THREAD MILLS

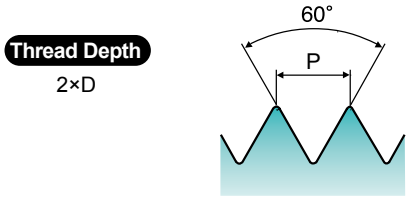
UNCOATED **L41A1** SERIES
TiAlN **L42A1** SERIES

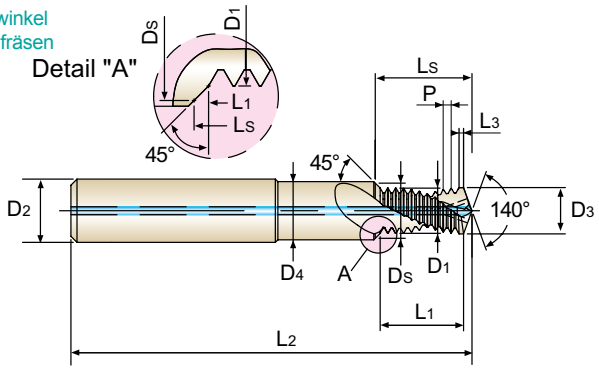
M Solid Carbide Drill and Thread Mill with Chamfer for ISO Metric Internal Thread - DIN 13

VOLLHARTMETALL BOHRGEWINDEFRÄSER MIT SENKFASE für ISO METRISCHE INNENGEWINDE - DIN 13
FRAISES À FILETER ET À PERCER CARBURE MONOBLOC AVEC CHANFREIN POUR FILETAGE INTER - DIN13
Fresa fora, filetta e smussa , filettature interne, ISO metriche passo grosso - DIN 13

- No. of Flute : 2
- Drill Point : 140° / Countersink : 90°
- Drilling, Chamfering and Thread milling

- Anz. der Nuten : 2
- 140° Spitzenwinkel, 90° Senkwinkel
- Bohren, Senken und Gewindefräsen





Material groups GG | Material groups Al | CARBIDE | DIN 6535HA | 60° | Bright / TiAlN | p.B53

Recommended ToolHolder

Flat Shank	Page	Plain Shank	Page
END MILL HOLDER	D117 - 137	HYDRAULIC CHUCK SHRINK FIT HOLDER	D15 - 46 D47 - 72
POWER MILLING CHUCK			D161 - 176
ER COLLET CHUCK SK SLIM CHUCK			D73 - 115 D183 - 201

Unit : mm

EDP No.		Nominal Diameter [D]	Pitch	Cutter Diameter	Shank Diameter	Effect. Diameter	Drill Diameter	Max. C'sink	Thread Length	Effect. Length	Drill Length	Overall Length
Bright	TiAlN		P	D1	D2	Ds	D3	D4	L1	Ls	L3	L2
L41A1310	L42A1310	M6	1.0	4.75	8	6.3	5.00	6.6	13.00	14.68	1.00	62
L41A1360	L42A1360	M8	1.25	6.35	10	8.3	6.75	9.0	16.27	18.48	1.25	74
L41A1420	L42A1420	M10	1.5	7.95	12	10.3	8.50	11.0	21.05	23.77	1.50	79
L41A1500	L42A1500	M12	1.75	9.95	14	12.3	10.25	13.5	24.21	27.25	1.50	89
L41A1540	L42A1540	M14	2.0	11.20	16	14.3	12.00	15.5	29.58	33.32	1.50	102

* Other coatings are available on your request

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended															◎	◎	◎	◎	◎	◎

ISO	N										S					H				
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎											

SELECTION GUIDE

YG THREADING TOOLS

THREAD MILLS

TYPE	Thread Mill without Coolant Hole				Thread Mill with Coolant Hole		
THREAD FORM	M	MF	UNC	UNF	M	MF	BSP(G)
HOLE TYPE	Max. 2.0xD Blind /Through Hole	Max. 1.5xD Blind /Through Hole	Max. 2.0xD Blind /Through Hole	Max. 2.0xD Blind /Through Hole	Max. 2.0xD Blind /Through Hole	Max. 1.5xD Blind /Through Hole	-
TOOL MATERIAL	CARBIDE						
FLUTE TYPE	Helix						
HELIX ANGLE	R15						
SERIES NO.	L1211 (p.B34)	L1212 (p.B35)	L1213 (p.B36)	L1214 (p.B37)	L4211 (p.B38)	L4212 (p.B39)	L6215 (p.B40)
SURFACE TREATMENT	TiAlN	TiAlN	TiAlN	TiAlN	TiAlN	TiAlN	TiAlN
MODEL							

Please visit globalyg1.com/mat for material search

◎ : Excellent ○ : Good

ISO	VDI 3323	Material Description	HB	HRc						
P	1	Non-alloy steel	125		◎	◎	◎	◎	◎	◎	◎
	2		190	13	◎	◎	◎	◎	◎	◎	◎
	3		250	25	◎	◎	◎	◎	◎	◎	◎
	4		270	28	◎	◎	◎	◎	◎	◎	◎
	5		300	32	◎	◎	◎	◎	◎	◎	◎
	6	Low alloy steel	180	10	◎	◎	◎	◎	◎	◎	◎
	7		275	29	◎	◎	◎	◎	◎	◎	◎
	8		300	32	◎	◎	◎	◎	◎	◎	◎
	9		350	38	◎	◎	◎	◎	◎	◎	◎
	10	High alloyed steel, and tool steel	200	15	◎	◎	◎	◎	◎	◎	◎
	11		325	35	◎	◎	◎	◎	◎	◎	◎
M	12	Stainless steel	200	15	○	○	○	○	○	○	○
	13		240	23	○	○	○	○	○	○	○
	14		180	10	○	○	○	○	○	○	○
K	15	Grey cast iron	180	10	◎	◎	◎	◎	◎	◎	◎
	16		260	26	◎	◎	◎	◎	◎	◎	◎
	17	Nodular Cast Iron	160	3	◎	◎	◎	◎	◎	◎	◎
	18		250	25	◎	◎	◎	◎	◎	◎	◎
	19	Malleable cast iron	130		◎	◎	◎	◎	◎	◎	◎
	20		230	21	◎	◎	◎	◎	◎	◎	◎
N	21	Aluminum-wrought alloy	60		◎	◎	◎	◎	◎	◎	◎
	22		100		◎	◎	◎	◎	◎	◎	◎
	23	Aluminum-cast, alloyed	75		◎	◎	◎	◎	◎	◎	◎
	24		90		◎	◎	◎	◎	◎	◎	◎
	25		130		◎	◎	◎	◎	◎	◎	◎
	26	Copper and Copper Alloys (Bronze / Brass)	110		◎	◎	◎	◎	◎	◎	◎
	27		90		◎	◎	◎	◎	◎	◎	◎
	28		100		◎	◎	◎	◎	◎	◎	◎
	29	Non Metallic Materials			◎	◎	◎	◎	◎	◎	◎
	30				◎	◎	◎	◎	◎	◎	◎
S	31	Heat Resistant Super Alloys	200	15	○	○	○	○	○	○	○
	32		280	30	○	○	○	○	○	○	○
	33		250	25	○	○	○	○	○	○	○
	34		350	38	○	○	○	○	○	○	○
	35		320	34	○	○	○	○	○	○	○
	36	Titanium Alloys	400 Rm		○	○	○	○	○	○	○
	37		1050 Rm		○	○	○	○	○	○	○
H	38	Hardened steel	550	55							
	39		630	60							
	40	Chilled Cast Iron	400	42							
	41	Hardened Cast Iron	550	55							

THREAD MILLS

Thread Mill with Coolant Hole & Chamfer					Miniature Thread Mill		Miniature Thread Mill for Hard Materials		Drill & Thread Mill with Chamfer
M	MF	UNC	UNF	NPT	M	UNC	M	UNC	M
Max. 2.0xD	Max. 1.5xD	Max. 2.0xD	Max. 2.0xD	-	Max. 2.0xD	Max. 2.0xD	Max. 2.0xD	Max. 2.0xD	Max. 2.0xD
Blind /Through Hole	Blind /Through Hole	Blind /Through Hole	Blind /Through Hole		Blind /Through Hole	Blind /Through Hole	Blind /Through Hole	Blind /Through Hole	Blind /Through Hole

CARBIDE

Helix					Helix		Straight		Helix	
R15					R15		—		R25	
L4271 (p.B41)	L4272 (p.B42)	L4273 (p.B43)	L4274 (p.B44)	L4276 (p.B45)	L12D1 (p.B46)	L12D3 (p.B47)	L19E1 (p.B48)	L19E3 (p.B49)	L41A1 / L42A1 (p.B50)	
TiAlN	TiAlN	TiAlN	TiAlN	TiAlN	TiAlN	TiAlN	AlTiN	AlTiN	Bright / TiAlN	
◎	◎	◎	◎	◎	◎	◎				1
◎	◎	◎	◎	◎	◎	◎				2
◎	◎	◎	◎	◎	◎	◎				3
◎	◎	◎	◎	◎	◎	◎				4
◎	◎	◎	◎	◎	◎	◎				5
◎	◎	◎	◎	◎	◎	◎	○	○		6 P
◎	◎	◎	◎	◎	◎	◎	○	○		7
◎	◎	◎	◎	◎	◎	◎	○	○		8
◎	◎	◎	◎	◎	◎	◎	○	○		9
◎	◎	◎	◎	◎	◎	◎	○	○		10
◎	◎	◎	◎	◎	◎	◎	○	○		11
○	○	○	○	○	○	○	○	○		12
○	○	○	○	○	○	○	○	○		13 M
○	○	○	○	○	○	○	○	○		14
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	15
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	16
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	17
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	18 K
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	19
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	20
◎	◎	◎	◎	◎	◎	◎			◎	21
◎	◎	◎	◎	◎	◎	◎			◎	22
◎	◎	◎	◎	◎	◎	◎			◎	23
◎	◎	◎	◎	◎	◎	◎			◎	24
◎	◎	◎	◎	◎	◎	◎			◎	25
◎	◎	◎	◎	◎	◎	◎			◎	26 N
◎	◎	◎	◎	◎	◎	◎			◎	27
◎	◎	◎	◎	◎	◎	◎			◎	28
◎	◎	◎	◎	◎	◎	◎			◎	29
◎	◎	◎	◎	◎	◎	◎			◎	30
○	○	○	○	○	○	○	◎	◎		31
○	○	○	○	○	○	○	◎	◎		32
○	○	○	○	○	○	○	◎	◎		33
○	○	○	○	○	○	○	◎	◎		34 S
○	○	○	○	○	○	○	◎	◎		35
○	○	○	○	○	○	○	○	○		36
○	○	○	○	○	○	○	○	○		37
							◎	◎		38
							◎	◎		39
							◎	◎		40 H
							◎	◎		41

THREAD MILLS

RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDKONDITIONEN

					L4273	L4274	L4276	L12D1	L12D3	L19E1	L19E3	L41A1 L42A1
ISO	VDI 3323	Material Description	HB	HRc	Vc (m/min)							
P	1	Non-alloy steel	125		80-120	80-120	80-120	80-120	80-120			
	2		190	13	80-120	80-120	80-120	80-120	80-120			
	3		250	25	80-120	80-120	80-120	80-120	80-120			
	4		270	28	80-120	80-120	80-120	80-120	80-120			
	5		300	32	80-120	80-120	80-120	80-120	80-120			
	6	Low alloy steel	180	10	80-120	80-120	80-120	80-120	80-120	80-120	80-120	
	7		275	29	80-120	80-120	80-120	80-120	80-120	80-120	80-120	
	8		300	32	80-120	80-120	80-120	80-120	80-120	80-120	80-120	
	9		350	38	80-120	80-120	80-120	80-120	80-120	80-120	80-120	
	10	High alloyed steel, and tool steel	200	15	80-120	80-120	80-120	80-120	80-120	80-120	80-120	
	11		325	35	80-120	80-120	80-120	80-120	80-120	80-120	80-120	
M	12	Stainless steel	200	15	40-80	40-80	40-80	40-80	40-80	40-80	40-80	
	13		240	23	40-80	40-80	40-80	40-80	40-80	40-80	40-80	
	14		180	10	40-80	40-80	40-80	40-80	40-80	40-80	40-80	
K	15	Grey cast iron	180	10	50-100	50-100	50-100	50-100	50-100	50-100	50-100	80-150
	16		260	26	50-100	50-100	50-100	50-100	50-100	50-100	50-100	80-150
	17	Nodular cast iron	160	3	50-100	50-100	50-100	50-100	50-100	50-100	50-100	80-150
	18		250	25	50-100	50-100	50-100	50-100	50-100	50-100	50-100	80-150
	19	Malleable cast iron	130		50-100	50-100	50-100	50-100	50-100	50-100	50-100	80-150
	20		230	21	50-100	50-100	50-100	50-100	50-100	50-100	50-100	80-150
N	21	Aluminum-wrought alloy	60		100-300	100-300	100-300	100-300	100-300			100-300
	22		100		100-300	100-300	100-300	100-300	100-300			100-300
	23	Aluminum-cast, alloyed	75		100-300	100-300	100-300	100-300	100-300			100-300
	24		90		100-300	100-300	100-300	100-300	100-300			100-300
	25		130		100-300	100-300	100-300	100-300	100-300			100-300
	26	Copper and Copper Alloys (Bronze / Brass)	110		100-300	100-300	100-300	100-300	100-300			100-300
	27		90		100-300	100-300	100-300	100-300	100-300			100-300
	28		100		100-300	100-300	100-300	100-300	100-300			100-300
	29	Non Metallic Materials			100-300	100-300	100-300	100-300	100-300			80-150
	30				100-300	100-300	100-300	100-300	100-300			80-150
S	31	Heat Resistant Super Alloys	200	15	20-60	20-60	20-60	20-60	20-60	20-60	20-60	
	32		280	30	20-60	20-60	20-60	20-60	20-60	20-60	20-60	
	33		250	25	20-60	20-60	20-60	20-60	20-60	20-60	20-60	
	34		350	38	20-60	20-60	20-60	20-60	20-60	20-60	20-60	
	35		320	34	20-60	20-60	20-60	20-60	20-60	20-60	20-60	
	36	Titanium Alloys	400 Rm		20-60	20-60	20-60	20-60	20-60	20-60	20-60	
	37		1050 Rm		20-60	20-60	20-60	20-60	20-60	20-60	20-60	
H	38	Hardened steel	550	55						25-60	25-60	
	39		630	60						25-50	25-50	
	40	Chilled Cast Iron	400	42						25-70	25-70	
	41	Hardened Cast Iron	550	55						25-60	25-60	

TO CALCULATE SPEED & FEED RATES
SCHNITTGESCHWINDIGKEIT & VORSCHUB KALKULIEREN

Calculate R.P.M of Cutter	Calculate Feed per Revolution	Finally Calculate Feed at Tool Center Line
$n = \frac{1000 \times V}{d \times \pi}$	$F_1 = Fz \times Z \times N$	$F_2 = \frac{F_1 \times (D - d)}{D}$

N	RPM
V	Recommended Cutting Speed
d	Diameter of Cutter
Fz	Recommended Feed per Tooth
Z	Number of Teeth
F_2	Feed at Center Line of Cutting
F_1	Feed at Cutting Edge
D	Major Diameter of Component

SURFACE TREATMENT AND COATING

The applied High Speed Steels holds a grant of good wear resistance and toughness. Therefore YG-1 normally delivers taps with bright and unfinished surface. For certain materials, various surface treatments provide higher advantage in machining.

STEAM TEMPERED - Vap

Steam Tempered is a Fe3O4-oxyd-coating which reduces friction between the tool and workpiece, also preventing cold welding.

NITRIDING - NI

Recommend surface treatment for machining materials that affect wear abrasion, such as grey cast iron, alu-alloys with high Si-percentages (more than 10%).

Below are the various surface treatments for excellent finish surfaces suitable for many applications. The surface treatments are produced and developed within the company.

TiN-COATING

TiN-coating yields a hardness of approx. 2,300 HV and also a heat resistant up to approx. 600°C. The current coating is an excellent all-round coating for normal applications.
Colour : Golden Coefficient of friction against steel : 0.4

TiCN-COATING

TiCN takes place of TiN when the conditions require the coating to have a different hardness and toughness.
The TiCN brings advantages for machining very difficult steels or cutting interrupted bores.
The TiCN-coating has a hardness of approx. 3,000 HV, but is heat resistance only holds up to approx. 400°C, meaning that the TiCN needs an excellent cooling system for a long service life.
Colour : Blue-Grey Coefficient of friction against steel : 0.4

TiAlN-COATING

A special coating for machining abrasive materials such as grey cast iron, alu-alloys with silicon, fiber reinforced plastics, etc., or machining at high temperatures with insufficient cooling, or at high speeds ≥ 600m/min. TiAlN has a hardness of approx. 3,000 HV and is heat resistant up to approx. 800°C.
Colour : Violet-Grey Coefficient of friction against steel : 0.4

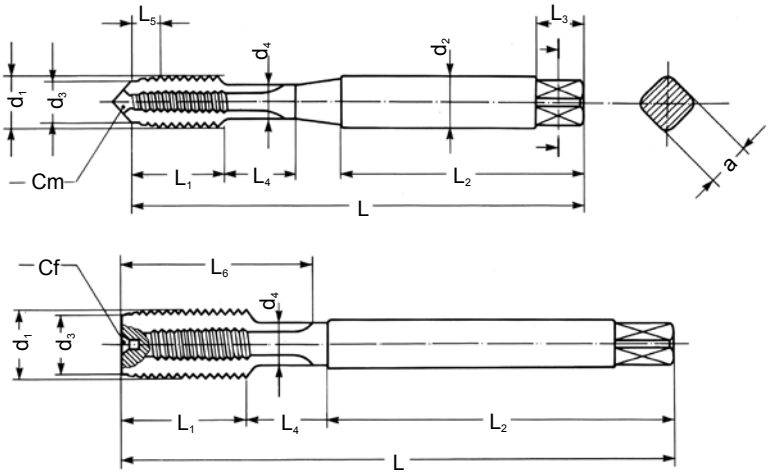
Hardslick-COATING

Hardslick combines the advantages of an extremely hard, thermally stable TiAlN-coating with the sliding and lubricating properties of an outer WC/C(Tungsten carbide/carbon)-coating in a novel way. The Hardslick coating has a hardness of approx. 3,000 HV and is temperature-resistant up to approx. 800°C.
Colour : Violet-Grey Coefficient of friction against steel : 0.2

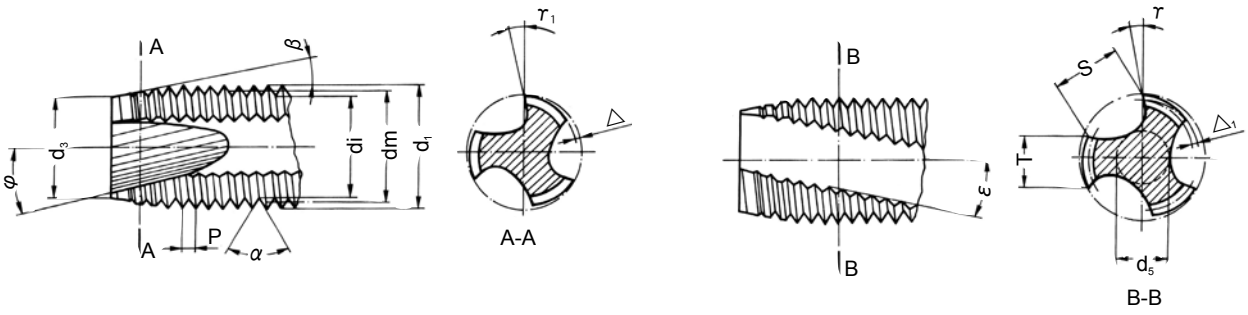
TECHNICAL DATA

SUPER CUTTING TAPS
HOCHLEISTUNGS GEWINDEBOHRER

TAPS TERMINOLOGY
FACHAUSDRÜCKE BEI GEWINDEBOHRERN (Terminologie)



d_1	Major diameter	d_1	Nenn Aussendurchmesser	d_1	Diamètre externe nominal
d_2	Shank diameter	d_2	Schaftdurchmesser	d_2	Diamètre de la queue
d_3	Chamfer diameter	d_3	Anschnittdurchmesser	d_3	Diamètre de l'entrée
d_4	Neck diameter	d_4	Bunddurchmesser	d_4	Diamètre de la collerette de dégagement
L	Total length	L	Gesamtlänge	L	Longueur totale
L_1	Thread length	L_1	Gewindelänge	L_1	Longueur de la patie filetée
L_2	Shank length	L_2	Schaftlänge	L_2	Longueur de la queue
L_3	Square length	L_3	Vierkantlänge	L_3	Longueur du carré
L_4	Neck length	L_4	Bundlänge	L_4	Longueur de la collerette de dégagement
L_5	Chamfer length	L_5	Anschnittlänge	L_5	Longueur de l'entrée
L_6	Flutes length	L_6	Nutenlänge	L_6	Longueur des goujures
a	Square	a	Vierkantma ß	a	Carré
Cm	Center male	Cm	Mittelpunkt des Aussengewindes	Cm	Centre mâle
Cf	Center female	Cf	Mittelpunkt des Innengewindes	Cf	Centre femelle



d_1	Major diameter	d_1	Nenn Aussendurchmesser	d_1	Diamètre externe nominal
dm	Flank diameter	dm	Flankendurchmesser	dm	Diamètre moyen
di	Minor diameter	di	Kerndurchmesser	di	Diamètre interne
d_3	Chamfer diameter	d_3	Anschnittdurchmesser	d_3	Diamètre de l'entrée
P	Pitch	P	Steigung	P	Pas
a	Flank angle	a	Flankenwinkel	α	Angle du filet
β	Chamfer angle	β	Anschnittwinkel	β	Demi-angle du cône d'entrée
φ	Gun nose angle	φ	Schälschnittwinkel	φ	Angle de l'entrée GUN
τ	Gun nose rake angle in front	τ_1	Schälschnitt-Spanwinkel	τ_1	Angle de coupe sur l'entrée GUN
△	Chamfer relief	△	Hinterschliff am Anschnitt	△	Détalonnage sur l'entrée
$△_1$	Pitch diameter relief on the land	$△_1$	Flankenhinterschliff auf Zahnbreite	$△_1$	Détalonnage sur le filet
τ	Rake angle	τ	Spanwinkel	τ	Angle de coupe frontale
T	Width of land	T	Zahnstollenbreite	T	Largeur des dents
S	Flute width	S	Nutenbreite	S	Largeur des goujoures
d_5	Web tickness	d_5	Seelendicke	d_5	Diamètre de l'âme
ε	Angle of spiral flute	ε	Spiralwinkel	ε	Angle d'hélice des goujures

RECOMMENDED TAP DRILL SIZE
EMPFOHLENE KERNLOCHMASSE

Unit : mm

Metric-ISO threads coarse pitch			
M	Pitch	Maximum core dia.	Drill size
1	0.25	0.785	0.75
1.1	0.25	0.885	0.85
1.2	0.25	0.985	0.95
1.4	0.30	1.160	1.10
1.6	0.35	1.321	1.25
1.7	0.35	1.346	1.30
1.8	0.35	1.521	1.45
2	0.40	1.679	1.60
2.2	0.45	1.838	1.75
2.3	0.40	1.920	1.90
2.5	0.45	2.138	2.05
2.6	0.45	2.176	2.10
3	0.50	2.599	2.50
3.5	0.60	3.010	2.90
4	0.70	3.422	3.30
4.5	0.75	3.878	3.70
5	0.80	4.334	4.20
6	1.00	5.153	5.00
7	1.00	6.153	6.00
8	1.25	6.912	6.80
9	1.25	7.912	7.80
10	1.50	8.676	8.50
11	1.50	9.676	9.50
12	1.75	10.441	10.20
14	2.00	12.210	12.00
16	2.00	14.210	14.00
18	2.50	15.744	15.50
20	2.50	17.744	17.50
22	2.50	19.744	19.50
24	3.00	21.252	21.00
27	3.00	24.252	24.00
30	3.50	26.771	26.50
33	3.50	29.771	29.50
36	4.00	32.270	32.00
39	4.00	35.270	35.00
42	4.50	37.799	37.50
45	4.50	40.799	40.50
48	5.00	43.297	43.00
52	5.00	47.297	47.00
56	5.50	50.796	50.50
60	5.50	54.796	54.50
64	6.00	58.305	58.00
68	6.00	62.305	62.00

Metric-ISO threads fine pitch			
MF	Pitch	Maximum core dia.	Drill size
2.5	0.35	2.221	2.15
3	0.35	2.271	2.65
3.5	0.35	3.221	3.15
4	0.50	3.599	3.50
4.5	0.50	4.099	4.00
5	0.50	4.599	4.50
5.5	0.50	5.099	5.00
6	0.75	5.378	5.20
7	0.75	6.378	6.20
8	0.75	7.378	7.20
8	1.00	7.153	7.00
9	0.75	8.378	8.20
9	1.00	8.153	8.00
10	0.75	9.378	9.20
10	1.00	9.153	9.00
10	1.25	8.912	8.80
11	0.75	10.378	10.20
11	1.00	10.153	10.00
12	1.00	11.153	11.00
12	1.25	10.912	10.80
12	1.50	10.676	10.50
14	1.00	13.153	13.00
14	1.25	12.912	12.80
14	1.50	12.676	12.50
15	1.00	14.153	14.00
15	1.50	13.676	13.50
16	1.00	15.153	15.00
16	1.50	14.676	14.50
17	1.00	16.153	16.00
17	1.50	15.676	15.50
18	1.00	17.153	17.00
18	1.50	16.676	16.50
18	2.00	16.210	16.00
20	1.00	19.153	19.00
20	1.50	18.676	18.50
20	2.00	18.210	18.00
22	1.00	21.153	21.00
22	1.50	20.676	20.50
22	2.00	20.210	20.00
24	1.00	23.153	23.00
24	1.50	22.676	22.50
24	2.00	22.210	22.00
25	1.00	24.153	24.00
25	1.50	23.676	23.50

Metric-ISO threads fine pitch			
MF	Pitch	Maximum core dia.	Drill size
25	2.00	23.210	23.00
26	1.50	24.676	24.50
27	1.00	26.153	26.00
27	1.50	25.676	25.50
27	2.00	25.210	25.00
28	1.00	27.153	27.00
28	1.50	26.676	26.50
28	2.00	26.210	26.00
30	1.00	29.153	29.00
30	1.50	28.676	28.50
30	2.00	28.210	28.00
30	3.00	27.252	27.00
32	1.50	30.675	30.50
32	2.00	30.210	30.00
33	1.50	31.676	31.50
33	2.00	31.210	31.00
33	3.00	30.252	30.00
35	1.50	33.676	33.50
36	1.50	34.676	34.50
36	2.00	34.210	34.00
36	3.00	33.252	33.00
38	1.50	36.676	36.50
39	1.50	37.676	37.50
39	2.00	37.210	37.00
39	3.00	36.252	36.00
40	1.50	38.676	38.50
40	2.00	38.210	38.00
40	3.00	37.252	37.00
42	1.50	40.676	40.50
42	2.00	40.210	40.00
42	3.00	39.252	39.00
45	1.50	43.676	43.50
45	2.00	43.210	43.00
45	3.00	42.252	42.00
48	1.50	46.676	46.50
48	2.00	46.210	46.00
48	3.00	45.252	45.00
50	1.50	48.676	48.50
50	2.00	48.210	48.00
50	3.00	47.252	47.00
52	1.50	50.676	50.50
52	2.00	50.210	50.00
52	3.00	49.252	49.00

TECHNICAL DATA

SUPER CUTTING TAPS
HOCHLEISTUNGS GEWINDEBOHRER

Unit : mm

American Unified coarse threads

UNC	T.P.I	Maximum core dia.	Drill size
#1	64	1.585	1.50
#2	56	1.872	1.80
#3	48	2.146	2.10
#4	40	2.385	2.30
#5	40	2.697	2.60
#6	32	2.896	2.85
#8	32	3.528	3.50
#10	24	3.950	3.90
#12	24	4.590	4.50
1/4"	20	5.250	5.20
5/16"	18	6.680	6.60
3/8"	16	8.082	8.00
7/16"	14	9.441	9.40
1/2"	13	10.881	10.75
9/16"	12	12.301	12.25
5/8"	11	13.693	13.50
3/4"	10	16.624	16.50
7/8"	9	19.520	19.50
1"	8	22.344	22.25
1*1/8"	7	25.082	25.00
1*1/4"	7	28.258	28.25
1*3/8"	6	30.851	30.75
1*1/2"	6	34.026	34.00
1*3/4"	5	39.560	39.50
2"	4.5	45.367	45.25

American Unified fine threads

UNF	T.P.I	Maximum core dia.	Drill size
#0	80	1.306	1.30
#1	72	1.613	1.60
#2	64	1.913	1.90
#3	56	2.197	2.10
#4	48	2.459	2.40
#5	44	2.741	2.70
#6	40	3.012	3.00
#8	36	3.597	3.50
#10	32	4.168	4.10
#12	28	4.717	4.70
1/4"	28	5.563	5.50
5/16"	24	6.995	6.90
3/8"	24	8.565	8.50
7/16"	20	9.947	9.90
1/2"	20	11.524	11.50
9/16"	18	12.969	12.90
5/8"	18	14.554	14.50
3/4"	16	17.546	17.50
7/8"	14	20.493	20.50
1"	12	23.363	23.25
1*1/8"	12	26.538	26.50
1*1/4"	12	29.713	29.50
1*3/8"	12	32.888	32.70
1*1/2"	12	36.063	36.00

Whitworth threads B.S.W.

BSW	T.P.I	Maximum core dia.	Drill size
3/32"	48	1.910	1.80
1/8"	40	2.590	2.50
5/32"	32	3.211	3.10
3/16"	24	3.743	3.60
7/32"	24	4.538	4.40
1/4"	20	5.224	5.10
5/16"	18	6.661	6.50
3/8"	16	8.052	7.90
7/16"	14	9.379	9.30
1/2"	12	10.610	10.50
9/16"	12	12.176	12.00
5/8"	11	13.598	13.50
3/4"	10	16.538	16.50
7/8"	9	19.411	19.25
1"	8	22.185	22.00
1*1/8"	7	24.879	24.75
1*1/4"	7	28.054	27.75
1*3/8"	6	30.555	30.50
1*1/2"	6	33.730	33.50
1*5/8"	5	35.921	35.50
1*3/4"	5	39.096	39.00
1*7/8"	4.5	41.648	41.50
2"	4.5	44.823	44.50
2*1/4"	4	50.420	50.00
2*1/2"	4	56.770	56.50
2*3/4"	3.5	62.108	62.00
3"	3.5	68.459	68.50

Whitworth pipe thread BSP.PI

G(BSP)	T.P.I	Maximum core dia.	Drill size
1/8"	28	8.848	8.80
1/4"	19	11.890	11.80
3/8"	19	15.395	15.25
1/2"	14	19.172	19.00
5/8"	14	21.128	21.00
3/4"	14	24.658	24.50
7/8"	14	28.418	28.25
1"	11	30.931	30.75
1*1/8"	11	35.579	35.50
1*1/4"	11	39.592	39.50
1*3/8"	11	42.005	42.00
1*1/2"	11	45.485	45.20
1*5/8"	11	49.670	49.60
1*3/4"	11	51.428	51.40
2"	11	57.296	57.20
2*1/4"	11	63.392	63.30
2*3/8"	11	67.080	67.00
2*1/2"	11	72.866	72.80
2*3/4"	11	79.216	79.10
3"	11	85.566	85.50
3*1/4"	11	91.662	91.50
3*1/2"	11	98.012	98.00
3*3/4"	11	104.362	104.00
4"	11	110.712	110.50