



2017 Master Catalog

WIDIA  TM



Solutions for Forming Threads in Through and Blind Hole Applications •

WIDIA-GTD™

Forming Taps



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

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

High-Performance Victory™ Solid Carbide Taps

- Advanced forming geometries designed for superior tap performance in aluminum.
- 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

- Manufactured from powdered metal high-speed steel coated for thread forming in steel, stainless steel, and aluminum.
- High hardness provides superior wear resistance.
- Offer performance advantages over conventional high-speed steel taps.
- Long tap life at up to 50% higher tapping speed than HSS taps.
- Standard coolant-fed options for longer tool life.

General Purpose Production Taps

- TRU-LEDE™ Fe taps made from vanadium high-speed steel for extending wear life and better part finish in ductile materials.
- TRU-LEDE™ tap made from HSS for use in general machining applications.
- Plug and bottoming entry tapers for form tapping without troublesome chips that clog and break taps.

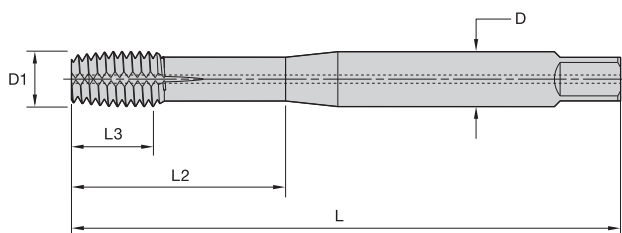
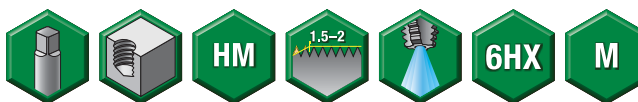


High-Performance Taps

Victory™ Solid Carbide Forming Taps • Blind Holes

WIDIA
GTD™

- WN14PG TiN + CrC/C for aluminum.

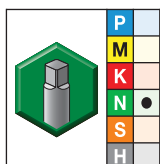


Shank Tolerance

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

WIDIA
VICTORY

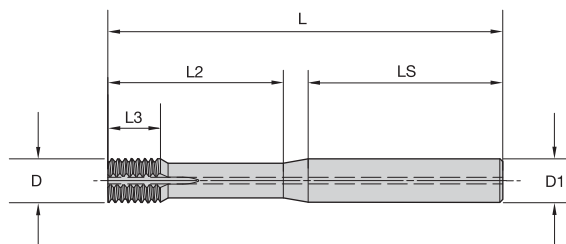
■ GX49 • Form E Bottoming Entry Taper • Through Coolant • Metric • For Aluminum



- first choice
- alternate choice

grade WN14PG TiN+CrC/C		metric dimensions					number of lube grooves	class of fit
order #	catalog #	D1 size	L	L3	L2	D		
5520842	GX495006	M6 X 1	80	10	30	6,0	2	6HX
5520843	GX495008	M8 X 1,25	90	13	35	8,0	2	6HX
5520844	GX495010	M10 X 1,5	100	15	39	10,0	3	6HX

- WN14PG TiN + CrC/C for aluminum.

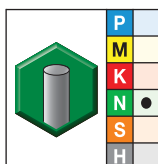


Shank Tolerance

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



■ GX49 • Form E Bottoming Entry Taper • Through Coolant • Metric • For Aluminum



- first choice
- alternate choice

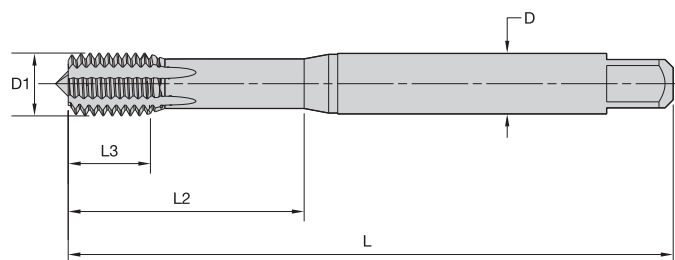
grade WN14PG TiN+CrC/C		metric dimensions						number of lube grooves	class of fit
order #	catalog #	D1 size	L	L3	L2	LS	D		
5551169	GX492908	M6 X 1	70	8	24	42	6,0	2	6HX
5551170	GX492909	M8 X 1,25	80	10	32	43	8,0	2	6HX
5551171	GX492911	M10 X 1,5	90	12	40	44	10,0	3	6HX
5551173	GX492915	M12 X 1,5	100	14	48	46	12,0	3	6HX
5551172	GX492914	M12 X 1,75	100	14	48	46	12,0	3	6HX

High-Performance Taps

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

WIDIA
GTD™

- WP31MG TiN for steel.
- WN38MG DLC for aluminum.

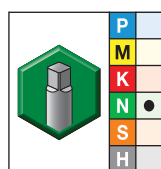
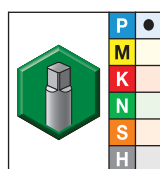


Shank Tolerance

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

■ GT22 • Form C Semi-Bottoming Entry Taper • Metric DIN 2174 • For Steel and Aluminum

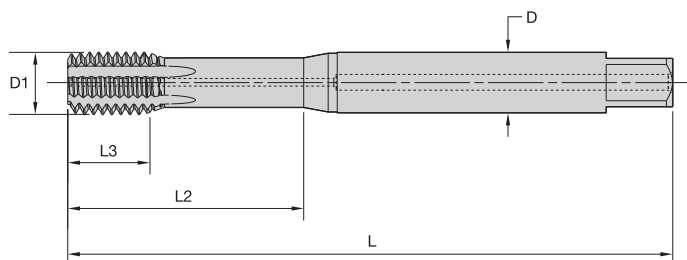


- first choice
- alternate choice

grade WP31MG TiN		grade WN38MG DLC		metric dimensions					dimension standard	class of fit
order #	catalog #	order #	catalog #	D1 size	L	L3	L2	D		
4158495	GT225016	4154671	GT225001	M3 X 0,5	56	6	18	3,5	DIN 2174	6HX
4158496	GT225017	4154672	GT225002	M4 X 0,7	63	7	21	4,5	DIN 2174	6HX
4158497	GT225018	4154673	GT225003	M5 X 0,8	70	8	25	6,0	DIN 2174	6HX
4158498	GT225019	4154674	GT225004	M6 X 1	80	10	30	6,0	DIN 2174	6HX
4158513	GT225024	4154679	GT225009	M8 X 1	90	10	35	8,0	DIN 2174	6HX
4158499	GT225020	4154675	GT225005	M8 X 1,25	90	14	35	8,0	DIN 2174	6HX
4158514	GT225025	4154680	GT225010	M10 X 1	90	10	35	10,0	DIN 2174	6HX
4158515	GT225026	4154681	GT225011	M10 X 1,25	100	16	39	10,0	DIN 2174	6HX
4158500	GT225021	4154676	GT225006	M10 X 1,5	100	16	39	10,0	DIN 2174	6HX
4158516	GT225027	4154682	GT225012	M12 X 1,25	100	15	—	9,0	DIN 2174	6HX
4158517	GT225028	4154683	GT225013	M12 X 1,5	100	15	—	9,0	DIN 2174	6HX
4158501	GT225022	4154677	GT225007	M12 X 1,75	110	18	—	9,0	DIN 2174	6HX
4158518	GT225029	4154684	GT225014	M14 X 1,5	100	15	—	11,0	DIN 2174	6HX
4158519	GT225030	4154685	GT225015	M16 X 1,5	100	15	—	12,0	DIN 2174	6HX
4158502	GT225023	4154678	GT225008	M16 X 2	110	22	—	12,0	DIN 2174	6HX

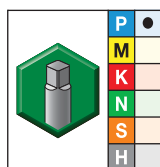
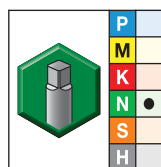
High-Performance Taps

- WP31MG TiN for steel.
- WN38MG DLC for aluminum.



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


GT23 • Form C Semi-Bottoming Entry Taper • Through Coolant • Metric DIN 2174 • For Steel and Aluminum

 grade WP31MG
TiN

 grade WN38MG
DLC

- first choice
- alternate choice

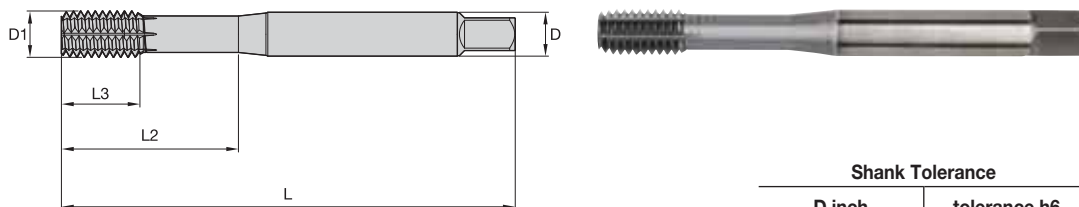
				metric dimensions					dimension standard	class of fit
order #	catalog #	order #	catalog #	D1 size	L	L3	L2	D		
4159965	GT235012	4159522	GT235001	M5 X 0,8	70	8	25	6,0	DIN 2174	6HX
4159966	GT235013	4159644	GT235002	M6 X 1	80	10	30	6,0	DIN 2174	6HX
4159971	GT235018	4159649	GT235007	M8 X 1	90	10	35	8,0	DIN 2174	6HX
4159967	GT235014	4159645	GT235003	M8 X 1,25	90	14	35	8,0	DIN 2174	6HX
4159972	GT235019	4159650	GT235008	M10 X 1	90	10	35	10,0	DIN 2174	6HX
4159968	GT235015	4159646	GT235004	M10 X 1,5	100	16	39	10,0	DIN 2174	6HX
4159993	GT235020	4159651	GT235009	M12 X 1,5	100	15	—	9,0	DIN 2174	6HX
4159969	GT235016	4159647	GT235005	M12 X 1,75	110	18	—	9,0	DIN 2174	6HX
4159994	GT235021	4159652	GT235010	M14 X 1,5	100	15	—	11,0	DIN 2174	6HX
4159995	GT235022	4159653	GT235011	M16 X 1,5	100	15	—	12,0	DIN 2174	6HX
4159970	GT235017	4159648	GT235006	M16 X 2	110	22	—	12,0	DIN 2174	6HX

High-Performance Taps

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

WIDIA
GTD™

- WU32MG TiCN for steel and stainless steel.

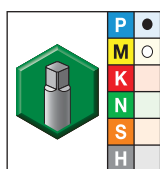


Shank Tolerance

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

WIDIA
VICTORY

- GT24 • Form C Semi-Bottoming Entry Taper • Machine Screw and Fractional • DIN Length ANSI Shank
- For Steel and Stainless Steel



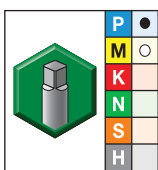
- first choice
- alternate choice

grade WU32MG TiCN		inch dimensions					number of lube grooves	pitch diameter limit
order #	catalog #	D1 TPI	L	L3	L2	D		
5944876	GT245001	6 - 32	2.22	.41	.81	.141	2	H3
5944877	GT245002	6 - 32	2.22	.41	.81	.141	2	H5
5944878	GT245003	8 - 32	2.48	.39	.83	.168	4	H3
5944879	GT245004	8 - 32	2.48	.39	.83	.168	4	H5
5944880	GT245005	10 - 24	2.78	.39	1.01	.194	4	H4
5944971	GT245006	10 - 24	2.78	.39	1.01	.194	4	H6
5944972	GT245007	10 - 32	2.77	.39	1.00	.194	4	H4
5944973	GT245008	10 - 32	2.77	.39	1.00	.194	4	H6
5944974	GT245009	1/4 - 20	3.18	.51	1.22	.255	4	H4
5944975	GT245010	1/4 - 20	3.18	.51	1.21	.255	4	H6
5944976	GT245011	1/4 - 28	3.16	.51	1.20	.255	4	H4
5944977	GT245012	1/4 - 28	3.16	.51	1.20	.255	4	H6
5944978	GT245013	5/16 - 18	3.58	.55	1.42	.318	4	H5
5944979	GT245014	5/16 - 18	3.58	.55	1.42	.318	4	H7
5944980	GT245015	5/16 - 24	3.56	.55	1.40	.318	4	H5
5944981	GT245016	5/16 - 24	3.56	.55	1.38	.318	4	H7
5944982	GT245017	3/8 - 16	3.98	.63	1.54	.381	6	H5
5944983	GT245018	3/8 - 16	3.98	.63	1.54	.381	6	H7
5944984	GT245019	3/8 - 24	3.95	.63	1.54	.381	6	H5
5944985	GT245020	3/8 - 24	3.94	.63	1.54	.381	6	H7
5944986	GT245021	7/16 - 14	3.94	.71	1.61	.323	6	H5
5944987	GT245022	7/16 - 14	3.94	.71	1.61	.323	6	H7
5944988	GT245023	7/16 - 20	3.94	.71	1.61	.323	6	H5
5944989	GT245024	7/16 - 20	3.94	.71	1.61	.323	6	H7

(continued)

WIDIA

(GT24 • Form C Semi-Bottoming Entry Taper • Machine Screw and Fractional • DIN Length ANSI Shank • For Steel and Stainless Steel — continued)



● first choice
○ alternate choice

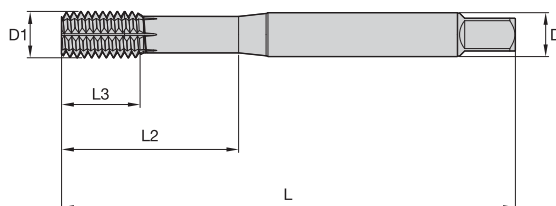
grade WU32MG TiCN		inch dimensions					number of lube grooves	pitch diameter limit
order #	catalog #	D1 TPI	L	L3	L2	D		
5944990	GT245025	1/2 - 13	4.33	.79	1.85	.367	6	H5
5945001	GT245026	1/2 - 13	4.33	.79	1.85	.367	6	H7
5945002	GT245027	1/2 - 20	4.33	.79	1.85	.367	6	H5
5945003	GT245028	1/2 - 20	4.33	.79	1.85	.367	6	H7
5945004	GT245029	5/8 - 11	4.33	.91	2.01	.480	6	H7
5945005	GT245030	5/8 - 11	4.33	.91	2.01	.480	6	H10
5945006	GT245031	5/8 - 18	4.33	.91	2.01	.480	6	H7
5945007	GT245032	5/8 - 18	4.33	.91	2.01	.480	6	H10
5945008	GT245033	3/4 - 10	4.92	.98	2.52	.590	6	H7
5945009	GT245034	3/4 - 10	4.92	.98	2.52	.590	6	H10
5945010	GT245035	3/4 - 16	4.92	.98	2.52	.590	6	H7
5945011	GT245036	3/4 - 16	4.92	.98	2.52	.590	6	H10

High-Performance Taps

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

WIDIA
GTD™

- WU32MG TiCN for steel and stainless steel.

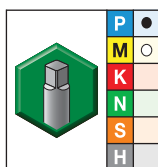


Shank Tolerance

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

WIDIA
VICTORY

- GT24 • Form C Semi-Bottoming Entry Taper • Metric • DIN Length ANSI Shank • For Steel and Stainless Steel

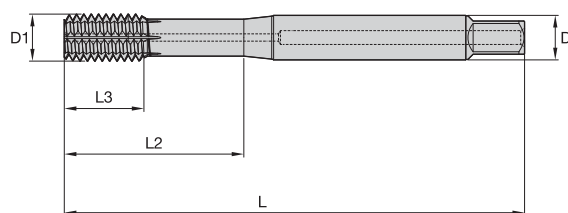


- first choice
- alternate choice

grade WU32MG TiCN		inch dimensions					number of lube grooves	pitch diameter limit
order #	catalog #	D1 TPI	L	L3	L2	D		
5945012	GT245037	M3 X 0,5	2.20	.39	.79	.141	2	D5
5945013	GT245038	M3,5 X 0,6	2.20	.39	.79	.141	2	D6
5945014	GT245039	M4 X 0,7	2.48	.39	.83	.168	4	D6
5945015	GT245040	M5 X 0,8	2.76	.39	.98	.194	4	D7
5945016	GT245041	M6 X 1	3.15	.51	1.18	.255	4	D8
5945017	GT245042	M7 X 1	3.15	.51	1.18	.318	4	D9
5945018	GT245043	M8 X 1	3.54	.55	1.38	.318	6	D9
5945019	GT245044	M8 X 1,25	3.54	.55	1.38	.318	6	D9
5945020	GT245045	M10 X 1,25	3.94	.63	1.53	.381	6	D9
5945021	GT245046	M10 X 1,5	3.94	.63	1.54	.381	6	D10
5945022	GT245047	M12 X 1,25	4.33	.71	1.73	.367	6	D9
5945023	GT245048	M12 X 1,5	4.33	.71	1.73	.367	6	D9
5945024	GT245049	M12 X 1,75	4.33	.71	1.73	.367	6	D11
5945025	GT245050	M14 X 1,5	4.33	.79	2.05	.429	6	D11
5945026	GT245051	M14 X 2	4.33	.79	2.05	.429	6	D12
5945027	GT245052	M16 X 1,5	4.33	.79	2.01	.480	6	D11
5945028	GT245053	M16 X 2	4.33	.79	2.01	.480	6	D12

High-Performance Taps

- WU32MG TiCN for steel and stainless steel.

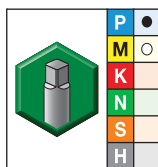


Shank Tolerance

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



- GT25 • Form C Semi-Bottoming Entry Taper • Through Coolant • Fractional • DIN Length ANSI Shank
- For Steel and Stainless Steel



- first choice
- alternate choice

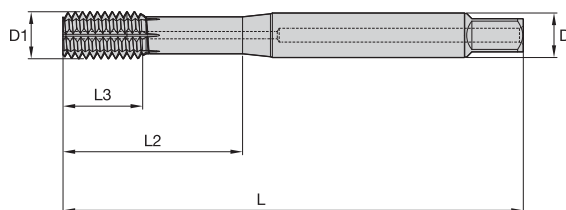
grade WU32MG TiCN		inch dimensions					number of lube grooves	pitch diameter limit
order #	catalog #	D1 TPI	L	L3	L2	D		
5945029	GT255001	1/4 - 20	3.15	.51	1.18	.255	4	H4
5945030	GT255002	1/4 - 20	3.15	.51	1.18	.255	4	H6
5945031	GT255003	1/4 - 28	3.15	.51	1.18	.255	4	H4
5945032	GT255004	1/4 - 28	3.15	.51	1.18	.255	4	H6
5945033	GT255005	5/16 - 18	3.54	.55	1.38	.318	6	H5
5945034	GT255006	5/16 - 18	3.54	.55	1.38	.318	6	H7
5945035	GT255007	5/16 - 24	3.54	.55	1.38	.318	6	H5
5945036	GT255008	5/16 - 24	3.54	.55	1.38	.318	6	H7
5945037	GT255009	3/8 - 16	3.94	.63	1.54	.381	6	H5
5945038	GT255010	3/8 - 16	3.94	.63	1.54	.381	6	H7
5945039	GT255011	3/8 - 24	3.94	.63	1.54	.381	6	H5
5945040	GT255012	3/8 - 24	3.94	.63	1.54	.381	6	H7
5945041	GT255013	7/16 - 14	3.94	.71	1.61	.323	6	H5
5945042	GT255014	7/16 - 14	3.94	.71	1.61	.323	6	H7
5945043	GT255015	7/16 - 20	3.94	.71	1.61	.323	6	H5
5945044	GT255016	7/16 - 20	3.94	.71	1.61	.323	6	H7
5945045	GT255017	1/2 - 13	4.33	.79	1.85	.367	6	H5
5945046	GT255018	1/2 - 13	4.33	.79	1.85	.367	6	H7
5945047	GT255019	1/2 - 20	4.33	.79	1.85	.367	6	H5
5945048	GT255020	1/2 - 20	4.33	.79	1.85	.367	6	H7
5945049	GT255021	5/8 - 11	4.33	.79	2.01	.480	6	H7
5945050	GT255022	5/8 - 11	4.33	.79	2.01	.480	6	H10
5945051	GT255023	5/8 - 18	4.33	.79	2.01	.480	6	H7
5945052	GT255024	5/8 - 18	4.33	.79	2.01	.480	6	H10
5945053	GT255025	3/4 - 10	4.92	.98	2.52	.590	6	H7
5945054	GT255026	3/4 - 10	4.92	.98	2.52	.590	6	H10
5945055	GT255027	3/4 - 16	4.92	.98	2.52	.590	6	H7
5945056	GT255028	3/4 - 16	4.92	.98	2.52	.590	6	H10

High-Performance Taps

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

WIDIA
GTD™

- WU32MG TiCN for steel and stainless steel.

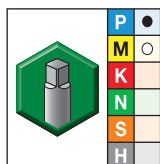


Shank Tolerance

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

WIDIA
VICTORY

- GT25 • Form C Semi-Bottoming Entry Taper • Through Coolant • Metric • DIN Length ANSI Shank
- For Steel and Stainless Steel

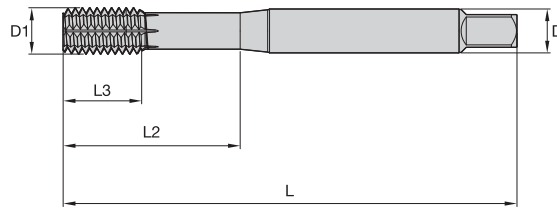


- first choice
- alternate choice

grade WU32MG TiCN		inch dimensions					number of lube grooves	pitch diameter limit
order #	catalog #	D1 TPI	L	L3	L2	D		
5945057	GT255029	M6 X 1	3.15	.51	1.18	.255	4	D8
5945058	GT255030	M7 X 1	3.15	.51	1.18	.318	4	D9
5945059	GT255031	M8 X 1	3.54	.55	1.38	.318	6	D9
5945060	GT255032	M8 X 1,25	3.54	.55	1.38	.318	6	D9
5945071	GT255033	M10 X 1,25	3.94	.63	1.54	.381	6	D9
5945072	GT255034	M10 X 1,5	3.94	.63	1.54	.381	6	D10
5945073	GT255035	M12 X 1,25	4.33	.71	1.73	.367	6	D9
5945074	GT255036	M12 X 1,5	4.33	.71	1.73	.367	6	D9
5945075	GT255037	M12 X 1,75	4.33	.71	1.73	.367	6	D11
5945076	GT255038	M14 X 1,5	4.33	.79	2.05	.429	6	D11
5945077	GT255039	M14 X 2	4.33	.79	2.05	.429	6	D12
5945078	GT255040	M16 X 1,5	4.33	.79	2.01	.480	6	D11
5945079	GT255041	M16 X 2	4.33	.79	2.01	.480	6	D12

High-Performance Taps

- WU32MG TiCN for steel and stainless steel.

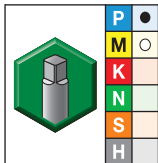


Shank Tolerance

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



- GT26 • Form E Bottoming Entry Taper • Machine Screw and Fractional • DIN Length ANSI Shank
- For Steel and Stainless Steel



- first choice
- alternate choice

grade WU32MG TiCN		inch dimensions					number of lube grooves	pitch diameter limit
order #	catalog #	D1 TPI	L	L3	L2	D		
5945080	GT265001	0 - 80	1.63	.31	.37	.141	0	H2
5945091	GT265002	2 - 56	1.75	.44	.50	.141	0	H3
5945092	GT265003	3 - 48	1.97	.39	.71	.141	0	H3
5945093	GT265004	3 - 56	1.97	.39	.71	.141	0	H3
5945094	GT265005	4 - 40	2.20	.39	.71	.141	0	H3
5945095	GT265006	4 - 40	2.20	.39	.71	.141	0	H5
5945096	GT265007	4 - 48	2.20	.39	.71	.141	0	H3
5945097	GT265008	4 - 48	2.20	.39	.71	.141	0	H5
5945098	GT265009	5 - 40	2.20	.39	.79	.141	2	H5
5945099	GT265010	6 - 32	2.21	.39	.79	.141	2	H3
5945100	GT265011	6 - 32	2.21	.39	.79	.141	2	H5
5945101	GT265012	8 - 32	2.48	.39	.83	.168	4	H3
5945102	GT265013	8 - 32	2.48	.39	.83	.168	4	H5
5945103	GT265014	10 - 24	2.76	.39	.98	.194	4	H4
5945104	GT265015	10 - 24	2.76	.39	.98	.194	4	H6
5945105	GT265016	10 - 32	2.76	.39	.98	.194	4	H4
5945106	GT265017	10 - 32	2.76	.39	.98	.194	4	H6
5945107	GT265018	1/4 - 20	3.15	.51	1.18	.255	4	H4
5945108	GT265019	1/4 - 20	3.15	.51	1.18	.255	4	H6
5945109	GT265020	1/4 - 28	3.15	.51	1.18	.255	4	H4
5945110	GT265021	1/4 - 28	3.15	.51	1.18	.255	4	H6
5945111	GT265022	5/16 - 18	3.54	.55	1.38	.318	6	H5
5945112	GT265023	5/16 - 18	3.54	.55	1.38	.318	6	H7
5945113	GT265024	5/16 - 24	3.54	.55	1.38	.318	6	H5

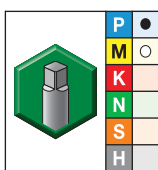
(continued)

High-Performance Taps

Victory™ Forming Taps HSS-E-PM • Blind Holes



(GT26 • Form E Bottoming Entry Taper • Machine Screw and Fractional • DIN Length ANSI Shank • For Steel and Stainless Steel — continued)

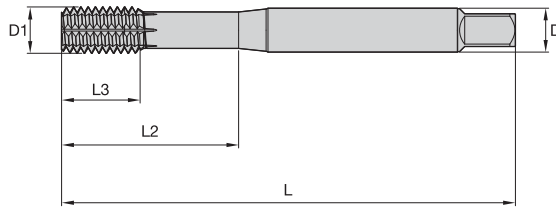


● first choice
○ alternate choice

grade WU32MG TiCN		inch dimensions					number of lube grooves	pitch diameter limit
order #	catalog #	D1 TPI	L	L3	L2	D		
5945114	GT265025	5/16 - 24	3.54	.55	1.38	.318	6	H7
5945115	GT265026	3/8 - 16	3.94	.63	1.54	.381	6	H5
5945116	GT265027	3/8 - 16	3.94	.63	1.54	.381	6	H7
5945117	GT265028	3/8 - 24	3.94	.63	1.54	.381	6	H5
5945118	GT265029	3/8 - 24	3.94	.63	1.54	.381	6	H7
5945119	GT265030	7/16 - 14	3.94	.71	1.61	.323	6	H5
5945120	GT265031	7/16 - 14	3.94	.71	1.61	.323	6	H7
5945121	GT265032	7/16 - 20	3.94	.71	1.61	.323	6	H5
5945122	GT265033	7/16 - 20	3.94	.71	1.61	.323	6	H7
5945123	GT265034	1/2 - 13	4.33	.79	1.85	.367	6	H5
5945124	GT265035	1/2 - 13	4.33	.79	1.85	.367	6	H7
5945125	GT265036	1/2 - 20	4.33	.79	1.85	.367	6	H5
5945126	GT265037	1/2 - 20	4.33	.79	1.85	.367	6	H7
5945127	GT265038	5/8 - 11	4.33	.79	2.01	.480	6	H7
5945128	GT265039	5/8 - 11	4.33	.79	2.01	.480	6	H10
5945129	GT265040	5/8 - 18	4.33	.79	2.01	.480	6	H7
5945130	GT265041	5/8 - 18	4.33	.79	2.01	.480	6	H10
5945131	GT265042	3/4 - 10	4.92	.98	2.52	.590	6	H7
5945132	GT265043	3/4 - 10	4.92	.98	2.52	.590	6	H10
5945133	GT265044	3/4 - 16	4.92	.98	2.52	.590	6	H7
5945134	GT265045	3/4 - 16	4.92	.98	2.52	.590	6	H10

High-Performance Taps

- WU32MG TiCN for steel and stainless steel.

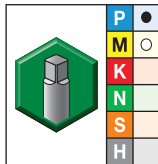


Shank Tolerance

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



■ GT26 • Form E Bottoming Entry Taper • Metric • DIN Length ANSI Shank • For Steel and Stainless Steel



- first choice
- alternate choice

grade WU32MG TiCN		inch dimensions					number of lube grooves	pitch diameter limit
order #	catalog #	D1 TPI	L	L3	L2	D		
5945135	GT265046	M3 X 0,5	2.20	.39	.79	.141	2	D5
5945136	GT265047	M3,5 X 0,6	2.20	.39	.79	.141	2	D6
5945137	GT265048	M4 X 0,7	2.48	.39	.83	.168	4	D6
5945138	GT265049	M5 X 0,8	2.76	.39	.98	.194	4	D7
5945139	GT265050	M6 X 1	3.15	.51	1.18	.255	4	D8
5945140	GT265051	M7 X 1	3.15	.51	1.18	.318	4	D9
5945141	GT265052	M8 X 1	3.54	.55	1.38	.318	6	D9
5945142	GT265053	M8 X 1,25	3.54	.55	1.38	.318	6	D9
5945143	GT265054	M10 X 1,25	3.94	.63	1.53	.381	6	D9
5945144	GT265055	M10 X 1,5	3.94	.63	1.54	.381	6	D10
5945145	GT265056	M12 X 1,25	4.33	.71	1.73	.367	6	D9
5945146	GT265057	M12 X 1,5	4.33	.71	1.73	.367	6	D9
5945147	GT265058	M12 X 1,75	4.33	.71	1.73	.367	6	D11
5945148	GT265059	M14 X 1,5	4.33	.79	2.05	.429	6	D11
5945149	GT265060	M14 X 2	4.33	.79	2.05	.429	6	D12
5945150	GT265061	M16 X 1,5	4.33	.79	2.01	.480	6	D11
5945151	GT265062	M16 X 2	4.33	.79	2.01	.480	6	D12

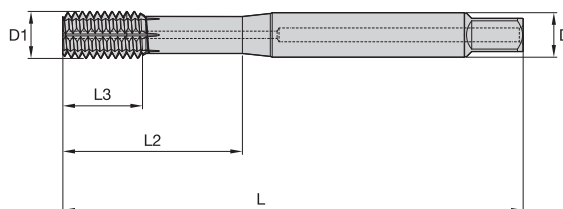
High-Performance Taps

High-Performance Taps

Victory™ Forming Taps HSS-E-PM • Blind Holes

WIDIA
GTD™

- WU32MG TiCN for steel and stainless steel.

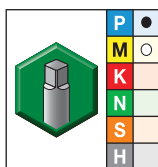


Shank Tolerance

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

WIDIA
VICTORY

- GT27 • Form E Bottoming Entry Taper • Through Coolant • Fractional • DIN Length ANSI Shank
- For Steel and Stainless Steel



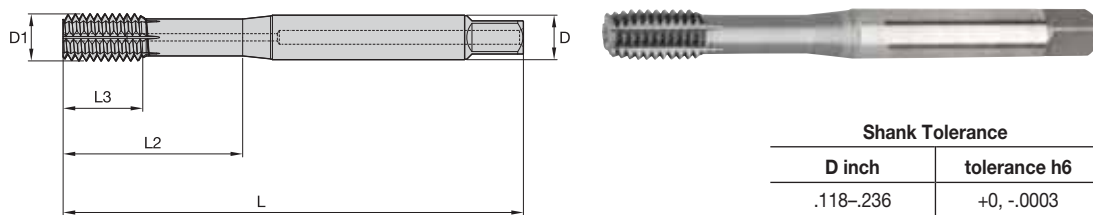
- first choice
- alternate choice

grade WU32MG
TiCN

		inch dimensions					number of lube grooves	pitch diameter limit
order #	catalog #	D1 TPI	L	L3	L2	D		
5944922	GT275001	1/4 - 20	3.15	.51	1.18	.255	4	H4
5944923	GT275002	1/4 - 20	3.15	.51	1.18	.255	4	H6
5944924	GT275003	1/4 - 28	3.15	.51	1.18	.255	4	H4
5944925	GT275004	1/4 - 28	3.15	.51	1.18	.255	4	H6
5944926	GT275005	5/16 - 18	3.54	.55	1.38	.318	6	H5
5944927	GT275006	5/16 - 18	3.54	.55	1.38	.318	6	H7
5944928	GT275007	5/16 - 24	3.54	.55	1.38	.318	6	H5
5944929	GT275008	5/16 - 24	3.54	.55	1.38	.318	6	H7
5944930	GT275009	3/8 - 16	3.94	.63	1.54	.381	6	H5
5945171	GT275010	3/8 - 16	3.94	.63	1.54	.381	6	H7
5945172	GT275011	3/8 - 24	3.94	.63	1.54	.381	6	H5
5945173	GT275012	3/8 - 24	3.94	.63	1.54	.381	6	H7
5945174	GT275013	7/16 - 14	3.94	.71	1.61	.323	6	H5
5945175	GT275014	7/16 - 14	3.94	.71	1.61	.323	6	H7
5945176	GT275015	7/16 - 20	3.94	.71	1.61	.323	6	H5
5945177	GT275016	7/16 - 20	3.94	.71	1.61	.323	6	H7
5945178	GT275017	1/2 - 13	4.33	.79	1.85	.367	6	H5
5945179	GT275018	1/2 - 13	4.33	.79	1.85	.367	6	H7
5945180	GT275019	1/2 - 20	4.33	.79	1.85	.367	6	H5
5945181	GT275020	1/2 - 20	4.33	.79	1.85	.367	6	H7
5945182	GT275021	5/8 - 11	4.33	.79	2.01	.480	6	H7
5945183	GT275022	5/8 - 11	4.33	.79	2.01	.480	6	H10
5945184	GT275023	5/8 - 18	4.33	.79	2.01	.480	6	H7
5945185	GT275024	5/8 - 18	4.33	.79	2.01	.480	6	H10
5945186	GT275025	3/4 - 10	4.92	.98	2.52	.590	6	H7
5945187	GT275026	3/4 - 10	4.92	.98	2.52	.590	6	H10
5945188	GT275027	3/4 - 16	4.92	.98	2.52	.590	6	H7
5945189	GT275028	3/4 - 16	4.92	.98	2.52	.590	6	H10

High-Performance Taps

- WU32MG TiCN for steel and stainless steel.

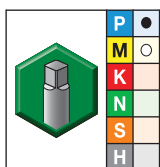


Shank Tolerance

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

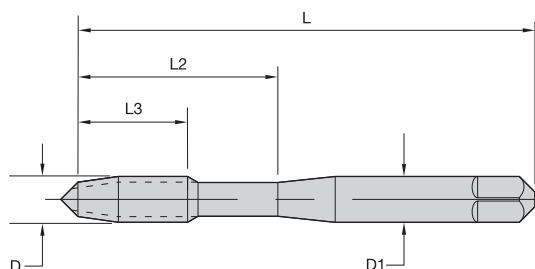


- GT27 • Form E Bottoming Entry Taper • Through Coolant • Metric • DIN Length ANSI Shank • For Steel and Stainless Steel

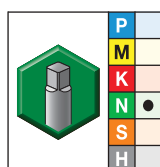
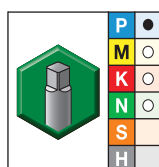
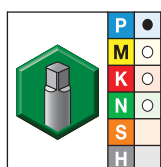


- first choice
- alternate choice

grade WU32MG TiCN		inch dimensions					number of lube grooves	pitch diameter limit
order #	catalog #	D1 TPI	L	L3	L2	D		
5945190	GT275029	M6 X 1	3.15	.51	1.18	.255	4	D8
5945191	GT275030	M7 X 1	3.15	.51	1.18	.318	4	D9
5945192	GT275031	M8 X 1	3.54	.55	1.38	.318	6	D9
5945193	GT275032	M8 X 1,25	3.54	.55	1.38	.318	6	D9
5945194	GT275033	M10 X 1,25	3.94	.63	1.54	.381	6	D9
5945195	GT275034	M10 X 1,5	3.94	.63	1.54	.381	6	D10
5945196	GT275035	M12 X 1,25	4.33	.71	1.73	.367	6	D9
5945197	GT275036	M12 X 1,5	4.33	.71	1.73	.367	6	D9
5945198	GT275037	M12 X 1,75	4.33	.71	1.73	.367	6	D11
5945199	GT275038	M14 X 1,5	4.33	.79	2.05	.429	6	D11
5945200	GT275039	M14 X 2	4.33	.79	2.05	.429	6	D12
5945211	GT275040	M16 X 1,5	4.33	.79	2.01	.480	6	D11
5945212	GT275041	M16 X 2	4.33	.79	2.01	.480	6	D12



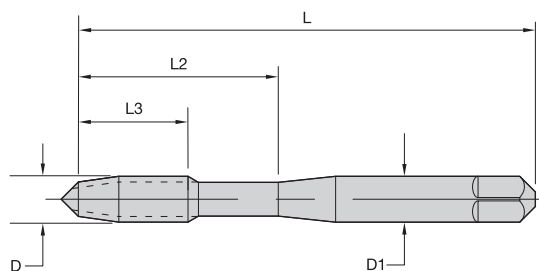
■ Series 5900 • Machine Screw and Fractional • Plug Entry Taper



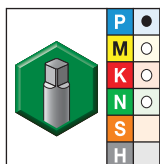
- first choice
- alternate choice

TiCN		TiN		uncoated		inch dimensions					number of lube grooves	pitch diameter limit
order #	catalog #	order #	catalog #	order #	catalog #	D1 size	L	L3	L2	D		
—	—	—	—	2747479	18202	6 - 32	2.00	.38	.69	.141	4	H5
2747215	18703	2747338	18303	2747477	18203	6 - 32	2.00	.38	.69	.141	4	H3
2747210	18706	—	—	2747471	18206	6 - 40	2.00	.38	.69	.141	4	H3
—	—	—	—	2747461	18210	8 - 32	2.13	.38	.75	.168	4	H5
—	—	2747322	18311	2747459	18211	8 - 32	2.13	.38	.75	.168	4	H3
2747188	18717	2747311	18317	2747447	18217	10 - 24	2.38	.50	.88	.194	4	H4
—	—	2747306	18320	2747441	18220	10 - 32	2.38	.50	.88	.194	4	H6
2747180	18721	3171069	18321	2747439	18221	10 - 32	2.38	.50	.88	.194	4	H4
—	—	—	—	2747437	18224	12 - 24	2.38	.50	.94	.220	4	H4
2747174	18728	2747296	18328	2747427	18228	1/4 - 20	2.50	.63	1.00	.255	4	H6
—	—	2747293	18329	2747425	18229	1/4 - 20	2.50	.63	1.00	.255	4	H4
—	—	2747288	18332	2747419	18232	1/4 - 28	2.50	.63	1.00	.255	4	H6
2747165	18733	—	—	2747417	18233	1/4 - 28	2.50	.63	1.00	.255	4	H4
2747156	18737	2747277	18337	2747409	18237	5/16 - 18	2.72	.69	1.13	.318	4	H5
—	—	2747273	18341	2747401	18241	5/16 - 24	2.72	.69	1.13	.318	4	H5
2747141	18745	2747265	18345	2747391	18245	3/8 - 16	2.94	.75	1.25	.381	4	H5
—	—	—	—	2747378	18252	1/2 - 13	3.38	.94	—	.367	4	H5

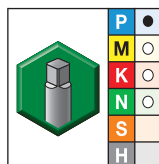
NOTE: Form taps require a larger drilled hole size prior to tapping than corresponding cutting taps.
Refer to tables on pages W231–W232 for the recommended pitch diameter limit for 2B or 3B class of fit.



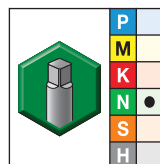
■ Series 5910 • Plug Entry Taper • Metric ANSI



TiCN



TiN

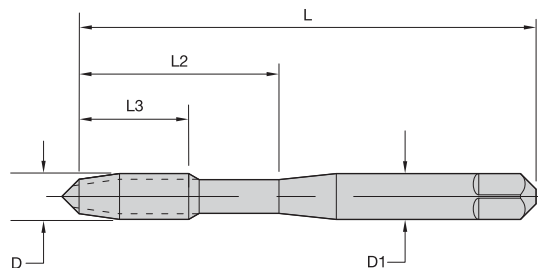
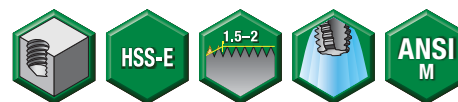


uncoated

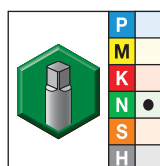
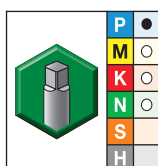
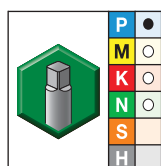
- first choice
- alternate choice

						inch dimensions					number of lube grooves	pitch diameter limit
order #	catalog #	order #	catalog #	order #	catalog #	D1 size	L	L3	L2	D		
2747101	18760	2747236	18360	2747360	18260	M6 X 1	64	16	25	6,5	4	D8
2747096	18762	2747232	18362	2747355	18262	M8 X 1,25	69	17	29	8,1	4	D9
2747092	18764	2747228	18364	2747351	18264	M10 X 1,5	75	19	32	9,7	4	D10

NOTE: Metric taps are manufactured to USCTI specifications and dimensions.
Metric tap blank dimensions are equivalent to inch taps.
Form taps require a larger drilled hole size prior to tapping than corresponding cutting taps.



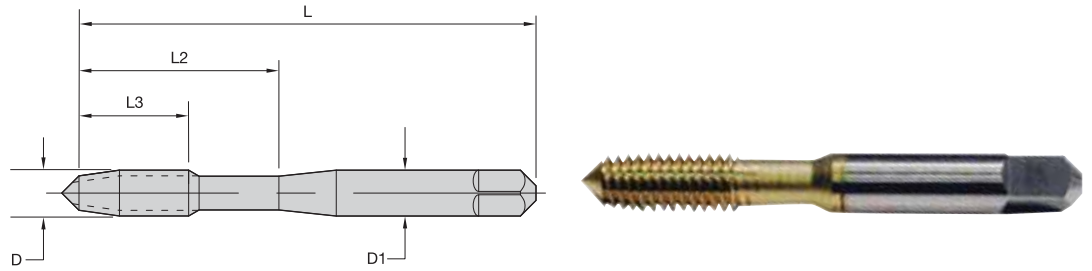
■ Series 5912 • Bottom Entry Taper • Metric ANSI



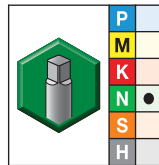
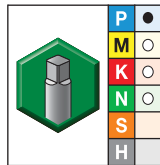
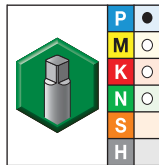
- first choice
- alternate choice

TiCN		TiN		uncoated		inch dimensions					number of lube grooves	pitch diameter limit
order #	catalog #	order #	catalog #	order #	catalog #	D1 size	L	L3	L2	D		
2747120	18755	2747246	18355	—	—	M4 X 0,7	54	10	19	4,3	4	D6
2747117	18757	2747241	18357	2747367	18257	M5 X 0,8	60	13	22	4,9	4	D7
2747113	18759	2747238	18359	2747364	18259	M6 X 1	64	16	25	6,5	4	D8
—	—	—	—	2747357	18261	M8 X 1,25	69	17	28	8,1	4	D9
2747099	18761	2747233	18361	—	—	M8 X 1,25	69	17	29	8,1	4	D9
2747090	18765	—	—	2747347	18265	M12 X 1,75	86	24	—	9,3	4	D11

NOTE: Metric taps are manufactured to USCTI specifications and dimensions.
Metric tap blank dimensions are equivalent to inch taps.
Form taps require a larger drilled hole size prior to tapping than corresponding cutting taps.



■ Series 5902 • Machine Screw and Fractional • Bottom Entry Taper



● first choice
 ○ alternate choice

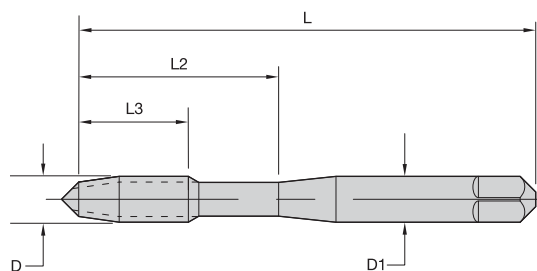
TiCN		TiN		uncoated		inch dimensions					number of lube grooves	pitch diameter limit
order #	catalog #	order #	catalog #	order #	catalog #	D1 size	L	L3	L2	D		
2747222	18700	2747344	18300	2747485	18200	6 - 32	2.00	.38	.69	.141	4	H3
2747220	18701	2747342	18301	2747483	18201	6 - 32	2.00	.38	.69	.141	4	H5
—		2747328	18308	2747467	18208	8 - 32	2.13	.38	.75	.168	4	H5
2747204	18709	2747326	18309	2747463	18209	8 - 32	2.13	.38	.75	.168	4	H3
2747198	18712	—		2747457	18212	8 - 36	2.13	.38	.75	.168	4	H3
2747194	18714	—		2747453	18214	10 - 24	2.38	.50	.88	.194	4	H6
2747192	18715	3171068	18315	2747451	18215	10 - 24	2.38	.50	.88	.194	4	H4
2747186	18718	2747310	18318	2747445	18218	10 - 32	2.38	.50	.88	.194	4	H6
2747184	18719	2747308	18319	2747443	18219	10 - 32	2.38	.50	.88	.194	4	H4
3171071	18723	—		3324580	18223	12 - 24	2.38	.50	.94	.220	4	H4
2747179	18726	2747300	18326	2747433	18226	1/4 - 20	2.50	.63	1.00	.255	4	H4
2747177	18727	2747298	18327	2747431	18227	1/4 - 20	2.50	.63	1.00	.255	4	H6
2747170	18730	2747291	18330	2747423	18230	1/4 - 28	2.50	.63	1.00	.255	4	H6
2747169	18731	2747289	18331	2747421	18231	1/4 - 28	2.50	.63	1.00	.255	4	H4
2747162	18734	—		2747415	18234	5/16 - 18	2.72	.69	1.13	.318	4	H5
2747160	18735	—		2747413	18235	5/16 - 18	2.72	.69	1.13	.318	4	H7
—		2747271	18342	2747399	18242	3/8 - 16	2.94	.75	1.25	.381	4	H5
2747145	18743	2747269	18343	2747397	18243	3/8 - 16	2.94	.75	1.25	.381	4	H7
2747133	18749	2747257	18349	2747383	18249	1/2 - 13	3.38	.94	—	.367	4	H7
2747131	18750	—		2747381	18250	1/2 - 13	3.38	.94	—	.367	4	H5

NOTE: Form taps require a larger drilled hole size prior to tapping than corresponding cutting taps.
 Refer to tables on pages W231–W232 for the recommended pitch diameter limit for 2B or 3B class of fit.

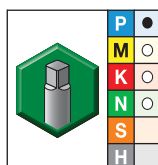
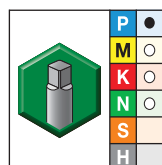
Production Taps

TRU-LEDE™ Forming Taps • Through Holes in General Machining Applications

- Series 2500TiN • TiN Coated
- Series 5500 • Uncoated



■ Series 2500/5500 • Machine Screw and Fractional • Plug Entry Taper

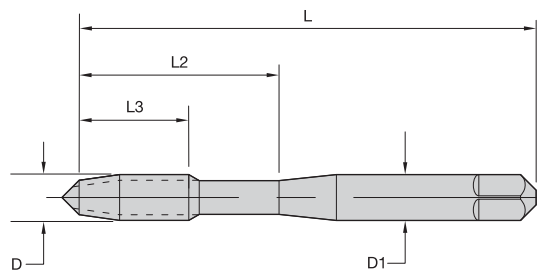


- first choice
- alternate choice

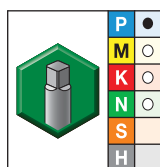
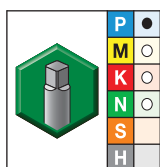
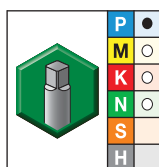
TiN		uncoated		inch dimensions					number of lube grooves	pitch diameter limit
order #	catalog #	order #	catalog #	D1 size	L	L3	L2	D		
2746344	19821	2864322	17000	4 - 40	1.88	.31	.56	.141	—	H3
—	—	2864319	17001	4 - 40	1.88	.31	.56	.141	—	H5
—	—	2864313	17004	5 - 40	1.94	.31	.63	.141	4	H3
2746342	19822	2864310	17008	6 - 32	2.00	.38	.69	.141	4	H3
—	—	2864307	17009	6 - 32	2.00	.38	.69	.141	4	H5
2746338	19824	2864298	17013	8 - 32	2.13	.38	.75	.168	4	H3
2746336	19826	—	—	8 - 32	2.13	.38	.75	.168	4	H5
2746333	19827	1295731	17018	10 - 24	2.38	.50	.88	.194	4	H4
2746331	19828	1295732	17020	10 - 32	2.38	.50	.88	.194	4	H4
2746327	19841	2747916	17027	1/4 - 20	2.50	.63	1.00	.255	4	H4
2746325	19842	2747910	17030	1/4 - 28	2.50	.63	1.00	.255	4	H4
2746324	19846	—	—	5/16 - 18	2.72	.69	1.13	.318	4	H5
—	—	2747904	17033	5/16 - 18	2.72	.69	1.13	.318	4	H5
—	—	2747898	17036	5/16 - 24	2.72	.69	1.13	.318	4	H5
2746322	19847	2747892	17039	3/8 - 16	2.94	.75	1.25	.381	4	H5
—	—	2747886	17042	3/8 - 24	2.94	.75	—	.323	4	H8
—	—	2747882	17049	1/2 - 13	3.38	.94	—	.367	4	H5
—	—	2747878	17051	1/2 - 20	3.38	.94	—	.367	4	H5
—	—	2747876	17053	5/8 - 11	3.81	1.09	—	.480	6	H7
—	—	2747872	17057	3/4 - 10	4.25	1.22	—	.590	6	H7

NOTE: Form taps require a larger drilled hole size prior to tapping than corresponding cutting taps.
Refer to tables on pages W231–W232 for the recommended pitch diameter limit for 2B or 3B class of fit.

- Series 2502TiN • TiN Coated
- Series 5502 • Uncoated
- Series 5502TC • TiCN Coated



■ Series 2502/5502 • Machine Screw and Fractional • Bottoming Entry Taper



- first choice
- alternate choice

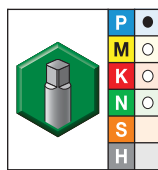
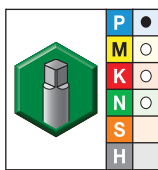
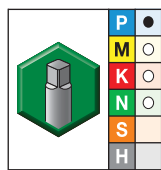
TiCN		TiN		uncoated		inch dimensions					number of lube grooves	pitch diameter limit
order #	catalog #	order #	catalog #	order #	catalog #	D1 size	L	L3	L2	D		
2746547	19500	2746349	19816	2747635	17200	0 - 80	1.63	.31	—	.141	0	H2
—	—	—	—	2747633	17201	0 - 80	1.63	.31	—	.141	0	H3
2746541	19506	2746347	19817	2747623	17206	2 - 56	1.75	.44	—	.141	0	H2
—	—	—	—	2747621	17207	2 - 56	1.75	.44	—	.141	0	H3
—	—	—	—	2747615	17210	3 - 48	1.81	.50	—	.141	0	H2
2746539	19514	2746320	19849	2747609	17214	4 - 40	1.88	.31	.56	.141	0	H3
—	—	—	—	2747607	17215	4 - 40	1.88	.31	.56	.141	0	H5
—	—	2746318	19851	2747601	17218	5 - 40	1.94	.31	.63	.141	4	H3
—	—	—	—	2747600	17219	5 - 40	1.94	.31	.63	.141	4	H5
2746535	19522	2746315	19852	2747598	17222	6 - 32	2.00	.38	.69	.141	4	H3
2746533	19523	2746313	19856	2747595	17223	6 - 32	2.00	.38	.69	.141	4	H5
2746531	19527	2746311	19857	2747588	17227	8 - 32	2.13	.38	.75	.168	4	H3
2746530	19528	2746309	19861	2747584	17228	8 - 32	2.13	.38	.75	.168	4	H5
2746528	19532	2746307	19862	2747576	17232	10 - 24	2.38	.50	.88	.194	4	H4
—	—	—	—	2747574	17233	10 - 24	2.38	.50	.88	.194	4	H6
2746526	19535	2746305	19866	2747569	17235	10 - 32	2.38	.50	.88	.194	4	H4
—	—	—	—	2747568	17236	10 - 32	2.38	.50	.88	.194	4	H6
—	—	—	—	2747566	17238	12 - 24	2.38	.50	.94	.220	4	H4
2746524	19542	2746304	19869	2747561	17242	1/4 - 20	2.50	.63	1.00	.255	4	H4
—	—	—	—	2747559	17243	1/4 - 20	2.50	.63	1.00	.255	4	H6
2746522	19545	2746302	19871	2747554	17245	1/4 - 28	2.50	.63	1.00	.255	4	H4
—	—	2746300	19872	—	—	5/16 - 18	2.72	.69	1.13	.318	4	H5
—	—	—	—	2747547	17249	5/16 - 18	2.72	.69	1.13	.318	4	H7
—	—	—	—	2747549	17248	5/16 - 18	2.72	.69	1.13	.318	4	H5

(continued)

Production Taps

TRU-LEDE™ Forming Taps • Blind Holes in General Machining Applications

(Series 2502/5502 • Machine Screw and Fractional • Bottoming Entry Taper — continued)

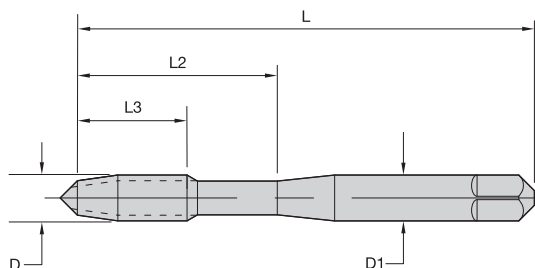
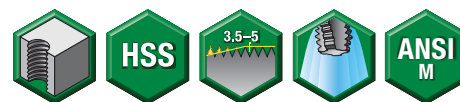


- first choice
- alternate choice

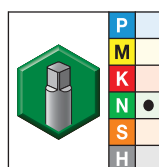
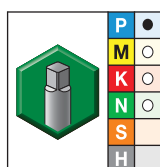
TiCN		TiN		uncoated		inch dimensions					number of lube grooves	pitch diameter limit
order #	catalog #	order #	catalog #	order #	catalog #	D1 size	L	L3	L2	D		
-	-	-	-	2747535	17255	3/8 - 16	2.94	.75	1.25	.381	4	H7
2746516	19554	2746298	19873	2747537	17254	3/8 - 16	2.94	.75	1.25	.381	4	H5
-	-	2746296	19874	2747534	17257	3/8 - 24	2.94	.75	1.25	.381	4	H5
-	-	-	-	2747528	17265	1/2 - 13	3.38	.94	-	.367	4	H8
-	-	2896309	19875	2747530	17264	1/2 - 13	3.38	.94	-	.367	4	H5
-	-	-	-	2747524	17266	1/2 - 20	3.38	.94	-	.367	4	H5
-	-	-	-	2747499	17280	5/8 - 11	3.81	1.09	-	.480	6	H7

NOTE: Form taps require a larger drilled hole size prior to tapping than corresponding cutting taps.
Refer to tables on pages W231–W232 for the recommended pitch diameter limit for 2B or 3B class of fit.

- Series 2510 • TiN Coated
- Series 5510 • Uncoated



■ Series 2510/5510 • Plug Entry Taper • Metric ANSI

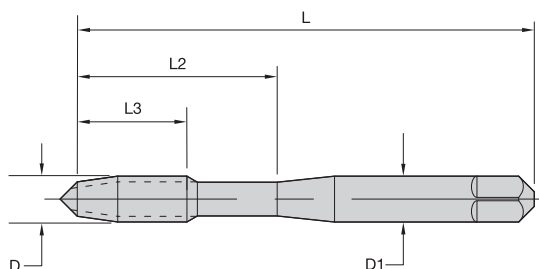
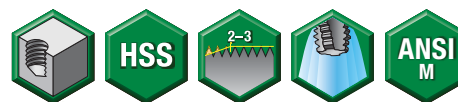


- first choice
- alternate choice

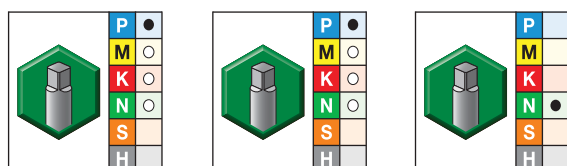
TiN		uncoated		inch dimensions					number of lube grooves	pitch diameter limit
order #	catalog #	order #	catalog #	D1 size	L	L3	L2	D		
2746236	19941	2747866	17082	M3 X 0,5	1.94	.31	.63	.141	4	D5
2746234	19942	2747864	17084	M4 X 0,7	2.13	.38	.75	.168	4	D6
2746232	19943	2747862	17086	M5 X 0,8	2.38	.50	.88	.194	4	D7
2746231	19944	2747860	17087	M6 X 1	2.50	.63	1.00	.255	4	D8
2746229	19945	2747858	17090	M8 X 1,25	2.72	.69	1.13	.318	4	D9
2746227	19946	—	—	M10 X 1,5	2.94	.75	1.25	.381	4	D10
2746225	19947	—	—	M12 X 1,75	3.38	.94	—	.367	4	D11

NOTE: Metric taps are manufactured to USCTI specifications and dimensions.
 Metric tap blank dimensions are equivalent to inch taps.
 Form taps require a larger drilled hole size prior to tapping than corresponding cutting taps.
 Refer to tables on pages W231–W232 for the recommended pitch diameter limit for 6H class of fit.

- Series 2512 • TiN Coated
- Series 5512TC • TiCN Coated
- Series 5512 • Uncoated



Series 2512/5512 • Bottom Entry Taper • Metric ANSI



- first choice
- alternate choice

TiCN		TiN		uncoated		inch dimensions					number of lube grooves	pitch diameter limit
order #	catalog #	order #	catalog #	order #	catalog #	D1 size	L	L3	L2	D		
2746510	19567	2746223	19948	2747522	17267	M3 X 0,5	1.94	.31	.63	.141	4	D5
2746508	19569	2746221	19949	2747518	17269	M4 X 0,7	2.13	.38	.75	.168	4	D6
2746506	19571	2746219	19950	2747515	17271	M5 X 0,8	2.38	.50	.88	.194	4	D7
2746504	19572	2746217	19951	2747513	17272	M6 X 1	2.50	.63	1.00	.255	4	D8
2746502	19574	2746215	19952	2747509	17275	M8 X 1,25	2.72	.69	1.13	.318	4	D9
2746498	19576	2746213	19953	2747505	17276	M10 X 1,5	2.94	.75	1.25	.381	4	D10
-		2746211	19954	2747501	17277	M12 X 1,75	3.38	.94	—	.367	4	D11

NOTE: Metric taps are manufactured to USCTI specifications and dimensions.

Metric tap blank dimensions are equivalent to inch taps.

Form taps require a larger drilled hole size prior to tapping than corresponding cutting taps.

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