



**Balax**

BALAX INC.

**Threading Solutions for Every Industry**

## A BALAX, INC. GUIDE TO TAPPING IN THE 21ST CENTURY

At Balax, we recognize the increased demands placed on our customers for improved quality and lower production costs. To accommodate these needs, you will find in this catalog new generations of high performance tools that will lead to "least cost tapped hole" by providing increased tool life, less machine downtime, and better thread quality. This catalog reflects our commitment to serve our customers by providing skillfully engineered, high quality, state of the art products made in the USA.

### **MATERIAL SPECIFIC TAP GEOMETRY**

In-Stock Thredfloer and Thredshaver are optimized to tap a specific material with geometry and coatings engineered to provide maximum results.

### **PREMIUM TAP MATERIALS OF CONSTRUCTION**

In-Stock Thredfloer and Thredshaver taps made from premium powder metal tool steel. These taps are produced at higher Rockwell C values and offer increased wear resistance and toughness compared to standard taps.

### **CARBIDE INSERTED TAPS**

In-Stock Thredfloer and Thredshaver taps that have the wear resistance of carbide while providing the core strength of HSS.

### **SPECIAL DESIGN FEATURES:**

Balax has introduced other important design features to its standard tap product lines that increase tap consistency and benefit tap life and productivity:

**Controlled Tap Blank Dimensions** with tighter tolerances than MCTI Industry Standards.

**Controlled Tap Chamfers** for bottoming applications with limited clearances.

**CNC Controlled Tap Geometries** for more consistent thread gaging and longer tap life.

### **BALAX, INC. TAPPING LABORATORY**

Balax is fully equipped to evaluate your future tapping projects and to help you make the decision whether to cold form or cut thread your part. Working with your part prints and actual material being tapped, Balax will provide you with the correct recommendation for pre-tap hole size, tapping torque, tapping speed, and tap lubrication. Based on all of this information, Balax will design and manufacture the optimum tap that will allow you to successfully production tap your parts from the very beginning.

## OVER 50 YEARS OF EXPERIENCE

For five (5) decades, Balax Inc, has been designing and manufacturing quality Thredfloer Cold Forming Taps and Thredshaver Cutting Taps in North Lake, Wisconsin. All our products are manufactured utilizing in-house operations that include blank making, heat treating, shank and square grinding, fluting, thread grinding and surface treatment. Balax operates its factory three shifts, five days a week in order to provide prompt delivery.

### **LOOKING FOR A SPECIALIZED TAP OR GAGE?**

Balax can create almost any tap for your company's specific needs. To contact one of our sales representatives directly, use our Toll-Free number. 8:30 AM - 4:30 PM CST.

**Phone: 800.886.1398 or 262.966.2355**

**Fax: 800.342.2529 or 262.966.1028**

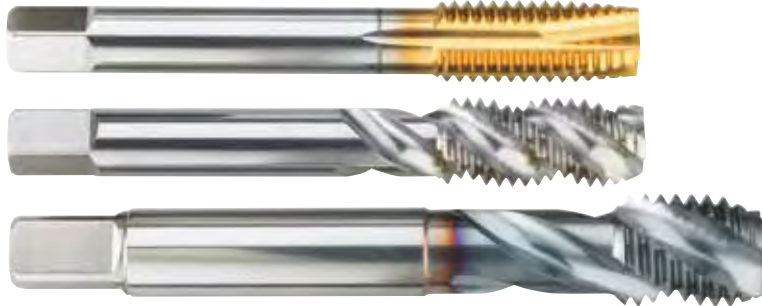
**Email: [balax@balax.com](mailto:balax@balax.com)**



**THREDFLOERS®**  
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**THREDSHAVERS®**  
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**CARBIDE INSERTED**  
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**THREAD GAGES**  
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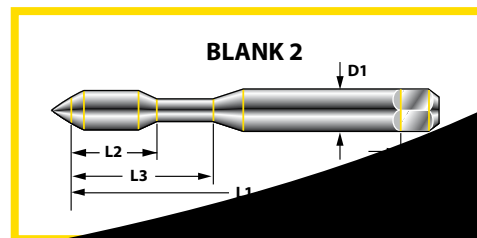


**TAPPING OIL**  
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**TECHNICAL INFORMATION**  
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HOLE SIZES REQUIRED FOR:		
75% THREAD	65% THREAD	55% THREAD
.0303	.0307	.0311
.0417	.0422	.0426
.0420	.0425	.0430
.0546	.0552	.0558
.066	.067	.068
.067	.068	.069
.078	.079	.080
.079	.080	



# SEVEN MAJOR ADVANTAGES OF THREAD FORMING – VS – CUTTING TAPS

Forming taps and cutting taps produce threads that gage identically and are interchangeable, but the similarity stops there. The way they produce threads is completely different: Forming taps displace metal — cutting taps remove it.

### 1. CHIPLESS TAPPING

Since the thread is formed and not cut, there are no chips to interfere with the tapping process or to cause chip-removal problems in blind holes.

### 2. STRONGER THREADS

The grain flow of formed threads follows the contour of the thread resulting in greater thread strength. This is especially true for materials that work-harden such as steel and stainless steel.

### 3. BETTER THREAD GAGING

Forming taps rearrange the metal in the hole to create the thread. Because no metal is cut away, the possibility of producing oversized threads is greatly reduced.

### 4. STRONGER TAPS

The absence of chips eliminates the need for flutes, resulting in a solid, stronger tap.

### 5. LONGER TAP LIFE

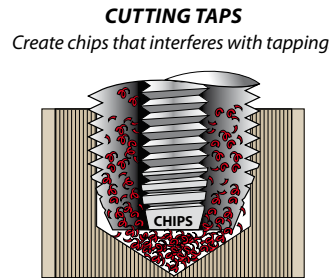
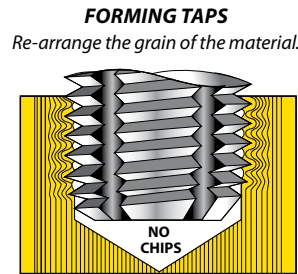
Forming taps last 3 to 20 times longer than cutting taps because they have no cutting edge to dull.

### 6. MORE EFFICIENT PRODUCTION

Longer tap life, less tap breakage, and faster tapping speeds combine to reduce cycle time and machine downtime.

### 7. IDEAL FOR NON-LEAD SCREW TAPPERS

The ability to form their own leads makes Thredfloer Taps especially well suited for CNC machines or other machines without lead screws.

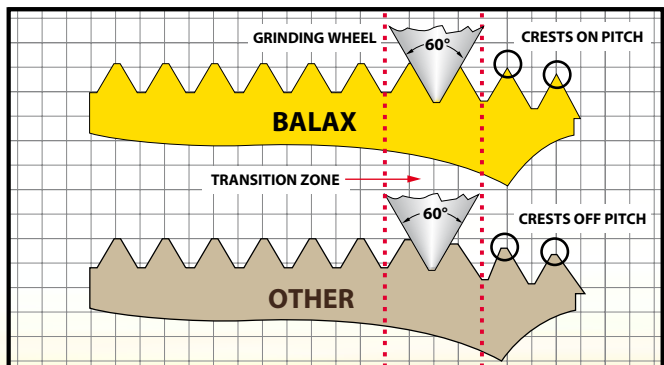


## WHY CHOOSE BALAX THREDFLOER'S ?





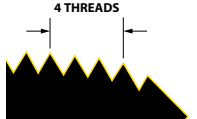

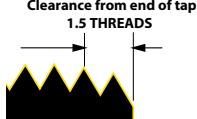








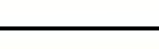

BALAX stands for "BALanced AXially," which is an important feature for all of our Thredfloer Cold Forming Taps. Balax Thredfloers are ground using our proprietary thread grinders that have a differential lead compensation device that produces cold forming taps with their lead crests exactly on pitch.

Other forming taps have lead thread cold forming teeth that are not ground on pitch. These forming taps actually cold-work the thread twice: (1) to form the inaccurate lead thread and (2) to move it on pitch. This creates an axial thrust on the tap which increases tapping torque and reduces tap life.

Balax Thredfloers form the thread exactly on pitch the first time with no axial thrust, hence the name "BALanced AXially". All Thredfloers require less tapping torque and provide longer tap life than forming taps ground with conventional methods.



# THREDFLOER SERIES

<p><b>MINIATURE</b></p>		<p>Offer significant advantages compared to extremely small cutting taps: greater tap strength, chipless tapping, better tap life, and better thread gaging.</p>
<p><b>BOTTOM (B)</b></p>		<p>For blind holes with <b>Clearance</b> Male Center (FT. PT.) Removed</p> 
<p><b>PLUG (P)</b></p>		<p>For thru holes</p> 
<p><b>ONE THREAD LEAD (OTL)</b></p>		<p>For blind holes with <b>Limited Clearance</b></p> 
<p><b>HIGH PERFORMANCE (HP)</b></p>		<p>Made from premium powdered metal tool steel for toughness and wear resistance. Have a unique forming lobe geometry to provide superior results in difficult materials to tap. (Bottom and Plug with the optimal # of grooves)</p>
<p><b>MATERIAL SPECIFIC TAPS</b></p>		<p>Designed for DIECAST ALUMINUM. Made from premium powdered metal for added tool life. Have extra lube grooves for better lubrication during tapping and Bal-Plus coating for lubricity and wear resistance. (Bottom and OTL)</p>
		<p>Designed for STEEL. Made from premium powdered metal for added tool life. Have extra lube grooves for better lubrication during tapping and TiCN coating for lubricity and wear resistance. (Bottom and OTL)</p>
		<p>Designed for STAINLESS STEEL. Made from premium powdered metal for added tool life. Have extra lube grooves for better lubrication during tapping and Super TiN coating for lubricity and wear resistance. (Bottom and OTL)</p>
<p><b>EXTENSION</b></p>		<p>Bottoming style taps for extra reach applications.</p>
<p><b>SCREW THREAD INSERT (STI)</b></p>		<p>Bottoming style taps for holes requiring Screw Thread Inserts (STI).</p>
<p><b>DIN</b></p>		<p>Bottoming style taps with the optimal # of grooves manufactured to DIN standard blank dimensions.</p>
<p><b>JAPANESE INDUSTRIAL STANDARD (JIS)</b></p>		<p>Bottoming style taps to JIS standard blank dimensions.</p>
<p><b>IN-LINE STUB</b></p>		<p>Bottoming style stub taps for sheet metal in-line tapping devices.</p>
<p><b>PIPE</b></p>		<p>NPT, NPTF, NPS, NPSC, NPSM, NPSF</p>

*Note: Almost all In-Stock taps can be modified by adding coolant thru, extra lube grooves, relieved shanks, and material specific surface coatings*

TAP SIZE	IMAGE	SERIES	BLANK	CHAMFER	COATING	CLASS 2B	CLASS 3B		
000-120		MINIATURE	ANSI	2.5	BRIGHT				
00-90		MINIATURE	ANSI	2.5	BRIGHT				
00-96		MINIATURE	ANSI	2.5	BRIGHT				
0-80		BOTTOM	ANSI	2.5	BRIGHT	H2, H3	H2		
					TiN	H2, H3	H2		
		OTL	ANSI	1.5	BRIGHT	H2, H3	H2		
1-64		BOTTOM	ANSI	2.5	BRIGHT	H3, H4	H2, H3		
					TiN	H3, H4	H2, H3		
		JIS	JIS	2.5	BRIGHT	H3, H4	H2, H3		
1-72		BOTTOM	ANSI	2.5	BRIGHT	H3, H4	H2, H3		
					TiN	H3, H4	H2, H3		
		OTL	ANSI	1.5	BRIGHT	H3, H4	H2, H3		
2-56		BOTTOM	ANSI	2.5	BRIGHT	H3, H4	H2, H3		
					TiN	H3, H4	H2, H3		
		HP	ANSI	2.5	BRIGHT	H3, H4	H2, H3		
					TiN	H3, H4	H2, H3		
					TiCN	H3, H4	H2, H3		
		EXTENSION			3" OAL	2.5	BRIGHT	H3, H4	H2, H3
					4" OAL	2.5	BRIGHT	H3, H4	H2, H3
		STI			#5 ANSI	2.5	BRIGHT	H2	H2
JIS					JIS	2.5	BRIGHT	H3, H4	H2, H3
	INLINE			INLINE	2.5	BRIGHT	H3, H4	H2, H3	
2-64		BOTTOM	ANSI	2.5	BRIGHT	H3, H4	H2, H3		
					TiN	H3, H4	H2, H3		
3-48		BOTTOM	ANSI	2.5	BRIGHT	H4, H5	H2, H3		
					TiN	H4, H5	H2, H3		
3-56		BOTTOM	ANSI	2.5	BRIGHT	H4, H5	H2, H3		
					TiN	H4, H5	H2, H3		
4-40		BOTTOM	ANSI	2.5	BRIGHT	H4, H5	H3, H4		
					TiN	H4, H5	H3, H4		
		PLUG	ANSI	4	BRIGHT	H4, H5	H3, H4		
					TiN	H4, H5	H3, H4		
		OTL	ANSI	1.5	BRIGHT	H4, H5	H3, H4		
		HP	ANSI	2.5	BRIGHT	H4, H5	H3, H4		
		*DIECAST (HP)	ANSI	2.5	BAL-PLUS	2B FIT	CFQ		
					BAL-PLUS	2B FIT	CFQ		
					TiCN	2B FIT	CFQ		
					TiCN	2B FIT	CFQ		
	*STEEL (HP)	ANSI	2.5	STiN	2B FIT	CFQ			
				STiN	2B FIT	CFQ			
	*STAINLESS (HP)	ANSI	2.5	STiN	2B FIT	CFQ			
				STiN	2B FIT	CFQ			
	EXTENSION			3" OAL	2.5	BRIGHT	H4, H5	H3, H4	
				4" OAL	2.5	BRIGHT	H4, H5	H3, H4	
	STI	#8 ANSI	2.5	BRIGHT	H2, H3	H2			
	JIS	JIS	2.5	BRIGHT	H4, H5	H3, H4			
	INLINE			INLINE	2.5	BRIGHT	H4, H5	H3, H4	

CFQ – CONTACT FACTORY FOR QUOTE • HP – HIGH PERFORMANCE  
 JIS – JAPANESE INDUSTRIAL STANDARD • OAL – OVER ALL LENGTH  
 OTL – ONE THREAD LEAD • STI – SCREW THREAD INSERT

\*RED INDICATES COATED TAPS IN-STOCK

H2	H3	H4	H5	H6	H7	SERIES
00102-000						MINIATURE
00302-000						MINIATURE
00202-000						MINIATURE
10002-010	10003-010	10004-010	10005-010	10006-010	10007-010	BOTTOM
10002-01T	10003-01T	10004-01T	10005-01T	10006-01T	10007-01T	
10032-010	10033-010					OTL
10022-010	10023-010					JIS
10122-010	10123-010	10124-010	10125-010	10126-010	10127-010	BOTTOM
10122-01T	10123-01T	10124-01T	10125-01T	10126-01T	10127-01T	
	10143-010	10144-010	10145-010			JIS
10242-010	10243-010	10244-010	10245-010	10246-010	10247-010	BOTTOM
10242-01T	10243-01T	10244-01T	10245-01T	10246-01T	10247-01T	
10272-010	10273-010					OTL
	10263-010	10264-010	10265-010			JIS
10282-010	10283-010	10284-010	10285-010	10286-010	10287-010	BOTTOM
10282-01T	10283-01T	10284-01T	10285-01T	10286-01T	10287-01T	
10332-010	10333-010	10334-010				OTL
	10383-010					HP
	10383-01T					
	10383-01C					
10362-000	10363-000					EXTENSION
10372-000	10373-000					
10322-010	10323-010					STI
	10303-010	10304-010	10305-010			JIS
		10344-000				INLINE
10422-010	10423-010	10424-010	10425-010	10426-010	10427-010	BOTTOM
10422-01T	10423-01T	10424-01T	10425-01T	10426-01T	10427-01T	
10522-010	10523-010	10524-010	10525-010	10526-010	10527-010	BOTTOM
10522-01T	10523-01T	10524-01T	10525-01T	10526-01T	10527-01T	
10622-010	10623-010	10624-010	10625-010	10626-010	10627-010	BOTTOM
10622-01T	10623-01T	10624-01T	10625-01T	10626-01T	10627-01T	
10722-010	10723-010	10724-010	10725-010	10726-010	10727-010	BOTTOM
10722-01T	10723-01T	10724-01T	10725-01T	10726-01T	10727-01T	
10742-000	10743-000	10744-000	10745-000	10746-000	10747-000	PLUG
10742-00T	10743-00T	10744-00T	10745-00T	10746-00T	10747-00T	
	10763-010	10764-010	10765-010			OTL
	10853-210	10854-210	10855-210			HP
			10852-81L			*DIECAST (HP)
			10762-81L			*DIECAST (HP)
			10852-81C			*STEEL (HP)
			10762-81C			*STEEL (HP)
			10852-81U			*STAINLESS (HP)
			10762-81U			*STAINLESS (HP)
	10783-000	10784-000	10785-000			EXTENSION
	10803-000	10804-000	10805-000			
10842-010	10843-010					STI
10822-010	10823-010	10824-010	10825-010	10826-010	10827-010	JIS
			10865-000			INLINE

\*RED INDICATES COATED TAPS IN-STOCK

\* Highlighted products are premium quality taps that are targeted to specific industry needs

TAP SIZE	IMAGE	SERIES	BLANK	CHAMFER	COATING	CLASS 2B	CLASS 3B				
4-48		BOTTOM	ANSI	2.5	BRIGHT	H4, H5	H3, H4				
					TiN	H4, H5	H3, H4				
5-40		BOTTOM	ANSI	2.5	BRIGHT	H4, H5	H3, H4				
					TiN	H4, H5	H3, H4				
		PLUG	ANSI	4	BRIGHT	H4, H5	H3, H4				
					TiN	H4, H5	H3, H4				
5-44		BOTTOM	ANSI	2.5	BRIGHT	H4, H5	H3, H4				
					TiN	H4, H5	H3, H4				
6-32		BOTTOM	ANSI CNC	2.5	BRIGHT	H5, H6	H3, H4				
					TiN	H5, H6	H3, H4				
		PLUG	ANSI CNC	4	BRIGHT	H5, H6	H3, H4				
					TiN	H5, H6	H3, H4				
		OTL	ANSI CNC	1.5	BRIGHT	H5, H6	H3, H4				
		HP	ANSI CNC	2.5	BRIGHT	H5, H6	H3, H4				
		*DIECAST (HP)	ANSI CNC	2.5	BAL-PLUS	2B FIT	CFQ				
					1.5	BAL-PLUS	2B FIT	CFQ			
						*STEEL (HP)	ANSI CNC	2.5	TiCN	2B FIT	CFQ
									1.5	TiCN	2B FIT
						*STAINLESS (HP)	ANSI CNC	2.5	STiN	2B FIT	CFQ
									1.5	STiN	2B FIT
	EXTENSION	3" OAL	2.5	BRIGHT	H5, H6	H3, H4					
				4" OAL	2.5	BRIGHT	H5, H6	H3, H4			
	STI	#10 ANSI	2.5	BRIGHT	H2, H3	H2					
	JIS	JIS	2.5	BRIGHT	H5, H6	H3, H4					
	INLINE	INLINE	2.5	BRIGHT	H5, H6	H3, H4					
6-40		BOTTOM	ANSI CNC	2.5	BRIGHT	H4, H5	H3, H4				
					TiN	H4, H5	H3, H4				
		PLUG	ANSI CNC	4	BRIGHT	H4, H5	H3, H4				
					TiN	H4, H5	H3, H4				
8-32		BOTTOM	ANSI CNC	2.5	BRIGHT	H5, H6	H3, H4				
					TiN	H5, H6	H3, H4				
		PLUG	ANSI CNC	4	BRIGHT	H5, H6	H3, H4				
					TiN	H5, H6	H3, H4				
		OTL	ANSI CNC	1.5	BRIGHT	H5, H6	H3, H4				
		HP	ANSI CNC	2.5	BRIGHT	H5, H6	H3, H4				
		*DIECAST (HP)	ANSI CNC	2.5	BAL-PLUS	2B FIT	CFQ				
					1.5	BAL-PLUS	2B FIT	CFQ			
						*STEEL (HP)	ANSI CNC	2.5	TiCN	2B FIT	CFQ
									1.5	TiCN	2B FIT
						*STAINLESS (HP)	ANSI CNC	2.5	STiN	2B FIT	CFQ
									1.5	STiN	2B FIT
	EXTENSION	3" OAL	2.5	BRIGHT	H5, H6	H3, H4					
				4" OAL	2.5	BRIGHT	H5, H6	H3, H4			
	STI	#12 ANSI	2.5	BRIGHT	H2, H3	H2					
	JIS	JIS	2.5	BRIGHT	H5, H6	H3, H4					
	INLINE	INLINE	2.5	BRIGHT	H5, H6	H3, H4					

CFQ – CONTACT FACTORY FOR QUOTE • HP – HIGH PERFORMANCE  
 JIS – JAPANESE INDUSTRIAL STANDARD • OAL – OVER ALL LENGTH  
 OTL – ONE THREAD LEAD • STI – SCREW THREAD INSERT

\*RED INDICATES COATED TAPS IN-STOCK

H2	H3	H4	H5	H6	H7	H8	H9	H10	SERIES
10942-010	10943-010	10944-010	10945-010	10946-010	10947-010				BOTTOM
10942-01T	10943-01T	10944-01T	10945-01T	10946-01T	10947-01T				
11042-010	11043-010	11044-010	11045-010	11046-010	11047-010				BOTTOM
11042-01T	11043-01T	11044-01T	11045-01T	11046-01T	11047-01T				
11062-000	11063-000	11064-000	11065-000	11066-000	11067-000				PLUG
11062-00T	11063-00T	11064-00T	11065-00T	11066-00T	11067-00T				
11162-010	11163-010	11164-010	11165-010	11166-010	11167-010				BOTTOM
11162-01T	11163-01T	11164-01T	11165-01T	11166-01T	11167-01T				
11282-010	11283-010	11284-010	11285-010	11286-010	11287-010	11288-010	11289-010	11290-010	BOTTOM
11282-01T	11283-01T	11284-01T	11285-01T	11286-01T	11287-01T	11288-01T	11289-01T	11290-01T	
11302-000	11303-000	11304-000	11305-000	11306-000	11307-000	11308-000	11309-000	11310-000	PLUG
11302-00T	11303-00T	11304-00T	11305-00T	11306-00T	11307-00T	11308-00T	11309-00T	11310-00T	
	11323-010	11324-010	11325-010						OTL
	11413-210	11414-210	11415-210	11416-210					HP
			11412-81L						*DIECAST (HP)
			11322-81L						*STEEL (HP)
			11412-81C						*STAINLESS (HP)
			11322-81C						*STAINLESS (HP)
			11412-81U						*STAINLESS (HP)
			11322-81U						*STAINLESS (HP)
	11343-000	11344-000	11345-000	11346-000					EXTENSION
	11363-000	11364-000	11365-000	11366-000					EXTENSION
11402-010	11403-010								STI
11382-010	11383-010	11384-010	11385-010	11386-010	11387-010	11388-010	11389-010	11390-010	JIS
			11425-000						INLINE
11502-010	11503-010	11504-010	11505-010	11506-010	11507-010	11508-010	11509-010	11510-010	BOTTOM
11502-01T	11503-01T	11504-01T	11505-01T	11506-01T	11507-01T	11508-01T	11509-01T	11510-01T	
11522-000	11523-000	11524-000	11525-000	11526-000	11527-000	11528-000	11529-000	11530-000	PLUG
11522-00T	11523-00T	11524-00T	11525-00T	11526-00T	11527-00T	11528-00T	11529-00T	11530-00T	
11622-010	11623-010	11624-010	11625-010	11626-010	11627-010	11628-010	11629-010	11630-010	BOTTOM
11502-01T	11623-01T	11624-01T	11625-01T	11626-01T	11627-01T	11628-01T	11629-01T	11630-01T	
11642-000	11643-000	11644-000	11645-000	11646-000	11647-000	11648-000	11649-000	11650-000	PLUG
11642-00T	11643-00T	11644-00T	11645-00T	11646-00T	11647-00T	11648-00T	11649-00T	11650-00T	
	11663-010	11664-010	11665-010						OTL
	11753-210	11754-210	11755-210	11756-210					HP
			11752-81L						*DIECAST (HP)
			11662-81L						*STEEL (HP)
			11752-81C						*STAINLESS (HP)
			11662-81C						*STAINLESS (HP)
			11752-81U						*STAINLESS (HP)
			11662-81U						*STAINLESS (HP)
	11683-000	11684-000	11685-000	11686-000					EXTENSION
	11703-000	11704-000	11705-000	11706-000					EXTENSION
11742-010	11743-010	11744-010							STI
11722-010	11723-010	11724-010	11725-010	11726-010	11727-010	11728-010	11729-010	11230-010	JIS
			11765-000						INLINE

\*RED INDICATES COATED TAPS IN-STOCK

\* Highlighted products are premium quality taps that are targeted to specific industry needs

TAP SIZE	IMAGE	SERIES	BLANK	CHAMFER	COATING	CLASS 2B	CLASS 3B
8-36		BOTTOM	ANSI CNC	2.5	BRIGHT	H4, H5	H3, H4
					TiN	H4, H5	H3, H4
		PLUG	ANSI CNC	4	BRIGHT	H4, H5	H3, H4
					TiN	H4, H5	H3, H4
		BOTTOM	ANSI CNC	2.5	BRIGHT	H5, H6, H7	H4, H5
					TiN	H5, H6, H7	H4, H5
		PLUG	ANSI CNC	4	BRIGHT	H5, H6, H7	H4, H5
					TiN	H5, H6, H7	H4, H5
		OTL	ANSI CNC	1.5	BRIGHT	H5, H6, H7	H4, H5
		HP	ANSI CNC	2.5	BRIGHT	H5, H6, H7	H4, H5
10-24		*DIECAST (HP)	ANSI CNC	2.5	BAL-PLUS	2B FIT	CFQ
					1.5	BAL-PLUS	2B FIT
		*STEEL (HP)	ANSI CNC	2.5	TiCN	2B FIT	CFQ
					1.5	TiCN	2B FIT
		*STAINLESS (HP)	ANSI CNC	2.5	STiN	2B FIT	CFQ
					1.5	STiN	2B FIT
	EXTENSIONS		4" OAL	2.5	BRIGHT	H5, H6, H7	H4, H5
			6" OAL	2.5	BRIGHT	H5, H6, H7	H4, H5
	STI		1/4 ANSI	2.5	BRIGHT	H3, H4	H2, H3
	JIS		JIS	2.5	BRIGHT	H5, H6, H7	H4, H5
	INLINE		INLINE	2.5	BRIGHT	H5, H6, H7	H4, H5
		BOTTOM	ANSI CNC	2.5	BRIGHT	H5, H6	H3, H4
					TiN	H5, H6	H3, H4
		PLUG	ANSI CNC	4	BRIGHT	H5, H6	H3, H4
					TiN	H5, H6	H3, H4
		OTL	ANSI CNC	1.5	BRIGHT	H5, H6	H3, H4
		HP	ANSI CNC	2.5	BRIGHT	H5, H6	H3, H4
10-32		*DIECAST (HP)	ANSI CNC	2.5	BAL-PLUS	2B FIT	CFQ
					1.5	BAL-PLUS	2B FIT
		*STEEL (HP)	ANSI CNC	2.5	TiCN	2B FIT	CFQ
					1.5	TiCN	2B FIT
		*STAINLESS (HP)	ANSI CNC	2.5	STiN	2B FIT	CFQ
					1.5	STiN	2B FIT
	EXTENSION		4" OAL	2.5	BRIGHT	H5, H6	H3, H4
			6" OAL	2.5	BRIGHT	H5, H6	H3, H4
	STI		1/4 ANSI	2.5	BRIGHT	H3, H4	H2, H3
	JIS		JIS	2.5	BRIGHT	H5, H6	H3, H4
	INLINE		INLINE	2.5	BRIGHT	H5, H6	H3, H4
12-24		BOTTOM	ANSI CNC	2.5	BRIGHT	H5, H6, H7	H4, H5
					TiN	H5, H6, H7	H4, H5
		PLUG	ANSI CNC	4	BRIGHT	H5, H6, H7	H4, H5
					TiN	H5, H6, H7	H4, H5
12-28		BOTTOM	ANSI CNC	2.5	BRIGHT	H5, H6, H7	H4, H5
					TiN	H5, H6, H7	H3, H4
		PLUG	ANSI CNC	4	BRIGHT	H5, H6, H7	H3, H4
					TiN	H5, H6, H7	H3, H4

CFQ – CONTACT FACTORY FOR QUOTE • HP – HIGH PERFORMANCE  
 JIS – JAPANESE INDUSTRIAL STANDARD • OAL – OVER ALL LENGTH  
 OTL – ONE THREAD LEAD • STI – SCREW THREAD INSERT

\*RED INDICATES COATED TAPS IN-STOCK

H2	H3	H4	H5	H6	H7	H8	H9	H10	SERIES
11842-010	11843-010	11844-010	11845-010	11846-010	11847-010	11848-010	11849-010	11850-010	BOTTOM
11842-01T	11843-01T	11844-01T	11845-01T	11846-01T	11847-01T	11848-01T	11849-01T	11850-01T	
11862-000	11863-000	11864-000	11865-000	11866-000	11867-000	11868-000	11869-000	11870-000	PLUG
11862-00T	11863-00T	11864-00T	11865-00T	11866-00T	11867-00T	11868-00T	11869-00T	11870-00T	
11962-010	11963-010	11964-010	11965-010	11966-010	11967-010	11968-010	11969-010	11970-010	BOTTOM
11962-01T	11963-01T	11964-01T	11965-01T	11966-01T	11967-01T	11968-01T	11969-01T	11970-01T	
11982-000	11983-000	11984-000	11985-000	11986-000	11987-000	11988-000	11989-000	11990-000	PLUG
11982-00T	11983-00T	11984-00T	11985-00T	11986-00T	11987-00T	11988-00T	11989-00T	11990-00T	
	12003-010	12004-010	12005-010						OTL
	12093-410	12094-410	12095-410	12096-410					HP
			12092-91L						*DIECAST (HP)
			12002-91L						*STEEL (HP)
			12092-91C						*STAINLESS (HP)
			12002-91C						
			12092-91U						
			12002-91U						
	12023-000	12024-000	12025-000	12026-000	12027-000				EXTENSIONS
	12043-000	12044-000	12045-000	12046-000	12047-000				
12082-010	12083-010	12084-010							STI
	12063-010	12064-010	12065-010	12066-010	12067-010	12068-010	12069-010	12070-010	JIS
					12107-000				INLINE
12182-010	12183-010	12184-010	12185-010	12186-010	12187-010	12188-010	12189-010	12190-010	BOTTOM
12182-01T	12183-01T	12184-01T	12185-01T	12186-01T	12187-01T	12188-01T	12189-01T	12190-01T	
12202-000	12203-000	12204-000	12205-000	12206-000	12207-000	12208-000	12209-000	12210-000	PLUG
12202-00T	12203-00T	12204-00T	12205-00T	12206-00T	12207-00T	12208-00T	12209-00T	12210-00T	
	12223-010	12224-010	12225-010						OTL
	12313-410	12314-410	12315-410	12316-410					HP
			12312-91L						*DIECAST (HP)
			12222-91L						*STEEL (HP)
			12312-91C						*STAINLESS (HP)
			12222-91C						
			12312-91U						
			12222-91U						
	12243-000	12244-000	12245-000	12246-000					EXTENSION
	12263-000	12264-000	12265-000	12266-000					
12302-010	12303-010	12304-010							STI
12282-010	12283-010	12284-010	12285-010	12286-010	12287-010	12288-010	12289-010	12290-010	JIS
			12325-000						INLINE
12402-010	12403-010	12404-010	12405-010	12406-010	12407-010	12408-010	12409-010	12410-010	BOTTOM
12402-01T	12403-01T	12404-01T	12405-01T	12406-01T	12407-01T	12408-01T	12409-01T	12410-01T	
12422-000	12423-000	12424-000	12425-000	12426-000	12427-000	12428-000	12429-000	12430-000	PLUG
12422-00T	12423-00T	12424-00T	12425-00T	12426-00T	12427-00T	12428-00T	12429-00T	12430-00T	
12522-010	12523-010	12524-010	12525-010	12526-010	12527-010	12528-010	12529-010	12530-010	BOTTOM
12522-01T	12523-01T	12524-01T	12525-01T	12526-01T	12527-01T	12528-01T	12529-01T	12530-01T	
12542-000	12543-000	12544-000	12545-000	12546-000	12547-000	12548-000	12549-000	12550-000	PLUG
12542-00T	12543-00T	12544-00T	12545-00T	12546-00T	12547-00T	12548-00T	12549-00T	12550-00T	

\*RED INDICATES COATED TAPS IN-STOCK

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TAP SIZE	IMAGE	SERIES	BLANK	CHAMFER	COATING	CLASS 2B	CLASS 3B
1/4-20		BOTTOM	ANSI CNC	2.5	BRIGHT	H6, H7, H8	H4, H5
	TIN				H6, H7, H8	H4, H5	
		PLUG	ANSI CNC	4	BRIGHT	H6, H7, H8	H4, H5
	TIN				H6, H7, H8	H4, H5	
		OTL	ANSI CNC	1.5	BRIGHT	H6, H7, H8	H4, H5
		HP (B)	ANSI CNC	2.5	BRIGHT	H6, H7, H8	H4, H5
		HP (P)	ANSI CNC	4	BRIGHT	H6, H7, H8	H4, H5
		*DIECAST (HP)	ANSI CNC	2.5	BAL-PLUS	2B FIT	CFQ
	1.5				BAL-PLUS	2B FIT	CFQ
		*STEEL (HP)	ANSI CNC	2.5	TiCN	2B FIT	CFQ
	1.5				TiCN	2B FIT	CFQ
		*STAINLESS (HP)	ANSI CNC	2.5	STiN	2B FIT	CFQ
	1.5				STiN	2B FIT	CFQ
		EXTENSION	ANSI CNC	4" OAL	2.5	BRIGHT	H6, H7, H8
	6" OAL			2.5	BRIGHT	H6, H7, H8	H4, H5
	STI	5/16 ANSI	2.5	BRIGHT	H3, H4	H2, H3	
	JIS	JIS	2.5	BRIGHT	H6, H7, H8	H4, H5	
	INLINE	INLINE	2.5	BRIGHT	H6, H7, H8	H4, H5	
1/4-28		BOTTOM	ANSI CNC	2.5	BRIGHT	H5, H6, H7	H4, H5
	TIN				H5, H6, H7	H4, H5	
		PLUG	ANSI CNC	4	BRIGHT	H5, H6, H7	H4, H5
	TIN				H5, H6, H7	H4, H5	
		OTL	ANSI CNC	1.5	BRIGHT	H5, H6, H7	H4, H5
		HP (B)	ANSI CNC	2.5	BRIGHT	H5, H6, H7	H4, H5
		HP (P)	ANSI CNC	4	BRIGHT	H5, H6, H7	H4, H5
		*DIECAST (HP)	ANSI CNC	2.5	BAL-PLUS	2B FIT	CFQ
	1.5				BAL-PLUS	2B FIT	CFQ
		*STEEL (HP)	ANSI CNC	2.5	TiCN	2B FIT	CFQ
	1.5				TiCN	2B FIT	CFQ
		*STAINLESS (HP)	ANSI CNC	2.5	STiN	2B FIT	CFQ
	1.5				STiN	2B FIT	CFQ
		EXTENSION	ANSI CNC	4" OAL	2.5	BRIGHT	H5, H6, H7
	6" OAL			2.5	BRIGHT	H5, H6, H7	H4, H5
	STI	5/16 ANSI	2.5	BRIGHT	H3, H4	H2, H3	
	JIS	JIS	2.5	BRIGHT	H5, H6, H7	H4, H5	
	INLINE	INLINE	2.5	BRIGHT	H5, H6, H7	H4, H5	
5/16-18		BOTTOM	ANSI CNC	2.5	BRIGHT	H7, H8, H9	H5, H6
	TIN				H7, H8, H9	H5, H6	
		PLUG	ANSI CNC	4	BRIGHT	H7, H8, H9	H5, H6
TIN	H7, H8, H9				H5, H6		
	OTL	ANSI CNC	1.5	BRIGHT	H7, H8, H9	H5, H6	

To provide better tap life, Balax, Inc. has improved the tap base material for its standard Thredfloer Taps by changing from wrought tool steel to powdered metal. For Thredfloer sizes

between #6 (M3.5) and 3/8" (M10), this change also involves changing tap blanks to a CNC or necked configuration.

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\*RED INDICATES COATED TAPS IN-STOCK

H2	H3	H4	H5	H6	H7	H8	H9	H10	SERIES
12642-010	12643-010	12644-010	12645-010	12646-010	12647-010	12648-010	12649-010	12650-010	BOTTOM
12642-01T	12643-01T	12644-01T	12645-01T	12646-01T	12647-01T	12648-01T	12649-01T	12650-01T	
12662-000	12663-000	12664-000	12665-000	12666-000	12667-000	12668-000	12669-000	12670-000	PLUG
12662-00T	12663-00T	12664-00T	12665-00T	12666-00T	12667-00T	12668-00T	12669-00T	12670-00T	
			12685-010	12686-010	12687-010	12688-010			OTL
			12775-410	12776-410	12777-410	12778-410			HP (B)
						12808-400			HP (P)
						12772-91L			*DIECAST (HP)
						12682-91L			*DIECAST (HP)
						12772-91C			*STEEL (HP)
						12682-91C			*STEEL (HP)
						12772-91U			*STAINLESS (HP)
						12682-91U			*STAINLESS (HP)
			12705-000	12706-000	12707-000	12708-000			EXTENSION
			12725-000	12726-000	12727-000	12728-000			
12762-010	12763-010	12764-010							STI
	12743-010	12744-010	12745-010	12746-010	12747-010	12748-010	12749-010	12750-010	JIS
						12788-000			INLINE
12862-010	12863-010	12864-010	12865-010	12866-010	12867-010	12868-010	12869-010	12870-010	BOTTOM
12862-01T	12863-01T	12864-01T	12865-01T	12866-01T	12867-01T	12868-01T	12869-01T	12870-01T	
12882-000	12883-000	12884-000	12885-000	12886-000	12887-000	12888-000	12889-000	12890-000	PLUG
12882-00T	12883-00T	12884-00T	12885-00T	12886-00T	12887-00T	12888-00T	12889-00T	12890-00T	
		12904-010	12905-010	12906-010	12907-010				OTL
		12994-410	12995-410	12996-410	12997-410				HP (B)
					13027-400				HP (P)
					12992-91L				*DIECAST (HP)
					12902-91L				*DIECAST (HP)
					12992-91C				*STEEL (HP)
					12902-91C				*STEEL (HP)
					12992-91U				*STAINLESS (HP)
					12902-91U				*STAINLESS (HP)
		12924-000	12925-000	12926-000	12927-000				EXTENSION
		12944-000	12945-000	12946-000	12947-000				
12982-010	12983-010	12984-010							STI
	12963-010	12964-010	12965-010	12966-010	12967-010	12968-010	12969-010	12970-010	JIS
					13007-000				INLINE
13082-010	13083-010	13084-010	13085-010	13086-010	13087-010	13088-010	13089-010	13090-010	BOTTOM
13082-01T	13083-01T	13084-01T	13085-01T	13086-01T	13087-01T	13088-01T	13089-01T	13090-01T	
13102-000	13103-000	13104-000	13105-000	13106-000	13107-000	13108-000	13109-000	13110-000	PLUG
13102-00T	13103-00T	13104-00T	13105-00T	13106-00T	13107-00T	13108-00T	13109-00T	13110-00T	
				13126-010	13127-010	13128-010	13129-010		OTL

\*RED INDICATES COATED TAPS IN-STOCK

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TAP SIZE	IMAGE	SERIES	BLANK	CHAMFER	COATING	CLASS 2B	CLASS 3B
5/16-18 CONT.		HP (B)	ANSI CNC	2.5	BRIGHT	H7, H8, H9	H5, H6
		HP (P)	ANSI CNC	4	BRIGHT	H7, H8, H9	H5, H6
		*DIECAST (HP)	ANSI CNC	2.5	BAL-PLUS	2B FIT	CFQ
		*DIECAST (HP)	ANSI CNC	1.5	BAL-PLUS	2B FIT	CFQ
		*STEEL (HP)	ANSI CNC	2.5	TiCN	2B FIT	CFQ
		*STEEL (HP)	ANSI CNC	1.5	TiCN	2B FIT	CFQ
		*STAINLESS (HP)	ANSI CNC	2.5	STiN	2B FIT	CFQ
		EXTENSION	4" OAL	2.5	BRIGHT	H7, H8, H9	H5, H6
		EXTENSION	6" OAL	2.5	BRIGHT	H7, H8, H9	H5, H6
		STI	7/16 ANSI	2.5	BRIGHT	H4, H5	H3, H4
5/16-24		BOTTOM	ANSI CNC	2.5	BRIGHT	H6, H7, H8	H4, H5
	TiN				H6, H7, H8	H4, H5	
		PLUG	ANSI CNC	4	BRIGHT	H6, H7, H8	H4, H5
	TiN				H6, H7, H8	H4, H5	
		OTL	ANSI CNC	1.5	BRIGHT	H6, H7, H8	H4, H5
		HP (B)	ANSI CNC	2.5	BRIGHT	H6, H7, H8	H4, H5
		HP (P)	ANSI CNC	4	BRIGHT	H6, H7, H8	H4, H5
		*DIECAST (HP)	ANSI CNC	2.5	BAL-PLUS	2B FIT	CFQ
					1.5	BAL-PLUS	2B FIT
		*STEEL (HP)	ANSI CNC	2.5	TiCN	2B FIT	CFQ
	1.5				TiCN	2B FIT	CFQ
	*STAINLESS (HP)	ANSI CNC	2.5	STiN	2B FIT	CFQ	
				1.5	STiN	2B FIT	CFQ
		EXTENSION	4" OAL	2.5	BRIGHT	H6, H7, H8	H4, H5
		EXTENSION	6" OAL	2.5	BRIGHT	H6, H7, H8	H4, H5

TAP SIZE	IMAGE	SERIES	BLANK	CHAMFER	COATING	CLASS 2B	CLASS 3B
3/8-16		BOTTOM	ANSI CNC	2.5	BRIGHT	H7, H8, H9	H6, H7
	TiN				H7, H8, H9	H6, H7	
		PLUG	ANSI CNC	4	BRIGHT	H7, H8, H9	H6, H7
	TiN				H7, H8, H9	H6, H7	
		OTL	ANSI CNC	1.5	BRIGHT	H7, H8, H9	H6, H7
		HP (B)	ANSI CNC	2.5	BRIGHT	H7, H8, H9	H6, H7
		HP (P)	ANSI CNC	4	BRIGHT	H7, H8, H9	H6, H7
		*DIECAST (HP)	ANSI CNC	2.5	BAL-PLUS	2B FIT	CFQ
					1.5	BAL-PLUS	2B FIT
		*STEEL (HP)	ANSI CNC	2.5	TiCN	2B FIT	CFQ
	1.5				TiCN	2B FIT	CFQ
	*STAINLESS (HP)	ANSI CNC	2.5	STiN	2B FIT	CFQ	
				1.5	STiN	2B FIT	CFQ
		EXTENSION	4" OAL	2.5	BRIGHT	H7, H8, H9	H6, H7
		EXTENSION	6" OAL	2.5	BRIGHT	H7, H8, H9	H6, H7
		STI	1/2 ANSI	2.5	BRIGHT	H4, H5	H3, H4

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\*RED INDICATES COATED TAPS IN-STOCK

H2	H3	H4	H5	H6	H7	H8	H9	H10	SERIES
				13176-410	13177-410	13178-410	13179-410		HP (B)
							13209-400		HP (P)
							13172-91L		*DIECAST (HP)
							13122-91L		*DIECAST (HP)
							13172-91C		*STEEL (HP)
							13122-91C		*STEEL (HP)
							13172-91U		*STAINLESS (HP)
							13122-91U		*STAINLESS (HP)
				13145-000	13146-000	13147-000	13148-000	13149-000	EXTENSION
				13165-000	13166-000	13167-000	13168-000	13169-000	EXTENSION
	13183-010	13184-010	13185-010						STI
13262-010	13263-010	13264-010	13265-010	13266-010	13267-010	13268-010	13269-010	13270-010	BOTTOM
13262-01T	13263-01T	13264-01T	13265-01T	13266-01T	13267-01T	13268-01T	13269-01T	13270-01T	
13282-000	13283-000	13284-000	13285-000	13286-000	13287-000	13288-000	13289-000	13290-000	PLUG
13282-00T	13283-00T	13284-00T	13285-00T	13286-00T	13287-00T	13288-00T	13289-00T	13290-00T	
			13305-010	13306-010	13307-010	13308-010			OTL
			13355-410	13356-410	13357-410	13358-410			HP (B)
						13378-400			HP (P)
						13352-91L			*DIECAST (HP)
						13302-91L			*DIECAST (HP)
						13352-91C			*STEEL (HP)
						13302-91C			*STEEL (HP)
						13352-91U			*STAINLESS (HP)
						13302-91U			*STAINLESS (HP)
		13324-000	13325-000	13326-000	13327-000	13328-000			EXTENSION
		13344-000	13345-000	13346-000	13347-000	13348-000			EXTENSION

H3	H4	H5	H6	H7	H8	H9	H10	H11	H12	SERIES
	13444-010	13445-010	13446-010	13447-010	13448-010	13449-010	13450-010	13451-010	13452-010	BOTTOM
	13444-01T	13445-01T	13446-01T	13447-01T	13448-01T	13449-01T	13450-01T	13451-01T	13452-01T	
	13464-000	13465-000	13466-000	13467-000	13468-000	13469-000	13470-000	13471-000	13472-000	PLUG
	13464-00T	13465-00T	13466-00T	13467-00T	13468-00T	13469-00T	13470-00T	13471-00T	13472-00T	
			13486-010	13487-010	13488-010	13489-010				OTL
			13536-410	13537-410	13538-410	13539-410				HP (B)
						13569-400				HP (P)
						13532-91L				*DIECAST (HP)
						13482-91L				*DIECAST (HP)
						13532-91C				*STEEL (HP)
						13482-91C				*STEEL (HP)
						13532-91U				*STAINLESS (HP)
						13482-91U				*STAINLESS (HP)
		13505-000	13506-000	13507-000	13508-000	13509-000				EXTENSION
		13525-000	13526-000	13527-000	13528-000	13529-000				EXTENSION
13543-000	13544-000	13545-000								STI

\*RED INDICATES COATED TAPS IN-STOCK

\* Highlighted products are premium quality taps that are targeted to specific industry needs

TAP SIZE	IMAGE	SERIES	BLANK	CHAMFER	COATING	CLASS 2B	CLASS 3B
3/8-24		BOTTOM	ANSI CNC	2.5	BRIGHT	H6, H7, H8	H5, H6
					TIN	H6, H7, H8	H5, H6
		PLUG	ANSI CNC	4	BRIGHT	H6, H7, H8	H5, H6
					TIN	H6, H7, H8	H5, H6
		OTL	ANSI CNC	1.5	BRIGHT	H6, H7, H8	H5, H6
		HP (B)	ANSI CNC	2.5	BRIGHT	H6, H7, H8	H5, H6
		HP (P)	ANSI CNC	4	BRIGHT	H6, H7, H8	H5, H6
		*DIECAST (HP)	ANSI CNC	2.5	BAL-PLUS	2B FIT	CFQ
					1.5	BAL-PLUS	2B FIT
		*STEEL (HP)	ANSI CNC	2.5	TiCN	2B FIT	CFQ
1.5					TiCN	2B FIT	CFQ
	*STAINLESS (HP)	ANSI CNC	2.5	STiN	2B FIT	CFQ	
				1.5	STiN	2B FIT	CFQ
	EXTENSION	ANSI	4" OAL	2.5	BRIGHT	H6, H7, H8	H5, H6
			6" OAL	2.5	BRIGHT	H6, H7, H8	H5, H6
7/16-14		BOTTOM	ANSI	2.5	BRIGHT	H8, H9, H10	H6, H7
					TIN	H8, H9, H10	H6, H7
		PLUG	ANSI	4	BRIGHT	H8, H9, H10	H6, H7
					TIN	H8, H9, H10	H6, H7
		HP	ANSI	2.5	BRIGHT	H8, H9, H10	H6, H7
	*STEEL (HP)	ANSI	2.5	TiCN	2B FIT	CFQ	
	*STAINLESS (HP)	ANSI	2.5	STiN	2B FIT	CFQ	
7/16-20		BOTTOM	ANSI	2.5	BRIGHT	H7, H8, H9	H5, H6
					TIN	H7, H8, H9	H5, H6
		PLUG	ANSI	4	BRIGHT	H7, H8, H9	H5, H6
					TIN	H7, H8, H9	H5, H6
		HP	ANSI	2.5	BRIGHT	H7, H8, H9	H5, H6
	*STEEL (HP)	ANSI	2.5	TiCN	2B FIT	CFQ	
	*STAINLESS (HP)	ANSI	2.5	STiN	2B FIT	CFQ	
1/2-13		BOTTOM	ANSI	2.5	BRIGHT	H9, H10, H11	H6, H7, H8
					TiN	H9, H10, H11	H6, H7, H8
		PLUG	ANSI	4	BRIGHT	H9, H10, H11	H6, H7, H8
					TIN	H9, H10, H11	H6, H7, H8
		HP	ANSI	2.5	BRIGHT	H9, H10, H11	H6, H7, H8
	*STEEL (HP)	ANSI	2.5	TiCN	2B FIT	CFQ	
	*STAINLESS (HP)	ANSI	2.5	STiN	2B FIT	CFQ	
1/2-20		BOTTOM	ANSI	2.5	BRIGHT	H7, H8, H9	H5, H6
					TIN	H7, H8, H9	H5, H6
	PLUG	ANSI	4	BRIGHT	H7, H8, H9	H5, H6	
				TIN	H7, H8, H9	H5, H6	

CFQ – CONTACT FACTORY FOR QUOTE • HP – HIGH PERFORMANCE  
 JIS – JAPANESE INDUSTRIAL STANDARD • OAL – OVER ALL LENGTH  
 OTL – ONE THREAD LEAD • STI – SCREW THREAD INSERT

\*RED INDICATES COATED TAPS IN-STOCK

H4	H5	H6	H7	H8	H9	H10	H11	H12	SERIES
13624-010	13625-010	13626-010	13627-010	13628-010	13629-010	13630-010	13631-010	13632-010	BOTTOM
13624-01T	13625-01T	13626-01T	13627-01T	13628-01T	13629-01T	13630-01T	13631-01T	13632-01T	
13644-000	13645-000	13646-000	13647-000	13648-000	13649-000	13650-000	13651-000	13652-000	PLUG
13644-00T	13645-00T	13646-00T	13647-00T	13648-00T	13649-00T	13650-00T	13651-00T	13652-00T	
	13665-010	13666-010	13667-010	13668-010					OTL
	13715-410	13716-410	13717-410	13718-410					HP (B)
				13738-400					HP (P)
				13712-91L					*DIECAST (HP)
				13662-91L					*STEEL (HP)
				13712-91C					*STAINLESS (HP)
				13662-91C					*DIECAST (HP)
				13712-91U					*STEEL (HP)
				13662-91U					*STAINLESS (HP)
13684-000	13685-000	13686-000	13687-000	13688-000					EXTENSION
13704-000	13705-000	13706-000	13707-000	13708-000					
13804-000	13805-000	13806-000	13807-000	13808-000	13809-000	13810-000	13811-000	13812-000	BOTTOM
13804-40T	13805-40T	13806-40T	13807-40T	13808-40T	13809-40T	13810-40T	13811-40T	13812-40T	
13824-000	13825-000	13826-000	13827-000	13828-000	13829-000	13830-000	13831-000	13832-000	PLUG
13824-40T	13825-40T	13826-40T	13827-40T	13828-40T	13829-40T	13830-40T	13831-40T	13832-40T	
					13842-600				HP
					13842-90C				*STEEL (HP)
					13842-90U				*STAINLESS (HP)
13924-000	13925-000	13926-000	13927-000	13928-000	13929-000	13930-000	13931-000	13932-000	BOTTOM
13924-40T	13925-40T	13926-40T	13927-40T	13928-40T	13929-40T	13930-40T	13931-40T	13932-40T	
13944-000	13945-000	13946-000	13947-000	13948-000	13949-000	13950-000	13951-000	13952-000	PLUG
13944-40T	13945-40T	13946-40T	13947-40T	13948-40T	13949-40T	13950-40T	13951-40T	13952-40T	
			13962-600						HP
			13962-90C						*STEEL (HP)
			13962-90U						*STAINLESS (HP)
14044-000	14045-000	14046-000	14047-000	14048-000	14049-000	14050-000	14051-000	14052-000	BOTTOM
14044-60T	14045-60T	14046-60T	14047-60T	14048-60T	14049-60T	14050-60T	14051-60T	14052-60T	
14064-000	14065-000	14066-000	14067-000	14068-000	14069-000	14070-000	14071-000	14072-000	PLUG
14064-60T	14065-60T	14066-60T	14067-60T	14068-60T	14069-60T	14070-60T	14071-60T	14072-60T	
					14082-600				HP
					14082-90C				*STEEL (HP)
					14082-90U				*STAINLESS (HP)
14164-000	14165-000	14166-000	14167-000	14168-000	14169-000	14170-000	14171-000	14172-000	BOTTOM
14164-60T	14165-60T	14166-60T	14167-60T	14168-60T	14169-60T	14170-60T	14171-60T	14172-60T	
14184-000	14185-000	14186-000	14187-000	14188-000	14189-000	14190-000	14191-000	14192-000	PLUG
14184-60T	14185-60T	14186-60T	14187-60T	14188-60T	14189-60T	14190-60T	14191-60T	14192-60T	

\*RED INDICATES COATED TAPS IN-STOCK

\* Highlighted products are premium quality taps that are targeted to specific industry needs

TAP SIZE	IMAGE	SERIES	BLANK	CHAMFER	COATING	CLASS 2B	CLASS 3B
1/2-20 Cont.		HP	ANSI	2.5	BRIGHT	H7, H8, H9	H5, H6
		*STEEL (HP)	ANSI	2.5	TiCN	2B FIT	CFQ
		*STAINLESS (HP)	ANSI	2.5	STiN	2B FIT	CFQ
9/16-12		BOTTOM	ANSI	2.5	BRIGHT	H9, H10, H11	H6, H7, H8
					TiN	H9, H10, H11	H6, H7, H8
		PLUG	ANSI	4	BRIGHT	H9, H10, H11	H6, H7, H8
					TiN	H9, H10, H11	H6, H7, H8
9/16-18		BOTTOM	ANSI	2.5	BRIGHT	H7, H8, H9	H5, H6, H7
					TiN	H7, H8, H9	H5, H6, H7
		PLUG	ANSI	4	BRIGHT	H7, H8, H9	H5, H6, H7
					TiN	H7, H8, H9	H5, H6, H7
5/8-11		BOTTOM	ANSI	2.5	BRIGHT	H10, H11, H12	H7, H8, H9
					TiN	H10, H11, H12	H7, H8, H9
		PLUG	ANSI	4	BRIGHT	H10, H11, H12	H7, H8, H9
					TiN	H10, H11, H12	H7, H8, H9
5/8-18		BOTTOM	ANSI	2.5	BRIGHT	H8, H9, H10	H5, H6, H7
					TiN	H8, H9, H10	H5, H6, H7
		PLUG	ANSI	4	BRIGHT	H8, H9, H10	H5, H6, H7
					TiN	H8, H9, H10	H5, H6, H7

TAP SIZE	IMAGE	SERIES	BLANK	CHAMFER	COATING	CLASS 2B	CLASS 3B
3/4-10		BOTTOM	ANSI	2.5	BRIGHT	H11, H12, H13	H7, H8, H9
					TiN	H11, H12, H13	H7, H8, H9
		PLUG	ANSI	4	BRIGHT	H11, H12, H13	H7, H8, H9
					TiN	H11, H12, H13	H7, H8, H9
3/4-16		BOTTOM	ANSI	2.5	BRIGHT	H9, H10, H11	H6, H7, H8
					TiN	H9, H10, H11	H6, H7, H8
		PLUG	ANSI	4	BRIGHT	H9, H10, H11	H6, H7, H8
					TiN	H9, H10, H11	H6, H7, H8
7/8-9		BOTTOM	ANSI	2.5	BRIGHT	H12, H13, H14	H8, H9, H10
					TiN	H12, H13, H14	H8, H9, H10
		PLUG	ANSI	4	BRIGHT	H12, H13, H14	H8, H9, H10
					TiN	H12, H13, H14	H8, H9, H10
7/8-14		BOTTOM	ANSI	2.5	BRIGHT	H10, H11, H12	H7, H8, H9
					TiN	H10, H11, H12	H7, H8, H9
		PLUG	ANSI	4	BRIGHT	H10, H11, H12	H7, H8, H9
					TiN	H10, H11, H12	H7, H8, H9
1-8		BOTTOM	ANSI	2.5	BRIGHT	H12, H13, H14	H9, H10, H11
					TiN	H12, H13, H14	H9, H10, H11
		PLUG	ANSI	4	BRIGHT	H12, H13, H14	H9, H10, H11
					TiN	H12, H13, H14	H9, H10, H11
1-12		BOTTOM	ANSI	2.5	BRIGHT	H11, H12, H13	H8, H9, H10
					TiN	H11, H12, H13	H8, H9, H10
		PLUG	ANSI	4	BRIGHT	H11, H12, H13	H8, H9, H10
					TiN	H11, H12, H13	H8, H9, H10

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H4	H5	H6	H7	H8	H9	H10	H11	H12	SERIES
			14202-600						HP
			14202-90C						*STEEL (HP)
			14202-90U						*STAINLESS (HP)
14284-000	14285-000	14286-000	14287-000	14288-000	14289-000	14290-000	14291-000	14292-000	BOTTOM
14284-60T	14285-60T	14286-60T	14287-60T	14288-60T	14289-60T	14290-60T	14291-60T	14292-60T	
14304-000	14305-000	14306-000	14307-000	14308-000	14309-000	14310-000	14311-000	14312-000	PLUG
14304-60T	14305-60T	14306-60T	14307-60T	14308-60T	14309-60T	14310-60T	14311-60T	14312-60T	
14404-000	14405-000	14406-000	14407-000	14408-000	14409-000	14410-000	14411-000	14412-000	BOTTOM
14404-60T	14405-60T	14406-60T	14407-60T	14408-60T	14409-60T	14410-60T	14411-60T	14412-60T	
14424-000	14425-000	14426-000	14427-000	14428-000	14429-000	14430-000	14431-000	14432-000	PLUG
14424-60T	14425-60T	14426-60T	14427-60T	14428-60T	14429-60T	14430-60T	14431-60T	14432-60T	
14524-000	14525-000	14526-000	14527-000	14528-000	14529-000	14530-000	14531-000	14532-000	BOTTOM
14524-60T	14525-60T	14526-60T	14527-60T	14528-60T	14529-60T	14530-60T	14531-60T	14532-60T	
14544-000	14545-000	14546-000	14547-000	14548-000	14549-000	14550-000	14551-000	14552-000	PLUG
14544-60T	14545-60T	14546-60T	14547-60T	14548-60T	14549-60T	14550-60T	14551-60T	14552-60T	
14644-000	14645-000	14646-000	14647-000	14648-000	14649-000	14650-000	14651-000	14652-000	BOTTOM
14644-60T	14645-60T	14646-60T	14647-60T	14648-60T	14649-60T	14650-60T	14651-60T	14652-60T	
14664-000	14665-000	14666-000	14667-000	14668-000	14669-000	14670-000	14671-000	14672-000	PLUG
14664-60T	14665-60T	14666-60T	14667-60T	14668-60T	14669-60T	14670-60T	14671-60T	14672-60T	

H6	H7	H8	H9	H10	H11	H12	H13	H14	SERIES
14766-000	14767-000	14768-000	14769-000	14770-000	14771-000	14772-000	14773-000	14774-000	BOTTOM
14766-60T	14767-60T	14768-60T	14769-60T	14770-60T	14771-60T	14772-60T	14773-60T	14774-60T	
14786-000	14787-000	14788-000	14789-000	14790-000	14791-000	14792-000	14793-000	14794-000	PLUG
14786-60T	14787-60T	14788-60T	14789-60T	14790-60T	14791-60T	14792-60T	14793-60T	14794-60T	
14886-000	14887-000	14888-000	14889-000	14890-000	14891-000	14892-000	14893-000	14894-000	BOTTOM
14886-60T	14887-60T	14888-60T	14889-60T	14890-60T	14891-60T	14892-60T	14893-60T	14894-60T	
14906-000	14907-000	14908-000	14909-000	14910-000	14911-000	14912-000	14913-000	14914-000	PLUG
14906-60T	14907-60T	14908-60T	14909-60T	14910-60T	14911-60T	14912-60T	14913-60T	14914-60T	
15006-000	15007-000	15008-000	15009-000	15010-000	15011-000	15012-000	15013-000	15014-000	BOTTOM
15006-60T	15007-60T	15008-60T	15009-60T	15010-60T	15011-60T	15012-60T	15013-60T	15014-60T	
15026-000	15027-000	15028-000	15029-000	15030-000	15031-000	15032-000	15033-000	15034-000	PLUG
15026-60T	15027-60T	15028-60T	15029-60T	15030-60T	15031-60T	15032-60T	15033-60T	15034-60T	
15126-000	15127-000	15128-000	15129-000	15130-000	15131-000	15132-000	15133-000	15134-000	BOTTOM
15126-60T	15127-60T	15128-60T	15129-60T	15130-60T	15131-60T	15132-60T	15133-60T	15134-60T	
15146-000	15147-000	15148-000	15149-000	15150-000	15151-000	15152-000	15153-000	15154-000	PLUG
15146-60T	15147-60T	15148-60T	15149-60T	15150-60T	15151-60T	15152-60T	15153-60T	15154-60T	
15246-000	15247-000	15248-000	15249-000	15250-000	15251-000	15252-000	15253-000	15254-000	BOTTOM
15246-60T	15247-60T	15248-60T	15249-60T	15250-60T	15251-60T	15252-60T	15253-60T	15254-60T	
15266-000	15267-000	15268-000	15269-000	15270-000	15271-000	15272-000	15273-000	15274-000	PLUG
15266-60T	15267-60T	15268-60T	15269-60T	15270-60T	15271-60T	15272-60T	15273-60T	15274-60T	
15366-000	15367-000	15368-000	15369-000	15370-000	15371-000	15372-000	15373-000	15374-000	BOTTOM
15366-60T	15367-60T	15368-60T	15369-60T	15370-60T	15371-60T	15372-60T	15373-60T	15374-60T	
15386-000	15387-000	15388-000	15389-000	15390-000	15391-000	15392-000	15393-000	15394-000	PLUG
15386-60T	15387-60T	15388-60T	15389-60T	15390-60T	15391-60T	15392-60T	15393-60T	15394-60T	

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MINIATURE






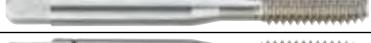



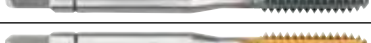
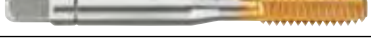



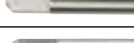




















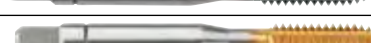
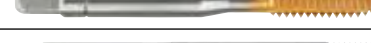
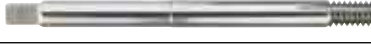


THREDFLOERS  
METRIC



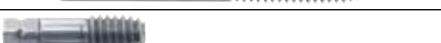








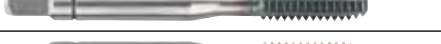



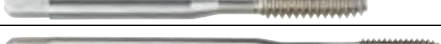


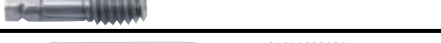



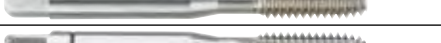








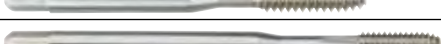







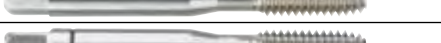




TAP SIZE	THREADS PER INCH	HOLE SIZE REQUIREMENT			TAP DRILL SIZE	BLANK	CHAMFER	COATING	CLASS UNM	
		75% THREAD	65% THREAD	55% THREAD					H#	EDP#
0.7mm X .175	145	.0247	.0250	.0254	#72	ANSI	2.5	BRIGHT	2	00802-000
0.8mm X .200	127	.0280	.0284	.0288	#70	ANSI	2.5	BRIGHT	2	00902-000
0.9mm X .225	113	.0314	.0319	.0323	1/32	ANSI	2.5	BRIGHT	2	01002-000
1.0mm X .250	102	.0348	.0353	.0358	#65	ANSI	2.5	BRIGHT	2	01102-000
1.1mm X .250	102	.0387	.0392	.0397	#61	ANSI	2.5	BRIGHT	2	01202-000
1.2mm X .250	102	.0427	.0432	.0437	#58	ANSI	2.5	BRIGHT	2	01302-000
1.4mm X .300	85	.0493	.0499	.0505	1.25mm	ANSI	2.5	BRIGHT	2	01402-000

TAP SIZE	IMAGE	SERIES	BLANK	CHAMFER	COATING	CLASS 4H		CLASS 6H		6G OVERSIZE	
						D#	EDP#	D#	EDP#	D#	EDP#
M1.6 X .35		BOTTOM	ANSI	2.5	BRIGHT	3	17003-010	5	17005-010	7	17007-010
					TiN	3	17003-01T	5	17005-01T	7	17007-01T
		DIN	DIN371	2.5	BRIGHT	3	17023-010	5	17025-010		
					TiN	3	17023-010	5	17025-010		
		JIS	JIS	2.5	BRIGHT	3	17043-010	5	17045-010		
		M1.7 X .35		BOTTOM	ANSI	2.5	BRIGHT	3	17143-010	5	17145-010
TiN	3						17143-01T	5	17145-01T	7	17147-01T
DIN	DIN371			2.5	BRIGHT	3	17163-010	5	17165-010		
					TiN	3	17163-010	5	17165-010		
JIS	JIS			2.5	BRIGHT	3	17183-010	5	17185-010		
M2 X .4				BOTTOM	ANSI	2.5	BRIGHT	3	17283-010	5	17285-010
		TiN	3				17283-01T	5	17285-01T	7	17287-01T
		OTL	ANSI	1.5	BRIGHT	3	17353-010	5	17355-010		
		STI	#4 ANSI	2.5	BRIGHT	2	17342-010	3	17343-010		
		DIN	DIN371	2.5	BRIGHT	3	17303-010	5	17305-010		
					TiN	3	17303-01T	5	17305-01T		
JIS	JIS	2.5	BRIGHT	3	17323-010	5	17325-010				
INLINE	INLINE	2.5	BRIGHT			5	17365-000				
M2.5 X .45		BOTTOM	ANSI	2.5	BRIGHT	3	17423-010	6	17426-010	8	17428-010
					TiN	3	17423-01T	6	17426-01T	8	17428-01T
		OTL	ANSI	1.5	BRIGHT	3	17493-010	6	17496-010		
		STI	#5 ANSI	2.5	BRIGHT	2	17482-010	3	17483-010		
		DIN	DIN371	2.5	BRIGHT	3	17443-010	6	17446-010		
					TiN	3	17443-01T	6	17446-01T		
JIS	JIS	2.5	BRIGHT	3	17463-010	6	17466-010				
INLINE	INLINE	2.5	BRIGHT			6	17506-000				
M2.6 X .45		BOTTOM	ANSI	2.5	BRIGHT	3	17513-010	6	17516-010		
					TiN	3	17513-01T	6	17516-01T		
M3 X .5		BOTTOM	ANSI	2.5	BRIGHT	3	17563-010	6	17566-010	8	17568-010
					TiN	3	17563-01T	6	17566-01T	8	17568-01T
	OTL	ANSI	1.5	BRIGHT	3	17583-010	6	17586-010			
	HP	ANSI	2.5	BRIGHT	3	17673-210	6	17676-210			
	*DIECAST (HP)	ANSI	2.5	BAL-PLUS		6	17676-81L				
				1.5	BAL-PLUS		6	17586-81L			
	*STEEL (HP)	ANSI	2.5	TiCN		6	17676-81C				
				1.5	TiCN		6	17586-81C			
	*STAINLESS (HP)	ANSI	2.5	STiN		6	17676-81U				
				1.5	STiN		6	17586-81U			
	EXTENSION	3" OAL	2.5	BRIGHT	3	17593-000	6	17596-000			
				4" OAL	2.5	BRIGHT	3	17603-000	6	17606-000	
STI	#8 ANSI	2.5	BRIGHT	2	17662-010	3	17663-010				
DIN	DIN371	2.5	BRIGHT	3	17623-210	6	17626-210				
			TiN	3	17623-21T	6	17626-21T				






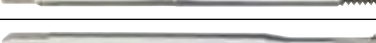










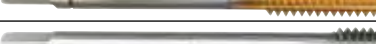
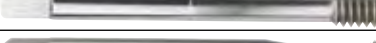







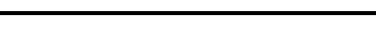




\*RED INDICATES COATED TAPS IN-STOCK

TAP SIZE	IMAGE	SERIES	BLANK	CHAMFER	COATING	CLASS 4H		CLASS 6H		6G OVERSIZE	
						D#	EDP#	D#	EDP#	D#	EDP#
M3 X .5 CONT.		JIS	JIS	2.5	BRIGHT	3	17643-010	6	17646-010		
		INLINE	INLINE	2.5	BRIGHT			6	17686-000		
M3.5 X .6		BOTTOM	ANSI CNC	2.5	BRIGHT	4	17744-010	7	17747-010	9	17749-010
	TiN				4	17744-01T	7	17747-01T	9	17749-01T	
		PLUG	ANSI CNC	4	BRIGHT	4	17764-000	7	17767-000		
	TiN				4	17764-00T	7	17767-00T			
		OTL	ANSI CNC	1.5	BRIGHT	4	17784-010	7	17787-010		
		HP	ANSI CNC	2.5	BRIGHT	4	17874-210	7	17877-210		
		*DIECAST (HP)	ANSI CNC	2.5	BAL-PLUS			7	17877-81L		
					BAL-PLUS			7	17878-81L		
		*STEEL (HP)	ANSI CNC	2.5	TiCN			7	17877-81C		
					TiCN			7	17878-81C		
		*STAINLESS (HP)	ANSI CNC	2.5	STiN			7	17877-81U		
					STiN			7	17878-81U		
		EXTENSION	3" OAL	2.5	BRIGHT	4	17794-000	7	17797-000		
										4" OAL	2.5
		STI	#10 ANSI	2.5	BRIGHT	3	17863-010	4	17864-010		
		DIN	DIN371	2.5	BRIGHT	4	17824-210	7	17827-210		
	TiN				4	17824-21T	7	17827-21T			
	JIS	JIS	2.5	BRIGHT	4	17844-010	7	17847-010			
	INLINE	INLINE	2.5	BRIGHT			7	17887-000			
M4 X .7		BOTTOM	ANSI CNC	2.5	BRIGHT	4	17944-010	7	17947-010	9	17949-010
					TiN	4	17944-01T	7	17947-01T	9	17949-01T
		PLUG	ANSI CNC	4	BRIGHT	4	17964-000	7	17967-000		
					TiN	4	17964-00T	7	17967-00T		
		OTL	ANSI CNC	1.5	BRIGHT	4	17984-010	7	17987-010		
		HP	ANSI CNC	2.5	BRIGHT	4	18074-210	7	18077-210		
		*DIECAST (HP)	ANSI CNC	2.5	BAL-PLUS			7	18077-81L		
					BAL-PLUS			7	17987-81L		
		*STEEL (HP)	ANSI CNC	2.5	TiCN			7	18077-81C		
					TiCN			7	17987-81C		
		*STAINLESS (HP)	ANSI CNC	2.5	STiN			7	18077-81U		
					STiN			7	17987-81U		
		EXTENSION	3" OAL	2.5	BRIGHT	4	17994-000	7	17997-000		
	4" OAL									2.5	BRIGHT
		STI	#10 ANSI	2.5	BRIGHT	3	18063-010	4	18064-010		
	DIN	DIN371	2.5	BRIGHT	4	18024-210	7	18027-210			
				TiN	4	18024-21T	7	18027-21T			
	JIS	JIS	2.5	BRIGHT	4	18044-010	7	18047-010			
	INLINE	INLINE	2.5	BRIGHT			7	18087-000			
M5 X .8		BOTTOM	ANSI CNC	2.5	BRIGHT	4	18144-010	8	18148-010	10	18150-010
					TiN	4	18144-01T	8	18148-01T	10	18150-01T
		PLUG	ANSI CNC	4	BRIGHT	4	18164-000	8	18168-000		
					TiN	4	18164-00T	8	18168-00T		
		OTL	ANSI CNC	1.5	BRIGHT	4	18184-010	8	18188-010		
		HP	ANSI CNC	2.5	BRIGHT	4	18274-410	8	18278-410		
		*DIECAST (HP)	ANSI CNC	2.5	BAL-PLUS			8	18278-91L		
					BAL-PLUS			8	18188-91L		
		*STEEL (HP)	ANSI CNC	2.5	TiCN			8	18278-91C		
					TiCN			8	18188-91C		
		*STAINLESS (HP)	ANSI CNC	2.5	STiN			8	18278-91U		
	STiN						8	18188-91U			
	EXTENSION	4" OAL	2.5	BRIGHT	4	18204-000	8	18208-000			
									6" OAL	2.5	BRIGHT
	STI	1/4 ANSI	2.5	BRIGHT	3	18263-010	4	18264-010			

THREDFLOERS  
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TAP SIZE	IMAGE	SERIES	BLANK	CHAMFER	COATING	CLASS 4H		CLASS 6H		6G OVERSIZE	
						D#	EDP#	D#	EDP#	D#	EDP#
M5 X 0.8 CONT.		DIN	DIN371	2.5	BRIGHT	4	18224-410	8	18228-410		
		JIS	JIS	2.5	BRIGHT	4	18244-010	8	18248-010		
		INLINE	INLINE	2.5	BRIGHT			8	18288-000		
M6 X 1.0		BOTTOM	ANSI CNC	2.5	BRIGHT	5	18345-010	9	18349-010	11	18351-010
	TiN				5	18345-01T	9	18349-01T	11	18351-01T	
		PLUG	ANSI CNC	4	BRIGHT	5	18365-000	9	18369-000		
	TiN				5	18365-00T	9	18369-00T			
		OTL	ANSI CNC	1.5	BRIGHT	5	18385-010	9	18389-010		
		HP (B)	ANSI CNC	2.5	BRIGHT	5	18475-410	9	18479-410		
		HP (P)	ANSI CNC	4	BRIGHT			9	18519-400		
		*DIECAST (HP)	ANSI CNC	2.5	BAL-PLUS			9	18479-91L		
	1.5			BAL-PLUS			9	18389-91L			
		*STEEL (HP)	ANSI CNC	2.5	TiCN			9	18479-91C		
	1.5			TiCN			9	18389-91C			
		*STAINLESS (HP)	ANSI CNC	2.5	STiN			9	18479-91U		
	1.5			STiN			9	18389-91U			
		EXTENSION	4" OAL	2.5	BRIGHT	5	18405-000	9	18409-000		
					6" OAL	2.5	BRIGHT	5	18415-000	9	18419-000
	STI	5/16 ANSI	2.5	BRIGHT	4	18464-010	5	18465-010			
	DIN	DIN371	2.5	BRIGHT	5	18425-410	9	18429-410			
				TiN	5	18425-41T	9	18429-41T			
	JIS	JIS	2.5	BRIGHT	5	18445-010	9	18449-010			
	INLINE	INLINE	2.5	BRIGHT			9	18489-000			
M8 X 1.25		BOTTOM	ANSI CNC	2.5	BRIGHT	5	18545-010	10	18550-010	12	18562-010
					TiN	5	18545-01T	10	18550-01T	12	18562-01T
		PLUG	ANSI CNC	4	BRIGHT	5	18565-000	10	18570-000		
					TiN	5	18565-00T	10	18570-00T		
		OTL	ANSI CNC	1.5	BRIGHT	5	18585-010	10	18590-010		
		HP (B)	ANSI CNC	2.5	BRIGHT	5	18675-410	10	18680-410		
		HP (P)	ANSI CNC	4	BRIGHT			10	18710-400		
		*DIECAST (HP)	ANSI CNC	2.5	BAL-PLUS			10	18680-91L		
				1.5	BAL-PLUS			10	18590-91L		
		*STEEL (HP)	ANSI CNC	2.5	TiCN			10	18680-91C		
				1.5	TiCN			10	18590-91C		
		*STAINLESS (HP)	ANSI CNC	2.5	STiN			10	18680-91U		
				1.5	STiN			10	18590-91U		
		EXTENSION	4" OAL	2.5	BRIGHT	5	18595-000	10	18600-000		
					6" OAL	2.5	BRIGHT	5	18605-000	10	18610-000
	STI	3/8 ANSI	2.5	BRIGHT	5	18665-010	6	18666-010			
	DIN	DIN371	2.5	BRIGHT	5	18625-410	10	18630-410			
				TiN	5	18625-41T	10	18630-41T			
	JIS	JIS	2.5	BRIGHT	5	18645-010	10	18650-010			
M10 X 1.0		BOTTOM	ANSI CNC	2.5	BRIGHT			9	19429-010		
					TiN			9	19429-01T		
M10 X 1.25		BOTTOM	ANSI CNC	2.5	BRIGHT			10	19450-010		
					TiN			10	19450-01T		
M10 X 1.5		BOTTOM	ANSI CNC	2.5	BRIGHT	6	18746-010	11	18751-010	13	18753-010
					TiN	6	18746-01T	11	18751-01T	13	18753-01T
		PLUG	ANSI CNC	4	BRIGHT	6	18766-000	11	18771-000		
					TiN	6	18766-00T	11	18771-00T		
	OTL	ANSI CNC	1.5	BRIGHT	6	18786-010	11	18791-010			
	HP (B)	ANSI CNC	2.5	BRIGHT	6	18856-410	11	18861-410			

\*RED INDICATES COATED TAPS IN-STOCK

TAP SIZE	IMAGE	SERIES	BLANK	CHAMFER	COATING	CLASS 4H		CLASS 6H	
						D#	EDP#	D#	EDP#
M10 X 1.5 CONT.		HP (P)	ANSI CNC	4	BRIGHT			11	18891-400
		*DIECAST (HP)	ANSI CNC	2.5	BAL-PLUS			11	18861-91L
				1.5	BAL-PLUS			11	18791-91L
		*STEEL (HP)	ANSI CNC	2.5	TICN			11	18861-91C
				1.5	TICN			11	18791-91C
		*STAINLESS (HP)	ANSI CNC	2.5	STiN			11	18861-91U
				1.5	STiN			11	18791-91U
		EXTENSION	4" OAL	2.5	BRIGHT	6	18796-000	11	18801-000
		6" OAL	2.5	BRIGHT	6	18806-000	11	18811-000	
		DIN	DIN371	2.5	BRIGHT	6	18826-400	11	18831-400
					TiN	6	18826-40T	11	18831-40T
		JIS	JIS	2.5	BRIGHT	6	18846-010	11	18851-010
M12 X 1.75		BOTTOM	ANSI	2.5	BRIGHT	6	18946-000	12	18952-000
					TiN	6	18946-40T	12	18952-40T
		PLUG	ANSI	4	BRIGHT	6	18966-000	12	18972-000
					TiN	6	18966-40T	12	18972-40T
		OTL	ANSI	1.5	BRIGHT	6	18986-000	12	18992-000
						HP (B)	ANSI	2.5	BRIGHT
		HP (P)	ANSI	4	BRIGHT				
					*DIECAST (HP)	ANSI	2.5	BAL-PLUS	
		*STEEL (HP)	ANSI	2.5				TICN	
					*STAINLESS (HP)	ANSI	2.5	STiN	
		EXTENSION	4" OAL	2.5				BRIGHT	6
					6" OAL	2.5	BRIGHT	6	19006-000
		DIN	DIN371	2.5			BRIGHT	6	19026-400
					DIN	DIN376	2.5	BRIGHT	
	JIS	JIS	2.5	TiN					
									
M14 X 1.25		PLUG	ANSI	4	BRIGHT	5	19095-000	10	19100-000
					TiN	5	19095-60T	10	19100-60T
M14 X 1.5		BOTTOM	ANSI	2.5	BRIGHT	6	19106-000	11	19111-000
					TiN	6	19106-60T	11	19111-60T
		PLUG	ANSI	4	BRIGHT	6	19126-000	11	19131-000
					TiN	6	19126-60T	11	19131-60T
M14 X 2.0		BOTTOM	ANSI	2.5	BRIGHT	7	19147-000	14	19154-000
					TiN	7	19147-60T	14	19154-60T
		PLUG	ANSI	4	BRIGHT	7	19167-000	14	19174-000
					TiN	7	19167-60T	14	19174-60T
M16 X 1.5		BOTTOM	ANSI	2.5	BRIGHT	6	19226-000	11	19231-000
					TiN	6	19226-60T	11	19231-60T
		PLUG	ANSI	4	BRIGHT	6	19246-000	11	19251-000
					TiN	6	19246-60T	11	19251-60T
M16 X 2.0		BOTTOM	ANSI	2.5	BRIGHT	7	19267-000	14	19274-000
					TiN	7	19267-60T	14	19274-60T
		PLUG	ANSI	4	BRIGHT	7	19287-000	14	19294-000
					TiN	7	19287-60T	14	19294-60T
M18 X 1.5		BOTTOM	ANSI	2.5	BRIGHT	6	19306-000	11	19331-000
					TiN	6	19306-60T	11	19331-60T
		PLUG	ANSI	4	BRIGHT	6	19326-000	11	19311-000
					TiN	6	19326-60T	11	19311-60T

\*RED INDICATES COATED TAPS IN-STOCK

\* Highlighted products are premium quality taps that are targeted to specific industry needs



## NPT AND NPTF THREDFLOER PIPE TAPS

Cold forming pipe taps may offer significant advantages compared to cutting taps when correctly applied. Benefits include smooth, burnished threads with no burrs or stop marks, better tap life, and the absence of chips during tapping.

To ensure successful results with a minimum of effort, a discussion of taper pipe tap applications with Balax "Application Engineers" is suggested prior to their purchase and use. The use of a torque limiting tap holder is recommended.



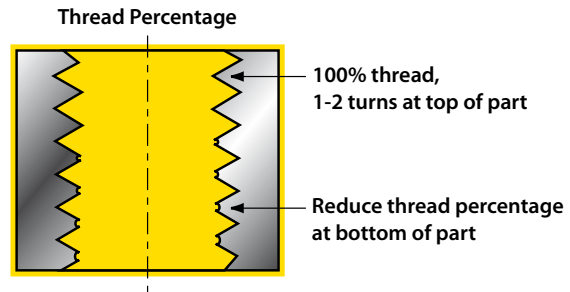
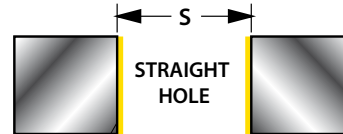
### STRAIGHT HOLE OPTION

For steel and stainless steel applications, straight hole tapping will reduce tapping torque and increase tap life.

Using the straight pre-tap hole, a cold forming tapered pipe tap will produce the correct tapered thread in the part by rearranging or flowing the metal from the top to the bottom of the hole.

This procedure will result in a sharp crested 100% thread at the top of the hole (usually 2 to 3 turns of complete thread), however, the thread at the bottom will have partially formed crests containing a cup or "U". For many applications, the highly polished and accurate threads at the top of the hole provide superior appearance and excellent sealing capability.

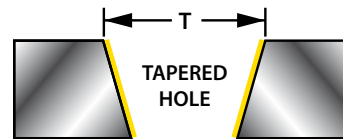
**USE THE STRAIGHT HOLE SIZES "S" IN THE TABLE BELOW.**



### TAPERED HOLE OPTION

For softer materials such as copper and aluminum where tapping torque is not a problem. The use of a tapered hole will result in a uniform thread height and crest configuration for the entire depth of thread in the part. This requires a special taper reamer.

**USE THE TAPER HOLE SIZES "T" IN THE TABLE BELOW.**



TAP SIZE NPT OR NPTF	NPT EDP#	NPTF EDP #	PROJECTION	STRAIGHT HOLE SIZE "S"			TAPER HOLE SIZE "T"		
				DUCTILE METALS	*DIE-CASTINGS	TOLERANCE	DUCTILE METALS	*DIE-CASTINGS	TOLERANCE
1/16-27	02000	02010	.130/.167"	.274"	.270"	+ .002"	.283"	.276"	+ .002"
1/8-27 SM (.3125 SHANK)	02100	02110	.130/.167"	.367"	.363"	+ .002"	.376"	.369"	+ .002"
1/8-27 LG (.4375 SHANK)	02200	02210	.130/.167"	.367"	.363"	+ .002"	.376"	.369"	+ .002"
1/4-18	02300	02310	.193/.249"	.478"	.474"	+ .003"	.492"	.481"	+ .003"
3/8-18	02400	02410	.193/.249"	.616"	.611"	+ .003"	.630"	.619"	+ .003"
1/2-14	02500	02510	.249/.321"	.763"	.759"	+ .003"	.781"	.766"	+ .003"
3/4-14	02600	02610	.249/.321"	.974"	.970"	+ .004"	.992"	.977"	+ .004"
1"-11.5	02700	02710	.305/.391"	1.221"	1.213"	+ .004"	1.243"	1.225"	+ .004"

*\*Sizes may have to be reduced for thin wall applications.*

## NPS AND NPSF THREDFLOER PIPE TAPS

NPS and NPSF threads require reamed pre-tap holes because of the requirement for 100% threads with controlled crest dimensions. NPSF taps are being successfully used in diecast applications, however, care in their application and use is required. Diecast aluminum containing high-silicon can become brittle when cold formed and may crumble at the crest of the thread.



TAP SIZE	NPS EDP #	NPSC EDP #	NPSM EDP #	NPSF EDP #	CHAMFER	*HOLE SIZE FOR 75% THREAD	
						NPS, NPSC, NPSM	NPSF
1/16-27				02030	2.5	-	.281 - .282"
1/8-27 SM (.3125 SHANK)	02120	02122	02124	02130	2.5	.379 - .380"	.373 - .374"
1/8-27 LG (.4375 SHANK)	02220	02222	02224	02230	2.5	.379 - .380"	.373 - .374"
1/4-18	02320	02322	02324	02330	2.5	.499 - .500"	.491 - .492"
3/8-18	02420	02422	02424	02430	2.5	.636 - .637"	.626 - .627"
1/2-14	02520	02522	02524	02530	2.5	.788 - .790"	.777 - .779"
3/4-14	02620	02622	02624	02630	2.5	.998 - 1.000"	.988 - .990"

*\* For diecast parts, subtract .001" - .002" to compensate for porosity.*

## COOLANT-THRU TAPS

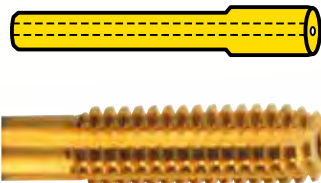
### FAST DELIVERY ON STANDARD COOLANT-THRU TAPS

Using Balax's EDM process, almost any standard Thredfloer tap can be modified into the coolant-thru tap style of your choice: thru-coolant, radial coolant, or angular coolant. It's economical and turn-around time is fast.

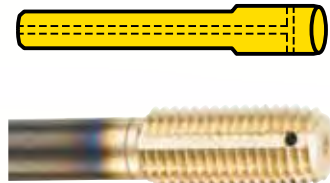
### SPECIAL COOLANT-THRU TAPS FOR CUSTOM APPLICATIONS

For processes requiring an engineered special coolant-thru tap, custom tap blanks are made with coolant-thru holes in the style best suited for the tapping application.

#### THRU - COOLANT



#### RADIAL - COOLANT

















#### ANGULAR - COOLANT























# THREDSHAVER SERIES AND APPLICATION CHART









THREDSHAVERS

TAP IMAGE								
HOLE TYPE: THRU OR BLIND								
SERIES		BX100	BX150	BX160	BX170	BX200	BX201	BX210
DESCRIPTION		SPIRAL POINT HIGH HOOK	SPIRAL POINT HARD STEEL	SPIRAL POINT A286	EXTENSION SPIRAL POINT	45° SPIRAL FLUTE	OTL 45° SPIRAL FLUTE	DIN LENGTH 38° SPIRAL FLUTE
STEEL AND STAINLESS STEEL	LOW CARBON STEEL <20Rc	●			●	●	●	●
	MEDIUM CARBON STEEL <30Rc		●					●
	HIGH CARBON STEEL <42Rc							
	ALLOY STEEL <35Rc		●					
	TOOL STEELS <35Rc		●					
	300 SERIES STAINLESS STEEL	●		●	●	●	●	
	400 SERIES STAINLESS STEEL		●					
IRON	CAST IRON / DUCTILE IRON							
NON-FERROUS	WROUGHT ALUMINUM ALLOYS	●			●	●	●	
	ALUMINUM DIECAST	●			●	●	●	
	ZINC DIECAST	●			●	●	●	
	MAGNESIUM	●			●	●	●	
	COPPER & BRASS	●			●	●	●	
	BRASS/BRONZE CASTINGS	●			●			
AEROSPACE	TITANIUM 6AL4V							
	NICKEL ALLOYS, INCONEL							
	A286, WAsPALLOY			●				

THREDSHAVERS





TAP IMAGE											
HOLE TYPE: THRU OR BLIND											
SERIES		BX220	BX300	BX400	BX500	BX510	BX600	BX610	BX700	BX710	BX800
DESCRIPTION		EXTENSION 45° SPIRAL FLUTE	STI 45° SPIRAL FLUTE	15° SPIRAL FLUTE HARD STEEL	15° SPIRAL FLUTE DIECAST ALUMINIUM	DIN 15° SPIRAL FLUTE DIECAST ALUMINIUM	PREMIUM STEEL STRAIGHT FLUTE CAST IRON	DIN PREMIUM STEEL STRAIGHT FLUTE CAST IRON	NPSF STRAIGHT FLUTE	NPT/NPTF SPIRAL FLUTE	CLEANOUT TAP
		●	●							●	
				●						●	
				●							
				●						●	
		●	●								●
				●							
					●	●	●	●	●	●	
		●	●		●	●					●
							●	●	●		

Designed for removing dirt, paint, weld spatter, and other obstructions in existing tapped holes. Cleanout taps have a special geometry to prevent recutting of thread flanks or cross threading that would result in damage to the part.

TAP SIZE	IMAGE	SERIES	DESCRIPTION	BLANK	# FLUTES	CHAMFER	COATING
2-56		BX100	SPIRAL POINT HIGH HOOK	ANSI	2	4.5	BRIGHT
			SPIRAL POINT STEEL	ANSI	2	4.5	TIN
			SPIRAL POINT STAINLESS	ANSI	2	4.5	TiCN
		BX150	SPIRAL POINT HARD STEEL	ANSI	2	5.5	NIT/STEAM
		BX200	45° HI-SPIRAL ALUMINUM	ANSI	2	2.5	BRIGHT
			45° HI-SPIRAL	ANSI	2	2.5	STEAM OXIDE
			45° HI-SPIRAL STEEL	ANSI	2	2.5	TIN
			45° HI-SPIRAL STAINLESS	ANSI	2	2.5	TiCN
	BX300	STI – 45° HI-SPIRAL	#3 ANSI	2	2.5	BRIGHT	
	BX400	15° SLO-SPIRAL HARD STEEL	ANSI	3	3	NIT/STEAM	
3-48		BX100	SPIRAL POINT HIGH HOOK	ANSI	2	4.5	BRIGHT
			SPIRAL POINT STEEL	ANSI	2	4.5	TIN
			SPIRAL POINT STAINLESS	ANSI	2	4.5	TiCN
		BX150	SPIRAL POINT HARD STEEL	ANSI	2	5.5	NIT/STEAM
		BX200	45° HI-SPIRAL ALUMINUM	ANSI	2	2.5	BRIGHT
			45° HI-SPIRAL	ANSI	2	2.5	STEAM OXIDE
			45° HI-SPIRAL STEEL	ANSI	2	2.5	TIN
			45° HI-SPIRAL STAINLESS	ANSI	2	2.5	TiCN
	BX300	STI – 45° HI-SPIRAL	#5 ANSI	3	2.5	BRIGHT	
	BX400	15° SLO-SPIRAL HARD STEEL	ANSI	3	3	NIT/STEAM	
4-40		BX100	SPIRAL POINT HIGH HOOK	ANSI	2	4.5	BRIGHT
			SPIRAL POINT STEEL	ANSI	3	4.5	BRIGHT
			SPIRAL POINT STEEL	ANSI	3	4.5	TIN
			SPIRAL POINT STAINLESS	ANSI	3	4.5	TiCN
	BX150	SPIRAL POINT HARD STEEL	ANSI	3	5.5	NIT/STEAM	
	BX170	EXTENSION – SPIRAL POINT	4" OAL	3	4.5	BRIGHT	
		BX200	45° HI-SPIRAL ALUMINUM	ANSI	2	2.5	BRIGHT
			45° HI-SPIRAL	ANSI	2	2.5	STEAM OXIDE
			45° HI-SPIRAL STEEL	ANSI	2	2.5	TIN
			45° HI-SPIRAL STAINLESS	ANSI	2	2.5	TiCN
BX220	EXTENSION – 45° HI-SPIRAL	4" OAL	2	2.5	BRIGHT		
BX300	STI – 45° HI-SPIRAL	#6 ANSI CNC	3	2.5	BRIGHT		
BX400	15° SLO-SPIRAL HARD STEEL	ANSI	3	3	NIT/STEAM		
5-40		BX100	SPIRAL POINT HIGH HOOK	ANSI	2	4.5	BRIGHT
			SPIRAL POINT STEEL	ANSI	3	4.5	BRIGHT
			SPIRAL POINT STEEL	ANSI	3	4.5	TIN
			SPIRAL POINT STAINLESS	ANSI	3	4.5	TiCN
	BX150	SPIRAL POINT HARD STEEL	ANSI	3	5.5	NIT/STEAM	
		BX200	45° HI-SPIRAL ALUMINUM	ANSI	2	2.5	BRIGHT
			45° HI-SPIRAL	ANSI	2	2.5	STEAM OXIDE
			45° HI-SPIRAL STEEL	ANSI	2	2.5	TIN
			45° HI-SPIRAL STAINLESS	ANSI	2	2.5	TiCN
	BX400	15° SLO-SPIRAL HARD STEEL	ANSI	3	3	NIT/STEAM	

\*RED INDICATES COATED TAPS IN-STOCK

CLASS 2B	CLASS 3B	H1	H2	H3	H4	H5	H6	H7	SERIES
H2	H1	30001-000	30002-000	30003-000					BX100
H2	H1	30001-00T	30002-00T	30003-00T					
H2	H1	30001-00C	30002-00C	30003-00C					
H2	H1		32002-006	32003-006					BX150
H2	H1	40001-010	40002-010	40003-010					BX200
H2	H1	40001-01S	40002-01S	40003-01S					
H2	H1	40001-01T	40002-01T	40003-01T					
H2	H1	40001-01C	40002-01C	40003-01C					BX300
H2	H1		44002-010						BX400
H2	H1		51002-016	51003-016					BX400
H2	H1	30011-000	30012-000	30013-000					BX100
H2	H1	30011-00T	30012-00T	30013-00T					
H2	H1	30011-00C	30012-00C	30013-00C					
H2	H1		32012-006	32013-006					BX150
H2	H1	40011-010	40012-010	40013-010					BX200
H2	H1	40011-01S	40012-01S	40013-01S					
H2	H1	40011-01T	40012-01T	40013-01T					
H2	H1	40011-01C	40012-01C	40013-01C					BX300
H2	H1		44012-010						BX400
H2	H1		51012-016	51013-016					BX400
H2	H2		34222-000	34223-000	34224-000	34225-000	34226-000	34227-000	BX100
H2	H2		30022-000	30023-000	30024-000	30025-000	30026-000	30027-000	
H2	H2		30022-00T	30023-00T	30024-00T	30025-00T	30026-00T	30027-00T	
H2	H2		30022-00C	30023-00C	30024-00C	30025-00C	30026-00C	30027-00C	BX150
H2	H2		32322-006	32323-006	32324-006	32325-006			BX170
H2	H2		35002-000						BX170
H2	H2		40022-010	40023-010	40024-010	40025-010	40026-010	40027-010	BX200
H2	H2		40022-01S	40023-01S	40024-01S	40025-01S	40026-01S	40027-01S	
H2	H2		40022-01T	40023-01T	40024-01T	40025-01T	40026-01T	40027-01T	
H2	H2		40022-01C	40023-01C	40024-01C	40025-01C	40026-01C	40027-01C	BX200
H2	H2		46002-010						BX220
H2	H1		44022-010	44023-010					BX300
H2	H2			51023-016					BX400
H2	H2		34232-000	34233-000	34234-000	34235-000	34236-000	34237-000	BX100
H2	H2		30032-000	30033-000	30034-000	30035-000	30036-000	30037-000	
H2	H2		30032-00T	30033-00T	30034-00T	30035-00T	30036-00T	30037-00T	
H2	H2		30032-00C	30033-00C	30034-00C	30035-00C	30036-00C	30037-00C	BX150
H2	H2		32032-006	32033-006	32034-006	32035-006			BX150
H2	H2		40032-010	40033-010	40034-010	40035-010	40036-010	40037-010	BX200
H2	H2		40032-01S	40033-01S	40034-01S	40035-01S	40036-01S	40037-01S	
H2	H2		40032-01T	40033-01T	40034-01T	40035-01T	40036-01T	40037-01T	
H2	H2		40032-01C	40033-01C	40034-01C	40035-01C	40036-01C	40037-01C	BX200
H2	H2			51033-016					BX400

TAP SIZE	IMAGE	SERIES	DESCRIPTION	BLANK	# FLUTES	CHAMFER	COATING
6-32		BX100	SPIRAL POINT HIGH HOOK	ANSI CNC	2	4.5	BRIGHT
			SPIRAL POINT STEEL	ANSI CNC	3	4.5	BRIGHT
			SPIRAL POINT STAINLESS STEEL	ANSI CNC	3	4.5	TiCN
		BX150	SPIRAL POINT HARD STEEL	ANSI CNC	3	5.5	NIT/STEAM
	BX160	SPIRAL POINT - A286	ANSI CNC	3	5.5	TiN	
	3			5.5	TiCN		
	BX170	EXTENSION - SPIRAL POINT	4" OAL	3	4.5	BRIGHT	
		BX200	45° HI-SPIRAL ALUMINUM	ANSI CNC	3	2.5	BRIGHT
			45° HI-SPIRAL	ANSI CNC	3	2.5	STEAM OXIDE
			45° HI-SPIRAL STEEL	ANSI CNC	3	2.5	TiN
			45° HI-SPIRAL STAINLESS	ANSI CNC	3	2.5	TiCN
	BX201	OTL 45° HI-SPIRAL	ANSI CNC	3	1.5	BRIGHT	
	BX220	EXTENSION - 45° HI-SPIRAL	4" OAL	3	2.5	BRIGHT	
	BX300	STI - 45° HI-SPIRAL	#10 ANSI CNC	3	2.5	BRIGHT	
BX400	15° SLO-SPIRAL HARD STEEL	ANSI CNC	3	3	NIT/STEAM		
BX500	SLO-SPIRAL DIECAST	ANSI CNC	3	2	BRIGHT		
			3	2	TiN		
BX600	STRAIGHT FLUTE CAST IRON	ANSI CNC	3	2	BRIGHT		
			3	2	TiCN		
8-32		BX100	SPIRAL POINT HIGH HOOK	ANSI CNC	3	4.5	BRIGHT
			SPIRAL POINT STEEL	ANSI CNC	3	4.5	TiN
			SPIRAL POINT STAINLESS STEEL	ANSI CNC	3	4.5	TiCN
		BX150	SPIRAL POINT HARD STEEL	ANSI CNC	3	5.5	NIT/STEAM
	BX160	SPIRAL POINT A286	ANSI CNC	3	5.5	TiN	
				3	5.5	TiCN	
	BX170	EXTENSION - SPIRAL POINT	4" OAL	3	4.5	BRIGHT	
		BX200	45° HI-SPIRAL ALUMINUM	ANSI CNC	3	2.5	BRIGHT
			45° HI-SPIRAL	ANSI CNC	3	2.5	STEAM OXIDE
			45° HI-SPIRAL STEEL	ANSI CNC	3	2.5	TiN
			45° HI-SPIRAL STAINLESS	ANSI CNC	3	2.5	TiCN
	BX201	OTL 45° HI-SPIRAL	ANSI CNC	3	1.5	BRIGHT	
	BX220	EXTENSION - 45° HI SPIRAL	4" OAL	3	2.5	BRIGHT	
	BX300	STI - 45° HI SPIRAL	#12 ANSI CNC	3	2.5	BRIGHT	
BX400	15° SLO-SPIRAL HARD STEEL	ANSI CNC	3	3	NIT/STEAM		
BX500	SLO-SPIRAL DIECAST	ANSI CNC	3	2	BRIGHT		
			3	2	TiN		
BX600	STRAIGHT FLUTE CAST IRON	ANSI CNC	3	2	BRIGHT		
			3	2	TiCN		

**COOLANT-THRU TAPS**

**FAST DELIVERY ON STANDARD COOLANT-THRU TAPS**

Using Balax's EDM process, almost any standard Thredfloer tap can be modified into the coolant-thru tap style of your choice: thru-coolant, radial coolant, or angular coolant. It's economical and turn-around time is fast.

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For processes requiring an engineered special coolant-thru tap, custom tap blanks are made with coolant-thru holes in the style best suited for the tapping application.

\*RED INDICATES COATED TAPS IN-STOCK

CLASS 2B	CLASS 3B	H2	H3	H4	H5	H6	H7	SERIES
H3	H2	34242-000	34243-000	34244-000	34245-000	34246-000	34247-000	BX100
H3	H2	30042-000	30043-000	30044-000	30045-000	30046-000	30047-000	
H3	H2	30042-00T	30043-00T	30044-00T	30045-00T	30046-00T	30047-00T	
H3	H2	30042-00C	30043-00C	30044-00C	30045-00C	30046-00C	30047-00C	
H3	H2	32042-006	32043-006	32044-006	32045-006	32046-006	32047-006	BX150
H3	H2		34043-00T	34044-00T	34045-00T	34046-00T	34047-00T	BX160
H3	H2		34043-00C	34044-00C	34045-00C	34046-00C	34047-00C	
H3	H2		35203-000					BX170
H3	H2	40042-010	40043-010	40044-010	40045-010	40046-010	40047-010	BX200
H3	H2	40042-01S	40043-01S	40044-01S	40045-01S	40046-01S	40047-01S	
H3	H2	40042-01T	40043-01T	40044-01T	40045-01T	40046-01T	40047-01T	
H3	H2	40042-01C	40043-01C	40044-01C	40045-01C	40046-01C	40047-01C	
H3	H2		41043-010					BX201
H3	H2		46203-010					BX220
H3	H2	44032-010	44033-010					BX300
H3	H2		51043-016		51045-016			BX400
H3	H2		52463-010					BX500
H3	H2		52463-01T					
H3	H2		54003-010		54005-010			BX600
H3	H2		54003-01C		54005-01C			
H3	H2	30052-000	30053-000	30054-000	30055-000	30056-000	30057-000	BX100
H3	H2	30052-00T	30053-00T	30054-00T	30055-00T	30056-00T	30057-00T	
H3	H2	30052-00C	30053-00C	30054-00C	30055-00C	30056-00C	30057-00C	
H3	H2	32052-006	32053-006	32054-006	32055-006	32056-006	32057-006	
H3	H2		34053-00T	34054-00T	34055-00T	34056-00T	34057-00T	BX160
H3	H2		34053-00C	34054-00C	34055-00C	34056-00C	34057-00C	
H3	H2		35303-000					BX170
H3	H2	40052-010	40053-010	40054-010	40055-010	40056-010	40057-010	BX200
H3	H2	40052-01S	40053-01S	40054-01S	40055-01S	40056-01S	40057-01S	
H3	H2	40052-01T	40053-01T	40054-01T	40055-01T	40056-01T	40057-01T	
H3	H2	40052-01C	40053-01C	40054-01C	40055-01C	40056-01C	40057-01C	
H3	H2		41053-010					BX201
H3	H2		46303-010					BX220
H3	H2	44042-010	44043-010					BX300
H3	H2		51053-016		51055-016			BX400
H3	H2		52473-010					BX500
H3	H2		52473-01T					
H3	H2		54013-010		54015-010			BX600
H3	H2		54013-01C		54015-01C			

**THRU - COOLANT**






**RADIAL - COOLANT**



**ANGULAR - COOLANT**



TAP SIZE	IMAGE	SERIES	DESCRIPTION	BLANK	# FLUTES	CHAMFER	COATING	
10-24		BX100	SPIRAL POINT HIGH HOOK	ANSI CNC	3	4.5	BRIGHT	
			SPIRAL POINT STEEL	ANSI CNC	3	4.5	TIN	
			SPIRAL POINT STAINLESS STEEL	ANSI CNC	3	4.5	TiCN	
		BX150	SPIRAL POINT HARD STEEL	ANSI CNC	3	5.5	NIT/STEAM	
		BX170	EXTENSION – SPIRAL POINT	6" OAL	3	4.5	BRIGHT	
			BX200	45° HI-SPIRAL ALUMINUM	ANSI CNC	3	2.5	BRIGHT
				45° HI-SPIRAL	ANSI CNC	3	2.5	STEAM OXIDE
				45° HI-SPIRAL STEEL	ANSI CNC	3	2.5	TIN
		45° HI-SPIRAL STAINLESS		ANSI CNC	3	2.5	TiCN	
		BX201	OTL 45° HI-SPIRAL	ANSI CNC	3	1.5	BRIGHT	
		BX220	EXTENSION – 45° HI SPIRAL	6" OAL	3	2.5	BRIGHT	
		BX300	STI – 45° HI SPIRAL	1/4" ANSI CNC	3	2.5	BRIGHT	
BX400	15° SLO-SPIRAL HARD STEEL	ANSI CNC	3	3	NIT/STEAM			
BX500	SLO-SPIRAL DIECAST	ANSI CNC	3	2	BRIGHT			
			3	2	TIN			
BX600	STRAIGHT FLUTE CAST IRON	ANSI CNC	4	2	BRIGHT			
			4	2	TiCN			
10-32		BX100	SPIRAL POINT HIGH HOOK	ANSI CNC	3	4.5	BRIGHT	
			SPIRAL POINT STEEL	ANSI CNC	3	4.5	TIN	
			SPIRAL POINT STAINLESS	ANSI CNC	3	4.5	TiCN	
		BX150	SPIRAL POINT HARD STEEL	ANSI CNC	3	5.5	NIT/STEAM	
		BX160	SPIRAL POINT – A286	ANSI CNC	3	5.5	TIN	
				ANSI CNC	3	5.5	TiCN	
	BX170	EXTENSION – SPIRAL POINT	6" OAL	3	4.5	BRIGHT		
	BX200	45° HI-SPIRAL	ALUMINUM	ANSI CNC	3	2.5	BRIGHT	
			STEAM OXIDE	ANSI CNC	3	2.5	STEAM OXIDE	
			TIN	ANSI CNC	3	2.5	TIN	
			TiCN	ANSI CNC	3	2.5	TiCN	
	BX201	OTL 45° HI-SPIRAL	ANSI CNC	3	1.5	BRIGHT		
	BX220	EXTENSION – 45° HI SPIRAL	6" OAL	3	2.5	BRIGHT		
	BX300	STI – 45° HI SPIRAL	1/4" ANSI CNC	3	2.5	BRIGHT		
	BX400	15° SLO-SPIRAL HARD STEEL	ANSI CNC	3	3	NIT/STEAM		
	BX500	SLO-SPIRAL DIECAST	ANSI CNC	3	2	BRIGHT		
				3	2	TIN		
	BX600	STRAIGHT FLUTE CAST IRON	ANSI CNC	4	2	BRIGHT		
4				2	TiCN			

**BALAX SERIES BX400**

Engineered for blind hole applications in difficult to cut materials, including many aerospace materials. The slow spiral flute design provides excellent tap strength while lifting chips from the

bottom of the hole. **BX400** taps are ground with special thread profiles to reduce tapping torque while providing accurate thread gaging results.



\*RED INDICATES COATED TAPS IN-STOCK

CLASS 2B	CLASS 3B	H2	H3	H4	H5	H6	H7	SERIES
H3	H3	30062-000	30063-000	30064-000	30065-000	30066-000	30067-000	BX100
H3	H3	30062-00T	30063-00T	30064-00T	30065-00T	30066-00T	30067-00T	
H3	H3	30062-00C	30063-00C	30064-00C	30065-00C	30066-00C	30067-00C	
H3	H3	32062-006	32063-006	32064-006	32065-006	32066-006	32067-006	BX150
H3	H3		35403-000					BX170
H3	H3	40062-010	40063-010	40064-010	40065-010	40066-010	40067-010	BX200
H3	H3	40062-01S	40063-01S	40064-01S	40065-01S	40066-01S	40067-01S	
H3	H3	40062-01T	40063-01T	40064-01T	40065-01T	40066-01T	40067-01T	
H3	H3	40062-01C	40063-01C	40064-01C	40065-01C	40066-01C	40067-01C	BX201
H3	H3		41063-010					BX220
H3	H3		46403-010					BX300
H3	H2	44052-010	44053-010					BX400
H3	H3		51063-016		51065-016			BX500
H3	H3		52483-010					BX600
H3	H3		52483-01T					BX600
H3	H3		54023-010		54025-010			BX600
H3	H3		54023-01C		54025-01C			BX600
H3	H2	30072-000	30073-000	30074-000	30075-000	30076-000	30077-000	BX100
H3	H2	30072-00T	30073-00T	30074-00T	30075-00T	30076-00T	30077-00T	
H3	H2	30072-00C	30073-00C	30074-00C	30075-00C	30076-00C	30077-00C	
H3	H2	32072-006	32073-006	32074-006	32075-006	32076-006	32077-006	BX150
H3	H2		34073-00T	34074-00T	34075-00T	34076-00T	34077-00T	BX160
H3	H2		34073-00C	34074-00C	34075-00C	34076-00C	34077-00C	
H3	H2		35503-000					BX170
H3	H2	40072-010	40073-010	40074-010	40075-010	40076-010	40077-010	BX200
H3	H2	40072-01S	40073-01S	40074-01S	40075-01S	40076-01S	40077-01S	
H3	H2	40072-01T	40073-01T	40074-01T	40075-01T	40076-01T	40077-01T	
H3	H2	40072-01C	40073-01C	40074-01C	40075-01C	40076-01C	40077-01C	BX201
H3	H2		41073-010					BX220
H3	H2		46503-010					BX300
H3	H2	44062-010	44063-010					BX400
H3	H2		51073-016		51075-016			BX500
H3	H2		52493-010					BX600
H3	H2		52493-01T					BX600
H3	H2		54033-010		54035-010			BX600
H3	H2		54033-01C		54035-01C			BX600

**BALAX SERIES BX500**









Slow Spiral Flute Thredshavers are engineered for multi-spindle applications in diecast aluminum. The heavy duty slow spiral design provides additional tap strength compared to hi-spiral

flute taps and excellent chip evacuation for deep blind hole tapping. Stock Coolant-Thru Diecast Thredshavers are now available to improve chip evacuation and tap life.

TAP SIZE	IMAGE	SERIES	DESCRIPTION	BLANK	# FLUTES	CHAMFER	COATING
1/4-20		BX100	SPIRAL POINT HIGH HOOK	ANSI CNC	3	4.5	BRIGHT
			SPIRAL POINT STEEL	ANSI CNC	3	4.5	TIN
			SPIRAL POINT STAINLESS	ANSI CNC	3	4.5	TiCN
		BX150	SPIRAL POINT HARD STEEL	ANSI CNC	3	5.5	NIT/STEAM
	BX170	EXTENSION - SPIRAL POINT	6" OAL	3	4.5	BRIGHT	
		BX200	45° HI-SPIRAL ALUMINUM	ANSI CNC	3	2.5	BRIGHT
			45° HI-SPIRAL	ANSI CNC	3	2.5	STEAM OXIDE
			45° HI-SPIRAL STEEL	ANSI CNC	3	2.5	TIN
			45° HI-SPIRAL STAINLESS	ANSI CNC	3	2.5	TiCN
		BX201	OTL 45° HI-SPIRAL	ANSI CNC	3	1.5	BRIGHT
	BX220	EXTENSION - 45° HI SPIRAL	6" OAL	3	2.5	BRIGHT	
	BX300	STI - 45° HI SPIRAL	5/16" ANSI CNC	3	2.5	BRIGHT	
BX400	15° SLO-SPIRAL HARD STEEL	ANSI CNC	3	3	NIT/STEAM		
	BX500	SLO-SPIRAL DIECAST	ANSI CNC	3	2	BRIGHT	
		SLO-SPIRAL DIECAST-TIN	ANSI CNC	3	2	TIN	
		SLO-SPIRAL DIECAST-COOLANT THRU	ANSI CNC	3	2	BRIGHT	
		SLO-SPIRAL DIECAST-TiCN	ANSI CNC	3	2	TIN	
	BX600	STRAIGHT FLUTE CAST IRON	ANSI CNC	4	2	BRIGHT	
		STRAIGHT FLUTE CAST IRON-TiCN	ANSI CNC	4	2	TiCN	
		STRAIGHT FLUTE CAST IRON-COOLANT THRU	ANSI CNC	4	2	BRIGHT	
BX800	CLEANOUT TAP	ANSI	3	4	NIT/STEAM		
1/4-28		BX100	SPIRAL POINT HIGH HOOK	ANSI CNC	3	4.5	BRIGHT
			SPIRAL POINT STEEL	ANSI CNC	3	4.5	TIN
			SPIRAL POINT STAINLESS STEEL	ANSI CNC	3	4.5	TiCN
		BX150	SPIRAL POINT HARD STEEL	ANSI CNC	3	5.5	NIT/STEAM
		BX160	SPIRAL POINT -A286	ANSI CNC	3	5.5	TIN
		ANSI CNC	3	5.5	TiCN		
	BX170	EXTENSION - SPIRAL POINT	6" OAL	3	4.5	BRIGHT	
		BX200	45° HI-SPIRAL ALUMINUM	ANSI CNC	3	2.5	BRIGHT
			45° HI-SPIRAL	ANSI CNC	3	2.5	STEAM OXIDE
			45° HI-SPIRAL STEEL	ANSI CNC	3	2.5	TIN
			45° HI-SPIRAL STAINLESS	ANSI CNC	3	2.5	TiCN
	BX201	OTL 45° HI-SPIRAL	ANSI CNC	3	1.5	BRIGHT	
BX220	EXTENSION - 45° HI SPIRAL	6" OAL	3	2.5	BRIGHT		
BX300	STI - 45° HI SPIRAL	5/16" ANSI CNC	3	2.5	BRIGHT		
BX400	15° SLO-SPIRAL HARD STEEL	ANSI CNC	3	3	NIT/STEAM		
	BX500	SLO-SPIRAL DIECAST	ANSI CNC	3	2	BRIGHT	
		SLO-SPIRAL DIECAST-TIN	ANSI CNC	3	2	TIN	
		SLO-SPIRAL DIECAST-COOLANT THRU	ANSI CNC	3	2	BRIGHT	
		SLO-SPIRAL DIECAST-TiCN	ANSI CNC	3	2	TIN	
	BX600	STRAIGHT FLUTE CAST IRON	ANSI CNC	4	2	BRIGHT	
		STRAIGHT FLUTE CAST IRON-TiCN	ANSI CNC	4	2	TiCN	
		STRAIGHT FLUTE CAST IRON-COOLANT THRU	ANSI CNC	4	2	BRIGHT	

\*RED INDICATES COATED TAPS IN-STOCK









CLASS 2B	CLASS 3B	EDP #	H2	H3	H4	H5	H6	H7	SERIES
H5	H3		30082-000	30083-000	30084-000	30085-000	30086-000	30087-000	BX100
H5	H3		30082-00T	30083-00T	30084-00T	30085-00T	30086-00T	30087-00T	
H5	H3		30082-00C	30083-00C	30084-00C	30085-00C	30086-00C	30087-00C	
H5	H3		32082-006	32083-006	32084-006	32085-006	32086-006	32087-006	BX150
H5	H3					35605-000			BX170
H5	H3		40082-010	40083-010	40084-010	40085-010	40086-010	40087-010	BX200
H5	H3		40082-01S	40083-01S	40084-01S	40085-01S	40086-01S	40087-01S	
H5	H3		40082-01T	40083-01T	40084-01T	40085-01T	40086-01T	40087-01T	
H5	H3		40082-01C	40083-01C	40084-01C	40085-01C	40086-01C	40087-01C	
H5	H3			41083-010		41085-010			
H5	H3					46605-010			BX220
H3	H2		44072-010	44073-010					BX300
H5	H3			51083-016		51085-016			BX400
H5	H3			52503-010		52505-010			BX500
H5	H3			52503-01T		52505-01T			
H5	H3			52503-0H0		52505-0H0			
H5	H3			52503-0HT		52505-0HT			
H5	H3			54043-010		54045-010			BX600
H5	H3			54043-01C		54045-01C			
H5	H3			54043-0H0		54045-0H0			
H5	H3			54043-0HC		54045-0HC			
YES	YES	54040-006							
H4	H3		30092-000	30093-000	30094-000	30095-000	30096-000	30097-000	BX100
H4	H3		30092-00T	30093-00T	30094-00T	30095-00T	30096-00T	30097-00T	
H4	H3		30092-00C	30093-00C	30094-00C	30095-00C	30096-00C	30097-00C	
H4	H3		32092-006	32093-006	32094-006	32095-006	32096-006	32097-006	BX150
H4	H3			34093-00T	34094-00T	34095-00T	34096-00T	34097-00T	BX160
H4	H3			34093-00C	34094-00C	34095-00C	34096-00C	34097-00C	
H4	H3				35704-000				BX170
H4	H3		40092-010	40093-010	40094-010	40095-010	40096-010	40097-010	BX200
H4	H3		40092-01S	40093-01S	40094-01S	40095-01S	40096-01S	40097-01S	
H4	H3		40092-01T	40093-01T	40094-01T	40095-01T	40096-01T	40097-01T	
H4	H3		40092-01C	40093-01C	40094-01C	40095-01C	40096-01C	40097-01C	
H4	H3			41093-010	41094-010				
H4	H3				46704-010				BX220
H3	H2		44082-010	44083-010					BX300
H4	H3			51093-016		51095-016			BX400
H4	H3			52513-010	52514-010				BX500
H4	H3			52513-01T	52514-01T				
H4	H3			52513-0H0	52514-0H0				
H4	H3			52513-0HT	52514-0HT				
H4	H3			54053-010		54055-010			BX600
H4	H3			54053-01C		54055-01C			
H4	H3			54053-0H0		54055-0H0			
H4	H3			54053-0HC		54055-0HC			

TAP SIZE	IMAGE	SERIES	DESCRIPTION	BLANK	# FLUTES	CHAMFER	COATING
5/16-18		BX100	SPIRAL POINT HIGH HOOK	ANSI CNC	3	4.5	BRIGHT
			SPIRAL POINT STEEL	ANSI CNC	3	4.5	TiN
			SPIRAL POINT STAINLESS	ANSI CNC	3	4.5	TiCN
		BX150	SPIRAL POINT HARD STEEL	ANSI CNC	3	5.5	NIT/STEAM
	BX170	EXTENSION - SPIRAL POINT	6" OAL	3	4.5	BRIGHT	
		BX200	45° HI-SPIRAL ALUMINUM	ANSI CNC	3	2.5	BRIGHT
			45° HI-SPIRAL	ANSI CNC	3	2.5	STEAM OXIDE
			45° HI-SPIRAL STEEL	ANSI CNC	3	2.5	TiN
			45° HI-SPIRAL STAINLESS	ANSI CNC	3	2.5	TiCN
	BX201	OTL 45° HI-SPIRAL	ANSI CNC	3	1.5	BRIGHT	
	BX220	EXTENSION - 45° HI SPIRAL	6" OAL	3	2.5	BRIGHT	
	BX400	15° SLO-SPIRAL HARD STEEL	ANSI CNC	3	3	NIT/STEAM	
		BX500	SLO-SPIRAL DIECAST	ANSI CNC	3	2	BRIGHT
			SLO-SPIRAL DIECAST-TiN	ANSI CNC	3	2	TiN
SLO-SPIRAL DIECAST-COOLANT THRU			ANSI CNC	3	2	TiN	
	BX600	STRAIGHT FLUTE CAST IRON	ANSI CNC	4	2	BRIGHT	
		STRAIGHT FLUTE CAST IRON-TiN	ANSI CNC	4	2	TiCN	
		STRAIGHT FLUTE CAST IRON-COOLANT THRU	ANSI CNC	4	2	TiCN	
BX800	CLEANOUT TAP	ANSI	4	4	NIT/STEAM		
5/16-24		BX100	SPIRAL POINT HIGH HOOK	ANSI CNC	3	4.5	BRIGHT
			SPIRAL POINT STEEL	ANSI CNC	3	4.5	TiN
			SPIRAL POINT STAINLESS	ANSI CNC	3	4.5	TiCN
		BX150	SPIRAL POINT HARD STEEL	ANSI CNC	3	5.5	NIT/STEAM
	BX160	SPIRAL POINT - A286	ANSI CNC	3	5.5	TiN	
			ANSI CNC	3	5.5	TiCN	
	BX170	EXTENSION - SPIRAL POINT	6" OAL	3	4.5	BRIGHT	
		BX200	45° HI-SPIRAL ALUMINUM	ANSI CNC	3	2.5	BRIGHT
			45° HI-SPIRAL	ANSI CNC	3	2.5	STEAM OXIDE
			45° HI-SPIRAL STEEL	ANSI CNC	3	2.5	TiN
			45° HI-SPIRAL STAINLESS	ANSI CNC	3	2.5	TiCN
	BX201	OTL 45° HI-SPIRAL	ANSI CNC	3	1.5	BRIGHT	
	BX220	EXTENSION - 45° HI SPIRAL	6" OAL	3	2.5	BRIGHT	
	BX400	15° SLO-SPIRAL HARD STEEL	ANSI CNC	3	3	NIT/STEAM	
	BX500	SLO-SPIRAL DIECAST	ANSI CNC	3	2	BRIGHT	
		SLO-SPIRAL DIECAST-TiN	ANSI CNC	3	2	TiN	
		SLO-SPIRAL DIECAST-COOLANT THRU	ANSI CNC	3	2	TiN	
	BX600	STRAIGHT FLUTE CAST IRON	ANSI CNC	4	2	BRIGHT	
		STRAIGHT FLUTE CAST IRON-TiN	ANSI CNC	4	2	TiCN	
		STRAIGHT FLUTE CAST IRON-COOLANT THRU	ANSI CNC	4	2	TiCN	

\*RED INDICATES COATED TAPS IN-STOCK

CLASS 2B	CLASS 3B	EDP #	H2	H3	H4	H5	H6	H7	H8	SERIES
H5	H3		30102-000	30103-000	30104-000	30105-000	30106-000	30107-000	30108-000	BX100
H5	H3		30102-00T	30103-00T	30104-00T	30105-00T	30106-00T	30107-00T	30108-00T	
H5	H3		30102-00C	30103-00C	30104-00C	30105-00C	30106-00C	30107-00C	30108-00C	
H5	H3			32103-006	32104-006	32105-006				BX150
H5	H3					35805-000				BX170
H5	H3		40102-010	40103-010	40104-010	40105-010	40106-010	40107-010	40108-010	BX200
H5	H3		40102-01S	40103-01S	40104-01S	40105-01S	40106-01S	40107-01S	40108-01S	
H5	H3		40102-01T	40103-01T	40104-01T	40105-01T	40106-01T	40107-01T	40108-01T	
H5	H3		40102-01C	40103-01C	40104-01C	40105-01C	40106-01C	40107-01C	40108-01C	
H5	H3			41103-010		41105-010				BX201
H5	H3					46805-010				BX220
H5	H3			51103-016		51105-016				BX400
H5	H3			52523-010		52525-010				BX500
H5	H3			52523-01T		52525-01T				
H5	H3			52523-0H0		52525-0H0				
H5	H3			52523-0HT		52525-0HT				
H5	H3			54063-010		54065-010				BX600
H5	H3			54063-01C		54065-01C				
H5	H3			54063-0H0		54065-0H0				
H5	H3			54063-0HC		54065-0HC				
YES	YES	54060-006								BX800
H4	H3		30112-000	30113-000	30114-000	30115-000	30116-000	30117-000	30118-000	BX100
H4	H3		30112-00T	30113-00T	30114-00T	30115-00T	30116-00T	30117-00T	30118-00T	
H4	H3		30112-00C	30113-00C	30114-00C	30115-00C	30116-00C	30117-00C	30118-00C	
H4	H3			32113-006	32114-006	32115-006				BX150
H4	H3			34113-00T	34114-00T	34115-00T	34116-00T	34117-00T		BX160
H4	H3			34113-00C	34114-00C	34115-00C	34116-00C	34117-00C		
H4	H3				35904-000					BX170
H4	H3		40112-010	40113-010	40114-010	40115-010	40116-010	40117-010	40118-010	BX200
H4	H3		40112-01S	40113-01S	40114-01S	40115-01S	40116-01S	40117-01S	40118-01S	
H4	H3		40112-01T	40113-01T	40114-01T	40115-01T	40116-01T	40117-01T	40118-01T	
H4	H3		40112-01C	40113-01C	40114-01C	40115-01C	40116-01C	40117-01C	40118-01C	
H4	H3			41113-010	41114-010					BX201
H4	H3				46904-010					BX220
H4	H3			51113-016		51115-016				BX400
H4	H3			52533-010	52534-010					BX500
H4	H3			52533-01T	52534-01T					
H4	H3			52533-0H0	52534-0H0					
H4	H3			52533-0HT	52534-0HT					
H4	H3			54073-010		54075-010				BX600
H4	H3			54073-01C		54075-01C				
H4	H3			54073-0H0		54075-0H0				
H4	H3			54073-0HC		54075-0HC				



TAP SIZE	IMAGE	SERIES	DESCRIPTION	BLANK	# FLUTES	CHAMFER	COATING
3/8-16		BX100	SPIRAL POINT HIGH HOOK	ANSI CNC	3	4.5	BRIGHT
			SPIRAL POINT STEEL	ANSI CNC	3	4.5	TiN
			SPIRAL POINT STAINLESS	ANSI CNC	3	4.5	TiCN
		BX150	SPIRAL POINT HARD STEEL	ANSI CNC	3	5.5	NIT/STEAM
	BX170	EXTENSION – SPIRAL POINT	6" OAL	3	4.5	BRIGHT	
		BX200	45° HI-SPIRAL ALUMINUM	ANSI CNC	3	2.5	BRIGHT
			45° HI-SPIRAL	ANSI CNC	3	2.5	STEAM OXIDE
			45° HI-SPIRAL STEEL	ANSI CNC	3	2.5	TiN
			45° HI-SPIRAL STAINLESS	ANSI CNC	3	2.5	TiCN
		BX201	OTL 45° HI-SPIRAL	ANSI CNC	3	1.5	BRIGHT
	BX220	EXTENSION – 45° HI SPIRAL	6" OAL	3	2.5	BRIGHT	
	BX400	15° SLO-SPIRAL HARD STEEL	ANSI CNC	3	3	NIT/STEAM	
		BX500	SLO-SPIRAL DIECAST	ANSI CNC	3	2	BRIGHT
			SLO-SPIRAL DIECAST-TiN	ANSI CNC	3	2	TiN
SLO-SPIRAL DIECAST-COOLANT THRU			ANSI CNC	3	2	TiN	
	BX600	STRAIGHT FLUTE CAST IRON	ANSI CNC	4	2	BRIGHT	
		STRAIGHT FLUTE CAST IRON-TiN	ANSI CNC	4	2	TiCN	
		STRAIGHT FLUTE CAST IRON-COOLANT THRU	ANSI CNC	4	2	TiCN	
BX800	CLEANOUT TAP	ANSI	4	4	NIT/STEAM		
3/8-24		BX100	SPIRAL POINT HIGH HOOK	ANSI CNC	3	4.5	BRIGHT
			SPIRAL POINT STEEL	ANSI CNC	3	4.5	TiN
			SPIRAL POINT STAINLESS	ANSI CNC	3	4.5	TiCN
		BX150	SPIRAL POINT HARD STEEL	ANSI CNC	3	5.5	NIT/STEAM
	BX170	EXTENSION – SPIRAL POINT	6" OAL	3	4.5	BRIGHT	
		BX200	45° HI-SPIRAL ALUMINUM	ANSI CNC	3	2.5	BRIGHT
			45° HI-SPIRAL	ANSI CNC	3	2.5	STEAM OXIDE
			45° HI-SPIRAL STEEL	ANSI CNC	3	2.5	TiN
			45° HI-SPIRAL STAINLESS	ANSI CNC	3	2.5	TiCN
		BX201	OTL 45° HI-SPIRAL	ANSI CNC	3	1.5	BRIGHT
	BX220	EXTENSION – 45° HI SPIRAL	6" OAL	3	2.5	BRIGHT	
	BX400	15° SLO-SPIRAL HARD STEEL	ANSI CNC	3	3	NIT/STEAM	
		BX500	SLO-SPIRAL DIECAST	ANSI CNC	3	2	BRIGHT
			SLO-SPIRAL DIECAST-TiN	ANSI CNC	3	2	TiN
SLO-SPIRAL DIECAST-COOLANT THRU			ANSI CNC	3	2	TiN	
	BX600	STRAIGHT FLUTE CAST IRON	ANSI CNC	4	2	BRIGHT	
		STRAIGHT FLUTE CAST IRON-TiN	ANSI CNC	4	2	TiCN	
		STRAIGHT FLUTE CAST IRON-COOLANT THRU	ANSI CNC	4	2	TiCN	

**BALAX SERIES BX600**

Made from premium tool steel with special flute and thread grinding geometry designed specifically for cutting abrasive materials with powdery chips. They provide outstanding tool life, especially with TiN or TiCN coating.

**STOCK COOLANT-THRU CAST IRON THREDSHAVER:** Now available to improve chip evacuation and tap-life in deep blind holes. These are stocked in Class 2B and 6H fits.



\*RED INDICATES COATED TAPS IN-STOCK

CLASS 2B	CLASS 3B	EDP #	H2	H3	H4	H5	H6	H7	H8	SERIES
H5	H3		30122-000	30123-000	30124-000	30125-000	30126-000	30127-000	30128-000	BX100
H5	H3		30122-00T	30123-00T	30124-00T	30125-00T	30126-00T	30127-00T	30128-00T	
H5	H3		30122-00C	30123-00C	30124-00C	30125-00C	30126-00C	30127-00C	30128-00C	
H5	H3			32123-006	32124-006	32125-006				BX150
H5	H3					36005-000				BX170
H5	H3		40122-010	40123-010	40124-010	40125-010	40126-010	40127-010	40128-010	BX200
H5	H3		40122-01S	40123-01S	40124-01S	40125-01S	40126-01S	40127-01S	40128-01S	
H5	H3		40122-01T	40123-01T	40124-01T	40125-01T	40126-01T	40127-01T	40128-01T	
H5	H3		40122-01C	40123-01C	40124-01C	40125-01C	4012601C	40127-01C	40128-01C	BX201
H5	H3			41123-010		41125-010				
H5	H3					47005-010				
H5	H3			51123-016		51125-016				BX400
H5	H3			52543-010		52545-010				BX500
H5	H3			52543-01T		52545-01T				
H5	H3			52543-0H0		52545-0H0				
H5	H3			52543-0HT		52545-0HT				
H5	H3			54083-010		54085-010				BX600
H5	H3			54083-01C		54085-01C				
H5	H3			54083-0H0		54085-0H0				
H5	H3			54083-0HC		54085-0HC				BX800
YES	YES	54080-006								
H4	H3		30132-000	30133-000	30134-000	30135-000	30136-000	30137-000	30138-000	BX100
H4	H3		30132-00T	30133-00T	30134-00T	30135-00T	30136-00T	30137-00T	30138-00T	
H4	H3		30132-00C	30133-00C	30134-00C	30135-00C	30136-00C	30137-00C	30138-00C	
H4	H3			32133-006	32134-006	32135-006				BX150
H4	H3				36104-000					BX170
H4	H3		40132-010	40133-010	40134-010	40135-010	40136-010	40137-010	40138-010	BX200
H4	H3		40132-01S	40133-01S	40134-01S	40135-01S	40136-01S	40137-01S	40138-01S	
H4	H3		40132-01T	40133-01T	40134-01T	40135-01T	40136-01T	40137-01T	40138-01T	
H4	H3		40132-01C	40133-01C	40134-01C	40135-01C	40136-01C	40137-01C	40138-01C	BX201
H4	H3			41133-010	41134-010					
H4	H3				47104-010					BX220
H4	H3			51133-016		51135-016				BX400
H4	H3			52553-010	52554-010					
H4	H3			52553-01T	52554-01T					
H4	H3			52553-0H0	52554-0H0					
H4	H3			52553-0HT	52554-0HT					BX500
H4	H3			54093-010		54095-010				
H4	H3			54093-01C		54095-01C				
H4	H3			54093-0H0		54095-0H0				
H4	H3			54093-0HC		54095-0HC				BX600
H4	H3									

TAP SIZE	IMAGE	SERIES	DESCRIPTION	BLANK	# FLUTES	CHAMFER	COATING
7/16-14		BX100	SPIRAL POINT HIGH HOOK	ANSI	3	4.5	BRIGHT
			SPIRAL POINT STEEL	ANSI	3	4.5	TiN
			SPIRAL POINT STAINLESS	ANSI	3	4.5	TiCN
		BX150	SPIRAL POINT HARD STEEL	ANSI	3	5.5	NIT/STEAM
		BX200	45° HI-SPIRAL ALUMINUM	ANSI	3	2.5	BRIGHT
			45° HI-SPIRAL	ANSI	3	2.5	STEAM OXIDE
			45° HI-SPIRAL STEEL	ANSI	3	2.5	TiN
			45° HI-SPIRAL STAINLESS	ANSI	3	2.5	TiCN
		BX201	OTL 45° HI-SPIRAL	ANSI	3	1.5	BRIGHT
		BX400	15° SLO-SPIRAL HARD STEEL	ANSI	3	3	NIT/STEAM
		BX600	STRAIGHT FLUTE CAST IRON	ANSI	4	2	BRIGHT
			STRAIGHT FLUTE CAST IRON-COOLANT THRU	ANSI	4	2	TiCN
			STRAIGHT FLUTE CAST IRON-COOLANT THRU	ANSI	4	2	BRIGHT
			STRAIGHT FLUTE CAST IRON-COOLANT THRU	ANSI	4	2	TiCN
	BX800	CLEANOUT TAP	ANSI	4	4	NIT/STEAM	
7/16-20		BX100	SPIRAL POINT HIGH HOOK	ANSI	3	4.5	BRIGHT
			SPIRAL POINT STEEL	ANSI	3	4.5	TiN
			SPIRAL POINT STAINLESS	ANSI	3	4.5	TiCN
		BX150	SPIRAL POINT HARD STEEL	ANSI	3	5.5	NIT/STEAM
		BX200	45° HI-SPIRAL ALUMINUM	ANSI	3	2.5	BRIGHT
			45° HI-SPIRAL	ANSI	3	2.5	STEAM OXIDE
			45° HI-SPIRAL STEEL	ANSI	3	2.5	TiN
			45° HI-SPIRAL STAINLESS	ANSI	3	2.5	TiCN
		BX201	OTL 45° HI-SPIRAL	ANSI	3	1.5	BRIGHT
		BX400	15° SLO-SPIRAL HARD STEEL	ANSI	3	3	NIT/STEAM
		BX600	STRAIGHT FLUTE CAST IRON	ANSI	4	2	BRIGHT
			STRAIGHT FLUTE CAST IRON-COOLANT THRU	ANSI	4	2	TiCN
			STRAIGHT FLUTE CAST IRON-COOLANT THRU	ANSI	4	2	BRIGHT
			STRAIGHT FLUTE CAST IRON-COOLANT THRU	ANSI	4	2	TiCN
1/2-13		BX100	SPIRAL POINT HIGH HOOK	ANSI	4	4.5	BRIGHT
			SPIRAL POINT STEEL	ANSI	4	4.5	TiN
			SPIRAL POINT STAINLESS	ANSI	4	4.5	TiCN
	BX150	SPIRAL POINT HARD STEEL	ANSI	4	5.5	NIT/STEAM	
		BX200	45° HI-SPIRAL ALUMINUM	ANSI	3	2.5	BRIGHT
			45° HI-SPIRAL	ANSI	3	2.5	STEAM OXIDE
			45° HI-SPIRAL STEEL	ANSI	3	2.5	TiN
			45° HI-SPIRAL STAINLESS	ANSI	3	2.5	TiCN
		BX201	OTL 45° HI-SPIRAL	ANSI	3	1.5	BRIGHT
		BX210	DIN - 38° SPIRAL FLUTE	110mm OAL	3	2.5	NIT/STEAM
			DIN - 38° SPIRAL FLUTE	110mm OAL	3	2.5	TiN
			DIN - 38° SPIRAL FLUTE	110mm OAL	3	2.5	TiCN
		BX400	15° SLO-SPIRAL HARD STEEL	ANSI	3	3	NIT/STEAM
	BX600	STRAIGHT FLUTE CAST IRON	ANSI	4	2	BRIGHT	
		STRAIGHT FLUTE CAST IRON-COOLANT THRU	ANSI	4	2	TiCN	
		STRAIGHT FLUTE CAST IRON-COOLANT THRU	ANSI	4	2	BRIGHT	
	BX800	CLEANOUT TAP	ANSI	4	4	NIT/STEAM	

\*RED INDICATES COATED TAPS IN-STOCK

CLASS2B	CLASS 3B	EDP #	H2	H3	H4	H5	H6	H7	H8	SERIES
H5	H3		30142-000	30143-000	30144-000	30145-000	30146-000	30147-000	30148-000	BX100
H5	H3		30142-00T	30143-00T	30144-00T	30145-00T	30146-00T	30147-00T	30148-00T	
H5	H3		30142-00C	30143-00C	30144-00C	30145-00C	30146-00C	30147-00C	30148-00C	
H5	H3			32143-006	32144-006	32145-006				BX150
H5	H3		40142-000	40143-000	40144-000	40145-000	40146-000	40147-000	40148-000	BX200
H5	H3		40142-00S	40143-00S	40144-00S	40145-00S	40146-00S	40147-00S	40148-00S	
H5	H3		40142-00T	40143-00T	40144-00T	40145-00T	40146-00T	40147-00T	40148-00T	
H5	H3		40142-00C	40143-00C	40144-00C	40145-00C	40146-00C	40147-00C	40148-00C	
H5	H3			41143-000		41145-000				BX201
H5	H3			51143-006		51145-006				BX400
H5	H3			54103-000		54105-000				BX600
H5	H3			54103-00C		54105-00C				
H5	H3			54103-0J0		54105-0J0				
H5	H3			54103-0JC		54105-0JC				
YES	YES	54100-006								BX800
H5	H3		30152-000	30153-000	30154-000	30155-000	30156-000	30157-000	30158-000	BX100
H5	H3		30152-00T	30153-00T	30154-00T	30155-00T	30156-00T	30157-00T	30158-00T	
H5	H3		30152-00C	30153-00C	30154-00C	30155-00C	30156-00C	30157-00C	30158-00C	
H5	H3			32153-006	32154-006	32155-006				BX150
H5	H3		40152-000	40153-000	40154-000	40155-000	40156-000	40157-000	40158-000	BX200
H5	H3		40152-00S	40153-00S	40154-00S	40155-00S	40156-00S	40157-00S	40158-00S	
H5	H3		40152-00T	40153-00T	40154-00T	40155-00T	40156-00T	40157-00T	40158-00T	
H5	H3		40152-00C	40153-00C	40154-00C	40155-00C	40156-00C	40157-00C	40158-00C	
H5	H3			41153-000		41155-000				BX201
H5	H3			51153-006		51155-006				BX400
H5	H3			54113-000		54115-000				BX600
H5	H3			54113-00C		54115-00C				
H5	H3			54113-0J0		54115-0J0				
H5	H3			54113-0JC		54115-0JC				
H5	H3		30162-000	30163-000	30164-000	30165-000	30166-000	30167-000	30168-000	BX100
H5	H3		30162-00T	30163-00T	30164-00T	30165-00T	30166-00T	30167-00T	30168-00T	
H5	H3		30162-00C	30163-00C	30164-00C	30165-00C	30166-00C	30167-00C	30168-00C	
H5	H3			32163-006	32164-006	32165-006				BX150
H5	H3		40162-000	40163-000	40164-000	40165-000	40166-000	40167-000	40168-000	BX200
H5	H3		40162-00S	40163-00S	40164-00S	40165-00S	40166-00S	40167-00S	40168-00S	
H5	H3		40162-00T	40163-00T	40164-00T	40165-00T	40166-00T	40167-00T	40168-00T	
H5	H3		40162-00C	40163-00C	40164-00C	40165-00C	40166-00C	40167-00C	40168-00C	
H5	H3			41163-000		41165-000				BX201
H5	H3					41280-006				BX210
H5	H3					41280-00T				
H5	H3					41280-00C				
H5	H3			51163-006		51165-006				BX400
H5	H3			54123-000		54125-000				BX600
H5	H3			54123-00C		54125-00C				
H5	H3			54123-0J0		54125-0J0				
H5	H3			54123-0JC		54125-0JC				
YES	YES	54120-006								BX800

TAP SIZE	IMAGE	SERIES	DESCRIPTION	BLANK	# FLUTES	CHAMFER	COATING		
1/2-20		BX100	SPIRAL POINT HIGH HOOK	ANSI	4	4.5	BRIGHT		
			SPIRAL POINT STEEL	ANSI	4	4.5	TIN		
			SPIRAL POINT STAINLESS	ANSI	4	4.5	TiCN		
		BX150	SPIRAL POINT HARD STEEL	ANSI	4	5.5	NIT/STEAM		
			45° HI-SPIRAL ALUMINUM	ANSI	3	2.5	BRIGHT		
		BX200	45° HI-SPIRAL	ANSI	3	2.5	STEAM OXIDE		
			45° HI-SPIRAL STEEL	ANSI	3	2.5	TiN		
			45° HI-SPIRAL STAINLESS	ANSI	3	2.5	TiCN		
		BX201	OTL 45° HI-SPIRAL	ANSI	3	1.5	BRIGHT		
		BX210	DIN - 38° SPIRAL FLUTE	110mm OAL	3	2.5	NIT/STEAM		
				3	2.5	TiN			
				3	2.5	TiCN			
		BX400	15° SLO-SPIRAL HARD STEEL	ANSI	3	3	NIT/STEAM		
				BX600	STRAIGHT FLUTE CAST IRON	ANSI	4	2	BRIGHT
						TiCN	4	2	TiCN
BRIGHT						4	2	BRIGHT	
	BX600	STRAIGHT FLUTE CAST IRON-COOLANT THRU	ANSI	4	2	TiCN			
			4	2	TiCN				
			4	2	TiCN				
5/8-11		BX100	SPIRAL POINT HIGH HOOK	ANSI	4	4.5	BRIGHT		
			SPIRAL POINT STEEL	ANSI	4	4.5	TiN		
			SPIRAL POINT STAINLESS	ANSI	4	4.5	TiCN		
		BX200	45° HI-SPIRAL ALUMINUM	ANSI	4	2.5	BRIGHT		
			45° HI-SPIRAL	ANSI	4	2.5	STEAM OXIDE		
			45° HI-SPIRAL STEEL	ANSI	4	2.5	TiN		
		BX210	DIN - 38° SPIRAL FLUTE	110mm OAL	3	2.5	NIT/STEAM		
				3	2.5	TiN			
				3	2.5	TiCN			
5/8-18		BX100	SPIRAL POINT HIGH HOOK	ANSI	4	4.5	BRIGHT		
			SPIRAL POINT STEEL	ANSI	4	4.5	TiN		
			SPIRAL POINT STAINLESS	ANSI	4	4.5	TiCN		
		BX200	45° HI-SPIRAL ALUMINUM	ANSI	4	2.5	BRIGHT		
			45° HI-SPIRAL	ANSI	4	2.5	STEAM OXIDE		
			45° HI-SPIRAL STEEL	ANSI	4	2.5	TiN		
		BX210	DIN - 38° SPIRAL FLUTE	110mm OAL	3	2.5	NIT/STEAM		
				3	2.5	TiN			
				3	2.5	TiCN			
3/4-10		BX100	SPIRAL POINT HIGH HOOK	ANSI	4	4.5	BRIGHT		
			SPIRAL POINT STEEL	ANSI	4	4.5	TiN		
			SPIRAL POINT STAINLESS	ANSI	4	4.5	TiCN		
		BX200	45° HI-SPIRAL ALUMINUM	ANSI	4	2.5	BRIGHT		
			45° HI-SPIRAL	ANSI	4	2.5	STEAM OXIDE		
			45° HI-SPIRAL STEEL	ANSI	4	2.5	TiN		
		BX210	DIN - 38° SPIRAL FLUTE	125mm OAL	3	2.5	NIT/STEAM		
				3	2.5	TiN			
				3	2.5	TiCN			

**BALAX SERIES BX210**






Engineered for deep blind hole tapping applications in steel forgings and castings. The heavy duty spiral flute design creates excellent chip evacuation while contributing to added

tap strength. **BX210** taps are made from special powdered metal and ground with special flute and thread geometry to provide excellent tap life.

CLASS 2B	CLASS 3B	H2	H3	H4	H5	H6	H7	H8	SERIES
H5	H3	30172-000	30173-000	30174-000	30175-000	30176-000	30177-000	30178-000	BX100
H5	H3	30172-00T	30173-00T	30174-00T	30175-00T	30176-00T	30177-00T	30178-00T	
H5	H3	30172-00C	30173-00C	30174-00C	30175-00C	30176-00C	30177-00C	30178-00C	
H5	H3		32173-006	32174-006	32175-006				BX150
H5	H3	40172-000	40173-000	40174-000	40175-000	40176-000	40177-000	40178-000	BX200
H5	H3	40172-00S	40173-00S	40174-00S	40175-00S	40176-00S	40177-00S	40178-00S	
H5	H3	40172-00T	40173-00T	40174-00T	40175-00T	40176-00T	40177-00T	40178-00T	
H5	H3	40172-00C	40173-00C	40174-00C	40175-00C	40176-00C	40177-00C	40178-00C	BX201
H5	H3		41173-000		41175-000				
H5	H3				41290-006				
H5	H3				41290-00T				BX210
H5	H3				41290-00C				BX400
H5	H3		51173-006		51175-006				
H5	H3		54133-000		54135-000				
H5	H3		54133-00C		54135-00C				BX600
H5	H3		54133-0J0		54135-0J0				
H5	H3		54133-0JC		54135-0JC				
H6	H3	30182-000	30183-000	30184-000	30185-000	30186-000	30187-000	30188-000	BX100
H6	H3	30182-00T	30183-00T	30184-00T	30185-00T	30186-00T	30187-00T	30188-00T	
H6	H3	30182-00C	30183-00C	30184-00C	30185-00C	30186-00C	30187-00C	30188-00C	
H6	H3	40182-000	40183-000	40184-000	40185-000	40186-000	40187-000	40188-000	BX200
H6	H3	40182-00S	40183-00S	40184-00S	40185-00S	40186-00S	40187-00S	40188-00S	
H6	H3	40182-00T	40183-00T	40184-00T	40185-00T	40186-00T	40187-00T	40188-00T	
H6	H3	40182-00C	40183-00C	40184-00C	40185-00C	40186-00C	40187-00C	40188-00C	BX210
H6	H3					41320-006			
H6	H3					41320-00T			
H6	H3					41320-00C			
H5	H3	30192-000	30193-000	30194-000	30195-000	30196-000	30197-000	30198-000	BX100
H5	H3	30192-00T	30193-00T	30194-00T	30195-00T	30196-00T	30197-00T	30198-00T	
H5	H3	30192-00C	30193-00C	30194-00C	30195-00C	30196-00C	30197-00C	30198-00C	
H5	H3	40192-000	40193-000	40194-000	40195-000	40196-000	40197-000	40198-000	BX200
H5	H3	40192-00S	40193-00S	40194-00S	40195-00S	40196-00S	40197-00S	40198-00S	
H5	H3	40192-00T	40193-00T	40194-00T	40195-00T	40196-00T	40197-00T	40198-00T	
H5	H3	40192-00C	40193-00C	40194-00C	40195-00C	40196-00C	40197-00C	40198-00C	BX210
H5	H3					41330-006			
H5	H3					41330-00T			
H5	H3					41330-00C			
H6	H4	30202-000	30203-000	30204-000	30205-000	30206-000	30207-000	30208-000	BX100
H6	H4	30202-00T	30203-00T	30204-00T	30205-00T	30206-00T	30207-00T	30208-00T	
H6	H4	30202-00C	30203-00C	30204-00C	30205-00C	30206-00C	30207-00C	30208-00C	
H6	H4	40202-000	40203-000	40204-000	40205-000	40206-000	40207-000	40208-000	BX200
H6	H4	40202-00S	40203-00S	40204-00S	40205-00S	40206-00S	40207-00S	40208-00S	
H6	H4	40202-00T	40203-00T	40204-00T	40205-00T	40206-00T	40207-00T	40208-00T	
H6	H4	40202-00C	40203-00C	40204-00C	40205-00C	40206-00C	40207-00C	40208-00C	BX210
H6	H4					41340-006			
H6	H4					41340-00T			
H6	H4					41340-00C			











TAP SIZE	IMAGE	SERIES	DESCRIPTION	BLANK	# FLUTES	CHAMFER	COATING	
3/4-16		BX100	SPIRAL POINT HIGH HOOK	ANSI	4	4.5	BRIGHT	
			SPIRAL POINT STEEL	ANSI	4	4.5	TiN	
			SPIRAL POINT STAINLESS	ANSI	4	4.5	TiCN	
		BX200	45° HI-SPIRAL ALUMINUM	ANSI	4	2.5	BRIGHT	
			45° HI-SPIRAL	ANSI	4	2.5	STEAM OXIDE	
			45° HI-SPIRAL STEEL	ANSI	4	2.5	TiN	
			45° HI-SPIRAL STAINLESS	ANSI	4	2.5	TiCN	
		BX210	DIN - 38° SPIRAL FLUTE	125mm OAL		3	2.5	NIT/STEAM
						3	2.5	TiN
					3	2.5	TiCN	
7/8-9		BX100	SPIRAL POINT HIGH HOOK	ANSI	4	4.5	BRIGHT	
			SPIRAL POINT STEEL	ANSI	4	4.5	TiN	
			SPIRAL POINT STAINLESS	ANSI	4	4.5	TiCN	
		BX200	45° HI-SPIRAL ALUMINUM	ANSI	4	2.5	BRIGHT	
			45° HI-SPIRAL	ANSI	4	2.5	STEAM OXIDE	
			45° HI-SPIRAL STEEL	ANSI	4	2.5	TiN	
			45° HI-SPIRAL STAINLESS	ANSI	4	2.5	TiCN	
		BX210	DIN - 38° SPIRAL FLUTE	140mm OAL		4	2.5	NIT/STEAM
						4	2.5	TiN
					4	2.5	TiCN	
7/8-14		BX100	SPIRAL POINT HIGH HOOK	ANSI	4	4.5	BRIGHT	
			SPIRAL POINT STEEL	ANSI	4	4.5	TiN	
			SPIRAL POINT STAINLESS	ANSI	4	4.5	TiCN	
		BX200	45° HI-SPIRAL ALUMINUM	ANSI	4	2.5	BRIGHT	
			45° HI-SPIRAL	ANSI	4	2.5	STEAM OXIDE	
			45° HI-SPIRAL STEEL	ANSI	4	2.5	TiN	
			45° HI-SPIRAL STAINLESS	ANSI	4	2.5	TiCN	
		BX210	DIN - 38° SPIRAL FLUTE	140mm OAL		4	2.5	NIT/STEAM
						4	2.5	TiN
					4	2.5	TiCN	
1-8		BX100	SPIRAL POINT HIGH HOOK	ANSI	4	4.5	BRIGHT	
			SPIRAL POINT STEEL	ANSI	4	4.5	TiN	
			SPIRAL POINT STAINLESS	ANSI	4	4.5	TiCN	
		BX200	45° HI-SPIRAL ALUMINUM	ANSI	4	2.5	BRIGHT	
			45° HI-SPIRAL	ANSI	4	2.5	STEAM OXIDE	
			45° HI-SPIRAL STEEL	ANSI	4	2.5	TiN	
			45° HI-SPIRAL STAINLESS	ANSI	4	2.5	TiCN	
		BX210	DIN - 38° SPIRAL FLUTE	160mm OAL		4	2.5	NIT/STEAM
						4	2.5	TiN
					4	2.5	TiCN	
1-12		BX100	SPIRAL POINT HIGH HOOK	ANSI	4	4.5	BRIGHT	
			SPIRAL POINT STEEL	ANSI	4	4.5	TiN	
			SPIRAL POINT STAINLESS	ANSI	4	4.5	TiCN	
		BX200	45° HI-SPIRAL ALUMINUM	ANSI	4	2.5	BRIGHT	
			45° HI-SPIRAL	ANSI	4	2.5	STEAM OXIDE	
			45° HI-SPIRAL STEEL	ANSI	4	2.5	TiN	
			45° HI-SPIRAL STAINLESS	ANSI	4	2.5	TiCN	
		BX210	DIN - 38° SPIRAL FLUTE	160mm OAL		4	2.5	NIT/STEAM
						4	2.5	TiN
					4	2.5	TiCN	

CLASS 2B	CLASS 3B	H2	H3	H4	H5	H6	H7	H8	SERIES
H5	H3	30212-000	30213-000	30214-000	30215-000	30216-000	30217-000	30218-000	BX100
H5	H3	30212-00T	30213-00T	30214-00T	30215-00T	30216-00T	30217-00T	30218-00T	
H5	H3	30212-00C	30213-00C	30214-00C	30215-00C	30216-00C	30217-00C	30218-00C	
H5	H3	40212-000	40213-000	40214-000	40215-000	40216-000	40217-000	40218-000	BX200
H5	H3	40212-00S	40213-00S	40214-00S	40215-00S	40216-00S	40217-00S	40218-00S	
H5	H3	40212-00T	40213-00T	40214-00T	40215-00T	40216-00T	40217-00T	40218-00T	
H5	H3	40212-00C	40213-00C	40214-00C	40215-00C	40216-00C	40217-00C	40218-00C	
H5	H3				41350-006				BX210
H5	H3				41350-00T				
H5	H3				41350-00C				
H6	H4	30222-000	30223-000	30224-000	30225-000	30226-000	30227-000	30228-000	BX100
H6	H4	30222-00T	30223-00T	30224-00T	30225-00T	30226-00T	30227-00T	30228-00T	
H6	H4	30222-00C	30223-00C	30224-00C	30225-00C	30226-00C	30227-00C	30228-00C	
H6	H4	40222-000	40223-000	40224-000	40225-000	40226-000	40227-000	40228-000	BX200
H6	H4	40222-00S	40223-00S	40224-00S	40225-00S	40226-00S	40227-00S	40228-00S	
H6	H4	40222-00T	40223-00T	40224-00T	40225-00T	40226-00T	40227-00T	40228-00T	
H6	H4	40222-00C	40223-00C	40224-00C	40225-00C	40226-00C	40227-00C	40228-00C	
H6	H4					41360-006			BX210
H6	H4					41360-00T			
H6	H4					41360-00C			
H6	H4	30232-000	30233-000	30234-000	30235-000	30236-000	30237-000	30238-000	BX100
H6	H4	30232-00T	30233-00T	30234-00T	30235-00T	30236-00T	30237-00T	30238-00T	
H6	H4	30232-00C	30233-00C	30234-00C	30235-00C	30236-00C	30237-00C	30238-00C	
H6	H4	40232-000	40233-000	40234-000	40235-000	40236-000	40237-000	40238-000	BX200
H6	H4	40232-00S	40233-00S	40234-00S	40235-00S	40236-00S	40237-00S	40238-00S	
H6	H4	40232-00T	40233-00T	40234-00T	40235-00T	40236-00T	40237-00T	40238-00T	
H6	H4	40232-00C	40233-00C	40234-00C	40235-00C	40236-00C	40237-00C	40238-00C	
H6	H4					41370-006			BX210
H6	H4					41370-00T			
H6	H4					41370-00C			
H6	H4	30242-000	30243-000	30244-000	30245-000	30246-000	30247-000	30248-000	BX100
H6	H4	30242-00T	30243-00T	30244-00T	30245-00T	30246-00T	30247-00T	30248-00T	
H6	H4	30242-00C	30243-00C	30244-00C	30245-00C	30246-00C	30247-00C	30248-00C	
H6	H4	40242-000	40243-000	40244-000	40245-000	40246-000	40247-000	40248-000	BX200
H6	H4	40242-00S	40243-00S	40244-00S	40245-00S	40246-00S	40247-00S	40248-00S	
H6	H4	40242-00T	40243-00T	40244-00T	40245-00T	40246-00T	40247-00T	40248-00T	
H6	H4	40242-00C	40243-00C	40244-00C	40245-00C	40246-00C	40247-00C	40248-00C	
H6	H4					41380-006			BX210
H6	H4					41380-00T			
H6	H4					41380-00C			
H6	H4	30252-000	30253-000	30254-000	30255-000	30256-000	30257-000	30258-000	BX100
H6	H4	30252-00T	30253-00T	30254-00T	30255-00T	30256-00T	30257-00T	30258-00T	
H6	H4	30252-00C	30253-00C	30254-00C	30255-00C	30256-00C	30257-00C	30258-00C	
H6	H4	40252-000	40253-000	40254-000	40255-000	40256-000	40257-000	40258-000	BX200
H6	H4	40252-00S	40253-00S	40254-00S	40255-00S	40256-00S	40257-00S	40258-00S	
H6	H4	40252-00T	40253-00T	40254-00T	40255-00T	40256-00T	40257-00T	40258-00T	
H6	H4	40252-00C	40253-00C	40254-00C	40255-00C	40256-00C	40257-00C	40258-00C	
H6	H4					41390-006			BX210
H6	H4					41390-00T			
H6	H4					41390-00C			

TAP SIZE	IMAGE	SERIES	DESCRIPTION	BLANK	# FLUTES	CHAMFER	COATING
M2 X .4		BX100	SPIRAL POINT HIGH HOOK	ANSI	2	4.5	BRIGHT
			SPIRAL POINT STEEL	ANSI	2	4.5	TiN
			SPIRAL POINT STAINLESS	ANSI	2	4.5	TiCN
M2.5 X .45		BX100	SPIRAL POINT HIGH HOOK	ANSI	2	4.5	BRIGHT
			SPIRAL POINT STEEL	ANSI	2	4.5	TiN
			SPIRAL POINT STAINLESS	ANSI	2	4.5	TiCN
	BX150	SPIRAL POINT HARD STEEL	ANSI	2	5.5	NIT/STEAM	
		BX200	45° SPIRAL FLUTE ALUMINUM	ANSI	2	2.5	BRIGHT
	45° HI-SPIRAL		ANSI	2	2.5	STEAM OXIDE	
	45° SPIRAL FLUTE STEEL		ANSI	2	2.5	TiN	
	45° SPIRAL FLUTE STAINLESS		ANSI	2	2.5	TiCN	
BX400	15° SPIRAL FLUTE STEEL	ANSI	2	3	NIT/STEAM		
M3 X .5		BX100	SPIRAL POINT HIGH HOOK	ANSI	3	4.5	BRIGHT
			SPIRAL POINT STEEL	ANSI	3	4.5	TiN
			SPIRAL POINT STAINLESS	ANSI	3	4.5	TiCN
	BX150	SPIRAL POINT HARD STEEL	ANSI	3	5.5	NIT/STEAM	
	BX170	EXTENSION - SPIRAL POINT	4" OAL	3	4.5	BRIGHT	
		BX200	45° HI-SPIRAL ALUMINUM	ANSI	3	2.5	BRIGHT
	45° HI-SPIRAL		ANSI	3	2.5	STEAM OXIDE	
	45° HI-SPIRAL STEEL		ANSI	3	2.5	TiN	
	45° HI-SPIRAL STAINLESS		ANSI	3	2.5	TiCN	
	BX201	OTL 45° HI-SPIRAL	ANSI	3	1.5	BRIGHT	
	BX220	EXTENSION - 45° SPIRAL FLUTE	4" OAL	3	2.5	BRIGHT	
	BX400	15° SPIRAL FLUTE STEEL	ANSI	3	3	NIT/STEAM	
	BX500	15° SPIRAL FLUTE DIECAST ALUMINUM	ANSI	3	2	BRIGHT	
TiN			3	2	TiN		
M3.5 X .6		BX100	SPIRAL POINT HIGH HOOK	ANSI CNC	3	4.5	BRIGHT
			SPIRAL POINT STEEL	ANSI CNC	3	4.5	TiN
			SPIRAL POINT STAINLESS	ANSI CNC	3	4.5	TiCN
	BX150	SPIRAL POINT HARD STEEL	ANSI CNC	3	5.5	NIT/STEAM	
	BX170	EXTENSION - SPIRAL POINT	4" OAL	3	4.5	BRIGHT	
		BX200	45° HI-SPIRAL ALUMINUM	ANSI CNC	3	2.5	BRIGHT
	45° HI-SPIRAL		ANSI CNC	3	2.5	STEAM OXIDE	
	45° HI-SPIRAL STEEL		ANSI CNC	3	2.5	TiN	
	45° HI-SPIRAL STAINLESS		ANSI CNC	3	2.5	TiCN	
	BX201	OTL 45° HI-SPIRAL	ANSI CNC	3	1.5	BRIGHT	
	BX220	EXTENSION - 45° SPIRAL FLUTE	4" OAL	3	2.5	BRIGHT	
	BX400	15° SPIRAL FLUTE STEEL	ANSI CNC	3	3	NIT/STEAM	
	BX500	15° SPIRAL FLUTE DIECAST ALUMINUM	ANSI CNC	3	2	BRIGHT	
TiN			3	2	TiN		
M4 X .7		BX100	SPIRAL POINT HIGH HOOK	ANSI CNC	3	4.5	BRIGHT
			SPIRAL POINT STEEL	ANSI CNC	3	4.5	TiN
			SPIRAL POINT STAINLESS	ANSI CNC	3	4.5	TiCN
	BX150	SPIRAL POINT HARD STEEL	ANSI CNC	3	5.5	NIT/STEAM	
BX170	EXTENSION - SPIRAL POINT	4" OAL	3	4.5	BRIGHT		

\*RED INDICATES COATED TAPS IN-STOCK

CLASS 6H	CLASS 4H	D2	D3	D4	D5	D6	SERIES
D3	D2	30992-000	30993-000				BX100
D3	D2	30992-00T	30993-00T				
D3	D2	30992-00C	30993-00C				
D3	D2	31002-000	31003-000	31004-000	31005-000		BX100
D3	D2	31002-00T	31003-00T	31004-00T	31005-00T		
D3	D2	31002-00C	31003-00C	31004-00C	31005-00C		
D3	D2	33002-006	33003-006				BX150
D3	D2	43002-010	43003-010	43004-010	43005-010		
D3	D2	43002-01S	43003-01S	43004-01S	43005-01S		
D3	D2	43002-01T	43003-01T	43004-01T	43005-01T		BX200
D3	D2	43002-01C	43003-01C	43004-01C	43005-01C		
D3	D2	43002-016	43003-016				
D3	D2	52002-016	52003-016				BX400
D3	D2	31012-000	31013-000	31014-000	31015-000		
D3	D2	31012-00T	31013-00T	31014-00T	31015-00T		
D3	D2	31012-00C	31013-00C	31014-00C	31015-00C		BX100
D3	D2	33012-006	33013-006				
D3	D2		38003-000				
D3	D2	43012-010	43013-010	43014-010	43015-010		BX170
D3	D2	43012-01S	43013-01S	43014-01S	43015-01S		
D3	D2	43012-01T	43013-01T	43014-01T	43015-01T		
D3	D2	43012-01C	43013-01C	43014-01C	43015-01C		BX200
D3	D2	43012-016	43013-016				
D3	D2		43313-010				
D3	D2		49003-010				BX201
D3	D2	52012-016	52013-016				
D3	D2		52783-010				
D3	D2		52783-01T				BX400
D4	D2	31022-000	31023-000	31024-000	31025-000		
D4	D2	31022-00T	31023-00T	31024-00T	31025-00T		
D4	D2	31022-00C	31023-00C	31024-00C	31025-00C		BX100
D4	D2		33023-006	33024-006	33025-006		
D4	D2			38104-000			
D4	D2	43022-010	43023-010	43024-010	43025-010	43026-010	BX150
D4	D2	43022-01S	43023-01S	43024-01S	43025-01S	43026-01S	
D4	D2	43022-01T	43023-01T	43024-01T	43025-01T	43026-01T	
D4	D2	43022-01C	43023-01C	43024-01C	43025-01C	43026-01C	BX200
D4	D2	43322-010		43324-010			
D4	D2			49104-010			
D4	D2		52023-016		52025-016		BX201
D4	D2			52794-010			
D4	D2			52794-01T			
D4	D2	31032-000	31033-000	31034-000	31035-000	31036-000	BX100
D4	D2	31032-00T	31033-00T	31034-00T	31035-00T	31036-00T	
D4	D2	31032-00C	31033-00C	31034-00C	31035-00C	31036-00C	
D4	D2		33033-006	33034-006	33035-006		BX150
D4	D2			38204-000			
D4	D2						
D4	D2						BX170

TAP SIZE	IMAGE	SERIES	DESCRIPTION	BLANK	# FLUTES	CHAMFER	COATING		
M4 X 0.7 CONT.		BX200	45° Hi-Spiral ALUMINUM	ANSI CNC	3	2.5	BRIGHT		
			45° Hi-Spiral	ANSI CNC	3	2.5	STEAM OXIDE		
			45° Hi-Spiral STEEL	ANSI CNC	3	2.5	TiN		
			45° Hi-Spiral STAINLESS	ANSI CNC	3	2.5	TiCN		
		BX201	0TL 45° Hi-Spiral	ANSI CNC	3	1.5	BRIGHT		
M5 X .8		BX200	45° Hi-Spiral ALUMINUM	ANSI CNC	3	2.5	BRIGHT		
			45° Hi-Spiral	ANSI CNC	3	2.5	STEAM OXIDE		
			45° Hi-Spiral STEEL	ANSI CNC	3	2.5	TiN		
			45° Hi-Spiral STAINLESS	ANSI CNC	3	2.5	TiCN		
		BX201	0TL 45° Hi-Spiral	ANSI CNC	3	1.5	BRIGHT		
M6 X1.0		BX100	Spiral Point HIGH HOOK	ANSI CNC	3	4.5	BRIGHT		
			Spiral Point STEEL	ANSI CNC	3	4.5	TiN		
			Spiral Point STAINLESS	ANSI CNC	3	4.5	TiCN		
		BX150	Spiral Point HARD STEEL	ANSI CNC	3	5.5	NIT/STEAM		
				BX170	EXTENSION - SPIRAL POINT	6" OAL	3	4.5	BRIGHT
					BX200	45° Hi-Spiral ALUMINUM	ANSI CNC	3	2.5
	45° Hi-Spiral	ANSI CNC				3	2.5	STEAM OXIDE	
	45° Hi-Spiral STEEL	ANSI CNC				3	2.5	TiN	
	45° Hi-Spiral STAINLESS	ANSI CNC	3	2.5		TiCN			
		BX201	0TL 45° Hi-Spiral	ANSI CNC	3	1.5	BRIGHT		
			BX220	EXTENSION - 45° SPIRAL FLUTE	6" OAL	3	2.5	BRIGHT	
				BX210	DIN - 38° SPIRAL FLUTE	DIN371	3	2.5	NIT/STEAM
	3	2.5				TiN			
	3	2.5	TiCN						
		BX400	15° SPIRAL FLUTE STEEL	ANSI CNC	3	3	NIT/STEAM		
BX500			15° SPIRAL FLUTE DIECAST ALUMINUM	ANSI CNC	3	2	BRIGHT		
				3	2	TiN			
	ANSI CNC	3		2	BRIGHT				
	BX500	15° SPIRAL FLUTE DIECAST-COOLANT THRU	ANSI CNC	3	2	TiN			













\*RED INDICATES COATED TAPS IN-STOCK

CLASS 6H	CLASS 4H	D2	D3	D4	D5	D6	D7	D8	SERIES
D4	D2		43033-010	43034-010	43035-010	43036-010			BX200
D4	D2		43033-01S	43034-01S	43035-01S	43036-01S			
D4	D2		43033-01T	43034-01T	43035-01T	43036-01T			
D4	D2		43033-01C	43034-01C	43035-01C	43036-01C			
D4	D2			43334-010					BX201
D4	D2			49204-010					BX220
D4	D2			52033-016		52035-016			BX400
D4	D2			52804-010					BX500
D4	D2			52804-01T					
D4	D3	31042-000	31043-000	31044-000	31045-000	31046-000			BX100
D4	D3	31042-00T	31043-00T	31044-00T	31045-00T	31046-00T			
D4	D3	31042-00C	31043-00C	31044-00C	31045-00C	31046-00C			
D4	D3		33043-006	33044-006	33045-006				BX150
D4	D3			38304-000					BX170
D4	D3		43043-010	43044-010	43045-010	43046-010	43047-010		BX200
D4	D3		43043-01S	43044-01S	43045-01S	43046-01S	43047-01S		
D4	D3		43043-01T	43044-01T	43045-01T	43046-01T	43047-01T		
D4	D3		43043-01C	43044-01C	43045-01C	43046-01C	43047-01C		
D4	D3		43343-010	43344-010					BX201
D4	D3			49304-010					BX220
D4	D3			52043-016		52045-016			BX400
D4	D3			52814-010					BX500
D4	D3			52814-01T					
D4	D3			52894-010					BX510
D4	D3			52894-01T					
D5	D3	31052-000	31053-000	31054-000	31055-000	31056-000	31057-000		BX100
D5	D3	31052-00T	31053-00T	31054-00T	31055-00T	31056-00T	31057-00T		
D5	D3	31052-00C	31053-00C	31054-00C	31055-00C	31056-00C	31057-00C		
D5	D3		33053-006	33054-006	33055-006				BX150
D5	D3			38405-000					BX170
D5	D3		43053-010	43054-010	43055-010	43056-010	43057-010	43058-010	BX200
D5	D3		43053-01S	43054-01S	43055-01S	43056-01S	43057-01S	43058-01S	
D5	D3		43053-01T	43054-01T	43055-01T	43056-01T	43057-01T	43058-01T	
D5	D3		43053-01C	43054-01C	43055-01C	43056-01C	43057-01C	43058-01C	
D5	D3		43353-010		43355-010				BX201
D5	D3				49405-010				BX220
D5	D3				43200-016				BX210
D5	D3				43200-01T				
D5	D3				43200-01C				
D5	D3		52053-016		52055-016				BX400
D5	D3				52825-010				BX500
D5	D3				52825-01T				
D5	D3				52825-0H0				
D5	D3				52825-0HT				

TAP SIZE	IMAGE	SERIES	DESCRIPTION	BLANK	# FLUTES	CHAMFER	COATING
M6 X 1.0 CONT.		BX510	DIN – PREMIUM STEEL 15° SPIRAL FLUTE	DIN371	3	2	BRIGHT
			DIECAST ALUMINUM		3	2	TiN
		DIN – PREMIUM STEEL 15° SPIRAL FLUTE	DIN371	3	2	BRIGHT	
			DIECAST-COOLANT THRU		3	2	TiN
		BX600	STRAIGHT FLUTE CAST IRON	ANSI CNC	4	2	BRIGHT
					4	2	TiCN
		STRAIGHT FLUTE CAST IRON-COOLANT THRU	ANSI CNC	4	2	BRIGHT	
					4	2	TiCN
		BX610	DIN – PREMIUM STEEL STRAIGHT FLUTE CAST IRON	DIN371	4	2	BRIGHT
					4	2	TiCN
		DIN – PREMIUM STEEL STRAIGHT FLUTE CAST IRON- COOLANT THRU	DIN371	4	2	BRIGHT	
					4	2	TiCN
	BX800	CLEANOUT TAP	ANSI	3	4	NIT/STEAM	
M8 X 1.25		BX100	SPIRAL POINT HIGH HOOK	ANSI CNC	3	4.5	BRIGHT
			SPIRAL POINT STEEL	ANSI CNC	3	4.5	TiN
			SPIRAL POINT STAINLESS STEEL	ANSI CNC	3	4.5	TiCN
		BX150	SPIRAL POINT HARD STEEL	ANSI CNC	3	5.5	NIT/STEAM
		BX170	EXTENSION – SPIRAL POINT	6" OAL	3	4.5	BRIGHT
		BX200	45° HI-SPIRAL ALUMINUM	ANSI CNC	3	2.5	BRIGHT
			45° HI-SPIRAL	ANSI CNC	3	2.5	STEAM OXIDE
			45° HI-SPIRAL STEEL	ANSI CNC	3	2.5	TiN
			45° HI-SPIRAL STAINLESS	ANSI CNC	3	2.5	TiCN
		BX201	OTL 45° HI-SPIRAL	ANSI CNC	3	1.5	BRIGHT
		BX220	EXTENSION – 45° SPIRAL FLUTE	6" OAL	3	2.5	BRIGHT
		BX210	DIN – 38° SPIRAL FLUTE	DIN371	3	2.5	NIT/STEAM
					3	2.5	TiN
					3	2.5	TiCN
		BX400	15° SPIRAL FLUTE STEEL	ANSI CNC	3	3	NIT/STEAM
		BX500	15° SPIRAL FLUTE DIECAST ALUMINUM	ANSI CNC	3	2	BRIGHT
						3	2
			15° SPIRAL FLUTE DIECAST-COOLANT THRU	ANSI CNC	3	2	BRIGHT
						3	2
		BX510	DIN – PREMIUM STEEL 15° SPIRAL FLUTE	DIN371	3	2	BRIGHT
						3	2
			DIN – PREMIUM STEEL 15° SPIRAL FLUTE	DIN371	3	2	BRIGHT
				DIECAST-COOLANT THRU		3	2
		BX600	STRAIGHT FLUTE CAST IRON	ANSI CNC	4	2	BRIGHT
					4	2	TiCN
STRAIGHT FLUTE CAST IRON-COOLANT THRU			ANSI CNC	4	2	BRIGHT	
					4	2	TiCN
	BX610	DIN – PREMIUM STEEL STRAIGHT FLUTE CAST IRON	DIN371	4	2	BRIGHT	
					4	2	TiCN
		DIN – PREMIUM STEEL STRAIGHT FLUTE CAST IRON- COOLANT THRU	DIN371	4	2	BRIGHT	
					4	2	TiCN
	BX800	CLEANOUT TAP	ANSI	4	4	NIT/STEAM	













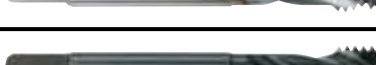
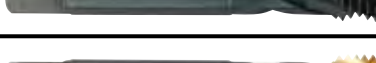


\*RED INDICATES COATED TAPS IN-STOCK

CLASS 6H	CLASS 4H	EDP #	D2	D3	D4	D5	D6	D7	D8	SERIES
D5	D3					52905-010				BX510
D5	D3					52905-01T				
D5	D3					52905-0H0				
D5	D3					52905-0HT				
D5	D3			54603-010		54605-010				BX600
D5	D3			54603-01C		54605-01C				
D5	D3			54603-0H0		54605-0H0				
D5	D3			54603-0HC		54605-0HC				
D5	D3					54805-010				BX610
D5	D3					54805-01C				
D5	D3					54805-0H0				
D5	D3					54805-0HC				
YES	YES	54600-006								BX800
D5	D3		31062-000	31063-000	31064-000	31065-000	31066-000	31067-000	31068-000	BX100
D5	D3		31062-00T	31063-00T	31064-00T	31065-00T	31066-00T	31067-00T	31068-00T	
D5	D3		31062-00C	31063-00C	31064-00C	31065-00C	31066-00C	31067-00C	31068-00C	
D5	D3			33063-006	33064-006	33065-006				BX150
D5	D3					38505-000				BX170
D5	D3			43063-010	43064-010	43065-010	43066-010	43067-010	43068-010	BX200
D5	D3			43063-01S	43064-01S	43065-01S	43066-01S	43067-01S	43068-01S	
D5	D3			43063-01T	43064-01T	43065-01T	43066-01T	43067-01T	43068-01T	
D5	D3			43063-01C	43064-01C	43065-01C	43066-01C	43067-01C	43068-01C	
D5	D3			43363-010		43365-010				BX201
D5	D3					49505-010				BX220
D5	D3					43210-016				BX210
D5	D3					43210-01T				
D5	D3					43210-01C				
D5	D3			52063-016		52065-016				BX400
D5	D3					52835-010				BX500
D5	D3					52835-01T				
D5	D3					52835-0H0				
D5	D3					52835-0HT				
D5	D3					52915-010				BX510
D5	D3					52915-01T				
D5	D3					52915-0H0				
D5	D3					52915-0HT				
D5	D3			54613-010		54615-010				BX600
D5	D3			54613-01T		54615-01C				
D5	D3			54613-0H0		54615-0H0				
D5	D3			54613-0HT		54615-0HC				
D5	D3					54815-010				BX610
D5	D3					54815-01C				
D5	D3					54815-0H0				
D5	D3					54815-0HC				
YES	YES	54610-006								BX800

TAP SIZE	IMAGE	SERIES	DESCRIPTION	BLANK	# FLUTES	CHAMFER	COATING
M10 X 1.5		BX100	SPIRAL POINT HIGH HOOK	ANSI CNC	3	4.5	BRIGHT
			SPIRAL POINT STEEL	ANSI CNC	3	4.5	TiN
			SPIRAL POINT STAINLESS STEEL	ANSI CNC	3	4.5	TiCN
		BX150	SPIRAL POINT HARD STEEL	ANSI CNC	3	5.5	NIT/STEAM
		BX170	EXTENSION - SPIRAL POINT	6" OAL	3	4.5	BRIGHT
		BX200	45° HI-SPIRAL ALUMINUM	ANSI CNC	3	2.5	BRIGHT
			45° HI-SPIRAL	ANSI CNC	3	2.5	STEAM OXIDE
			45° HI-SPIRAL STEEL	ANSI CNC	3	2.5	TiN
			45° HI-SPIRAL STAINLESS	ANSI CNC	3	2.5	TiCN
		BX201	OTL 45° HI-SPIRAL	ANSI CNC	3	1.5	BRIGHT
		BX220	EXTENSION - 45° SPIRAL FLUTE	6" OAL	3	2.5	BRIGHT
		BX210	DIN - 38° SPIRAL FLUTE	DIN371	3	2.5	NIT/STEAM
					3	2.5	TiN
					3	2.5	TiCN
		BX400	15° SPIRAL FLUTE STEEL	ANSI CNC	3	3	NIT/STEAM
			BX500	15° SPIRAL FLUTE DIECAST ALUMINUM	ANSI CNC	3	2
	3					2	TiN
	15° SPIRAL FLUTE DIECAST-COOLANT THRU			ANSI CNC	3	2	BRIGHT
					3	2	TiN
		BX510	DIN - PREMIUM STEEL 15° SPIRAL FLUTE DIECAST ALUMINUM	DIN371	3	2	BRIGHT
					3	2	TiN
			DIN - PREMIUM STEEL 15° SPIRAL FLUTE DIECAST-COOLANT THRU	DIN371	3	2	BRIGHT
					3	2	TiN
		BX600	STRAIGHT FLUTE CAST IRON	ANSI CNC	4	2	BRIGHT
4					2	TiCN	
4					2	TiCN	
	BX610	DIN - PREMIUM STEEL STRAIGHT FLUTE CAST IRON	DIN371	4	2	BRIGHT	
				4	2	TiCN	
		DIN - PREMIUM STEEL STRAIGHT FLUTE CAST IRON-COOLANT THRU	DIN371	4	2	BRIGHT	
				4	2	TiCN	
	BX800	CLEANOUT TAP	ANSI	4	4	NIT/STEAM	
	BX800	CLEANOUT TAP	ANSI	4	4	NIT/STEAM	
M12 X 1.75		BX100	SPIRAL POINT HIGH HOOK	ANSI	4	4.5	BRIGHT
			SPIRAL POINT STEEL	ANSI	4	4.5	TiN
			SPIRAL POINT STAINLESS STEEL	ANSI	4	4.5	TiCN
		BX150	SPIRAL POINT HARD STEEL	ANSI	4	5.5	NIT/STEAM
			BX200	45° HI-SPIRAL ALUMINUM	ANSI	3	2.5
	45° HI-SPIRAL			ANSI	3	2.5	STEAM OXIDE
	45° HI-SPIRAL STEEL			ANSI	3	2.5	TiN
	45° HI-SPIRAL STAINLESS			ANSI	3	2.5	TiCN
		BX201	OTL 45° HI-SPIRAL	ANSI	3	1.5	BRIGHT
			BX210	DIN - 38° SPIRAL FLUTE	DIN376	3	2.5
3	2.5					TiN	
3	2.5					TiCN	
	BX400	15° SPIRAL FLUTE STEEL	ANSI	3	3	NIT/STEAM	

CLASS 6H	CLASS 4H	EDP #	D2	D3	D4	D5	D6	D7	D8	SERIES
D6	D4		31072-000	31073-000	31074-000	31075-000	31076-000	31077-000	31078-000	BX100
D6	D4		31072-00T	31073-00T	31074-00T	31075-00T	31076-00T	31077-00T	31078-00T	
D6	D4		31072-00C	31073-00C	31074-00C	31075-00C	31076-00C	31077-00C	31078-00C	
D6	D4				33074-006	33075-006	33076-006			BX150
D6	D4						38606-000			BX170
D6	D4			43073-010	43074-010	43075-010	43076-010	43077-010	43078-010	BX200
D6	D4			43073-01S	43074-01S	43075-01S	43076-01S	43077-01S	43078-01S	
D6	D4			43073-01T	43074-01T	43075-01T	43076-01T	43077-01T	43078-01T	
D6	D4			43073-01C	43074-01C	43075-01C	43076-01C	43077-01C	43078-01C	BX201
D6	D4				43374-010		43376-010			BX220
D6	D4						49606-010			BX220
D6	D4						43220-006			BX210
D6	D4						43220-00T			
D6	D4						43220-00C			
D6	D4				52074-016		52076-016			BX400
D6	D4						52846-010			BX500
D6	D4						52846-01T			
D6	D4						52846-0H0			
D6	D4						52846-0HT			
D6	D4						52926-000			BX510
D6	D4						52926-00T			
D6	D4						52926-0J0			
D6	D4						52926-0JT			
D6	D4				54624-010		54626-010			BX600
D6	D4				54624-01C		54626-01C			
D6	D4				54624-0H0		54626-0H0			
D6	D4				54624-0HC		54626-0HC			
D6	D4						54826-000			BX610
D6	D4						54826-00C			
D6	D4						54826-0J0			
D6	D4						54826-0JC			
YES	YES	54620-006								BX800
YES	YES	54625-006								BX800
D6	D4		31082-000	31083-000	31084-000	31085-000	31086-000	31087-000	31088-000	BX100
D6	D4		31082-00T	31083-00T	31084-00T	31085-00T	31086-00T	31087-00T	31088-00T	
D6	D4		31082-00C	31083-00C	31084-00C	31085-00C	31086-00C	31087-00C	31088-00C	
D6	D4				33084-006	33085-006	33086-006			BX150
D6	D4			43083-000	43084-000	43085-000	43086-000	43087-000	43088-000	BX200
D6	D4			43083-00S	43084-00S	43085-00S	43086-00S	43087-00S	43088-00S	
D6	D4			43083-00T	43084-00T	43085-00T	43086-00T	43087-00T	43088-00T	
D6	D4			43083-00C	43084-00C	43085-00C	43086-00C	43087-00C	43088-00C	BX201
D6	D4				43384-000		43386-000			BX201
D6	D4						43230-006			BX210
D6	D4						43230-00T			
D6	D4						43230-00C			
D6	D4				52084-006		52086-006			BX400



TAP SIZE	IMAGE	SERIES	DESCRIPTION	BLANK	# FLUTES	CHAMFER	COATING	
M12 X 1.75 CONT.		BX500	15° SPIRAL FLUTE DIECAST ALUMINUM	ANSI	3	2	BRIGHT	
					3	2	TiN	
			15° SPIRAL FLUTE DIECAST-COOLANT THRU	ANSI	3	2	BRIGHT	
		BX600	STRAIGHT FLUTE CAST IRON	ANSI	4	2	BRIGHT	
					4	2	TiCN	
			STRAIGHT FLUTE CAST IRON-COOLANT THRU	ANSI	4	2	BRIGHT	
		BX610	DIN – PREMIUM STEEL STRAIGHT FLUTE CAST IRON	DIN376	4	2	BRIGHT	
					4	2	TiCN	
			DIN – PREMIUM STEEL ST FL CAST IRON-COOLANT THRU	DIN376	4	2	BRIGHT	
		BX800	CLEANOUT TAP	ANSI	4	4	NIT/STEAM	
					4	4	TiCN	
					4	4	TiCN	
M14 X 1.5		BX210	DIN – 38° SPIRAL FLUTE	DIN376	3	2.5	NIT/STEAM	
					3	2.5	TiN	
					3	2.5	TiCN	
M14 X 2.0		BX100	SPIRAL POINT HIGH HOOK	ANSI	4	4.5	BRIGHT	
			BX200	45° HI-SPIRAL	ANSI	4	2.5	BRIGHT
				BX210	DIN – 38° SPIRAL FLUTE	DIN376	3	2.5
		3			2.5	TiN		
		3	2.5		TiCN			
M16 X 1.5		BX210	DIN – 38° SPIRAL FLUTE	DIN376	3	2.5	NIT/STEAM	
					3	2.5	TiN	
					3	2.5	TiCN	
M16 X 2.0		BX100	SPIRAL POINT HIGH HOOK	ANSI	4	4.5	BRIGHT	
			BX200	45° HI-SPIRAL	ANSI	4	2.5	BRIGHT
				BX210	DIN – 38° SPIRAL FLUTE	DIN376	3	2.5
		3			2.5	TiN		
		3	2.5		TiCN			
M18 X 1.5		BX210	DIN – 38° SPIRAL FLUTE	DIN376	3	2.5	NIT/STEAM	
					3	2.5	TiN	
					3	2.5	TiCN	
M18 X 2.5		BX210	DIN – 38° SPIRAL FLUTE	DIN376	3	2.5	NIT/STEAM	
					3	2.5	TiN	
					3	2.5	TiCN	
M20 X 1.5		BX210	DIN – 38° SPIRAL FLUTE	DIN376	3	2.5	NIT/STEAM	
					3	2.5	TiN	
					3	2.5	TiCN	
M20 X 2.5		BX210	DIN – 38° SPIRAL FLUTE	DIN376	3	2.5	NIT/STEAM	
					3	2.5	TiN	
					3	2.5	TiCN	
M22 X 1.5		BX210	DIN – 38° SPIRAL FLUTE	DIN376	4	2.5	NIT/STEAM	
					4	2.5	TiN	
					4	2.5	TiCN	
M22 X 2.5		BX210	DIN – 38° SPIRAL FLUTE	DIN376	4	2.5	NIT/STEAM	
					4	2.5	TiN	
					4	2.5	TiCN	
M24 X 2.0		BX210	DIN – 38° SPIRAL FLUTE	DIN376	4	2.5	NIT/STEAM	
					4	2.5	TiN	
					4	2.5	TiCN	
M24 X 3.0		BX210	DIN – 38° SPIRAL FLUTE	DIN376	4	2.5	NIT/STEAM	
					4	2.5	TiN	
					4	2.5	TiCN	

CLASS 6H	CLASS 4H	EDP #	D3	D4	D5	D6	D7	D8	SERIES
D6	D4					52856-000			BX500
D6	D4					52856-00T			
D6	D4					52856-0J0			
D6	D4					52856-0JT			BX600
D6	D4				54634-000	54636-000			
D6	D4				54634-00C	54636-00C			
D6	D4				54634-0J0	54636-0J0			BX610
D6	D4				54634-0JC	54636-0JC			
D6	D4					54846-000			
D6	D4					54846-00C			BX800
D6	D4					54846-0J0			
D6	D4					54846-0JC			
YES	YES	54630-006							
D6	D4					43240-006			BX210
D6	D4					43240-00T			
D6	D4					43240-00C			
D7	D4		31093-000				31097-000		BX100
D7	D4		43093-000				43097-000		BX200
D7	D4						43250-006		BX210
D7	D4						43250-00T		
D7	D4						43250-00C		
D6	D4					43260-006			BX210
D6	D4					43260-00T			
D6	D4					43260-00C			
D7	D4		31103-000				31107-000		BX100
D7	D4		43103-000				43107-000		BX200
D7	D4						43270-006		BX210
D7	D4						43270-00T		
D7	D4						43270-00C		
D6	D4					43280-006			BX210
D6	D4					43280-00T			
D6	D4					43280-00C			
D7	D5						43290-006		BX210
D7	D5						43290-00T		
D7	D5						43290-00C		
D6	D4					43300-006			BX210
D6	D4					43300-00T			
D6	D4					43300-00C			
D7	D5						43310-006		BX210
D7	D5						43310-00T		
D7	D5						43310-00C		
D6	D4					43320-006			BX210
D6	D4					43320-00T			
D6	D4					43320-00C			
D7	D5						43340-006		BX210
D7	D5						43340-00T		
D7	D5						43340-00C		
D7	D5						43350-006		BX210
D7	D5						43350-00T		
D7	D5						43350-00C		
D8	D6							43370-006	BX210
D8	D6							43370-00T	
D8	D6							43370-00C	

# THREDSHAVER PIPE TAPS

NPSF, NPT, NPTF

THREDSHAVERS  
PIPE TAPS

TAP SIZE	IMAGE	SERIES	DESCRIPTION	BLANK	# FLUTES	CHAMFER	COATING	PROJECTION	EDP #
1/16-27		BX710	NPT – SPIRAL FLUTE	ANSI PIPE	4	1.5	BRIGHT	.222/.259	59900
			NPTF – SPIRAL FLUTE		4	1.5	BRIGHT	.222/.259	59902
1/8-27 SM (.3125 SHANK)		BX700	NPSF – STRAIGHT FLUTE	ANSI PIPE	4	2	BRIGHT	-	59914
		BX710	NPT – SPIRAL FLUTE	ANSI PIPE	4	1.5	BRIGHT	.222/.259	59910
	NPTF – SPIRAL FLUTE		4		1.5	BRIGHT	.222/.259	59912	
1/8-27 LG (.4375 SHANK)		BX700	NPSF – STRAIGHT FLUTE	ANSI PIPE	4	2	BRIGHT	-	59924
		BX710	NPT – SPIRAL FLUTE	ANSI PIPE	4	1.5	BRIGHT	.222/.259	59920
	NPTF – SPIRAL FLUTE		4		1.5	BRIGHT	.222/.259	59922	
1/4-18		BX700	NPSF – STRAIGHT FLUTE	ANSI PIPE	4	2	BRIGHT	-	59934
		BX710	NPT – SPIRAL FLUTE	ANSI PIPE	4	1.5	BRIGHT	.333/.389	59930
	NPTF – SPIRAL FLUTE		4		1.5	BRIGHT	.333/.389	59932	
3/8-18		BX700	NPSF – STRAIGHT FLUTE	ANSI PIPE	4	2	BRIGHT	-	59944
		BX710	NPT – SPIRAL FLUTE	ANSI PIPE	4	1.5	BRIGHT	.333/.389	59940
	NPTF – SPIRAL FLUTE		4		1.5	BRIGHT	.333/.389	59942	
1/2-14		BX700	NPSF – STRAIGHT FLUTE	ANSI PIPE	4	2	BRIGHT	-	59954
		BX710	NPT – SPIRAL FLUTE	ANSI PIPE	4	1.5	BRIGHT	.429/.500	59950
	NPTF – SPIRAL FLUTE		4		1.5	BRIGHT	.429/.500	59952	
3/4-14		BX710	NPT – SPIRAL FLUTE	ANSI PIPE	5	1.5	BRIGHT	.429/.500	59960
			NPTF – SPIRAL FLUTE		5	1.5	BRIGHT	.429/.500	59962

## SAE SHORT PROJECTION

Series BX710 (NPT and NPTF) are made to SAE short projection specifications

### B700 – Recommended Applications

MATERIALS	EXAMPLES	HOLE THRU	BLIND HOLE	NITRIDE	STEAM OXIDE	BRIGHT FINISH	BALWEAR	BALUBE	TIN	SUPER TIN	TICN	TIAIN
DIECAST ALUMINUM	380, 383	•	•	•					•			
DIECAST ZINC		•	•			•						
CAST IRON	GREY IRON, DUCTILE	•	•	•	•				•			
BRONZE CASTING		•	•	•	•				•			

### BX710 – Recommended Applications

MATERIALS	EXAMPLES	HOLE THRU	BLIND HOLE	NITRIDE	STEAM OXIDE	BRIGHT FINISH	BALWEAR	BALUBE	TIN	SUPER TIN	TICN	TIAIN
LOW CARBON STEEL RC 20 & BELOW	1010, 1020, 1035 1040, 1215	•	•						•			
HIGH CARBON STEEL ALLOY STEEL	1050, 1065	•	•	•	•							
TOOL & DIE STEEL PRE-HEAT TREAT	D2, H13, M1, M7	•	•	•	•							
AUSTENITIC STAINLESS STEEL	302, 303, 304, 316	•	•						•		•	
MARTENSITIC STAINLESS STEEL	410, 420, 440	•	•	•	•							
WROUGHT IRON	2024, 6061, 7075	•	•			•						
DIECAST ALUMINUM	380, 383	•	•	•					•			
DIECAST ZINC		•	•			•						
COPPER & BRASS FREE MACHINING		•	•				•		•			

# CARBIDE INSERTED THREDFLOERS AND THREDSHAVERS

The next generation of high performance taps are now available from Balax. Made with embedded carbide thread sections, these taps offer many advantages and give you the best of both worlds.

- The torsional strength of a High Speed Steel (HSS) tap body
- The exceptional wear resistance of carbide in the areas where all the tapping work is done.

## EXTENDED TAP LIFE

In automotive diecast aluminum, the tap life of carbide inserted Cold Forming taps can be from two hundred thousand holes to 1 million, depending on the thread percentage, coolant lubricity and other factors.

The tap life of carbide inserted Cutting taps running in abrasive automotive diecast aluminum or cast iron, is typically at least 3-5 times that of conventional taps and the taps may be resharpened to provide additional cost savings.

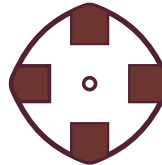
## MORE ECONOMICAL THAN SOLID CARBIDE

Carbide Inserted Taps are more cost effective than large diameter solid carbide taps or most extended length solid carbide taps because less carbide blank material is required.

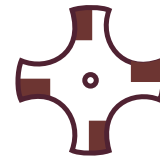
## LESS TAP BREAKAGE

Carbide Inserted Taps may be used in multi-spindle applications where breakage of solid carbide taps is a problem.

THREDFLOER



THREDSHAVER



## ANSI THREDFLOERS















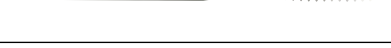

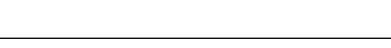
Designed for diecast aluminum and other non-ferrous applications.

TAP SIZE	SERIES	BLANK	CHAMFER	COATING	CLASS 2B	
					H #	EDP #
6-32	BOTTOM	ANSI CNC	2.5	BRIGHT	5	11435-010
8-32	BOTTOM	ANSI CNC	2.5	BRIGHT	5	11785-010
10-24	BOTTOM	ANSI CNC	2.5	BRIGHT	5	12115-010
10-32	BOTTOM	ANSI CNC	2.5	BRIGHT	5	12335-010
1/4-20	BOTTOM	ANSI CNC	2.5	BRIGHT	7	12797-010
1/4-28	BOTTOM	ANSI CNC	2.5	BRIGHT	6	13016-010
5/16-18	BOTTOM	ANSI CNC	2.5	BRIGHT	8	13198-010
5/16-24	BOTTOM	ANSI CNC	2.5	BRIGHT	7	13367-010
3/8-16	BOTTOM	ANSI CNC	2.5	BRIGHT	8	13558-010
3/8-24	BOTTOM	ANSI CNC	2.5	BRIGHT	7	13727-010

NPSF THREDSHAVER – Designed for diecast aluminum and cast iron production tapping applications.

TAP SIZE	IMAGE	SERIES	DESCRIPTION	BLANK	# FLUTES	CHAMFER	COATING	EDP #
1/4-18		BX730	NPSF STRAIGHT FLUTE	ANSI PIPE	4	2	BRIGHT	59938
3/8-18		BX730	NPSF STRAIGHT FLUTE	ANSI PIPE	4	2	BRIGHT	59948
1/2-14		BX730	NPSF STRAIGHT FLUTE	ANSI PIPE	4	2	BRIGHT	59958

**METRIC – CARBIDE INSERTED THREDFLOERS AND THREDSHAVERS**

TAP SIZE	IMAGE	SERIES	DESCRIPTION	BLANK	# FLUTES	CHAMFER	COATING	CLASS 6H	
								D #	EDP #
M3.5 X .6		BOTTOM	THREDFLOER	ANSI CNC	-	2.5	BRIGHT	7	17897-010
M4 X .7		BOTTOM	THREDFLOER	ANSI CNC	-	2.5	BRIGHT	7	18097-010
M5 X .8		BOTTOM	THREDFLOER	ANSI CNC	-	2.5	BRIGHT	8	18298-010
M6 X 1.0		BOTTOM	THREDFLOER	ANSI CNC	-	2.5	BRIGHT	9	18499-010
		DIN	DIN – THREDFLOER	DIN371	-	2.5	BRIGHT	9	18599-010
		BX520	15° SPIRAL FLUTE DIECAST ALUMINUM	ANSI CNC	3	2	BRIGHT	5	53005-010
			15° SPIRAL FLUTE DIECAST-COOLANT THRU	ANSI CNC	3	2	BRIGHT	5	53005-0H0
		BX530	DIN – 15° SPIRAL FLUTE DIECAST ALUMINUM	DIN371	3	2	BRIGHT	5	53105-010
			DIN – 15° SPIRAL FLUTE DIECAST-COOLANT THRU	DIN371	3	2	BRIGHT	5	53105-0H0
		BX620	STRAIGHT FLUTE CAST IRON	ANSI CNC	3	2	BRIGHT	5	55105-010
			STRAIGHT FLUTE CAST IRON-COOLANT THRU	ANSI CNC	3	2	BRIGHT	5	55105-0H0
		BX630	DIN – STRAIGHT FLUTE CAST IRON	DIN371	3	2	BRIGHT	5	55205-010
			DIN – STRAIGHT FLUTE CAST IRON-COOLANT THRU	DIN371	3	2	BRIGHT	5	55205-0H0
M8 X 1.25		BOTTOM	THREDFLOER	ANSI CNC	-	2.5	BRIGHT	10	18690-010
		DIN	DIN – THREDFLOER	DIN371	-	2.5	BRIGHT	10	18700-010
		BX520	15° SPIRAL FLUTE DIECAST ALUMINUM	ANSI CNC	3	2	BRIGHT	5	53015-010
			15° SPIRAL FLUTE DIECAST-COOLANT THRU	ANSI CNC	3	2	BRIGHT	5	53015-0H0
		BX530	DIN – 15° SPIRAL FLUTE DIECAST ALUMINUM	DIN371	3	2	BRIGHT	5	53115-010
			DIN – 15° SPIRAL FLUTE DIECAST-COOLANT THRU	DIN371	3	2	BRIGHT	5	53115-0H0
		BX620	STRAIGHT FLUTE CAST IRON	ANSI CNC	4	2	BRIGHT	5	55115-010
			STRAIGHT FLUTE CAST IRON-COOLANT THRU	ANSI CNC	4	2	BRIGHT	5	55115-0H0
		BX630	DIN – STRAIGHT FLUTE CAST IRON	DIN371	4	2	BRIGHT	5	55215-010
			DIN – STRAIGHT FLUTE CAST IRON-COOLANT THRU	DIN371	4	2	BRIGHT	5	55215-0H0













CARBIDE INSERTED  
METRIC

**BALAX SERIES BX520 (ANSI) AND BX530 (DIN)**

Slow-Spiral Flute Thredshavers are designed to provide extended tap life in automotive diecast aluminum applications. The heavy duty slow spiral design provides additional tap strength compared to hi-spiral flute taps and excellent chip evacuation for deep blind hole tapping.

*Coolant-Thru Carbide Inserted Diecast Thredshavers* are available to improve chip evacuation and tap life.

**METRIC – CARBIDE INSERTED THREDFLOERS AND THREDSHAVERS – CONTINUED**

TAP SIZE	IMAGE	SERIES	DESCRIPTION	BLANK	# FLUTES	CHAMFER	COATING	CLASS 6H	
								D #	EDP #
M10 X 1.5		BOTTOM	THREDFLOER	ANSI CNC	-	2.5	BRIGHT	11	18871-010
		DIN	DIN – THREDFLOER	DIN371	-	2.5	BRIGHT	11	18881-000
		BX520	15° SPIRAL FLUTE DIECAST ALUMINUM	ANSI CNC	3	2	BRIGHT	6	53026-010
			15° SPIRAL FLUTE DIECAST-COOLANT THRU	ANSI CNC	3	2	BRIGHT	6	53026-0H0
		BX530	DIN – 15° SPIRAL FLUTE DIECAST ALUMINUM	DIN371	3	2	BRIGHT	6	53126-000
			DIN 15° SPIRAL FLUTE DIECAST-COOLANT THRU	DIN371	3	2	BRIGHT	6	53126-0J0
		BX620	STRAIGHT FLUTE CAST IRON	ANSI CNC	4	2	BRIGHT	6	55126-010
			STRAIGHT FLUTE CAST IRON-COOLANT THRU	ANSI CNC	4	2	BRIGHT	6	55126-0H0
		BX630	DIN – STRAIGHT FLUTE CAST IRON	DIN371	4	2	BRIGHT	6	55226-000
			DIN – STRAIGHT FLUTE CAST IRON-COOLANT THRU	DIN371	4	2	BRIGHT	6	55226-0J0
M12 X 1.75		BOTTOM	THREDFLOER	ANSI CNC	-	2.5	BRIGHT	12	19072-000
		DIN	DIN – THREDFLOER	DIN376	-	2.5	BRIGHT	12	19082-000
		BX520	15° SPIRAL FLUTE DIECAST ALUMINUM	ANSI CNC	3	2	BRIGHT	6	53036-000
			15° SPIRAL FLUTE DIECAST-COOLANT THRU	ANSI CNC	3	2	BRIGHT	6	53036-0J0
		BX530	DIN – 15° SPIRAL FLUTE DIECAST ALUMINUM	DIN376	3	2	BRIGHT	6	53136-000
			DIN – 15° SPIRAL FLUTE DIECAST-COOLANT THRU	DIN376	3	2	BRIGHT	6	53136-0J0
		BX620	STRAIGHT FLUTE CAST IRON	ANSI CNC	4	2	BRIGHT	6	55136-000
			STRAIGHT FLUTE CAST IRON-COOLANT THRU	ANSI CNC	4	2	BRIGHT	6	55136-0J0
		BX630	DIN – STRAIGHT FLUTE CAST IRON	DIN376	4	2	BRIGHT	6	55236-000
			DIN – STRAIGHT FLUTE CAST IRON-COOLANT THRU	DIN376	4	2	BRIGHT	6	55236-0J0

CARBIDE INSERTED METRIC

**BALAX SERIES BX620 (ANSI) AND BX630 (DIN)**

Carbide Inserted Cast Iron Thredshavers are designed to provide extended tap life in cast iron production tapping applications.

*Coolant-Thru Carbide Inserted Cast Iron Thredshavers* are available to improve chip evacuation and tap life.

# PRECISION GROUND TAPERLOCK THREAD GAGES



## PRECISION GROUND TAPERLOCK THREAD GAGES

### SUPERIOR METALLURGY

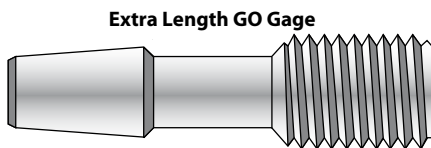
- Made from High Speed Tool Steel., the same material as used in tap manufacturing.
- Heat treated to 63-65 Rockwell C , the same hardness as used in tap manufacturing.

### SUPERIOR ACCURACY

- Thread ground on proprietary Balax Thread Grinders. This unique grinding process provides accurate thread profiles with less lead error than other gage grinding methods used today.

### EXTRA LENGTH FEATURE

Balax "Go" Gages in sizes 4-40 (M3 x .5) and larger are made with a relieved or undercut thread section. This *longer-than-standard* length feature allows gaging to thread depths achieved with standard tap thread lengths. Reversible gages are no longer required to check deep tapped holes.



Extra Length GO Gage

### MINIATURE GAGES

Available in sizes ranging from 000-120 to 00-90 or .90 UNM to 1.40 UNM. The high quality materials and special grinding process used to manufacture Our Miniature Gages provide a consistency and accuracy never before available with miniature gages. They are held in special collet type holders.

## CERTIFICATE OF INSPECTION

All Balax Thread Gages are furnished with actual fifth place (.00000) measurements of pitch diameter and major diameter to guarantee the accuracy of your gage to "Class-X" tolerance levels.

BALAX Inc. - P.O. Box 96 - North Lake, WI 53064 -		(262) 966-2355 - FAX: (262) 966-1028			
THREAD PLUG <input type="checkbox"/> GO <input type="checkbox"/> NO GO <input type="checkbox"/> SET PLUG	SIZE	CLASS	GAGE TOL.	FREQ. OF CALIBRATION	SER. No. TA No. CO. NAME
SPECIFICATION		ACTUAL CERTIFIED CALIBRATION		REMARKS	
MAJOR DIAMETER	BASIC TOL.	MAJOR DIAMETER		CERTIFICATION OF MASTERS ARE TRACEABLE TO THE NATIONAL INSTITUTE OF STANDARDS AND TECHNOLOGY, NIST	
PITCH DIAMETER	BASIC TOL.	PITCH DIAMETER		<input type="checkbox"/> CERTIFIED OK	
MINOR DIAMETER	<input type="checkbox"/> MIN/CM DEPTH to P / R <input type="checkbox"/> MIN/PCD and TABS & G of ANSI FORM B1 2881 16M	MINOR DIAMETER	<input type="checkbox"/> WITHIN TOL.	<input type="checkbox"/> CERT. NEAR LOW LIMIT <input type="checkbox"/> RECONDITION BY LAPPING <input type="checkbox"/> RECONDITION BY CUT OFF <input type="checkbox"/> NEEDS RECONDITIONING <input type="checkbox"/> NEW REPLACEMENT	
LEAD	<input type="checkbox"/> 50 deg per Table G of ANSI FORM B1 2881 16M	LEAD	<input type="checkbox"/> WITHIN TOL.	NIST 9104 - 4562A TEMP 68 deg HUMIDITY 50%	
ANGLE	<input type="checkbox"/> 55 deg per Table G of ANSI FORM B1 2881 16M	ANGLE THREAD FORM	<input type="checkbox"/> WITHIN TOL.	<input type="checkbox"/> TEST #	
THREAD FORM	<input type="checkbox"/> MIN. 3 - 7750 16M <input type="checkbox"/> ANSI FORM B1 2881 16M	HARDNESS	<input type="checkbox"/> 59-63 RC		
HARDNESS		INSPECTOR	DATE	NOTES	



### TITANIUM NITRIDE

Titanium Nitrided thread gages are available for all stock sizes.

### SPECIAL GAGES

Balax can custom manufacture gages to your specifications.

# TAPERLOCK GAGES



**TIN COATED SETS HAVE TWO OPTIONS:**  
 - BOTH ELEMENTS TIN  
 - ONLY GO MEMBER TIN

## ANSI

SIZE	"GO" GAGE			CLASS 2B "NO-GO"		CLASS 3B "NO-GO"		2B SET			3B SET		
	PD (in.)	EDP #	TiN EDP#	PD (in.)	EDP #	PD (in.)	EDP #	EDP#	BOTH TiN EDP#	"GO" TiN ONLY#	EPD#	BOTH TiN EDP#	"GO" TiN ONLY#
0-80	.0519	90000	90000T	.0542	90002	.0536	90004	90006	90006T	90006G	90008	90008T	90008G
1-64	.0629	90010	90010T	.0655	90012	.0648	90014	90016	90016T	90016G	90018	90018T	90018G
1-72	.0640	90020	90020T	.0665	90022	.0659	90024	90026	90026T	90026G	90028	90028T	90028G
2-56	.0744	90030	90030T	.0772	90032	.0765	90034	90036	90036T	90036G	90038	90038T	90038G
2-64	.0759	90040	90040T	.0786	90042	.0779	90044	90046	90046T	90046G	90048	90048T	90048G
3-48	.0855	90050	90050T	.0885	90052	.0877	90054	90056	90056T	90056G	90058	90058T	90058G
3-56	.0874	90060	90060T	.0902	90062	.0895	90064	90066	90066T	90066G	90068	90068T	90068G
4-40	.0958	90070	90070T	.0991	90072	.0982	90074	90076	90076T	90076G	90078	90078T	90078G
4-48	.0985	90080	90080T	.1016	90082	.1008	90084	90086	90086T	90086G	90088	90088T	90088G
5-40	.1088	90090	90090T	.1121	90092	.1113	90094	90096	90096T	90096G	90098	90098T	90098G
5-44	.1102	90100	90100T	.1134	90102	.1126	90104	90106	90106T	90106G	90108	90108T	90108G
6-32	.1177	90110	90110T	.1214	90112	.1204	90114	90116	90116T	90116G	90118	90118T	90118G
6-40	.1218	90120	90120T	.1252	90122	.1243	90124	90126	90126T	90126G	90128	90128T	90128G
8-32	.1437	90130	90130T	.1475	90132	.1465	90134	90136	90136T	90136G	90138	90138T	90138G
8-36	.1460	90140	90140T	.1496	90142	.1487	90144	90146	90146T	90146G	90148	90148T	90148G
10-24	.1629	90150	90150T	.1672	90152	.1661	90154	90156	90156T	90156G	90158	90158T	90158G
10-32	.1697	90160	90160T	.1736	90162	.1726	90164	90166	90166T	90166G	90168	90168T	90168G
12-24	.1889	90724	90724T	.1933	90726	.1922	90728	90730	90730T	90730G	90732	90732T	90732G
12-28	.1928	90734	90734T	.1970	90736	.1959	90738	90740	90740T	90740G	90742	90742T	90742G
1/4-20	.2175	90170	90170T	.2223	90172	.2211	90174	90176	90176T	90176G	90178	90178T	90178G
1/4-28	.2268	90180	90180T	.2311	90182	.2300	90184	90186	90186T	90186G	90188	90188T	90188G
1/4-32	.2297	90744	90744T	.2339	90746	.2328	90748	90750	90750T	90750G	90752	90752T	90752G
5/16-18	.2764	90190	90190T	.2817	90192	.2803	90194	90196	90196T	90196G	90198	90198T	90198G
5/16-24	.2854	90200	90200T	.2902	90202	.2890	90204	90206	90206T	90206G	90208	90208T	90208G
5/16-32	.2922	91000	91000T	.2964	91002	.2953	91004	91006	91006T	91006G	91008	91008T	91008G
3/8-16	.3344	90210	90210T	.3401	90212	.3387	90214	90216	90216T	90216G	90218	90218T	90218G
3/8-24	.3479	90220	90220T	.3528	90222	.3516	90224	90226	90226T	90226G	90228	90228T	90228G
3/8-32	.3547	91010	91010T	.3591	91012	.3580	91014	91016	91016T	91016G	91018	91018T	91018G
7/16-14	.3911	90230	90230T	.3972	90232	.3957	90234	90236	90236T	90236G	90238	90238T	90238G
7/16-20	.4050	90240	90240T	.4104	90242	.4091	90244	90246	90246T	90246G	90248	90248T	90248G
7/16-28	.4143	91020	91020T	.4189	91022	.4178	91024	91026	91026T	91026G	91028	91028T	91028G
1/2-13	.4500	90250	90250T	.4565	90252	.4548	90254	90256	90256T	90256G	90258	90258T	90258G
1/2-20	.4675	90260	90260T	.4731	90262	.4717	90264	90266	90266T	90266G	90268	90268T	90268G
1/2-28	.4768	91030	91030T	.4816	91032	.4804	91034	91036	91036T	91036G	91038	91038T	91038G
9/16-12	.5084	90270	90270T	.5152	90272	.5135	90274	90276	90276T	90276G	90278	90278T	90278G
9/16-18	.5264	90280	90280T	.5323	90282	.5308	90284	90286	90286T	90286G	90288	90288T	90288G
9/16-24	.5354	91040	91040T	.5405	91042	.5392	91044	91046	91046T	91046G	91048	91048T	91048G
5/8-11	.5660	90290	90290T	.5732	00292	.5714	90294	90296	90296T	90296G	90298	90298T	90298G
5/8-18	.5889	90300	90300T	.5949	90302	.5934	90304	90306	90306T	90306G	90308	90308T	90308G
5/8-24	.5979	91050	91050T	.6031	91052	.6018	91054	91056	91056T	91056G	91058	91058T	91058G
3/4-10	.6850	90310	90310T	.6927	90312	.6907	90314	90316	90316T	90316G	90318	90318T	90318G
3/4-16	.7094	90320	90320T	.7159	90322	.7143	90324	90326	90326T	90326G	90328	90328T	90328G
3/4-20	.7175	91060	91060T	.7232	91062	.7218	91064	91066	91066T	91066G	91068	91068T	91068G
7/8-9	.8028	90330	90330T	.8110	90332	.8089	90334	90336	90336T	90336G	90338	90338T	90338G
7/8-14	.8286	90340	90340T	.8356	90342	.8339	90344	90346	90346T	90346G	90348	90348T	90348G
7/8-20	.8425	91070	91070T	.8482	91072	.8468	91074	91076	91076T	91076G	91078	91078T	91078G
1-8	.9188	90350	90350T	.9276	90352	.9254	90354	90356	90356T	90356G	90358	90358T	90358G
1-12	.9459	90360	90360T	.9535	90362	.9516	90364	90366	90366T	90366G	90368	90368T	90368G

THREAD GAGES

# TAPERLOCK GAGES – CONTINUED



**TIN COATED SETS HAVE TWO OPTIONS:**  
 – BOTH ELEMENTS TIN  
 – ONLY GO MEMBER TIN

## METRIC

SIZE	"GO"			4H "NO-GO"		6H "NO-GO"		4H SET			6H SET		
	mm	EDP #	TiN EDP#	mm	EDP #	mm	EDP #	EDP#	BOTH TiN EDP#	"GO" TiN ONLY#	EDP#	BOTH TiN EDP#	"GO" TiN ONLY#
M1.6 X .35	1.373	90370	90370T	1.427	90374	1.458	90372	90378	90378T	90378G	90376	90376T	90376G
M1.7 X .35	1.473	90371	90371T	1.527	90375	1.558	90373	90624	90624T	90624G	90377	90377T	90377G
M2 X .4	1.740	90380	90380T	1.796	90384	1.830	90382	90388	90388T	90388G	90386	90386T	90386G
M2.5 X .45	2.208	90390	90390T	2.268	90394	2.303	90392	90398	90398T	90398G	90396	90396T	90396G
M2.6 X .45	2.308	90400	90400T	2.371	90404	2.403	90402	90408	90408T	90408G	90406	90406T	90406G
M3 X .5	2.675	90410	90410T	2.738	90414	2.775	90412	90418	90418T	90418G	90416	90416T	90416G
M3.5 X .6	3.110	90420	90420T	3.181	90424	3.222	90422	90428	90428T	90428G	90426	90426T	90426G
M4 X .7	3.545	90430	90430T	3.620	90434	3.663	90432	90438	90438T	90438G	90436	90436T	90436G
M5 X .8	4.480	90440	90440T	4.560	90444	4.605	90442	90448	90448T	90448G	90446	90446T	90446G
M6 X 1	5.350	90450	90450T	5.445	90454	5.500	90452	90458	90458T	90458G	90456	90456T	90456G
M8 X 1.25	7.188	90460	90460T	7.288	90464	7.348	90462	90468	90468T	90468G	90466	90466T	90466G
M10 X 1.25	9.188	91200	91200T	9.288	CFQ	9.348	91202	CFQ	CFQ	CFQ	91206	91206T	91206G
M10 X 1.5	9.026	90470	90470T	9.138	90474	9.206	90472	90478	90478T	90478G	90476	90476T	90476G
M12 X 1.25	11.188	91210	91210T	11.300	CFQ	11.368	91212	CFQ	CFQ	CFQ	91216	91216T	91216G
M12 X 1.5	11.026	91220	91220T	11.144	CFQ	11.216	91222	CFQ	CFQ	CFQ	91226	91226T	91226G
M12 X 1.75	10.863	90481	90481T	10.988	90485	11.063	90483	90489	90489T	90489G	90487	90487T	90487G
M14 X 1.5	13.026	91230	91230T	13.144	CFQ	13.216	91232	CFQ	CFQ	CFQ	91236	91236T	91236G
M14 X 2	12.701	91240	91240T	12.833	CFQ	12.913	91242	CFQ	CFQ	CFQ	91246	91246T	91246G
M16 X 1.5	15.026	91250	91250T	15.144	CFQ	15.216	91252	CFQ	CFQ	CFQ	91256	91256T	91256G
M16 X 2	14.701	91260	91260T	14.833	CFQ	14.913	91262	CFQ	CFQ	CFQ	91266	91266T	91266G
M18 X 1.5	17.026	91270	91270T	17.144	CFQ	17.216	91272	CFQ	CFQ	CFQ	91276	91276T	91276G
M18 X 2.5	16.376	91280	91280T	16.516	CFQ	16.600	91282	CFQ	CFQ	CFQ	91286	91286T	91286G
M20 X 1.5	19.026	91290	91290T	19.144	CFQ	19.216	91292	CFQ	CFQ	CFQ	91296	91296T	91296G
M20 X 2.5	18.376	91300	91300T	18.516	CFQ	18.600	91302	CFQ	CFQ	CFQ	91306	91306T	91306G
M22 X 1.5	21.026	91310	91310T	21.144	CFQ	21.216	91312	CFQ	CFQ	CFQ	91316	91316T	91316G
M22 X 2.5	20.376	91320	91320T	20.516	CFQ	20.600	91322	CFQ	CFQ	CFQ	91326	91326T	91326G
M24 X 2	22.701	91330	91330T	22.841	CFQ	22.925	91332	CFQ	CFQ	CFQ	91336	91336T	91336G
M24 X 3	22.051	91340	91340T	22.221	CFQ	22.316	91342	CFQ	CFQ	CFQ	91346	91346T	91346G

THREAD GAGES  
METRIC - PRE-PLATE

## OVERSIZE PRE-PLATE TAPERLOCK GAGES

### ANSI

SIZE	"GO" GAGE		"NO-GO" GAGE		SET
	PD	EDP #	PD	EDP #	EDP #
0-80	.0531	90576	.0554	90577	90976
1-72	.0652	90578	.0677	90579	90978
2-56	.0756	90580	.0784	90581	90980
4-40	.0970	90582	.1003	90583	90982
6-32	.1189	90584	.1226	90585	90984
8-32	.1449	90586	.1487	90587	90986
10-24	.1641	90588	.1684	90589	90988
10-32	.1709	90590	.1748	90591	90990
1/4-20	.2187	90592	.2235	90593	90992
1/4-28	.2280	90594	.2323	90595	90994

### METRIC

SIZE	6G "GO" GAGE		6G "NO-GO" GAGE		6G SET
	mm	EDP #	mm	EDP #	EDP #
M1.6 X .35	1.392	90596	1.477	90597	90996
M2 X .4	1.759	90598	1.849	90599	90998
M2.5 X .45	2.228	90600	2.323	90601	90900
M3 X .5	2.695	90602	2.795	90603	90902
M3.5 X .6	3.131	90604	3.243	90605	90904
M4 X .7	3.567	90606	3.685	90607	90906
M5 X .8	4.504	90608	4.629	90609	90908
M6 X 1	5.376	90610	5.526	90611	90910
M8 X 1.25	7.216	90612	7.376	90613	90912
M10 X 1.5	9.058	90614	9.238	90615	90914

**NOTES:**

1. Machine screw and fractional pre-plate gages are designed for Class 2B fit with a .0003" plating thickness allowance.
2. Metric pre-plate gages are designed to a "6G" tolerance.



## STI TAPERLOCK GAGES



### ANSI

SIZE	"GO" GAGE		CLASS 2B "NO-GO"		CLASS 3B "NO-GO"		SET	
	PITCH DIA.	EDP #	PITCH DIA.	EDP #	PITCH DIA.	EDP #	CLASS 2B	CLASS 3B
2-56	.0976	90480	.0996	90482	.0989	90766	90484	90767
3-48	.1126	91110	.1148	91112	.1140	91114	91116	91118
4-40	.1283	90486	.1308	90488	.1299	90493	90490	90491
5-40	.1413	90754	.1438	90756	.1430	90757	90758	90759
6-32	.1583	90492	.1611	90494	.1601	90495	90496	90497
6-40	.1543	90848	.1569	90850	.1560	90851	90852	90853
8-32	.1843	90498	.1872	90500	.1862	90501	90502	90503
10-24	.2170	90504	.2203	90506	.2192	90507	90508	90509
10-32	.2103	90510	.2133	90512	.2123	90513	90514	90515
12-24	.2430	90760	.2464	90762	.2453	90763	90764	90765
1/4-20	.2825	90516	.2864	90518	.2851	90519	90520	90521
1/4-28	.2732	90522	.2765	90524	.2754	90525	90526	90527
5/16-18	.3486	90700	.3529	90702	.3515	90703	90704	90705
5/16-24	.3395	90706	.3433	90708	.3421	90709	90710	90711
3/8-16	.4156	90712	.4203	90714	.4189	90715	90716	90717
3/8-24	.4020	90718	.4059	90720	.4047	90721	90722	90723
7/16-14	.4839	91080	.4890	91082	.4875	91084	91086	91088
7/16-20	.4700	91090	.4744	91092	.4731	91094	91096	91098
1/2-13	.5499	91100	.5554	91102	.5537	91104	91106	91108
1/2-20	.5325	90854	.5371	90856	.5357	90857	90858	90859

## STI TAPERLOCK GAGES



### METRIC

SIZE	"GO" GAGE			4H TOLERANCE "NO-GO"			4H SET EDP #
	mm	in.	EDP #	mm	in.	EDP #	
M2 X .4	2.260	.0890	90788	2.295	.0904	90790	90792
M2.5 X .45	2.792	.1099	90794	2.832	.1115	90796	90798
M3 X .5	3.325	.1309	90800	3.367	.1326	90802	90804
M3.5 X .6	3.890	.1531	90806	3.940	.1551	90808	90810
M4 X .7	4.455	.1754	90812	4.509	.1775	90814	90816
M5 X .8	5.520	.2173	90818	5.577	.2196	90820	90822
M6 X 1.0	6.650	.2618	90824	6.719	.2645	90826	90828
M8 X 1.25	8.812	.3469	90830	8.886	.3498	90832	90834
M10 X 1.5	10.974	.4320	90836	11.061	.4355	90838	90840
M12 X 1.75	13.137	.5172	90842	13.236	.5211	90844	90846

## MINIATURE GAGES



### ANSI – MACHINE SCREW

SIZE	"GO" GAGE		"NO-GO" GAGE		SET EDP #
	PITCH DIA.	EDP #	PITCH DIA.	EDP #	
000-120	.0286	90558	.0298	90560	90562
00-90	.0398	90570	.0412	90572	90574
00-96	.0402	90564	.0416	90566	90568

### METRIC – UNM

SIZE	THREAD PITCH		"GO" GAGE			"NO-GO" GAGE			UNM SET EDP #
	mm	TPI	mm	in.	EDP #	mm	in.	EDP #	
.70 UNM	.175	145	.586	.0231	90539	.608	.0240	90529	90531
.80 UNM	.200	127	.670	.0264	90533	.694	.0273	90535	90537
.90 UNM	.225	113	.754	.0297	90528	.780	.0307	90530	90532
1.00 UNM	.250	102	.838	.0330	90534	.866	.0341	90536	90538
1.10 UNM	.250	102	.938	.0369	90540	.966	.0380	90542	90544
1.20 UNM	.250	102	1.038	.0409	90546	1.066	.0420	90548	90550
1.40 UNM	.300	85	1.204	.0474	90552	1.237	.0487	90554	90556

## NPT TAPERLOCK GAGES



### NPT

THREAD GAGES MINIATURE - NPT	SIZE	PROJECTION TO NOTCH L1 (in.)	PLUG GAGE EDP #	PLUG GAGE WITH HANDLE EDP #
	1/16 – 27	.1600	91120	91122
	1/8 – 27	.1615	91124	91126
	1/4 – 18	.2278	91128	91130
	3/8 – 18	.240	91132	91134
	1/2 – 14	.320	91136	91138
	3/4 – 14	.339	91140	91142
	1 – 11-1/2	.400	91144	91146
	1-1/4 – 11-1/2	.420	91148	91150
1-1/2 – 11-1/2	.420	91152	91154	

# BALAX BAL-TAP "S" TAPPING FLUID

## FOR COLD FORMING AND CUTTING TAPS

Bal-Tap "S" contains space age additives to help you increase tapping speeds and reduce tap wear and breakage. The result? Increased productivity and improved thread quality.

Bal-Tap "S" is a non-hazardous, petroleum-based fluid, with a dark blue-green color and non-offensive odor. It is ideal for forming or cutting tap applications in all metals except; brass, bronze and copper.

### BAL-TAP "S" BENEFITS INCLUDE:

- Extended tap life
- Improved part surface finish
- Faster tapping speeds
- CFC Trichloroethane-free composition
- Adherence to the wall of the part for improved tap lubrication
- Maintains its EP film strength under extreme pressure and temperature
- Less cost than other tapping fluids

## FOR COLD FORMING TAPS

- First tapping fluid designed specifically for cold form tapping
- Performs especially well in harder materials, such as steel and stainless steel
- Reduces tapping torque and tap breakage

## FOR CUTTING TAPS

- Ideal for exotic and hard-to-machine materials where tapping torque exceeds tap strength
- Reduces cutting edge temperature and preserves cutting edge sharpness
- Reduces galling and tearing, leaving a smoother thread finish
- Improves thread gaging

### STOCK SIZES

SIZE	EDP #
PINT BOTTLE	00002
PINT BOTTLE CASE (12 PER CASE)	00003
GALLON BOTTLE CASE (4 PER CASE)	00006
5-GALLON PAIL	00004
55-GALLON DRUM*	00005

Contact Balax for a Material Data Safety Sheet.

\*55-Gallon Drums shipped via truck. Purchaser must have loading dock facilities.



# SURFACE TREATMENTS

SURFACE TREATMENT	THREDFOER TAPS		THREDSHAVER TAPS		THREAD GAGES	
	EDP SUFFIX	ADVANTAGE	EDP SUFFIX	ADVANTAGES	EDP SUFFIX	ADVANTAGES
<b>NITRIDE*</b>	1	Lubricity and Wear	1	Cutting Edge Wear	–	N/A
<b>STEAM OXIDE*</b>	2	Toughness and Lubricity	5	TOUGHNESS	–	N/A
<b>NITRIDE/STEAM OXIDE*</b>	6	Combined Properties	6	Combined Properties	–	N/A
<b>CHROME PLATE</b>	3	Lubricity	3	Lubricity	–	N/A
<b>NITRIDE CHROME PLATE</b>	7	Lubricity and Wear	–	N/A	–	N/A
<b>BALWEAR</b>	4	Recommended for Copper	4	N/A	–	N/A
<b>BALUBE</b>	5	Recommended for Brass	5	Lubricity	–	N/A
<b>TITANIUM NITRIDE</b>	T	Lubricity and Wear	T	Lubricity and Wear	T/G**	WEAR
<b>SUPER TIN</b>	U	Wear Resistance	–	N/A	–	N/A
<b>TITANIUM CARBONITRIDE</b>	C	Wear	C	Wear	–	N/A
<b>TITANIUM ALUMINUM NITRIDE</b>	A	Lubricity and Wear	A	Wear and Heat Resistance	–	N/A
<b>BAL-PLUS</b>	L	Anti-Galling and Wear	L	Lubricity	–	N/A

\* Not for shiny wrought aluminum, i.e. 6061T6, etc.

\*\*TiN coating on “GO” members of sets.

**Nitride** – Salt bath case hardening process to increase wear resistance. Resist “galling or pickup” when tapping mild steels. Provides abrasion resistance when tapping diecast alloys containing silicon.

**Steam Oxide** – Dark blue tool finish that increases the lubricity of the tool surface. May assist in lubricating deep hole tapping in ferrous materials. Sometimes called black oxide, is well suited for use with oil lubricants during cold form tapping. Steam oxide can be applied over a nitride surface.

**Hard Chrome Plate** – Bright shiny chrome plating provides lubricity and increased wear resistance. Used during tapping brass, aluminum, and other softer alloys to prevent pickup or galling.

**Balwear** – Special form of chrome plating that is used to resist “pickup” and abrasion during cold form tapping on pure or high copper content alloys.

**Balube** – Soft chromium deposition which serves a similar purpose as steam oxide in ferrous materials. On cold forming taps Balube can be applied over a nitride surface.

**Titanium Nitride (TiN)** – Shiny gold colored thin film coating formed in a low temperature physical vapor deposition process. Provides added lubricity for most cold forming applications using water soluble coolants. Adds wear resistance and lubricity for most cutting tap applications.

**Super Titanium Nitride (Super TiN)** – Multi-layer coating that improves the titanium nitride performance for very abrasive cold form tapping applications.

**Titanium Carbonitride (TiCN)** – Blue-gray colored thin film coating formed in a low temperature, physical vapor deposition process. May provide better wear resistance than TiN for cutting tap applications. Has higher surface hardness than titanium nitride, may lack lubricity necessary for some cold forming applications. Best used for extending cutting edge life in cutting taps.

**Titanium Aluminum Nitride (TiAlN)** – Violet-gray colored thin film coating formed in a low temperature, physical vapor deposition process. May provide added lubricity for cold forming taps when poor lubricity is encountered. May provide added lubricity and wear in cutting tap applications where heat generation is a problem.

**Bal-Plus** – Shiny gold colored thin-film coating that provides anti-galling and extra wear resistance when cold form tapping wrought aluminum such as 6061 and in most diecast aluminums. May provide added lubricity and wear in cutting applications where galling is a problem.

# BALAX – EDP ORDERING NUMBER SYSTEM

Balax part numbers consist of a five-digit number describing the basic tap and a three digit suffix that specifies the desired options.

**1 1 2 8 5**

### EDP NUMBER – 11285

Found in the tables.  
Describes the tap type, size,  
and H/D number

### THREDFLOER EXAMPLE:

**1 1 2 8 5 - 2 1 4**

6-32 Bottom H5 Thredfloer with  
2 grooves, front point removed,  
and Balwear surface treatment.

### THREDSHAVER EXAMPLE:

**5 4 7 1 5 - 0 1 C**

M8 X 1.25 BH5 Straight Flute  
Threshaver with front point  
removed and TiCN

### THREAD GAGE EXAMPLE:

**9 0 1 1 6 - 0 0 T**

6-32 2B Gage Set with TiN.

**2**

### THREDSHAVERS & GAGES

0 = Standard configuration.

### THREDFLOERS – 2

0 = Standard configuration.

6-32 or M3.5 and larger  
have one groove. Smaller  
taps have no grooves.

1 = 1 Groove (for taps smaller  
than 6-32 or M3.5)

2 = 2 Grooves

4 = 4 Grooves

6 = 1 Groove Per Relief

7 = Burr Bit grooves

8 = 2 Grooves (HP only)

9 = 1 Groove Per Relief  
(HP only).

**1**

### FRONT POINT – 1

0 = With Front point

1 = Front point removed

2 = Ettco Notch

4 = Rear and Front

points removed

B = Angular Outlets, Front  
point removed

C = Angular Outlets

H = Coolant-thru, Front

point removed

J = Coolant-thru

P = Individual Packages

Q = Individual Packages,  
Front point removed

R = Radial Outlets

S = Radial Outlets, Front  
point removed

W = Individual Packages,  
Coolant-thru

X = Individual Packages, FT PT  
removed, Coolant-thru

**4**

### SURFACE TREATMENT – 4

0 = Bright Finish

1 = Nitride

2 = Steam Oxide

3 = HardChrome

4 = Balwear

5 = Balube

6 = Nitride/Steam Oxide

7 = Nitride/HardChrome

A = Titanium Aluminum Nitride

C = Titanium Carbonitride

G = "GO" Element TiN Coated  
(Sets only)

L = Bal-Plus

N = Aluminum Chromium  
Nitride

R = CRN

S = Steam (Cut Tap)

T = Titanium Nitride

U = Super TiN

## FRONT POINTS

Standard on all tap blanks 3/8" (M10) and smaller. For some bottoming applications the front point helps center the tap in the hole and fits in the cone created by the drill at the bottom of the hole. For bottoming applications where clearance is a problem, Balax can remove front points when specified, free-of charge. Front points will be removed on all one-thread lead taps.



Front Point Not Removed



Front Point Removed

## VENT GROOVES

Standard on all #6 taps (M3.5) and larger. Vent grooves provide a lubrication path, and, for holes completely filled with lubricant, the groove prevents hydraulic locking and bottom blowout of weak bottomed diecastings. For deep hole tapping, extra vent grooves help distribute and increase the flow of lubricant to the tap. HP and DIN series come with the optimal # of grooves:



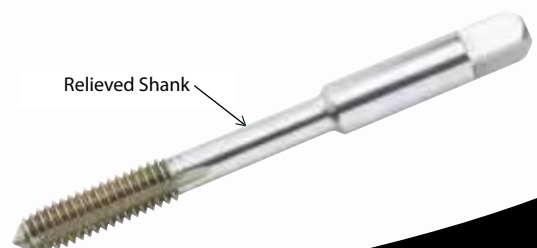
1-Groove Tap



4-Groove Tap

## RELIEVED SHANK TAPS

All taps 3/8" (M10) and smaller are made with the shank diameter larger than the major diameter of the tap. These taps are unable to tap beyond the basic thread length of the tap due to the diameter of the shank. Rather than purchasing a special tap, a stock male center forming tap may be economically modified by grinding a relieved shank to increase tapping depth. Consult with a Balax "Tapplication Engineer" for further information. Multiple grooves are recommended.



Relieved Shank

# THREDFLOER APPLICATION DATA

## MATERIAL TO BE TAPPED

Cold Form Tap use begins with an evaluation of the metal to be tapped. If you see a stringy chip while machining, then the material is an excellent Thredfloer candidate. If you see a very fine powdery chip, then the metal may be too brittle to be cold form tapped. Examples of proven Thredfloer applications include all materials listed in the "Suggested Treatments" chart below.

**Steels and stainless steels applications:** The ability to cold form steel and stainless steel successfully and with good tap life is related to the material hardness, tap size and thread pitch, and tap lubrication. In general, use the following guidelines for tapping feasibility and refer to the surface treatment/lubrication selector for the correct tap specification.

HARDNESS	SIZE/PITCH RESTRICTION
16 Rc AND SOFTER	1" and Smaller: 8 pitch and finer. Up to 1-1/2" / 10 pitch and finer.
17 - 23 Rc	1" and smaller: 10 pitch and finer
24 -35 Rc	Machine screw size and miniature taps only
30 - 35 Rc	with extreme care may work for miniature and small machine screw threads with 56 more threads per inch.

## SUGGESTED TREATMENTS FOR THREDFLOER APPLICATIONS

MATERIAL	SUGGESTED TREATMENTS	
	BEST	GOOD
WROUGHT ALUMINUM	Chrome or Bal-Plus	Bright Finish
DIECAST ALUMINUM	Bal-Plus or TiCN	Nitride, TiN
COPPER	Balwear or TiN	Bright Finish
MILD STEEL	TiN or TiCN	Nitride
300 STAINLESS STEEL	Super TiN	Nitride/Steam Oxide
HIGH CARBON STEEL	Nitride/Steam Oxide or TiCN	Nitride/Steam Oxide
LEADED STEEL	TiCN	Nitride/Steam Oxide
DIECAST ZINC	Chrome Plate	Bright Finish
TITANIUM	Nitride/Steam Oxide	Nitride/Steam Oxide
400 STAINLESS STEEL	Nitride/Steam Oxide	Nitride/Steam Oxide

## LUBRICATION

Cold forming taps create threads using a progressive cold working process that requires lubrication. Cutting oils are generally preferred because of their lubricity compared to water soluble coolants.

**Non-ferrous materials:** Water soluble coolants may be used, but at increased concentrations of 5:1 to 10:1 for added lubricity. Water soluble drawing oils may work because of their lubricity.

**Steels and stainless steels:** A high sulfur/high chlorine content tapping oil with fat additive is recommended. A cutting oil

with an "EP" or extreme pressure rated additive may also be satisfactory. In general, when tapping steels or stainless steels, a maximum "EP" rating for the tapping oil is desired.

Note that titanium nitride or super titanium nitride surface treatments may allow forming taps to work successfully in softer steels and stainless steels in conjunction with water soluble coolants possessing good lubricity characteristics.

# THREDFLOER APPLICATION DATA – CONTINUED

## SURFACE TREATMENT / LUBRICATION SELECTOR

Surface treatments and proper lubrication are very important and can have a major effect on tap life and threaded part quality. Use the following application guidelines to determine the correct treatment and lubricant for the material being tapped.

MATERIAL CATEGORY	MATERIAL TYPE	TAP TREATMENT	LUBRICATION RECOMMENDED
SOFT	Aluminum (plate or wrought material), Diecast Zinc, or wrought Brass	Bright finish for most application, or add hard chrome for tap wear and lubricity	Water soluble 5:1 or light tapping oil.
SOFT AND ABRASIVE	Diecast Aluminum	Nitride, Super TiN, or Bal-Plus	Water soluble 5:1 or light tapping oil.
	Copper	Balwear or Nitride/Balwear	
INTERMEDIATE HARDNESS	Mild Steel	Nitride or Super TiN	Extreme pressure rated tapping oil with high sulphur and high chlorine content. Balax has developed Bal-Tap "S", a specialized tapping oil, designed specifically for cold forming taps.
	300 Series Stainless	Nitride/Steam Oxide or Super TiN	
HARD MATERIALS	Alloyed Steels and 400 Series Stainless	Nitride/Steam Oxide or Super TiN	

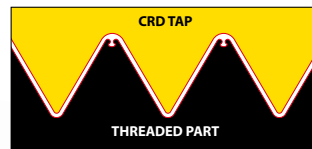
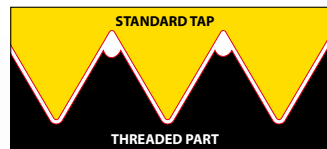
## CONTROL ROOT DIAMETER "CRD"

The root diameter of a forming tap may be ground to a specific size or diameter to serve several functions:

- Smooth or flatten the "U" shaped cup in the crest of the formed thread to reduce cross-threading.
- Smooth the crest of the thread to eliminate burrs or roughness and to improve the appearance of the thread.
- Size the after-tap minor diameter to a specific tolerance to minimize the effects of pre-tap hole size variations.
- Works best for thin walled stampings or diecast parts where some porosity is present.

The root diameter for a "CRD" Thredfloer Tap is calculated and carefully ground to a definite dimension to perform the burnishing or sizing of the thread crest. Most common application is to size the "CRD" for 65-75 percent thread height.

Consult with a Balax "Application Engineer" to confirm the intended use and specifications for any "CRD" taps you wish to purchase.



## DIECAST CORED HOLES

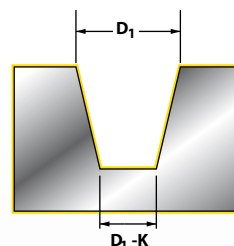
Diecast cored holes can be tapped directly with cold forming taps without the need for pre-tap drilling.

The procedure for determining core pin size is as follows:

1. Determine  $D_1$ , which is the diameter of the hole at the top, by selecting the 65 percent thread pre-tap hole size from the applicable Thredfloer hole size chart.
2. Determine the diameter of the hole at the bottom by subtracting the following constant "K" from the  $D_1$  hole size diameter at the top.

**Note:** The draft angle or core pin taper should be kept as straight as possible to provide uniform after-tap thread percentage. The above procedures will result in an after-tap hole with 65% thread at the top and 100% thread at the bottom.

TAP THREAD PITCH	"K" VALUE
10 TO 14 THREADS PER INCH	.012"
15 TO 25 THREADS PER INCH	.010"
26 THREADS PER INCH OR MORE, AND TAP SIZE #4 (M3) OR LARGER	.007"
26 THREADS PER INCH OR MORE, AND TAP SIZE SMALLER THAN #4 (M3)	.004"



$D_1$  = Hole diameter at top = 65% hole size from charts

$D_1 - K$  = Hole diameter at bottom

## SUGGESTED TAPPING SPEEDS

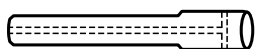
MATERIAL	SFM	TAPPING RPM																	
		#0 M1.6	#1	#2 M2	#3 M2.5	#4	#5 M3	#6 M3.5	#8 M4	#10 M5	#12	1/4 M6	5/16 M8	3/8 M10	7/16 M11	1/2 M12	5/8 M16	3/4 M18	1" M24
LOW CARBON STEEL	55	3503	2879	2444	2123	1877	1682	1523	1282	1106	973	841	674	561	481	420	336	280	210
MEDIUM CARBON STEEL	35	2229	1832	1555	1351	1194	1070	969	816	704	619	535	429	357	306	268	214	178	134
HIGH CARBON STEEL	10	637	524	444	386	341	306	277	233	201	177	153	122	102	87	76	61	51	38
CAST STEEL	25	1592	1309	1111	965	853	764	692	583	503	442	382	306	255	219	191	153	127	96
300 SERIES STAINLESS STEEL	20	1274	1047	889	772	682	611	554	466	402	354	306	245	204	175	153	122	102	76
400 SERIES STAINLESS STEEL	15	955	785	667	579	512	459	415	350	302	265	229	184	153	131	115	92	76	57
GREY CAST IRON	70	4459	3665	3111	2702	2389	2140	1939	1631	1408	1238	1070	857	713	612	535	428	357	268
DUCTILE CAST IRON	50	3185	2618	2222	1930	1706	1529	1385	1165	1006	885	764	612	510	437	382	306	255	191
ALLOY CAST IRON	40	2548	2094	1778	1544	1365	1223	1108	932	805	708	611	490	408	350	306	245	204	153
ALUMINUM CAST ALLOYS	60	3822	3141	2666	2316	2047	1834	1662	1398	1207	1062	917	735	611	525	459	367	306	229
ALUMINUM DIECAST ALLOYS	70	4459	3665	3111	2702	2389	2140	1939	1631	1408	1238	1070	857	713	612	535	428	357	268
ALUMINUM WROUGHT ALLOYS	80	5096	4188	3555	3088	2730	2446	2215	1864	1609	1415	1223	980	815	700	611	489	408	306
ZINC DIECASTINGS	80	5096	4188	3555	3088	2730	2446	2215	1864	1609	1415	1223	980	815	700	611	489	408	306
COPPER	60	3822	3141	2666	2316	2047	1834	1662	1398	1207	1062	917	735	611	525	459	367	306	229
BRASS, FREE MACHINING	60	3822	3141	2666	2316	2047	1834	1662	1398	1207	1062	917	735	611	525	459	367	306	229
CAST BRONZE	50	3185	2618	2222	1930	1706	1529	1385	1165	1006	885	764	612	510	437	382	306	255	191
NICKEL ALLOYS	10	637	524	444	386	341	306	277	233	201	177	153	122	102	87	76	61	51	38
TITANIUM ALLOYS	10	637	524	444	386	341	306	277	233	201	177	153	122	102	87	76	61	51	38
PLASTIC, THERMOSETTING	40	2548	2094	1778	1544	1365	1223	1108	932	805	708	611	490	408	350	306	245	204	153
PLASTIC, THERMOPLASTIC	80	5096	4188	3555	3088	2730	2446	2215	1864	1609	1415	1223	980	815	700	611	489	408	306

- Speeds are starting points for cold forming taps or for cutting taps in thru hole applications.
- Fine pitch cold forming taps less than 1/2" diameter may be run faster in soft material with good lubrication. Increase tapping RPM gradually until tap heat buildup due to lubrication failure begins to occur.
- For cutting taps in blind holes, reduce RPM by 25% to 50%.
- Tap Feed Rate = Tap RPM x Tap Pitch (Displacement/Revolution)  
 Example: 1/4-28 Tap @ 1000 RPM  
 Feed Rate = 1000 Rev/Min. x 1/28 Inch/Rev) = 35.71 in/Min  
 Example: M6 x 1.0 Tap @ 1000 RPM  
 Feed Rate = 1000 Rev/Min. x 1.0 mm/Rev) = 1000 mm/Min

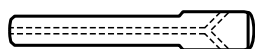
## COOLANT-THRU TAPS



**THRU - COOLANT**



**RADIAL - COOLANT**



**ANGULAR - COOLANT**



### FAST DELIVERY ON STANDARD COOLANT-THRU TAPS

Using Balax's EDM process, almost any standard Thredshaver or Thredfloer tap can be modified into the coolant-thru tap style of your choice: thru-coolant, radial coolant, or angular coolant. It's economical and turn-around time is fast.

### SPECIAL COOLANT-THRU TAPS FOR CUSTOM APPLICATIONS

For processes requiring an engineered special coolant-thru tap, custom tap blanks are made with coolant-thru holes in the style best suited for the tapping application.



# TECHNICAL FORMULAS

## THREAD PERCENTAGE CALCULATIONS

The following formulas can be used to calculate thread percentages in tapped holes for the following conditions.

1. Cold formed threads: The after-tap minor diameter is created by the relationship between the pre-tap hole size and the cold forming tap "D" or "H" number, and is measured using cylindrical pin gages or other means.
2. Cut threads: The after-tap minor diameter is created directly by the drill and is measured using cylindrical pin gages or other means.

### MACHINE SCREW & FRACTIONAL SIZES

$$\text{Thread Percentage} = \frac{(\text{Thread Major Diameter [in.]} - \text{Minor Diameter [in.]})}{.01299} \times \text{TPI}$$

**EXAMPLE:** 1/4-20 thread with .201 inch minor diameter.

$$\text{Thread Percentage} = \frac{(.250 - .201)}{.01299} \times 20 = 75.44\%$$

### MACHINE SCREW MAJOR DIAMETERS

MACHINE SCREW #	0	1	2	3	4	5	6	8	10	12
MAJOR DIAMETER (in)	.060	.073	.086	.099	.112	.125	.138	.164	.190	.216

### METRIC SIZES

$$\text{Thread Percentage} = \frac{(\text{Thread Major Diameter [mm]} - \text{Minor Diameter [mm]})}{.01299 \times \text{Thread Pitch [mm]}}$$

Example: M8 x 1.25 with 6.80 mm minor diameter.

$$\text{Thread Percentage} = \frac{(8.0 - 6.80)}{.01299 \times 1.25} = 73.90\%$$

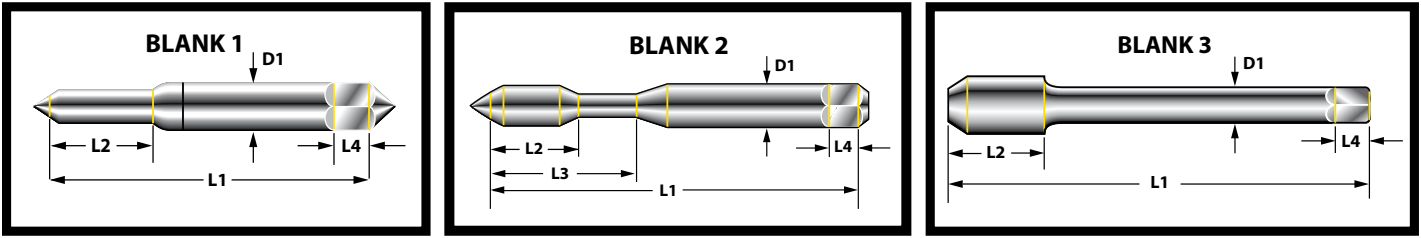
## HOW TO ADJUST FOR PLATING THICKNESSES

Standard cold forming or cutting tap "H" or "D" numbers must be increased to accommodate for the coating thickness. Platings or coatings that are very thick are not always uniformly applied to the threads and may cause gaging problems

regardless of the tap oversize condition. Heavy plating or coating thicknesses are especially difficult for fine pitch threads because they tend to fill in the thread profile rather than coat the thread flanks evenly.

INCHES	MILS	MICRONS	NUMBER OF "H" OR "D" NUMBERS TO ADD TO STANDARD TAP SELECTION
0.000125	0.125	3.2	1
0.000250	0.250	6.4	2
0.000375	0.375	9.5	3
0.000500	0.500	12.7	4
0.000625	0.625	15.9	5
0.000750	0.750	19.1	6
0.000875	0.875	22.2	7
0.001000	1.000	25.4	8

# ANSI CNC TAP BLANK DIMENSIONS



DIMENSIONS ARE FROM TABLE 302 of MCTI TAP STANDARDS

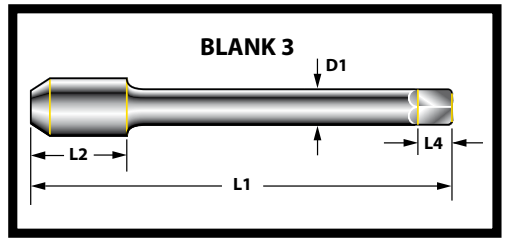
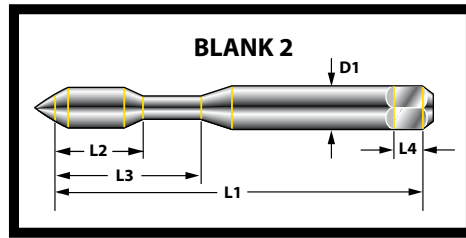
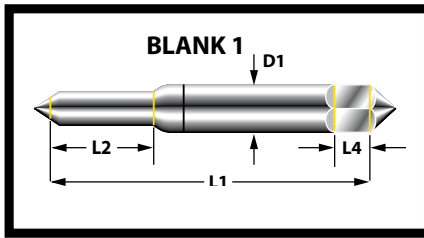
AMERICAN SIZE	METRIC SIZE	BLANK	LENGTH			SHANK D1 (in.)	SQUARE	
			L1 (in.)	L2 (in.)	L3 (in.)		(in.)	L4 (in.)
000	M.7, M.8	1	1-5/8	.190	-	.141	.110	3/16
00	M.9 -M1.2	1	1-5/8	.250	-	.141	.110	3/16
0	M1.4, M1.7	1	1-5/8	.312	-	.141	.110	3/16
1	-	1	1-11/16	.375	-	.141	.110	3/16
2	M2.0	1	1-3/4	.438	-	.141	.110	3/16
3	M2.5	1	1-13/16	.500	-	.141	.110	3/16
4	-	1	1-7/8	.563	-	.141	.110	3/16
5	M3.0	1	1-15/16	.626	-	.141	.110	3/16
6	M3.5	2	2	.450	11/16	.141	.110	3/16
8	M4.0	2	2-1/8	.470	3/4	.168	.131	1/4
10	M5.0	2	2-3/8	.600	7/8	.194	.152	1/4
12	-	2	2-3/8	.620	15/16	.220	.165	9/32
1/4	M6.0	2	2-1/2	.790	1	.255	.191	5/16
5/16	M8.0	2	2-23/32	.880	1-1/8	.318	.238	3/8
3/8	M10	2	2-15/16	.950	1-1/4	.381	.286	7/16
7/16	M11	3	3-5/32	.950	-	.323	.242	13/32
1/2	M12	3	3-3/8	1	-	.367	.275	7/16
9/16	M14	3	3-19/32	1	-	.429	.322	1/2
5/8	M16	3	3-13/16	1	-	.480	.360	9/16
11/16	M18	3	4-1/32	1	-	.542	.406	5/8
3/4	-	3	4-1/4	1	-	.590	.442	11/16
13/16	M20	3	4-15/32	1	-	.652	.489	11/16
7/8	M22	3	4-11/16	1	-	.697	.523	3/4
15/16	M24	3	4-29/32	1	-	.760	.570	3/4
1	-	3	5-1/8	1	-	.800	.600	13/16

# STANDARD PIPE TAP BLANK DIMENSIONS

DIMENSIONS ARE FROM TABLE 311 OF MCTI TAP STANDARDS

SIZE	BLANK	LENGTH		SHANK D1 (in.)	SQUARE	
		L1 (in.)	L2 (in.)		(in.)	L4 (in.)
1/16	1	2-1/8	.687	.3125	.234	3/8
1/8	3	2-1/8	.750	.3125	.234	3/8
1/8	1	2-1/8	.750	.4375	.328	3/8
1/4	1	2-7/16	1.062	.5625	.421	7/16
3/8	1	2-9/16	1.062	.7000	.531	1/2
1/2	3	3-1/8	1.375	.6875	.515	5/8
3/4	3	3-1/4	1.375	.9063	.679	11/16
1	3	3-3/4	1.750	1.1250	.843	13/16

# DIN, JIS, AND INLINE TAP BLANK DIMENSIONS



## DIN DIMENSIONS

METRIC SIZE	DIN STYLE	BLANK	LENGTH			SHANK D1 (mm)	SQUARE	
			L1 (mm)	L2 (mm)	L3 (mm)		(mm)	L4 (mm)
M1.6, M1.7	371	1	40	8	-	2.5	2.1	5
M2.0	371	1	45	8	-	2.8	2.1	5
M2.2	371	1	45	9	-	2.8	2.1	5
M2.5	371	1	50	9	-	2.8	2.1	5
M3.0	371	2	56	10	18	3.5	2.7	6
M3.5	371	2	56	10	18	4	3	6
M4.0	371	2	63	12	21	4.5	3.4	6
M5.0	371	2	70	14	25	6	4.9	8
M6.0	371	2	80	16	30	6	4.9	8
M8.0	371	2	90	18	35	8	6.2	9
M10	371	2	100	20	39	10	8	11
M12	371	2	110	22	40	12	9	12
M12	376	3	110	27	-	9	7	10
M14	376	3	110	22	-	11	9	12
M16	376	3	110	22	-	12	9	12
M18	376	3	125	25	-	14	11	14
M20	376	3	140	27	-	16	12	15
M22	376	3	140	27	-	18	14.5	17
M24	376	3	160	27	-	18	14.5	17

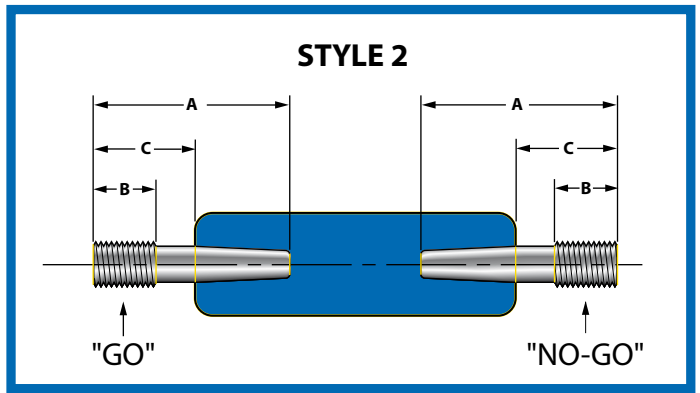
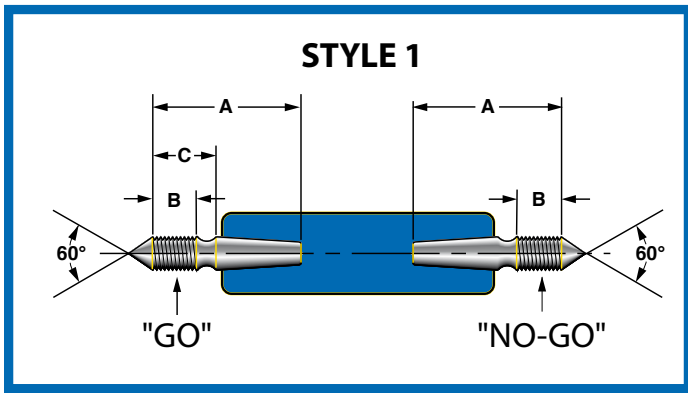
## JIS DIMENSIONS

AMERICAN SIZE	METRIC SIZE	BLANK	LENGTH		SHANK D1 (mm)	SQUARE	
			L1 (mm)	L2 (mm)		(mm)	L4 (mm)
0	M1.6, M1.7	1	36	8	3	2.5	5
1	M2.0	1	40	9	3	2.5	5
2	M2.2	1	42	10	3	2.5	5
4	M2.5	1	44	11	3	2.5	5
-	M3.0	1	46	18	4	3.2	6
6	M3.5	1	48	18	4	3.2	6
8	M4.0	1	52	20	5	4	7
10	M5.0	1	60	22	5.5	4.5	7
1/4	M6.0	1	62	24	6	4.5	7
5/16	M8.0	3	70	20	6.2	5	8
-	M10	3	75	22	7	5.5	8
-	M12	3	82	30	8.5	6.5	9

## INLINE DIMENSIONS

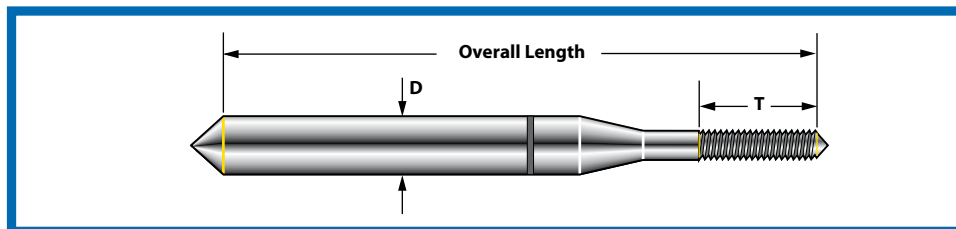
AMERICAN SIZE	METRIC SIZE	BLANK	LENGTH		SHANK D1 (mm)	SQUARE	
			L1 (in.)	L2 (in.)		(in.)	L4 (in.)
#2 - #8	M2 - M4	1	.850	.300	.141	.110	1/4
#10 - #12	M5	3	.850	.300	.141	.110	1/4
1/4	M6.0	3	.930	.370	.194	.152	1/4

# TAPERLOCK GAGE BLANK DIMENSIONS



GAGE STYLE	HANDLE SIZE #	AMERICAN SIZE	METRIC SIZE	"GO" GAGE			"NO-GO" GAGE		
				A	B	C	A	B	C
1	000	0, 1, 2, 3	M1.6 TO M2.6	15/16	1/4	-	7/8	3/16	-
1	00	4	-	1-5/16	5/16	9/16	31/32	7/32	-
1	00	5, 6	M3.0 TO M3.5	1-7/16	5/16	11/16	31/32	7/32	-
2	0	8	M4.0	1-5/8	13/32	3/4	1-5/32	9/32	17/32
2	0	10	M5.0	1-3/4	13/32	7/8	1-5/32	9/32	17/32
2	0	12	-	1-13/16	13/32	15/16	1-5/32	5/16	17/32
2	1	1/4	M6.0	1-3/4	1/2	1	1-5/16	5/16	9/16
2	1	5/16	M8.0	1-7/8	1/2	1-1/8	1-5/16	5/16	9/16
2	2	3/8	M10	2	3/4	1-1/4	1-3/8	3/8	5/8
2	2	7/16	-	2-3/16	3/4	1-7/16	1-3/8	3/8	5/8
2	2	1/2	M12	2-13/32	3/4	1-21/32	1-3/8	3/8	5/8
2	3	9/16	M14	2-13/32	7/8	1-21/32	1-1/2	1/2	3/4
2	3	5/8	M16	2-9/16	7/8	1-13/16	1-1/2	1/2	3/4
2	3	11/16, 3/4, 13/16	M18, M20	2-3/4	7/8	2	1-1/2	1/2	3/4
2	4	7/8	M22	3-3/32	1	2-7/32	1-13/16	5/8	15/16
2	4	15/16, 1"	M24	3-3/8	1	2-1/2	1-13/16	5/8	15/16

# MINIATURE GAGE BLANK DIMENSIONS



AMERICAN SIZE	METRIC SIZE	OVERALL LENGTH	D: SHANK DIAMETER	T: THREAD LENGTH	
				"GO" GAGE	"NO-GO" GAGE
000-120	.90 UNM	1-5/8	.141	1/8	1/16
00-96	1.0 UNM	1-5/8	.141	5/32	1/16
00-90	1.10 UNM				
	1.20 UNM				
	1.40 UNM				

# THREDFLOER HOLE SIZE AND CLASS OF FIT

The following table gives the hole size for three thread percentages when used with the recommended "H" or "D" numbers. The largest "H" or "D" numbers will place the finished thread pitch diameter .0005 to .0010 under the "NO-GO" P.D. limit. They will also provide the longest tap life before the tap wears under size. For a slightly tighter fit, the smaller recommended "H" or "D" numbers may be used.



## THREDFLOERS – MACHINE SCREW AND FRACTIONAL SIZE

SIZE	THREADS PER INCH		HOLE SIZES REQUIRED FOR:			TAP DRILL SIZE (65% THREAD)	"H" NUMBER PER CLASS OF FIT			STOCK "H" NUMBER
	NC UNC	NF UNF	75% THREAD	65% THREAD	55% THREAD		2B	3B	2	
000		120	.0303	.0307	.0311	#68	-	-	-	2
00	90	96	.0417	.0422	.0426	#58	-	-	-	2
			.0420	.0425	.0430	#58	-	-	-	
0		80	.0546	.0552	.0558	#54 OR 1.4 mm*	3, 2	2	2	2, 3, 4, 5, 6, 7
1	64	72	.066	.067	.068	#51 OR 1.7 mm	4, 3	3, 2	3, 2	
			.067	.068	.069	#51 OR 1.75 mm	4, 3	3, 2	3, 2	
2	56	64	.078	.079	.080	#47 OR 2.0 mm	4, 3	3, 2	3, 2	
			.079	.080	.081	2.0 mm*	4, 3	3, 2	3, 2	
3	48	56	.090	.091	.092	2.3 mm*	5, 4	3, 2	3, 2	
			.091	.092	.093	2.3 mm*	5, 4	3, 2	3, 2	
4	40	48	.100	.101	.103	#39	5, 4	4, 3	4, 3	
			.103	.104	.105	#37	5, 4	4, 3	3, 2	
5	40	44	.113	.114	.116	#33 OR 2.9 mm	5, 4	4, 3	4, 3	
			.114	.115	.117	#33 OR 2.9 mm	5, 4	4, 3	4, 3	
6	32	40	.124	.125	.126	3.1 mm	6, 5	4, 3	5, 4	
			.126	.127	.128	1/8" OR 3.2 mm*	5, 4	4, 3	4, 3	
8	32	36	.149	.150	.152	#25 OR 3.8 mm	6, 5	4, 3	4, 3	
			.151	.152	.153	#24	5, 4	4, 3	3, 2	
10	24	32	.170	.172	.174	11/64"	7, 6, 5	5, 4	5, 4	
			.175	.176	.178	#16 OR .176**	6, 5	4, 3	4, 3	
12	24	28	.196	.198	.200	#9 OR 5.0 mm	7, 6, 5	5, 4	5, 4	
			.199	.201	.203	#7 OR 5.1 mm	7, 6, 5	4, 3	4, 3	
1/4"	20	28	.225	.227	.230	5.75 mm*	8, 7, 6	5, 4	5, 4	
			.233	.235	.237	"A"	7, 6, 5	5, 4	4, 3	
5/16"	18	24	.285	.287	.291	7.25 mm*	9, 8, 7	6, 5	6, 5	
			.292	.294	.297	.293**	8, 7, 6	5, 4	5, 4	
3/8"	16	24	.344	.347	.350	"S" OR 11/32"	9, 8, 7	7, 6	7, 6	
			.355	.357	.359	9.0 mm*	8, 7, 6	6, 5	5, 4	
7/16"	14	20	.402	.405	.409	"Y"	10, 9, 8	7, 6	8, 7, 6	
			.414	.416	.418	"Z" OR 10.5 mm*	9, 8, 7	6, 5	5, 4	
1/2"	13	20	.462	.466	.470	.463**	11, 10, 9	8, 7, 6	8, 7, 6	
			.475	.477	.480	.476**	9, 8, 7	6, 5	5, 4	
9/16"	12	18	.520	.524	.528	.521**	11, 10, 9	8, 7, 6	9, 8, 7	
			.535	.537	.540	.536**	9, 8, 7	7, 6, 5	7, 6, 5	
5/8"	11	18	.579	.583	.586	37/64"	12, 11, 10	9, 8, 7	9, 8, 7	
			.598	.600	.603	.598**	10, 9, 8	7, 6, 5	7, 6, 5	
3/4"	10	16	.700	.704	.709	45/64"	13, 12, 11	9, 8, 7	11, 10, 9	
			.720	.723	.726	23/32"	11, 10, 9	8, 7, 6	7, 6, 5	
7/8"	9	14	.818	.823	.829	.823"	14, 13, 12	10, 9, 8	12, 11, 10	
			.839	.843	.845	27/32"	12, 11, 10	9, 8, 7	8, 7, 6	
1"	8	12	.935	.942	.948	15/16"	14, 13, 12	11, 10, 9	13, 12, 11	
			.959	.963	.967	.963"	13, 12, 11	10, 9, 8	10, 9, 8	

NOTE: Drill Sizes were selected wherever possible to produce approximately 65% thread. The drills marked \* are stocked by Balax.

TECHNICAL INFO  
HOLE SIZE

# THREDFLOER HOLE SIZE AND CLASS OF FIT – CONTINUED

## THREDFLOERS – METRIC

SIZE	HOLE SIZES REQUIRED FOR 6H TOLERANCE			TAP DRILL SIZE	HOLE SIZES REQUIRED FOR 4H TOLERANCE			TAP DRILL SIZE	STOCK "D" NUMBER PER CLASS OF FIT	
	75% THREAD	65% THREAD	55% THREAD		75% THREAD	65% THREAD	55% THREAD		6H TOLERANCE	4H TOLERANCE
M1.6 X .35	.057	.058	.059	1.45 mm	.056	.057	.058	#54	D5	D3
M1.7 X .35	.061	.062	.063	1.55 mm	.060	.061	.062	#53	D5	D3
M2 X .4	.072	.073	.074	1.85 mm	.071	.072	.073	1.80 mm	D5	D3
M2.5 X .45	.091	.092	.093	2.30 mm	.089	.090	.091	#43	D6	D3
M2.6 X .45	.095	.096	.097	2.40 mm	.093	.094	.095	2.35 mm	D6	D3
M3 X .5	.110	.111	.112	#35	.108	.109	.110	2.75 mm	D6	D3
M3.5 X .6	.128	.129	.130	#30	.126	.127	.128	3.2 mm	D7	D4
M4 X .7	.145	.146	.148	3.7 mm	.144	.145	.147	#27	D7	D4
M5 X .8	.183	.184	.185	#14	.181	.182	.184	4.6 mm	D8	D4
M6 X 1	.218	.220	.222	5.5 mm	.216	.218	.220	5.5 mm	D9	D5
M8 X 1.25	.291	.294	.296	7.4 mm	.289	.291	.294	7.3 mm	D10	D5
M10 X 1	.375	.377	.379	9.5 mm	.373	.375	.377	9.5 mm	D9	D5
M10 X 1.25	.370	.373	.375	9.4 mm	.368	.370	.373	9.3 mm	D10	D5
M10 X 1.5	.365	.368	.371	9.3 mm	.362	.365	.368	9.2 mm	D11	D6
M12 X 1.75	.439	.442	.446	7/16"	.436	.439	.443	11.0 mm	D12	D6
M14 X 1.25	.527	.530	.532	13.4 mm	.525	.528	.530	13.3 mm	D10	D5
M14 X 1.5	.522	.525	.528	13.3 mm	.519	.522	.525	13.2 mm	D11	D6
M14 X 2	.512	.516	.520	13.0 mm	.509	.513	.517	12.9 mm	D14	D7
M16 X 1.5	.601	.604	.607	15.3 mm	.598	.601	.604	15.2 mm	D11	D6
M16 X 2	.591	.595	.599	15.0 mm	.588	.592	.596	14.9 mm	D14	D7
M18 X 1.5	.680	.683	.686	17.3 mm	.677	.680	.683	17.2 mm	D11	D6

## STI THREDFLOERS – MACHINE SCREW AND FRACTIONAL SIZE

STI THREAD SIZE	HOLE SIZES REQUIRED FOR				TAP DRILL SIZE	"H" NUMBER PER CLASS OF FIT		BLANK SIZE
	85% THREAD	75% THREAD	65% THREAD	55% THREAD		2B	3B	
1-64	.0849	.0854	.0862	.0870	#44	2	2	#3
2-56	.099	.100	.101	.102	#39	2	2	#5
4-40	.130	.131	.132	.134	3.3 mm	3, 2	2	#8
6-32	.161	.162	.163	.165	4.1 mm	3, 2	2	#10
8-32	.187	.188	.189	.191	3/16	3, 2	2	#12
10-24	.221	.222	.224	.226	#2	4, 3	3, 2	1/4"
10-32	.213	.214	.215	.217	#3	4, 3	3, 2	1/4"
1/4-20	.287	.288	.290	.293	7.3 mm	4, 3	3, 2	5/16"
1/4-28	.276	.278	.279	.281	J	4, 3	3, 2	5/16"
5/16-18	.353	.355	.357	.360	9.0 mm	5, 4	4, 3	7/16"
5/16-24	.343	.344	.347	.349	8.8 mm	5, 4	4, 3	3/8"
3/8-16	.420	.422	.425	.428	27/64"	5, 4	4, 3	1/2"
3/8-24	.406	.407	.409	.411	11/32"	5, 4	4, 3	1/2"

## STI THREDFLOERS – METRIC

STI THREAD SIZE	HOLE SIZES REQUIRED FOR				TAP DRILL SIZE	"D" NUMBER PER CLASS OF FIT		BLANK SIZE
	85% THREAD	75% THREAD	65% THREAD	55% THREAD		5H	4H	
M2 X .4	.091	.091	.092	.093	2.3 mm	D3	D2	#4
M2.5 X .45	.112	.112	.113	.114	#34	D3	D2	#5
M3 X .5	.133	.133	.134	.135	3.4 mm	D3	D2	#8
M3.5 X .6	.156	.157	.158	.159	#22	D4	D3	#10
M4 X .7	.178	.179	.180	.182	#15	D4	D3	#10
M5 X .8	.220	.221	.223	.225	#2	D4	D3	1/4"
M6 X 1.0	.266	.267	.269	.271	6.8 mm	D5	D4	5/16"
M8 X 1.25	.352	.353	.355	.358	9 mm	D6	D5	3/8"
M10 X 1.5	.438	.439	.442	.445	7/16"	D6	D5	1/2"

# IMPORTANT NOTES ON THREDFLOER PRE-TAP HOLE SIZES

## DETERMINING DRILL SIZE

Thread forming taps require a larger pre-tap hole size than cutting taps because they do not produce a chip during tapping. The pre-tap hole size tolerance for smaller fine-pitch taps must be controlled more closely to prevent after-tap minor diameter problems.

Finding the correct drill size for a Thredfloer Tap may be a "Cut and Try" process. Not all drills are alike and therefore the pre-tap holes produced by different drills may be vastly different. What

matters is the actual pre-tap hole size, how consistently this hole size is maintained, and finally, the after-tap thread percentage or minor diameter. To get good results, you must know the actual hole size and not just the drill size! Thin wall parts may expand during tapping and produce oversize after-tap minor diameters. Diecast parts may contain porosity which may cause oversize holes due to shrinkage.

## THREAD INSPECTION PROCEDURES

**Pitch Diameter:** The easy part is getting the "GO" and "NO-GO" thread gages, which check pitch diameter, to work correctly. As a rule of thumb, Thredfloer Taps should be two to three "H" or "D" numbers larger than cutting taps in order to gage correctly. Threads that are tight or loose after tapping can be rectified by increasing or decreasing tap pitch diameter ("H" or "D" number).

**Minor Diameter:** The most common problem is thread percentage. Unless otherwise specified, acceptance criteria are the minimum and maximum minor diameters for various thread sizes and classes of fit, as published by the ANSI Standards. These measurements are checked with cylindrical plug gages. It is important that these criteria be inspected during the initial "Testing" stage of drilling and tapping. Failure to check minor diameters may be very expensive.

It is often possible to fine tune the after-tap minor diameter by varying the tap pitch diameter. Changing a Thredfloer Tap by one "H" or "D" number is the same as changing the drill size by .0005 inches. For example, if the after tap minor diameter is too large, it may be reduced by using a larger tap pitch diameter, providing the no-go gage doesn't pass the part.

**Example:** A 1/4-20 Class 2B minor diameter should be .196/.207 inches. After tapping with an H5 tap, the part measured .205/.206", which is almost oversize. By switching to an H7 tap, you can reduce the after-tap minor diameter to .202/.203".

### Suggested Procedure for Using a Thredfloer Tap

1. Test drill a part and measure the pre-tap hole size.
2. Test tap the part. Check pitch diameter with go and no-go gages. Check the thread percentage or minor diameter against the customer requirement.
3. Establish a maximum condition for the pre-tap hole size and monitor this frequently during the production tap run.

## VISUAL THREAD INSPECTION

All formed threads have a cup or "U" in the crest due to the nature of the thread forming process. A properly sized hole should result in a thread percentage of 65-75%. Tapping with too small of a pre-tap hole size results in excessive tapping torque, tap wear, and possible tap breakage.

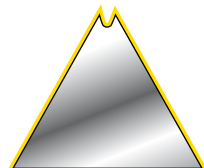
Always check your hole size after drilling. Do Not expect the drill will cut the size hole marked on the drill. Use a drill that will produce a 75% hole size where after-tap minor diameter gaging to 2B or 3B tolerances is required.

**Correct Hole**



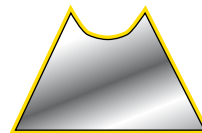
Pre-tap hole size is correct. Thread percentage is 65-75%, and the after-tap minor diameter is in specification.

**Too Small**



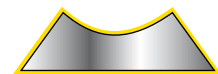
Resulting in a high thread percentage (90-100%) and an after-tap minor diameter which is too small.

**Large**



Suitable for some applications. Thread percentage is 55%. After-tap minor diameter is too large for 2B and 3B tolerances.

**Too Large**



Resulting in a low thread percentage (40%) and an after-tap minor diameter which is too big.

# THREDSHAVER CUTTING TAP DRILL SIZES

## THREDSHAVERS – MACHINE SCREW AND FRACTIONAL

SIZE	THEORETICAL HOLE SIZES FOR				CLASS 2B				CLASS 3B				UNJ3B			
	85% THREAD	75% THREAD	65% THREAD	55% THREAD	MINOR DIAMETER		RECOMMENDED DRILL SIZE		MINOR DIAMETER		RECOMMENDED DRIELL SIZE		MINOR DIAMETER		RECOMMENDED DRIELL SIZE	
					MIN	MAX			MIN	MAX			MIN	MAX		
0-80	.046	.048	.049	.051	.0465	.0514	3/64" (.0469)	.0465	.0514	3/64" (.0469)	.0479	.0511	1.25mm (.0492)			
1-64	.056	.058	.060	.062	.0561	.0623	#53 (.0595)	.0561	.0623	#53 (.0595)	.0578	.0619	#53 (.0595)			
1-72	.058	.059	.061	.063	.0580	.0635	#53 (.0595)	.0580	.0635	#53 (.0595)	.0595	.0631	1.55mm (.061)			
2-56	.066	.069	.071	.073	.0667	.0737	#50 (.070)	.0667	.0737	#50 (.070)	.0686	.0732	#50 (.070)			
2-64	.069	.071	.073	.075	.0691	.0753	#50 (.070)	.0691	.0753	#50 (.070)	.0708	.0749	#49 (.073)			
3-48	.076	.079	.081	.084	.0764	.0845	#47 (.0785)	.0764	.0845	#47 (.0785)	.0787	.0841	#45 (.082)			
3-56	.079	.082	.084	.086	.0797	.0865	#45 (.082)	.0797	.0865	#45 (.082)	.0816	.0862	2.15mm (.0846)			
4-40	.084	.088	.091	.094	.0849	.0939	#43 (.089)	.0849	.0939	#43 (.089)	.0877	.0942	2.35mm (.0925)			
4-48	.089	.092	.094	.097	.0894	.0968	#42 (.0935)	.0894	.0968	#42 (.0935)	.0917	.0971	3/32" (.0938)			
5-40	.097	.101	.104	.107	.0979	.1062	#38 (.1015)	.0979	.1062	#38 (.1015)	.1007	.1072	#37 (.104)			
5-44	.100	.103	.106	.109	.1004	.1079	#37 (.104)	.1004	.1079	#37 (.104)	.1029	.1088	#36 (.1065)			
6-32	.103	.108	.112	.116	.104	.114	#35 (.110)	.1040	.1140	#35 (.110)	.1076	.1157	#33 (.113)			
6-40	.110	.114	.117	.120	.111	.119	#33 (.113)	.1110	.1186	#33 (.113)	.1137	.1202	#32 (.116)			
8-32	.129	.134	.138	.142	.130	.139	#29 (.136)	.1300	.1389	#29 (.136)	.1336	.1417	#29 (.136)			
8-36	.133	.137	.141	.144	.134	.142	#29 (.136)	.1340	.1416	#29 (.136)	.1370	.1442	#28 (.1405)			
10-24	.144	.149	.155	.160	.145	.156	#24 (.152)	.1450	.1555	#24 (.152)	.1494	.1600	#23 (.154)			
10-32	.155	.160	.164	.168	.156	.164	#20 (.161)	.1560	.1641	#20 (.161)	.1596	.1675	#20 (.161)			
12-24	.170	.175	.181	.186	.171	.181	#16 (.177)	.1710	.1807	#16 (.177)	.1754	.1852	#15 (.180)			
12-28	.177	.181	.186	.190	.177	.186	#14 (.182)	.1770	.1857	#14 (.182)	.1812	.1896	#13 (.185)			
1/4-20	.195	.201	.208	.214	.196	.207	13/64" (.2031)	.1960	.2067	13/64" (.2031)	.2013	.2121	#5 (.2055)			
1/4-28	.211	.215	.220	.224	.211	.220	5.5mm (.2165)	.2110	.2190	5.5mm (.2165)	.2152	.2229	7/32" (.2188)			
5/16-18	.251	.258	.266	.273	.252	.265	G (.261)	.2520	.2630	F (.257)	.2584	.2690	G (.261)			
5/16-24	.266	.272	.277	.283	.267	.277	I (.272)	.2670	.2754	I (.272)	.2719	.2799	I (.272)			
3/8-16	.306	.314	.322	.330	.307	.321	O (.316)	.3070	.3182	5/16" (.3125)	.3141	.3250	O (.316)			
3/8-24	.329	.334	.340	.345	.330	.340	Q (.332)	.3300	.3372	Q (.332)	.3344	.3417	8.5mm (.3346)			
7/16-14	.359	.368	.377	.386	.360	.376	U (.368)	.3600	.3717	U (.368)	.3680	.3795	3/8" (.375)			
7/16-20	.382	.389	.395	.402	.383	.395	25/64" (.3906)	.3830	.3916	W (.386)	.3888	.3970	25/64" (.3906)			
1/2-13	.415	.425	.435	.445	.417	.434	27/64" (.4219)	.4170	.4284	27/64" (.4219)	.4251	.4368	11mm (.433)			
1/2-20	.445	.451	.458	.464	.446	.457	29/64" (.4531)	.4460	.4537	11.4mm (.4488)	.4513	.4591	29/64" (.4531)			
9/16-12	.470	.481	.492	.503	.472	.490	31/64" (.4844)	.4720	.4843	12.1mm (.4763)	.4814	.4914	31/64" (.4844)			
9/16-18	.501	.508	.516	.523	.502	.515	13mm (.5118)	.5020	.5106	12.9mm (.5079)	.5084	.5166	33/64" (.5156)			
5/8-11	.525	.536	.548	.560	.527	.546	17/32" (.5312)	.5270	.5391	17/32" (.5312)	.5365	.5474	13.7mm (.5394)			
5/8-18	.564	.571	.578	.585	.565	.578	14.5mm (.5709)	.5650	.5730	14.5mm (.5709)	.5709	.5788	14.5mm (.5709)			
3/4-10	.639	.652	.665	.678	.642	.663	21/32" (.6562)	.6420	.6545	16.5mm (.6496)	.6526	.6646	21/32" (.6562)			
3/4-16	.681	.689	.697	.705	.682	.696	11/16" (.6875)	.6820	.6908	11/16" (.6875)	.6892	.6977	17.5mm (.689)			
7/8-9	.752	.767	.781	.796	.755	.778	49/64" (.7656)	.7550	.7681	49/64" (.7656)	.7668	.7801	19.6mm (.7716)			
7/8-14	.796	.805	.815	.824	.798	.814	13/16" (.8125)	.7980	.8068	2.4mm (.8031)	.8055	.8152	13/16" (.8125)			
1-8	.862	.878	.894	.911	.865	.890	7/8" (.875)	.8650	.8797	7/8" (.875)	.8783	.8933	57/64" (.8906)			
1-12	.908	.919	.930	.940	.910	.928	59/64" (.9219)	.9100	.9198	23.2mm (.9134)	.9189	.9289	23.5mm (.9252)			



**THRESHAVERS – METRIC**

SIZE	THEORETICAL HOLE SIZES FOR				CLASS 6H						CLASS 4H					
	85% THREAD	75% THREAD	65% THREAD	55% THREAD	MINOR DIA. (mm)		MINOR DIA. (in.)		RECOMMENDED DRILL SIZE		MINOR DIA. (mm)		MINOR DIA. (in.)		RECOMMENDED DRILL SIZE	
M2 X 0.4	.061	.063	.065	.067	1.567	1.679	.0617	.0661	1.60mm	(.0630)	1.567	1.638	.0617	.0645	1/16"	(.0625)
M2.5 X 0.45	.079	.081	.083	.086	2.013	2.138	.0793	.0842	#45	(.0820)	2.013	2.093	.0793	.0824	2.05mm	(.0807)
M3 X 0.5	.096	.099	.101	.104	2.459	2.599	.0968	.1023	#39	(.0995)	2.459	2.549	.0968	.1004	#40	(.0980)
M3.5 X 0.6	.112	.115	.118	.121	2.850	3.010	.1122	.1185	2.9mm	(.1142)	2.850	2.950	.1122	.1161	#33	(.1130)
M4 X 0.7	.127	.131	.134	.138	3.242	3.422	.1276	.1347	3.3mm	(.1299)	3.242	3.354	.1276	.1320	#30	(.1285)
M5 X 0.8	.162	.166	.170	.174	4.134	4.334	.1628	.1706	#19	(.1660)	4.134	4.259	.1628	.1677	4.2mm	(.1654)
M6 X 1	.193	.198	.203	.208	4.917	5.153	.1936	.2029	5mm	(.1969)	4.917	5.067	.1936	.1995	#9	(.1960)
M8 X 1.25	.261	.267	.273	.280	6.647	6.912	.2617	.2721	H	(.2660)	6.647	6.817	.2617	.2684	17/64	(.2656)
M10 X 1.5	.328	.336	.344	.351	8.376	8.676	.3298	.3416	8.5mm	(.3346)	8.376	8.566	.3298	.3372	Q	(.3320)
M10 X 1.25	.339	.346	.352	.359	8.647	8.912	.3404	.3509	8.75mm	(.3445)	8.647	8.817	.3404	.3471	8.75mm	(.3445)
M12 X 1.75	.396	.405	.414	.423	10.106	10.441	.3979	.4111	13/32"	(.4063)	10.106	10.318	.3979	.4062	Y	(.4040)
M12 X 1.5	.407	.415	.423	.430	10.376	10.676	.4085	.4203	10.5mm	(.4134)	10.376	10.566	.4085	.4160	10.5mm	(.4134)
M12 X 1.25	.418	.424	.431	.437	10.647	10.912	.4192	.4296	10.75mm	(.4232)	10.647	10.817	.4192	.4259	10.75mm	(.4232)
M14 X 2	.464	.474	.485	.495	11.835	12.210	.4659	.4807	12mm	(.4724)	11.835	12.071	.4659	.4752	12mm	(.4724)
M14 X 1.5	.486	.494	.501	.509	12.376	12.676	.4872	.4991	12.5mm	(.4921)	12.376	12.566	.4872	.4947	12.5mm	(.4921)
M16 X 2	.543	.553	.563	.574	13.835	14.210	.5447	.5594	14mm	(.5512)	13.835	14.071	.5447	.5540	14mm	(.5512)
M16 X 1.5	.565	.572	.580	.588	14.376	14.676	.5660	.5778	14.5mm	(.5709)	14.376	14.566	.5660	.5735	14.5mm	(.5709)
M18 X 2.5	.600	.613	.625	.638	15.294	15.744	.6021	.6198	15.5mm	(.6102)	15.294	15.574	.6021	.6131	15.5mm	(.6102)
M18 X 1.5	.643	.651	.659	.666	16.376	16.676	.6447	.6565	16.5mm	(.6496)	16.376	16.566	.6447	.6522	16.5mm	(.6496)
M20 X 2.5	.679	.692	.704	.717	17.294	17.744	.6809	.6986	17.5mm	(.6890)	17.294	17.574	.6809	.6919	17.5mm	(.6890)
M20 X 1.5	.722	.730	.737	.745	18.376	18.676	.7235	.7353	18.5mm	(.7283)	18.376	18.566	.7235	.7309	18.5mm	(.7283)
M22 X 2.5	.757	.770	.783	.796	19.294	19.744	.7596	.7773	19.5mm	(.7677)	19.294	19.574	.7596	.7706	19.5mm	(.7677)
M22 X 1.5	.801	.809	.816	.824	20.376	20.676	.8022	.8140	20.5mm	(.8071)	20.376	20.566	.8022	.8097	20.5mm	(.8071)
M24 X 3	.814	.830	.845	.860	20.752	21.252	.8170	.8367	21mm	(.8268)	20.752	21.067	.8170	.8294	21mm	(.8268)
M24 X 2	.858	.868	.878	.889	21.835	22.210	.8596	.8744	22mm	(.8661)	21.835	22.071	.8596	.8689	22mm	(.8661)

**THRESHAVER PIPE TAP DRILL SIZES – NPT, NPTF & NPSF**

SIZE	NPT & NPTF DRILL ONLY		NPT & NPTF DRILL / TAPER REAM		NPSF STRAIGHT THREAD
	NPT DRILL SIZE	NPTF DRILL SIZE	DRILL SIZE	REAM DIAMETER LARGE END	SUGGESTED HOLE SIZE
1/16-27	D (.246)	D (.246)	15/64"	.2515	.250/.252
1/8-27	Q (.332)	R (.339)	21/64"	.3440	.343/.345
1/4-18	7/16"	7/16"	27/64"	.4472	.444/.447
3/8-18	9/16"	37/64"	9/16"	.5826	.580/.583
1/2-14	45/64"	45/64"	11/16"	.7213	.715/.719
3/4-14	29/32"	59/64"	57/64"	.9317	.926/.930

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