

E524 HSS UNF Taps Straight Flute



ISO 529  
**Tap tolerance:** Class 2 for 2B fit  
**Chamfer thread numbers:** 1, 2 and 3  
**Cutting rake:** 7°  
**Flute geometry** Straight flutes  
**Surface treatment:** Bright  
**Range:** No 4 - No 10, 1/4 - 1 in  
**Application:** For hand or machine tapping of through or blind holes.

494089

| Size x    | Cutter   | Overall    | Flute      | Shank    | Square  |        | Price<br>Each |
|-----------|----------|------------|------------|----------|---------|--------|---------------|
| Pitch(mm) | Dia.(mm) | Length(mm) | Length(mm) | Dia.(mm) | A/F(mm) | Type   | Order Code    |
| 4 x 48    | 2.845    | 48.0       | 12.5       | 3.15     | 2.5     | Plug   | 022-204       |
| 5 x 44    | 3.175    | 48.0       | 12.5       | 3.15     | 2.5     | Second | 022-205       |
| 6 x 40    | 3.505    | 50.0       | 14.0       | 3.55     | 2.8     | Second | 022-207       |
| 6 x 40    | 3.505    | 50.0       | 14.0       | 3.55     | 2.8     | Plug   | 022-208       |
| 8 x 36    | 4.166    | 53.0       | 9.5        | 4.50     | 3.55    | Second | 022-209       |
| 8 x 36    | 4.166    | 53.0       | 9.5        | 4.50     | 3.55    | Plug   | 022-210       |
| 10 x 32   | 4.826    | 58.0       | 11.0       | 5.00     | 4       | Set 2  | 148-5373      |
| 10 x 32   | 4.826    | 58.0       | 11.0       | 5.00     | 4       | Taper  | 147-4105      |
| 10 x 32   | 4.826    | 58.0       | 11.0       | 5.00     | 4       | Second | 147-4106      |
| 10 x 32   | 4.826    | 58.0       | 11.0       | 5.00     | 4       | Plug   | 147-4107      |
| ¼ x 28    | 6.350    | 66.0       | 13.0       | 6.30     | 5       | Set 3  | 148-5375      |
| ¼ x 28    | 6.350    | 66.0       | 13.0       | 6.30     | 05      | Taper  | 147-4109      |
| ¼ x 28    | 6.350    | 66.0       | 13.0       | 6.30     | 5.00    | Second | 147-4111      |
| ¼ x 28    | 6.350    | 66.0       | 13.0       | 6.30     | 5.00    | Plug   | 147-4112      |
| ⅝ x 24    | 7.938    | 72.0       | 16.0       | 8.00     | 6.30    | Set 3  | 148-5376      |
| ⅝ x 24    | 7.938    | 72.0       | 16.0       | 8.00     | 6.30    | Taper  | 147-4113      |
| ⅝ x 24    | 7.938    | 72.0       | 16.0       | 8.00     | 6.30    | Second | 147-4114      |
| ⅝ x 24    | 7.938    | 72.0       | 16.0       | 8.00     | 6.30    | Plug   | 147-4115      |
| ¾ x 24    | 9.525    | 80.0       | 18.0       | 10.00    | 8.00    | Set 3  | 705-4919      |
| ¾ x 24    | 9.525    | 80.0       | 18.0       | 10.00    | 8.00    | Taper  | 147-4116      |
| ¾ x 24    | 9.525    | 80.0       | 18.0       | 10.00    | 8.00    | Second | 147-4117      |
| ¾ x 24    | 9.525    | 80.0       | 18.0       | 10.00    | 8.00    | Plug   | 147-4118      |
| 7/16 x 20 | 11.112   | 85.0       | 19.0       | 8.00     | 6.30    | Set 3  | 148-5377      |
| 7/16 x 20 | 11.112   | 85.0       | 19.0       | 8.00     | 6.30    | Taper  | 147-4119      |
| 7/16 x 20 | 11.112   | 85.0       | 19.0       | 8.00     | 6.30    | Second | 147-4120      |
| 7/16 x 20 | 11.112   | 85.0       | 19.0       | 8.00     | 6.30    | Plug   | 147-4122      |
| ½ x 20    | 12.700   | 89.0       | 22.0       | 9.00     | 7.10    | Set 3  | 148-5378      |
| ½ x 20    | 12.700   | 89.0       | 22.0       | 9.00     | 7.10    | Taper  | 147-4123      |
| ½ x 20    | 12.700   | 89.0       | 22.0       | 9.00     | 7.10    | Second | 147-4124      |
| ½ x 20    | 12.700   | 89.0       | 22.0       | 9.00     | 7.10    | Plug   | 147-4125      |
| ⅞ x 18    | 14.288   | 95.0       | 24.0       | 11.20    | 9.00    | Set 3  | 148-5379      |
| ⅞ x 18    | 14.288   | 95.0       | 24.0       | 11.20    | 9.00    | Taper  | 147-4126      |
| ⅞ x 18    | 14.288   | 95.0       | 24.0       | 11.20    | 9.00    | Second | 147-4127      |
| ⅞ x 18    | 14.288   | 95.0       | 24.0       | 11.20    | 9.00    | Plug   | 147-4128      |
| ⅞ x 18    | 15.875   | 102.0      | 24.0       | 12.50    | 10.00   | Set 3  | 148-5380      |
| ⅞ x 18    | 15.875   | 102.0      | 24.0       | 12.50    | 10.00   | Taper  | 147-4129      |
| ⅞ x 18    | 15.875   | 102.0      | 24.0       | 12.50    | 10.00   | Second | 147-4130      |
| ⅞ x 18    | 15.875   | 102.0      | 24.0       | 12.50    | 10.00   | Plug   | 147-4131      |
| ¾ x 16    | 19.050   | 112.0      | 29.0       | 14.00    | 11.20   | Set 3  | 148-8967      |
| ¾ x 16    | 19.050   | 112.0      | 29.0       | 14.00    | 11.20   | Taper  | 147-4132      |
| ¾ x 16    | 19.050   | 112.0      | 29.0       | 14.00    | 11.20   | Second | 147-4134      |
| ¾ x 16    | 19.050   | 112.0      | 29.0       | 14.00    | 11.20   | Plug   | 147-4135      |
| 7/8 x 14  | 22.225   | 118.0      | 29.0       | 16.00    | 12.50   | Set 3  | 148-5381      |
| 7/8 x 14  | 22.225   | 118.0      | 29.0       | 16.00    | 12.50   | Taper  | 147-4136      |
| 7/8 x 14  | 22.225   | 118.0      | 29.0       | 16.00    | 12.50   | Second | 147-4137      |
| 7/8 x 14  | 22.225   | 118.0      | 29.0       | 16.00    | 12.50   | Plug   | 147-4138      |
| 1 x 12    | 25.400   | 130.0      | 35.0       | 18.00    | 14.00   | Set 3  | 148-5382      |