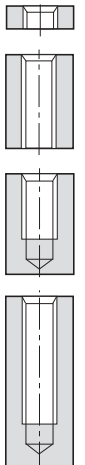


TAP SELECTION CHART by materials

 TYPE OF HOLE	SUITABILITY OF TAP	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	RECOMMENDED LUBRICATION						
			(●) GOOD	DESCRIPTION	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	TIN SP	TIN SF	TIN SF	ST SP	ST SF	ST SP	ST SF	ST SF	ST SF	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
			(○) SUITABLE	TYPE NO. (1)	0420	0720 (P)	0120	0220	0320	1220	4220	3220	1223	4223	3223	1221 SO	4221 SO	1221 OR	4221 OR	3221 OR	1224 HR	5224 HR	1221 IN	5221 IN	1220 AL	5220 AL	1220 AS			5220 AS	0222 GG	0223 GG	6220	6220 G	
				CATALOGUE SYMBOL	TPR + (SEC) + BOT	NO. 1(P) + (NO. 2) + BOT																													
				DIN CHAMFER	-	-	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	C
	LEAD (NO. OF THREADS)	-	-	6 - 8 (3,5 - 5)	3 - 4,5 (2 - 3)	1,5 - 2	3 - 5	2 - 3	2 - 3	3 - 5	2 - 3	2 - 3	3 - 5	2 - 3	3 - 5	2 - 3	2 - 3	2 - 3	3,5 - 5	2 - 3	3,5 - 5	2 - 3	3,5 - 5	2 - 3	3 - 5	2 - 3	2 - 3	2 - 3	2 - 3						
	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	3 - 4	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	3 - 4	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.																												(3) Cutting Speed m/min					
STEELS UNDER 450 N/mm ²	●	○	○	○									●	●	○	○														●	●	10 - 16	OIL/ EMULSION		
STEELS UP TO 750 N/mm ²	●	●	●	●			○	○	○	○	○	○	○	○	●	●	○													●	●	10 - 16	OIL/ EMULSION		
STEELS UP TO 1000 N/mm ²	●	●					○	○	○	●	○	●			○	○	●															5 - 10	OIL/ EMULSION		
STEELS OVER 1000 N/mm ²	○	●								○	○	○					○	●	●													2 - 6	OIL/ EMULSION		
STAINLESS STEELS	○	●		○						○	○				○	○				●	●					○	○			○	●	4 - 8	SPECIAL CUTTING OIL		
CAST IRON (SHORT CHIPPING)	●	●		○	○																								●	●		6 - 12	DRY/ EMULSION		
MALLEABLE CAST IRON (LONG CHIPPING)	●	●		○			○	○							●	●	●															6 - 12	OIL/ EMULSION		
BRASS (SHORT CHIPPING)	●	○		●	●				○			○														○						20 - 25	DRY		
BRASS (LONG CHIPPING)	●	○		○			●	●	●																				○	○		15 - 20	LIGHT OIL/ EMULSION		
SOFT ALUMINIUM, COPPER, ZINC, ETC	●	○		○			○	○		○	○											●	●						●	○		15 - 25	LIGHT OIL/ EMULSION		
ALUMINIUM ALLOYS, MALLEABLE BRONZE, ETC	●	●		○			●	●	○																				○	●		12 - 20	LIGHT OIL/ EMULSION		
TOUGH ALUMINIUM (Si > 10%) HARD BRONZE, ETC	○	●		○			○	○	○	○	○														●	●			○			12 - 18	LIGHT OIL/ EMULSION		
SOFT PLASTICS, THERMO PLASTICS, PVC, ETC	○			○			○	○	○													●	●									12 - 20	DRY		
HARD PLASTICS, GRP, BAKELITE, ETC	○			○	○							○																○	○				DRY		
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.