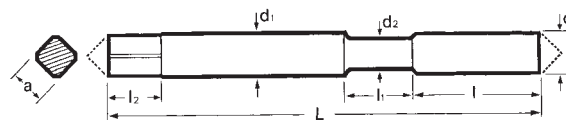


SHORT MACHINE TAPS**Metric Coarse**

BS 949 ISO 529

	Range	Tap Tolerance	Finish
Straight Flute			
60 000	M1-M60	Class 2 for 6H fit	Bright
60 007	M1-M60	Class 2 for 6H fit	P1 Blue
60 005	M3-M16	Class 2 for 6H fit	TiN
Straight Flute Left Hand			
60 030	M3-M24	Class 2 for 6H fit	Bright

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

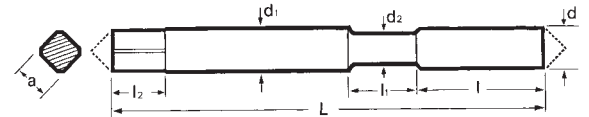


Nominal dia	Pitch	Thread length max	Overall length	Shank dia	Square a/f	Square length	Recess dia	Recess length	Tap drill size 75% to 80% full thread	60 000 Straight Flute Number of Flutes Bright	60 007 Straight Flute P1 Blue	60 005 Straight Flute TiN	60 030 Straight Flute Left H'nd Bright
mm d	mm	mm l	mm L	mm d ₁	mm a	mm l ₂	mm d ₂	mm l ₁	mm				
M1	0.25	5.5	38.5	2.5	2.0	4	–	4.5	0.75	3	3	*	–
M1.2	0.25	5.5	38.5	2.5	2.0	4	–	4.5	0.95	3	3	*	–
M1.4	0.3	7	40	2.5	2.0	4	–	5	1.10	3	3	*	–
M1.6	0.35	8	41	2.5	2.0	4	–	5	1.25	3	3	*	–
M2	0.4	8	41	2.5	2.0	4	–	5.5	1.60	3	3	*	–
M2.5	0.45	9.5	44.5	2.8	2.24	5	–	6	2.05	3	3	*	–
M3	0.5	16	48	3.15	2.5	5	–	–	2.50	3	3	3	3
M3.5	0.6	19	50	3.55	2.8	5	–	–	2.90	3	3	3	–
M4	0.7	13	53	4.0	3.15	6	2.80	8	3.30	3	3	3	3
M4.5	0.75	13	53	4.5	3.55	6	3.15	8	3.70	3	3	3	–
M5	0.8	16	58	5.0	4.0	7	3.55	9	4.20	3	3	3	3
M6	1.0	19	66	6.3	5.0	8	4.50	11	5.00	3	3	3	3
M7	1.0	19	66	7.1	5.6	8	5.30	11	6.00	3	3	3	–
M8	1.25	22	72	8.0	6.3	9	6.00	13	6.80	3	3	3	3
M9	1.25	22	72	9.0	7.1	10	7.10	14	7.80	3	3	3	–
M10	1.5	24	80	10.0	8.0	11	7.50	15	8.50	4	4	4	4
M11	1.5	25	85	8.0	6.3	9			9.50	4	4	4	–
M12	1.75	29	89	9.0	7.1	10			10.20	4	4	4	4
M14	2.0	30	95	11.2	9.0	12			12.00	4	4	4	4
M16	2.0	32	102	12.5	10.0	13			14.00	4	4	4	4
M18	2.5	37	112	14.0	11.2	14			15.50	4	4	*	4
M20	2.5	37	112	14.0	11.2	14			17.50	4	4	*	4
M22	2.5	38	118	16.0	12.5	16			19.50	4	4	*	4
M24	3.0	45	130	18.0	14.0	18			21.00	4	4	*	4
M27	3.0	45	135	20.0	16.0	20			24.00	4	4	*	–
M30	3.5	48	138	20.0	16.0	20			26.50	4	4	*	–
M33	3.5	51	151	22.4	18.0	22			29.50	4	4	*	–
M36	4.0	57	162	25.0	20.0	24			32.00	4	4	*	–
M39	4.0	60	170	28.0	22.4	26			35.00	6	6	*	–
M42	4.5	60	170	28.0	22.4	26			37.50	6	6	*	–
M45	4.5	67	187	31.5	25.0	28			40.50	6	6	*	–
M48	5.0	67	187	31.5	25.0	28			43.00	6	6	*	–
M52	5.0	70	200	35.5	28.0	31			47.00	6	6	*	–
M56	5.5	70	200	35.5	28.0	31			50.50	6	6	*	–
M60	5.5	76	221	40.0	31.5	34			54.50	6	6	*	–

SHORT MACHINE TAPS**Metric Coarse**

BS 949 ISO 529

	Range	Tap Tolerance	Finish
Spiral Point			
60 010	M1-M30	Class 2 for 6H fit	P1 Blue
60 018	M3-M16	Class 2 for 6H fit	Bright
60 015	M3-M16	Class 2 for 6H fit	TiN
Spiral Flute			
60 020	M2-M30	Class 2 for 6H fit	Bright
60 027	M2-M30	Class 2 for 6H fit	P1 Blue
60 025	M3-M16	Class 2 for 6H fit	TiN



Nom dia	Pitch	Thread length max	Overall length	Shank dia	Square a/f	length	Recess dia	length	Tap drill sizes 75% to 80% full thread	60 010	60 018	60 015	60 020	60 027	60 025
mm d	mm d	mm l	mm L	mm d ₁	mm a	mm l ₂	mm d ₂	mm l ₁	mm	Spiral point Number of Flutes	Spiral Point Number of Flutes	Spiral Point Number of Flutes	Spiral Flute Number of Flutes	P1 Blue	TiN
M1	0.25	5.5	38.5	2.5	2.0	4	—	4.5	0.75	2	*	*	—	—	—
M1.2	0.25	5.5	38.5	2.5	2.0	4	—	4.5	0.95	2	*	*	—	—	—
M1.4	0.3	7	40	2.5	2.0	4	—	5	1.10	2	*	*	—	—	—
M1.6	0.35	8	41	2.5	2.0	4	—	5	1.25	2	*	*	—	—	—
M2	0.4	8	41	2.5	2.0	4	—	5.5	1.60	2	*	*	2	2	*
M2.5	0.45	9.5	44.5	2.8	2.24	5	—	6	2.05	2	*	*	2	2	*
M3	0.5	16	48	3.15	2.5	5	—	—	2.50	3	3	3	3	3	3
M3.5	0.6	19	50	3.55	2.8	5	—	—	2.90	3	3	3	3	3	*
M4	0.7	13	53	4.0	3.15	6	2.80	8	3.30	3	3	3	3	3	3
M5	0.8	16	58	5.0	4.0	7	3.55	9	4.20	3	3	3	3	3	3
M6	1.0	19	66	6.3	5.0	8	4.50	11	5.00	3	3	3	3	3	3
M7	1.0	19	66	7.1	5.6	8	5.30	11	6.00	3	3	3	3	3	3
M8	1.25	22	72	8.0	6.3	9	6.00	13	6.80	3	3	3	3	3	3
M10	1.5	24	80	10.0	8.0	11	7.50	15	8.50	3	3	3	3	3	3
M12	1.75	29	89	9.0	7.1	10			10.20	3	3	3	3	3	3
M14	2.0	30	95	11.2	9.0	12			12.00	3	3	3	3	3	3
M16	2.0	32	102	12.5	10.0	13			14.00	3	3	3	4	4	4
M18	2.5	37	112	14.0	11.2	14			15.50	4	*	*	4	4	*
M20	2.5	37	112	14.0	11.2	14			17.50	4	*	*	4	4	*
M22	2.5	38	118	16.0	12.5	16			19.50	4	*	*	4	4	*
M24	3.0	45	130	18.0	14.0	18			21.00	4	*	*	4	4	*
M27	3.0	45	135	20.0	16.0	20			24.00	4	*	*	4	4	*
M30	3.5	48	138	20.0	16.0	20			26.50	4	*	*	4	4	*