

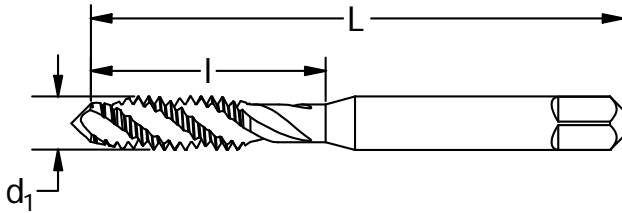
# Threading

## General Purpose - Inch High-Spiral



Styles: **1093, 1093-TN, 1094, 1094-TN**

**Note**  
Tapping Speeds and Feeds see  
Technical section.



Spiral Flute

High Speed Steel

order number

tap size and pitch $d_1$	thread form	decimal equiv.	no. of flutes	H- limit	overall length		thread length		order number			
					L (in)	I (in)	1093 Bright	1093-TN TiN	1094 Bright	1094-TN TiN		
4-40	UNC	.1120	2	H2	1.875	.563	C58515	—	C58516	C55566		
6-32	UNC	.1380	2	H3	2.000	.688	C58532	C55571	C58533	C55570		
8-32	UNC	.1640	3	H3	2.125	.750	C58538	C55573	C58539	C55572		
10-24	UNC	.1900	3	H3	2.375	.875	C58544	C55575	C58545	—		
10-32	UNF	.1900	3	H3	2.375	.875	C58546	C55577	C58547	C55576		
1/4-20	UNC	.2500	3	H3	2.500	1.000	C58562	—	C58563	—		
1/4-28	UNF	.2500	3	H3	2.500	1.000	C58564	—	C58565	—		
5/16-18	UNC	.3125	3	H3	2.719	1.125	C58570	—	C58571	—		
5/16-24	UNF	.3125	3	H3	2.719	1.125	C58572	—	C58573	—		
3/8-16	UNC	.3750	3	H3	2.938	1.250	C58581	—	C58582	—		
3/8-24	UNF	.3750	3	H3	2.938	1.250	C58583	—	C58584	—		
1/2-13	UNC	.5000	3	H3	3.375	1.656	C58613	—	C58614	—		
1/2-20	UNF	.5000	3	H3	3.375	1.656	C58615	—	C58616	—		

## General Purpose - Metric High-Spiral

Styles: **1093, 1093-TC, 1094, 1094-TC**

tap size and pitch $d_1$	decimal equiv.	no. of flutes	D- limit	overall length		thread length		order number			
				L in	mm	I in	mm	1093 Bright	1093-TC TiCN	1094 Bright	1094-TC TiCN
M3 x 0.5	.1181	2	D3	1.938	49.21	.625	15.88	C58800	—	C58801	C58901
M4 x 0.7	.1575	3	D4	2.125	53.98	.750	19.05	C58804	C58904	C58805	C58905
M5 x 0.8	.1969	3	D4	2.375	60.33	.875	22.23	C58806	C58906	C58807	C58907
M6 x 1.0	.2362	3	D5	2.500	63.50	1.000	25.40	C58808	C58908	C58809	C58909
M8 x 1.25	.3150	3	D5	2.719	69.06	1.125	28.58	C58810	C58910	C58811	C58911
M10 x 1.5	.3937	3	D8	2.938	74.61	1.250	31.75	C58812	C58912	C58813	C58913
M12x1.75	.4724	3	D6	3.375	85.73	1.656	42.07	—	—	C58815	—

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
	Bright	◆		◆							☆		
TiN	☆		☆		☆								
TiCN	☆		☆		☆					☆			

☆ = Best Performance    ◆ = Acceptable

