

**SHORT MACHINE TAPS****BA**

BS 949 ISO 529

|  |              |               |
|--|--------------|---------------|
|  | <b>Range</b> | <b>Finish</b> |
|--|--------------|---------------|

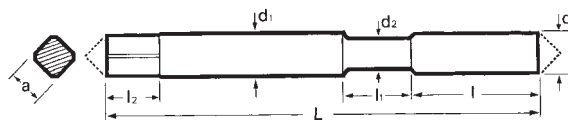
|                       |              |        |
|-----------------------|--------------|--------|
| <b>Straight Flute</b> |              |        |
| <b>60 500</b>         | No. 14-No. 0 | Bright |

|                                 |                |        |
|---------------------------------|----------------|--------|
| <b>Straight Flute Left Hand</b> |                |        |
| <b>60 530</b>                   | No.s. 4, 2, 0. | Bright |

|                     |                            |         |
|---------------------|----------------------------|---------|
| <b>Spiral Point</b> |                            |         |
| <b>60 510</b>       | No. 10-No. 0               | P1 Blue |
| <b>60 518</b>       | Available to special order | Bright  |

|                     |                            |         |
|---------------------|----------------------------|---------|
| <b>Spiral Flute</b> |                            |         |
| <b>60 520</b>       | No. 6-No. 0                | Bright  |
| <b>60 527</b>       | Available to special order | P1 Blue |

Straight Flute Taps are available with – Taper, Second, and Bottoming leads.



| Nominal dia | Basic major dia | Threads per | Thread length max | Overall length | Shank dia         | Square a/f | Recess dia        | Tap drill sizes           | 60 500         | 60 530            | 60 510                   | 60 518       | 60 520       |
|-------------|-----------------|-------------|-------------------|----------------|-------------------|------------|-------------------|---------------------------|----------------|-------------------|--------------------------|--------------|--------------|
| No. d       | mm d            | in          | mm l              | mm L           | mm d <sub>1</sub> | mm a       | mm l <sub>2</sub> | 75% to 80% full thread mm | Straight Flute | Straight Flute LH | Spiral Point             | Spiral Point | Spiral Flute |
|             |                 |             |                   |                |                   |            |                   |                           | Bright         | Bright            | Number of Flutes P1 Blue | Bright       | Bright       |
| 14          | 1.00            | 110.4       | 5.5               | 38.5           | 2.5               | 2.0        | 4                 | 0.8                       | 3              | –                 | –                        | –            | –            |
| 12          | 1.30            | 90.9        | 7                 | 40             | 2.5               | 2.0        | 4                 | 1.05                      | 3              | –                 | –                        | –            | –            |
| 10          | 1.70            | 72.6        | 8                 | 41             | 2.5               | 2.0        | 4                 | 1.40                      | 3              | –                 | 2                        | *            | –            |
| 9           | 1.90            | 65.1        | 8                 | 41             | 2.5               | 2.0        | 4                 | 1.55                      | 3              | –                 | 2                        | *            | –            |
| 8           | 2.20            | 59.1        | 9.5               | 44.5           | 2.8               | 2.24       | 5                 | 1.80                      | 3              | –                 | 2                        | *            | –            |
| 7           | 2.50            | 52.9        | 9.5               | 44.5           | 2.8               | 2.24       | 5                 | 2.05                      | 3              | –                 | 2                        | *            | –            |
| 6           | 2.80            | 47.9        | 9.5               | 44.5           | 2.8               | 2.24       | 5                 | 2.30                      | 3              | –                 | 2                        | *            | 2            |
| 5           | 3.20            | 43.0        | 16                | 48             | 3.15              | 2.5        | 5                 | 2.65                      | 3              | –                 | 3                        | *            | 3            |
| 4           | 3.60            | 38.5        | 19                | 50             | 3.55              | 2.8        | 5                 | 3.00                      | 3              | 3                 | 3                        | *            | 3            |
| 3           | 4.10            | 34.8        | 13                | 53             | 4.5               | 3.55       | 6                 | 3.40                      | 3              | –                 | 3                        | *            | –            |
| 2           | 4.70            | 31.4        | 16                | 58             | 5.0               | 4.0        | 7                 | 4.00                      | 3              | 3                 | 3                        | *            | 3            |
| 1           | 5.30            | 28.2        | 17                | 62             | 5.6               | 4.5        | 7                 | 4.50                      | 3              | –                 | 3                        | *            | –            |
| 0           | 6.00            | 25.4        | 19                | 66             | 6.3               | 5.0        | 8                 | 5.10                      | 3              | 3                 | 3                        | *            | 3            |

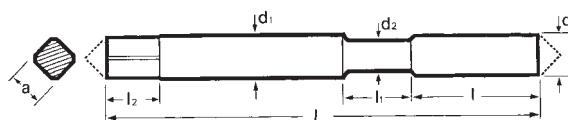
\* Available to Special Order Minimum quantities apply

**SHORT MACHINE TAPS****BS BRASS**

BS 949 ISO 529

|  |              |               |
|--|--------------|---------------|
|  | <b>Range</b> | <b>Finish</b> |
|--|--------------|---------------|

|                       |         |        |
|-----------------------|---------|--------|
| <b>Straight Flute</b> |         |        |
| <b>60 580</b>         | 1/4"-1" | Bright |



Straight Flute Taps are available with – Taper, Second, and Bottoming leads.

| Nominal dia | Threads per | Thread length | Overall length | Shank dia         | Square a/f | Recess dia        | Tap drill sizes           | 60 580                           | 60 580                           | 60 580                           |
|-------------|-------------|---------------|----------------|-------------------|------------|-------------------|---------------------------|----------------------------------|----------------------------------|----------------------------------|
| in d        | in          | mm l          | mm L           | mm d <sub>1</sub> | mm a       | mm l <sub>2</sub> | 75% to 80% full thread mm | Taper Lead                       | Second Lead                      | Bottoming Lead                   |
|             |             |               |                |                   |            |                   |                           | Number of Straight Flutes Bright | Number of Straight Flutes Bright | Number of Straight Flutes Bright |
| **1/4       | 26          | 19            | 66             | 6.3               | 5.0        | 8                 | 4.50                      | 3                                | 3                                | 3                                |
| 5/16        | 26          | 22            | 72             | 8.0               | 6.3        | 9                 | 6.00                      | 3                                | 3                                | 3                                |
| 3/8         | 26          | 24            | 80             | 10.0              | 8.0        | 11                | 7.50                      | 4                                | 4                                | 4                                |
| 7/16        | 26          | 25            | 85             | 8.0               | 6.3        | 9                 | –                         | 4                                | 4                                | 4                                |
| 1/2         | 26          | 29            | 89             | 9.0               | 7.1        | 10                | –                         | 4                                | 4                                | 4                                |
| 9/16        | 26          | 30            | 95             | 11.2              | 9.0        | 12                | –                         | 4                                | 4                                | 4                                |
| 5/8         | 26          | 32            | 102            | 12.5              | 10.0       | 13                | –                         | 4                                | 4                                | 4                                |
| 3/4         | 26          | 37            | 112            | 14.0              | 11.2       | 14                | –                         | 4                                | 4                                | 4                                |
| 7/8         | 26          | 38            | 118            | 16.0              | 12.5       | 16                | –                         | 4                                | 4                                | 4                                |
| 1           | 26          | 45            | 130            | 18.0              | 14.0       | 18                | –                         | 4                                | 4                                | 4                                |

\*\* 1/4in BRASS thread is identical to 1/4in BSF.