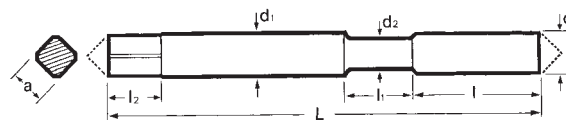


SHORT MACHINE TAPS**Metric Coarse**

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.

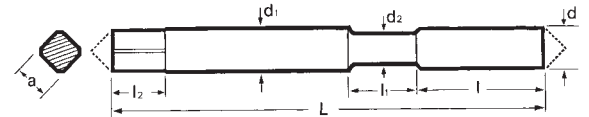


Nominal dia	Pitch	Thread length max	Overall length	Shank dia	Square a/f	Square length	Recess dia	Recess length	Tap drill size 75% to 80% full thread	60 000 Straight Flute Number of Flutes Bright	60 007 Straight Flute P1 Blue	60 005 Straight Flute TiN	60 030 Straight Flute Left H'nd Bright
mm d	mm	mm 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	Recess length	Tap drill sizes	60 010	60 018	60 015	60 020	60 027	60 025
							75% to 80% full thread	Spiral point	Spiral point	Spiral Point	Spiral	Flute	Sp Flute
mm d	mm d	mm l	mm L	mm d ₁	mm a	mm l ₂	mm	Number of Flutes	Number of Flutes	Number of Flutes	Number of Flutes	Number of Flutes	Number of Flutes
							mm	P1 Blue	Bright	TiN	Bright	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
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
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	3
M8	1.25	22	72	8.0	6.3	9	6.00	13	6.80	3	3	3	3
M10	1.5	24	80	10.0	8.0	11	7.50	15	8.50	3	3	3	3
M12	1.75	29	89	9.0	7.1	10			10.20	3	3	3	3
M14	2.0	30	95	11.2	9.0	12			12.00	3	3	3	3
M16	2.0	32	102	12.5	10.0	13			14.00	3	3	4	4
M18	2.5	37	112	14.0	11.2	14			15.50	4	*	4	*
M20	2.5	37	112	14.0	11.2	14			17.50	4	*	4	*
M22	2.5	38	118	16.0	12.5	16			19.50	4	*	4	*
M24	3.0	45	130	18.0	14.0	18			21.00	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	*