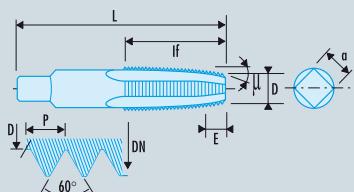


Workshop drill bits, taps and dies

Taps



Tap selection guide



- Ground-thread backed-off taps.
- ISO metric RH thread.
- 6H machining.
- Set of 2 (ref. T2) for soft metals : 1 taper tap, 1 bottoming tap.
- Set of 3 (ref. T3) for hard metals : 1 taper tap, 1 second tap, 1 bottoming tap.

Max. hardness : 70 daN/mm² :
 - for taps 227 and 80 daN/mm²
 - for taps 227.S.

Types	D	E
Second	= 6 P	6°
Bottoming DN - 1.2p.	= 3.5 P	9°
Bottoming 18°	= 2 P	18°

227 Standard taps

▷ ISO 2857, ISO 529; NF ISO 529, NF EN 22857.

227.T3 Set of 3 taps : taper, second and bottoming.

227.T2 Set of 2 taps : taper and bottoming.

• HSS steel.

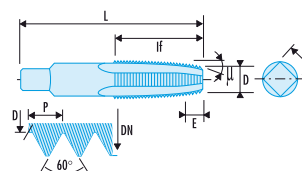
	Taps	DN mm	a mm	P mm	L mm	ΔΔ g
227.3X50T3	x3	3	2,50	0,50	48	17
227.4X70T3	x3	4	3,15	0,70	53	23
227.5X80T3	x3	5	4	0,80	58	37
227.6X100T3	x3	6	5	1	66	50
227.7X100T3	x3	7	5,6	1	66	61
227.8X125T3	x3	8	6,3	1,25	72	83
227.9X125T3	x3	9	7,1	1,25	72	98
227.10X150T3	x3	10	8	1,50	80	137
227.12X175T3	x3	12	7,1	1,75	89	147
227.14X200T3	x3	14	9	2	95	242
227.16X200T3	x3	16	10	2	102	306
227.3X50T2	x2	3	2,5	0,50	48	5
227.4X70T2	x2	4	3,15	0,70	53	8
227.5X80T2	x2	5	4	0,80	58	15
227.6X100T2	x2	6	5	1	66	23
227.8X125T2	x2	8	6,3	1,25	72	42
227.10X150T2	x2	10	8	1,50	80	72
227.12X175T2	x2	12	7,1	1,75	89	79



227.T3



227.T2



Dies

221 Split dies

▷ ISO 261, DIN ISO 261, NF ISO 261.

- ISO metric RH thread.
- Chrome-vanadium HSS hardened to 62/64 HRC (234 daN/mm²).
- Tapered adjusting screw

	DN mm	e mm	P mm	Ø mm	h mm	ΔΔ g
221.4X70	4	8	0,70	25,4	3,5	27
221.5X80	5	8	0,80	25,4	3,5	29
221.6X100	6	9	1	25,4	3,5	29
221.8X125	8	9	1,25	25,4	3,5	30
221.9X125	9	9	1,25	25,4	3,5	30
221.10X150	10	13	1,50	38,1	6	79
221.12X175	12	13	1,75	38,1	6	89
221.14X200	14	13	2	38,1	6	79
221.16X200	16	13	2	38,1	6	74
221.18X250	18	15	2,50	38,1	8	75

