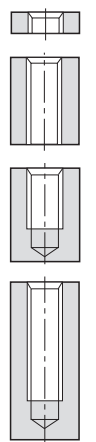


TAP SELECTION CHART by materials

 1 SUITABILITY OF TAP 2 (●) MOST SUITABLE 3 (○) SUITABLE 4 TYPE OF HOLE	DESCRIPTION	HAND TAPS ISO 529 ISO 2284 JIS B4430											GENERAL PURPOSE MACHINE TAPS ISO 529 / 2283 / 2284 / JIS B4430 DIN 371 / 376 / 374 / 5156											SPECIAL APPLICATION MACHINE TAPS ISO 529 / 2283 / 2284 / JIS B4430 DIN 371 / 376 / 374 / 5156											See Table of Cutting Speed for conversion from m/min to rpm (pg A5)	RECOMMENDED LUBRICATION
		STD SET	(PILOT) SER SET	STR. FL TPR (FORM D)	STR. FL SEC (FORM C)	STR. FL BOT (FORM E)	BF SP	BF SF	BF SF 15°	TIN SP	TIN SF	TIN SF 15°	ST SP	ST SF	ST SP	ST SF	ST SF15°	RED RING SP	RED RING SF	BLUE RING SP	BLUE RING SF	YELLOW RING BF SP	YELLOW RING BF SF	GREEN RING SP	GREEN RING SF	STR. FL. NITR	STR. FL. TIN	POLY-GON	POLY-GON + OG							
		0420	0720 (P)	0120	0220	0320	1220	4220	3220	1223	4223	3223	1221 SO SP	4221 SO SF	1221 (OR) B6	4221 (OR) B7	3221 (OR) B7	1224 HR B5	5224 HR B8	1221 IN B5	5221 IN B8	1220 AL B5	5220 AL B8	1220 AS B5	5220 AS B8	0222 GG B5	0223 GG B5	6220 B8	6220 G B8							
		B3	B3	B4	B4	B4	B6	B7	B7	B6	B7	B7	B6	B7	B6	B7	B7	B5	B8	B5	B8	B5	B8	B5	B8	B5	B8	B5	B8	B8						
TPR + (SEC) + BOT	NO. 1(P) + (NO. 2) + BOT	[TAP IMAGES]											[TAP IMAGES]											(3) Cutting Speed m/min												
DIN CHAMFER LEAD (NO. OF THREADS)	-	-	D	C	E	B	C	C	B	C	C	B	C	B	C	C	B	C	B	C	B	C	B			C	C	C	C	C						
SHORT CHIPPING	1-4	1-4	1-2	1-4	1-4	1-2	3-4	3-4	1-2	3-4	3-4	1-2	3-4	1-2	3-4	1-2	3-4	1-2	3-4	-	-	1-2	3-4			1-4	1-4	-	-							
LONG CHIPPING	1-4	1-4	1-2	1-3	-	1-2	3-4	3-4	1-2	3-4	3-4	1-2	3-4	1-2	3-4	1-2	3-4	1-2	3-4	1-2	3-4	1-2	3-4			-	-	1-2	1-4							
TYPE OF MATERIAL	NOTE: STR. FL. Taps with larger diameter or fine pitch may be used to tap deeper in long chipping materials due to a greater Flute Volume: Metal Removal ratio.																																		10 - 16	OIL/ EMULSION
STEELS UNDER 450 N/mm ²	●	○	○	○								●	●	○	○															●	●					
STEELS UP TO 750 N/mm ²	●	●	●	●		○	○	○	○	○	○	○	○	●	●	○														●	●					
STEELS UP TO 1000 N/mm ²	●	●				○	○	○	●	○	●			○	○	●																				
STEELS OVER 1000 N/mm ²	○	●							○	○	○				○	●	●																			
STAINLESS STEELS	○	●		○					○	○				○	○			●	●				○	○					○	●						
CAST IRON (SHORT CHIPPING)	●	●		○	○																					●	●									
MALLEABLE CAST IRON (LONG CHIPPING)	●	●		○		○	○							●	●	●																				
BRASS (SHORT CHIPPING)	●	○		●	●				○																○											
BRASS (LONG CHIPPING)	●	○		○		●	●	●																			○	○								
SOFT ALUMINIUM, COPPER, ZINC, etc	●	○		○		○	○		○	○											●	●						●	○							
ALUMINIUM ALLOYS, MALLEABLE BRONZE, etc	●	●		○		●	●	○																				○	●							
TOUGH ALUMINIUM (Si > 10%) HARD BRONZE, etc	○	●		○		○	○	○	○	○																		○								
SOFT PLASTICS, THERMO PLASTICS, PVC, etc	○			○		○	○	○													●	●														
HARD PLASTICS, GRP, BAKELITE, etc	○			○	○																					○	○									
SPECIAL ALLOYS, TITANIUM, INCONEL, etc	TAPS WITH SPECIAL GEOMETRY CAN BE SUPPLIED AGAINST SPECIAL REQUEST.																																			

Note (1) The full Type No. is preceded by the Norm letter. eg A0220 = ISO 529 STR. FL. SEC. D0220 = DIN 371 STR. FL. FORM C.
 Note (2) Colour coded rings are available only on DIN Taps.
 Note (3) Cutting speeds can be increased by 50 – 100% when using TIN coated or Polygon taps. Experimenting is advisable.
 Note (4) Additional surface treatments can be added to increase performance in certain applications.