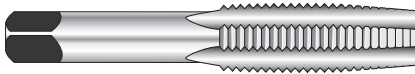


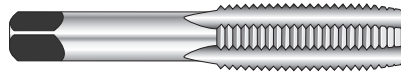
# HIGH SPEED STEEL METRIC THREAD HAND TAPS

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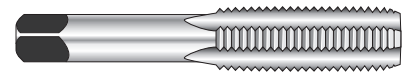
**TAPER TAP (T)**  
7-10 Thread Chamfer  
at 5 degrees per side

GENERAL PURPOSE



**PLUG TAP (P)**  
3-5 Thread Chamfer  
at 8 degrees per side

GROUND THREAD



**BOTTOMING TAP (B)**  
1-2 Thread Chamfer  
at 18 degrees per side

High Speed Steel Metric Thread Hand Taps with straight flutes are designed for general purpose hand tapping or in production machines where ground thread accuracy and performance are required. They are suitable for tapping most materials in through or blind holes. Hand taps retain chips in the flutes during use and work best on materials that produce chips and the swarf breaks easily. They are also known as Straight Flute Taps.

SIZE mm	PITCH mm	NO. OF FLUTES	PRICE		TAP DRILL SIZES mm
			TAPER, PLUG or BOTTOM	TAPER, PLUG & BOTTOM (3 PC SET)	
			SHTM	SHTMS	
M1.5	0.35	2	15.48	46.44	M1.15
M1.6	<b>0.35</b>	2	15.48	46.44	M1.25
M1.8	<b>0.35</b>	2	15.48	46.44	M1.45
M2	<b>0.40</b>	3	12.42	37.26	M1.60
M2	0.45	3	10.50	31.50	M2.05
M2.2	<b>0.45</b>	3	10.50	31.50	M1.75
M2.3	0.40	3	10.50	31.50	M1.90
M2.5	<b>0.45</b>	3	10.50	31.50	M2.05
M2.6	0.45	3	10.50	31.50	M2.20
M3	<b>0.50</b>	3	7.78	23.34	M2.50
M3	0.60	3	8.60	25.80	M2.40
M3.5	<b>0.60</b>	3	8.60	25.80	M2.90
M4	<b>0.70</b>	4	6.82	20.46	M3.30
M4	0.50	4	7.88	23.64	M3.50
M4.5	<b>0.75</b>	4	8.60	25.80	M3.70
M5	<b>0.80</b>	4	6.82	20.46	M4.20
M5	0.90	4	6.82	20.46	M4.10
M5.5	0.90	4	6.82	20.46	M4.60
M6	<b>1.00</b>	4	6.62	19.86	M5.00
M6.3	1.00	4	7.04	21.12	M5.30
M7	<b>1.00</b>	4	7.18	21.54	M6.00
M8	<b>1.25</b>	4	7.32	21.96	M6.80
M8	1.00	4	7.90	23.70	M7.00
M9	<b>1.25</b>	4	9.30	27.90	M7.80
M10	<b>1.50</b>	4	9.30	27.90	M8.50
M10	1.25	4	10.26	30.78	M8.80
M10	1.00	4	10.26	30.78	M9.00
M11	<b>1.50</b>	4	10.26	30.78	M9.50
M12	<b>1.75</b>	4	18.22	54.66	M10.20
M12	1.50	4	18.00	54.00	M10.50
M12	1.25	4	18.00	54.00	M10.80
M14	<b>2.00</b>	4	23.68	71.04	M12.00
M14	1.50	4	26.04	78.12	M12.50
M14	1.25	4	26.04	78.12	M12.80

SIZE mm	PITCH mm	NO. OF FLUTES	PRICE		TAP DRILL SIZES mm
			TAPER, PLUG or BOTTOM	TAPER, PLUG & BOTTOM (3 PC SET)	
			SHTM	SHTMS	
M16	<b>2.00</b>	4	31.52	94.56	M14.00
M16	1.50	4	31.52	94.56	M14.50
M18	<b>2.50</b>	4	34.86	104.58	M15.50
M18	2.00	4	38.30	114.90	M16.00
M18	1.00	4	38.30	114.90	M17.00
M18	1.50	4	38.30	114.90	M16.50
M20	<b>2.50</b>	4	39.46	118.38	M17.50
M20	1.50	4	43.34	130.02	M18.50
M20	1.00	4	43.34	130.02	M19.00
M20	2.00	4	43.34	130.02	M18.00
M22	<b>2.50</b>	4	54.98	164.94	M19.50
M22	1.50	4	60.42	181.26	M20.50
M24	<b>3.00</b>	4	73.50	220.50	M21.00
M24	2.00	4	80.82	242.46	M22.00
M24	1.50	4	80.82	242.46	M22.50
M27	<b>3.00</b>	4	97.50	292.50	M24.00
M27	2.00	4	107.20	321.60	M25.00
M30	<b>3.50</b>	4	146.38	439.14	M26.50
M30	2.00	4	146.38	439.14	M28.00
M30	1.50	4	146.38	439.14	M28.50
M32	2.00	4	146.38	439.14	M30.00
M33	<b>3.50</b>	4	158.60	475.80	M29.50
M33	2.00	4	174.44	523.32	M31.00
M36	4.00	4	191.06	573.18	M32.00
M36	3.00	4	276.50	829.50	M33.00
M39	<b>4.00</b>	6	220.46	661.38	M35.00
M39	3.00	6	242.44	727.32	M36.00
M42	<b>4.50</b>	6	261.24	783.72	M37.50
M42	1.50	6	261.24	783.72	M40.50
M45	<b>4.50</b>	6	295.16	885.48	M40.50
M45	1.50	6	295.16	885.48	M43.50
M48	<b>5.00</b>	6	299.34	898.02	M43.00
M48	1.50	6	329.24	987.72	M46.50
M52	<b>5.00</b>	6	386.64	1159.92	M47.00
M52	1.50	6	391.36	1174.08	M50.50

Metric pitches in **bold type** are **coarse thread** form.

- Please specify Taper (T), Plug (P) or Bottoming (B) chamfer. Examples: SHTM04X.70T, SHTM10X1.50P, SHTM24X1.50B.

## PACKAGING

M1.5 -M14 -12 Taps/Box • M16 - M24 - 3 Taps/Box • M27 - M52 - 1 Tap/Tub

**NOTE:** Titanium Nitride Coated Metric Hand Taps are available upon request.  
Tap pitch diameter limits are those recommended for Class 6H tolerances.