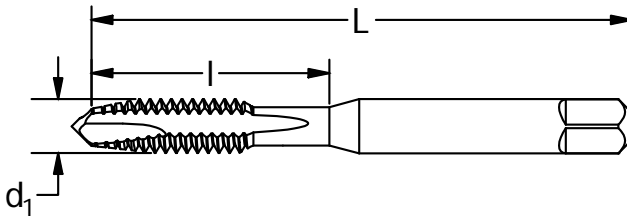


Note
Tapping Speeds and Feeds see
Technical section.



Surface
Treatment



Feature:

Thru hole application in a variety of materials.

Spiral Point

High Speed Steel

tap size and pitch d_1	thread form	decimal equiv	no. of flutes	H- limit	overall length L (in)	thread length I (in)	order number			
							1011 Bright	1011SO Black Oxide	1011TN TiN	1011TC TiCN
*0-80	UNF	.0600	2	H1	1.688	.313	C57009	—	—	—
*0-80	UNF	.0600	2	H2	1.688	.313	C57011	C57600	C55290	C55370
*1-64	UNC	.0730	2	H2	1.688	.375	C57022	—	—	—
*1-72	UNF	.0730	2	H1	1.688	.375	C57023	—	—	—
*1-72	UNF	.0730	2	H2	1.688	.375	C57024	—	—	—
*2-56	UNC	.0860	2	H2	1.750	.438	C57031	C57602	C55292	C55372
*2-64	UNF	.0860	2	H2	1.750	.438	C57033	—	—	—
*3-48	UNC	.0990	2	H2	1.813	.500	C57038	—	C55294	—
*3-56	UNF	.0990	2	H2	1.813	.500	C57041	—	—	—
4-40	UNC	.1120	2	H1	1.875	.563	C57047	—	—	—
4-40	UNC	.1120	2	H2	1.875	.563	C57048	C57604	C55296	C55374
4-48	UNF	.1120	2	H2	1.875	.563	C57051	—	—	—
5-40	UNC	.1250	2	H2	1.938	.625	C57062	C57606	C55298	C55376
6-32	UNC	.1380	2	H1	2.000	.688	C57069	—	—	—
6-32	UNC	.1380	2	H2	2.000	.688	C57070	C57608	C55299	—
6-32	UNC	.1380	2	H3	2.000	.688	C57072	C57609	C55300	C55378
6-32	UNC	.1380	2	H7	2.000	.688	C57074	—	—	—
6-40	UNF	.1380	2	H2	2.000	.688	C57076	—	C55302	—
8-32	UNC	.1640	2	H2	2.125	.750	C57083	C57610	C55303	—
8-32	UNC	.1640	2	H3	2.125	.750	C57085	C57611	C55304	C55380
8-32	UNC	.1640	2	H7	2.125	.750	C57087	—	C55305	—
8-36	UNF	.1640	2	H2	2.125	.750	C57089	—	C55306	—
10-24	UNC	.1900	2	H1	2.375	.875	C57094	—	—	—
10-24	UNC	.1900	2	H2	2.375	.875	C57095	—	C55307	—
10-24	UNC	.1900	2	H3	2.375	.875	C57097	C57001	C55308	C55382
10-24	UNC	.1900	2	H7	2.375	.875	C57099	—	C55309	—
10-32	UNF	.1900	2	H2	2.375	.875	C57102	—	C55311	—
10-32	UNF	.1900	2	H3	2.375	.875	C57104	C57002	C55310	C55383
10-32	UNF	.1900	2	H7	2.375	.875	C57106	—	C55346	—
12-24	UNC	.2160	2	H3	2.375	.938	C57112	C57616	C55312	C55384
12-28	UNF	.2160	2	H3	2.375	.938	C57114	—	C55313	—
1/4-20	UNC	.2500	2	H1	2.500	1.000	C57127	—	C55348	—
1/4-20	UNC	.2500	2	H2	2.500	1.000	C57128	C57618	C55315	—
1/4-20	UNC	.2500	2	H3	2.500	1.000	C57129	C57619	C55316	—
1/4-20	UNC	.2500	3	H3	2.500	1.000	C57130	C57620	—	C55386
1/4-20	UNC	.2500	2	H5	2.500	1.000	C57132	—	C55317	—
1/4-20	UNC	.2500	3	H5	2.500	1.000	C57133	—	—	—
1/4-20	UNC	.2500	2	H11	2.500	1.000	C57135	—	—	—
1/4-28	UNF	.2500	2	H2	2.500	1.000	C57137	—	—	—

* #0 - #3: 302 blank style.

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Styles: **1011, 1011SO, 1011TN, 1011TC** (cont'd)

General Purpose
Inch

tap size and pitch d ₁	thread form	decimal equiv	no. of flutes	H- limit	overall length L (in)	thread length l (in)	order number			
							1011 Bright	1011SO Black Oxide	1011TN TiN	1011TC TiCN
1/4-28	UNF	.2500	3	H2	2.500	1.000	C57138	—	—	C55387
1/4-28	UNF	.2500	2	H3	2.500	1.000	C57139	C57622	C55318	—
5/16-18	UNC	.3125	2	H1	2.719	1.125	C57149	—	—	—
5/16-18	UNC	.3125	2	H2	2.719	1.125	C57150	—	C55319	—
5/16-18	UNC	.3125	2	H3	2.719	1.125	C57151	C57624	C55320	—
5/16-18	UNC	.3125	3	H3	2.719	1.125	C57152	C57625	C55321	C55388
5/16-18	UNC	.3125	2	H5	2.719	1.125	C57154	—	C55354	—
5/16-18	UNC	.3125	3	H5	2.719	1.125	C57155	—	C55355	—
5/16-24	UNF	.3125	2	H1	2.719	1.125	C57157	—	—	—
5/16-24	UNF	.3125	2	H3	2.719	1.125	C57160	C57626	C55322	—
5/16-24	UNF	.3125	3	H4	2.719	1.125	C57164	—	—	C55389
3/8-16	UNC	.3750	3	H2	2.938	1.250	C57175	—	C55323	—
3/8-16	UNC	.3750	3	H3	2.938	1.250	C57176	C57628	C55324	C55390
3/8-16	UNC	.3750	3	H5	2.938	1.250	C57177	—	C55325	—
3/8-24	UNF	.3750	3	H1	2.938	1.250	C57179	—	—	—
3/8-24	UNF	.3750	3	H2	2.938	1.250	C57180	—	—	—
3/8-24	UNF	.3750	3	H3	2.938	1.250	C57181	C57630	C55326	C55391
3/8-24	UNF	.3750	3	H4	2.938	1.250	C57182	—	—	—
7/16-14	UNC	.4375	3	H2	3.156	1.438	C57191	—	—	—
7/16-14	UNC	.4375	3	H3	3.156	1.438	C57192	C57632	C55328	—
7/16-14	UNC	.4375	3	H5	3.156	1.438	C57193	—	—	—
7/16-20	UNF	.4375	3	H3	3.156	1.438	C57195	—	C55330	C55392
7/16-20	UNF	.4375	3	H5	3.156	1.438	C57196	—	—	—
1/2-13	UNC	.5000	3	H2	3.375	1.656	C57214	—	—	—
1/2-13	UNC	.5000	3	H3	3.375	1.656	C57215	C57636	C55332	C55394
1/2-13	UNC	.5000	3	H5	3.375	1.656	C57216	—	C55333	—
1/2-20	UNF	.5000	3	H3	3.375	1.656	C57220	C57638	C55334	C55395
5/8-11	UNC	.6250	3	H3	3.813	1.813	C57230	C57640	C55336	C55396
5/8-11	UNC	.6250	3	H5	3.813	1.813	C57232	—	—	—
5/8-18	UNF	.6250	3	H3	3.813	1.813	C57555	C57642	—	—
3/4-10	UNC	.7500	3	H3	4.250	2.000	C57246	C57644	C55338	C55398
3/4-10	UNC	.7500	3	H5	4.250	2.000	C57247	—	—	—
3/4-16	UNF	.7500	3	H3	4.250	2.000	C60999	—	—	—

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Spiral Point
High Speed Steel

Material Reference	Steel (HRc)				Stainless Steel			Cast Iron (HRc)		Aluminum and Non-Ferrous	Hi-Temp Alloy		Hardened Steel (HRc)
	Low Carbon		Alloy		Austenitic	Martensitic	PH	Gray	Nodular		Ni, Co, Fe Based Super Alloy	Titanium	
	Hardness	13-38	>38	16-38	> 38	300 Series	400 series		18-22	22-32			>45
TiN	◆		◆		◆					☆			
TiCN	☆		☆		☆			◆					

☆ = Best Performance ◆ = Acceptable