



## THREADING TAPS

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# MANUFACTURING AND TESTING EQUIPMENT

**DiCTOOLS**

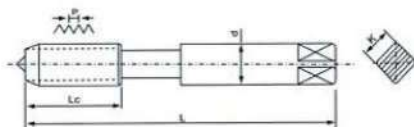
Quality Tooling Solutions (an ISO 9001 : 2015 Co.)

**Dedicated Impex company**



## GB(ISO)TAPS WITH ENFORCED SHANK

Conform to GB/T3464.1-94, equal to ISO529-1975  
M2 HSS  
For manual and machine  
For through holes or blind holes



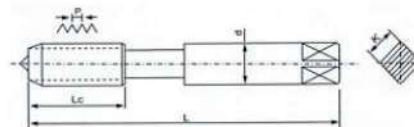
Material: High Speed Steel Alloy Steel

### TECHNICAL PARAMETER

M	P(mm)	L(mm)	Lc(mm)	d(mm)	K(mm)	Hole(mm)	Tap limits
M3	0.5	48	11	2.24	1.8	2.5	H1 H2 H3
M4	0.7	53	13	3.15	2.5	3.3	H1 H2 H3
M5	0.8	58	16	4.0	3.15	4.2	H1 H2 H3
M6	1.0	66	19	4.5	3.55	5.0	H1 H2 H3
M6x0.75	0.75	66	19	4.5	3.55	5.25	H1 H2 H3
M8	1.25	72	22	6.3	5.0	6.7	H1 H2 H3
M8x1.0	1.0	72	22	6.3	5.0	7.0	H1 H2 H3
M10	1.5	80	24	8.0	6.3	8.5	H1 H2 H3
M10x1.25	1.25	80	24	8.0	6.3	8.75	H1 H2 H3
M10x1.0	1.0	80	24	8.0	6.3	9.0	H1 H2 H3
M12	1.75	80	29	9.0	7.1	10.25	H1 H2 H3
M12x1.25	1.25	80	29	9.0	7.1	10.75	H1 H2 H3
M12x1.0	1.0	80	22	9.0	7.1	11.0	H1 H2 H3
M14	2.0	95	30	11.2	9.0	12.0	H1 H2 H3
M14x1.5	1.5	95	30	11.2	9.0	12.5	H1 H2 H3
M14x1.0	1.0	87	22	11.2	9.0	13.0	H1 H2 H3
M16	2.0	102	32	12.5	10	14.0	H1 H2 H3
M16x1.5	1.5	102	32	12.5	10	14.5	H1 H2 H3
M16x1.0	1.0	92	22	12.5	10	15.0	H1 H2 H3
M18	2.5	112	37	14	11.2	15.5	H1 H2 H3
M18x1.5	1.5	112	37	14	11.2	16.5	H1 H2 H3
M18x1.0	1.0	97	22	14	11.2	17.0	H1 H2 H3
M20	2.5	112	37	14	11.2	17.5	H1 H2 H3
M20x2.0	2.0	112	37	14	11.2	18.0	H1 H2 H3
M20x1.5	1.5	112	37	14	11.2	15.5	H1 H2 H3
M20x1.0	1.0	102	22	14	11.2	19.0	H1 H2 H3
M22	2.5	118	38	16	12.5	19.5	H1 H2 H3
M22x2.0	2.0	118	38	16	12.5	20.0	H1 H2 H3
M22x1.5	1.5	118	38	16	12.5	20.5	H1 H2 H3
M22x1.0	1.0	109	24	16	12.5	21.0	H1 H2 H3

## GB(ISO)TAPS WITH ENFORCED SHANK

Conform to GB/T3464.1-94, equal to ISO529-1975  
M2 HSS  
For manual and machine  
For through holes or blind holes



Material: High Speed Steel Alloy Steel

### TECHNICAL PARAMETER

M	P(mm)	L(mm)	Lc(mm)	d(mm)	K(mm)	Hole(mm)	Tap limits
M24	3.0	130	45	18	14	21.0	H1 H2 H3
M24x2.0	2.0	130	45	18	14	22.0	H1 H2 H3
M24x1.5	1.5	130	45	18	14	22.5	H1 H2 H3
M24x1.0	1.0	114	24	18	14	23.0	H1 H2 H3
M27	3.0	125	25	20	16	24.0	H1 H2 H3
M27x2.0	2.0	127	37	20	16	25.0	H1 H2 H3
M30	3.5	128	37	20	16	26.0	H1 H2 H3
M30x2.0	2.0	127	48	20	16	28.0	H1 H2 H3
M30x1.5	1.5	127	37	20	16	28.5	H1 H2 H3
M32x1.5	1.5	137	37	22.4	18	30.5	H1 H2 H3
M33	3.5	151	51	22.4	18	29.5	H1 H2 H3
M35x1.5	1.5	144	39	25	20	33.5	H1 H2 H3
M36	4.0	162	57	25	20	32.0	H1 H2 H3
M36x1.5	1.5	144	39	25	20	34.5	H1 H2 H3
M39	4.0	170	60	28	22.4	35.0	H1 H2 H3
M40x1.5	1.5	149	39	28	22.4	38.5	H1 H2 H3
M42	4.5	170	60	28	22.4	37.5	H1 H2 H3
M42x1.5	1.5	149	39	28	22.4	40.5	H1 H2 H3
M45	4.5	187	67	31.5	25	40.5	H1 H2 H3
M45x1.5	1.5	165	45	28	22.4	43.5	H1 H2 H3
M48	5.0	187	67	31.5	25	43.0	H1 H2 H3
M48x1.5	1.5	165	45	31.5	25	46.5	H1 H2 H3
M50x1.5	1.5	165	45	31.5	25	48.5	H1 H2 H3
M52	5.0	200	70	35.5	28	47.0	H1 H2 H3
M52x1.5	1.5	175	45	35.5	28	50.5	H1 H2 H3

Up to M6: With male center

P 2.5mm: Both one piece and of set are available

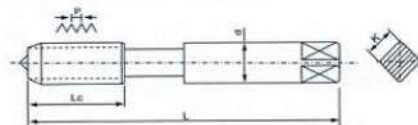
One piece with chamfer of 3.5P, 2P

3 of set with chamfers 8P, 4P, 2P

P 2.5mm: 3 of set with chamfers 8P, 4P, 2P are available

## SPIRAL FLUTEA TOP WITH STRAIGHT SHANK

Conform to GB/T3464.1-94,equal to ISO527-1975  
 M2 HSS  
 M35 HSS-E,Coatings,available for specified requirements  
 For machine  
 For through holes  
 Good cutting action,high speeding



Material:High Speed Steel

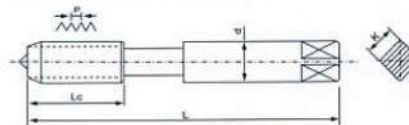


### TECHNICAL PARAMETER

M	P(mm)	L(mm)	Lc(mm)	d(mm)	K(mm)	Hole(mm)	Tap limits
M3	0.5	48	11	2.24	1.8	2.5	H1 H2 H3
M4	0.7	53	13	3.15	2.5	3.3	H1 H2 H3
M5	0.8	58	16	4.0	3.15	4.2	H1 H2 H3
M6	1.0	66	19	4.5	3.55	5.0	H1 H2 H3
M6x0.75	0.75	66	19	4.5	3.55	5.25	H1 H2 H3
M8	1.25	72	22	6.3	5.0	6.7	H1 H2 H3
M8x1.0	1.0	72	22	6.3	5.0	7.0	H1 H2 H3
M10	1.5	80	24	8.0	6.3	8.5	H1 H2 H3
M10x1.25	1.25	80	24	8.0	6.3	8.75	H1 H2 H3
M10x1.0	1.0	80	24	8.0	6.3	9.0	H1 H2 H3
M12	1.75	89	29	9.0	7.1	10.25	H1 H2 H3
M12x1.5	1.5	89	29	9.0	7.1	10.5	H1 H2 H3
M12x1.0	1.0	80	22	9.0	7.1	11.0	H1 H2 H3
M14	2.0	95	30	11.2	9.0	12.0	H1 H2 H3
M14x1.5	1.5	95	30	11.2	9.0	12.5	H1 H2 H3
M14x1.0	1.0	87	22	11.2	9.0	13.0	H1 H2 H3
M16	2.0	102	32	12.5	10	14.0	H1 H2 H3

## SPIRAL FLUTEA TOP WITH STRAIGHT SHANK

Conform to GB/T3464.1-94,equal to ISO527-1975  
 M2 HSS  
 M35 HSS-E,Coatings,available for specified requirements  
 For machine  
 For through holes  
 Good cutting action,high speeding



Material:High Speed Steel Alloy Steel



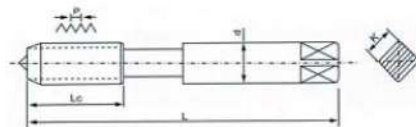
### TECHNICAL PARAMETER

M	P(mm)	L(mm)	Lc(mm)	d(mm)	K(mm)	Hole(mm)	Tap limits
M16x1.5	1.5	102	32	12.5	10	14.5	H1 H2 H3
M16x1.0	1.0	92	22	12.5	10	15.0	H1 H2 H3
M18	2.5	112	37	14	11.2	15.5	H1 H2 H3
M18x1.5	1.5	112	37	14	11.2	16.5	H1 H2 H3
M18x1.0	1.0	97	22	14	11.2	17.0	H1 H2 H3
M20	2.5	112	37	14	11.2	17.5	H1 H2 H3
M20x2.2	2.0	112	37	14	11.2	18.0	H1 H2 H3
M20x1.5	1.5	112	37	14	11.2	18.5	H1 H2 H3
M20x1.0	1.0	102	22			19.0	H1 H2 H3
M22	2.5	118	38	16	12.5	19.5	H1 H2 H3
M22x2.0	2.0	118	38	16	12.5	20.0	H1 H2 H3
M22x1.5	1.5	118	38	16	12.5	20.5	H1 H2 H3
M22x1.0	1.0	109	24	16	12.5	21.0	H1 H2 H3
M24	3.0	130	45	18	14	21.0	H1 H2 H3
M24x2.0	2.0	130	45	18	14	22.0	H1 H2 H3
M24x1.5	1.5	130	45	18	14	22.5	H1 H2 H3
M24x1.0	1.0	114	24	18	14	23.0	H1 H2 H3

Up to M6:With male center

## SPIRAL POINTED TAPS WITH STRAIGHT SHANK

Conform to GB/T3464.1-94,equal to ISO529-1975  
 M2 HSS  
 M35 HSS-E,Coatings,available for specified requirements  
 For machine  
 For through holes  
 Good cutting action,high speeding



Material:High Speed Steel

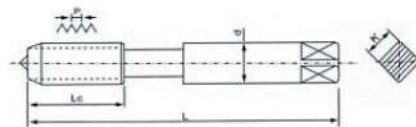


### TECHNICAL PARAMETER

M	P(mm)	L(mm)	Lc(mm)	d(mm)	K(mm)	Hole(mm)	Tap limits
M3	0.5	48	11	2.24	1.8	2.5	H1 H2 H3
M4	0.7	53	13	3.15	2.5	3.3	H1 H2 H3
M5	0.8	58	16	4.0	3.15	4.2	H1 H2 H3
M6	1.0	66	19	4.5	3.55	5.0	H1 H2 H3
M6x0.75	0.75	66	19	4.5	3.55	5.25	H1 H2 H3
M8	1.25	72	22	6.3	5.0	6.7	H1 H2 H3
M8x1.0	1.0	72	22	6.3	5.0	7.0	H1 H2 H3
M10	1.5	80	24	8.0	6.3	8.5	H1 H2 H3
M10x1.25	1.25	80	24	8.0	6.3	8.75	H1 H2 H3
M10x1.0	1.0	80	24	8.0	6.3	9.0	H1 H2 H3
M12	1.75	89	29	9.0	7.1	10.25	H1 H2 H3
M12x1.5	1.5	89	29	9.0	7.1	10.5	H1 H2 H3
M12x1.0	1.0	80	22	9.0	7.1	11.0	H1 H2 H3
M14	2.0	95	30	11.2	9.0	12.0	H1 H2 H3
M14x1.5	1.5	95	30	11.2	9.0	12.5	H1 H2 H3
M14x1.0	1.0	87	22	11.2	9.0	13.0	H1 H2 H3
M16	2.0	102	32	12.5	10	14.0	H1 H2 H3

## SPIRAL POINTED TAPS WITH STRAIGHT SHANK

Conform to GB/T3464.1-94,equal to ISO529-1975  
 M2 HSS  
 M35 HSS-E,Coatings,available for specified requirements  
 For machine  
 For through holes  
 Good cutting action,high speeding



Material:High Speed Steel



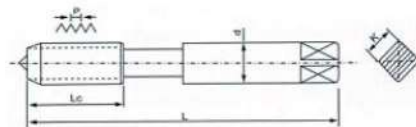
### TECHNICAL PARAMETER

M	P(mm)	L(mm)	Lc(mm)	d(mm)	K(mm)	Hole(mm)	Tap limits
M16x1.5	1.5	102	32	12.5	10	14.5	H1 H2 H3
M16x1.0	1.0	92	22	12.5	10	15.0	H1 H2 H3
M18	2.5	112	37	14	11.2	15.5	H1 H2 H3
M18x1.5	1.5	112	37	14	11.2	16.5	H1 H2 H3
M18x1.0	1.0	97	22	14	11.2	17.0	H1 H2 H3
M20	2.5	112	37	14	11.2	17.5	H1 H2 H3
M20x2.2	2.0	112	37	14	11.2	18.0	H1 H2 H3
M20x1.5	1.5	112	37	14	11.2	18.5	H1 H2 H3
M20x1.0	1.0	102	22			19.0	H1 H2 H3
M22	2.5	118	38	16	12.5	19.5	H1 H2 H3
M22x2.0	2.0	118	38	16	12.5	20.0	H1 H2 H3
M22x1.5	1.5	118	38	16	12.5	20.5	H1 H2 H3
M22x1.0	1.0	109	24	16	12.5	21.0	H1 H2 H3
M24	3.0	130	45	18	14	21.0	H1 H2 H3
M24x2.0	2.0	130	45	18	14	22.0	H1 H2 H3
M24x1.5	1.5	130	45	18	14	22.5	H1 H2 H3
M24x1.0	1.0	114	24	18	14	23.0	H1 H2 H3

Up to M6:With male center

## EXTRUSION TAPS

Conform to GB/T3464.1-94, equal to ISO529-1975  
 M2 HSS  
 M35 HSS-E, Coatings, available for specified requirements  
 For machine  
 For through holes  
 Good cutting action, high speeding



Material: High Speed Steel

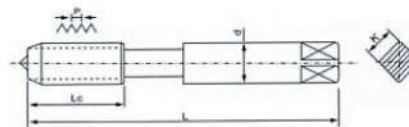


### TECHNICAL PARAMETER

M	P(mm)	L(mm)	Lc(mm)	d(mm)	K(mm)	Hole(mm)	Tap limits
M3	0.5	48	11	2.24	1.8	2.5	H1 H2 H3
M4	0.7	53	13	3.15	2.5	3.3	H1 H2 H3
M5	0.8	58	16	4.0	3.15	4.2	H1 H2 H3
M6	1.0	66	19	4.5	3.55	5.0	H1 H2 H3
M6x0.75	0.75	66	19	4.5	3.55	5.25	H1 H2 H3
M8	1.25	72	22	6.3	5.0	6.7	H1 H2 H3
M8x1.0	1.0	72	22	6.3	5.0	7.0	H1 H2 H3
M10	1.5	80	24	8.0	6.3	8.5	H1 H2 H3
M10x1.25	1.25	80	24	8.0	6.3	8.75	H1 H2 H3
M10x1.0	1.0	80	24	8.0	6.3	9.0	H1 H2 H3
M12	1.75	89	29	9.0	7.1	10.25	H1 H2 H3
M12x1.5	1.5	89	29	9.0	7.1	10.5	H1 H2 H3
M12x1.0	1.0	80	22	9.0	7.1	11.0	H1 H2 H3
M14	2.0	95	30	11.2	9.0	12.0	H1 H2 H3
M14x1.5	1.5	95	30	11.2	9.0	12.5	H1 H2 H3
M14x1.0	1.0	87	22	11.2	9.0	13.0	H1 H2 H3
M16	2.0	102	32	12.5	10	14.0	H1 H2 H3

## EXTRUSION TAPS

Conform to GB/T3464.1-94, equal to ISO529-1975  
 M2 HSS  
 M35 HSS-E, Coatings, available for specified requirements  
 For machine  
 For through holes  
 Good cutting action, high speeding



Material: High Speed Steel



### TECHNICAL PARAMETER

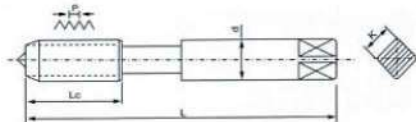
M	P(mm)	L(mm)	Lc(mm)	d(mm)	K(mm)	Hole(mm)	Tap limits
M16x1.5	1.5	102	32	12.5	10	14.5	H1 H2 H3
M16x1.0	1.0	92	22	12.5	10	15.0	H1 H2 H3
M18	2.5	112	37	14	11.2	15.5	H1 H2 H3
M18x1.5	1.5	112	37	14	11.2	16.5	H1 H2 H3
M18x1.0	1.0	97	22	14	11.2	17.0	H1 H2 H3
M20	2.5	112	37	14	11.2	17.5	H1 H2 H3
M20x2.2	2.0	112	37	14	11.2	18.0	H1 H2 H3
M20x1.5	1.5	112	37	14	11.2	18.5	H1 H2 H3
M20x1.0	1.0	102	22			19.0	H1 H2 H3
M22	2.5	118	38	16	12.5	19.5	H1 H2 H3
M22x2.0	2.0	118	38	16	12.5	20.0	H1 H2 H3
M22x1.5	1.5	118	38	16	12.5	20.5	H1 H2 H3
M22x1.0	1.0	109	24	16	12.5	21.0	H1 H2 H3
M24	3.0	130	45	18	14	21.0	H1 H2 H3
M24x2.0	2.0	130	45	18	14	22.0	H1 H2 H3
M24x1.5	1.5	130	45	18	14	22.5	H1 H2 H3
M24x1.0	1.0	114	24	18	14	23.0	H1 H2 H3

Up to M6: With male center

## DIN352

### DIN352 HAND TAPS

DIN352, for metric-ISO thread DIN 13, Tolerance 6H=ISO2  
 M2 HSS  
 M35 HSS-E, Coating, available for specified requirements  
 3 Of set: Taper, Second and Plug.  
 For through holes and blind holes



Material: High Speed Steel Alloy Steel

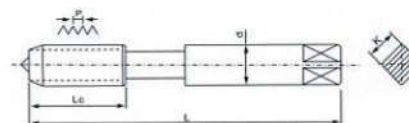
#### TECHNICAL PARAMETER

M	P(mm)	L(mm)	Lc(mm)	d(mm)	K(mm)	Hole(mm)	Tap limits
M3	0.5	40	11	35	2.7	2.5	6H
M4	0.7	45	13	4.5	3.4	3.2	6H
M5	0.8	50	16	6	4.9	4.2	6H
M6	1.0	50	19	6	4.9	5.0	6H
M7	1.0	50	19	6	4.9	6.0	6H
M8	1.25	56	22	6	4.9	6.75	6H
M9	1.25	63	22	7	5.5	7.75	6H
M10	1.5	70	24	7	5.5	8.5	6H
M11	1.5	70	24	8	6.2	9.5	6H
M12	1.75	75	29	9	7	10.25	6H
M14	2.0	80	30	11	9	12	6H
M16	2.0	80	32	12	9	14	6H
M18	2.5	95	40	14	11	15.5	6H
M20	2.5	95	40	16	12	17.5	6H
M22	2.5	100	40	18	14.5	19.5	6H
M24	3.0	110	50	18	14.5	21.0	6H
M27	3.0	110	50	20	16	24.0	6H
M30	3.5	125	56	22	18	26.5	6H
M33	3.5	125	56	25	20	29.5	6H
M36	4.0	150	63	28	22	32.0	6H
M39	4.0	150	63	32	24	35.0	6H
M42	4.5	150	63	32	24	37.5	6H
M45	4.5	160	70	36	29	40.5	6H
M48	5.0	180	75	36	29	43.0	6H
M52	5.0	180	75	40	32	47.0	6H

## DIN371/DIN376

### DIN371/DIN376 STRAIGHT FLUTE MACHINE TAPS

DIN371/376, for metric-ISO thread DIN 13, tolerance 6H  
 M2 HSS  
 M35 HSS-E, Coating, available for specified requirements  
 For machine  
 Short version for through holes  
 Good cutting action, high speeding



Material: High Speed Steel

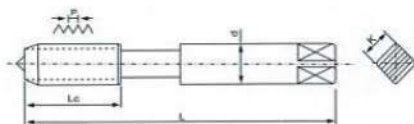
#### TECHNICAL PARAMETER

M	P(mm)	L(mm)	Lc(mm)	Chamfer	d(mm)	K(mm)	n	Hole(mm)	Tap limits
DIN371									
M3	0.5	56	11	5P	3.5	2.7	3	2.5	6H
M4	0.7	63	13	5P	4.5	3.4	3	3.3	6H
M5	0.8	70	16	5P	6	4.9	3	4.2	6H
M6	1.0	80	19	5P	6	4.9	3	5.0	6H
M8	1.25	90	22	5P	6	6.2	3	6.75	6H
M10	1.5	100	24	5P	10	8	3	8.5	6H
DIN376									
M12	1.75	110	29	5P	9	7	4	10.25	6H
M14	2.2	110	30	5P	11	9	4	12.0	6H
M16	2.0	110	32	5P	12	9	4	14.0	6H
M18	2.5	125	34	5P	14	11	4	15.5	6H
M20	2.5	140	34	5P	16	12	4	17.5	6H
M22	2.5	140	34	5P	18	14.5	4	19.5	6H
M24	3.0	160	38	5P	18	14.5	4	21.0	6H

## DIN371/DIN376

### DIN371/DIN376 SPIRAL POINTED MACHINE TAPS

DIN371/376, for metric-ISO thread DIN13, tolerance 6H  
 M2 HSS  
 M35 HSS-E, Coating, available for specified requirements  
 For machine  
 Short version for through holes  
 Good cutting action, high speeding



Material: High Speed Steel

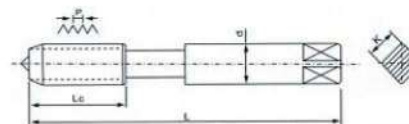
#### TECHNICAL PARAMETER

M	P(mm)	L(mm)	Lc(mm)	Chamfer	d(mm)	K(mm)	n	Hole(mm)	Tap limits
<b>DIN371</b>									
M3	0.5	56	11	5P	3.5	2.7	3	2.5	6H
M4	0.7	63	13	5P	4.5	3.4	3	3.3	6H
M5	0.8	70	16	5P	6	4.9	3	4.2	6H
M6	1.0	80	19	5P	6	4.9	3	5.0	6H
M8	1.25	90	22	5P	6	6.2	3	6.75	6H
M10	1.5	100	24	5P	10	8	3	8.5	6H
<b>DIN376</b>									
M12	1.75	110	29	5P	9	7	4	10.25	6H
M14	2.2	110	30	5P	11	9	4	12.0	6H
M16	2.0	110	32	5P	12	9	4	14.0	6H
M18	2.5	125	34	5P	14	11	4	15.5	6H
M20	2.5	140	34	5P	16	12	4	17.5	6H
M22	2.5	140	34	5P	18	14.5	4	19.5	6H
M24	3.0	160	38	5P	18	14.5	4	21.0	6H

## DIN371/DIN376

### DIN371/DIN376 CORKSCREW SPIN MACHINE TAPS

DIN371/376, with 35° Spiral flute, metric-ISO thread DIN13, tolerance 6H=ISO2  
 M2 HSS  
 M35 HSS-E, Coating, available for specified requirements  
 For blind holes  
 Good cutting action, high speeding



Material: High Speed Steel

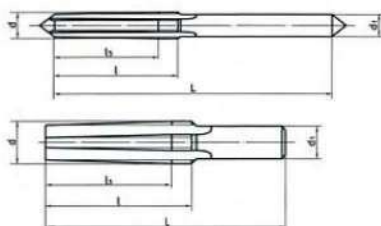
#### TECHNICAL PARAMETER

M	P(mm)	L(mm)	Lc(mm)	Chamfer	d(mm)	K(mm)	n	Hole(mm)	Tap limits
<b>DIN371</b>									
M3	0.5	56	11	5P	3.5	2.7	3	2.5	6H
M4	0.7	63	13	5P	4.5	3.4	3	3.3	6H
M5	0.8	70	16	5P	6	4.9	3	4.2	6H
M6	1.0	80	19	5P	6	4.9	3	5.0	6H
M8	1.25	90	22	5P	6	6.2	3	6.75	6H
M10	1.5	100	24	5P	10	8	3	8.5	6H
<b>DIN376</b>									
M12	1.75	110	29	5P	9	7	4	10.25	6H
M14	2.2	110	30	5P	11	9	4	12.0	6H
M16	2.0	110	32	5P	12	9	4	14.0	6H
M18	2.5	125	34	5P	14	11	4	15.5	6H
M20	2.5	140	34	5P	16	12	4	17.5	6H
M22	2.5	140	34	5P	18	14.5	4	19.5	6H
M24	3.0	160	38	5P	18	14.5	4	21.0	6H



## NUT TAPS

Standard : GB/T 967-2008  
 Material : HSS  
 Precision : H1, H2, H3  
 Used for : M2-M5  
 Used for : ≥M6



### TECHNICAL PARAMETER

Item	Diameter	Pitch	L	l	ls	di
M2	2	0.4	36	12	8	1.4
M2.2	2.2	0.45	36	14	10	1.6
M2.5	2.5	0.45	36	14	10	1.8
M3	3	0.5	40	15	12	2.24
M3x0.35	3	0.35	40	11	8	2.24
M3.5	3.5	0.6	45	18	14	2.5
M3.5x0.35	3.5	0.35	45	11	8	2.5
M4	4	0.7	50	21	16	3.15
M4x0.5	4	0.5	50	15	11	3.15
M5	5	0.8	55	24	19	4.0
M5x0.5	5	0.5	55	15	11	4.0
M6	6	1.0	60	30	24	4.5
M6x0.75	6	0.75	55	22	17	4.5
M8	8	1.25	65	36	31	6.3
M8x1	8	1	60	30	25	6.3
M8x0.75	8	0.75	55	22	17	6.3
M10	10	1.5	70	40	34	8.0
M10x1.25	10	1.25	65	36	30	8.0
M10x1	10	1	60	30	25	8.0
M10x0.75	10	0.75	55	22	17	8.0
M12	12	1.75	80	47	40	9.0
M12x1.5	12	1.5	80	45	37	9.0
M12x1.25	12	1.25	70	36	30	9.0
M12x1	12	1	65	30	25	9.0
M14	14	2	90	54	46	11.2
M14x1.5	14	1.5	80	45	37	11.2
M14x1.0	14	1	70	30	25	11.2
M16	16	2	95	58	50	12.5
M16x1.5	16	1.5	85	45	37	12.5
M16x1.0	16	1	70	30	25	12.5

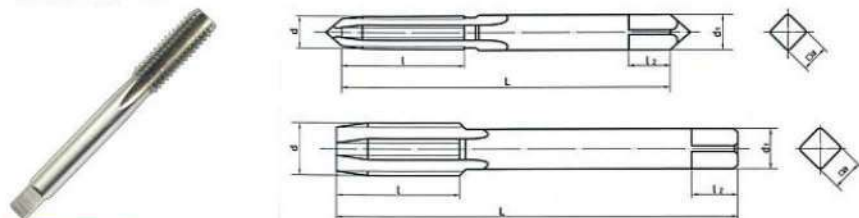
## NUT TAPS

### TECHNICAL PARAMETER

Item	Diameter	Pitch	L	l	ls	di
M18	18	2.5	110	62	52	14.0
M18x2	18	2	100	54	44	14
M18x1.5	18	1.5	90	45	37	14
M18x1	18	1	80	30	25	14
M20	20	2.5	110	62	52	16.0
M20x2	20	2	100	54	44	16
M20x1.5	20	1.5	90	45	37	16
M20x1	20	1	80	30	25	16
M22	22	2.5	110	62	52	18.0
M22x2	22	2	100	54	44	18
M22x1.5	22	1.5	90	45	37	18
M22x1	22	1	80	30	25	18
M24	24	3	130	72	60	18.0
M24x2	24	2	110	54	44	18
M24x1.5	24	1.5	100	45	37	18
M24x1	24	1	90	30	25	18
M27	27	3	130	72	60	22.4
M27x2	27	2	110	54	44	22.4
M27x1.5	27	1.5	100	45	37	22.4
M27x1	27	1	90	30	35	22.4
M30	30	3.5	150	84	70	25.0
M30x2	30	2	120	54	44	25
M30x1.5	30	1.5	110	45	37	25
M30x1	30	1	100	30	25	25

## SWIVEL NUT TAPS

Material : HSS  
 Precision : Meet the installed requirement of the swivel nut  
 Used for : M2-M6  
 Used for :  $\geq M7$

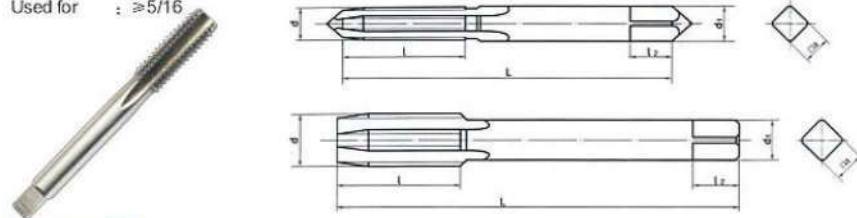


### TECHNICAL PARAMETER

Item	Diameter	Pitch	d	L	l	d <sub>1</sub>	Square size	
							a	l <sub>2</sub>
M3	3	0.5	3.65	53	17	4.0	4.0	6
M4	4	0.7	4.91	58	20.5	5.0	5.0	7
M5	5	0.8	6.04	66	24.5	6.3	6.3	8
M6	6	1.0	7.30	72	29.0	8.0	8.0	9
M8	8	1.25	9.63	80	31.5	10.0	10.0	11
M10	10	1.5	11.95	89	29.0	9.0	9.0	10
M10x1.25	10	1.25	11.63	85	25.0	8.0	8.0	9
M12	12	1.75	14.28	95	30.0	1.12	1.12	12
M12x1.5	12	1.5	13.95	95	30.0	11.2	11.2	12
M12x1.25	12	1.25	13.63	95	30.0	11.2	11.2	12
M14	14	2	16.60	102	32.0	12.5	12.5	13
M14x1.5	14	1.5	15.95	102	32.0	12.5	12.5	13
M14x1.25	14	1.25	15.63	102	32.0	12.5	12.5	13
M16	16	2	18.60	112	37.0	14.0	14.0	14
M16x1.5	16	1.5	17.95	112	29.0	14.0	14.0	14
M18	18	2.5	21.25	112	37.0	14.0	14.0	14
M18x2	18	2	20.60	112	37.0	14.0	14.0	14
M18x1.5	18	1.5	19.95	112	37.0	14.0	14.0	14

## TAP FOR UNIFIED THREADS

Standard : U.S.A Standard  
 Material : GCr15 or GCr15  
 Precision : Grinding or cutting  
 Used for : No.2-1/4  
 Used for :  $\geq 5/16$

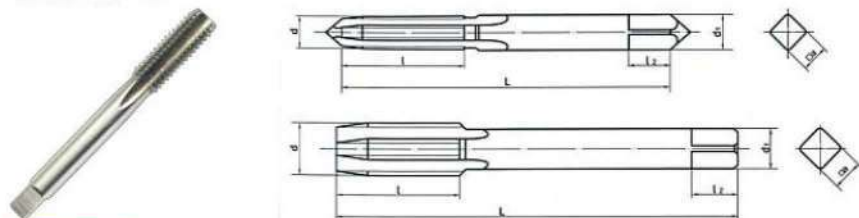


### TECHNICAL PARAMETER

Item	Thread/inch	Diameter	Pitch	d <sub>1</sub>	l	L	Square size	
							a	l <sub>2</sub>
No.2-56 UNC	56	2.184	0.454	3.55	13	42	2.8	5
No.2-64 UNF	64	2.184	0.397	3.55	13	44	2.8	5
No.3-48 UNC	48	2.515	0.529	3.55	15	46	2.8	5
No.3-56 UNF	56	2.515	0.454	3.55	15	46	2.8	5
No.4-40 UNC	40	2.845	0.635	3.55	14	45	2.8	5
No.4-48 UNF	48	2.845	0.529	3.55	14	45	2.8	5
No.5-40 UNC	40	3.175	0.635	3.55	15	45	2.8	5
No.5-44 UNF	44	3.175	0.577	3.55	15	45	2.8	5
No.6-32 UNC	32	3.505	0.794	3.55	17	48	2.8	5
No.6-40 UNF	40	3.505	0.635	3.55	17	48	2.8	5
No.8-32 UNC	32	4.166	0.794	4	19	51	3.15	6
No.8-36 UNF	36	4.166	0.706	4	19	51	3.15	6
No.10-24 UNC	24	4.826	1.058	5	22	56	4	7
No.10-32 UNF	32	4.826	0.794	5	22	56	4	7
No.12-24 UNC	24	5.486	1.058	5.6	24	58	4.5	7
No.12-28 UNF	28	5.486	0.907	5.6	24	58	4.5	7
1/4-20 UNC	20	6.350	1.27	6.3	25	59	5	8
1/4-28 UNF	28	6.350	0.909	6.3	25	59	5	8
5/16-18 UNC	18	7.938	1.411	6.3	29	69	5	8
5/16-24 UNF	24	7.938	1.058	6.3	29	69	5	8
3/8-16 UNC	16	9.525	1.588	6.3	30	74	5.6	8
3/8-24 UNF	24	9.525	1.058	6.3	30	74	5.6	8
7/16-14 UNC	14	11.112	1.814	8	30	76	6.3	9
7/16-20 UNF	20	11.112	1.27	8	30	76	6.3	9
1/2-13 UNC	13	12.700	1.954	9	40	85	7.1	10
1/2-20 UNF	20	12.700	1.27	9	40	85	7.1	10
9/16-12 UNC	12	14.288	2.117	11.2	40	90	9	12
9/16-18 UNF	18	14.288	1.411	11.2	40	90	9	12
5/8-11 UNC	11	15.875	2.309	12.5	45	95	10	13

## SWIVEL NUT TAPS

Material : HSS  
 Precision : Meet the installed requirement of the swivel nut  
 Used for : M2-M6  
 Used for :  $\geq M7$

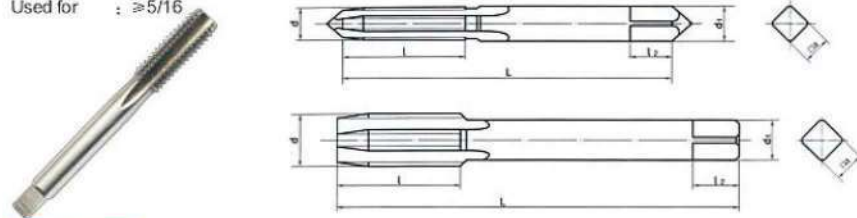


### TECHNICAL PARAMETER

Item	Diameter	Pitch	d	L	l	d <sub>1</sub>	Square size	
							a	l <sub>2</sub>
M3	3	0.5	3.65	53	17	4.0	4.0	6
M4	4	0.7	4.91	58	20.5	5.0	5.0	7
M5	5	0.8	6.04	66	24.5	6.3	6.3	8
M6	6	1.0	7.30	72	29.0	8.0	8.0	9
M8	8	1.25	9.63	80	31.5	10.0	10.0	11
M10	10	1.5	11.95	89	29.0	9.0	9.0	10
M10x1.25	10	1.25	11.63	85	25.0	8.0	8.0	9
M12	12	1.75	14.28	95	30.0	1.12	1.12	12
M12x1.5	12	1.5	13.95	95	30.0	11.2	11.2	12
M12x1.25	12	1.25	13.63	95	30.0	11.2	11.2	12
M14	14	2	16.60	102	32.0	12.5	12.5	13
M14x1.5	14	1.5	15.95	102	32.0	12.5	12.5	13
M14x1.25	14	1.25	15.63	102	32.0	12.5	12.5	13
M16	16	2	18.60	112	37.0	14.0	14.0	14
M16x1.5	16	1.5	17.95	112	29.0	14.0	14.0	14
M18	18	2.5	21.25	112	37.0	14.0	14.0	14
M18x2	18	2	20.60	112	37.0	14.0	14.0	14
M18x1.5	18	1.5	19.95	112	37.0	14.0	14.0	14

## TAP FOR UNIFIED THREADS

Standard : U.S.A Standard  
 Material : GCr15 or GCr15  
 Precision : Grinding or cutting  
 Used for : No.2-1/4  
 Used for :  $\geq 5/16$



### TECHNICAL PARAMETER

Item	Thread/inch	Diameter	Pitch	d <sub>1</sub>	l	L	Square size	
							a	l <sub>2</sub>
No.2-56 UNC	56	2.184	0.454	3.55	13	42	2.8	5
No.2-64 UNF	64	2.184	0.397	3.55	13	44	2.8	5
No.3-48 UNC	48	2.515	0.529	3.55	15	46	2.8	5
No.3-56 UNF	56	2.515	0.454	3.55	15	46	2.8	5
No.4-40 UNC	40	2.845	0.635	3.55	14	45	2.8	5
No.4-48 UNF	48	2.845	0.529	3.55	14	45	2.8	5
No.5-40 UNC	40	3.175	0.635	3.55	15	45	2.8	5
No.5-44 UNF	44	3.175	0.577	3.55	15	45	2.8	5
No.6-32 UNC	32	3.505	0.794	3.55	17	48	2.8	5
No.6-40 UNF	40	3.505	0.635	3.55	17	48	2.8	5
No.8-32 UNC	32	4.166	0.794	4	19	51	3.15	6
No.8-36 UNF	36	4.166	0.706	4	19	51	3.15	6
No.10-24 UNC	24	4.826	1.058	5	22	56	4	7
No.10-32 UNF	32	4.826	0.794	5	22	56	4	7
No.12-24 UNC	24	5.486	1.058	5.6	24	58	4.5	7
No.12-28 UNF	28	5.486	0.907	5.6	24	58	4.5	7
1/4-20 UNC	20	6.350	1.27	6.3	25	59	5	8
1/4-28 UNF	28	6.350	0.909	6.3	25	59	5	8
5/16-18 UNC	18	7.938	1.411	6.3	29	69	5	8
5/16-24 UNF	24	7.938	1.058	6.3	29	69	5	8
3/8-16 UNC	16	9.525	1.588	6.3	30	74	5.6	8
3/8-24 UNF	24	9.525	1.058	6.3	30	74	5.6	8
7/16-14 UNC	14	11.112	1.814	8	30	76	6.3	9
7/16-20 UNF	20	11.112	1.27	8	30	76	6.3	9
1/2-13 UNC	13	12.700	1.954	9	40	85	7.1	10
1/2-20 UNF	20	12.700	1.27	9	40	85	7.1	10
9/16-12 UNC	12	14.288	2.117	11.2	40	90	9	12
9/16-18 UNF	18	14.288	1.411	11.2	40	90	9	12
5/8-11 UNC	11	15.875	2.309	12.5	45	95	10	13

## TAP FOR UNIFIED THREADS

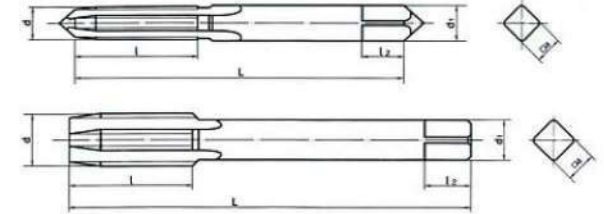
### TECHNICAL PARAMETER

Item	Thread/inch	Diameter	Pitch	d <sub>1</sub>	l	L	Square size	
							a	l <sub>2</sub>
5/8-18 UNF	18	15.875	1.411	12.5	45	95	10	13
3/4-10 UNC	10	19.050	2.540	14	50	107	11.2	14
3/4-16 UNF	16	19.050	1.588	14	50	107	11.2	14
7/8-9 UNC	9	22.225	2.822	18	56	118	14	18
7/8-14 UNF	14	22.225	1.814	18	56	118	14	18
1-8 UNC	8	25.400	3.175	20	63	130	16	20
1-12 UNF	12	25.400	2.117	20	63	130	16	20
1 1/8-7 UNC	7	28.575	3.629	22.4	65	138	18	22
1 1/8-12 UNF	12	28.575	2.117	22.4	65	138	18	22
1 1/4-7 UNC	7	31.750	3.629	25	65	146	20	24
1 1/4-12 UNF	12	31.750	2.117	25	65	146	20	24
1 3/8-6 UNC	6	34.925	4.233	28	76	153	22.4	26
1 3/8-12 UNF	12	34.925	2.117	28	76	153	22.4	26
1 1/2-6 UNC	6	38.100	4.233	31.5	76	162	25	28
1 1/2-12 UNF	12	38.100	2.117	31.5	76	162	25	28
1 3/4-5 UNC	5	44.450	5.080	35.5	77	177	28	31
2-4 1/2 UNC	4 1/2	50.800	5.644	40	80	180	31.5	34

Note: Expecting the specifications in the table, we can produce other specifications' tooth tap according to customers' needs

## TAP FOR WITHWORTH THREADS

Standard : JB/T 8825.1-1998  
 Material : HSS or GCr15  
 Precision : grinding or cutting



### TECHNICAL PARAMETER

Item	Thread/inch	Diameter	Pitch	d <sub>1</sub>	l	L	Square size	
							a	l <sub>2</sub>
1/8-20 BSW	40	3.175	0.635	3.15	14.5	48	2.5	5
3/16-24 BSW	24	4.762	1.058	5	20.5	58	4	7
3/16-32 BSF	32	4.762	0.794	5	20.5	58	4	7
1/4-20 BSW	20	6.35	1.270	6.3	24.5	66	5	8
1/4-26 BSF	26	6.35	0.977	6.3	24.5	66	5	8
9/32-26 BSF	26	7.144	0.977	5.6	19	66	4.5	7
5/16-18 BSW	18	7.938	1.411	6.3	22	72	5	8
5/16-22 BSF	22	7.938	1.154	6.3	22	72	5	8
3/8-16 BSW	16	9.525	1.588	7.1	24	80	5.6	8
3/8-20 BSF	20	9.525	1.27	7.1	24	80	5.6	8
7/16-14 BSW	14	11.112	1.814	8	25	85	6.3	9
7/16-18 BSF	18	11.112	1.411	8	25	85	6.3	9
1/2-12 BSW	12	12.7	2.117	9	29	89	7.1	10
1/2-16 BSF	16	12.7	1.588	9	29	89	7.1	10
9/16-12 BSW	12	14.288	2.117	11.2	30	95	9	12
9/16-16 BSF	16	14.288	1.588	11.2	30	95	9	12
5/8-11 BSW	11	15.875	2.309	12.5	32	102	10	13
5/8-14 BSF	14	15.875	1.814	12.5	32	102	10	13
1 1/16-11 BSW	11	17.462	2.309	14	37	112	11.2	14
1 1/16-14 BSF	14	17.462	1.814	14	37	112	11.2	14
3/4-10 BSW	10	19.050	2.540	14	37	112	11.2	14
3/4-12 BSF	12	19.050	2.117	14	37	112	11.2	14
7/8-9 BSW	9	22.225	2.822	16	38	118	12.5	16
7/8-11 BSF	11	22.225	2.309	16	38	118	12.5	16
1-8 BSW	8	25.4	3.175	18	45	130	14	18
1-10 BSF	10	25.4	2.510	18	45	130	14	18
1 1/8-7 BSW	7	28.575	3.629	20	48	138	16	20
1 1/8-9 BSF	9	28.575	2.822	20	48	138	16	20

## TAP FOR WITHWORTH THREADS

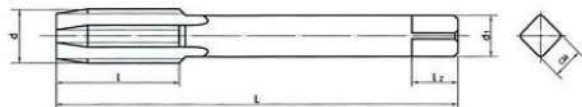
### TECHNICAL PARAMETER

Item	Thread/inch	Diameter	Pitch	d <sub>1</sub>	l	L	Square size	
							a	l <sub>2</sub>
11/4-7 BSW	7	31.75	3.629	22.4	51	151	18	22
11/4-9 BSF	9	31.75	2.822	22.4	51	151	18.0	22
11/2-6 BSW	6	38.1	4.233	28	60	170	22.4	26
11/2-8 BSF	8	38.1	3.175	28	60	170	22.4	26
13/4-5 BSW	5	44.45	5.08	31.5	67	187	25	28
13/4-7 BSF	7	44.45	3.629	31.5	67	187	25	28
2-41/2 BSW	41/2	50.8	5.644	35.5	70	200	28	31
2-7 BSF	7	50.8	3.629	35.5	70	200	28	31

55°

## TAP FOR 55° PARALLEL PIPE THREADS

Standard : GB/T 20333-2006  
Material : HSS



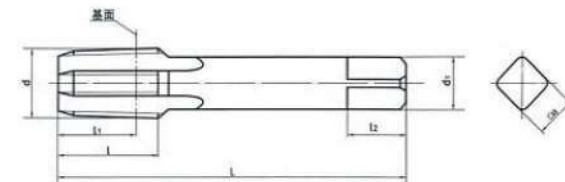
### TECHNICAL PARAMETER

Item	Thread/inch	Diameter	Pitch	d <sub>1</sub>	l	L	Square size	
							a	l <sub>2</sub>
G 1/16	28	7.723	0.907	5.6	14	52	4.5	7
G 1/8	28	9.728	0.907	8	15	59	6.3	9
G 1/4	19	13.157	1.337	10	19	67	8	11
G 3/8	19	16.662	1.337	12.5	21	75	10	13
G 1/2	14	20.955	1.814	16	26	87	12.5	16
G 5/8	14	22.911	1.814	18	26	91	14	18
G 3/4	14	26.441	1.814	20	28	96	16	20
G 7/8	14	30.201	1.814	22.4	29	102	18	22
G 1	11	33.249	2.309	25	33	109	20	24
G 1 1/4	11	41.910	2.309	31.5	36	119	25	28
G 1 1/2	11	47.803	2.309	35.5	37	125	28	31
G 1 3/4	11	53.746	2.309	35.5	39	132	28	31
G 2	11	59.614	2.309	40	41	140	31.5	34

55°

## TAP FOR 55° TAPER PIPE THREADS

Standard : GB/T 20333-2006  
Material : HSS



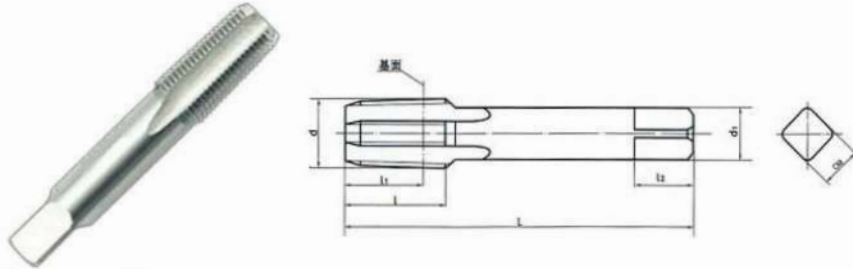
### TECHNICAL PARAMETER

Item	Thread/inch	Diameter	Pitch	d <sub>1</sub>	l	L	l <sub>1</sub> (max)	Square size	
								a	l <sub>2</sub>
Rc 1/16	28	7.732	0.907	5.6	14	52	10.1	4.5	7
Rc 1/8	28	9.728	0.907	8	15	59	10.1	6.3	9
Rc 1/4	19	13.157	1.337	10	19	67	15	8	11
Rc 3/8	19	16.662	1.337	12.5	21	75	15.4	10	13
Rc 1/2	14	20.955	1.814	16	26	87	20.5	12.5	16
Rc 3/4	14	26.441	1.814	20	28	96	21.8	16	20
Rc 1	11	33.249	2.309	25	33	109	26	20	24
Rc 1 1/4	11	41.910	2.309	31.5	36	119	28.3	25	28
Rc 1 1/2	11	47.803	2.309	35.5	37	125	28.3	28	31
Rc 2	11	59.614	2.309	40	41	140	32.7	31.5	34

60°

## TAP FOR 60° TAPER PIPE THREADS

Standard : JB/T 8364.2-96  
Material : HSS



### TECHNICAL PARAMETER

Item	Thread/inch	Diameter	Pitch	d <sub>1</sub>	l	L	l <sub>1</sub> (max)	Square size	
								a	l <sub>2</sub>
1/16 NPT	27	7.894	0.941	8.0	17	54	11	6.3	9
1/8 NPT	27	10.242	0.941	8.0	19	54	11	6.3	9
1/4 NPT	18	13.616	1.411	11.2	27	62	16	9	12
3/8 NPT	18	17.055	1.411	14	27	65	16	11.2	14
1/2 NPT	14	21.224	1.814	18	35	79	21	14	18
3/4 NPT	14	26.569	1.814	22.4	35	83	21	18	22
1 NPT	11.5	33.228	2.209	28	44	95	26	22.4	26
1 1/4 NPT	11.5	41.985	2.209	35.5	44	102	27	28	31
1 1/2 NPT	11.5	48.054	2.209	40	44	108	27	31.5	34
2 NPT	11.5	60.092	2.209	50	44	114	28	40	42

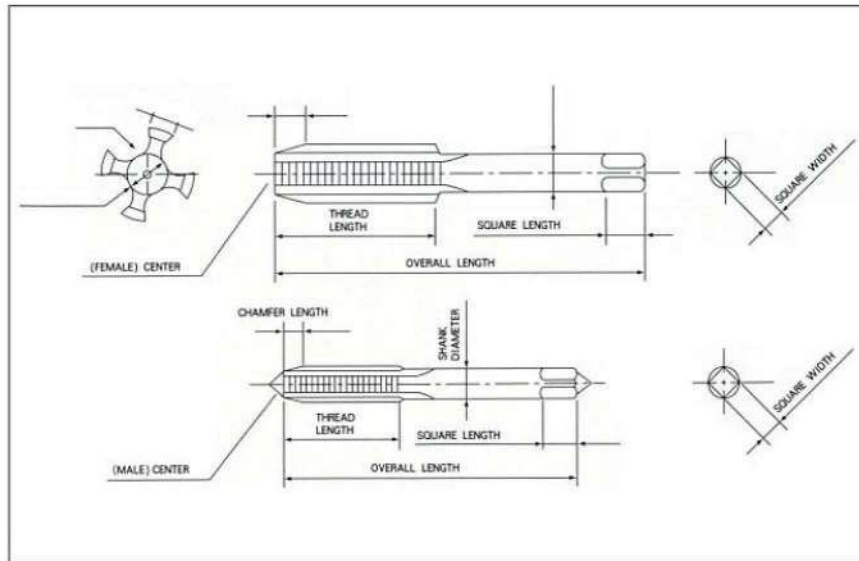
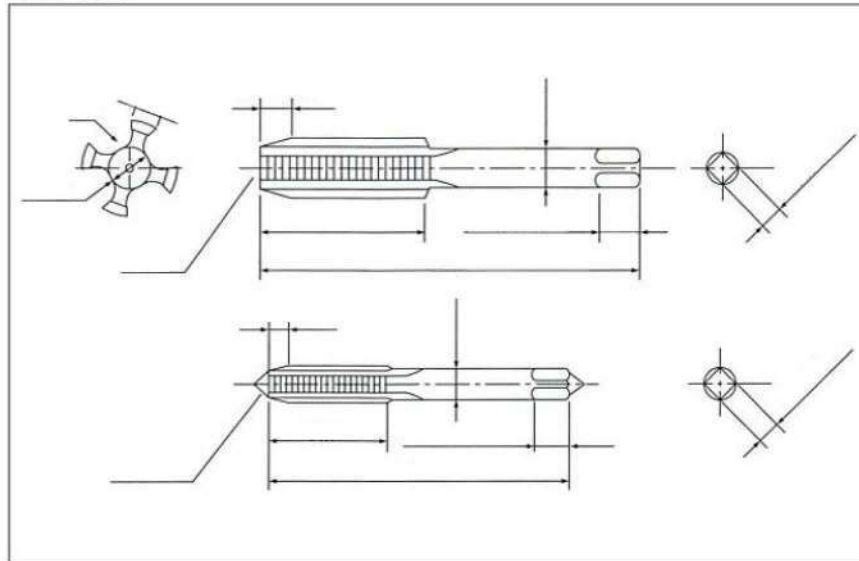
Note: Former code Z, K

## NON-STANDARD TAP



# NAME OF EACH PART

## TERMINOLOGY

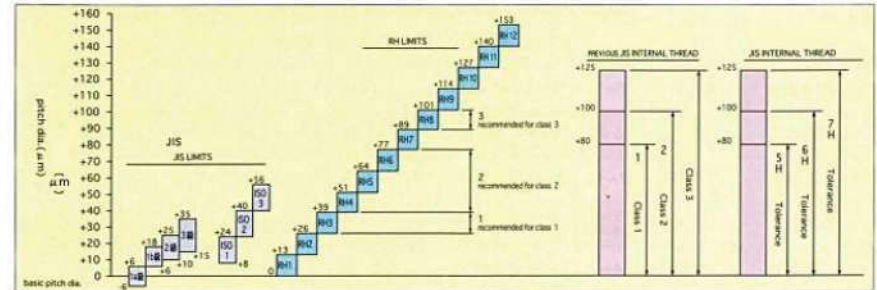


# RH LIMIT

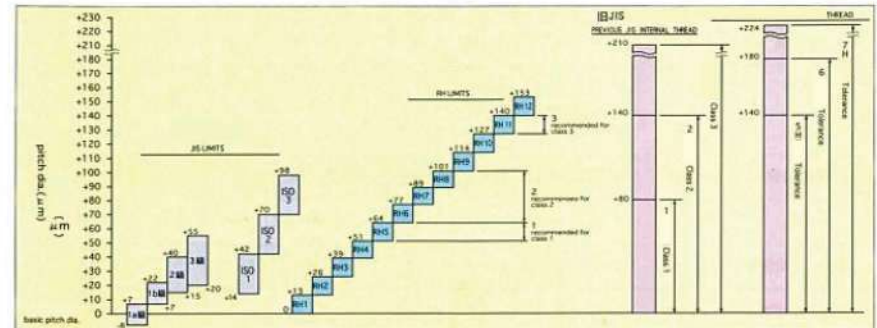
$0.0127 \times n$  upper limit;  $0.0127 \times n$   
 $-0.0127$  lower limit;  $0.0127 \times n - 0.0127$

mm Unit: mm (n = RH#) (n = RH number)

M3 × 0.5 Example M3 × 0.5



M10 × 1.5 Example M10 × 1.5



1/2 - 13UNC Example 1/2 - 13UNC

