

**SGSP - DIN
Spiral Fluted Taps**

**SGPO - DIN
Spiral Pointed Taps**

High Performance Tap for a Variety of Materials



2018

SGSP Spiral Fluted Taps SGPO Spiral Pointed Taps

High Performance Tap for a Variety of Materials

Covers a wide range of applications -
Aluminum, Cast Iron, Carbon Steel,
Alloy Steel and Stainless Steel
ANSI Shank DIN Overall Length



Features

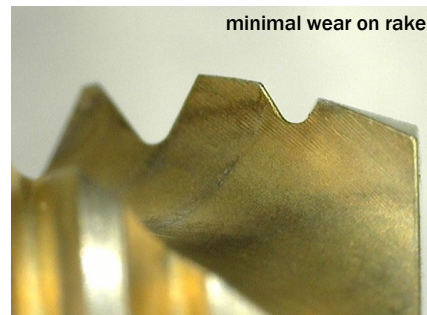
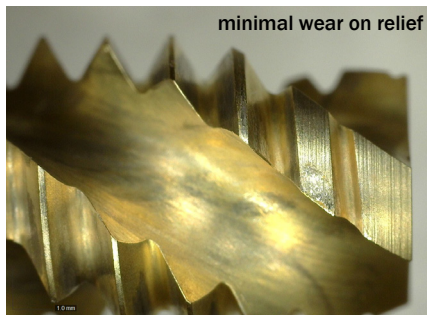
- Made from high grade powder HSS and SG coating for longer tool life
- Optimized edge and flute shape allow for stable cutting threads, high rigidity and chip ejection
- High flexibility for superior performance on a variety of materials, machines, and cutting conditions
- Stable cutting threads and long tool life regardless of cutting speed
- Achieves easy flow of chips while cutting on Stainless Steels, Structural Steels and Aluminum Alloys

Performance

SGSP proved stable tapping in 304 stainless steel with minimal wear after 600 holes

Tool: 1/4-20 Spiral Fluted Tap
Work Material: 304 Stainless Steel
Drill Size: 5.2mm
Tapping Length: 2D (1/2")

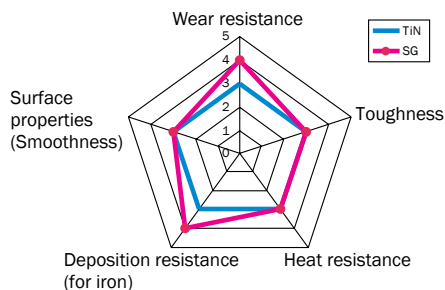
Cutting Speed: 25 SFM
Coolant: External - Water Soluble
Machine: Vertical Machining Center (CAT#40)
Tapping Method: Synchronized



SGSP 25 SFM
304 Stainless Steel - After 600 Holes

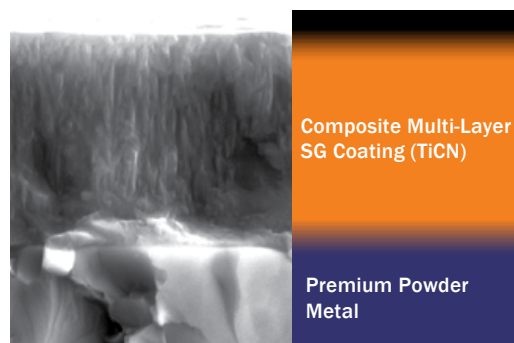
Characteristics

Characteristics of SG Coating



Composite multi-layer film coating method characterized by improved wear resistance as compared to TiN.

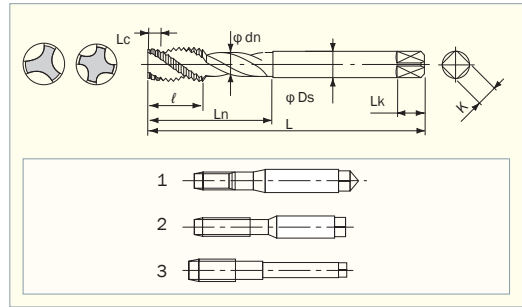
SG Coating (TiN + TiCN)



Stocked Size

SGSP-DIN Spiral Fluted Taps

- Modified Bottoming Style 2.5 Thread Chamfer
- SG Coating
- DIN Overall Length
- Premium Powdered High Speed Steel



List 6801 Machine Screw Sizes & Fractional Sizes

Nominal Size	Thread/Inch		No. of Flutes	EDP No					Dimensions				Style
	NC/UNC	NF/UNF		H2	H3	H4	H5	H6	Overall Length	Length of Thread	Under Neck Length	Shank Dia.	
MACHINE SCREW SIZES									L	ℓ	Ln	Ds	
2	56		3F	1539482					1.772	0.441	0.591	0.141	1
4	40		3F	1539499					2.205	0.272	0.563	0.141	
6	32		3F	1540459	1486439				2.205	0.374	0.689	0.141	
8	32		3F	1540465	1486451				2.480	0.374	0.752	0.168	
10	24		3F		1486474				2.756	0.496	0.874	0.194	
		32	3F	1540471	1486480				2.756	0.374	0.874	0.194	
12	24		3F		1486497				3.150	0.496	0.937	0.220	
FRACTIONAL SIZES													
1/4	20		3F		1486519		1540488		3.150	0.606	1.000	0.255	2
		28	3F		1486525	1540494			3.150	0.413	1.000	0.255	
5/16	18		3F		1486531		1540500		3.543	0.697	1.126	0.318	
		24	3F		1486548	1540516			3.543	0.480	1.126	0.318	
3/8	16		3F		1486554		1540522		3.937	0.783	1.252	0.381	
		24	3F		1486560	1540539			3.543	0.480	1.252	0.381	
7/16	14		3F		1486577		1540545		3.937	0.894	1.236	0.323	
		20	3F		1486583		1540551		3.937	0.626	1.236	0.323	
1/2	13		3F		1486590		1540568		4.331	1.024	1.425	0.367	
		20	3F		1486605		1540574		3.937	0.646	1.425	0.367	
5/8	11		3F			1514622		1540580	4.331	1.185	1.748	0.480	3
		18	3F			1514639		1540597	3.937	0.732	1.748	0.480	
3/4	10		4F			1514645		1540602	4.921	1.303	1.937	0.590	
		16	4F			1514651		1540619	4.331	0.827	1.937	0.590	
1	8		4F			1514680		1540625	6.299	1.626	2.323	0.800	

⚠ WARNING: Cancer - www.P65Warnings.ca.gov

Applications

- Suitable for tapping Structural Steels to Stainless Steels, Aluminum Alloys

Selection Chart

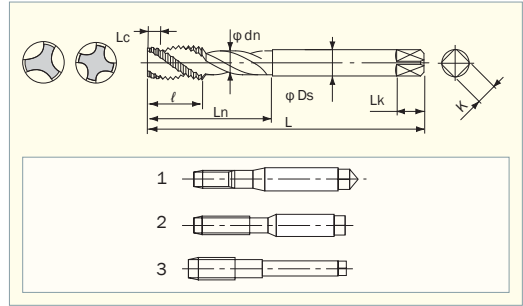
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Carbon Steel			Alloy Steel 4140,4340	Die Steel ~20HRC D2,H13	Hardened Steel >35HRC	Aluminum 6061 7075	Stainless Steel			Cast Iron Grey Ductile	Nickel Alloy	Titanium Alloy
Low Carbon 1010,1018	Medium Carbon 1035,1045	High Carbon 1065,1095					300 Series	400 Series	17-4PH			
●	●	●	●	○	○	○	●	○	△	○		△

Stocked Size

SGSP-DIN Spiral Fluted Taps

- Modified Bottoming Style 2.5 Thread Chamfer
- SG Coating
- DIN Overall Length
- Premium Powdered High Speed Steel



List 6800 Metric Sizes

Nominal Size	Pitch	No. of Flutes	EDP No						Dimensions				Style
			D3	D4	D5	D6	D7	D8	Overall Length	Length of Thread	Under Neck Length	Shank Dia.	
METRIC SIZES													
									L	ℓ	Ln	Ds	
M3	0.5	3F	1486233						2.205	0.228	0.626	0.141	1
M4	0.7	3F		1486256					2.480	0.307	0.689	0.168	
M5	0.8	3F		1486262					2.756	0.374	0.874	0.194	
M6	1.0	3F			1486279				3.150	0.453	1.000	0.255	
M8	1.25	3F			1486307				3.543	0.594	1.126	0.318	2
M10	1.25	3F			1486313				3.937	0.594	1.252	0.381	
M10	1.5	3F				1486320			3.937	0.740	1.252	0.381	3
M12	1.25	3F				1486336			3.937	0.634	1.425	0.367	
M12	1.5	3F				1514479			3.937	0.780	1.425	0.367	
M12	1.75	3F				1486342			4.331	0.882	1.425	0.367	
M14	2.0	3F					1514491		4.331	1.024	1.669	0.429	
M16	2.0	3F					1514513		4.331	1.024	1.748	0.480	
M18	2.5	4F					1514536		4.921	1.280	1.937	0.542	
M20	2.5	4F					1514559		5.512	1.280	1.996	0.652	
M24	3.0	4F						1514594	6.299	1.535	2.323	0.760	

1 piece per package

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SGSP Work Material & Cutting Condition Recommendations

Work Material		Tapping Speed SFM
Low Carbon Steel	1010 1018	50 - 120
Medium Carbon Steel	1035 1045	30 - 120
High Carbon Steel	1065 1095	30 - 120
Alloy Steel	4140 4130	25 - 50
Die Steel	D2 H13 (up to 20 HRC)	20 - 50
Hardened Steel	~ 35 HRC	15 - 45
Stainless Steel	Austentic 303 304 316	15 - 25
	Martensitic 410 430	15 - 25
	17-4PH	10 - 15
Aluminum	6061 7075 Casting	35 - 120
Cast Iron	Grey Nodular	30 - 80

Applications

- Suitable for tapping Structural Steels to Stainless Steels, Aluminum Alloys

Selection Chart

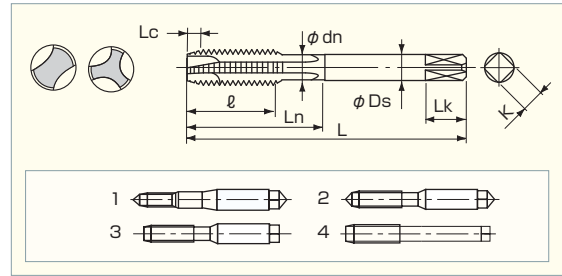
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Carbon Steel			Alloy Steel 4140,4340	Die Steel ~20HRC D2,H13	Hardened Steel >35HRC	Aluminum 6061 7075	Stainless Steel			Cast Iron Grey Ductile	Nickel Alloy	Titanium Alloy
Low Carbon 1010,1018	Medium Carbon 1035,1045	High Carbon 1065,1095					300 Series	400 Series	17-4PH			
●	●	●	●	○	○	○	●	○	△	○		△

Stocked Size

SGPO-DIN Spiral Pointed Taps

- Plug Style 5 Thread Chamfer
- SG Coating
- DIN Overall Length
- Premium Powdered High Speed Steel



List 6803 Machine Screw Sizes & Fractional Sizes

Nominal Size	Thread/Inch		No. of Flutes	EDP No					Dimensions				Style
	NC/UNC	NF/UNF		H2	H3	H4	H5	H6	Overall Length	Length of Thread	Under Neck Length	Shank Dia.	
MACHINE SCREW SIZES									L	ℓ	Ln	Ds	
2	56		2F	1543378					1.772	0.441	0.591	0.141	1
4	40		2F	1543384					2.205	0.469	0.602	0.141	2
6	32		3F	1542519	1542525				2.205	0.555	0.768	0.141	
8	32		3F	1542531	1542548				2.480	0.555	0.768	0.168	
10	24		3F		1542554				2.756	0.709	0.984	0.194	
		32	3F	1542560	1542577				2.756	0.555	0.984	0.194	
12	24		3F		1542583				3.150	0.709	0.984	0.220	
FRACTIONAL SIZES													
1/4	20		3F		1542590		1542605		3.150	0.850	1.181	0.255	3
		28	3F		1542611	1542628			3.150	0.618	1.181	0.255	
5/16	18		3F		1542634		1542640		3.543	0.945	1.299	0.318	
		24	3F		1542657	1542663			3.543	0.709	1.299	0.318	
3/8	16		3F		1542670		1542686		3.937	1.063	1.457	0.381	
		24	3F		1542692	1542708			3.543	0.709	1.457	0.381	
7/16	14		3F		1542714		1542720		3.937	1.142	-	0.323	4
		20	3F		1542737		1542743		3.937	0.902	-	0.323	
1/2	13		3F		1542750		1542766		4.331	1.232	-	0.367	
		20	3F		1542772		1542789		3.937	0.902	-	0.367	
5/8	11		3F			1542795	1542800		4.331	1.181	-	0.480	
		18	3F			1542817	1542823		3.937	0.835	-	0.480	
3/4	10		3F			1542830	1542846		4.921	1.299	-	0.590	
		16	3F			1542852	1542869		4.331	0.937	-	0.590	
1	8		3F			1542875	1542881		6.299	1.626	-	0.800	

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Applications

- Suitable for tapping Structural Steels to Stainless Steels, Aluminum Alloys

Selection Chart

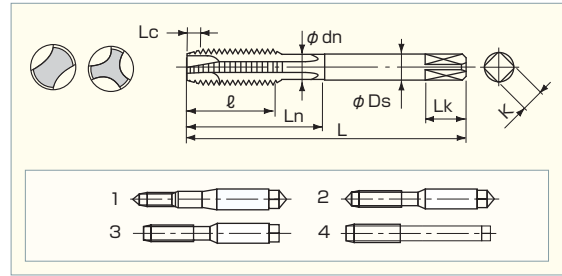
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Carbon Steel			Alloy Steel 4140,4340	Die Steel ~20HRC D2,H13	Hardened Steel >35HRC	Aluminum 6061 7075	Stainless Steel			Cast Iron Grey Ductile	Nickel Alloy	Titanium Alloy
Low Carbon 1010,1018	Medium Carbon 1035,1045	High Carbon 1065,1095					300 Series	400 Series	17-4PH			
●	●	●	●	○	○	○	●	○	△	○		△

Stocked Size

SGPO-DIN Spiral Pointed Taps

- Plug Style 5 Thread Chamfer
- SG Coating
- DIN Overall Length
- Premium Powdered High Speed Steel



List 6802 Metric Sizes

Nominal Size	Pitch	No. of Flutes	EDP No						Dimensions				Style	
			D3	D4	D5	D6	D7	D8	Overall Length L	Length of Thread l	Under Neck Length Ln	Shank Dia. Ds		
METRIC SIZES														
M3	0.5	3F	1542451							2.205	0.394	0.630	0.141	2
M4	0.7	3F		1542898						2.480	0.492	0.752	0.168	
M5	0.8	3F		1542903						2.756	0.571	0.882	0.194	
M6	1.0	3F			1542910					3.150	0.669	1.000	0.255	
M8	1.25	3F			1542926					3.543	0.866	1.181	0.318	3
M10	1.25	3F			1542932					3.937	0.866	1.437	0.381	
M10	1.5	3F				1542949				3.937	1.063	1.437	0.381	4
M12	1.25	3F			1542955					3.937	0.906	-	0.367	
M12	1.5	3F				1542978				3.937	1.102	-	0.367	
M12	1.75	3F				1542961				4.331	1.260	-	0.367	
M14	2.0	3F					1542468			4.331	1.260	-	0.429	4
M16	2.0	3F					1542474			4.331	1.260	-	0.480	
M18	2.5	3F					1542480			4.921	1.476	-	0.542	
M20	2.5	3F					1542497			5.512	1.476	-	0.652	
M24	3.0	3F						1542502		6.299	1.772	-	0.760	

1 piece per package

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SGPO Work Material & Cutting Condition Recommendations

Work Material		Tapping Speed SFM
Low Carbon Steel	1010 1018	50 - 120
Medium Carbon Steel	1035 1045	50 - 160
High Carbon Steel	1065 1095	30 - 160
Alloy Steel	4140 4130	30 - 100
Die Steel	D2 H13 (up to 20 HRC)	25 - 50
Hardened Steel	~ 35 HRC	25 - 60
Stainless Steel	Austenitic 303 304 316	15 - 50
	Martensitic 410 430	15 - 30
	17-4PH	15 - 25
Aluminum	6061 7075 Casting	50 - 160
Cast Iron	Grey Nodular	50 - 150

Applications

- Suitable for tapping Structural Steels to Stainless Steels, Aluminum Alloys

Selection Chart

● : Great ○ : Good △ : OK

Carbon Steel			Alloy Steel 4140,4340	Die Steel ~20HRC D2,H13	Hardened Steel >35HRC	Aluminum 6061 7075	Stainless Steel			Cast Iron Grey Ductile	Nickel Alloy	Titanium Alloy
Low Carbon 1010,1018	Medium Carbon 1035,1045	High Carbon 1065,1095					300 Series	400 Series	17-4PH			
●	●	●	●	○	○	○	●	○	△	○		△

SGSP/SGPO Tap Drill Size Recommendations

Tap Size	Theoretical Hole Size % Thread (Inch)					Class 2B Fit (Inch)			Class 3B Fit (Inch)		
	80%	75%	70%	65%	60%	Minor Dia. Min.	Minor Dia. Max.	Recommended Drill	Minor Dia. Min.	Minor Dia. Max.	Recommended Drill
2-56	0.0674	0.0686	0.0698	0.0709	0.0721	0.0667	0.0737	#50 (0.070)	0.0667	0.0737	#50 (0.070)
4-40	0.0860	0.0876	0.0893	0.0909	0.0925	0.0849	0.0939	#43 (0.089)	0.0849	0.0939	#43 (0.089)
6-32	0.1055	0.1076	0.1096	0.1116	0.1136	0.1040	0.1140	#35 (0.110)	0.1040	0.1140	#35 (0.110)
8-32	0.1315	0.1336	0.1356	0.1376	0.1396	0.1300	0.1390	#29 (0.136)	0.1300	0.1389	#29 (0.136)
10-24	0.1467	0.1494	0.1521	0.1548	0.1575	0.1450	0.1560	#24 (0.152)	0.1450	0.1560	#24 (0.152)
10-32	0.1575	0.1596	0.1616	0.1636	0.1656	0.1560	0.1640	#20 (0.161)	0.1560	0.1641	#20 (0.161)
12-24	0.1727	0.1754	0.1781	0.1808	0.1835	0.1710	0.1810	#16 (0.177)	0.1710	0.1810	#16 (0.177)
1/4 - 20	0.1980	0.2013	0.2045	0.2078	0.2110	0.1960	0.2070	13/64 (0.2031)	0.1960	0.2067	13/64 (0.2031)
1/4 - 28	0.2129	0.2152	0.2175	0.2198	0.2222	0.2110	0.2200	5.5mm (0.2165)	0.2110	0.2190	5.5mm (0.2165)
5/16 - 18	0.2548	0.2584	0.2620	0.2656	0.2692	0.2520	0.2650	G (0.261)	0.2520	0.2630	F (0.257)
5/16 - 24	0.2692	0.2719	0.2746	0.2773	0.2800	0.2670	0.2770	I (0.272)	0.2670	0.2754	I (0.272)
3/8 - 16	0.3101	0.3141	0.3182	0.3222	0.3263	0.3070	0.3210	O (0.316)	0.3070	0.3182	5/16 (0.3125)
3/8 - 24	0.3317	0.3344	0.3371	0.3398	0.3425	0.3300	0.3400	Q (0.332)	0.3300	0.3372	Q (0.332)
7/16 - 14	0.3633	0.3679	0.3726	0.3772	0.3818	0.3600	0.3760	U (0.368)	0.3600	0.3717	U (0.368)
7/16 - 20	0.3855	0.3888	0.3920	0.3953	0.3985	0.3830	0.3950	25/64 (0.3906)	0.3830	0.3916	W (0.386)
1/2 - 13	0.4201	0.4251	0.4301	0.4351	0.4400	0.4170	0.4340	27/64 (0.4219)	0.4170	0.4284	27/64 (0.4219)
1/2 - 20	0.4480	0.4513	0.4545	0.4578	0.4610	0.4460	0.4570	29/64 (0.4531)	0.4460	0.4537	11.4mm (0.4488)
5/8 - 11	0.5305	0.5364	0.5423	0.5482	0.5541	0.5270	0.5460	17/32 (0.5312)	0.5270	0.5391	17/32 (0.5312)
5/8 - 18	0.5673	0.5709	0.5745	0.5781	0.5817	0.5650	0.5780	14.5mm (0.5709)	0.5650	0.5730	14.5mm (0.5709)
3/4 - 10	0.6461	0.6526	0.6591	0.6656	0.6721	0.6420	0.6630	21/32 (0.6562)	0.6420	0.6545	16.5mm (0.6496)
3/4 - 16	0.6851	0.6891	0.6932	0.6972	0.7013	0.6820	0.6960	11/16 (0.6875)	0.6820	0.6908	11/16 (0.6875)
1 - 8	0.8701	0.8782	0.8863	0.8945	0.9026	0.8650	0.8900	7/8 (0.875)	0.8650	0.8797	7/8 (0.875)
Tap Size	Theoretical Hole Size % Thread (Inch)					Class 6H Fit (Inch)					
	80%	75%	70%	65%	60%	Minor Dia. Min.	Minor Dia. Max.	Recommended Drill			
M3 X 0.5	0.0976	0.0988	0.1004	0.1016	0.1028	0.0968	0.1023	#39 (0.0995)			
M4 X 0.7	0.1287	0.1307	0.1323	0.1343	0.1358	0.1276	0.1347	3.3mm (0.1299)			
M5 X 0.8	0.1642	0.1661	0.1681	0.1701	0.1724	0.1628	0.1706	#19 (0.1660)			
M6 X 1.0	0.1953	0.1980	0.2004	0.2031	0.2055	0.1936	0.2029	5.0mm (0.1969)			
M8 X 1.25	0.2638	0.2669	0.2701	0.2732	0.2768	0.2617	0.2721	H (0.2660)			
M10 X 1.25	0.3425	0.3457	0.3488	0.3520	0.3555	0.3404	0.3509	8.8mm (0.3465)			
M10 X 1.5	0.3323	0.3362	0.3402	0.3437	0.3476	0.3298	0.3416	8.5mm (0.3346)			
M12 X 1.25	0.4213	0.4244	0.4276	0.4307	0.4343	0.4192	0.4296	10.8mm (0.4252)			
M12 X 1.5	0.4110	0.4150	0.4189	0.4224	0.4264	0.4085	0.4203	10.6mm (0.4173)			
M12 X 1.75	0.4008	0.4055	0.4098	0.4142	0.4189	0.3979	0.4111	13/32 (0.4063)			
M14 X 2.0	0.4693	0.4744	0.4795	0.4846	0.4898	0.4659	0.4807	12.2mm (0.4803)			
M16 X 2.0	0.5480	0.5531	0.5583	0.5634	0.5685	0.5447	0.5594	14.2mm (0.5591)			
M20 X 2.5	0.6850	0.6913	0.6980	0.7043	0.7106	0.6809	0.6986	17.7mm (0.6969)			
M24 X 3.0	0.8220	0.8299	0.8374	0.8453	0.8528	0.8170	0.8367	21.2mm (0.8346)			

Suggested Percentage of Full Thread in Tapped Holes

	Material	Deep Hole Tapping	Average Commercial Work	Thin Sheet Stock or Stamping
Free Cutting	Aluminum, Brass, Bronze, Cast Iron, Copper, Mild Steel, Tool Steel	60%-70%	65%-70%	75%-85%
Hard or Tough Cutting	Cast Steel, Drop Forging, Monel Metal, Nickel Steel, Stainless Steel	55%-65%	60%-70%	

Classes and Tap Recommendations


Tap Size	Basic Pitch Diameter	Class 2B		Class 3B	
	All Classes Min.	Pitch Diameter Limits Max	Recommended Tap	Pitch Diameter Limits Max	Recommended Tap
2-56	0.0744	0.0772	H2	0.0765	H2
4-40	0.0958	0.0991	H2	0.0982	H2
6-32	0.1177	0.1214	H3	0.1204	H2
8-32	0.1437	0.1475	H3	0.1465	H2
10-24	0.1629	0.1672	H3	0.1661	H3
10-32	0.1697	0.1736	H3	0.1726	H2
12-24	0.1889	0.1933	H3	0.1922	H3
1/4 - 20	0.2175	0.2224	H5	0.2211	H3
1/4 - 28	0.2268	0.2311	H4	0.2300	H3
5/16 - 18	0.2764	0.2817	H5	0.2803	H3
5/16 - 24	0.2854	0.2902	H4	0.2890	H3
3/8 - 16	0.3344	0.3401	H5	0.3387	H3
3/8 - 24	0.3479	0.3528	H4	0.3516	H3
7/16 - 14	0.3911	0.3972	H5	0.3957	H3
7/16 - 20	0.4050	0.4104	H5	0.4091	H3
1/2 - 13	0.4500	0.4565	H5	0.4548	H3
1/2 - 20	0.4675	0.4731	H5	0.4717	H3
5/8 - 11	0.5660	0.5732	H6	0.5714	H4
5/8 - 18	0.5889	0.5949	H6	0.5934	H4
3/4 - 10	0.6850	0.6927	H6	0.6907	H4
3/4 - 16	0.7094	0.7159	H6	0.7143	H4
1 - 8	0.9188	0.9276	H6	0.9254	H4

Tap Size	Pitch Diameter Limits - Class 6H		Class 6H
	Maximum	Minimum	Recommended Tap
M3 x 0.5	0.1054	0.1092	D3
M4 x 0.7	0.1396	0.1442	D4
M5 x 0.8	0.1764	0.1812	D4
M6 x 1.0	0.2107	0.2165	D5
M8 x 1.25	0.2830	0.2892	D5
M10 x 1.25	0.3617	0.3680	D5
M10 x 1.5	0.3554	0.3624	D6
M12 x 1.25	0.4405	0.4476	D6
M12 x 1.5	0.4341	0.4416	D6
M12 x 1.75	0.4277	0.4355	D6
M14 x 2.0	0.5001	0.5083	D7
M16 x 2.0	0.5788	0.5871	D7
M20 x 2.5	0.7235	0.7322	D7
M24 x 3.0	0.8682	0.8785	D8

H2 = Basic P.D. + .0005" to Basic P.D. + .0010"
H3 = Basic P.D. + .0010" to Basic P.D. + .0015"
H4 = Basic P.D. + .0015" to Basic P.D. + .0020"
H5 = Basic P.D. + .0020" to Basic P.D. + .0025"
H6 = Basic P.D. + .0025" to Basic P.D. + .0030"

D3 = Basic P.D. + .0009" to Basic P.D. + .0015"
D4 = Basic P.D. + .0012" to Basic P.D. + .0020"
D5 = Basic P.D. + .0015" to Basic P.D. + .0025"
D6 = Basic P.D. + .0018" to Basic P.D. + .0030"
D7 = Basic P.D. + .0019" to Basic P.D. + .0035"
D8 = Basic P.D. + .0024" to Basic P.D. + .0040"

The above recommended taps normally produce the class of thread indicated in average materials when used with reasonable care. However, if the tap specified does not give a satisfactory gage fit in the work, a choice of some other limit tap may be necessary.

 **WARNING:** This product can expose you to chemicals including cobalt, which is known to the State of California to cause cancer. For more information go to www.P65Warnings.ca.gov



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