4
-	-	2746578	19357	-	-	-	-	7/8 - 14	4.69	2.22	.697	4	H4
-	-	-	-	-	-	2749329	14524	7/8 - 14	4.69	2.22	.697	4	H6
-	-	-	-	-	-	2749338	14517	7/8 - 14	4.69	2.22	.697	4	H4
-	-	-	-	2709874	19475	-	-	1 - 8	5.13	2.50	.800	4	H4
-	-	2746572	19367	-	-	-	-	1 - 8	5.13	2.50	.800	4	H4
-	-	-	-	-	-	2749311	14553	1 - 8	5.13	2.50	.800	4	H6
-	-	-	-	-	-	2749326	14545	1 - 8	5.13	2.50	.800	4	H4
-	-	-	-	-	-	2749305	14558	1 - 12	5.13	2.50	.800	4	H4
-	-	-	-	-	-	2749292	14569	1 - 14	5.13	2.50	.800	4	H4
-	-	-	-	-	-	2749297	14567	1 - 14	5.13	2.50	.800	4	H2
-	-	-	-	-	-	2749280	14595	1 1/8 - 7	5.44	2.56	.896	4	H4
-	-	-	-	-	-	2749271	14604	1 1/8 - 12	5.44	2.56	.896	4	H4
-	-	-	-	-	-	2749263	14613	1 1/4 - 7	5.75	2.56	1.021	4	H4
-	-	-	-	-	-	2749258	14621	1 1/4 - 12	5.75	2.56	1.021	6	H4
-	-	-	-	-	-	2749252	14633	1 3/8 - 6	6.06	3.00	1.108	4	H4
-	-	-	-	-	-	2749247	14641	1 3/8 - 12	6.06	3.00	1.108	6	H4
-	-	-	-	-	-	3012775	14646	1 1/2 - 6	6.38	3.00	1.233	4	H4
-	-	-	-	-	-	2749234	14654	1 1/2 - 12	6.38	3.00	1.233	6	H4

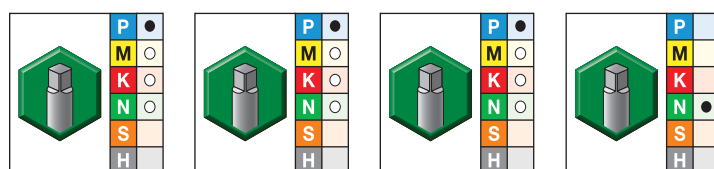
Production Taps

Hand Taps • Blind Holes in General Machining Applications

- Series 5305TC • TiCN Coated
- Series 2305 • TiN Coated
- Series 5305S • SH50 Steam Oxide
- Series 5305 • Uncoated



■ Series 5305/2305 • Machine Screw Sizes • Bottoming Chamfer

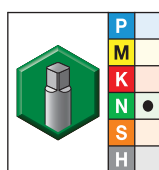
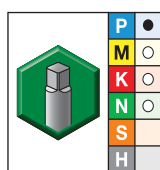
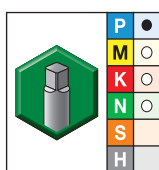
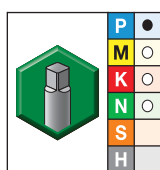


- first choice
- alternate choice

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		
-	-	-	-	-	-	2748985	15104	0 - 80	1.63	.31	.141	2	H1
2863721	19174	2746711	19204	-	-	2748977	15108	0 - 80	1.63	.31	.141	2	H2
-	-	-	-	-	-	2748970	15116	1 - 64	1.69	.38	.141	2	H1
-	-	-	-	-	-	2748962	15122	1 - 72	1.69	.38	.141	2	H1
-	-	-	-	-	-	3049563	15126	1 - 72	1.69	.38	.141	2	H2
-	-	-	-	-	-	2748955	15130	2 - 56	1.75	.44	.141	3	H1
3171079	19175	-	-	-	-	2748947	15136	2 - 56	1.75	.44	.141	3	H2
-	-	-	-	-	-	2748942	15139	2 - 56	1.75	.44	.141	2	H2
-	-	-	-	-	-	2748930	15146	2 - 64	1.75	.44	.141	3	H2
-	-	-	-	-	-	2748920	15158	3 - 48	1.81	.50	.141	3	H2
-	-	2748616	15432	-	-	2748914	15161	3 - 48	1.81	.50	.141	2	H2
-	-	-	-	-	-	2748906	15168	3 - 56	1.81	.50	.141	3	H2
2746756	19176	2041050	19213	2709823	19570	2748882	15186	4 - 40	1.88	.56	.141	3	H2
-	-	2748612	15434	-	-	2748876	15190	4 - 40	1.88	.56	.141	2	H2
-	-	-	-	-	-	2748864	15198	4 - 48	1.88	.56	.141	3	H2
2746754	19177	2746695	19218	-	-	2865316	15211	5 - 40	1.94	.63	.141	3	H2
-	-	2748607	15436	-	-	3177073	15215	5 - 40	1.94	.63	.141	2	H2
-	-	-	-	-	-	2748852	15222	5 - 44	1.94	.63	.141	3	H2
-	-	-	-	-	-	2865289	15227	6 - 32	2.00	.69	.141	3	H1
-	-	2041052	19223	-	-	2865277	15233	6 - 32	2.00	.69	.141	3	H2
-	-	-	-	-	-	2891496	15236	6 - 32	2.00	.69	.141	2	H2
2746752	19178	-	-	2746494	19580	2748840	15239	6 - 32	2.00	.69	.141	3	H3
-	-	2748604	15438	-	-	2748835	15246	6 - 32	2.00	.69	.141	2	H3
-	-	-	-	-	-	2748820	15259	6 - 40	2.00	.69	.141	3	H2

(continued)

(Series 5305/2305 • Machine Screw Sizes • Bottoming Chamfer — continued)



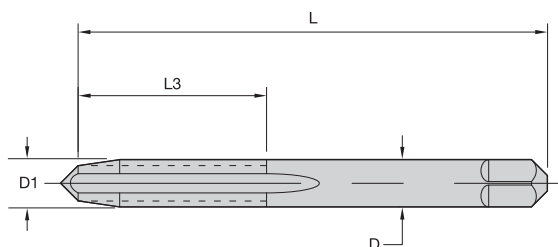
● first choice

○ alternate choice

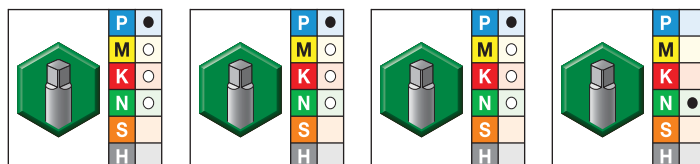
TiCN		TiN		oxide		uncoated		inch dimensions				number of flutes	pitch diameter limit
order #	catalog #	order #	catalog #	order #	catalog #	order #	catalog #	D1 size	L	L3	D		
-	-	-	-	-	-	2748811	15269	8 - 32	2.13	.75	.168	4	H1
-	-	1773455	19228	-	-	2748803	15277	8 - 32	2.13	.75	.168	4	H2
-	-	-	-	-	-	2748795	15280	8 - 32	2.13	.75	.168	2	H2
-	-	-	-	-	-	2748791	15282	8 - 32	2.13	.75	.168	3	H2
2746750	19179	-	-	2863495	19590	2748781	15285	8 - 32	2.13	.75	.168	4	H3
-	-	-	-	-	-	2748773	15292	8 - 32	2.13	.75	.168	2	H3
-	-	-	-	-	-	2969917	15294	8 - 32	2.13	.75	.168	3	H3
2709451	19860	-	-	-	-	-	-	8 - 32	2.13	.75	.168	4	H3
-	-	-	-	-	-	2748758	15303	8 - 36	2.13	.75	.168	4	H2
2746747	19181	2603957	19233	2746488	19605	2748733	15329	10 - 24	2.38	.88	.194	4	H3
-	-	-	-	-	-	2748728	15336	10 - 24	2.38	.88	.194	2	H3
-	-	2748597	15443	-	-	2748722	15338	10 - 24	2.38	.88	.194	3	H3
-	-	-	-	-	-	2748744	15322	10 - 24	2.38	.88	.194	4	H2
-	-	-	-	-	-	2748689	15354	10 - 32	2.38	.88	.194	4	H2
-	-	-	-	-	-	2748682	15357	10 - 32	2.38	.88	.194	2	H2
-	-	2748592	15446	-	-	2748680	15359	10 - 32	2.38	.88	.194	3	H2
2746745	19182	2622812	19238	2863477	19620	2748675	15362	10 - 32	2.38	.88	.194	4	H3
-	-	2748593	15445	-	-	2748663	15369	10 - 32	2.38	.88	.194	2	H3
-	-	2748590	15447	-	-	2748661	15371	10 - 32	2.38	.88	.194	3	H3
-	-	-	-	-	-	2748702	15346	10 - 32	2.38	.88	.194	4	H1
2746743	19183	2746661	19243	-	-	2748641	15385	12 - 24	2.38	.94	.220	4	H3
-	-	-	-	-	-	2748624	15392	12 - 28	2.38	.94	.220	4	H3

NOTE: Hand 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 5303/2303 • Fractional Sizes • Bottoming Chamfer

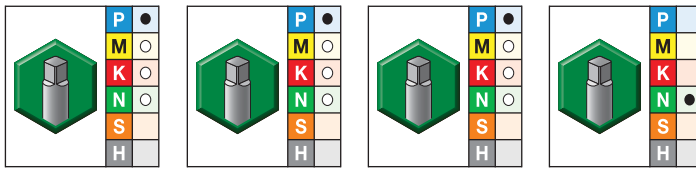


● first choice
○ alternate choice

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		
-	-	-	-	-	-	2749836	14012	1/4 - 20	2.50	1.00	.255	4	H1
-	-	-	-	-	-	2749826	14017	1/4 - 20	2.50	1.00	.255	4	H2
2746741	19184	2463628	19251	2746748	19180	2749818	14024	1/4 - 20	2.50	1.00	.255	4	H3
-	-	-	-	-	-	2749805	14031	1/4 - 20	2.50	1.00	.255	2	H3
-	-	-	-	-	-	2749800	14033	1/4 - 20	2.50	1.00	.255	3	H3
-	-	-	-	-	-	2749793	14037	1/4 - 20	2.50	1.00	.255	4	H5
2746739	19185	2463630	19256	2746691	19220	2749766	14057	1/4 - 28	2.50	1.00	.255	4	H3
-	-	-	-	-	-	2749758	14064	1/4 - 28	2.50	1.00	.255	2	H3
-	-	2748576	15455	-	-	2749755	14066	1/4 - 28	2.50	1.00	.255	3	H3
-	-	-	-	-	-	1854370	14068	1/4 - 28	2.50	1.00	.255	4	H4
-	-	-	-	-	-	2749742	14083	5/16 - 18	2.72	1.13	.318	4	H1
-	-	-	-	-	-	2749739	14088	5/16 - 18	2.72	1.13	.318	4	H2
2746737	19186	2746633	19261	2746657	19245	2749732	14094	5/16 - 18	2.72	1.13	.318	4	H3
-	-	2748573	15457	-	-	2749716	14101	5/16 - 18	2.72	1.13	.318	2	H3
-	-	2748571	15458	-	-	2749712	14103	5/16 - 18	2.72	1.13	.318	3	H3
-	-	-	-	-	-	2749706	14105	5/16 - 18	2.72	1.13	.318	4	H5
2746735	19187	2746627	19266	2746629	19265	2038474	14124	5/16 - 24	2.72	1.13	.318	4	H3
-	-	2748568	15461	-	-	2749669	14131	5/16 - 24	2.72	1.13	.318	3	H3
-	-	-	-	-	-	2749662	14134	5/16 - 24	2.72	1.13	.318	4	H4
-	-	-	-	-	-	2749656	14148	3/8 - 16	2.94	1.25	.381	4	H1
-	-	-	-	-	-	2749652	14153	3/8 - 16	2.94	1.25	.381	4	H2
2746733	19188	2746623	19271	2746609	19285	2749647	14159	3/8 - 16	2.94	1.25	.381	4	H3
-	-	2748565	15463	-	-	2749633	14166	3/8 - 16	2.94	1.25	.381	3	H3
-	-	-	-	-	-	2749625	14170	3/8 - 16	2.94	1.25	.381	4	H5
2746731	19189	2746619	19275	2746593	19310	1951472	14192	3/8 - 24	2.94	1.25	.381	4	H3
-	-	2748561	15465	-	-	2749593	14199	3/8 - 24	2.94	1.25	.381	3	H3
-	-	-	-	-	-	2749589	14202	3/8 - 24	2.94	1.25	.381	4	H4
2746729	19191	2746613	19281	-	-	2749582	14223	7/16 - 14	3.16	1.44	.323	4	H3

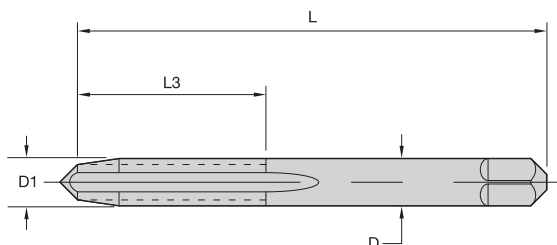
(continued)

(Series 5303/2303 • Fractional Sizes • Bottoming Chamfer — continued)

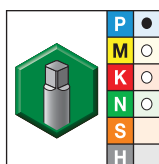

 ● first choice
 ○ alternate choice

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		
-	-	-	-	-	-	2749570	14233	7/16 - 14	3.16	1.44	.323	4	H5
2746727	19192	2746607	19287	-	-	2038865	14248	7/16 - 20	3.16	1.44	.323	4	H3
-	-	-	-	-	-	2749548	14257	7/16 - 20	3.16	1.44	.323	4	H5
-	-	-	-	-	-	2749545	14275	1/2 - 13	3.38	1.66	.367	4	H1
2746725	19193	2746601	19293	2746580	19355	2749540	14283	1/2 - 13	3.38	1.66	.367	4	H3
-	-	2748556	15468	-	-	2749526	14290	1/2 - 13	3.38	1.66	.367	3	H3
-	-	-	-	-	-	2749520	14294	1/2 - 13	3.38	1.66	.367	4	H5
2746723	19194	3113801	19303	2746566	19380	1951476	14310	1/2 - 20	3.38	1.66	.367	4	H3
-	-	-	-	-	-	2866184	14340	9/16 - 12	3.59	1.66	.429	4	H3
-	-	-	-	-	-	2749474	14358	9/16 - 18	3.59	1.66	.429	4	H3
2746721	19197	2863585	19313	2746562	19415	2749456	14381	5/8 - 11	3.81	1.81	.480	4	H3
-	-	-	-	-	-	2749441	14389	5/8 - 11	3.81	1.81	.480	4	H5
2746719	19198	2746590	19323	-	-	2749428	14404	5/8 - 18	3.81	1.81	.480	4	H3
-	-	-	-	-	-	2749411	14412	5/8 - 18	3.81	1.81	.480	4	H5
-	-	-	-	-	-	2749403	14425	11/16 - 11	4.03	1.06	.542	4	H3
-	-	-	-	-	-	2749396	14429	11/16 - 16	4.03	1.06	.542	4	H3
2746717	19199	2746586	19333	2746558	19450	3180808	14450	3/4 - 10	4.25	2.00	.590	4	H3
-	-	-	-	-	-	2749376	14458	3/4 - 10	4.25	2.00	.590	4	H5
-	-	2863572	19343	2746553	19460	2749370	14473	3/4 - 16	4.25	2.00	.590	4	H3
-	-	-	-	-	-	2749358	14483	3/4 - 16	4.25	2.00	.590	4	H5
-	-	2746582	19353	2709881	19470	2749352	14501	7/8 - 9	4.69	2.22	.697	4	H4
-	-	2746574	19363	-	-	2749336	14518	7/8 - 14	4.69	2.22	.697	4	H4
-	-	2746570	19373	2709867	19480	2749324	14546	1 - 8	5.13	2.50	.800	4	H4
-	-	-	-	-	-	3006761	14559	1 - 12	5.13	2.50	.800	4	H4
-	-	-	-	-	-	3180807	14570	1 - 14	5.13	2.50	.800	4	H4
-	-	-	-	-	-	2749278	14596	1 1/8 - 7	5.44	2.56	.896	4	H4
-	-	-	-	-	-	2749269	14605	1 1/8 - 12	5.44	2.56	.896	4	H4
-	-	-	-	-	-	2749261	14614	1 1/4 - 7	5.75	2.56	1.021	4	H4
-	-	-	-	-	-	2749256	14622	1 1/4 - 12	5.75	2.56	1.021	6	H4
-	-	-	-	-	-	2749251	14634	1 3/8 - 6	6.06	3.00	1.108	4	H4
-	-	-	-	-	-	2749246	14642	1 3/8 - 12	6.06	3.00	1.108	6	H4
-	-	-	-	-	-	2749240	14647	1 1/2 - 6	6.38	3.00	1.233	4	H4
-	-	-	-	-	-	2749233	14655	1 1/2 - 12	6.38	3.00	1.233	6	H4

NOTE: Hand 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.



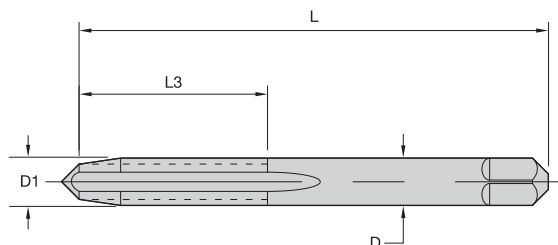
■ Series 5305 • Machine Screw Sizes • Sets of One Each Taper, Plug, and Bottoming Chamfer



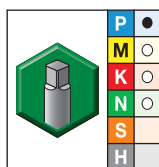
● first choice
○ alternate choice

uncoated		inch dimensions				number of flutes	pitch diameter limit
order #	catalog #	D1 size	L	L3	D		
2748981	15105	0 - 80	1.63	.31	.141	2	H1
2748968	15117	1 - 64	1.69	.38	.141	2	H1
2748961	15123	1 - 72	1.69	.38	.141	2	H1
2748945	15137	2 - 56	1.75	.44	.141	3	H2
2748928	15147	2 - 64	1.75	.44	.141	3	H2
2748918	15159	3 - 48	1.81	.50	.141	3	H2
2748902	15169	3 - 56	1.81	.50	.141	3	H2
2748880	15187	4 - 40	1.88	.56	.141	3	H2
2748863	15199	4 - 48	1.88	.56	.141	3	H2
2865313	15212	5 - 40	1.94	.63	.141	3	H2
2748851	15223	5 - 44	1.94	.63	.141	3	H2
2865286	15228	6 - 32	2.00	.69	.141	3	H1
2865274	15234	6 - 32	2.00	.69	.141	3	H2
2748838	15240	6 - 32	2.00	.69	.141	3	H3
2748818	15260	6 - 40	2.00	.69	.141	3	H2
2748801	15278	8 - 32	2.13	.75	.168	4	H2
2865185	15286	8 - 32	2.13	.75	.168	4	H3
2748756	15304	8 - 36	2.13	.75	.168	4	H2
2748743	15323	10 - 24	2.38	.88	.194	4	H2
2748731	15330	10 - 24	2.38	.88	.194	4	H3
2748685	15355	10 - 32	2.38	.88	.194	4	H2
2748670	15363	10 - 32	2.38	.88	.194	4	H3
2748637	15386	12 - 24	2.38	.94	.220	4	H3
2748623	15393	12 - 28	2.38	.94	.220	4	H3

NOTE: Hand taps for 3B class of fit are suitable for UNJ aerospace internal threading applications.
Tap sets include one of each: taper, plug, and bottoming chamfer.
Refer to tables on pages W231-W232 for the recommended pitch diameter limit for 2B or 3B class of fit.



■ Series 5303 • Fractional Sizes • Sets of One Each Taper, Plug, and Bottoming Chamfer

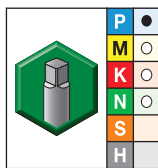


● first choice
○ alternate choice

uncoated		inch dimensions				number of flutes	pitch diameter limit
order #	catalog #	D1 size	L	L3	D		
2749834	14013	1/4 - 20	2.50	1.00	.255	4	H1
2749824	14018	1/4 - 20	2.50	1.00	.255	4	H2
2749815	14025	1/4 - 20	2.50	1.00	.255	4	H3
2749764	14058	1/4 - 28	2.50	1.00	.255	4	H3
2749729	14095	5/16 - 18	2.72	1.13	.318	4	H3
2749680	14125	5/16 - 24	2.72	1.13	.318	4	H3
2749644	14160	3/8 - 16	2.94	1.25	.381	4	H3
2749605	14193	3/8 - 24	2.94	1.25	.381	4	H3
2749581	14224	7/16 - 14	3.16	1.44	.323	4	H3
2749560	14249	7/16 - 20	3.16	1.44	.323	4	H3
2749538	14284	1/2 - 13	3.38	1.66	.367	4	H3
2749503	14311	1/2 - 20	3.38	1.66	.367	4	H3
2749488	14341	9/16 - 12	3.59	1.66	.429	4	H3
2749472	14359	9/16 - 18	3.59	1.66	.429	4	H3
2749454	14382	5/8 - 11	3.81	1.81	.480	4	H3
2749426	14405	5/8 - 18	3.81	1.81	.480	4	H3
2749402	14426	11/16 - 11	4.03	1.06	.542	4	H3
2749388	14451	3/4 - 10	4.25	2.00	.590	4	H3
2749368	14474	3/4 - 16	4.25	2.00	.590	4	H3
2749350	14502	7/8 - 9	4.69	2.22	.697	4	H4
2749335	14519	7/8 - 14	4.69	2.22	.697	4	H4
2749320	14547	1 - 8	5.13	2.50	.800	4	H4
3303777	14560	1 - 12	5.13	2.50	.800	4	H4
2749288	14571	1 - 14	5.13	2.50	.800	4	H4

(continued)

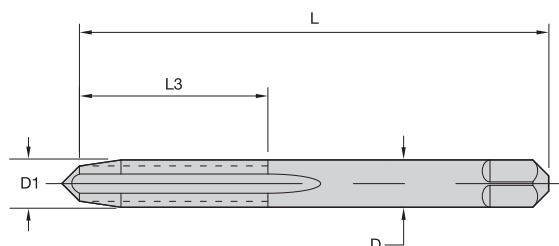
(Series 5303 • Fractional Sizes • Sets of One Each Taper, Plug, and Bottoming Chamfer — continued)



● first choice
○ alternate choice

uncoated		inch dimensions				number of flutes	pitch diameter limit
order #	catalog #	D1 size	L	L3	D		
2749275	14597	1 1/8 - 7	5.44	2.56	.896	4	H4
2749267	14606	1 1/8 - 12	5.44	2.56	.896	4	H4
2749260	14615	1 1/4 - 7	5.75	2.56	1.021	4	H4
2749254	14623	1 1/4 - 12	5.75	2.56	1.021	6	H4
2749249	14635	1 3/8 - 6	6.06	3.00	1.108	4	H4
2749243	14643	1 3/8 - 12	6.06	3.00	1.108	6	H4
2749237	14648	1 1/2 - 6	6.38	3.00	1.233	4	H4
2749231	14656	1 1/2 - 12	6.38	3.00	1.233	6	H4

NOTE: Hand taps for 3B class of fit are suitable for UNJ aerospace internal threading applications.
Tap sets include one of each: taper, plug, and bottoming chamfer.
Refer to tables on pages W231–W232 for the recommended pitch diameter limit for 2B or 3B class of fit.



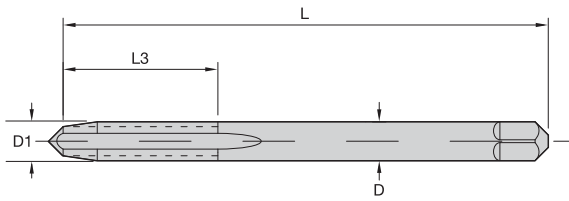
- first choice
- alternate choice

■ Series 5305L/5303L • Fractional Sizes • Sets of One Each Taper, Plug, and Bottoming Chamfer and Sets

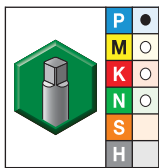
taper chamfer 7-10 pitch		plug chamfer 3-5 pitch		full bottom 1-2 pitch		taper and plug bottoming set		inch dimensions				number of flutes	pitch diameter limit
order #	catalog #	order #	catalog #	order #	catalog #	order #	catalog #	D1 TPI	L	L3	D		
2749814	14026	2749813	14027	2749811	14028	2749810	14029	1/4 - 20	2.50	1.00	.255	4	H3
-	-	3171054	14060	-	-	-	-	1/4 - 28	2.50	1.00	.255	4	H3
2749727	14096	2749724	14097	2749721	14098	2749719	14099	5/16 - 18	2.72	1.13	.318	4	H3
2749679	14126	2749677	14127	2749675	14128	2749674	14129	5/16 - 24	2.72	1.13	.318	4	H3
2749642	14161	2749639	14162	2749637	14163	2749636	14164	3/8 - 16	2.94	1.25	.381	4	H3
2749603	14194	2749601	14195	2749599	14196	2749597	14197	3/8 - 24	2.94	1.25	.381	4	H3
2749580	14225	-	-	-	-	-	-	7/16 - 14	3.16	1.44	.323	4	H3
3171055	14250	2749557	14251	2749554	14252	-	-	7/16 - 20	3.16	1.44	.323	4	H3
2866246	14285	2749535	14286	2749533	14287	2749531	14288	1/2 - 13	3.38	1.66	.367	4	H3
2749502	14312	2749499	14313	2749497	14314	2749495	14315	1/2 - 20	3.38	1.66	.367	4	H3
2749470	14360	-	-	-	-	-	-	9/16 - 18	3.59	1.66	.429	4	H3
2749451	14383	2749449	14384	2749447	14385	-	-	5/8 - 11	3.81	1.81	.480	4	H3
2749424	14406	2749421	14407	2749420	14408	-	-	5/8 - 18	3.81	1.81	.480	4	H3
2749386	14452	2749384	14453	2749382	14454	-	-	3/4 - 10	4.25	2.00	.590	4	H3
2749367	14475	2749365	14476	2749363	14477	-	-	3/4 - 16	4.25	2.00	.590	4	H3

Production Taps

6" Extension Hand Taps • Long-Reach Applications



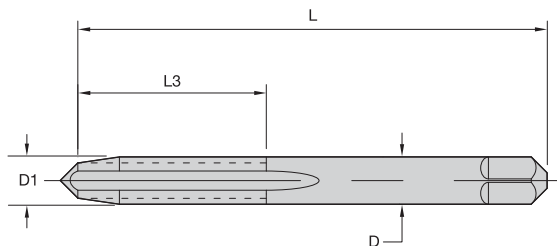
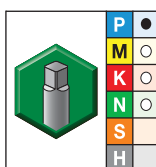
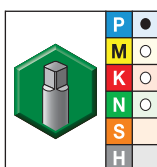
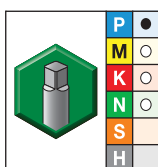
■ Series 5305(EXT)/5303(EXT) • Machine Screw and Fractional • Bottoming Chamfer



- first choice
- alternate choice

uncoated		inch dimensions				number of flutes	pitch diameter limit
order #	catalog #	D1 TPI	L	L3	D		
2747076	18828	6 - 32	6.00	.69	.141	3	H3
2747037	18892	8 - 32	6.00	.75	.168	4	H3
2747072	18834	10 - 24	6.00	.88	.194	4	H3
2747069	18837	10 - 32	6.00	.88	.194	4	H3
2747065	18840	1/4 - 20	6.00	1.00	.255	4	H3
2747061	18843	1/4 - 28	6.00	1.00	.255	4	H3
2747057	18846	5/16 - 18	6.00	.67	.318	4	H3
1779890	18849	5/16 - 24	6.00	.59	.318	4	H3
2747049	18852	3/8 - 16	6.00	1.25	.381	4	H3
2747047	18855	3/8 - 24	6.00	1.25	.381	4	H3

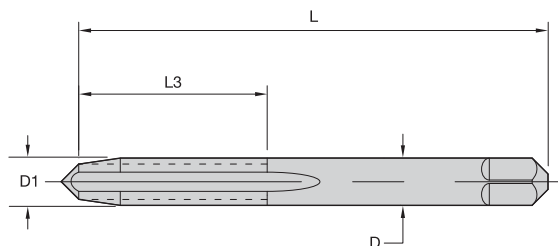
NOTE: Refer to tables on pages W231–W232 for the recommended pitch diameter limit for 2B or 3B class of fit.


Series 5353 • Plug Chamfer • Metric ANSI


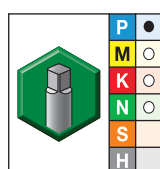
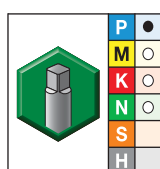
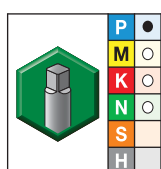
- first choice
- alternate choice

TiCN		TiN		uncoated		inch dimensions				number of flutes	pitch diameter limit
order #	catalog #	order #	catalog #	order #	catalog #	D1 size	L	L3	D		
-	-	-	-	2749224	14718	M1,6 X 0,35	1.63	.31	.141	2	D3
-	-	-	-	2749219	14726	M2 X 0,4	1.75	.44	.141	3	D3
-	-	-	-	2749210	14734	M2,5 X 0,45	1.81	.50	.141	3	D3
3171081	19217	3111251	15471	2749205	14742	M3 X 0,5	1.94	.63	.141	3	D3
-	-	-	-	2749199	14750	M3,5 X 0,6	2.00	.69	.141	3	D4
2746693	19219	2748549	15473	2749194	14758	M4 X 0,7	2.13	.75	.168	4	D4
-	-	-	-	2749191	14766	M4,5 X 0,75	2.38	.88	.194	4	D4
2746687	19222	2863245	19906	2749186	14774	M5 X 0,8	2.38	.88	.194	4	D4
2746683	19224	-	-	2749177	14782	M6 X 1	2.50	1.00	.255	4	D5
-	-	-	-	2749167	14790	M7 X 1	2.72	1.13	.318	4	D5
2746681	19225	2746288	19912	2749160	14798	M8 X 1,25	2.72	1.13	.318	4	D5
2746677	19227	2746284	19915	2749151	14814	M10 X 1,5	2.94	1.25	.381	4	D6
3005011	19229	2746209	19955	2749141	14830	M12 X 1,75	3.38	1.66	.367	4	D6
-	-	-	-	2749284	14586	M14 X 1,25	3.59	1.66	.429	4	H4
-	-	-	-	2749131	14846	M14 X 2	3.59	1.66	.429	4	D7
-	-	-	-	3012777	14862	M16 X 2	3.81	1.81	.480	4	D7
-	-	-	-	2749282	14590	M18 X 1,5	4.03	1.81	.542	4	H4
-	-	-	-	2749113	14878	M18 X 2,5	4.03	1.06	.542	4	D7
-	-	-	-	2749104	14894	M20 X 2,5	4.47	2.00	.652	4	D7
-	-	-	-	2749094	14910	M24 X 3	4.91	2.22	.760	4	D8
-	-	-	-	2749084	14926	M30 X 3,5	5.44	2.56	1.021	4	D9
-	-	-	-	2749076	14942	M36 X 4	6.06	3.00	1.233	4	D9

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



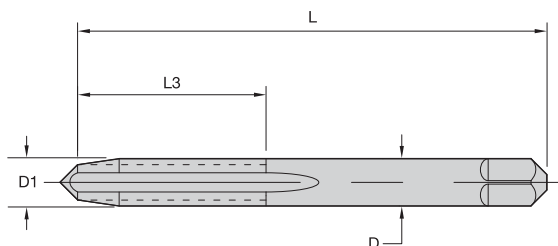
■ Series 5353 • Bottoming Chamfer • Metric ANSI



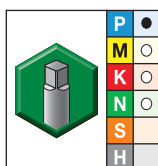
● first choice
○ alternate choice

TiCN		TiN		uncoated		inch dimensions				number of flutes	pitch diameter limit
order #	catalog #	order #	catalog #	order #	catalog #	D1 size	L	L3	D		
2896313	19201	3044179	15472	2749204	14743	M3 X 0,5	1.94	.63	.141	3	D3
2746713	19203	2978979	15474	—	—	M4 X 0,7	2.13	.75	.168	4	D4
2746709	19205	2746294	19907	2749182	14775	M5 X 0,8	2.38	.88	.194	4	D4
2746707	19206	—	—	—	—	M6 X 1	2.50	1.00	.255	4	D5
2746701	19212	—	—	—	—	M8 X 1,25	2.72	1.13	.318	4	D5
2746699	19214	2746282	19916	—	—	M10 X 1,5	2.94	1.25	.381	4	D6
3171080	19215	—	—	—	—	M12 X 1,75	3.38	1.66	.367	4	D6
—	—	—	—	2749127	14847	M14 X 2	3.59	1.66	.429	4	D7
—	—	—	—	2749122	14863	M16 X 2	3.81	1.81	.480	4	D7
—	—	—	—	2749102	14895	M20 X 2,5	4.47	2.00	.652	4	D7
—	—	—	—	2749093	14911	M24 X 3	4.91	2.22	.760	4	D8
—	—	—	—	2749081	14927	M30 X 3,5	5.44	2.56	1.021	4	D9
—	—	—	—	2749073	14943	M36 X 4	6.06	3.00	1.233	4	D9

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



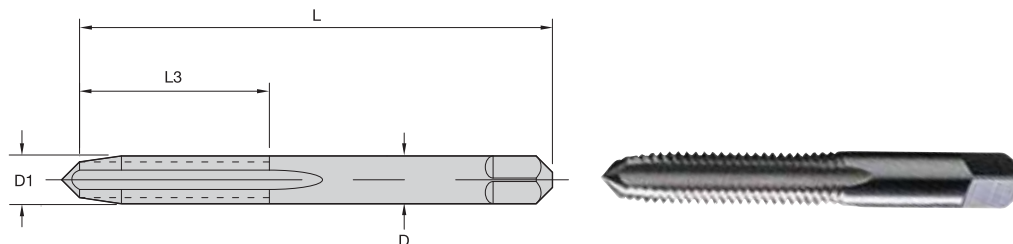
■ Series 5353 • Sets of One Each, Taper, Plug, Bottoming Chamfer • Metric ANSI



- first choice
- alternate choice

uncoated		inch dimensions				number of flutes	pitch diameter limit
order #	catalog #	D1 size	L	L3	D		
2749202	14744	M3 X 0,5	1.94	.63	.141	3	D3
2749192	14760	M4 X 0,7	2.13	.75	.168	4	D4
2749181	14777	M5 X 0,8	2.38	.88	.194	4	D4
2749171	14784	M6 X 1	2.50	1.00	.255	4	D5
2749153	14800	M8 X 1,25	2.72	1.13	.318	4	D5
2749145	14816	M10 X 1,5	2.94	1.25	.381	4	D6
2749136	14832	M12 X 1,75	3.38	1.66	.367	4	D6
2749125	14848	M14 X 2	3.59	1.66	.429	4	D7
2749119	14864	M16 X 2	3.81	1.81	.480	4	D7
2749099	14896	M20 X 2,5	4.47	2.00	.652	4	D7

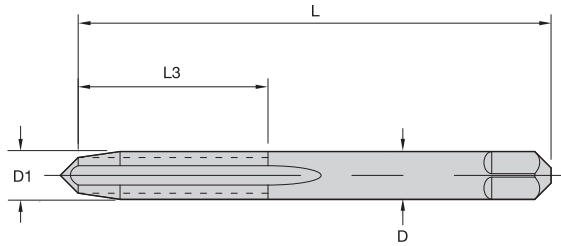
NOTE: Metric taps for 6H class of fit are suitable for MJ aerospace internal threading applications.
 Metric taps are manufactured to USCTI specifications and dimensions.
 Metric tap blank dimensions are equivalent to inch taps.
 Refer to tables on pages W231–W232 for the recommended pitch diameter limit for 6H class of fit.



- first choice
- alternate choice

■ Series 7305 • Machine Screw • Taper, Plug, Bottoming Chamfer, and Sets

taper chamfer 7-10 pitch		plug chamfer 3-5 pitch		full bottom 1-2 pitch		taper and plug bottoming set		D1 size	L	L3	D	class of fit
order #	catalog #	order #	catalog #	order #	catalog #	order #	catalog #					
2751095	11516	2751092	11517	2751090	11518	2751086	11519	4 - 40	2	.56	.141	2B
2751081	11524	2751080	11525	2751079	11526	2751077	11527	5 - 40	2	.63	.141	2B
2751075	11528	2751073	11529	2751071	11530	2751070	11531	6 - 32	2	.69	.141	2B
-		2751068	11537	-		-		6 - 40	2	.69	.141	2B
2751066	11540	2751064	11541	2751060	11542	2751058	11543	8 - 32	2	.75	.168	2B
-		2751056	11545	-		-		8 - 36	2	.75	.168	2B
2751055	11548	2751053	11549	2751051	11550	2751048	11551	10 - 24	2	.88	.194	2B
2751047	11552	2751045	11553	2751043	11554	2885052	11555	10 - 32	2	.88	.194	2B
2751041	11556	2751040	11557	2751037	11558	2751036	11559	12 - 24	2	.94	.220	2B
-		2751034	11561	-		-		12 - 28	2	.94	.220	2B

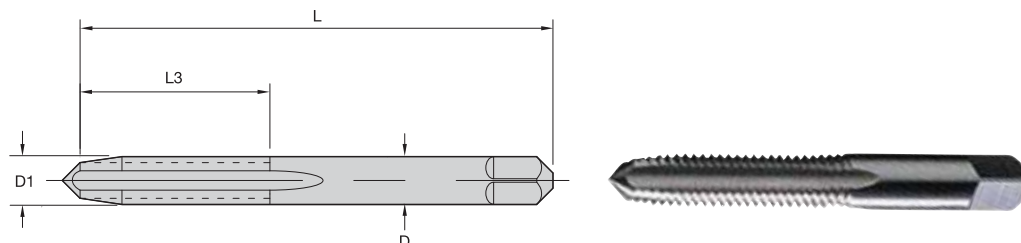


- first choice
- alternate choice

■ Series 7303 • Fractional • Taper, Plug, Bottoming Chamfer, and Sets

taper chamfer 7-10 pitch		plug chamfer 3-5 pitch		full bottom 1-2 pitch		taper and plug bottoming set		inch dimensions				class of fit
order #	catalog #	order #	catalog #	order #	catalog #	order #	catalog #	D1 size	L	L3	D	
2751033	11584	2867820	11585	2751031	11586	2751030	11587	3/16 - 24	2	.88	.194	2B
2751027	11596	2751025	11597	2751023	11598	2751020	11599	1/4 - 20	3	1.00	.255	2B
2751019	11600	2751015	11601	2751013	11602	2751011	11603	1/4 - 28	3	1.00	.255	2B
2751010	11604	2751008	11605	2751007	11606	2751004	11607	5/16 - 18	3	1.13	.318	2B
2751002	11608	2751001	11609	2750999	11610	2750998	11611	5/16 - 24	3	1.13	.318	2B
2750996	11612	2750995	11613	2750993	11614	2750991	11615	3/8 - 16	3	1.25	.381	2B
2750990	11616	2750988	11617	2750986	11618	2750985	11619	3/8 - 24	3	1.25	.381	2B
2750984	11620	2750983	11621	2750980	11622	2750975	11623	7/16 - 14	3	1.44	.323	2B
2750972	11624	2750969	11625	2750967	11626	2750965	11627	7/16 - 20	3	1.44	.323	2B
2750962	11628	2750959	11629	2750957	11630	2750953	11631	1/2 - 13	3	1.66	.367	2B
2750951	11632	2750948	11633	2750946	11634	2750945	11635	1/2 - 20	3	1.66	.367	2B
2750943	11636	2750941	11637	2750940	11638	2750939	11639	9/16 - 12	4	1.66	.429	2B
2750937	11640	2750935	11641	2750933	11642	2750932	11643	9/16 - 18	4	1.66	.429	2B
2750928	11644	2750926	11645	2750923	11646	2750920	11647	5/8 - 11	4	1.81	.480	2B
2750918	11648	2750917	11649	2750916	11650	-	-	5/8 - 18	3	1.25	.381	2B
-	-	-	-	-	-	2750915	11651	5/8 - 18	4	1.81	.480	2B
2750912	11652	2750910	11653	2750907	11654	2750906	11655	3/4 - 10	4	2.00	.590	2B
2750904	11656	2750902	11657	2750901	11658	2750900	11659	3/4 - 16	4	2.00	.590	2B
2750898	11660	2750896	11661	2750895	11662	2750893	11663	7/8 - 9	5	2.22	.697	2B
2750892	11664	2750888	11665	2750886	11666	2750885	11667	7/8 - 14	5	2.22	.697	2B
2750883	11668	2750882	11669	2750880	11670	2750879	11671	1 - 8	5	2.50	.800	2B
2750878	11672	-	-	2750875	11674	2750873	11675	1 - 12	5	2.50	.800	2B
2750871	11676	2750868	11677	2750867	11678	2750865	11679	1 - 14	5	2.50	.800	2B
2750862	11680	2750857	11681	2750856	11682	2750854	11683	1 1/8 - 7	5	2.56	.896	2B
-	-	2750852	11685	2750848	11686	-	-	1 1/8 - 8	5	2.56	.896	2B
2750843	11688	2750841	11689	2750838	11690	-	-	1 1/8 - 12	5	2.56	.896	2B
2750835	11692	2750834	11693	2750832	11694	2750831	11695	1 1/4 - 7	6	2.56	1.021	2B
2750827	11696	2750824	11697	2750822	11698	-	-	1 1/4 - 8	6	2.56	1.021	2B
2750812	11700	2750809	11701	2750807	11702	-	-	1 1/4 - 12	6	2.56	1.021	2B
2750780	11716	2750778	11717	2750777	11718	2750776	11719	1 1/2 - 6	6	3.00	1.233	2B
-	-	2750770	11721	2750667	11722	-	-	1 1/2 - 8	6	3.00	1.233	2B
2750621	11724	-	-	2750617	11726	-	-	1 1/2 - 12	6	3.00	1.233	2B

- Constructed from select high-speed steel.
- Ground thread straight-flute design for sharp cutting action.
- Ideal for hand and power tapping for through or blind holes.
- 6H class of fit maintenance pitch diameter tolerances for longer life.
- Industrial-quality taps at maintenance prices.



- first choice
- alternate choice

■ Series 7353 • Plug Chamfer • Metric ANSI

uncoated		inch dimensions				number of flutes
order #	catalog #	D1 size	L	L3	D	
2750421	11900	M6 X 1	2.50	1.00	.255	6H
2750420	11901	M8 X 1,25	2.72	1.13	.318	6H
2750418	11902	M10 X 1,5	2.94	1.25	.381	6H
2750415	11903	M12 X 1,75	3.38	1.66	.367	6H
2750412	11904	M14 X 1,25	3.59	1.66	.429	6H
2750410	11905	M14 X 2	3.59	1.66	.429	6H
2750409	11906	M16 X 2	3.81	1.81	.480	6H
2750407	11907	M18 X 1,5	4.03	1.59	.542	6H
2750406	11908	M18 X 2,5	4.03	1.59	.542	6H
2750402	11909	M20 X 2,5	4.47	2.00	.652	6H
2750400	11910	M22 X 2,5	4.69	2.22	.697	6H
2750397	11911	M24 X 3	4.91	2.22	.760	6H

NOTE: Metric taps are manufactured to USCTI specifications and dimensions.
Metric tap blank dimensions are equivalent to inch taps.