



## Metric Coarse HSS Ground Thread Taps

Straight Flute Individual Sizes  
ISO 529



## METRIC COARSE HSS



Sets of Three  
1 each, taper, second and plug lead

(1) Diameter and pitch not mentioned in ISO.

Size - Pitch (mm)	Thread Length	Overall Length	Shank Diameter	Weight each	Taper	Second	Plug
					Order Code SHR-085	Order Code SHR-085	Order Code SHR-085
M1.0 x 0.25	5.5	38.5	2.50	3g	-0100A	-0100B	-0100C
M1.6 x 0.35	8.0	41.0	2.50	3g	-0130A	-0130B	-0130C
M2.0 x 0.40	8.0	41.0	2.50	3g	-0160A	-0160B	-0160C
M2.5 x 0.45	9.5	44.5	2.80	4g	-0200A	-0200B	-0200C
M3.0 x 0.50	11.0	48.0	3.15	4g	-0230A	-0230B	-0230C
M3.0 x 0.60	14.5	48.0	3.15	4g	-0240A	-0240B	-0240C
M3.5 x 0.60	13.0	50.0	3.55	4g	-0260A	-0260B	-0260C
M4.0 x 0.70	13.0	53.0	4.00	6g	-0280A	-0280B	-0280C
M4.0 x 0.75	17.0	53.0	4.00	6g	-0290A	-0290B	-0290C
M5.0 x 0.80	12.0	58.0	5.00	8g	-0330A	-0330B	-0330C
M5.0 x 0.90	12.0	58.0	5.00	6g	-0340A	-0340B	-0340C
M6.0 x 1.00	19.0	66.0	6.30	14g	-0370A	-0370B	-0370C
M7.0 x 1.00	17.0	66.0	7.10	21g	-0390A	-0390B	-0390C
M8.0 x 1.25	22.0	72.0	8.00	23g	-0410A	-0410B	-0410C
M10.0 x 1.50	24.0	80.0	10.00	39g	-0450A	-0450B	-0450C
M12.0 x 1.75	23.0	89.0	9.00	48g	-0480A	-0480B	-0480C
M14.0 x 2.00	25.0	95.0	11.20	76g	-0510A	-0510B	-0510C
M16.0 x 2.00	25.0	102.0	12.50	100g	-0530A	-0530B	-0530C
M18.0 x 2.50	30.0	112.0	14.00	133g	-0550A	-0550B	-0550C
M20.0 x 2.50	30.0	112.0	14.00	144g	-0570A	-0570B	-0570C
M24.0 x 3.00	36.0	130.0	18.00	260g	-0610A	-0610B	-0610C
M27.0 x 3.00	36.0	135.0	20.00	256g	-0640A	-0640B	-0640C
M30.0 x 3.50	42.0	138.0	20.00	380g	-0660A	-0660B	-0660C

Square AF	Tap Drill Size	Set of 3 Order Code SHR-085
2.00	0.75	-0100D
2.00	1.25	-0130D
2.00	1.60	-0160D
2.24	1.75	-0180D
2.24	2.05	-0200D
2.50	2.40	-0230D
2.50	2.50	-0240D
2.80	2.90	-0260D
3.15	3.30	-0280D
3.15	3.30	-0290D
3.55	3.70	-0310D
4.00	4.20	-0330D
4.00	4.20	-0340D
5.00	5.00	-0370D
6.30	6.80	-0410D
7.10	7.80	-0420D
8.00	8.50	-0450D
6.30	9.50	-0460D
7.10	10.20	-0480D
9.00	12.00	-0510D
10.00	14.00	-0530D
11.20	15.50	-0550D
11.20	17.50	-0570D
14.00	21.00	-0610D
16.00	24.00	-0640D
16.00	26.50	-0660D
20.00	32.00	-0690D
22.40	37.50	-0710D

## Metric Coarse HSS Ground Thread Dies

BS 1127

For use in diestocks to produce external screw threads.



Size - Pitch (mm)	Outside Diameter	Thickness	Weight each	Order Code SHR-086
M2.0 x 0.40	13/16"	1/4"	13g	-0110K
M2.5 x 0.45	13/16"	1/4"	12g	-0130K
M3.0 x 0.50	13/16"	1/4"	14g	-0140K
M3.5 x 0.60	13/16"	1/4"	13g	-0150K
M4.0 x 0.70	13/16"	1/4"	13g	-0160K
M4.0 x 0.70	1"	3/8"	25g	-0410K
M5.0 x 0.80	1"	3/8"	24g	-0430K
M5.0 x 0.80	13/16"	1/4"	12g	-0180K
M6.0 x 1.00	13/16"	1/4"	12g	-0200K
M6.0 x 1.00	1"	3/8"	27g	-0440K
M6.0 x 1.00	15/16"	7/16"	54g	-0590K
M7.0 x 1.00	13/16"	1/4"	11g	-0210K
M8.0 x 1.25	1"	3/8"	27g	-0460K
M8.0 x 1.25	15/16"	7/16"	62g	-0610K
M8.0 x 1.25	1 1/2"	1 1/2"	85g	-0790K
M9.0 x 1.25	1"	3/8"	26g	-0470K
M10.0 x 1.50	1"	3/8"	26g	-0480K
M10.0 x 1.50	15/16"	7/16"	51g	-0630K
M10.0 x 1.50	1 1/2"	1 1/2"	85g	-0810K
M11.0 x 1.50	15/16"	7/16"	54g	-0640K
M12.0 x 1.75	15/16"	7/16"	54g	-0650K
M12.0 x 1.75	1 1/2"	1 1/2"	78g	-0830K
M12.0 x 1.75	2"	5/8"	156g	-1020K
M14.0 x 2.00	1 5/8"	7/16"	50g	-0660K
M14.0 x 2.00	1 1/2"	1 1/2"	73g	-0840K
M14.0 x 2.00	2"	5/8"	167g	-1030K
M16.0 x 2.00	1 1/2"	1 1/2"	72g	-0850K
M16.0 x 2.00	2"	5/8"	167g	-1040K
M18.0 x 2.50	1 1/2"	1 1/2"	96g	-0860K
M20.0 x 2.50	1 1/2"	1 1/2"	66g	-0870K
M20.0 x 2.50	2"	5/8"	160g	-1060K
M22.0 x 2.50	2"	5/8"	157g	-1070K
M24.0 x 3.00	2"	5/8"	152g	-1080K
M30.0 x 3.50	3"	7/8"	471g	-1220K

## Metric Coarse HSS Ground Thread Die Nuts

BS 1127

For use with spanners to clean and repair existing external screw threads.

## METRIC COARSE HSS



Size - Pitch (mm)	Outside Diameter	Thickness	Weight each	Order Code SHR-086
M3.0 x 0.50	0.71"	1/4"	11g	-1310K
M4.0 x 0.70	0.71"	1/4"	10g	-1330K
M5.0 x 0.80	0.71"	1/4"	11g	-1350K
M6.0 x 1.00	0.71"	1/4"	10g	-1360K
M7.0 x 1.00	0.82"	5/16"	16g	-1440K
M8.0 x 1.25	0.82"	5/16"	16g	-1450K
M9.0 x 1.25	0.92"	3/8"	25g	-1490K
M10.0 x 1.50	0.92"	3/8"	24g	-1500K
M12.0 x 1.75	1.10"	1/2"	36g	-1570K
M14.0 x 2.00	1.30"	5/8"	45g	-1600K
M16.0 x 2.00	1.30"	5/8"	48g	-1610K
M18.0 x 2.50	1.48"	1 1/16"	106g	-1640K
M20.0 x 2.50	1.48"	1 1/16"	140g	-1650K
M22.0 x 2.50	1.67"	1 3/16"	147g	-1690K
M24.0 x 3.00	2.05"	1 5/16"	274g	-1720K
M30.0 x 3.50	2.22"	1 1/16"	330g	-1760K
M36.0 x 4.00	2.76"	1 1/4"	489g	-1790K





## Metric Coarse HSS Ground Thread Taps

Spiral Point/Gun Nose

**METRIC COARSE HSS**



Size - Pitch (mm)	Shank Dia.	A/F Square	Weight Each	Order Code SHR-085
M1.6 x 0.35	2.50	2.00	9g	-0130E
M2.0 x 0.40	2.50	2.00	9g	-0160E
M2.5 x 0.45	2.80	2.24	9g	-0200E
M3.0 x 0.50	3.15	2.50	12g	-0230E
M3.5 x 0.60	3.55	2.80	12g	-0260E
M4.0 x 0.70	4.00	3.15	18g	-0280E
M4.5 x 0.75	4.50	3.55	18g	-0310E
M5.0 x 0.80	5.00	4.00	18g	-0330E
M6.0 x 1.00	6.30	5.00	45g	-0370E
M7.0 x 1.00	7.10	5.60	54g	-0390E
M8.0 x 1.25	8.00	6.30	72g	-0410E
M10.0 x 1.50	10.00	8.00	120g	-0450E
M12.0 x 1.75	9.00	7.10	149g	-0480E
M14.0 x 2.00	11.20	9.00	233g	-0510E
M16.0 x 2.00	12.50	10.00	307g	-0530E
M18.0 x 2.50	14.00	11.20	427g	-0550E
M20.0 x 2.50	14.00	11.20	459g	-0570E
M24.0 x 3.00	18.00	14.00	826g	-0610E

Spiral Flute

**METRIC COARSE HSS**



Size - Pitch (mm)	Shank Dia.	A/F Square	Weight Each	Order Code SHR-085
2.00 - 0.40	2.50	2.00	9g	-0160F
2.50 - 0.45	2.80	2.24	9g	-0200F
3.00 - 0.50	3.15	2.50	12g	-0230F
3.50 - 0.60	3.55	2.80	12g	-0260F
4.00 - 0.70	4.00	3.15	18g	-0280F
5.00 - 0.80	5.00	4.00	24g	-0330F
6.00 - 1.00	6.30	5.00	33g	-0370F
8.00 - 1.25	8.00	6.30	69g	-0410F
10.00 - 1.50	10.00	8.00	114g	-0450F
12.00 - 1.75	9.00	7.10	147g	-0480F
14.00 - 2.00	11.20	9.00	167g	-0510F
16.00 - 2.00	12.50	10.00	304g	-0530F
18.00 - 2.50	14.00	11.20	420g	-0550F
20.00 - 2.50	14.00	11.20	448g	-0570F
24.00 - 3.00	18.00	14.00	795g	-0610F
30.00 - 3.50	20.00	16.00	953g	-0660F

Fluteless

**METRIC COARSE HSS**



Size - Pitch (mm)	Shank Dia.	Weight Each	Order Code SHR-085
2.00 - 0.40	2.50	9g	-0160K
2.50 - 0.45	2.80	12g	-0200K
3.00 - 0.50	3.15	12g	-0230K
4.00 - 0.70	4.00	18g	-0280K
5.00 - 0.80	5.00	24g	-0330K
6.00 - 1.00	6.30	33g	-0370K
8.00 - 1.25	8.00	69g	-0410K
10.00 - 1.50	10.00	114g	-0450K
12.00 - 1.75	9.00	147g	-0480K
16.00 - 2.00	12.50	304g	-0530K

Straight Flute Long Series

Also Available in UNC/F and BSW/F Thread Forms **METRIC COARSE HSS**



Size - Pitch (mm)	Thread Length	Overall Length	Shank Diameter	Weight Each	Taper	Second	Plug
					Order Code SHR-085	Order Code SHR-085	Order Code SHR-085
M3.0 x 0.50	11	66	2.24	5g	-0230G	-0230H	-0230J
M4.0 x 0.70	13	73	3.15	9g	-0280G	-0280H	-0280J
M5.0 x 0.80	16	79	4.00	13g	-0330G	-0330H	-0330J
M6.0 x 1.00	19	89	4.50	16g	-0370G	-0370H	-0370J
M8.0 x 1.25	22	97	6.30	30g	-0410G	-0410H	-0410J
M10.0 x 1.50	24	108	8.00	48g	-0450G	-0450H	-0450J
M12.0 x 1.75	29	119	9.00	68g	-0480G	-0480H	-0480J
M16.0 x 2.00	32	137	12.50	130g	-0530G	-0530H	-0530J

Sets of Three

1 each, taper, second and plug lead.



Straight Flute Individual Sizes

Size - Pitch (mm)	Thread Length	Overall Length	Shank Diameter	Weight each	Taper	Second	Plug
					Order Code SHR-087	Order Code SHR-087	Order Code SHR-087
M5.0 x 0.80	16.0	58.0	5.00	9g	-	-0330M	-0330N
M6.0 x 1.00	19.0	66.0	6.30	14g	-0370L	-0370M	-0370N
M8.0 x 1.25	22.0	72.0	8.00	26g	-0410L	-0410M	-0410N
M10.0 x 1.50	24.0	80.0	10.00	42g	-	-0450M	-0450N
M12.0 x 1.75	23.0	89.0	9.00	48g	-	-0480M	-0480N
M16.0 x 2.00	25.0	102.0	12.50	102g	-0530L	-0530M	-0530N

**HSS**

**LEFT HAND**

**METRIC COARSE**

## Metric HSS Left Hand Dies

**HSS**

**LEFT HAND**

**METRIC COARSE**

BS 1127

For use in diestocks to produce external screw threads.



Size - Pitch (mm)	Outside Diameter	Order Code SHR-087
M6.0 x 1.00	1"	-2530K
M8.0 x 1.25	1"	-2550K





## Metric Fine HSS Ground Thread Taps

ISO 529  
Straight Flute Individual Sizes

(1) Diameter and pitch not mentioned in ISO.



Left Hand Also Available

METRIC FINE

HSS



Sets of Three  
1 each, taper, second and plug lead.

Size - Pitch (mm)	Thread Length	Overall Length	Shank Diameter	Weight each	Taper	Second	Plug
					Order Code SHR-085	Order Code SHR-085	Order Code SHR-085
<b>Metric Fine</b>							
M3.5 x 0.35	13.0	50.0	3.55	4g	-0250A	-0250B	-0250C
M4.0 x 0.50	13.0	53.0	4.00	6g	-0270A	-0270B	-0270C
M5.0 x 0.50	16.0	58.0	5.00	9g	-0320A	-0320B	-0320C
M6.0 x 0.75	19.0	66.0	6.30	17g	-0360A	-0360B	-0360C
M8.0 x 1.00 <sup>(1)</sup>	19.0	72.0	8.00	21g	-0400A	-0400B	-0400C
M10.0 x 1.25 <sup>(1)</sup>	20.0	80.0	10.00	45g	-0440A	-0440B	-0440C
M12.0 x 1.25	29.0	89.0	9.00	46g	-0470A	-0470B	-0470C
M14.0 x 1.00	30.0	95.0	11.20	71g	-0485A	-0485B	-0485C
M14.0 x 1.50	30.0	95.0	11.20	76g	-0500A	-0500B	-0500C
M16.0 x 1.50	32.0	102.0	12.50	101g	-0520A	-0520B	-0520C
M18.0 x 1.50	45.0	95.0	14.00	132g	-0540A	-0540B	-0540C
M20.0 x 1.50	37.0	112.0	14.00	144g	-0560A	-0560B	-0560C
M22.0 x 1.50	38.0	118.0	16.00	86g	-0580A	-0580B	-0580C
M24.0 x 2.00	45.0	130.0	18.00	250g	-0600A	-0600B	-0600C
M30.0 x 1.50	37.0	127.0	20.00	398g	-0645A	-0645B	-0645C
M30.0 x 2.00	37.0	127.0	20.00	366g	-0650A	-0650B	-0650C
<b>ISO Metric Special Pitch</b>							
M2.0 x 0.45	8.0	41.0	2.50	3g	-0170A	-0170B	-0170C
M6.0 x 0.50	15.0	55.0	6.00	7g	-0355A	-0355B	-0355C
M8.0 x 0.75	19.0	72.0	8.00	22g	-0395A	-0395B	-0395C
M10.0 x 0.75	20.0	80.0	10.00	36g	-0425A	-0425B	-0425C
M10.0 x 1.00 <sup>(1)</sup>	24.0	80.0	10.00	38g	-0430A	-0430B	-0430C
M12.0 x 1.00	29.0	89.0	9.00	44g	-0465A	-0465B	-0465C
M12.0 x 1.50	29.0	89.0	9.00	48g	-0475A	-0475B	-0475C
M14.0 x 1.25	30.0	95.0	11.20	72g	-0490A	-0490B	-0490C
M16.0 x 1.00	32.0	102.0	12.50	96g	-0515A	-0515B	-0515C
M18.0 x 1.00	37.0	112.0	14.00	130g	-0535A	-0535B	-0535C
M20.0 x 1.00	37.0	112.0	14.00	146g	-0555A	-0555B	-0555C
M24.0 x 1.50	45.0	130.0	18.00	254g	-0595A	-0595B	-0595C
M25.0 x 1.50	45.0	130.0	18.00	260g	-0620A	-0620B	-0620C

Square AF	Tap Drill Size	Set of 3
		Order Code SHR-085
<b>Metric Fine</b>		
2.50	2.65	-0220D
2.80	3.15	-0250D
3.15	3.50	-0270D
4.00	4.50	-0320D
5.00	5.20	-0360D
6.30	7.00	-0400D
8.00	8.80	-0440D
7.10	10.80	-0470D
9.00	13.00	-0485D
9.00	12.50	-0500D
10.00	14.50	-0520D
11.20	16.80	-0540D
11.20	18.50	-0560D
12.50	20.50	-0580D
14.00	22.50	-0600D
16.00	28.50	-0645D
16.00	28.00	-0650D
<b>ISO Metric Special Pitch</b>		
5.00	5.50	-0355D
6.34	7.20	-0395D
8.00	9.20	-0425D
8.00	9.00	-0430D
7.10	11.00	-0465D
7.10	10.50	-0475D
9.00	12.80	-0490D
10.00	15.00	-0515D
11.20	17.00	-0535D
11.20	19.00	-0555D
14.00	22.50	-0595D
14.00	23.50	-0620D
18.00	30.50	-

## Metric Fine HSS Ground Thread Dies

BS 1127  
For use in diestocks to produce external screw threads.



Size - Pitch (mm)	Outside Diameter	Thickness	Weight each	Order Code SHR-086
<b>Metric Fine</b>				
M4.0 x 0.50	13/16"	1/4"	12g	-1930K
M5.0 x 0.50	13/16"	1/4"	12g	-1950K
M6.0 x 0.50	13/16"	1/4"	12g	-0190K
M6.0 x 0.75	13/16"	1/4"	12g	-1980K
M8.0 x 1.00	1"	3/8"	27g	-2040K
M10.0 x 1.25	1"	3/8"	25g	-2080K
M10.0 x 1.25	1 5/16"	7/16"	53g	-2130K
M12.0 x 1.25	1 5/16"	7/16"	53g	-2150K
M14.0 x 1.00	1 5/16"	7/16"	48g	-0655K
M14.0 x 1.50	1 5/16"	7/16"	49g	-2180K
M16.0 x 1.50	1 1/2"	1/2"	73g	-2220K
M18.0 x 1.50	1 1/2"	1/2"	74g	-2230K
M20.0 x 1.50	1 1/2"	1/2"	66g	-2250K
M20.0 x 1.50	2"	5/8"	154g	-2330K
M22.0 x 1.50	2"	5/8"	178g	-2350K
M24.0 x 2.00	2"	5/8"	153g	-2380K
<b>ISO Metric Special Pitch</b>				
M5.0 x 0.90	13/16"	1/4"	12g	-0185K
M8.0 x 0.75	1"	3/8"	27g	-2030K
M10.0 x 1.00	1"	3/8"	25g	-2070K
M12.0 x 1.00	1 5/16"	7/16"	50g	-2140K
M12.0 x 1.50	1 5/16"	7/16"	53g	-2160K
M14.0 x 1.25	1 5/16"	7/16"	48g	-2170K
M16.0 x 1.00	1 1/2"	1/2"	68g	-2210K
M20.0 x 1.00	1 1/2"	1/2"	64g	-2240K
M24.0 x 1.50	2"	5/8"	145g	-2370K
M25.0 x 1.50	2"	5/8"	145g	-2390K

HSS

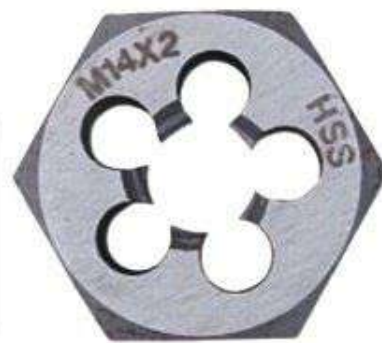
METRIC FINE

## Metric Fine HSS Ground Thread Die Nuts

BS 1127  
For use with spanners to clean and repair existing external screw threads.



Group 582



METRIC FINE

Size - Pitch (mm)	Width	Thickness	Weight each	Order Code SHR-086
<b>Metric Fine</b>				
M6.0 x 0.75	0.71"	1/4"	10g	-2550K
M8.0 x 1.00	0.82"	5/16"	16g	-2590K
M10.0 x 1.25	0.92"	3/8"	24g	-2640K
M12.0 x 1.25	1.10"	1/2"	46g	-2660K
M14.0 x 1.50	1.30"	5/8"	77g	-2770K
M16.0 x 1.50	1.30"	5/8"	71g	-2790K
M18.0 x 1.50	1.48"	11/16"	102g	-2810K
M20.0 x 1.50	1.48"	11/16"	92g	-2830K
M22.0 x 1.50	1.67"	13/16"	146g	-2860K
M24.0 x 2.00	2.05"	1 5/16"	249g	-2890K
<b>ISO Metric Special Pitch</b>				
M10.0 x 0.75	0.92"	3/8"	22g	-1495K
M10.0 x 1.00	0.92"	3/8"	22g	-2630K
M12.0 x 1.00	1.10"	1/2"	35g	-2650K
M12.0 x 1.50	1.10"	1/2"	52g	-2670K
M14.0 x 1.25	1.30"	5/8"	70g	-2760K
M24.0 x 1.50	2.05"	1 5/16"	249g	-2880K





**Metric Fine HSS Ground Thread Taps**

ISO 529

Spiral Point/Gun Nose

**METRIC FINE**

... = Metric Spark Plug  
\* = Metric Conduit



Size - Pitch (mm)	Shank Diameter	A/F Square	Weight each	Order Code SHR-085
<b>Metric Fine</b>				
M5.0 x 0.50	5.00	4.00	10g	-0320E
M6.0 x 0.75	6.30	5.00	27g	-0360E
M8.0 x 1.00	8.00	6.30	23g	-0400E
M10.0 x 1.25	10.00	8.00	40g	-0440E
M12.0 x 1.25	9.00	7.10	48g	-0470E
M14.0 x 1.50	11.20	9.00	78g	-0500E
M16.0 x 1.50	12.50	10.00	82g	-0520E
M18.0 x 1.50	14.00	11.20	132g	-0540E
M20.0 x 1.50	14.00	11.20	159g	-0560E
M22.0 x 1.50	16.00	12.50	185g	-0580E
<b>ISO Metric Special Pitch</b>				
M10.0 x 1.00	10.00	8.00	40g	-0430E
M12.0 x 1.50	9.00	7.10	40g	-0475E

Spiral Flute

... = Metric Spark Plug  
\* = Metric Conduit

**METRIC FINE HSS**



Size - Pitch (mm)	Shank Diameter	A/F Square	Weight each	Order Code SHR-085
<b>Metric Fine</b>				
M4.0 x 0.50	4.00	3.15	6g	-0270F
M5.0 x 0.50	5.00	4.00	10g	-0320F
M8.0 x 1.00	8.00	6.30	22g	-0400F
M10.0 x 1.25	10.00	8.00	37g	-0440F
M12.0 x 1.25	9.00	7.10	47g	-0470F
M14.0 x 1.50	11.20	9.00	75g	-0500F
M16.0 x 1.50	12.50	10.00	82g	-0520F
M18.0 x 1.50	14.00	11.00	148g	-0540F
M20.0 x 1.50	14.00	11.20	131g	-0560F
<b>ISO Metric Special Pitch</b>				
M10.0 x 1.00	10.00	8.00	38g	-0430F
M12.0 x 1.50	9.00	7.10	48g	-0475F
M14.0 x 1.25	11.20	9.00	75g	-0490F

**HSS Ground Flute Tap & Drill Set**

Industrial quality. Ground flute, blue finish. Supplied in indexing metal cases. Manufactured to BS328 : Part 1 : 1986, DIN 338N & ANSI B94 -11M.

**METRIC COARSE**



**28**  
PIECES

**METRIC Tap & Drill** Taps M3 - M12 + Tapping Drills 2.5 - 10.2

**28 Piece Tap & Drill Set**  
Taps (Taper, Second and Bottom)

M3 M4	M5 M6	M8 M10	M12
<b>Tapping Drills</b>			
(mm) 2.5	3.3 4.2	5.0 6.8	8.5 10.2

Number of Pieces: 28  
Order Code: SHR-025  
-9960K

**Machine Tapping Speeds**

Group	Materials Colour defines similar machineability	Hardness		Tensile Strength N/mm <sup>2</sup>	Cutting Speed M/min	Hole Type	Tap Type
		Brinell HB	Rockwell HRC				
Carbon	1.1 Mild Steel	<130	-	<400	15 - 20	Various Through Hole Blind Hole	Straight Flute Spiral Point/ Gun Nose Spiral Flute
	1.2 Case Hardening & Structural Steel	<200	-	<700	15 - 20		
	1.3 Medium Carbon Steel	<260	<26	<850	15 - 20		
Alloy	1.4 Low Alloy Steel	<260	<26	<850	10 - 15	Through Hole Blind Hole	Spiral Point/ Gun Nose Spiral Flute
	1.5 Medium to High Alloy Steel	260 - 340	26 - 36	850 - 1200	6 - 10		
	1.6 Heat Treated Steel	340 - 450	36 - 48	1200 - 1500	4 - 6		
Stainless Steels	2.1 Free Machining Stainless	<230	<20	<800	8 - 10	Through Hole Blind Hole	Spiral Point/ Gun Nose Spiral Flute
	2.2 Medium Strength Austenitic Stainless	<290	<30	<1000	6 - 8		
	2.3 Difficult to Machine, Duplex Stainless	<340	<36	<1200	4 - 6		
Cast Iron	3.1 Grey Cast Iron - Soft	<180	-	-	18 - 25	Blind & Through Hole	Straight Flute
	3.2 Grey Cast Iron - Hard	180 - 300	-	-	15 - 18		
	3.3 Malleable & Nodular Iron	<220	-	-	8 - 12	Through Hole	Spiral Point/ Gun Nose
	3.4 Malleable & Nodular Iron - Hard	200 - 300	-	-	4 - 6		
Aluminium	7.1 Unalloyed Aluminium - Zinc - Magnesium	-	-	<150	20 - 25	Blind & Through Hole	Fluteless
	7.2 Aluminium Alloy less than 5% Si	-	-	150 - 300	17 - 22		
	7.3 Aluminium Alloy 5% to 10% Si	-	-	200 - 500	15 - 20		
	7.4 Aluminium Alloy above 10% Si	-	-	200 - 500	12 - 15		

**Power Requirements For Taps**

Many factors are involved when considering power requirements for a particular application. Factors such as the choice of tap design, tapping drill size, depth of threaded hole, lubricant and tapping speed all play a part in determining these requirements.

To estimate the power requirements for varying percentage thread depths, the following general formula and constants may be used:

$$\text{Tapping Power (KW)} = \frac{C \times D \times p^2 \times N \times K}{10000}$$

$$\text{HP} = \text{KW} \times 1.341$$

Where D = Thread Diameter (mm)  
P = Pitch (mm)  
N = Spindle speed RPM  
K = Material Factor Constant  
C = A constant based on % thread depth, as follows:

C	% Thread Depth
0.231	60
0.326	75
0.433	80





UNC (Unified Coarse)  
HSS Ground Thread Taps

ISO 529



Straight Flute Individual Sizes

Size - Pitch	Thread Length	Overall Length	Shank Diameter	Weight each	Taper			Second			Plug			Set of 3 Order Code SHR-085
					Order Code SHR-085	Order Code SHR-085	Order Code SHR-085	Order Code SHR-085	Order Code SHR-085	Order Code SHR-085	Order Code SHR-085	Order Code SHR-085	Order Code SHR-085	
No.4 x 40	11.0	48.0	3.15	3g	-0790A	-0790B	-0790C	-0790D	-0790E	-0790F	-0790G	-0790H	-0790D	
No.6 x 32	13.0	50.0	3.55	4g	-0810A	-0810B	-0810C	-0810D	-0810E	-0810F	-0810G	-0810H	-0810D	
No.8 x 32	13.0	53.0	4.50	7g	-0820A	-0820B	-0820C	-0820D	-0820E	-0820F	-0820G	-0820H	-0820D	
No.10 x 24	16.0	58.0	5.00	8g	-0830A	-0830B	-0830C	-0830D	-0830E	-0830F	-0830G	-0830H	-0830D	
No.12 x 24	17.0	62.0	5.60	11g	-0840A	-0840B	-0840C	-0840D	-0840E	-0840F	-0840G	-0840H	-0840D	
1/4" x 20	19.0	66.0	6.30	14g	-0850A	-0850B	-0850C	-0850D	-0850E	-0850F	-0850G	-0850H	-0850D	
5/16" x 18	22.0	72.0	8.00	22g	-0860A	-0860B	-0860C	-0860D	-0860E	-0860F	-0860G	-0860H	-0860D	
3/8" x 16	24.0	80.0	10.00	38g	-0870A	-0870B	-0870C	-0870D	-0870E	-0870F	-0870G	-0870H	-0870D	
7/16" x 14	25.0	85.0	8.00	38g	-0880A	-0880B	-0880C	-0880D	-0880E	-0880F	-0880G	-0880H	-0880D	
1/2" x 13	29.0	89.0	9.00	50g	-0890A	-0890B	-0890C	-0890D	-0890E	-0890F	-0890G	-0890H	-0890D	
9/16" x 12	30.0	95.0	11.20	75g	-0900A	-0900B	-0900C	-0900D	-0900E	-0900F	-0900G	-0900H	-0900D	
5/8" x 11	32.0	102.0	12.50	82g	-0910A	-0910B	-0910C	-0910D	-0910E	-0910F	-0910G	-0910H	-0910D	
3/4" x 10	37.0	112.0	14.00	142g	-0920A	-0920B	-0920C	-0920D	-0920E	-0920F	-0920G	-0920H	-0920D	
7/8" x 9	38.0	118.0	16.00	193g	-	-	-	-	-	-	-	-	-0930D	
1" x 8	45.0	130.0	18.00	323g	-0940A	-0940B	-0940C	-0940D	-0940E	-0940F	-0940G	-0940H	-0940D	

Sets of Three  
1 each, taper, second  
and plug lead.

UNC HSS



UNC (Unified Coarse)  
HSS Ground Thread Taps

ISO 529  
Spiral Point/Gun Nose



Size - Pitch	Shank Dia.	A/F Square	Weight each	Order Code SHR-085
No.3 x 48	2.80	2.24	2g	-0780E
No.4 x 40	3.15	2.50	1g	-0790E
No.5 x 40	3.15	2.50	2g	-0800E
No.6 x 32	3.55	2.80	2g	-0810E
No.8 x 32	4.50	3.55	4g	-0820E
No.10 x 24	5.00	4.00	5g	-0830E
No.12 x 24	5.60	4.50	8g	-0840E
1/4" x 20	6.30	5.00	11g	-0850E
5/16" x 18	8.00	6.30	17g	-0860E
3/8" x 16	10.00	8.00	33g	-0870E
7/16" x 14	8.00	6.30	38g	-0880E
1/2" x 13	9.00	7.10	44g	-0890E
9/16" x 12	11.20	9.00	62g	-0900E
5/8" x 11	12.50	10.00	91g	-0910E
3/4" x 10	14.00	11.20	130g	-0920E
7/8" x 9	16.00	12.20	173g	-0930E
1" x 8	18.00	14.00	294g	-0940E

UNC HSS

Spiral Flute



UNC HSS

Size - Pitch	Shank Dia.	A/F Square	Weight each	Order Code SHR-085
No.3 x 48	2.80	2.24	1g	-0780F
No.4 x 40	3.15	2.50	1g	-0790F
No.5 x 40	3.15	2.50	2g	-0800F
No.6 x 32	3.55	2.80	3g	-0810F
No.8 x 32	4.50	3.55	4g	-0820F
No.10 x 24	5.00	4.00	5g	-0830F
1/4" x 20	6.30	5.00	11g	-0850F
5/16" x 18	8.00	6.30	19g	-0860F
3/8" x 16	10.00	8.00	31g	-0870F
1/2" x 13	9.00	7.10	41g	-0890F
9/16" x 11	12.50	10.00	89g	-0910F
3/4" x 10	14.00	11.20	123g	-0920F
1" x 8	18.00	14.00	240g	-0940F

UNC (Unified Coarse)  
HSS Ground Thread Dies

BS 1127  
For use in diestocks to produce  
external screw threads.

UNC HSS



Size - Pitch	Outside Diameter	Thickness	Weight each	Order Code SHR-086
No.6 x 32	13/16"	1/4"	7g	-3020K
No.8 x 32	13/16"	1/4"	13g	-3030K
No.10 x 24	13/16"	1/4"	17g	-3040K
1/4" x 20	13/16"	3/8"	12g	-3060K
1/4" x 20	1"	3/8"	26g	-3220K
5/16" x 18	1"	3/8"	27g	-3230K
3/8" x 16	1"	3/8"	24g	-3240K
3/8" x 16	1 1/16"	7/16"	62g	-3360K
7/16" x 14	1"	3/8"	27g	-3250K
1/2" x 13	1 1/16"	3/16"	52g	-3380K
1/2" x 13	1 1/2"	1/2"	79g	-3480K
5/8" x 11	1 1/2"	1/2"	71g	-3500K
3/4" x 10	1 1/2"	1/2"	70g	-3510K

UNC (Unified Coarse)  
HSS Ground Thread  
Die Nuts

BS 1127  
For use with spanners to clean  
and repair existing external  
screw threads.

UNC HSS



Size - Pitch	Width	Thickness	Weight each	Order Code SHR-086
1/4" x 20	0.71"	1/4"	13g	-3920K
5/16" x 18	0.82"	5/16"	12g	-3950K
3/8" x 16	0.92"	3/8"	11g	-3970K
7/16" x 14	1.01"	7/16"	33g	-3990K
1/2" x 13	1.10"	1/2"	45g	-4010K
5/8" x 11	1.30"	5/8"	72g	-4040K
3/4" x 10	1.48"	11/16"	102g	-4070K
1" x 8	2.05"	19/16"	269g	-4110K





## UNF (Unified Fine) HSS Ground Thread Taps

ISO 529



### Straight Flute Individual Sizes

Size - Pitch	Thread Length	Overall Length	Shank Diameter	Taper	Second	Plug
				Order Code SHR-085	Order Code SHR-085	Order Code SHR-085
No.5 x 44	11.0	48.0	3.15	-	-1060B	-
No.8 x 36	13.0	53.0	4.50	-1080A	-1080B	-1080C
No.10 x 32	16.0	58.0	5.00	-1090A	-1090B	-1090C
No.12 x 28	17.0	62.0	5.60	-1100A	-1100B	-1100C
1/4" x 28	19.0	66.0	6.30	-1110A	-1110B	-1110C
5/16" x 24	19.0	69.0	8.00	-1120A	-1120B	-1120C
3/8" x 24	20.0	76.0	10.00	-1130A	-1130B	-1130C
7/16" x 20	25.0	85.0	8.00	-1140A	-1140B	-1140C
1/2" x 20	29.0	89.0	9.00	-1150A	-1150B	-1150C
9/16" x 18	30.0	95.0	11.20	-1160A	-1160B	-1160C
5/8" x 18	32.0	102.0	12.50	-1170A	-1170B	-1170C
3/4" x 16	37.0	112.0	14.00	-1180A	-1180B	-1180C

Sets of Three  
1 each, taper, second and plug lead.

UNC HSS



### Set of 3

Order Code SHR-085
-1060D
-1080D
-1090D
-
-1110D
-1120D
-1130D
-1140D
-1150D
-1160D
-1170D
-1180D

## UNF (Unified Fine) HSS Ground Thread Taps

Spiral Flute

UNF HSS



UNF HSS

## UNF (Unified Fine) HSS Ground Thread Taps

Spiral Point/Gun Nose



Size - Pitch	Shank Dia.	A/F Square	Weight each	Order Code SHR-085
No.6 x 40	3.55	2.80	4g	-1070F
No.8 x 36	4.50	3.55	6g	-1080F
No.10 x 32	5.00	4.00	7g	-1090F
1/4" x 28	6.30	5.00	14g	-1110F
5/16" x 24	8.00	6.30	22g	-1120F
3/8" x 24	10.00	8.00	37g	-1130F
7/16" x 20	8.00	6.30	39g	-1140F
1/2" x 20	9.00	7.10	48g	-1150F
9/16" x 18	11.20	9.00	75g	-1160F
5/8" x 18	12.50	10.00	95g	-1170F
3/4" x 16	14.00	11.20	131g	-1180F

Size - Pitch	Shank Dia.	A/F Square	Weight each	Order Code SHR-085
No.6 x 40	3.55	2.80	5g	-1070E
No.8 x 36	4.50	3.55	7g	-1080E
No.10 x 32	5.00	4.00	7g	-1090E
No.12 x 28	5.60	4.50	11g	-1100E
1/4" x 28	6.30	5.00	15g	-1110E
5/16" x 24	8.00	6.30	23g	-1120E
3/8" x 24	10.00	8.00	37g	-1130E
7/16" x 20	8.00	6.30	33g	-1140E
1/2" x 20	9.00	7.10	52g	-1150E
9/16" x 18	11.20	9.00	71g	-1160E
5/8" x 18	12.50	10.00	100g	-1170E
3/4" x 16	14.00	11.20	156g	-1180E

## UNF (Unified Fine) HSS Ground Thread Dies

ISO 529

For use in diestocks to produce external screw threads.

UNF HSS



### UNF (Unified Fine)

Size - Pitch	Outside Diameter	Thickness	Weight each	Order Code SHR-086
No.10 x 32	13/16"	1/4"	12g	-4300K
1/4" x 28	13/16"	1/4"	12g	-4320K
1/4" x 28	1"	3/8"	28g	-4490K
5/16" x 24	1"	3/8"	42g	-4500K
3/8" x 24	1"	3/8"	42g	-4510K
3/8" x 24	1 1/16"	7/16"	55g	-4640K
7/16" x 20	1"	3/8"	23g	-4520K
7/16" x 20	1 1/16"	7/16"	53g	-4650K
1/2" x 20	1 1/16"	7/16"	51g	-4660K
1/2" x 20	1 1/2"	1/2"	73g	-4780K
9/16" x 18	1 1/16"	7/16"	49g	-4670K
3/4" x 16	2"	5/8"	165g	-4970K
7/8" x 14	2"	5/8"	159g	-4980K
1" x 12	2"	5/8"	156g	-4990K

## UNF (Unified Fine) HSS Ground Thread Die Nuts

BS 1127

For use with spanners to clean and repair existing external screw threads.

UNF HSS



### UNF (Fine)

Size - Pitch	Width	Thickness	Weight each	Order Code SHR-086
1/4" x 28	0.71"	1/4"	10g	-5280K
3/16" x 24	0.92"	3/8"	24g	-5330K
7/16" x 20	1.10"	7/16"	33g	-5350K
1/2" x 20	1.10"	1/2"	44g	-5370K
9/16" x 18	1.30"	5/8"	76g	-5390K
5/8" x 18	1.30"	5/8"	72g	-5400K





**BSW HSS**

**BSW (British Standard Whitworth) HSS Ground Thread Taps**

ISO 529  
Spiral Point/Gun Nose



Size - Pitch	Shank Dia.	A/F Square	Weight each	Order Code SHR-085
1/8" x 40	3.15	2.50	3g	-1320E
3/16" x 24	5.00	4.00	8g	-1340E
1/4" x 20	6.30	5.00	15g	-1360E
5/16" x 18	8.00	6.30	23g	-1370E
3/8" x 16	10.00	8.00	38g	-1380E
5/8" x 11	12.50	10.00	62g	-1420E
3/4" x 10	14.00	11.20	85g	-1430E



**BSW (British Standard Whitworth) HSS Ground Thread Taps**

ISO 529



**Straight Flute Individual Sizes**

Size - Pitch	Thread Length	Overall Length	Shank Diameter	Weight each	Taper			Second			Plug		
					Order Code SHR-085	Order Code SHR-085	Order Code SHR-085	Order Code SHR-085	Order Code SHR-085	Order Code SHR-085	Order Code SHR-085	Order Code SHR-085	Order Code SHR-085
1/8" x 40	16.0	48.0	3.15	1g	-1320A	-1320B	-1320C	-1320A	-1320B	-1320C	-1320A	-1320B	-1320C
3/16" x 24	16.0	58.0	5.00	8g	-1340A	-1340B	-1340C	-1340A	-1340B	-1340C	-1340A	-1340B	-1340C
1/4" x 20	19.0	66.0	6.30	14g	-1360A	-1360B	-1360C	-1360A	-1360B	-1360C	-1360A	-1360B	-1360C
5/16" x 18	22.0	72.0	8.00	23g	-1370A	-1370B	-1370C	-1370A	-1370B	-1370C	-1370A	-1370B	-1370C
3/8" x 16	24.0	80.0	10.00	38g	-1380A	-1380B	-1380C	-1380A	-1380B	-1380C	-1380A	-1380B	-1380C
7/16" x 14	25.0	85.0	8.00	37g	-1390A	-1390B	-1390C	-1390A	-1390B	-1390C	-1390A	-1390B	-1390C
1/2" x 12	29.0	89.0	9.00	49g	-1400A	-1400B	-1400C	-1400A	-1400B	-1400C	-1400A	-1400B	-1400C
5/8" x 11	32.0	102.0	12.50	98g	-1420A	-1420B	-1420C	-1420A	-1420B	-1420C	-1420A	-1420B	-1420C
3/4" x 10	37.0	112.0	14.00	143g	-1430A	-1430B	-1430C	-1430A	-1430B	-1430C	-1430A	-1430B	-1430C
1" x 8	45.0	130.0	18.00	269g	-1450A	-1450B	-1450C	-1450A	-1450B	-1450C	-1450A	-1450B	-1450C

**BSW (British Standard Whitworth) HSS Ground Thread Die Nuts**

BS 1127  
For use with spanners to clean and repair existing external screw threads.



Size - Pitch	Width	Thickness	Weight each	Order Code SHR-086
1/4" x 20	0.71"	1/4"	10g	-6490K
5/16" x 18	0.82"	5/16"	16g	-6570K
3/8" x 16	0.92"	3/8"	25g	-6590K
7/16" x 14	1.01"	7/16"	35g	-6610K
1/2" x 12	1.10"	1/2"	44g	-6630K
5/8" x 11	1.30"	5/8"	78g	-6660K
3/4" x 10	1.48"	11/16"	102g	-6700K
1" x 8	2.05"	15/16"	265g	-6780K

**Spiral Flute**

**BSW HSS**



Size - Pitch	Shank Dia.	A/F Square	Weight each	Order Code SHR-085
1/8" x 40	3.15	2.50	2g	-1320F
3/16" x 24	5.00	4.00	6g	-1340F
1/4" x 20	6.30	5.00	14g	-1360F
5/16" x 18	8.00	6.30	26g	-1370F
3/8" x 16	10.00	8.00	37g	-1380F
7/16" x 14	8.00	6.30	21g	-1390F
1/2" x 12	9.00	7.10	46g	-1400F
5/8" x 11	12.50	10.00	60g	-1420F
3/4" x 10	14.00	11.20	75g	-1430F

**Fluteless**

**BSW HSS**



Size - Pitch	Shank Dia.	Weight each	Order Code SHR-085
1/4" x 20	6.30	14g	-1360K

**Sets of Three**

1 each, taper, second and plug lead.

**BSW HSS**



Order Code SHR-085	Order Code SHR-085	Order Code SHR-085	Order Code SHR-085
-1320D	-1340D	-1360D	-1370D
-1380D	-1390D	-1400D	-1420D
-1430D	-1450D		

**BSW (British Standard Whitworth) HSS Ground Thread Dies**

BS 1127  
For use in diestocks to produce external screw threads.



Size - Pitch	Outside Diameter	Thickness	Weight each	Order Code SHR-086
1/8" x 40	13/16"	1/4"	13g	-5600K
3/16" x 24	13/16"	1/4"	12g	-5620K
1/4" x 20	13/16"	1/4"	12g	-5640K
5/16" x 18	1"	3/8"	27g	-5730K
3/8" x 16	1"	3/8"	27g	-5740K
7/16" x 14	1 1/16"	7/16"	54g	-5810K
1/2" x 12	1 1/16"	7/16"	53g	-5820K
5/8" x 11	1 1/2"	1/2"	52g	-5940K
3/4" x 10	1 1/2"	1/2"	71g	-5960K
			66g	-5980K





## BSP(F) (British Standard Pipe Fittings) HSS Ground Thread Taps

ISO 529

Sets of Three

1 each, taper, second and plug lead.

**BSP HSS**



### Straight Flute Individual Sizes

Size - Pitch	Thread Length	Overall Length	Shank Diameter	Weight each	Taper	Second	Plug	Set of 3 Order Code SHR-085
					Order Code SHR-085	Order Code SHR-085	Order Code SHR-085	
1/8" x 28	15.0	59.0	8.0	26g	-2010A	-2010B	-2010C	-2010D
1/4" x 19	19.0	67.0	10.0	47g	-2020A	-2020B	-2020C	-2020D
3/8" x 19	21.0	75.0	12.5	75g	-2030A	-2030B	-2030C	-2030D
1/2" x 14	26.0	87.0	16.0	137g	-2040A	-2040B	-2040C	-2040D
5/8" x 14	26.0	91.0	18.0	191g	-	-	-	-2050D
3/4" x 14	28.0	96.0	20.0	228g	-2060A	-2060B	-2060C	-2060D
7/8" x 14	29.0	102.0	22.4	228g	-	-2070B	-	-
1" x 11	33.0	109.0	25.0	446g	-2080A	-2080B	-2080C	-2080D

## BSP(F) (British Standard Pipe Fine) HSS Ground Thread Taps

ISO 529

Spiral Point/Gun Nose



Size - Pitch	Shank Dia. (mm)	A/F Square (mm)	Weight each	Order Code SHR-085
1/8" x 28	8.0	6.3	24g	-2010E
1/4" x 19	10.0	8.0	51g	-2020E
3/8" x 19	12.5	10.0	85g	-2030E
1/2" x 14	16.0	12.5	143g	-2040E
3/4" x 14	20.0	16.0	250g	-2060E

**BSP HSS**

## BSP(F) (British Standard Pipe Fitting) HSS Ground Thread Taps

ISO 529

Spiral Flute



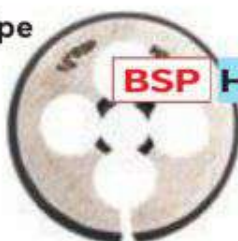
Size - Pitch	Shank Dia. (mm)	A/F Square (mm)	Weight each	Order Code SHR-085
1/8" x 28	8.0	6.3	24g	-2010F
1/4" x 19	10.0	8.0	51g	-2020F
3/8" x 19	12.5	10.0	85g	-2030F
1/2" x 14	16.0	12.5	143g	-2040F
3/4" x 14	20.0	16.0	250g	-2060F

**BSP HSS**

## BSP(F) (British Standard Pipe Fitting) HSS Ground Thread Dies

BS 1127

For use in diestocks to produce external screw threads.



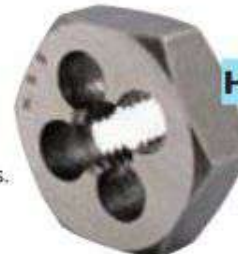
**BSP HSS**

Size - Pitch	Outside Diameter	Thickness	Weight each	Order Code SHR-086
1/8" x 28	1"	3/8"	26g	-8620K
1/8" x 28	1 1/16"	7/16"	50g	-8640K
1/4" x 19	1 1/16"	7/16"	50g	-8650K
1/4" x 19	1 1/2"	1/2"	76g	-8690K
3/8" x 19	1 1/2"	1/2"	75g	-8700K
1/2" x 14	2"	5/8"	158g	-8760K
3/4" x 14	2"	5/8"	144g	-8780K

## BSP(F) (British Standard Pipe Fitting) HSS Ground Thread Die Nuts

BS 1127

For use with spanners to clean and repair existing external screw threads.

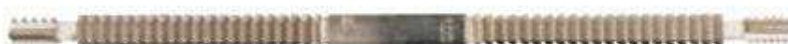


**HSS**

Size - Pitch	Width	Thickness	Weight each	Order Code SHR-086
1/8" x 28	0.92"	3/8"	23g	-8940K
1/4" x 19	1.10"	1/2"	43g	-8960K
3/8" x 19	1.30"	5/8"	80g	-8980K
1/2" x 14	1.67"	13/16"	161g	-9000K
3/4" x 14	2.05"	15/16"	247g	-9040K
1" x 11	2.58"	1 1/8"	428g	-9080K

## Thread Restoring Files

Restore internal and external threads by filing, where the use of taps and dies are impractical. The restorer file overlaps several good threads and files the damaged ones. Restore right and left hand, internal and external threads. Long lasting, fast cutting teeth. Thread restoring files are available in ISO, Whit/BSF, UNF/UNC and BSP thread types.



Thread Type	Range	Weight each	Order Code SHR-017
ISO	80 to 3mm	133g	-9020C
Whit/BSF	10 tpi to 24 tpi	132g	-9001A
UNF/UNC	11 tpi to 24 tpi	130g	-9010B
BSP	11 tpi to 28 tpi	127g	-9030D





**BSF (British Standard Fine)  
HSS Ground Thread Taps**

ISO 529

Sets of Three  
1 each, taper,  
second and plug lead.

**BSF HSS**



**Straight Flute Individual Sizes**

Size - Pitch	Thread Length	Overall Length	Shank Diameter	Weight each	Taper	Second	Plug	Set of 3
					Order Code	Order Code	Order Code	
3/16" x 32	16.0	58.0	5.0	8g	SHR-085 -1600A	SHR-085 -1600B	SHR-085 -1600C	SHR-085 -1600D
1/4" x 26	19.0	66.0	6.3	14g	SHR-085 -1610A	SHR-085 -1610B	SHR-085 -1610C	SHR-085 -1610D
5/16" x 22	22.0	72.0	8.0	23g	SHR-085 -1630A	SHR-085 -1630B	SHR-085 -1630C	SHR-085 -1630D
3/8" x 20	24.0	80.0	10.0	38g	SHR-085 -1640A	SHR-085 -1640B	SHR-085 -1640C	SHR-085 -1640D
7/16" x 18	25.0	85.0	8.0	24g	SHR-085 -1650A	SHR-085 -1650B	SHR-085 -1650C	SHR-085 -1650D
1/2" x 16	29.0	89.0	9.0	30g	SHR-085 -1660A	SHR-085 -1660B	SHR-085 -1660C	SHR-085 -1660D
5/8" x 14	32.0	102.0	12.5	60g	-	SHR-085 -1680B	SHR-085 -1680C	SHR-085 -1680D
3/4" x 12	37.0	112.0	14.0	85g	SHR-085 -1690A	SHR-085 -1690B	SHR-085 -1690C	SHR-085 -1690D

**BSF (British Standard Fine)  
HSS Ground Thread Taps**

ISO 529

**BSF HSS**



**Spiral Point/Gun Nose**

Size - Pitch	Shank Dia.	A/F Square	Weight each	Order Code
3/8" x 20	10.0	8.0	40g	SHR-085 -1640E
7/16" x 18	8.0	6.3	35g	SHR-085 -1650E
1/2" x 16	9.0	7.1	54g	SHR-085 -1660E

**BSF (British Standard Fine)  
HSS Ground Thread Taps**

ISO 529

**BSF HSS**



**Spiral Flute**

Size - Pitch	Shank Dia.	A/F Square	Weight each	Order Code
1/4" x 26	6.3	5.0	15g	SHR-085 -1610F
3/8" x 20	10.0	8.0	40g	SHR-085 -1640F
1/2" x 16	9.0	7.1	50g	SHR-085 -1660F

**BSF (British Standard Fine)  
HSS Ground Thread Dies**

BS 1127

For use in diestocks to produce external screw threads.

**BSF HSS**



Size - Pitch	Outside Diameter	Thickness	Weight each	Order Code
3/16" x 32	13/16"	1/4"	12g	SHR-086 -6950K
1/4" x 26	1"	3/8"	27g	SHR-086 -7020K
5/16" x 22	1"	3/8"	27g	SHR-086 -7030K
3/8" x 20	1"	3/8"	26g	SHR-086 -7040K
7/8" x 20	1 5/16"	7/16"	51g	SHR-086 -7100K

**BSF (British Standard Fine)  
HSS Ground Thread Die Nuts**

BS 1127

For use with spanners to clean and repair existing external screw threads.

**BSF HSS**



Size - Pitch	Width	Thickness	Weight each	Order Code
1/4" x 26	0.71"	1/4"	10g	SHR-086 -7720K
3/8" x 20	0.92"	3/8"	24g	SHR-086 -7780K
1/2" x 16	1.10"	1/2"	48g	SHR-086 -7820K
5/8" x 14	1.30"	5/8"	78g	SHR-086 -7850K
3/4" x 12	1.48"	11/16"	108g	SHR-086 -7890K





## BSP(F) Threading Set

HSSGT Straight Flute Taps:

Taper: 1/8" x 28, 1/4" x 19, 3/8" x 19 and 1/2" x 14.

Second: 3/4" x 14.

Plug: 1/8" x 28, 1/4" x 19, 3/8" x 19 and 1/2" x 14.

Outside Diameter HSS Dies BSPF x 1 5/16":

1/8" x 28, 1/4" x 19 and 3/8" x 19.

BSPF HSS Hexagon

Die Nuts: 1/2" x 14 and 3/4" x 14.

HSS Straight Shank Jobber Drills: 8.80 and 11.80mm,

Parallel Shank Drills 1/2": 15.25, 19.00 and 24.50mm.

Holder: 1 5/16" outside diameter diestock.

Traditional Tap Wrenches: 1/16" - 1/4" and 1/4" - 3/4".



BSP HSS

22  
PIECES

Range	Number of Pieces	Order Code
1/16" - 3/4" BSPF	22	SHR-086 -9989K

## BSPT (British Standard Pipe Taper) HSS Ground Thread Taps

ISO 529

Straight Flute



R = With Reamer

NR = Without Reamer

Size - Pitch	Thread Length (mm)	Shank Diameter (mm)	Overall Length (mm)	Weight each	Square AF	Tap Drill Size R	Tap Drill Size NR	Order Code SHR-085	Order Code SHR-085	Order Code SHR-085
1/8" x 28	15.0	8.0	59.0	29g	6.30	8.00	8.40	-	-	-2200C
1/4" x 19	19.0	10.0	67.0	50g	8.00	10.80	11.20	-	-	-2210C
3/8" x 19	21.0	12.5	75.0	66g	10.00	14.25	14.75	-	-	-2220C
1/2" x 14	26.0	16.0	87.0	142g	12.50	17.75	18.25	-	-	-2230C
3/4" x 14	28.0	20.0	96.0	241g	16.00	23.00	23.75	-	-	-2240C
1" x 11	33.0	25.0	109.0	267g	20.00	29.00	30.00	-	-	-2250C



Page 65

BSPT HSS

Left Hand Also Available



Taper

Second

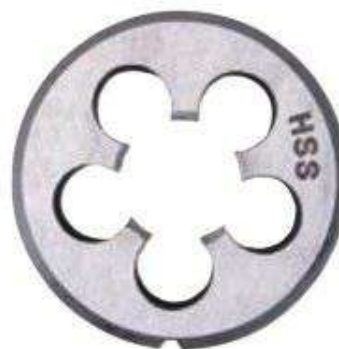
Plug

## BSPT (British Standard Pipe Taper) HSS Ground Thread Dies

ISO 2284

For use in diestocks to produce external screw threads.

Size - Pitch	Outside Diameter	Thickness	Weight each	Order Code SHR-086
1/8" x 28	1"	3/8"	26g	-9150K
1/4" x 19	1 1/16"	7/16"	62g	-9170K
3/8" x 19	1 1/2"	1/2"	75g	-9200K
1/2" x 14	2"	5/8"	175g	-9230K



BSPT HSS



Page 65

## NPTF (National Pipe Taper Fuel) HSS Ground Thread Taps

ANSI 94.9

Straight Flute

NPTF HSS

## NPT (National Pipe Taper) HSS Ground Thread Taps

ANSI 94.9

Straight Flute

Left Hand Also Available



Size - Pitch	Thread Length	Shank Diameter	Overall Length	Weight each	Order Code SHR-085
1/16" x 27	1 1/16"	0.312	2 1/8"	20g	-3010C
1/8" x 27	3/4"	0.437	2 1/8"	50g	-3020C
1/4" x 18	1 1/16"	0.562	2 7/16"	70g	-3030C
3/8" x 18	1 1/16"	0.700	2 9/16"	100g	-3040C
1/2" x 14	1 3/8"	0.687	3 1/8"	180g	-3050C
3/4" x 14	1 3/8"	0.906	3 1/4"	230g	-3060C
1" x 11.5	1 3/4"	1.125	3 3/4"	420g	-3070C



# HSS Taps & Dies



## NPT (National Pipe Taper) HSS Ground Thread Taps

ANSI 94.9  
Straight Flute



**Left Hand Also Available**

Size - Pitch	Thread Length	Overall Length (mm)	Shank Diameter	Weight each	Taper		
					Order Code SHR-085	Order Code SHR-085	Order Code SHR-085
1/16" x 27	1 1/16"	0.312	2 1/8"	20g	-	-	-3010C
1/8" x 27	3/8"	0.437	2 1/8"	50g	-	-	-3020C
1/4" x 18	1 1/16"	0.562	2 7/16"	70g	-	-	-3030C
3/8" x 18	1 1/16"	0.700	2 3/16"	100g	-	-	-3040C
1/2" x 14	1 3/8"	0.687	3 1/8"	180g	-	-	-3050C
3/4" x 14	1 3/8"	0.906	3 1/4"	230g	-	-	-3060C
1" x 11.5	1 3/4"	1.125	3 3/4"	420g	-	-	-3070C

## HSS Threading Set

Machine ground HSS taps and dies for general workshop and maintenance use. Conforms to ISO529 and BS1127.

**Contents:**  
Tap & Die Sizes: M3 x 0.50, M4 x 0.70, M5 x 0.80 and M6 x 1.00mm.  
'T' Type Tap Wrench (capacity M3 - M6).  
Die Holder 1" O/D.



**10 PIECES**

Range	Number of Pieces	Order Code
M3 - M6	10	SEN-086
		-9920K



## BA (British Association) HSS Ground Thread Taps

ISO 529



**BA HSS**

ISO 529 - 1975 (E)		Maximum Deviation on Thread Length	
Nominal Dia. of Tap Over	Including	+0.0	-2.5
-	5.5mm	+0.0	-3.2
5.5mm	12.0mm	+0.0	-5.0
12.0mm	39.0mm	+0.0	-6.5
39.0mm	-	-	-



### Straight Flute Individual Sizes

Size - Pitch	Shank Diameter	Weight each	Taper		
			Order Code SHR-085	Order Code SHR-085	Order Code SHR-085
No.0 x 0.0394	6.30	14g	-	-	-
No.2 x 0.0319	5.00	8g	-1820A	-1820B	-1820C
No.4 x 0.0260	3.55	4g	-1840A	-1840B	-1840C
No.5 x 0.0232	3.15	4g	-	-	-
No.6 x 0.0209	2.80	3g	-1860A	-1860B	-1860C
No.8 x 0.0169	2.80	3g	-	-	-
No.12 x 0.0110	2.50	3g	-	-	-1920C



Set of 3

Order Code
SHR-085
-1800D
-1820D
-1840D
-1850D
-1860D
-1880D



## BA (British Association) HSS Ground Thread Taps

Spiral Point/Gun Nose



Size - Pitch	Shank Dia.	A/F Square	Weight each	Order Code SHR-085
No.2 x 0.0319	5.00	4.00	9g	-1820E
No.4 x 0.0260	3.55	2.80	4g	-1840E
No.6 x 0.0209	2.80	2.24	3g	-1860E
No.8 x 0.0169	2.80	2.24	3g	-1880E

**BA HSS**

## BA (British Association) HSS Ground Thread Taps

Spiral Flute



Size - Pitch	Shank Dia.	A/F Square	Weight each	Order Code SHR-085
No.0 x 0.0394	6.30	5.00	14g	-1800F
No.2 x 0.0319	5.00	4.00	6g	-1820F
No.4 x 0.0260	3.55	2.80	4g	-1840F
No.8 x 0.0169	2.80	2.24	3g	-1880F

**BA HSS**

## NPTF (National Pipe Taper Fuel) HSS Ground Thread Taps

ANSI 94.9  
Straight Flute



Size - Pitch	Thread Length	Shank Diameter (mm)	Overall Length	Weight each	Order Code SHR-085
1/16" x 27	1 1/16"	0.312	2 1/8"	20g	-3400C
1/8" x 27	3/4"	0.437	2 1/8"	50g	-3410C
1/4" x 18	1 1/16"	0.562	2 7/16"	91g	-3420C
1/2" x 14	1 3/8"	0.687	3 1/8"	205g	-3440C

**NPTF HSS**

## NPT (National Pipe Taper) HSS Ground Thread Dies

For use in diestocks to produce external screw threads.



**NPT HSS**

Size - Pitch	Outside Diameter	Thickness	Weight each	Order Code SHR-086
1/8" x 27	1"	3/8"	22g	-9390K
1/4" x 27	1 1/16"	7/16"	44g	-9400K
1/2" x 18	1 1/8"	7/16"	69g	-9410K
3/4" x 27	1 1/2"	1/2"	55g	-9420K
1" x 18	1 1/2"	1/2"	88g	-9430K
1 1/2" x 14	2"	5/8"	159g	-9470K