



- Used for thread forming in copper, brass, aluminum, die castings, leaded steels, low carbon steels and stainless steels
- Bright finish
- Premium high speed steel

Extended life results from tap geometry that allows optimum cutting performance and close control over tapped hole size. Superior wear resistance, heat treated for toughness.

■ HSS ROLL FORM INCH						
Tap	Threads Per Inch	Thread Limits	O/A Length (in)	Thread Length (in)	Code No.	Price \$
NC						
4	40	H5	1-7/8	.560	124-650	16.40
6	32	H5	2	.480	124-655	13.40
8	32	H5	2-1/8	.500	124-660	13.40
10	24	H6	2-3/8	.640	124-665	13.40
1/4	20	H6	2-1/2	.830	124-675	13.70
5/16	18	H7	2-23/32	.930	124-685	15.90
3/8	16	H7	2-15/16	.980	124-695	21.70
1/2	13	H8	2-23/32	.930	124-705	40.30
NF						
10	32	H6	2-3/8	.640	124-670	13.40
1/4	28	H6	2-1/2	.830	124-680	13.70
5/16	24	H7	2-23/32	.930	124-690	15.90
3/8	24	H7	2-15/16	.980	124-700	21.70
1/2	20	H8	2-15/16	.980	124-710	40.30

■ HSS ROLL FORM TAPS METRIC SIZES					
Nominal Size and Pitch	Thread Limits	O/A Length (in)	Thread Length (in)	Code No.	Price \$
M3 x .5	D5	1-15/16	.620	124-750	18.70
M4 x .7	D6	2-1/8	.500	124-755	15.70
M5 x .8	D7	2-3/8	.640	124-760	15.70
M6 x 1.0	D8	2-1/2	.830	124-765	16.70
M8 x 1.25	D9	2-23/32	.930	124-770	18.00
M10 x 1.5	D10	2-15/16	.980	124-775	25.10

cutting conditions				
Materials		Condition	Hardness (HRC)	Cutting Speed (FPM)
Main Group	Sub-Group			
Steels	Sheet, low/medium carbon and Stainless Steels	Hardened	<20	20-50
Aluminum	Pure/low			30-60
Copper	Alloyed			30-60
Aluminum	Die cast, Zinc Die cast			30-80
Copper	Brass			
Alloys	Bronze			

