



Taps



TAPS

YG-1 Machine Taps

YG-1 machine taps are all HSS 8% cobalt as standard for performance machine tapping operations.

Our range includes metric coarse pitch and metric fine pitch, spiral flute and spiral point and also cold forming roll taps.

Application

Tap grades are available for a wide range of machining applications from mild steel to exotics.

Coatings

We offer taps in uncoated grades with steam tempered, nitrided or bright finish and coated taps in TiN or hardslick coating.



TAPS

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Machine Taps Recommendation Table

TAPS

Material Groups	List of Materials	Material			
		Surface Treatment/Coating			
		Hardness HB	Tensile Strength	Chip	Cut Speed Vc m/mm
	<ul style="list-style-type: none"> ● Recommended ○ Suitable 				
Steels	Magnetic Soft steels	< 120	< 400	Extra Long	25-20
	Structure steels, case carbonising steels	< 200	< 700	Medium/Long	15-20
	Plain carbon steels	< 250	< 850	Long	12-18
	Alloy steels	< 250	< 850	Long	10-15
	Alloy steels/Hardened + Tempered steels	< 350	< 1,200	Long	6-10
	Alloy steels/Hardened + Tempered steels	> 350	> 1,200	Long	3-5
Stainless Steels	Free machining	< 250	< 850	Medium	7-10
	Austenitic	< 250	< 850	Long	5-8
	Ferritic, Ferritic+Austenitic, Martensitic	< 300	< 1,000	Long	4-6
Cast Iron	Grey Cast Iron	< 150	< 500	Extra short	10-15
	Grey Cast Iron	< 300	< 1,000	Extra short	5-8
	Nodular graphite, Malleable Cast iron	< 200	< 700	Short	10-15
	Nodular graphite, Malleable Cast iron	< 300	< 1,000	Short	5-8
Titanium	Titanium unalloyed	< 200	< 700	Extra Long	10-15
	Titanium alloyed	< 270	< 900	Medium/Short	8-12
	Titanium alloyed	< 350	< 1,250	Medium/Short	4-6
Nickel	Nickel unalloyed	< 150	< 500	Extra Long	8-12
	Nickel alloyed	< 270	< 900	Long	10-15
	Nickel alloyed	< 350	< 1,250	Long	2-4
Copper Brass Bronze	Copper, unalloyed	< 100	< 350	Extra Long	8-12
	Short chipping Brass, Bronze, Copper	< 200	< 700	Medium/Short	25-35
	Long chipping Brass, Bronze, Copper	< 200	< 700	Long	15-20
	AMPCO (Cu-Al-Fe alloys)	< 470	< 1,500	Short	3-5
Aluminium	Aluminium, Magnesium, unalloyed	< 100	< 350	Extra Long	10-15
	Aluminium, Alloyed Si < 0.5%	< 150	< 500	Medium	25-35
	Aluminium, Alloyed Si < 10%	< 120	< 400	Medium/Short	15-20
	Aluminium, Alloyed Si > 10%	< 120	< 400	Short	10-15
Sintetic Materials	Thermoplastics			Extra Long	20-30
	Thermosetting plastics			Short	8-12
	Reinforced plastic materials			Extra short	5-7

* For coated taps cutting speed can be doubled

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TAPS Metric Coarse Machine Taps



Spiral Flute Machine Taps - Metric Coarse Pitch - For Blind Holes

SPIRAL FLUTE UNCOATED HSSE
- RIGHT HAND

Ordering Code	Size	DIN	Pitch mm	Overall Length	Shank Dia	Size of Square	Drill Dia	2007 £
Series + 136	M2	371	0.40	45	2.8	2.1	1.60	6.01
Series + 176	M2.5	371	0.45	50	2.8	2.1	2.05	6.37
Series + 206	M3	371	0.50	56	3.5	2.7	2.50	5.04
Series + 246	M4	371	0.70	63	4.5	3.4	3.30	5.08
Series + 286	M5	371	0.80	70	6.0	4.9	4.20	5.29
Series + 316	M6	371	1.00	80	6.0	4.9	5.00	5.34
Series + 366	M8	371	1.25	90	8.0	6.2	6.80	6.31
Series + 426	M10	371	1.50	100	10.0	8.0	8.50	7.39
Series + 506	M12	376	1.75	110	9.0	7.0	10.20	9.76
Series + 546	M14	376	2.00	110	11.0	9.0	12.00	11.81
Series + 606	M16	376	2.00	110	12.0	9.0	14.00	13.26
Series + 706	M20	376	2.50	140	16.0	12.0	17.50	20.03
Series + 786	M24	376	3.00	160	18.0	14.5	21.00	21.55

Ordering codes = Series (see previous page for available series) + code e.g. Series TB312 + Code 246 = TB312246

SPIRAL FLUTE TIN COATED HSSE
- RIGHT HAND

Ordering Code	Size	DIN	Pitch mm	Overall Length	Shank Dia	Size of Square	Drill Dia	2007 £
TD711206	M3	371	0.50	56	3.5	2.7	2.50	6.78
TD711246	M4	371	0.70	63	4.5	3.4	3.30	6.83
TD711286	M5	371	0.80	70	6.0	4.9	4.20	7.12
TD711316	M6	371	1.00	80	6.0	4.9	5.00	7.12
TD711366	M8	371	1.25	90	8.0	6.2	6.80	8.50
TD711426	M10	371	1.50	100	10.0	8.0	8.50	9.95
TD711506	M12	376	1.75	110	9.0	7.0	10.20	13.12
TD711606	M16	376	2.00	110	12.0	9.0	14.00	17.82
TD711706	M20	376	2.50	140	16.0	12.0	17.50	26.44

*With TIN coating the cutting speed recommendation can be doubled

Finish	Explanation
Steam Tempered - VAP	The Steam Tempered is an Fe3O4 oxyd-coating which reduces the friction between tool and workpiece and prevents cold welding
Nitriding - NI	We recommend this surface treatment for machining materials which effect a hard wear/abrasion, such as grey cast iron, alu-alloys with high Si-percentage above 10%
TIN Coating - TIN	The TIN coating has a hardness of approx. 2,300 HV and is temperature resistant up to approx 600°C. This is an excellent all-round coating for normal applications. Colour - gold.
TICN Coating - TICN	TiCN takes the place of TIN when the conditions require the coating to have a different hardness and toughness. The TiCN coating has an advantage in machining very difficult steels or cutting interrupted bores. Heat resistant up to 400°C. Colour - blue/grey
TIALN Coating - TIALN	This is a special coating for machining abrasive materials such as grey cast iron, alu-alloys with silicon, fibre reinforced plastics etc. or machining under high temperatures. The TIALN coating has a hardness of approx. 3,000 HV and is temperature-resistant up to approx 800°C. Colour - violet/grey
Hardslick Coating - Hard	Hardslick combines in a novel way the advantages of an extremely hard, thermally stable TIALN coating with the sliding and lubricating properties of an outer WC/C-coating. The HARDSLICK coating has a hardness of approx. 3,000 HV and is temperature-resistant up to approx 800°C. Colour - violet/grey

For the full series see pages 254 - 255

Spiral Point Machine Taps - Metric Coarse Pitch - For Through Holes

SPIRAL POINT UNCOATED HSSE - RIGHT HAND



Ordering Code	Size	DIN	Pitch mm	Overall Length	Shank Dia	Size of Square	Drill Dia	2007 £
Series + 136	M2	371	0.40	45	2.8	2.1	1.60	6.01
Series + 176	M2.5	371	0.45	50	2.8	2.1	2.05	6.37
Series + 206	M3	371	0.50	56	3.5	2.7	2.50	5.04
Series + 246	M4	371	0.70	63	4.5	3.4	3.30	5.08
Series + 286	M5	371	0.80	70	6.0	4.9	4.20	5.29
Series + 316	M6	371	1.00	80	6.0	4.9	5.00	5.34
Series + 366	M8	371	1.25	90	8.0	6.2	6.80	6.31
Series + 426	M10	371	1.50	100	10.0	8.0	8.50	7.39
Series + 506	M12	376	1.75	110	9.0	7.0	10.20	9.76
Series + 546	M14	376	2.00	110	11.0	9.0	12.00	11.81
Series + 606	M16	376	2.00	110	12.0	9.0	14.00	13.26
Series + 706	M20	376	2.50	140	16.0	12.0	17.50	20.08
Series + 786	M24	376	3.00	160	18.0	14.5	21.00	21.55

Ordering codes = Series (see previous page for available series) + code e.g. Series TC227 + Code 246 = TC227246

SPIRAL POINT HARDSLICK COATED HSSE - RIGHT HAND



Ordering Code	Size	DIN	Pitch mm	Overall Length	Shank Dia	Size of Square	Drill Dia	2007 £
TCH23136	M2	371	0.40	45	2.8	2.1	1.60	7.09
TCH23206	M3	371	0.50	56	3.5	2.7	2.50	7.09
TCH23246	M4	371	0.70	63	4.5	3.4	3.30	7.15
TCH23286	M5	371	0.80	70	6.0	4.9	4.20	7.43
TCH23316	M6	371	1.00	80	6.0	4.9	5.00	7.51
TCH23366	M8	371	1.25	90	8.0	6.2	6.80	8.89
TCH23426	M10	371	1.50	100	10.0	8.0	8.50	10.40
TCH23506	M12	376	1.75	110	9.0	7.0	10.20	13.72
TCH23606	M16	376	2.00	110	12.0	9.0	14.00	18.64
TCH23706	M20	376	2.50	140	16.0	12.0	17.50	27.64

* With hardsllick coating the cutting speed recommendation can be doubled

Finish	Explanation
Steam Tempered - VAP	The Steam Tempered is an Fe3O4 oxyd-coating which reduces the friction between tool and workpiece and prevents cold welding
Nitriding - NI	We recommend this surface treatment for machining materials which effect a hard wear/abrasion, such as grey cast iron, alu-alloys with high Si-percentage above 10%
TIN Coating - TIN	The TIN coating has a hardness of approx. 2,300 HV and is temperature resistant up to approx 600°C. This is an excellent all-round coating for normal applications. Colour - gold.
TICN Coating - TICN	TiCN takes the place of TIN when the conditions require the coating to have a different hardness and toughness. The TICN coating has an advantage in machining very difficult steels or cutting interrupted bores. Heat resistant up to 400°C. Colour - blue/grey
TiALN Coating - TiALN	This is a special coating for machining abrasive materials such as grey cast iron, alu-alloys with silicon, fibre reinforced plastics etc. or machining under high temperatures. The TiALN coating has a hardness of approx. 3,000 HV and is temperature-resistant up to approx 800°C. Colour - violet/grey
Hardsllick Coating - Hard	Hardsllick combines in a novel way the advantages of an extremely hard, thermally stable TiALN coating with the sliding and lubricating properties of an outer WC/C-coating. The HARDSLICK coating has a hardness of approx. 3,000 HV and is temperature-resistant up to approx 800°C. Colour - violet/grey



Metric Coarse Pitch Roll Taps

Cold Forming



Metric Coarse Pitch Roll Taps - Cold Forming

Roll Taps (Cold Forming) - Metric Coarse Pitch - For Through + Blind Holes

HSSE COLD FORMING TAPS WITH OIL GROOVES - TIN COATED



Ordering Code	Size	Pitch mm	Overall Length	Shank Dia	Size of Square	Drill Dia	2007 £
TD703136	M2	0.40	45	2.8	2.1	1.83	10.27
TD703176	M2.5	0.45	50	2.8	2.1	2.30	8.84
TD703206	M3	0.50	56	3.5	2.7	2.80	7.52
TD703246	M4	0.70	63	4.5	3.4	3.70	7.52
TD703286	M5	0.80	70	6.0	4.9	4.65	7.65
TD703316	M6	1.00	80	6.0	4.9	5.55	7.65
TD703366	M8	1.25	90	8.0	6.2	7.40	10.45
TD703426	M10	1.50	100	10.0	8.0	9.30	12.58
TD703506	M12	1.75	110	9.0	7.0	11.20	16.73
TD703546	M14	2.00	110	11.0	9.0	13.0	20.17
TD703606	M16	2.00	110	12.0	9.0	15.0	24.30
TD703706	M20	2.50	140	16.0	12.0	18.80	37.81

Metric Fine Pitch Machine Taps

Spiral Flute Machine Taps - Metric Fine Pitch - For Blind Holes

SPIRAL FLUTE UNCOATED HSSE - RIGHT HAND FINE PITCH



Ordering Code	Size	Pitch mm	Overall Length	Shank Dia	Size of Square	Drill Dia	2007 £
TC411256	M4	0.50	63	2.8	2.1	3.5	6.66
TC411296	M5	0.50	70	3.5	2.7	4.5	6.82
TC411336	M6	0.50	80	4.5	3.4	5.5	6.82
TC411326	M6	0.75	80	4.5	3.4	5.2	6.82
TC411356	M7	0.75	80	5.5	4.3	6.2	9.92
TC411936	M8	0.50	80	6.0	4.9	7.5	9.02
TC411386	M8	0.75	80	6.0	4.9	7.2	7.78
TC411376	M8	1.00	90	6.0	4.9	7.0	7.39
TC411456	M10	0.75	90	7.0	5.5	9.2	10.91
TC411446	M10	1.00	90	7.0	5.5	9.0	8.65
TC411436	M10	1.25	100	7.0	5.5	8.8	8.99
TC411536	M12	1.00	100	9.0	7.0	11.0	10.03
TC411526	M12	1.25	100	9.0	7.0	10.8	9.58
TC411516	M12	1.50	100	9.0	7.0	10.5	9.58
TC411576	M14	1.00	100	11.0	9.0	13.0	12.40
TC411566	M14	1.25	100	11.0	9.0	12.8	12.78
TC411556	M14	1.50	100	11.0	9.0	12.5	11.82
TC411626	M16	1.00	100	12.0	9.0	15.0	16.33
TC411616	M16	1.50	100	12.0	9.0	14.5	16.07
TC411686	M18	1.00	110	14.0	11.0	17.0	21.41
TC411676	M18	1.50	110	14.0	11.0	16.5	19.49
TC411736	M20	1.00	125	16.0	12.0	19.0	23.54
TC411726	M20	1.50	125	16.0	12.0	18.5	21.86

TAPS

TAPS Metric Coarse Pitch Roll + Fine Pitch Machine Taps

Spiral Point Machine Taps - Metric Fine Pitch - For Through Holes

SPIRAL POINT UNCOATED HSSE - RIGHT HAND FINE PITCH



Ordering Code	Size	Pitch mm	Overall Length	Shank Dia	Size of Square	Drill Dia	2007 £
TC222256	M4	0.50	63	2.8	2.1	3.5	6.66
TC222296	M5	0.50	70	3.5	2.7	4.5	6.82
TC222336	M6	0.50	80	4.5	3.4	5.5	6.82
TC222326	M6	0.75	80	4.5	3.4	5.2	6.82
TC222356	M7	0.75	80	5.5	4.3	6.2	9.92
TC222936	M8	0.50	80	6.0	4.9	7.5	9.02
TC222386	M8	0.75	80	6.0	4.9	7.2	7.78
TC222376	M8	1.00	90	6.0	4.9	7.0	7.39
TC222456	M10	0.75	90	7.0	5.5	9.2	10.91
TC222446	M10	1.00	90	7.0	5.5	9.0	8.65
TC222436	M10	1.25	100	7.0	5.5	8.8	8.99
TC222536	M12	1.00	100	9.0	7.0	11.0	10.03
TC222526	M12	1.25	100	9.0	7.0	10.8	9.58
TC222516	M12	1.50	100	9.0	7.0	10.5	9.58
TC222576	M14	1.00	100	11.0	9.0	13.0	12.40
TC222566	M14	1.25	100	11.0	9.0	12.8	12.78
TC222556	M14	1.50	100	11.0	9.0	12.5	11.82
TC222626	M16	1.00	100	12.0	9.0	15.0	16.33
TC222616	M16	1.50	100	12.0	9.0	14.5	16.07
TC222686	M18	1.00	110	14.0	11.0	17.0	21.41
TC222676	M18	1.50	110	14.0	11.0	16.5	19.49
TC222736	M20	1.00	125	16.0	12.0	19.0	23.54
TC222726	M20	1.50	125	16.0	12.0	18.5	21.86

TAPS

- Same day despatch until 6 pm
- Next day delivery
- 10,000 lines ex-stock
- Pre-discounted prices



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TAPS Metric Fine Pitch Machine Taps