

YU-SS20

BEST VALUE IN THE WORLD OF CUTTING TOOLS



Stainless Steel Solutions

THREADING AND HOLEMAKING TOOLS

- ▀ **Advanced geometries to work in tough stainless steel applications**
- ▀ **High-performance coatings for long tool life**
- ▀ **Engineered flute shapes for excellent chip curling and evacuation**





INOX taps and drills are the YG-1 solution for better productivity in stainless steels. We put our advanced engineering skills to work and designed holemaking tools with the right stuff – reliable chip management with boosts in productivity to keep parts moving out the door.

With advanced flute designs and cutting geometries, chip management is no problem. You're left with smooth bores, precise threads and tools that are ready for more.

CONTENTS:

YG TAP INOX

PAGE 4



Cut through stainless steel with tools that were born for it. YG-1 engineering gives you premium performance in a range of styles without the premium price.

THREAD MILLS

PAGE 18



Get consistent, smooth threads with thread mills. High performance, precision and long life, with an extra measure of versatility.

DREAM DRILLS • INOX

PAGE 30



Optimized flute shapes and geometries combine for outstanding performance and long tool life in stainless steel.

Synchro Tapping ER Chuck

PAGE 48



The right partner to get the best out of YG Tap INOX. One more way YG-1 delivers the value advantage at every turn.

We design advanced solutions to move the industry forward. That's the YG-1 spirit. Tap into it.

The same properties that make stainless steel alloys so strong and corrosion resistant also make them very hard to machine. But the right blend of cutting tool properties and advanced geometries can deliver aggressive cutting parameters and significant boosts in productivity.



◀ Machining effectively

YG-1 INOX Taps, shown here, combine specially designed geometries and coatings to enable aggressive cutting parameters and deliver more parts per tool.



▲ Using coolant

Machining stainless steel alloys requires coolant. It must be high-quality coolant with at least eight or nine percent oil content in an oil/water emulsion.

GUIDE TO ICONS

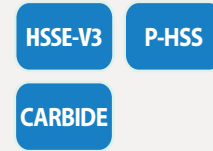
Work Material



Helix Angle



Tool Material



Tolerance of Outside Diameter



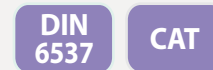
Tolerance of Shank Diameter



Cutting Conditions



Standard of Tools



Point Angle



Coolant Pressure



Finish



Thread Pitch



Steam Tempered



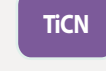
Type of Shank



Coating



Chamfer Lead



Taper Accuracy



Coolant System



YG TAP INOX AND THREAD MILLS: Tools for the Age of Stainless Steel

With stainless steels being formulated for ever-tougher performance, YG-1 engineers developed the INOX line to handle anything engineered steels can throw at them. Whether you're tapping deep holes in molds and engine parts or threading for aerospace tolerances, INOX tools are up to the challenge.



How YG TAP INOX and THREAD MILLS Get the Job Done

YG TAP INOX

YG-1 puts a new spin on threading and tapping with tools engineered to produce high-quality threads at a low cost per hole.

► Styles:

Spiral flute taps – Modified bottoming chamfers for blind hole applications

Spiral point taps – Plug chamfers for through hole applications

► Oxide, TiCN and Hardslick finish options

► Wide range of pitch limits

► Standard and extended lengths

THREAD MILLS

► Versatile – One tool mills left- and right-hand threads in blind and through holes

► High-quality thread finish with full threads to the bottom of the hole





► Consistent close-tolerance pitch diameter

► Excellent option for underpowered machines when threading large-diameter holes





► Higher cutting speed than conventional HSS taps

SELECTION GUIDE

YG TAP INOX

Series	Model	Tool Material	Standard	Work Material	Dimensions	Tolerance	Chamfer	Thread Depth	Surface Treatment	Page
SPIRAL FLUTE - INCH/METRIC										
B1/B0/ B2/D2		HSSE-V3	UNC/UNF	VA	USCTI 302A	H	2P~3P	2.5xD	Bright Steam Oxide TiN/Hardslick	6
G7/G8/ G9/H0		HSS	UNC/UNF	VA	USCTI Long Shank	H	2P~3P		TiN Hardslick	9
BS/BT		HSSE-V3	M/MF	VA	USCTI 302A	D	2P~3P		Steam Oxide Hardslick	10
E6/E8/E9		HSSE-V3	M/MF	VA	DIN Length-ANSI Shank	D	2P~3P		Steam Oxide TiCN Hardslick	11

SPIRAL POINT – INCH/METRIC

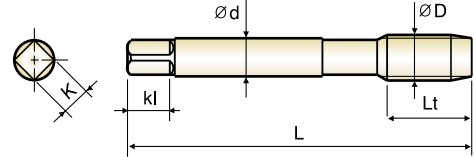
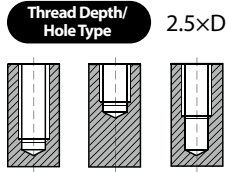
I0/I2/J2		HSSE-V3	UNC/UNF	VA	USCTI 302A	H	4P~5P	3.0xD	Steam Oxide TiN Hardslick	12
M0/M1/ M2/M3		HSS	UNC/UNF	VA	USCTI Long Shank	H	4P~5P		TiN Hardslick	15
O9/IA		HSSE-V3	M/MF	VA	USCTI 302A	D	4P~5P		Steam Oxide Hardslick	16
K3/K5/K6		HSSE-V3	M/MF	VA	DIN Length-ANSI Shank	D	4P~5P		Steam Oxide TiCN Hardslick	17

THREAD MILLS - INCH

SERIES	MODEL	Description	PAGE
TE		SOLID CARBIDE THREAD MILL FOR UNIFIED INTERNAL THREADS - ANSI B 1.1	18
TD		SOLID CARBIDE THREAD MILL FOR METRIC INTERNAL THREADS - DIN 13	19
TF / TG		SOLID CARBIDE THREAD MILL FOR UNIFIED INTERNAL THREADS - ANSI B 1.20.1(NPT) / ANSI B1.20.3(NPTF)	20

SPIRAL FLUTE TAPS MODIFIED BOTTOMING STYLE

B1 | B0 | B2 | D2 SERIES



VA
HSSE-V3
UNC UNF
USCTI 302A
2P~3P
Bright
Steam Oxide
TiN
Hardslick
R45

Unit: Inch

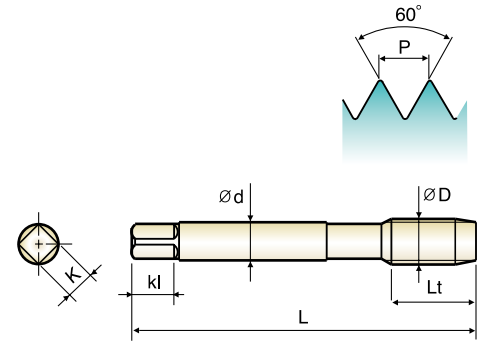
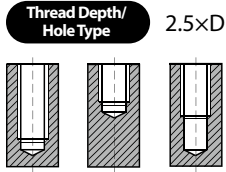
Size	Threads Per Inch		Limit	No. of Flutes	OAL	Square Length	Shank Diameter	Square Size	EDP No.			
	UNC	UNF							L	kl	d	k
#2	56	—	H2	2	1.7500	0.1900	0.1410	0.1100	B1082	B0082	B2082	D2082
#3	48	—	H2	2	1.8100	0.1900	0.1410	0.1100	—	B0122	—	D2122
#4	40	—	H2	2	1.8800	0.1900	0.1410	0.1100	B1162	B0162	B2162	D2162
			H3		1.8800	0.1900	0.1410	0.1100	—	B0163	—	D2163
			H4		1.8800	0.1900	0.1410	0.1100	—	B0164	—	D2164
	—	48	H2		1.8800	0.1900	0.1410	0.1100	—	B0182	—	D2182
#5	40	—	H2	3	1.9400	0.1900	0.1410	0.1100	B1202	B0202	B2202	D2202
#6	32	—	H2	3	2.0000	0.1900	0.1410	0.1100	—	B0242	—	D2242
			H3		2.0000	0.1900	0.1410	0.1100	B1243	B0243	B2243	D2243
			H4		2.0000	0.1900	0.1410	0.1100	—	B0244	—	D2244
			H5		2.0000	0.1900	0.1410	0.1100	—	B0245	—	D2245
	—	40	H2		2.0000	0.1900	0.1410	0.1100	—	B0262	—	D2262
			H3		2.0000	0.1900	0.1410	0.1100	—	B0263	—	D2263
#8	32	—	H2	3	2.1300	0.2500	0.1680	0.1310	—	B0282	—	D2282
			H3		2.1300	0.2500	0.1680	0.1310	B1283	B0283	B2283	D2283
			H4		2.1300	0.2500	0.1680	0.1310	—	B0284	—	D2284
			H5		2.1300	0.2500	0.1680	0.1310	—	B0285	—	D2285
			H6		2.1300	0.2500	0.1680	0.1310	—	B0286	—	D2286
	—	36	H3		2.1300	0.2500	0.1680	0.1310	—	—	—	D2303
			H2		2.3800	0.2500	0.1940	0.1520	—	B0322	—	D2322
#10	24	—	H3	3	2.3800	0.2500	0.1940	0.1520	B1323	B0323	B2323	D2323
			H5		2.3800	0.2500	0.1940	0.1520	—	B0325	—	D2325
			H7		2.3800	0.2500	0.1940	0.1520	—	B0327	—	D2327
			H2		2.3800	0.2500	0.1940	0.1520	—	B0342	—	D2342
	—	32	H2		2.3800	0.2500	0.1940	0.1520	B1343	B0343	B2343	D2343
			H3		2.3800	0.2500	0.1940	0.1520	—	—	—	—

NEXT PAGE ►

- See recommended cutting speed on page 17.
- See application information on pages 21–29.

SPIRAL FLUTE TAPS MODIFIED BOTTOMING STYLE

B1 | B0 | B2 | D2 SERIES



VA
HSSE-V3
UNC UNF
USCTI 302A
2P~3P
Bright
Steam Oxide
TiN
Hardslick
R45

Unit: Inch

Size	Threads Per Inch		Limit	No. of Flutes	OAL	Square Length		Shank Diameter	Square Size	EDP No.			
	UNC	UNF				L	kl			d	k	Bright	Steam Oxide
1/4	20	—	H2	3	2.5000	0.3100	0.2550	0.1910	—	B0402	—	D2402	
			H3		2.5000	0.3100	0.2550	0.1910	B1403	B0403	B2403	D2403	
			H5		2.5000	0.3100	0.2550	0.1910	B1405	B0405	B2405	D2405	
			H7		2.5000	0.3100	0.2550	0.1910	—	B0407	—	D2407	
	—	28	H2		2.5000	0.3100	0.2550	0.1910	—	—	—	—	D2422
			H3		2.5000	0.3100	0.2550	0.1910	B1423	B0423	B2423	D2423	
			H4		2.5000	0.3100	0.2550	0.1910	—	B0424	—	D2424	
			H5		2.5000	0.3100	0.2550	0.1910	—	B0425	—	D2425	
			H6		2.5000	0.3100	0.2550	0.1910	—	B0426	—	D2426	
			H7		2.5000	0.3100	0.2550	0.1910	—	B0427	—	D2427	
5/16	18	—	H3	2.7200	0.3800	0.3180	0.2380	B1443	B0443	B2443	D2443		
			H5	2.7200	0.3800	0.3180	0.2380	B1445	B0445	B2445	D2445		
			H7	2.7200	0.3800	0.3180	0.2380	—	B0447	—	D2447		
	—	24	H3	2.7200	0.3800	0.3180	0.2380	B1463	B0463	B2463	D2463		
			H4	2.7200	0.3800	0.3180	0.2380	—	B0464	—	D2464		
			H5	2.7200	0.3800	0.3180	0.2380	—	B0465	—	D2465		
3/8	16	—	H3	2.9400	0.4400	0.3810	0.2860	B1483	B0483	B2483	D2483		
			H5	2.9400	0.4400	0.3810	0.2860	B1485	B0485	B2485	D2485		
			H7	2.9400	0.4400	0.3810	0.2860	—	B0487	—	D2487		
	—	24	H3	2.9400	0.4400	0.3810	0.2860	B1503	B0503	B2503	D2503		
			H4	2.9400	0.4400	0.3810	0.2860	—	—	—	D2504		
			H5	2.9400	0.4400	0.3810	0.2860	—	B0505	—	D2505		

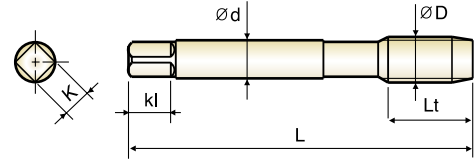
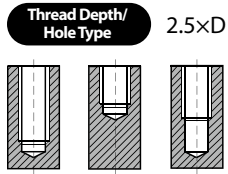
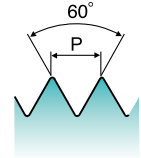
NEXT PAGE ►

► See recommended cutting speed on page 17.

► See application information on pages 21–29.

SPIRAL FLUTE TAPS MODIFIED BOTTOMING STYLE

B1 | B0 | B2 | D2 SERIES



VA
HSSE-V3
UNC UNF
USCTI 302A
2P~3P
Bright
Steam Oxide
TiN
Hardslick
R45

Unit: Inch

Size	Threads Per Inch		Limit	No. of Flutes	OAL	Square Length	Shank Diameter	Square Size	EDP No.			
	UNC	UNF							L	kl	d	k
7/16	14	—	H3	3	3.1600	0.4100	0.3230	0.2420	B1523	B0523	B2523	D2523
			H5		3.1600	0.4100	0.3230	0.2420	B1525	B0525	B2525	D2525
			H7		3.1600	0.4100	0.3230	0.2420	—	—	—	D2527
	—	20	H3		3.1600	0.4100	0.3230	0.2420	B1543	B0543	B2543	D2543
			H5		3.1600	0.4100	0.3230	0.2420	B1545	B0545	B2545	D2545
			H7		3.1600	0.4100	0.3230	0.2420	—	B0547	—	D2547
1/2	13	—	H3	3	3.3800	0.4400	0.3670	0.2750	B1563	B0563	B2563	D2563
			H5		3.3800	0.4400	0.3670	0.2750	B1565	B0565	B2565	D2565
			H7		3.3800	0.4400	0.3670	0.2750	—	—	—	D2567
	—	20	H3		3.3800	0.4400	0.3670	0.2750	B1583	B0583	B2583	D2583
			H5		3.3800	0.4400	0.3670	0.2750	—	B0585	—	D2585
			H6		3.3800	0.4400	0.3670	0.2750	—	—	—	D2586
9/16	12	—	H3	3	3.5900	0.5000	0.4290	0.3220	B1603	B0603	B2603	D2603
	—	18	H3		3.5900	0.5000	0.4290	0.3220	B1623	B0623	B2623	D2623
5/8	11	—	H3	4	3.8100	0.5600	0.4800	0.3600	B1643	B0643	B2643	D2643
			H5		3.8100	0.5600	0.4800	0.3600	B1645	B0645	B2645	D2645
	—	18	H3		3.8100	0.5600	0.4800	0.3600	B1663	B0663	B2663	D2663
			H5		3.8100	0.5600	0.4800	0.3600	B1665	B0665	B2665	D2665
3/4	10	—	H3	4	4.2500	0.6900	0.5900	0.4420	B1703	B0703	B2703	D2703
			H6		4.2500	0.6900	0.5900	0.4420	—	B0706	—	D2706
	—	16	H3		4.2500	0.6900	0.5900	0.4420	B1723	B0723	B2723	D2723
			H5		4.2500	0.6900	0.5900	0.4420	B1725	B0725	B2725	D2725
7/8	9	—	H4	4	4.6900	0.7500	0.6970	0.5230	B1744	B0744	B2744	D2744
	—	14	H4		4.6900	0.7500	0.6970	0.5230	B1764	B0764	B2764	D2764
1	8	—	H4	4	5.1300	0.8100	0.8000	0.6000	B1784	B0784	B2784	D2784
	—	12	H4		5.1300	0.8100	0.8000	0.6000	B1804	B0804	B2804	D2804

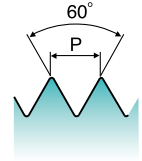
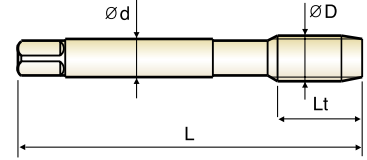
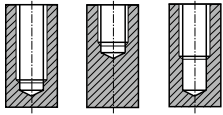
- ▶ See recommended cutting speed on page 17.
- ▶ See application information on pages 21–29.

EXTENDED-LENGTH SPIRAL FLUTE TAPS MODIFIED BOTTOMING STYLE

G7 | G8 | G9 | H0 SERIES

Extended length for greater reach

**Thread Depth/
Hole Type** 2.5×D



VA
P-HSS
UNC UNF
USCTI Long Shank
2P~3P
TiN
Hardslick
R45

Unit: Inch

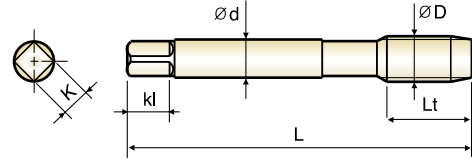
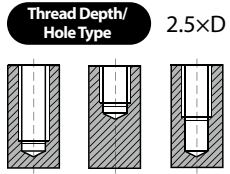
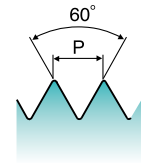
Size	Threads Per Inch		Limit	No. of Flutes	Thread Length Lt	Shank Diameter d	Square Size k	EDP No.			
	UNC	UNF						TiN 4" OAL	TiN 6" OAL	Hardslick 4" OAL	Hardslick 6" OAL
#4	40	—	H2	3	0.2360	0.1410	0.1100	G7162	—	G9162	—
#6	32	—	H3	3	0.2760	0.1410	0.1100	G7243	G8243	G9243	H0243
#8	32	—	H3	3	0.2760	0.1680	0.1310	G7283	G8283	G9283	H0283
#10	24	—	H3	3	0.3540	0.1940	0.1520	G7323	G8323	G9323	H0323
	—	32	H3		0.2760	0.1940	0.1520	G7343	G8343	G9343	H0343
1/4	20	—	H3	3	0.4330	0.2550	0.1910	G7403	G8403	G9403	H0403
	—	28	H3		0.3540	0.2550	0.1910	—	G8423	—	H0423
5/16	18	—	H3	3	0.4720	0.3180	0.2380	—	G8443	—	H0443
	—	24	H3		0.3940	0.3180	0.2380	—	G8463	—	H0463
3/8	16	—	H3	3	0.5510	0.3810	0.2860	—	G8483	—	H0483
	—	24	H3		0.3940	0.3810	0.2860	—	G8503	—	H0503
7/16	14	—	H3	3	0.5910	0.3230	0.2420	—	G8523	—	H0523
	—	20	H3		0.4720	0.3230	0.2420	—	G8543	—	H0543
1/2	13	—	H3	3	0.6300	0.3670	0.2750	—	G8563	—	H0563
	—	20	H3		0.4720	0.3670	0.2750	—	G8583	—	H0583
5/8	11	—	H3	4	0.7480	0.4800	0.3600	—	G8643	—	H0643

► See recommended cutting speed on page 17.

► See application information on pages 21–29.

METRIC SPIRAL FLUTE TAPS MODIFIED BOTTOMING STYLE

BS | BT SERIES



VA
HSSE-V3
M MF
USCTI 302A
2P~3P
Steam Oxide
Hardslick
R45

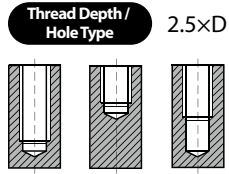
Unit: Metric

Size	Pitch	Limit	No. of Flutes	OAL	Square Length	Shank Diameter	Square Size	EDP No.	
				L	kl	d	k	Steam Oxide	Hardslick
M3	0.5	D3	3	1.9400	0.1900	0.1410	0.1100	BS203	BT203
M3.5	0.6	D4	3	2.0000	0.1900	0.1410	0.1100	BS224	BT224
M4	0.7	D4	3	2.1300	0.2500	0.1680	0.1310	BS244	BT244
M5	0.8	D4	3	2.3800	0.2500	0.1940	0.1520	BS284	BT284
M6	1.0	D5	3	2.5000	0.3100	0.2550	0.1910	BS315	BT315
M7	1.0	D5	3	2.7200	0.3800	0.3180	0.2380	BS345	BT345
M8	1.25	D5	3	2.7200	0.3800	0.3180	0.2380	BS365	BT365
	1.0	D5	3	2.7200	0.3800	0.3180	0.2380	BS375	BT375
M10	1.5	D6	3	2.9400	0.4400	0.3810	0.2860	BS426	BT426
	1.25	D5	3	2.9400	0.4400	0.3810	0.2860	BS435	BT435
M12	1.75	D6	3	3.3800	0.4400	0.3670	0.2750	BS506	BT506
	1.25	D5	3	3.3800	0.4400	0.3670	0.2750	BS525	BT525
M14	2.0	D7	3	3.5900	0.5000	0.4290	0.3220	BS547	BT547
	1.5	D6	3	3.5900	0.5000	0.4290	0.3220	BS556	BT556
M16	2.0	D7	3	3.8100	0.5600	0.4800	0.3600	BS607	BT607
	1.5	D6	3	3.8100	0.5600	0.4800	0.3600	BS616	BT616
M18	2.5	D7	4	4.0300	0.6300	0.5420	0.4060	BS657	BT657
	1.5	D6	4	4.0300	0.6300	0.5420	0.4060	BS676	BT676

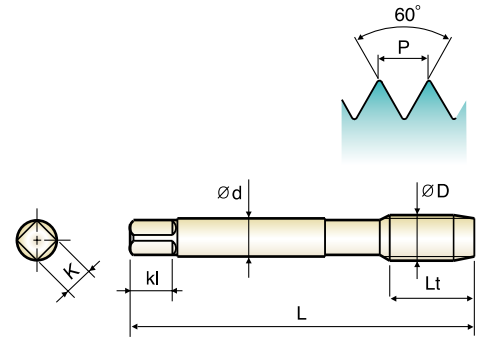
- ▶ See recommended cutting speed on page 17.
- ▶ See application information on pages 21–29.

METRIC SPIRAL FLUTE TAPS MODIFIED BOTTOMING STYLE

E6 | E8 | E9 SERIES



DIN Length/ANSI Shank



VA
HSSE-V3
M MF
2P~3P
Steam Oxide
TICN
Hardslick
R45

Unit: Metric

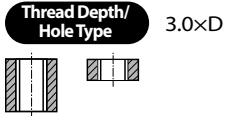
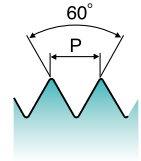
Size	Pitch	Limit	No. of Flutes	OAL	Square Length	Shank Diameter	Square Size	EDP No.		
				L	kl	d	k	Steam Oxide	TICN	Hardslick
M3	0.5	D3	3	2.2050	0.1900	0.1410	0.1100	E6203	E8203	E9203
M3.5	0.6	D4	3	2.2050	0.1900	0.1410	0.1100	E6224	E8224	E9224
M4	0.7	D4	3	2.4800	0.2500	0.1680	0.1310	E6244	E8244	E9244
M5	0.8	D4	3	2.7560	0.2500	0.1940	0.1520	E6284	E8284	E9284
M6	1.0	D5	3	3.1500	0.2800	0.2550	0.1910	E6315	E8315	E9315
M7	1.0	D5	3	3.5430	0.3800	0.3180	0.2380	E6345	E8345	E9345
M8	1.25	D5	3	3.5430	0.3800	0.3180	0.2380	E6365	E8365	E9365
	1.0			3.5430	0.3800	0.3180	0.2380	E6375	E8375	E9375
M10	1.5	D6	3	3.9370	0.4400	0.3810	0.2860	E6426	E8426	E9426
	1.25	D5		3.9370	0.4400	0.3810	0.2860	E6435	E8435	E9435
M12	1.75	D6	3	4.3310	0.4400	0.3670	0.2750	E6506	E8506	E9506
	1.25	D5		3.9370	0.4400	0.3670	0.2750	E6525	E8525	E9525
M14	2.0	D7	3	4.3310	0.5000	0.4290	0.3220	E6547	E8547	E9547
	1.5	D6		3.9370	0.5000	0.4290	0.3220	E6556	E8556	E9556
M16	2.0	D7	3	4.3310	0.5600	0.4800	0.3600	E6607	E8607	E9607
	1.5	D6	4	3.9370	0.5600	0.4800	0.3600	E6616	E8616	E9616
M18	2.5	D7	4	4.9210	0.6300	0.5420	0.4060	E6657	E8657	E9657
	1.5	D6		4.3310	0.6300	0.5420	0.4060	E6676	E8676	E9676

▶ See recommended cutting speed on page 17.

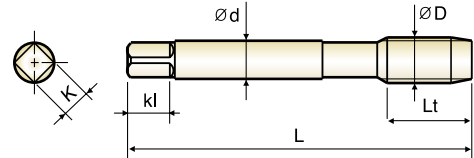
▶ See application information on pages 21–29.

SPIRAL POINT TAPS PLUG STYLE

I0 | I2 | J2 SERIES



USCTI



VA
HSSE-V3
UNC UNF
USCTI 302A
4P~5P
Steam Oxide
TiN
Hardslick

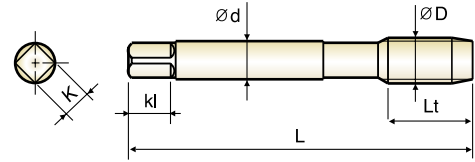
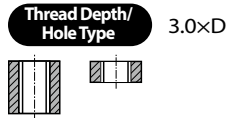
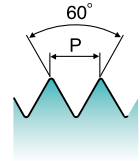
Unit: Inch

Size	Threads Per Inch		Limit	No. of Flutes	OAL	Square Length	Shank Diameter	Square Size	EDP No.		
	UNC	UNF			L	kl	d	k	Steam Oxide	TiN	Hardslick
#2	56		H2	2	1.7500	0.1900	0.1410	0.1100	I0082	I2082	J2082
			H3		1.7500	0.1900	0.1410	0.1100	I0083	—	J2083
			H4		1.7500	0.1900	0.1410	0.1100	I0084	—	J2084
#3	48	—	H2	2	1.8100	0.1900	0.1410	0.1100	I0122	—	J2122
#4	40	—	H2	2	1.8800	0.1900	0.1410	0.1100	I0162	I2162	J2162
			H3		1.8800	0.1900	0.1410	0.1100	I0163	—	J2163
			H4		1.8800	0.1900	0.1410	0.1100	I0164	—	J2164
			H5		1.8800	0.1900	0.1410	0.1100	I0165	—	J2165
			H6		1.8800	0.1900	0.1410	0.1100	I0166	—	J2166
	—	48	H2	1.8800	0.1900	0.1410	0.1100	I0182	—	J2182	
		H4	1.8800	0.1900	0.1410	0.1100	I0184	—	J2184		
#5	40	—	H2	3	1.9400	0.1900	0.1410	0.1100	I0202	I2202	J2202
#6	32	—	H3	3	2.0000	0.1900	0.1410	0.1100	I0243	I2243	J2243
			H3		2.0000	0.1900	0.1410	0.1100	I0244	—	J2244
			H4		2.0000	0.1900	0.1410	0.1100	I0245	—	J2245
			H7		2.0000	0.1900	0.1410	0.1100	I0247	—	J2247
	—	40	H2	2.0000	0.1900	0.1410	0.1100	I0262	—	J2262	
			H3	2.0000	0.1900	0.1410	0.1100	I0263	—	J2263	
#8	32	—	H2	3	2.1300	0.2500	0.1680	0.1310	I0282	—	J2282
			H3		2.1300	0.2500	0.1680	0.1310	I0283	I2283	J2283
			H4		2.1300	0.2500	0.1680	0.1310	I0284	—	J2284
			H5		2.1300	0.2500	0.1680	0.1310	I0285	—	J2286
	—	36	H2	2.1300	0.2500	0.1680	0.1310	I0302	—	J2302	
#10	24	—	H3	3	2.3800	0.2500	0.1940	0.1520	I0323	I2323	J2323
			H4		2.3800	0.2500	0.1940	0.1520	I0324	—	J2324
			H5		2.3800	0.2500	0.1940	0.1520	I0325	—	J2325
	—	32	H2		2.3800	0.2500	0.1940	0.1520	I0342	—	J2342
			H3		2.3800	0.2500	0.1940	0.1520	I0343	I2343	J2343
			H4		2.3800	0.2500	0.1940	0.1520	I0344	—	J2344

- ▶ See recommended cutting speed on page 17.
- ▶ See application information on pages 21–29.

SPIRAL POINT TAPS PLUG STYLE

10 | 12 | J2 SERIES



VA
HSSE-V3
UNC UNF
USCTI 302A
4P~5P
Steam Oxide
TiN
Hardslick

Unit: Inch

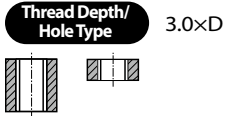
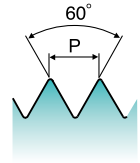
Size	Threads Per Inch		Limit	No. of Flutes	OAL	Square Length	Shank Diameter	Square Size	EDP No.		
	UNC	UNF			L	kl	d	k	Steam Oxide	TiN	Hardslick
#10	—	32	H5	3	2.3800	0.2500	0.1940	0.1520	I0345	—	J2345
					2.3800	0.2500	0.1940	0.1520	I0346	—	J2346
					2.3800	0.2500	0.1940	0.1520	I0347	—	J2347
#12	24	—	H3	3	2.3800	0.2800	0.2200	0.1650	I0363	—	J2363
	—	28			2.3800	0.2800	0.2200	0.1650	I0383	—	J2383
1/4	20	—	H2	3	2.5000	0.3100	0.2550	0.1910	I0402	—	J2402
			H3		2.5000	0.3100	0.2550	0.1910	I0403	I2403	J2403
			H5		2.5000	0.3100	0.2550	0.1910	I0405	I2405	J2405
			H7		2.5000	0.3100	0.2550	0.1910	I0407	—	J2407
	—	28	H2		2.5000	0.3100	0.2550	0.1910	—	—	J2422
			H3		2.5000	0.3100	0.2550	0.1910	I0423	I2423	J2423
			H4		2.5000	0.3100	0.2550	0.1910	I0424	—	J2424
			H5		2.5000	0.3100	0.2550	0.1910	I0425	—	J2425
			H6		2.5000	0.3100	0.2550	0.1910	I0426	—	J2426
			H7		2.5000	0.3100	0.2550	0.1910	I0427	—	J2427
5/16	18	—	H3	3	2.7200	0.3800	0.3180	0.2380	I0443	I2443	J2443
			H5		2.7200	0.3800	0.3180	0.2380	I0445	I2445	J2445
			H7		2.7200	0.3800	0.3180	0.2380	I0447	—	J2447
	—	24	H3		2.7200	0.3800	0.3180	0.2380	I0463	I2463	J2463
			H4		2.7200	0.3800	0.3180	0.2380	I0464	—	J2464
			H5		2.7200	0.3800	0.3180	0.2380	I0465	—	J2465
			H6		2.7200	0.3800	0.3180	0.2380	I0466	—	J2466
3/8	16	—	H3	3	2.9400	0.4400	0.3810	0.2860	I0483	I2483	J2483
			H5		2.9400	0.4400	0.3810	0.2860	I0485	I2485	J2485
			H7		2.9400	0.4400	0.3810	0.2860	I0487	—	J2487
	—	24	H3		2.9400	0.4400	0.3810	0.2860	I0503	I2503	J2503
			H4		2.9400	0.4400	0.3810	0.2860	I0504	—	J2504
			H5		2.9400	0.4400	0.3810	0.2860	I0505	—	J2505
			H7		2.9400	0.4400	0.3810	0.2860	I0507	—	J2507

► See recommended cutting speed on page 17.

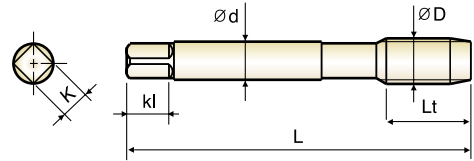
► See application information on pages 21–29.

SPIRAL POINT TAPS PLUG STYLE

I0 | I2 | J2 SERIES



USCTI



VA
HSSE-V3
UNC UNF
USCTI 302A
4P~5P
Steam Oxide
TiN
Hardslick

Unit: Inch

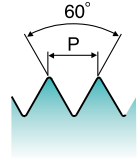
Size	Threads Per Inch		Limit	No. of Flutes	OAL	Square Length	Shank Diameter	Square Size	EDP No.		
	UNC	UNF			L	kl	d	k	Steam Oxide	TiN	Hardslick
7/16	14	—	H3	3	3.1600	0.4100	0.3230	0.2420	I0523	I2523	J2523
			H5		3.1600	0.4100	0.3230	0.2420	I0525	I2525	J2525
	—	20	H3		3.1600	0.4100	0.3230	0.2420	I0543	I2543	J2543
			H5		3.1600	0.4100	0.3230	0.2420	I0545	I2545	J2545
1/2	13	—	H3	3	3.3800	0.4400	0.3670	0.2750	I0563	I2563	J2563
			H5		3.3800	0.4400	0.3670	0.2750	I0565	I2565	J2565
	—	20	H3		3.3800	0.4400	0.3670	0.2750	I0583	I2583	J2583
			H5		3.3800	0.4400	0.3670	0.2750	I0585	—	J2585
9/16	12	—	H3	3	3.5900	0.5000	0.4290	0.3220	I0603	I2603	J2603
	—	18	H3		3.5900	0.5000	0.4290	0.3220	I0623	I2623	J2623
5/8	11	—	H3	3	3.8100	0.5600	0.4800	0.3600	I0643	I2643	J2643
			H5		3.8100	0.5600	0.4800	0.3600	I0645	I2645	J2645
	—	18	H3		3.8100	0.5600	0.4800	0.3600	I0663	—	J2663
			H5		3.8100	0.5600	0.4800	0.3600	I0665	I2665	J2665
			H7		3.8100	0.5600	0.4800	0.3600	I0667	—	J2667
3/4	10	—	H3	3	4.2500	0.6900	0.5900	0.4420	I0703	I2703	J2703
	—	16	H5		4.2500	0.6900	0.5900	0.4420	I0725	I2725	J2725
7/8	9	—	H4	3	4.6900	0.7500	0.6970	0.5230	I0744	I2744	J2744
	—	14	H6		4.6900	0.7500	0.6970	0.5230	I0766	I2766	J2766
1	8	—	H4	3	5.1300	0.8100	0.8000	0.6000	I0784	I2784	J2784
	—	12	H6		5.1300	0.8100	0.8000	0.6000	I0806	I2806	J2806

- ▶ See recommended cutting speed on page 17.
- ▶ See application information on pages 21–29.

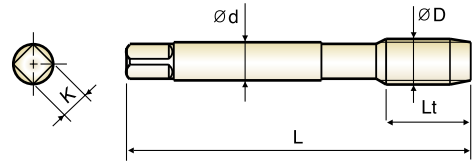
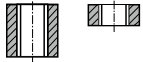
EXTENDED-LENGTH SPIRAL POINT TAPS PLUG STYLE

M0 | M1 | M2 | M3 SERIES

Extended length for greater reach



**Thread Depth/
Hole Type** 3.0×D



VA
P-HSS
UNC
UNF
USCTI
Long Shank
4P~5P
TIN
Hardslick

Unit: Inch

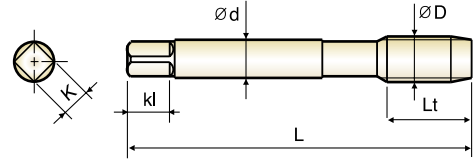
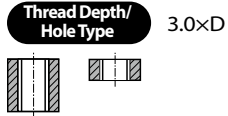
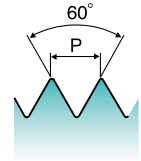
Size	Threads Per Inch		Limit	No. of Flutes	Maximum Tapping Depth	Thread Length	Shank Diameter	Square Size	EDP No.			
	UNC	UNF							TIN 4" OAL	TIN 6" OAL	Hardslick 4" OAL	Hardslick 6" OAL
#4	40	—	H2	2	0.844	8.51	0.1410	0.1100	M0162	—	M2162	—
#6	32	—	H3	2	1.031	10.49	0.1410	0.1100	M0243	M1243	M2243	M3243
#8	32	—	H3	3	1.125	11.51	0.1680	0.1310	M0283	M1283	M2283	M3283
#10	24	—	H3	3	1.312	13.49	0.1940	0.1520	M0323	M1323	M2323	M3323
	—	32				13.49	0.1940	0.1520	M0343	M1343	M2343	M3343
1/4	20	—	H3	3	1.500	15.01	0.2550	0.1910	M0403	M1403	M2403	M3403
	—	28				15.01	0.2550	0.1910	—	M1423	—	M3423
5/16	18	—	H3	3	1.688	16.99	0.3180	0.2380	—	M1443	—	M3443
	—	24			1.688	16.99	0.3180	0.2380	—	M1463	—	M3463
3/8	16	—	H3	3	1.875	19.00	0.3810	0.2860	—	M1483	—	M3483
	—	24			—	19.00	0.3810	0.2860	—	M1503	—	M3503
7/16	14	—	H3	3	—	22.00	0.3230	0.2420	—	M1523	—	M3523
	—	20			—	22.00	0.3230	0.2420	—	M1543	—	M3543
1/2	13	—	H3	3	—	24.99	0.3670	0.2750	—	M1563	—	M3563
	—	20			—	24.99	0.3670	0.2750	—	M1583	—	M3583
9/16	12	—	H3	3	—	24.99	0.4290	0.3220	—	M1603	—	M3603
	—	18			—	24.99	0.4290	0.3220	—	M1623	—	M3623
5/8	11	—	H3	3	—	27.51	0.4800	0.3600	—	M1643	—	M3643

▶ See recommended cutting speed on page 17.

▶ See application information on pages 21–29.

METRIC SPIRAL POINT TAPS PLUG STYLE

09 | IA SERIES



VA
HSSE-V3
M MF
USCTI 302A
4P~5P
Steam Oxide
Hardslick

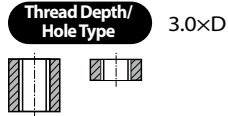
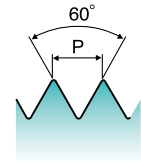
Unit: Metric

Size	Pitch	Limit	No. of Flutes	OAL	Square Length	Shank Diameter	Square Size	EDP No.	
				L	kl	d	k	Steam Oxide	Hardslick
M3	0.5	D3	3	1.9400	0.1900	0.1410	0.1100	O9203	IA203
M3.5	0.6	D4	3	2.0000	0.1900	0.1410	0.1100	O9224	IA224
M4	0.7	D4	3	2.1300	0.2500	0.1680	0.1310	O9244	IA244
M5	0.8	D4	3	2.3800	0.2500	0.1940	0.1520	O9284	IA284
M6	1.0	D5	3	2.5000	0.3100	0.2550	0.1910	O9315	IA315
M7	1.0	D5	3	2.7200	0.3800	0.3180	0.2380	O9345	IA345
M8	1.25	D5	3	2.7200	0.3800	0.3180	0.2380	O9365	IA365
	1.0			2.7200	0.3800	0.3180	0.2380	O9375	IA375
M10	1.5	D6	3	2.9400	0.4400	0.3810	0.2860	O9426	IA426
	1.25	D5		2.9400	0.4400	0.3810	0.2860	O9435	IA435
M12	1.75	D6	3	3.3800	0.4400	0.3670	0.2750	O9506	IA506
	1.25	D5		3.3800	0.4400	0.3670	0.2750	O9525	IA525
M14	2.0	D7	3	3.5900	0.5000	0.4290	0.3220	O9547	IA547
	1.5	D6		3.5900	0.5000	0.4290	0.3220	O9556	IA556
M16	2.0	D7	3	3.8100	0.5600	0.4800	0.3600	O9607	IA607
	1.5	D6		3.8100	0.5600	0.4800	0.3600	O9616	IA616
M18	2.5	D7	3	4.0300	0.6300	0.5420	0.4060	O9657	IA657
	1.5	D6		4.0300	0.6300	0.5420	0.4060	O9676	IA676

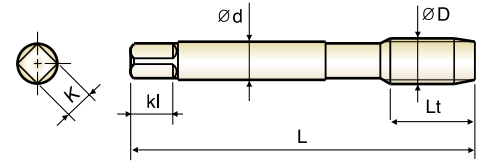
- ▶ See recommended cutting speed on page 17.
- ▶ See application information on pages 21–29.

METRIC SPIRAL POINT TAPS PLUG STYLE

K3 | K5 | K6 SERIES



DIN Length/ANSI Shank



VA
HSSE-V3
M MF
4P~5P
Steam Oxide
TICN
Hardslick

Unit: Metric

Size	Pitch	Limit	No. of Flutes	OAL	Square Length	Shank Diameter	Square Size	EDP No.		
				L	kl	d	k	Steam Oxide	TICN	Hardslick
M3	0.5	D3	3	2.2050	0.1900	0.1410	0.1100	K3203	K5203	K6203
M3.5	0.6	D4	3	2.2050	0.1900	0.1410	0.1100	K3224	K5224	K6224
M4	0.7	D4	3	2.4800	0.2500	0.1680	0.1310	K3244	K5244	K6244
M5	0.8	D4	3	2.7560	0.2500	0.1940	0.1520	K3284	K5284	K6284
M6	1.0	D5	3	3.1500	0.2800	0.2550	0.1910	K3315	K5315	K6315
M7	1.0	D5	3	3.5430	0.3800	0.3180	0.2380	K3345	K5345	K6345
M8	1.25	D5	3	3.5430	0.3800	0.3180	0.2380	K3365	K5365	K6365
	1.0			3.5430	0.3800	0.3180	0.2380	K3375	K5375	K6375
M10	1.5	D6	3	3.9370	0.4400	0.3810	0.2860	K3426	K5426	K6426
	1.25	D5		3.9370	0.4400	0.3810	0.2860	K3435	K5435	K6435
M12	1.75	D6	3	4.3310	0.4400	0.3670	0.2750	K3506	K5506	K6506
	1.25	D5		3.9370	0.4400	0.3670	0.2750	K3525	K5525	K6525
M14	2.0	D7	3	4.3310	0.5000	0.4290	0.3220	K3547	K5547	K6547
	1.5	D6		3.9370	0.5000	0.4290	0.3220	K3556	K5556	K6556
M16	2.0	D7	3	4.3310	0.5600	0.4800	0.3600	K3607	K5607	K6607
	1.5	D6		3.9370	0.5600	0.4800	0.3600	K3616	K5616	K6616
M18	2.5	D7	3	4.9210	0.6300	0.5420	0.4060	K3657	K5657	K6657
	1.5	D6		4.3310	0.6300	0.5420	0.4060	K3676	K5676	K6676

► See application information on pages 21–29.

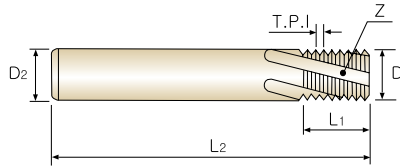
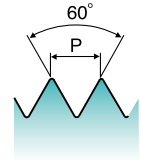
RECOMMENDED CUTTING SPEED

Unit: Inch

MATERIAL	M								
	STAINLESS STEEL (FREE MACHING) 303, 416, 420F, 430F, 440F			STAINLESS STEEL (DIFFICULT) 304, 304L, 316, 316L			STAINLESS STEEL (PH) 13-8 PH, 15-5PH, 17-4 PH, Custom 450		
ISO HARDNESS (BHN)	M < 250			M < 275			M < 325		
 THROUGH HOLES	min. 40	start 60	max. 75	min. 25	start 35	max. 55	min. 30	start 45	max. 60
 BLIND HOLES	min. 25	start 40	max. 55	min. 20	start 25	max. 35	min. 15	start 20	max. 30

SOLID CARBIDE THREAD MILL FOR UNIFIED INTERNAL THREADS - ANSI B 1.1

TE SERIES



- ▶ Material: solid carbide
- ▶ Shank: plain straight
- ▶ Spiral angle: 15°

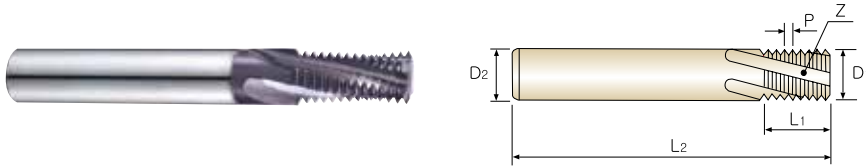
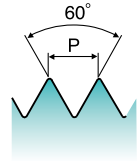
Unit: Inch

Size	Pitch	Cutter Diameter	Shank Diameter	Thread Length	Overall Length	No. of Flutes	EDP No.
							TAIN
	TPI	D ₁	D ₂	L ₁	L ₂	Z	
#2	56	.065	.125	.125	2.000	3	TE080
#3	48	.075	.125	.167	2.000	3	TE120
#5	44	.095	.125	.228	2.000	3	TE220
#4	40	.085	.125	.175	2.000	3	TE160
#8	36	.115	.125	.250	2.000	3	TE300
#6	32	.100	.125	.218	2.000	3	TE240
#8	32	.115	.125	.250	2.000	3	TE280
#10	32	.120	.125	.312	2.000	3	TE340
1/2	32	.370	.375	1.000	3.500	4	TEF90
#10	28	.120	.125	.312	2.000	3	TEK90
1/4	28	.180	.187	.500	2.500	3	TE420
1/2	28	.370	.375	1.000	3.500	4	TE590
#10	24	.120	.125	.312	2.000	3	TE320
5/16	24	.235	.250	.625	2.500	3	TE460
3/8	24	.285	.312	.750	3.000	4	TE500
1/2	24	.370	.375	1.000	3.500	4	TE570
1/4	20	.180	.187	.500	2.500	3	TE400
7/16	20	.335	.375	.875	3.500	4	TE540
1/2	20	.370	.375	1.000	3.500	4	TE580
5/16	18	.235	.250	.625	2.500	3	TE440
9/16	18	.370	.375	.875	3.500	4	TE620
3/8	16	.285	.312	.750	3.000	4	TE480
3/4	16	.490	.500	1.250	3.500	4	TE720
7/16	14	.305	.312	.750	3.000	4	TE520
7/8	14	.490	.500	1.250	3.500	4	TE760
1/2	13	.350	.375	.875	3.500	4	TE560
9/16	12	.370	.375	.875	3.500	4	TE600
3/4	12	.495	.500	1.250	3.500	4	TE710
5/8	11	.470	.500	1.250	3.500	4	TE640
3/4	10	.495	.500	1.250	3.500	4	TE700
7/8	9	.620	.625	1.375	4.000	4	TE740
1	8	.620	.625	1.375	4.000	4	TE780
	12	.745	.750	1.500	4.000	5	TE800
1-1/8 & 1-1/4	7	.745	.750	1.572	4.500	5	TE820

▶ See recommended cutting speed on page 20.

SOLID CARBIDE THREAD MILL FOR METRIC INTERNAL THREADS - DIN 13

TD SERIES



- ▶ Material: solid carbide
- ▶ Shank: plain straight
- ▶ Spiral angle: 15°

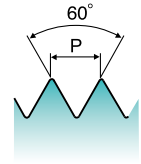
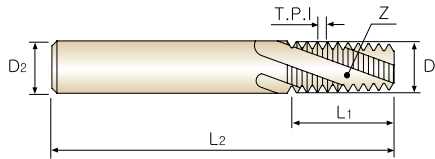
Unit: Metric

Size	Pitch (mm)	Cutter Diameter	Shank Diameter	Thread Length	Overall Length	No. of Flutes	EDP No.
	P	D ₁	D ₂	L ₁	L ₂	Z	TIAIN
M3	0.50	.085	.125	.178	2.000	3	TD200
M4	0.70	.115	.125	.276	2.000	3	TD240
M4.5	0.75	.120	.125	.250	2.000	3	TD260
M8	0.75	.235	.250	.625	2.500	3	TD380
M5	0.80	.120	.125	.312	2.000	3	TD280
M6	1.00	.170	.187	.500	2.500	3	TD310
M12	1.00	.360	.375	.875	3.500	4	TD530
M8	1.25	.235	.250	.625	2.500	3	TD360
M10	1.50	.300	.312	.750	3.000	4	TD420
M14	1.50	.370	.375	.875	3.500	4	TD550
M18	1.50	.490	.500	1.250	3.500	4	TD670
M12	1.75	.360	.375	.875	3.500	4	TD500
M16	2.00	.470	.500	1.250	3.500	4	TD600
M20	2.50	.495	.500	1.250	3.500	4	TD700
M24	3.00	.620	.625	1.375	4.000	4	TD780

▶ See recommended cutting speed on page 20.

SOLID CARBIDE THREAD MILL FOR UNIFIED INTERNAL THREADS ANSI B 1.20.1 (NPT) / ANSI B1.20.3 (NPTF)

TF | TG SERIES



- ▶ Material: solid carbide
- ▶ Shank: plain straight
- ▶ Spiral angle: 15°

TF Series (NPT)

Unit: Inch

Size	Pitch	Cutter Diameter	Shank Diameter	Thread Length	Overall Length	No. of Flutes	EDP No.
	TPI	D ₁	D ₂	L ₁	L ₂	Z	TIAIN
1/16 & 1/8	27	.245	.250	.437	2.500	3	TF020
1/4 & 3/8	18	.305	.312	.625	3.000	4	TF400
1/4 & 3/8	18	.363	.375	.680	3.500	4	TF480
1/2 & 3/4	14	.495	.500	.875	3.500	4	TF560
1"-2"	11.5	.620	.625	1.125	4.000	4	TF780
2-1/2"-6"	8	.745	.750	1.500	5.000	4	TFF40

TG Series (NPTF)

Unit: Inch

Size	Pitch	Cutter Diameter	Shank Diameter	Thread Length	Overall Length	No. of Flutes	EDP No.
	TPI	D ₁	D ₂	L ₁	L ₂	Z	TIAIN
1/16 & 1/8	27	.245	.250	.437	2.500	3	TG020
1/4 & 3/8	18	.305	.312	.625	3.000	4	TG400
1/2 & 3/4	14	.495	.500	.875	3.500	4	TG560
1"-2"	11.5	.620	.625	1.125	4.000	4	TG780
2-1/2"-6"	8	.745	.750	1.500	5.000	4	TGF40

RECOMMENDED CUTTING SPEED

MATERIAL	CUTTING SPEED (SFM)	FEED PER TOOTH (FZ)	
		Cutter Diameter < 5/16	Cutter Diameter > 5/16
M STAINLESS STEELS	150 - 250	.0004 - .0008	.0008 - .0024

TAP DRILL SIZES – UNIFIED THREAD

Size	Threads Per Inch				Minor Diameter			Tap Drill Diameter (Cutting Tap)				
	UNC	UNF	UNEF	UN	Min. 2B&3B	Max. 2B	Max. 3B	80% Thread	75% Thread	70% Thread	65% Thread	60% Thread
#0	-	80	-	-	.0465	.0514	.0514	.0470	.0478	.0486	.0494	.0503
#1	64	-	-	-	.0561	.0623	.0623	.0568	.0578	.0588	.0598	.0608
	-	72	-	-	.0580	.0635	.0635	.0586	.0595	.0604	.0613	.0622
#2	56	-	-	-	.0667	.0737	.0737	.0674	.0686	.0698	.0709	.0721
	-	64	-	-	.0691	.0753	.0753	.0698	.0708	.0718	.0728	.0738
#3	48	-	-	-	.0764	.0845	.0845	.0774	.0787	.0801	.0814	.0828
	-	56	-	-	.0797	.0865	.0865	.0804	.0816	.0828	.0839	.0851
#4	40	-	-	-	.0849	.0939	.0939	.0860	.0876	.0893	.0909	.0925
	-	48	-	-	.0894	.0968	.0968	.0904	.0917	.0931	.0944	.0958
#5	40	-	-	-	.0979	.1062	.1062	.0990	.1006	.1023	.1039	.1055
	-	44	-	-	.1004	.1079	.1079	.1014	.1029	.1043	.1058	.1073
#6	32	-	-	-	.1040	.1140	.1140	.1055	.1076	.1096	.1116	.1136
	-	40	-	-	.1110	.1190	.1186	.1120	.1136	.1153	.1169	.1185
#8	32	-	-	-	.1300	.1390	.1389	.1315	.1336	.1356	.1376	.1396
	-	36	-	-	.1340	.1420	.1416	.1351	.1369	.1387	.1405	.1424
#10	24	-	-	-	.1450	.1560	.1555	.1467	.1494	.1521	.1548	.1575
	-	32	-	-	.1560	.1640	.1641	.1575	.1596	.1616	.1636	.1656
#12	24	-	-	-	.1710	.1810	.1807	.1727	.1754	.1781	.1808	.1835
	-	28	-	-	.1770	.1860	.1857	.1789	.1812	.1835	.1858	.1882
	-	-	32	-	.1820	.1900	.1895	.1835	.1856	.1876	.1896	.1916
1/4	20	-	-	-	.1960	.2070	.2067	.1980	.2013	.2045	.2078	.2110
	-	28	-	-	.2110	.2200	.2190	.2129	.2152	.2175	.2198	.2222
	-	-	32	-	.2160	.2240	.2229	.2175	.2196	.2216	.2236	.2256
5/16	18	-	-	-	.2520	.2650	.2630	.2548	.2584	.2620	.2656	.2692
	-	-	-	20	.2580	.2700	.2680	.2605	.2638	.2670	.2703	.2735
	-	24	-	-	.2670	.2770	.2754	.2692	.2719	.2746	.2773	.2800
	-	-	-	28	.2740	.2820	.2807	.2754	.2777	.2800	.2823	.2847
	-	-	32	-	.2790	.2860	.2847	.2800	.2821	.2841	.2861	.2881
3/8	16	-	-	-	.3070	.3210	.3182	.3101	.3141	.3182	.3222	.3263
	-	-	-	20	.3210	.3320	.3297	.3230	.3263	.3295	.3328	.3360
	-	24	-	-	.3300	.3400	.3372	.3317	.3344	.3371	.3398	.3425
	-	-	-	28	.3360	.3450	.3426	.3379	.3402	.3425	.3448	.3472
	-	-	32	-	.3410	.3490	.3469	.3425	.3446	.3466	.3486	.3506
7/16	14	-	-	-	.3600	.3760	.3717	.3633	.3679	.3726	.3772	.3818
	-	-	-	16	.3700	.3840	.3800	.3726	.3766	.3807	.3847	.3888
	-	20	-	-	.3830	.3950	.3916	.3855	.3888	.3920	.3953	.3985
	-	-	28	-	.3990	.4070	.4051	.4004	.4027	.4050	.4073	.4097
	-	-	-	32	.4040	.4110	.4094	.4050	.4071	.4091	.4111	.4131
1/2	13	-	-	-	.4170	.4340	.4284	.4201	.4251	.4301	.4351	.4400
	-	-	-	16	.4320	.4460	.4419	.4351	.4391	.4432	.4472	.4513
	-	20	-	-	.4460	.4570	.4537	.4480	.4513	.4545	.4578	.4610
	-	-	28	-	.4610	.4700	.4676	.4629	.4652	.4675	.4698	.4722
	-	-	-	32	.4660	.4740	.4719	.4675	.4696	.4716	.4736	.4756
9/16	12	-	-	-	.4720	.4900	.4843	.4759	.4813	.4867	.4921	.4976
	-	-	-	16	.4950	.5090	.5040	.4976	.5016	.5057	.5097	.5138
	-	18	-	-	.5020	.5150	.5106	.5048	.5084	.5120	.5156	.5192
	-	-	-	20	.5080	.5200	.5162	.5105	.5138	.5170	.5203	.5235
	-	-	24	-	.5170	.5270	.5244	.5192	.5219	.5246	.5273	.5300
	-	-	-	28	.5240	.5320	.5301	.5254	.5277	.5300	.5323	.5347
5/8	-	-	-	32	.5290	.5360	.5344	.5300	.5321	.5341	.5361	.5381
	11	-	-	-	.5270	.5460	.5391	.5305	.5364	.5423	.5482	.5541

TAP DRILL SIZES – UNIFIED THREAD

Size	Threads Per Inch				Minor Diameter			Tap Drill Diameter (Cutting Tap)				
	UNC	UNF	UNEF	UN	Min. 2B&3B	Max. 2B	Max. 3B	80% Thread	75% Thread	70% Thread	65% Thread	60% Thread
5/8	-	-	-	12	.5350	.5530	.5463	.5384	.5438	.5492	.5546	.5601
	-	-	-	16	.5570	.5710	.5662	.5601	.5641	.5682	.5722	.5763
	-	18	-	-	.5650	.5780	.5730	.5673	.5709	.5745	.5781	.5817
	-	-	-	20	.5710	.5820	.5787	.5730	.5763	.5795	.5828	.5860
	-	-	24	-	.5800	.5900	.5869	.5817	.5844	.5871	.5898	.5925
	-	-	-	28	.5860	.5950	.5926	.5879	.5902	.5925	.5948	.5972
11/16	-	-	-	32	.5910	.5980	.5969	.5925	.5946	.5966	.5986	.6006
	-	-	-	12	.5970	.6150	.6085	.6009	.6063	.6117	.6171	.6226
	-	-	-	16	.6200	.6340	.6284	.6226	.6266	.6307	.6347	.6388
	-	-	-	20	.6330	.6450	.6412	.6355	.6388	.6420	.6453	.6485
	-	-	24	-	.6420	.6520	.6494	.6442	.6469	.6496	.6523	.6550
	-	-	-	28	.6490	.6570	.6551	.6504	.6527	.6550	.6573	.6597
3/4	-	-	-	32	.6540	.6610	.6594	.6550	.6571	.6591	.6611	.6631
	10	-	-	-	.6420	.6630	.6545	.6461	.6526	.6591	.6656	.6721
	-	-	-	12	.6600	.6780	.6707	.6634	.6688	.6742	.6796	.6851
	-	16	-	-	.6820	.6960	.6908	.6851	.6891	.6932	.6972	.7013
	-	-	20	-	.6960	.7070	.7037	.6980	.7013	.7045	.7078	.7110
	-	-	-	28	.7110	.7200	.7176	.7129	.7152	.7175	.7198	.7222
13/16	-	-	-	32	.7160	.7240	.7219	.7175	.7196	.7216	.7236	.7256
	-	-	-	12	.7220	.7400	.7329	.7259	.7313	.7367	.7421	.7476
	-	-	-	16	.7450	.7590	.7533	.7476	.7516	.7557	.7597	.7638
	-	-	20	-	.7580	.7700	.7662	.7605	.7638	.7670	.7703	.7735
	-	-	-	28	.7740	.7820	.7801	.7754	.7777	.7800	.7823	.7847
	-	-	-	32	.7790	.7860	.7844	.7800	.7821	.7841	.7861	.7881
7/8	9	-	-	-	.7550	.7780	.7681	.7595	.7668	.7740	.7812	.7884
	-	-	-	12	.7850	.8030	.7948	.7884	.7938	.7992	.8046	.8101
	-	14	-	-	.7980	.8140	.8068	.8008	.8054	.8101	.8147	.8193
	-	-	-	16	.8070	.8210	.8158	.8101	.8141	.8182	.8222	.8263
	-	-	20	-	.8210	.8320	.8287	.8230	.8263	.8295	.8328	.8360
	-	-	-	28	.8360	.8450	.8426	.8379	.8402	.8425	.8448	.8472
15/16	-	-	-	32	.8410	.8490	.8469	.8425	.8446	.8466	.8486	.8506
	-	-	-	12	.8470	.8650	.8575	.8509	.8563	.8617	.8671	.8726
	-	-	-	16	.8700	.8840	.8783	.8726	.8766	.8807	.8847	.8888
	-	-	20	-	.8830	.8950	.8912	.8855	.8888	.8920	.8953	.8985
	-	-	-	28	.8990	.9070	.9051	.9004	.9027	.9050	.9073	.9097
	-	-	-	32	.9040	.9110	.9094	.9050	.9071	.9091	.9111	.9131
1	8	-	-	-	.8650	.8900	.8797	.8701	.8782	.8863	.8945	.9026
	-	12	-	-	.9100	.9280	.9198	.9134	.9188	.9242	.9296	.9351
	-	-	-	16	.9320	.9460	.9408	.9351	.9391	.9432	.9472	.9513
	-	-	20	-	.9460	.9570	.9537	.9480	.9513	.9545	.9578	.9610
	-	-	-	28	.9610	.9700	.9676	.9629	.9652	.9675	.9698	.9722
	-	-	-	32	.9660	.9740	.9719	.9675	.9696	.9716	.9736	.9756
1-1/16	-	-	-	8	.9270	.9520	.9422	.9326	.9407	.9488	.9570	.9651
	-	-	-	12	.9720	.9900	.9823	.9759	.9813	.9867	.9921	.9976
	-	-	-	16	.9950	1.0090	1.0033	.9976	1.0016	1.0057	1.0097	1.0138
	-	-	18	-	1.0020	1.0150	1.0105	1.0048	1.0084	1.0120	1.0156	1.0192
	-	-	-	20	1.0080	1.0200	1.0162	1.0105	1.0138	1.0170	1.0203	1.0235
	-	-	-	28	1.0240	1.0320	1.0301	1.0254	1.0277	1.0300	1.0323	1.0347
1-1/8	7	-	-	-	.9700	.9980	.9875	.9765	.9858	.9951	1.0044	1.0137
	-	-	-	8	.9900	1.0150	1.0047	.9951	1.0032	1.0113	1.0195	1.0276
	-	12	-	-	1.0350	1.0530	1.0448	1.0384	1.0438	1.0492	1.0546	1.0601
	-	-	-	16	1.0570	1.0710	1.0658	1.0601	1.0641	1.0682	1.0722	1.0763
	-	-	18	-	1.0650	1.0780	1.0730	1.0673	1.0709	1.0745	1.0781	1.0817
	-	-	-	20	1.0710	1.0820	1.0787	1.0730	1.0763	1.0795	1.0828	1.0860

TAP DRILL SIZES – UNIFIED THREAD

Size	Threads Per Inch				Minor Diameter			Tap Drill Diameter (Cutting Tap)				
	UNC	UNF	UNEF	UN	Min. 2B&3B	Max. 2B	Max. 3B	80% Thread	75% Thread	70% Thread	65% Thread	60% Thread
1-1/8	-	-	-	28	1.0860	1.0950	1.0926	1.0879	1.0902	1.0925	1.0948	1.0972
1-3/16	-	-	-	8	1.0520	1.0770	1.0672	1.0576	1.0657	1.0738	1.0820	1.0901
	-	-	-	12	1.0970	1.1150	1.1073	1.1009	1.1063	1.1117	1.1171	1.1226
	-	-	-	16	1.1200	1.1340	1.1283	1.1226	1.1266	1.1307	1.1347	1.1388
	-	-	18	-	1.1270	1.1400	1.1355	1.1298	1.1334	1.1370	1.1406	1.1442
	-	-	-	20	1.1330	1.1450	1.1412	1.1355	1.1388	1.1420	1.1453	1.1485
	-	-	-	28	1.1490	1.1570	1.1551	1.1504	1.1527	1.1550	1.1573	1.1597
1-1/4	7	-	-	-	1.0950	1.1230	1.1125	1.1015	1.1108	1.1201	1.1294	1.1387
	-	-	-	8	1.1150	1.1400	1.1297	1.1201	1.1282	1.1363	1.1445	1.1526
	-	12	-	-	1.1600	1.1780	1.1698	1.1634	1.1688	1.1742	1.1796	1.1851
	-	-	-	16	1.1820	1.1960	1.1908	1.1851	1.1891	1.1932	1.1972	1.2013
	-	-	18	-	1.1900	1.2030	1.1980	1.1923	1.1959	1.1995	1.2031	1.2067
	-	-	-	20	1.1960	1.2070	1.2037	1.1980	1.2013	1.2045	1.2078	1.2110
1-5/16	-	-	-	28	1.2110	1.2200	1.2176	1.2129	1.2152	1.2175	1.2198	1.2222
	-	-	-	8	1.1770	1.2020	1.1922	1.1826	1.1907	1.1988	1.2070	1.2151
	-	-	-	12	1.2220	1.2400	1.2323	1.2259	1.2313	1.2367	1.2421	1.2476
	-	-	-	16	1.2450	1.2590	1.2533	1.2476	1.2516	1.2557	1.2597	1.2638
	-	-	18	-	1.2520	1.2650	1.2605	1.2548	1.2584	1.2620	1.2656	1.2692
	-	-	-	20	1.2580	1.2700	1.2662	1.2605	1.2638	1.2670	1.2703	1.2735
1-3/8	-	-	-	28	1.2740	1.2820	1.2801	1.2754	1.2777	1.2800	1.2823	1.2847
	6	-	-	-	1.1950	1.2250	1.2146	1.2018	1.2126	1.2235	1.2343	1.2451
	-	-	-	8	1.2400	1.2650	1.2547	1.2451	1.2532	1.2613	1.2695	1.2776
	-	12	-	-	1.2850	1.3030	1.2948	1.2884	1.2938	1.2992	1.3046	1.3101
	-	-	-	16	1.3070	1.3210	1.3158	1.3101	1.3141	1.3182	1.3222	1.3263
	-	-	18	-	1.3150	1.3280	1.3230	1.3173	1.3209	1.3245	1.3281	1.3317
1-7/16	-	-	-	20	1.3210	1.3320	1.3287	1.3230	1.3263	1.3295	1.3328	1.3360
	-	-	-	28	1.3360	1.3450	1.3426	1.3379	1.3402	1.3425	1.3448	1.3472
	-	-	-	6	1.2570	1.2880	1.2771	1.2643	1.2751	1.2860	1.2968	1.3076
	-	-	-	8	1.3020	1.3270	1.3172	1.3076	1.3157	1.3238	1.3320	1.3401
	-	-	-	12	1.3470	1.3650	1.3573	1.3509	1.3563	1.3617	1.3671	1.3726
	-	-	-	16	1.3700	1.3840	1.3783	1.3726	1.3766	1.3807	1.3847	1.3888
1-1/2	-	-	18	-	1.3770	1.3900	1.3855	1.3798	1.3834	1.3870	1.3906	1.3942
	-	-	-	20	1.3830	1.3950	1.3912	1.3855	1.3888	1.3920	1.3953	1.3985
	-	-	-	28	1.3990	1.4070	1.4051	1.4004	1.4027	1.4050	1.4073	1.4097
	6	-	-	-	1.3200	1.3500	1.3396	1.3268	1.3376	1.3485	1.3593	1.3701
	-	-	-	8	1.3650	1.3900	1.3797	1.3701	1.3782	1.3863	1.3945	1.4026
	-	12	-	-	1.4100	1.4280	1.4198	1.4134	1.4188	1.4242	1.4296	1.4351
1-9/16	-	-	-	16	1.4320	1.4460	1.4408	1.4351	1.4391	1.4432	1.4472	1.4513
	-	-	18	-	1.4400	1.4520	1.4480	1.4423	1.4459	1.4495	1.4531	1.4567
	-	-	-	20	1.4460	1.4570	1.4537	1.4480	1.4513	1.4545	1.4578	1.4610
	-	-	-	28	1.4610	1.4700	1.4676	1.4629	1.4652	1.4675	1.4698	1.4722
	-	-	-	6	1.3820	1.4130	1.4021	1.3893	1.4001	1.4110	1.4218	1.4326
	-	-	-	8	1.4270	1.4520	1.4422	1.4326	1.4407	1.4488	1.4570	1.4651
1-5/8	-	-	-	12	1.4720	1.4900	1.4823	1.4759	1.4813	1.4867	1.4921	1.4976
	-	-	-	16	1.4950	1.5090	1.5033	1.4976	1.5016	1.5057	1.5097	1.5138
	-	-	18	-	1.5020	1.5150	1.5105	1.5048	1.5084	1.5120	1.5156	1.5192
	-	-	-	20	1.5080	1.5200	1.5162	1.5105	1.5138	1.5170	1.5203	1.5235
	-	-	-	6	1.4450	1.4750	1.4646	1.4518	1.4626	1.4735	1.4843	1.4951
	-	-	-	8	1.4900	1.5150	1.5047	1.4951	1.5032	1.5113	1.5195	1.5276
1-11/16	-	-	-	12	1.5350	1.5530	1.5448	1.5384	1.5438	1.5492	1.5546	1.5601
	-	-	-	16	1.5570	1.5710	1.5658	1.5601	1.5641	1.5682	1.5722	1.5763
	-	-	18	-	1.5650	1.5780	1.5730	1.5673	1.5709	1.5745	1.5781	1.5817
	-	-	-	20	1.5710	1.5820	1.5787	1.5730	1.5763	1.5795	1.5828	1.5860
1-11/16	-	-	6	1.5070	1.5380	1.5271	1.5143	1.5251	1.5360	1.5468	1.5576	

TAP DRILL SIZES – UNIFIED THREAD

Size	Threads Per Inch				Minor Diameter			Tap Drill Diameter (Cutting Tap)				
	UNC	UNF	UNEF	UN	Min. 2B&3B	Max. 2B	Max. 3B	80% Thread	75% Thread	70% Thread	65% Thread	60% Thread
1-11/16	-	-	-	8	1.5520	1.5770	1.5672	1.5576	1.5657	1.5738	1.5820	1.5901
	-	-	-	12	1.5970	1.6150	1.6073	1.6009	1.6063	1.6117	1.6171	1.6226
	-	-	-	16	1.6200	1.6340	1.6283	1.6226	1.6266	1.6307	1.6347	1.6388
	-	-	18	-	1.6270	1.6400	1.6355	1.6298	1.6334	1.6370	1.6406	1.6442
	-	-	-	20	1.6330	1.6450	1.6412	1.6355	1.6388	1.6420	1.6453	1.6485
1-3/4	5	-	-	-	1.5340	1.5680	1.5575	1.5422	1.5552	1.5681	1.5811	1.5941
	-	-	-	6	1.5700	1.6000	1.5896	1.5768	1.5876	1.5985	1.6093	1.6201
	-	-	-	8	1.6150	1.6400	1.6297	1.6201	1.6282	1.6363	1.6445	1.6526
	-	-	-	12	1.6600	1.6780	1.6698	1.6634	1.6688	1.6742	1.6796	1.6851
	-	-	-	16	1.6820	1.6960	1.6908	1.6851	1.6891	1.6932	1.6972	1.7013
1-13/16	-	-	-	20	1.6960	1.7070	1.7037	1.6980	1.7013	1.7045	1.7078	1.7110
	-	-	-	6	1.6320	1.6630	1.6521	1.6393	1.6501	1.6610	1.6718	1.6826
	-	-	-	8	1.6770	1.7020	1.6922	1.6826	1.6907	1.6988	1.7070	1.7151
	-	-	-	12	1.7220	1.7400	1.7323	1.7259	1.7313	1.7367	1.7421	1.7476
	-	-	-	16	1.7450	1.7590	1.7533	1.7476	1.7516	1.7557	1.7597	1.7638
1-7/8	-	-	-	20	1.7580	1.7700	1.7662	1.7605	1.7638	1.7670	1.7703	1.7735
	-	-	-	6	1.6950	1.7250	1.7146	1.7018	1.7126	1.7235	1.7343	1.7451
	-	-	-	8	1.7400	1.7650	1.7547	1.7451	1.7532	1.7613	1.7695	1.7776
	-	-	-	12	1.7850	1.8030	1.7948	1.7884	1.7938	1.7992	1.8046	1.8101
	-	-	-	16	1.8070	1.8210	1.8158	1.8101	1.8141	1.8182	1.8222	1.8263
1-15/16	-	-	-	20	1.8210	1.8320	1.8287	1.8230	1.8263	1.8295	1.8328	1.8360
	-	-	-	6	1.7570	1.7880	1.7771	1.7643	1.7751	1.7860	1.7968	1.8076
	-	-	-	8	1.8020	1.8270	1.8172	1.8076	1.8157	1.8238	1.8320	1.8401
	-	-	-	12	1.8470	1.8650	1.8573	1.8509	1.8563	1.8617	1.8671	1.8726
	-	-	-	16	1.8700	1.8840	1.8783	1.8726	1.8766	1.8807	1.8847	1.8888
2	-	-	-	20	1.8830	1.8950	1.8912	1.8855	1.8888	1.8920	1.8953	1.8985
	4 1/2	-	-	-	1.7590	1.7950	1.7861	1.7691	1.7835	1.7979	1.8124	1.8268
	-	-	-	6	1.8200	1.8500	1.8396	1.8268	1.8376	1.8485	1.8593	1.8701
	-	-	-	8	1.8650	1.8900	1.8797	1.8701	1.8782	1.8863	1.8945	1.9026
	-	-	-	12	1.9100	1.9280	1.9198	1.9134	1.9188	1.9242	1.9296	1.9351
2-1/8	-	-	-	16	1.9320	1.9460	1.9408	1.9351	1.9391	1.9432	1.9472	1.9513
	-	-	-	20	1.9460	1.9570	1.9537	1.9480	1.9513	1.9545	1.9578	1.9610
	-	-	-	6	1.9450	1.9750	1.9646	1.9518	1.9626	1.9735	1.9843	1.9951
	-	-	-	8	1.9900	2.0150	2.0047	1.9951	2.0032	2.0113	2.0195	2.0276
	-	-	-	12	2.0350	2.0530	2.0448	2.0384	2.0438	2.0492	2.0546	2.0601
2-1/4	-	-	-	16	2.0570	2.0710	2.0658	2.0601	2.0641	2.0682	2.0722	2.0763
	-	-	-	20	2.0710	2.0820	2.0787	2.0730	2.0763	2.0795	2.0828	2.0860
	4 1/2	-	-	-	2.0090	2.0450	2.0361	2.0191	2.0335	2.0479	2.0624	2.0768
	-	-	-	6	2.0700	2.1000	2.0896	2.0768	2.0876	2.0985	2.1093	2.1201
	-	-	-	8	2.1150	2.1400	2.1297	2.1201	2.1282	2.1363	2.1445	2.1526
2-3/8	-	-	-	12	2.1600	2.1780	2.1698	2.1634	2.1688	2.1742	2.1796	2.1851
	-	-	-	16	2.1820	2.1960	2.1908	2.1851	2.1891	2.1932	2.1972	2.2013
	-	-	-	20	2.1960	2.2070	2.2037	2.1980	2.2013	2.2045	2.2078	2.2110
	-	-	-	6	2.1950	2.2260	2.2146	2.2018	2.2126	2.2235	2.2343	2.2451
	-	-	-	8	2.2400	2.2650	2.2547	2.2451	2.2532	2.2613	2.2695	2.2776
2-1/2	-	-	-	12	2.2850	2.3030	2.2948	2.2884	2.2938	2.2992	2.3046	2.3101
	-	-	-	16	2.3070	2.3210	2.3158	2.3101	2.3141	2.3182	2.3222	2.3263
	-	-	-	20	2.3210	2.3320	2.3287	2.3230	2.3263	2.3295	2.3328	2.3360
	4	-	-	-	2.2290	2.2670	2.2594	2.2402	2.2564	2.2727	2.2889	2.3052
	-	-	-	6	2.3200	2.3500	2.3396	2.3268	2.3376	2.3485	2.3593	2.3701
2-1/2	-	-	-	8	2.3650	2.3900	2.3797	2.3701	2.3782	2.3863	2.3945	2.4026
	-	-	-	12	2.4100	2.4280	2.4198	2.4134	2.4188	2.4242	2.4296	2.4351
	-	-	-	16	2.4320	2.4460	2.4408	2.4351	2.4391	2.4432	2.4472	2.4513
	-	-	-	20	2.4460	2.4570	2.4537	2.4480	2.4513	2.4545	2.4578	2.4610

TAP DRILL SIZES – METRIC THREAD

Size	Pitch		Minor dia.		Tap Drill Diameter									
	M	MF	Min. 6H	Max. 6H	80% Thread		75% Thread		70% Thread		65% Thread		60% Thread	
					mm	Inch	mm	Inch	mm	Inch	mm	Inch	mm	Inch
M1	0.25	–	.729	.798	0.74	.0291	0.76	.0298	0.77	.0304	0.79	.0311	0.81	.0317
	–	0.2	.783	.841	0.79	.0312	0.81	.0317	0.82	.0322	0.83	.0327	0.84	.0332
M1.1	0.25	–	.829	.898	0.84	.0331	0.86	.0337	0.87	.0344	0.89	.0350	0.91	.0356
	–	0.2	.883	.941	0.89	.0351	0.91	.0356	0.92	.0361	0.93	.0367	0.94	.0372
M1.2	0.25	–	.929	.998	0.94	.0370	0.96	.0377	0.97	.0383	0.99	.0389	1.01	.0396
	–	0.2	.983	1.041	0.99	.0391	1.01	.0396	1.02	.0401	1.03	.0406	1.04	.0411
M1.4	0.3	–	1.075	1.159	1.09	.0428	1.11	.0436	1.13	.0444	1.15	.0451	1.17	.0459
	–	0.2	1.183	1.241	1.19	.0469	1.21	.0474	1.22	.0480	1.23	.0485	1.24	.0490
M1.6	0.35	–	1.221	1.321	1.24	.0487	1.26	.0496	1.28	.0505	1.30	.0514	1.33	.0523
	–	0.2	1.383	1.441	1.39	.0548	1.41	.0553	1.42	.0558	1.43	.0563	1.44	.0569
M1.7	0.35	–	1.321	1.421	1.34	.0526	1.36	.0535	1.38	.0544	1.40	.0553	1.43	.0562
	–	0.3	1.375	1.459	1.39	.0547	1.41	.0554	1.43	.0562	1.45	.0570	1.47	.0577
	–	0.25	1.429	1.498	1.44	.0567	1.46	.0573	1.47	.0580	1.49	.0586	1.51	.0593
	–	0.2	1.483	1.541	1.49	.0587	1.51	.0593	1.52	.0598	1.53	.0603	1.54	.0608
M1.8	0.35	–	1.421	1.521	1.44	.0565	1.46	.0574	1.48	.0583	1.50	.0592	1.53	.0601
	–	0.2	1.583	1.641	1.59	.0627	1.61	.0632	1.62	.0637	1.63	.0642	1.64	.0647
M2	0.4	–	1.567	1.679	1.58	.0624	1.61	.0634	1.64	.0644	1.66	.0654	1.69	.0665
	–	0.25	1.729	1.798	1.74	.0685	1.76	.0692	1.77	.0698	1.79	.0704	1.81	.0711
M2.2	0.45	–	1.713	1.838	1.73	.0682	1.76	.0694	1.79	.0705	1.82	.0717	1.85	.0728
	–	0.25	1.929	1.998	1.94	.0764	1.96	.0770	1.97	.0777	1.99	.0783	2.01	.0789
M2.3	0.4	–	1.867	1.979	1.88	.0742	1.91	.0752	1.94	.0762	1.96	.0773	1.99	.0783
	–	0.35	1.921	2.021	1.94	.0762	1.96	.0771	1.98	.0780	2.00	.0789	2.03	.0798
	–	0.25	2.029	2.098	2.04	.0803	2.06	.0810	2.07	.0816	2.09	.0822	2.11	.0829
M2.5	0.45	–	2.013	2.138	2.03	.0800	2.06	.0812	2.09	.0823	2.12	.0835	2.15	.0846
	–	0.35	2.121	2.221	2.14	.0841	2.16	.0850	2.18	.0859	2.20	.0868	2.23	.0877
M2.6	0.45	–	2.113	2.238	2.13	.0840	2.16	.0851	2.19	.0863	2.22	.0874	2.25	.0886
	–	0.35	2.221	2.321	2.24	.0880	2.26	.0889	2.28	.0898	2.30	.0907	2.33	.0916
M3	0.5	–	2.459	2.599	2.48	.0977	2.51	.0989	2.55	.1002	2.58	.1015	2.61	.1028
	–	0.35	2.621	2.721	2.64	.1038	2.66	.1047	2.68	.1056	2.70	.1065	2.73	.1074
M3.5	0.6	–	2.850	3.010	2.88	.1132	2.92	.1148	2.95	.1163	2.99	.1178	3.03	.1194
	–	0.35	3.121	3.221	3.14	.1235	3.16	.1244	3.18	.1253	3.20	.1262	3.23	.1271
M4	0.7	–	3.242	3.422	3.27	.1288	3.32	.1306	3.36	.1324	3.41	.1342	3.45	.1360
	–	0.5	3.459	3.599	3.48	.1370	3.51	.1383	3.55	.1396	3.58	.1409	3.61	.1421
M4.5	0.75	–	3.688	3.878	3.72	.1465	3.77	.1484	3.82	.1503	3.87	.1522	3.92	.1542
	–	0.5	3.959	4.099	3.98	.1567	4.01	.1580	4.05	.1593	4.08	.1605	4.11	.1618
	–	0.9	4.026	4.226	4.06	.1600	4.12	.1623	4.18	.1646	4.24	.1669	4.30	.1692
M5	0.8	–	4.134	4.334	4.17	.1641	4.22	.1662	4.27	.1682	4.32	.1703	4.38	.1723
	–	0.5	4.459	4.599	4.48	.1764	4.51	.1777	4.55	.1790	4.58	.1802	4.61	.1815
	–	0.9	4.526	4.726	4.56	.1797	4.62	.1820	4.68	.1843	4.74	.1866	4.80	.1889
M5.5	–	0.75	4.688	4.878	4.72	.1858	4.77	.1878	4.82	.1897	4.87	.1916	4.92	.1935
	–	0.5	4.959	5.099	4.98	.1961	5.01	.1974	5.05	.1986	5.08	.1999	5.11	.2012
M6	1	–	4.917	5.153	4.96	.1953	5.03	.1979	5.09	.2004	5.16	.2030	5.22	.2055
	–	0.75	5.188	5.378	5.22	.2055	5.27	.2075	5.32	.2094	5.37	.2113	5.42	.2132
	–	0.5	5.459	5.599	5.48	.2158	5.51	.2170	5.55	.2183	5.58	.2196	5.61	.2209
M7	1	–	5.917	6.153	5.96	.2347	6.03	.2372	6.09	.2398	6.16	.2423	6.22	.2449
	–	0.75	6.188	6.378	6.22	.2449	6.27	.2468	6.32	.2487	6.37	.2507	6.42	.2526
	–	0.5	6.459	6.599	6.48	.2551	6.51	.2564	6.55	.2577	6.58	.2590	6.61	.2602
M8	1.25	–	6.647	6.912	6.70	.2638	6.78	.2670	6.86	.2702	6.94	.2734	7.03	.2766
	–	1	6.917	7.153	6.96	.2740	7.03	.2766	7.09	.2792	7.16	.2817	7.22	.2843
	–	0.75	7.188	7.378	7.22	.2843	7.27	.2862	7.32	.2881	7.37	.2900	7.42	.2919
	–	0.5	7.459	7.599	7.48	.2945	7.51	.2958	7.55	.2971	7.58	.2983	7.61	.2996

TAP DRILL SIZES – METRIC THREAD

Size	Pitch		Minor dia.		Tap Drill Diameter									
	M	MF	Min. 6H	Max. 6H	80% Thread		75% Thread		70% Thread		65% Thread		60% Thread	
					mm	Inch	mm	Inch	mm	Inch	mm	Inch	mm	Inch
M9	1.25	–	7.647	7.912	7.70	.3032	7.78	.3064	7.86	.3096	7.94	.3128	8.03	.3160
	–	1	7.917	8.153	7.96	.3134	8.03	.3160	8.09	.3185	8.16	.3211	8.22	.3236
	–	0.75	8.188	8.378	8.22	.3236	8.27	.3256	8.32	.3275	8.37	.3294	8.42	.3313
	–	0.5	8.459	8.599	8.48	.3339	8.51	.3352	8.55	.3364	8.58	.3377	8.61	.3390
M10	1.5	–	8.376	8.676	8.44	.3323	8.54	.3362	8.64	.3400	8.73	.3438	8.83	.3477
	–	1.25	8.647	8.912	8.70	.3426	8.78	.3458	8.86	.3490	8.94	.3521	9.03	.3553
	–	1	8.917	9.153	8.96	.3528	9.03	.3553	9.09	.3579	9.16	.3605	9.22	.3630
	–	0.75	9.188	9.378	9.22	.3630	9.27	.3649	9.32	.3669	9.37	.3688	9.42	.3707
	–	0.5	9.459	9.599	9.48	.3732	9.51	.3745	9.55	.3758	9.58	.3771	9.61	.3784
M11	1.5	–	9.376	9.676	9.44	.3717	9.54	.3755	9.64	.3794	9.73	.3832	9.83	.3870
	–	1	9.917	10.153	9.96	.3922	10.03	.3947	10.09	.3973	10.16	.3998	10.22	.4024
	–	0.75	10.188	10.378	10.22	.4024	10.27	.4043	10.32	.4062	10.37	.4081	10.42	.4101
	–	0.5	10.459	10.599	10.48	.4126	10.51	.4139	10.55	.4152	10.58	.4164	10.61	.4177
M12	1.75	–	10.106	10.441	10.18	.4008	10.30	.4053	10.41	.4098	10.52	.4143	10.64	.4187
	–	1.5	10.376	10.676	10.44	.4111	10.54	.4149	10.64	.4187	10.73	.4226	10.83	.4264
	–	1.25	10.647	10.912	10.70	.4213	10.78	.4245	10.86	.4277	10.94	.4309	11.03	.4341
	–	1	10.917	11.153	10.96	.4315	11.03	.4341	11.09	.4366	11.16	.4392	11.22	.4418
	–	0.75	11.188	11.378	11.22	.4418	11.27	.4437	11.32	.4456	11.37	.4475	11.42	.4494
	–	0.5	11.459	11.599	11.48	.4520	11.51	.4533	11.55	.4545	11.58	.4558	11.61	.4571
	–	1.75	11.106	11.441	11.18	.4402	11.30	.4447	11.41	.4492	11.52	.4536	11.64	.4581
M13	–	1.5	11.376	11.676	11.44	.4504	11.54	.4543	11.64	.4581	11.73	.4619	11.83	.4658
	–	1.25	11.647	11.912	11.70	.4607	11.78	.4639	11.86	.4671	11.94	.4703	12.03	.4735
	–	1	11.917	12.153	11.96	.4709	12.03	.4735	12.09	.4760	12.16	.4786	12.22	.4811
	–	0.75	12.188	12.378	12.22	.4811	12.27	.4830	12.32	.4850	12.37	.4869	12.42	.4888
	–	0.5	12.459	12.599	12.48	.4914	12.51	.4926	12.55	.4939	12.58	.4952	12.61	.4965
M14	2	–	11.835	12.210	11.92	.4694	12.05	.4745	12.18	.4796	12.31	.4847	12.44	.4898
	–	1.5	12.376	12.676	12.44	.4898	12.54	.4936	12.64	.4975	12.73	.5013	12.83	.5052
	–	1.25	12.647	12.912	12.70	.5000	12.78	.5032	12.86	.5064	12.94	.5096	13.03	.5128
	–	1	12.917	13.153	12.96	.5103	13.03	.5128	13.09	.5154	13.16	.5179	13.22	.5205
	–	0.75	13.188	13.378	13.22	.5205	13.27	.5224	13.32	.5243	13.37	.5262	13.42	.5282
	–	0.5	13.459	13.599	13.48	.5307	13.51	.5320	13.55	.5333	13.58	.5346	13.61	.5358
M15	–	2	12.835	13.210	12.92	.5087	13.05	.5138	13.18	.5190	13.31	.5241	13.44	.5292
	–	1.5	13.376	13.676	13.44	.5292	13.54	.5330	13.64	.5369	13.73	.5407	13.83	.5445
	–	1.25	13.647	13.912	13.70	.5394	13.78	.5426	13.86	.5458	13.94	.5490	14.03	.5522
	–	1	13.917	14.153	13.96	.5496	14.03	.5522	14.09	.5548	14.16	.5573	14.22	.5599
	–	0.75	14.188	14.378	14.22	.5599	14.27	.5618	14.32	.5637	14.37	.5656	14.42	.5675
	–	0.5	14.459	14.599	14.48	.5701	14.51	.5714	14.55	.5727	14.58	.5739	14.61	.5752
M16	2	–	13.835	14.210	13.92	.5481	14.05	.5532	14.18	.5583	14.31	.5634	14.44	.5685
	–	1.5	14.376	14.676	14.44	.5685	14.54	.5724	14.64	.5762	14.73	.5801	14.83	.5839
	–	1	14.917	15.153	14.96	.5890	15.03	.5916	15.09	.5941	15.16	.5967	15.22	.5992
M17	–	2	14.835	15.210	14.92	.5875	15.05	.5926	15.18	.5977	15.31	.6028	15.44	.6079
	–	1.5	15.376	15.676	15.44	.6079	15.54	.6118	15.64	.6156	15.73	.6194	15.83	.6233
	–	1.25	15.647	15.912	15.70	.6181	15.78	.6213	15.86	.6245	15.94	.6277	16.03	.6309
	–	1	15.917	16.153	15.96	.6284	16.03	.6309	16.09	.6335	16.16	.6360	16.22	.6386
	–	0.75	16.188	16.378	16.22	.6386	16.27	.6405	16.32	.6424	16.37	.6444	16.42	.6463
	–	0.5	16.459	16.599	16.48	.6488	16.51	.6501	16.55	.6514	16.58	.6527	16.61	.6539
M18	2.5	–	15.294	15.744	15.40	.6064	15.56	.6128	15.73	.6192	15.89	.6256	16.05	.6319
	–	2	15.835	16.210	15.92	.6268	16.05	.6319	16.18	.6371	16.31	.6422	16.44	.6473
	–	1.5	16.376	16.676	16.44	.6473	16.54	.6511	16.64	.6550	16.73	.6588	16.83	.6626
	–	1	16.917	17.153	16.96	.6677	17.03	.6703	17.09	.6729	17.16	.6754	17.22	.6780
M19	–	2.5	16.294	16.744	16.40	.6457	16.56	.6521	16.73	.6585	16.89	.6649	17.05	.6713
	–	2	16.835	17.210	16.92	.6662	17.05	.6713	17.18	.6764	17.31	.6815	17.44	.6867

TAP DRILL SIZES – METRIC THREAD

Size	Pitch		Minor dia.		Tap Drill Diameter									
	M	MF	Min. 6H	Max. 6H	80% Thread		75% Thread		70% Thread		65% Thread		60% Thread	
					mm	Inch	mm	Inch	mm	Inch	mm	Inch	mm	Inch
M19	–	1.5	17.376	17.676	17.44	.6867	17.54	.6905	17.64	.6943	17.73	.6982	17.83	.7020
	–	1.25	17.647	17.912	17.70	.6969	17.78	.7001	17.86	.7033	17.94	.7065	18.03	.7097
	–	1	17.917	18.153	17.96	.7071	18.03	.7097	18.09	.7122	18.16	.7148	18.22	.7173
	–	0.75	18.188	18.378	18.22	.7173	18.27	.7193	18.32	.7212	18.37	.7231	18.42	.7250
	–	0.5	18.459	18.599	18.48	.7276	18.51	.7289	18.55	.7301	18.58	.7314	18.61	.7327
M20	2.5	–	17.294	17.744	17.40	.6851	17.56	.6915	17.73	.6979	17.89	.7043	18.05	.7107
	–	2	17.835	18.210	17.92	.7056	18.05	.7107	18.18	.7158	18.31	.7209	18.44	.7260
	–	1.5	18.376	18.676	18.44	.7260	18.54	.7299	18.64	.7337	18.73	.7375	18.83	.7414
	–	1	18.917	19.153	18.96	.7465	19.03	.7490	19.09	.7516	19.16	.7542	19.22	.7567
M21	–	2.5	18.294	18.744	18.40	.7245	18.56	.7309	18.73	.7373	18.89	.7437	19.05	.7501
	–	1.5	19.376	19.676	19.44	.7654	19.54	.7692	19.64	.7731	19.73	.7769	19.83	.7807
	–	1	19.917	20.153	19.96	.7859	20.03	.7884	20.09	.7910	20.16	.7935	20.22	.7961
M22	2.5	–	19.294	19.744	19.40	.7639	19.56	.7702	19.73	.7766	19.89	.7830	20.05	.7894
	–	2	19.835	20.210	19.92	.7843	20.05	.7894	20.18	.7945	20.31	.7997	20.44	.8048
	–	1.5	20.376	20.676	20.44	.8048	20.54	.8086	20.64	.8124	20.73	.8163	20.83	.8201
	–	1	20.917	21.153	20.96	.8252	21.03	.8278	21.09	.8303	21.16	.8329	21.22	.8355
M23	–	2.5	20.294	20.744	20.40	.8032	20.56	.8096	20.73	.8160	20.89	.8224	21.05	.8288
	–	2	20.835	21.210	20.92	.8237	21.05	.8288	21.18	.8339	21.31	.8390	21.44	.8441
	–	1.5	21.376	21.676	21.44	.8441	21.54	.8480	21.64	.8518	21.73	.8556	21.83	.8595
	–	1	21.917	22.153	21.96	.8646	22.03	.8672	22.09	.8697	22.16	.8723	22.22	.8748
M24	3	–	20.752	21.252	20.88	.8221	21.08	.8298	21.27	.8375	21.47	.8452	21.66	.8528
	–	2	21.835	22.210	21.92	.8631	22.05	.8682	22.18	.8733	22.31	.8784	22.44	.8835
	–	1.5	22.376	22.676	22.44	.8835	22.54	.8873	22.64	.8912	22.73	.8950	22.83	.8989
	–	1	22.917	23.153	22.96	.9040	23.03	.9065	23.09	.9091	23.16	.9116	23.22	.9142
M25	–	3	21.752	22.252	21.88	.8615	22.08	.8692	22.27	.8769	22.47	.8845	22.66	.8922
	–	2	22.835	23.210	22.92	.9024	23.05	.9075	23.18	.9127	23.31	.9178	23.44	.9229
	–	1.5	23.376	23.676	23.44	.9229	23.54	.9267	23.64	.9306	23.73	.9344	23.83	.9382
	–	1	23.917	24.153	23.96	.9433	24.03	.9459	24.09	.9485	24.16	.9510	24.22	.9536
M26	–	3	22.752	23.252	22.88	.9009	23.08	.9085	23.27	.9162	23.47	.9239	23.66	.9316
	–	2	23.835	24.210	23.92	.9418	24.05	.9469	24.18	.9520	24.31	.9571	24.44	.9623
	–	1.5	24.376	24.676	24.44	.9623	24.54	.9661	24.64	.9699	24.73	.9738	24.83	.9776
M27	3	–	23.752	24.252	23.88	.9402	24.08	.9479	24.27	.9556	24.47	.9633	24.66	.9709
	–	2.5	24.294	24.744	24.40	.9607	24.56	.9671	24.73	.9735	24.89	.9799	25.05	.9863
	–	2	24.835	25.210	24.92	.9812	25.05	.9863	25.18	.9914	25.31	.9965	25.44	1.0016
	–	1.5	25.376	25.676	25.44	1.0016	25.54	1.0055	25.64	1.0093	25.73	1.0131	25.83	1.0170
	–	1	25.917	26.153	25.96	1.0221	26.03	1.0246	26.09	1.0272	26.16	1.0297	26.22	1.0323
M28	–	3	24.752	25.252	24.88	.9796	25.08	.9873	25.27	.9950	25.47	1.0026	25.66	1.0103
	–	2	25.835	26.210	25.92	1.0205	26.05	1.0256	26.18	1.0308	26.31	1.0359	26.44	1.0410
	–	1.5	26.376	26.676	26.44	1.0410	26.54	1.0448	26.64	1.0487	26.73	1.0525	26.83	1.0563
	–	1	26.917	27.153	26.96	1.0614	27.03	1.0640	27.09	1.0666	27.16	1.0691	27.22	1.0717
M30	3.5	–	26.211	26.771	26.36	1.0379	26.59	1.0469	26.82	1.0558	27.04	1.0648	27.27	1.0737
	–	3	26.752	27.252	26.88	1.0584	27.08	1.0660	27.27	1.0737	27.47	1.0814	27.66	1.0890
	–	2	27.835	28.210	27.92	1.0993	28.05	1.1044	28.18	1.1095	28.31	1.1146	28.44	1.1197
	–	1.5	28.376	28.676	28.44	1.1197	28.54	1.1236	28.64	1.1274	28.73	1.1312	28.83	1.1351
	–	1	28.917	29.153	28.96	1.1402	29.03	1.1427	29.09	1.1453	29.16	1.1479	29.22	1.1504
M32	–	3	28.752	29.252	28.88	1.1371	29.08	1.1448	29.27	1.1524	29.47	1.1601	29.66	1.1678
	–	2	29.835	30.210	29.92	1.1780	30.05	1.1831	30.18	1.1882	30.31	1.1934	30.44	1.1985
	–	1.5	30.376	30.676	30.44	1.1985	30.54	1.2023	30.64	1.2061	30.73	1.2100	30.83	1.2138
M33	3.5	–	29.211	29.771	29.36	1.1560	29.59	1.1650	29.82	1.1739	30.04	1.1829	30.27	1.1918
	–	3	29.752	30.252	29.88	1.1765	30.08	1.1841	30.27	1.1918	30.47	1.1995	30.66	1.2072
	–	2	30.835	31.210	30.92	1.2174	31.05	1.2225	31.18	1.2276	31.31	1.2327	31.44	1.2378
	–	1.5	31.376	31.676	31.44	1.2378	31.54	1.2417	31.64	1.2455	31.73	1.2493	31.83	1.2532
	–	1	31.917	32.153	31.96	1.2583	32.03	1.2609	32.09	1.2634	32.16	1.2660	32.22	1.2685

TAP DRILL SIZES – METRIC THREAD

Size	Pitch		Minor dia.		Tap Drill Diameter									
	M	MF	Min. 6H	Max. 6H	80% Thread		75% Thread		70% Thread		65% Thread		60% Thread	
					mm	Inch	mm	Inch	mm	Inch	mm	Inch	mm	Inch
M34	-	3	30.752	31.252	30.88	1.2158	31.08	1.2235	31.27	1.2312	31.47	1.2389	31.66	1.2465
	-	2	31.835	32.210	31.92	1.2568	32.05	1.2619	32.18	1.2670	32.31	1.2721	32.44	1.2772
	-	1.5	32.376	32.676	32.44	1.2772	32.54	1.2810	32.64	1.2849	32.73	1.2887	32.83	1.2926
	-	1	32.917	33.153	32.96	1.2977	33.03	1.3002	33.09	1.3028	33.16	1.3053	33.22	1.3079
M35	-	3	31.752	32.252	31.88	1.2552	32.08	1.2629	32.27	1.2706	32.47	1.2782	32.66	1.2859
	-	1.5	33.376	33.676	33.44	1.3166	33.54	1.3204	33.64	1.3243	33.73	1.3281	33.83	1.3319
	-	1	33.917	34.153	33.96	1.3370	34.03	1.3396	34.09	1.3422	34.16	1.3447	34.22	1.3473
M36	4	-	31.670	32.270	31.84	1.2537	32.10	1.2639	32.36	1.2741	32.62	1.2844	32.88	1.2946
	-	3	32.752	33.252	32.88	1.2946	33.08	1.3023	33.27	1.3099	33.47	1.3176	33.66	1.3253
	-	2	33.835	34.210	33.92	1.3355	34.05	1.3406	34.18	1.3457	34.31	1.3508	34.44	1.3560
	-	1.5	34.376	34.676	34.44	1.3560	34.54	1.3598	34.64	1.3636	34.73	1.3675	34.83	1.3713
	-	1	34.917	35.153	34.96	1.3764	35.03	1.3790	35.09	1.3815	35.16	1.3841	35.22	1.3866
M37	-	1.5	35.376	35.676	35.44	1.3953	35.54	1.3992	35.64	1.4030	35.73	1.4068	35.83	1.4107
	-	1	35.917	36.153	35.96	1.4158	36.03	1.4183	36.09	1.4209	36.16	1.4234	36.22	1.4260
M38	-	4	33.670	34.270	33.84	1.3324	34.10	1.3426	34.36	1.3529	34.62	1.3631	34.88	1.3733
	-	3	34.752	35.252	34.88	1.3733	35.08	1.3810	35.27	1.3887	35.47	1.3963	35.66	1.4040
	-	2	35.835	36.210	35.92	1.4142	36.05	1.4193	36.18	1.4245	36.31	1.4296	36.44	1.4347
	-	1.5	36.376	36.676	36.44	1.4347	36.54	1.4385	36.64	1.4424	36.73	1.4462	36.83	1.4500
M39	4	-	34.670	35.270	34.84	1.3718	35.10	1.3820	35.36	1.3922	35.62	1.4025	35.88	1.4127
	-	3	35.752	36.252	35.88	1.4127	36.08	1.4204	36.27	1.4280	36.47	1.4357	36.66	1.4434
	-	2	36.835	37.210	36.92	1.4536	37.05	1.4587	37.18	1.4638	37.31	1.4689	37.44	1.4741
	-	1.5	37.376	37.676	37.44	1.4741	37.54	1.4779	37.64	1.4817	37.73	1.4856	37.83	1.4894
	-	1	37.917	38.153	37.96	1.4945	38.03	1.4971	38.09	1.4996	38.16	1.5022	38.22	1.5047
M40	-	4	35.670	36.270	35.84	1.4111	36.10	1.4214	36.36	1.4316	36.62	1.4418	36.88	1.4521
	-	3	36.752	37.252	36.88	1.4521	37.08	1.4597	37.27	1.4674	37.47	1.4751	37.66	1.4827
	-	2	37.835	38.210	37.92	1.4930	38.05	1.4981	38.18	1.5032	38.31	1.5083	38.44	1.5134
	-	1.5	38.376	38.676	38.44	1.5134	38.54	1.5173	38.64	1.5211	38.73	1.5249	38.83	1.5288
	-	1	38.917	39.153	38.96	1.5339	39.03	1.5364	39.09	1.5390	39.16	1.5416	39.22	1.5441
M42	4.5	-	37.129	37.799	37.32	1.4694	37.62	1.4809	37.91	1.4924	38.20	1.5039	38.49	1.5155
	-	4	37.670	38.270	37.84	1.4899	38.10	1.5001	38.36	1.5103	38.62	1.5206	38.88	1.5308
	-	3	38.752	39.252	38.88	1.5308	39.08	1.5385	39.27	1.5461	39.47	1.5538	39.66	1.5615
	-	2	39.835	40.210	39.92	1.5717	40.05	1.5768	40.18	1.5819	40.31	1.5871	40.44	1.5922
	-	1.5	40.376	40.676	40.44	1.5922	40.54	1.5960	40.64	1.5998	40.73	1.6037	40.83	1.6075
M45	4.5	-	40.129	40.799	40.32	1.5875	40.62	1.5990	40.91	1.6106	41.20	1.6221	41.49	1.6336
	-	4	40.670	41.270	40.84	1.6080	41.10	1.6182	41.36	1.6285	41.62	1.6387	41.88	1.6489
	-	3	41.752	42.252	41.88	1.6489	42.08	1.6566	42.27	1.6643	42.47	1.6719	42.66	1.6796
	-	2	42.835	43.210	42.92	1.6898	43.05	1.6949	43.18	1.7001	43.31	1.7052	43.44	1.7103
	-	1.5	43.376	43.676	43.44	1.7103	43.54	1.7141	43.64	1.7180	43.73	1.7218	43.83	1.7256
	-	1	43.917	44.153	43.96	1.7307	44.03	1.7333	44.09	1.7359	44.16	1.7384	44.22	1.7410
M46	-	1.5	44.376	44.676	44.44	1.7497	44.54	1.7535	44.64	1.7573	44.73	1.7612	44.83	1.7650
M48	5	-	42.587	43.297	42.80	1.6852	43.13	1.6980	43.45	1.7108	43.78	1.7235	44.10	1.7363
	-	4	43.670	44.270	43.84	1.7261	44.10	1.7363	44.36	1.7466	44.62	1.7568	44.88	1.7670
	-	3	44.752	45.252	44.88	1.7670	45.08	1.7747	45.27	1.7824	45.47	1.7900	45.66	1.7977
	-	2	45.835	46.210	45.92	1.8079	46.05	1.8130	46.18	1.8182	46.31	1.8233	46.44	1.8284
	-	1.5	46.376	46.676	46.44	1.8284	46.54	1.8322	46.64	1.8361	46.73	1.8399	46.83	1.8437
	-	1	46.917	47.153	46.96	1.8488	47.03	1.8514	47.09	1.8540	47.16	1.8565	47.22	1.8591
M50	-	5	44.587	45.297	44.80	1.7639	45.13	1.7767	45.45	1.7895	45.78	1.8023	46.10	1.8151
	-	3	46.752	47.252	46.88	1.8458	47.08	1.8534	47.27	1.8611	47.47	1.8688	47.66	1.8764
	-	2	47.835	48.210	47.92	1.8867	48.05	1.8918	48.18	1.8969	48.31	1.9020	48.44	1.9071
	-	1.5	48.376	48.676	48.44	1.9071	48.54	1.9110	48.64	1.9148	48.73	1.9186	48.83	1.9225
	-	1	48.917	49.153	48.96	1.9276	49.03	1.9301	49.09	1.9327	49.16	1.9353	49.22	1.9378

TAP DRILL SIZES – METRIC THREAD

Size	Pitch		Minor dia.		Tap Drill Diameter									
	M	MF	Min. 6H	Max. 6H	80% Thread		75% Thread		70% Thread		65% Thread		60% Thread	
					mm	Inch	mm	Inch	mm	Inch	mm	Inch	mm	Inch
M52	5	–	46.587	47.297	46.80	1.8427	47.13	1.8555	47.45	1.8682	47.78	1.8810	48.10	1.8938
	–	4	47.670	48.270	47.84	1.8836	48.10	1.8938	48.36	1.9040	48.62	1.9143	48.88	1.9245
	–	3	48.752	49.252	48.88	1.9245	49.08	1.9322	49.27	1.9398	49.47	1.9475	49.66	1.9552
	–	2	49.835	50.210	49.92	1.9654	50.05	1.9705	50.18	1.9756	50.31	1.9808	50.44	1.9859
	–	1.5	50.376	50.676	50.44	1.9859	50.54	1.9897	50.64	1.9935	50.73	1.9974	50.83	2.0012
M55	–	4	50.670	51.270	50.84	2.0017	51.10	2.0119	51.36	2.0222	51.62	2.0324	51.88	2.0426
	–	3	51.752	52.252	51.88	2.0426	52.08	2.0503	52.27	2.0580	52.47	2.0656	52.66	2.0733
	–	2	52.835	53.210	52.92	2.0835	53.05	2.0886	53.18	2.0938	53.31	2.0989	53.44	2.1040
	–	1.5	53.376	53.676	53.44	2.1040	53.54	2.1078	53.64	2.1117	53.73	2.1155	53.83	2.1193
M56	5.5	–	50.046	50.796	50.28	1.9797	50.64	1.9938	51.00	2.0078	51.36	2.0219	51.71	2.0360
	–	4	51.670	52.270	51.84	2.0411	52.10	2.0513	52.36	2.0615	52.62	2.0718	52.88	2.0820
	–	3	52.752	53.252	52.88	2.0820	53.08	2.0897	53.27	2.0973	53.47	2.1050	53.66	2.1127
	–	2	53.835	54.210	53.92	2.1229	54.05	2.1280	54.18	2.1331	54.31	2.1382	54.44	2.1434
	–	1.5	54.376	54.676	54.44	2.1434	54.54	2.1472	54.64	2.1510	54.73	2.1549	54.83	2.1587
M58	–	4	53.670	54.270	53.84	2.1198	54.10	2.1300	54.36	2.1403	54.62	2.1505	54.88	2.1607
	–	3	54.752	55.252	54.88	2.1607	55.08	2.1684	55.27	2.1761	55.47	2.1837	55.66	2.1914
	–	2	55.835	56.210	55.92	2.2016	56.05	2.2067	56.18	2.2119	56.31	2.2170	56.44	2.2221
	–	1.5	56.376	56.676	56.44	2.2221	56.54	2.2259	56.64	2.2298	56.73	2.2336	56.83	2.2374
M60	5.5	–	54.046	54.796	54.28	2.1372	54.64	2.1512	55.00	2.1653	55.36	2.1794	55.71	2.1934
	–	4	55.670	56.270	55.84	2.1985	56.10	2.2088	56.36	2.2190	56.62	2.2292	56.88	2.2395
	–	3	56.752	57.252	56.88	2.2395	57.08	2.2471	57.27	2.2548	57.47	2.2625	57.66	2.2701
	–	2	57.835	58.210	57.92	2.2804	58.05	2.2855	58.18	2.2906	58.31	2.2957	58.44	2.3008
	–	1.5	58.376	58.676	58.44	2.3008	58.54	2.3047	58.64	2.3085	58.73	2.3123	58.83	2.3162
M62	–	4	57.670	58.270	57.84	2.2773	58.10	2.2875	58.36	2.2977	58.62	2.3080	58.88	2.3182
	–	3	58.752	59.252	58.88	2.3182	59.08	2.3259	59.27	2.3335	59.47	2.3412	59.66	2.3489
	–	1	60.917	61.153	60.96	2.4000	61.03	2.4026	61.09	2.4051	61.16	2.4077	61.22	2.4103
	–	1.5	60.376	60.676	60.44	2.3796	60.54	2.3834	60.64	2.3872	60.73	2.3911	60.83	2.3949
M64	6	–	57.505	58.305	57.76	2.2742	58.15	2.2895	58.54	2.3049	58.93	2.3202	59.32	2.3356
	–	4	59.670	60.270	59.84	2.3560	60.10	2.3663	60.36	2.3765	60.62	2.3867	60.88	2.3969
	–	3	60.752	61.252	60.88	2.3969	61.08	2.4046	61.27	2.4123	61.47	2.4200	61.66	2.4276
	–	2	61.835	62.210	61.92	2.4379	62.05	2.4430	62.18	2.4481	62.31	2.4532	62.44	2.4583
	–	1.5	62.376	62.676	62.44	2.4583	62.54	2.4621	62.64	2.4660	62.73	2.4698	62.83	2.4737
M65	–	4	60.670	61.270	60.84	2.3954	61.10	2.4056	61.36	2.4159	61.62	2.4261	61.88	2.4363
	–	3	61.752	62.252	61.88	2.4363	62.08	2.4440	62.27	2.4517	62.47	2.4593	62.66	2.4670
	–	2	62.835	63.210	62.92	2.4772	63.05	2.4823	63.18	2.4875	63.31	2.4926	63.44	2.4977
	–	1.5	63.376	63.676	63.44	2.4977	63.54	2.5015	63.64	2.5054	63.73	2.5092	63.83	2.5130



DREAM DRILL • INOX:
The Performance of
Your Dreams

YG-1's advanced point geometry with cutting-edge technology is at the business end of every DREAM DRILL • INOX tool.

And if metalworking is your second language, you know DREAM DRILL • INOX means Productivity with a capital P in stainless steel.

DREAM DRILL•INOX

FOR STEELS, STAINLESS STEELS, TITANIUM AND NON-FERROUS METALS

YG-1's advanced point geometry is literally cutting-edge technology at the business end of every DREAM DRILL. And it's just the beginning of a long list of features that boost productivity.






- ▶ High-strength cutting edges for extended tool life, versatile use
- ▶ Multilayer coating for better productivity, reliability and longer tool life
- ▶ Advanced point geometry for superior centering and chip curling



DREAM DRILL•INOX with coolant holes

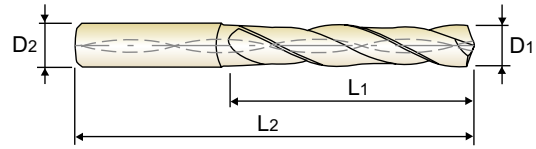
SELECTION GUIDE

DREAM DRILL•INOX

SERIES	MODEL	DESCRIPTION	LENGTH	SIZE		PAGE
				Min.	Max.	
INCH						
3xD DH463 DH714		With coolant holes	STUB	D1/8	D5/8	32
5xD DH464 DH715		With coolant holes	LONG	D13/64	D/2	34
METRIC						
3xD DH451		With coolant holes	SHORT	.1181	.7874	35
5xD DH452		With coolant holes	LONG	.0394	.7874	39
8xD DH453		With coolant holes	EXTRA LONG	.1181	.7874	43
RECOMMENDED CUTTING CONDITIONS						47

TiAIN-COATED SOLID CARBIDE DREAM DRILLS INOX with Coolant Holes

DH463 | DH714 SERIES



CARBIDE
140°
20 bar
Page 47

STUB

3 × D

Unit: Inch

EDP No.	Drill Diameter		Shank Diameter	Flute Length	Overall Length
	Fractional	Decimal			
TiAIN	D1		D2	L1	L2
DH714008	1/8	.1250	3/16	1.102	2.992
DH463008	1/8	.1250	15/64	1.102	2.992
DH714011	11/64	.1719	3/16	1.417	3.386
DH463011	11/64	.1719	15/64	1.417	3.386
DH714012	3/16	.1875	3/16	1.575	3.543
DH463012	3/16	.1875	15/64	1.575	3.543
DH463013	13/64	.2031	15/64	1.082	3.228
DH714013	13/64	.2031	1/4	1.082	3.228
DH463014	7/32	.2188	15/64	1.181	3.228
DH714014	7/32	.2188	1/4	1.181	3.228
DH463015	15/64	.2344	15/64	1.181	3.228
DH714015	15/64	.2344	1/4	1.181	3.228
DH714016	1/4	.2500	1/4	1.279	3.465
DH463016	1/4	.2500	17/64	1.279	3.465
DH463206	F	.2570	17/64	1.279	3.465
DH714206	F	.2570	5/16	1.279	3.465
DH463017	17/64	.2656	17/64	1.378	3.465
DH714017	17/64	.2656	5/16	1.378	3.465
DH463209	I	.2720	.2720	1.378	3.465
DH714209	I	.2720	5/16	1.378	3.465
DH463018	9/32	.2812	5/16	1.476	3.701
DH463019	19/64	.2969	5/16	1.476	3.701

EDP No.	Drill Diameter		Shank Diameter	Flute Length	Overall Length
	Fractional	Decimal			
TiAIN	D1		D2	L1	L2
DH463020	5/16	.3125	5/16	1.575	3.701
DH463021	21/64	.3281	11/32	1.673	3.937
DH714021	21/64	.3281	3/8	1.673	3.937
DH463217	Q	.3320	11/32	1.673	3.937
DH714217	Q	.3320	3/8	1.673	3.937
DH463022	11/32	.3438	11/32	1.772	3.937
DH714022	11/32	.3438	3/8	1.772	3.937
DH714023	23/64	.3594	3/8	1.870	4.174
DH463023	23/64	.3594	25/64	1.870	4.174
DH714221	U	.3680	3/8	1.870	4.174
DH463221	U	.3680	25/64	1.870	4.174
DH714024	3/8	.3750	3/8	1.969	4.174
DH463024	3/8	.3750	25/64	1.969	4.174
DH463025	25/64	.3906	25/64	1.969	4.174
DH714025	25/64	.3906	7/16	1.969	4.174
DH463026	13/32	.4062	27/64	2.067	4.567
DH714026	13/32	.4062	7/16	2.067	4.567
DH463027	27/64	.4219	27/64	2.165	4.567
DH714027	27/64	.4219	7/16	2.165	4.567
DH714028	7/16	.4375	7/16	2.264	4.803
DH463028	7/16	.4375	15/32	2.264	4.803
DH463029	29/64	.4531	15/32	2.264	4.803

- ▶ See recommended cutting speed on page 47.
- ▶ Other shank types are available upon your request.

NEXT PAGE ▶

TiAIN-COATED SOLID CARBIDE DREAM DRILLS INOX with Coolant Holes

DH463 | DH714 SERIES



CARBIDE
140°
20 bar
Page 47

STUB

3 × D

Unit: Inch

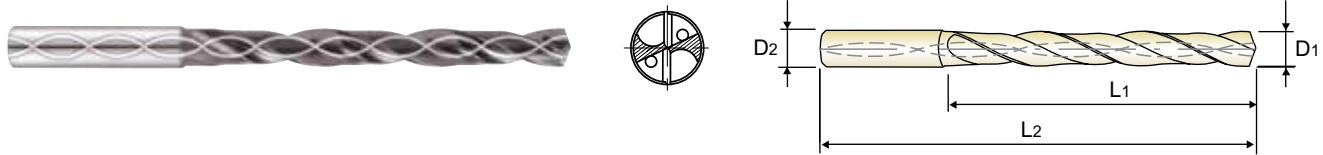
EDP No.	Drill Diameter		Shank Diameter	Flute Length	Overall Length
	Fractional	Decimal			
TiAIN	D1		D2	L1	L2
DH714029	29/64	.4531	1/2	2.264	4.803
DH463030	15/32	.4688	15/32	2.362	4.803
DH714030	15/32	.4688	1/2	2.362	4.803
DH463031	31/64	.4844	1/2	2.461	5.039
DH463032	1/2	.5000	1/2	2.559	5.039
DH463033	33/64	.5156	35/64	2.657	5.276
DH714033	33/64	.5156	9/16	2.657	5.276
DH463034	17/32	.5312	35/64	2.756	5.276
DH714034	17/32	.5312	9/16	2.756	5.276

EDP No.	Drill Diameter		Shank Diameter	Flute Length	Overall Length
	Fractional	Decimal			
TiAIN	D1		D2	L1	L2
DH463035	35/64	.5469	35/64	2.756	5.276
DH714035	35/64	.5469	9/16	2.756	5.276
DH714036	9/16	.5625	9/16	2.854	5.512
DH463036	9/16	.5625	37/64	2.854	5.512
DH463037	37/64	.5781	37/64	2.953	5.512
DH714037	37/64	.5781	5/8	2.953	5.512
DH463038	19/32	.5937	5/8	3.051	5.709
DH463039	39/64	.6094	5/8	3.051	5.709
DH463040	5/8	.6250	5/8	3.150	5.709

- ▶ See recommended cutting speed on page 47.
- ▶ Other shank types are available upon your request.

TiAIN-COATED SOLID CARBIDE DREAM DRILLS INOX with Coolant Holes

DH464 | DH715 SERIES



Page 47

LONG

5 × D

Unit: Inch

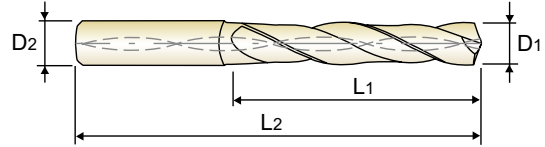
EDP No.	Drill Diameter		Shank Diameter	Flute Length	Overall Length
	Fractional	Decimal			
TiAIN	D1		D2	L1	L2
DH464013	13/64	.2031	15/64	1-3/4	3-15/16
DH715013	13/64	.2031	1/4	1-3/4	3-15/16
DH464014	7/32	.2188	15/64	1-57/64	3-15/16
DH715014	7/32	.2188	1/4	1-57/64	3-15/16
DH464015	15/64	.2344	15/64	1-57/64	3-15/16
DH715015	15/64	.2344	1/4	1-57/64	3-15/16
DH715016	1/4	.2500	1/4	2-3/64	4-19/64
DH464016	1/4	.2500	17/64	2-3/64	4-19/64
DH464206	F	.2570	17/64	2-13/64	4-19/64
DH715206	F	.2570	5/16	2-13/64	4-19/64
DH464017	17/64	.2656	17/64	2-13/64	4-19/64
DH715017	17/64	.2656	5/16	2-13/64	4-19/64
DH464209	I	.2720	.2720	2-13/64	4-19/64
DH715209	I	.2720	5/16	2-13/64	4-19/64
DH464018	9/32	.2812	5/16	2-23/64	4-41/64
DH464019	19/64	.2969	5/16	2-33/64	4-41/64
DH464020	5/16	.3125	5/16	2-33/64	4-41/64
DH464021	21/64	.3281	11/32	2-43/64	5
DH715021	21/64	.3281	3/8	2-43/64	5
DH464217	Q	.3320	11/32	2-43/64	5
DH715217	Q	.3320	3/8	2-43/64	5
DH464022	11/32	.3438	11/32	2-27/32	5

EDP No.	Drill Diameter		Shank Diameter	Flute Length	Overall Length
	Fractional	Decimal			
TiAIN	D1		D2	L1	L2
DH715022	11/32	.3438	3/8	2-27/32	5
DH715023	23/64	.3594	3/8	3	5-23/64
DH464023	23/64	.3594	25/64	3	5-23/64
DH715221	U	.3680	3/8	3	5-23/64
DH464221	U	.3680	25/64	3	5-23/64
DH715024	3/8	.3750	3/8	3-5/32	5-23/64
DH464024	3/8	.3750	25/64	3-5/32	5-23/64
DH464025	25/64	.3906	25/64	3-5/32	5-23/64
DH715025	25/64	.3906	7/16	3-5/32	5-23/64
DH464026	13/32	.4062	27/64	3-5/16	5-7/8
DH715026	13/32	.4062	7/16	3-5/16	5-7/8
DH464027	27/64	.4219	27/64	3-15/32	5-7/8
DH715027	27/64	.4219	7/16	3-15/32	5-7/8
DH715028	7/16	.4375	7/16	3-5/8	6-7/32
DH464028	7/16	.4375	15/32	3-5/8	6-7/32
DH464029	29/64	.4531	15/32	3-25/32	6-7/32
DH715029	29/64	.4531	1/2	3-25/32	6-7/32
DH464030	15/32	.4688	15/32	3-25/32	6-7/32
DH715030	15/32	.4688	1/2	3-25/32	6-7/32
DH464031	31/64	.4844	1/2	3-15/16	6-37/64
DH464032	1/2	.5000	1/2	4-3/32	6-37/64

- ▶ See recommended cutting speed on page 47.
- ▶ Other shank types are available upon your request.

TiAlN-COATED SOLID CARBIDE DREAM DRILLS INOX with Coolant Holes

DH451 SERIES



Page 47

SHORT

3 × D

Unit: Metric

EDP No.	Drill Diameter			Shank Diameter D2	Flute Length L1	Overall Length L2
	Metric	Fractional	Decimal			
TiAlN	D1			D2	L1	L2
DH451030	3.0		.1181	6	20	62
DH451031	3.1		.1220	6	20	62
DH451008F	3.175	1/8	.1250	6	20	62
DH451032	3.2		.1260	6	20	62
DH451033	3.3		.1299	6	20	62
DH451034	3.4		.1339	6	20	62
DH451035	3.5		.1378	6	20	62
DH451009F	3.572	9/64	.1406	6	20	62
DH451036	3.6		.1417	6	20	62
DH451037	3.7		.1457	6	20	62
DH451038	3.8		.1496	6	24	66
DH451039	3.9		.1535	6	24	66
DH451010F	3.969	5/32	.1563	6	24	66
DH451040	4.0		.1575	6	24	66
DH451041	4.1		.1614	6	24	66
DH451042	4.2		.1654	6	24	66
DH451043	4.3		.1693	6	24	66
DH451011F	4.366	11/64	.1719	6	24	66
DH451044	4.4		.1732	6	24	66
DH451045	4.5		.1772	6	24	66
DH451046	4.6		.1811	6	24	66
DH451047	4.7		.1850	6	24	66
DH451012F	4.763	3/16	.1875	6	24	66
DH451048	4.8		.1890	6	28	66
DH451049	4.9		.1929	6	28	66
DH451050	5.0		.1969	6	28	66
DH451051	5.1		.2008	6	28	66
DH451013F	5.159	13/64	.2031	6	28	66
DH451052	5.2		.2047	6	28	66

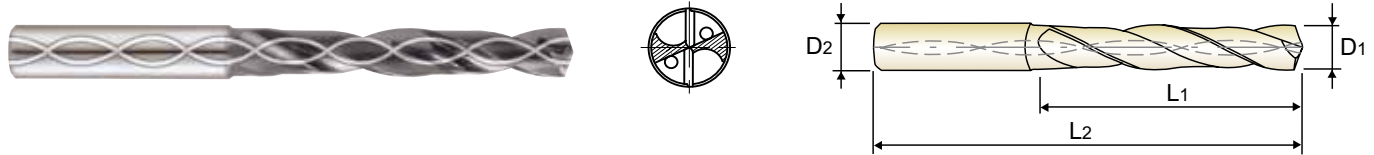
EDP No.	Drill Diameter			Shank Diameter D2	Flute Length L1	Overall Length L2
	Metric	Fractional	Decimal			
TiAlN	D1			D2	L1	L2
DH451053	5.3		.2087	6	28	66
DH451054	5.4		.2126	6	28	66
DH451055	5.5		.2165	6	28	66
DH451014F	5.556	7/32	.2188	6	28	66
DH451056	5.6		.2205	6	28	66
DH451057	5.7		.2244	6	28	66
DH451058	5.8		.2283	6	28	66
DH451059	5.9		.2323	6	28	66
DH451015F	5.953	15/64	.2344	6	28	66
DH451060	6.0		.2362	6	28	66
DH451061	6.1		.2402	8	34	79
DH451062	6.2		.2441	8	34	79
DH451063	6.3		.2480	8	34	79
DH451016F	6.350	1/4	.2500	8	34	79
DH451064	6.4		.2520	8	34	79
DH451065	6.5		.2559	8	34	79
DH451006L	6.528	F	.2570	8	34	79
DH451066	6.6		.2598	8	34	79
DH451067	6.7		.2638	8	34	79
DH451017F	6.747	17/64	.2656	8	34	79
DH451068	6.8		.2677	8	34	79
DH451069	6.9		.2717	8	34	79
DH451009L	6.909	I	.2720	8	34	79
DH451070	7.0		.2756	8	34	79
DH451071	7.1		.2795	8	41	79
DH451018F	7.144	9/32	.2812	8	41	79
DH451072	7.2		.2835	8	41	79
DH451073	7.3		.2874	8	41	79
DH451074	7.4		.2913	8	41	79

NEXT PAGE ►

- See recommended cutting speed on page 47.
- Other shank types are available upon your request.

TiAIN-COATED SOLID CARBIDE DREAM DRILLS INOX with Coolant Holes

DH451 SERIES



Page 47

SHORT

3 × D

Unit: Metric

EDP No.	Drill Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal			
TiAIN	D1			D2	L1	L2
DH451075	7.5		.2953	8	41	79
DH451019F	7.541	19/64	.2969	8	41	79
DH451076	7.6		.2992	8	41	79
DH451077	7.7		.3031	8	41	79
DH451078	7.8		.3071	8	41	79
DH451079	7.9		.3110	8	41	79
DH451020F	7.938	5/16	.3125	8	41	79
DH451080	8.0		.3150	8	41	79
DH451081	8.1		.3189	10	47	89
DH451082	8.2		.3228	10	47	89
DH451083	8.3		.3268	10	47	89
DH451021F	8.334	21/64	.3281	10	47	89
DH451084	8.4		.3307	10	47	89
DH451017L	8.433	Q	.3320	10	47	89
DH451085	8.5		.3346	10	47	89
DH451086	8.6		.3386	10	47	89
DH451087	8.7		.3425	10	47	89
DH451022F	8.731	11/32	.3438	10	47	89
DH451088	8.8		.3465	10	47	89
DH451089	8.9		.3504	10	47	89
DH451090	9.0		.3543	10	47	89
DH451091	9.1		.3583	10	47	89
DH451023F	9.128	23/64	.3594	10	47	89
DH451092	9.2		.3622	10	47	89
DH451093	9.3		.3661	10	47	89
DH451021L	9.347	U	.3680	10	47	89
DH451094	9.4		.3701	10	47	89
DH451095	9.5		.3740	10	47	89
DH451024F	9.525	3/8	.3750	10	47	89
DH451096	9.6		.3780	10	47	89

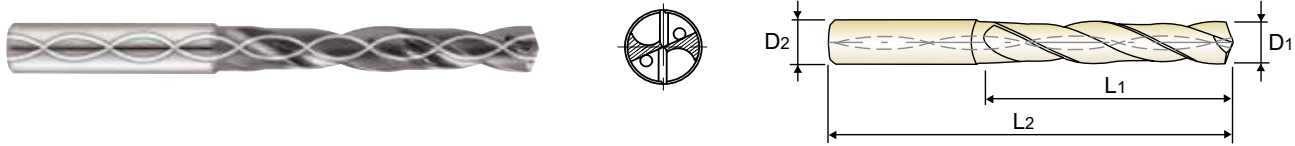
EDP No.	Drill Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal			
TiAIN	D1			D2	L1	L2
DH451097	9.7		.3819	10	47	89
DH451098	9.8		.3858	10	47	89
DH451099	9.9		.3898	10	47	89
DH451025F	9.922	25/64	.3906	10	47	89
DH451100	10.0		.3937	10	47	89
DH451101	10.1		.3976	12	55	102
DH451102	10.2		.4016	12	55	102
DH451103	10.3		.4055	12	55	102
DH451026F	10.319	13/32	.4062	12	55	102
DH451104	10.4		.4094	12	55	102
DH451105	10.5		.4134	12	55	102
DH451106	10.6		.4173	12	55	102
DH451107	10.7		.4212	12	55	102
DH451027F	10.716	27/64	.4219	12	55	102
DH451108	10.8		.4252	12	55	102
DH451109	10.9		.4291	12	55	102
DH451110	11.0		.4330	12	55	102
DH451111	11.1		.4370	12	55	102
DH451028F	11.113	7/16	.4375	12	55	102
DH451112	11.2		.4409	12	55	102
DH451113	11.3		.4448	12	55	102
DH451114	11.4		.4488	12	55	102
DH451115	11.5		.4527	12	55	102
DH451029F	11.509	29/64	.4531	12	55	102
DH451116	11.6		.4566	12	55	102
DH451117	11.7		.4606	12	55	102
DH451118	11.8		.4645	12	55	102
DH451119	11.9		.4685	12	55	102
DH451030F	11.906	15/32	.4688	12	55	102
DH451120	12.0		.4724	12	55	102

- ▶ See recommended cutting speed on page 47.
- ▶ Other shank types are available upon your request.

NEXT PAGE ▶

TiAIN-COATED SOLID CARBIDE DREAM DRILLS INOX with Coolant Holes

DH451 SERIES



Page 47

SHORT

3 × D

Unit: Metric

EDP No.	Drill Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal			
TiAIN	D1			D2	L1	L2
DH451121	12.1		.4764	14	60	107
DH451122	12.2		.4803	14	60	107
DH451123	12.3		.4843	14	60	107
DH451031F	12.303	31/64	.4844	14	60	107
DH451124	12.4		.4882	14	60	107
DH451125	12.5		.4921	14	60	107
DH451126	12.6		.4961	14	60	107
DH451032F	12.7	1/2	.5000	14	60	107
DH451128	12.8		.5039	14	60	107
DH451129	12.9		.5079	14	60	107
DH451130	13.0		.5118	14	60	107
DH451131	13.1		.5157	14	60	107
DH451132	13.2		.5197	14	60	107
DH451133	13.3		.5236	14	60	107
DH451134	13.4		.5276	14	60	107
DH451135	13.5		.5314	14	60	107
DH451136	13.6		.5354	14	60	107
DH451137	13.7		.5394	14	60	107
DH451138	13.8		.5433	14	60	107
DH451139	13.9		.5472	14	60	107
DH451140	14.0		.5512	14	60	107
DH451141	14.1		.5551	16	65	115
DH451142	14.2		.5591	16	65	115
DH451036F	14.288	9/16	.5625	16	65	115
DH451143	14.3		.5630	16	65	115
DH451144	14.4		.5669	16	65	115
DH451145	14.5		.5708	16	65	115
DH451146	14.6		.5748	16	65	115
DH451147	14.7		.5787	16	65	115
DH451148	14.8		.5827	16	65	115

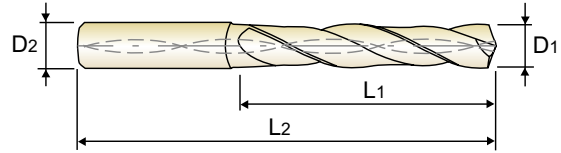
EDP No.	Drill Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal			
TiAIN	D1			D2	L1	L2
DH451149	14.9		.5866	16	65	115
DH451150	15.0		.5905	16	65	115
DH451151	15.1		.5945	16	65	115
DH451152	15.2		.5984	16	65	115
DH451153	15.3		.6024	16	65	115
DH451154	15.4		.6063	16	65	115
DH451155	15.5		.6102	16	65	115
DH451156	15.6		.6142	16	65	115
DH451157	15.7		.6181	16	65	115
DH451158	15.8		.6220	16	65	115
DH451040F	15.875	5/8	.6250	16	65	115
DH451159	15.9		.6260	16	65	115
DH451160	16.0		.6299	16	65	115
DH451161	16.1		.6339	18	73	123
DH451162	16.2		.6378	18	73	123
DH451163	16.3		.6417	18	73	123
DH451164	16.4		.6457	18	73	123
DH451165	16.5		.6495	18	73	123
DH451166	16.6		.6535	18	73	123
DH451167	16.7		.6575	18	73	123
DH451168	16.8		.6614	18	73	123
DH451169	16.9		.6654	18	73	123
DH451170	17.0		.6692	18	73	123
DH451171	17.1		.6732	18	73	123
DH451172	17.2		.6772	18	73	123
DH451173	17.3		.6811	18	73	123
DH451174	17.4		.6850	18	73	123
DH451044F	17.463	11/16	.6875	18	73	123
DH451175	17.5		.6889	18	73	123
DH451176	17.6		.6929	18	73	123

NEXT PAGE ►

- See recommended cutting speed on page 47.
- Other shank types are available upon your request.

TiAIN-COATED SOLID CARBIDE DREAM DRILLS INOX with Coolant Holes

DH451 SERIES



DIN 6537
CARBIDE
h6
m7
140°
20 bar

Page 47

SHORT

3 × D

Unit: Metric

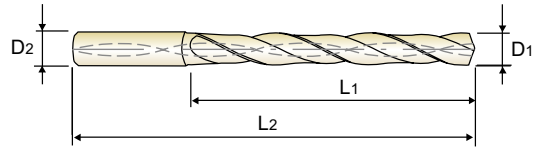
EDP No.	Drill Diameter			Shank Diameter	Flute Length		Overall Length
	Metric	Fractional	Decimal		L ₁	L ₂	
TiAIN	D ₁			D ₂	L ₁	L ₂	
DH451177	17.7		.6968	18	73	123	
DH451178	17.8		.7008	18	73	123	
DH451179	17.9		.7047	18	73	123	
DH451180	18.0		.7087	18	73	123	
DH451181	18.1		.7126	20	79	131	
DH451182	18.2		.7165	20	79	131	
DH451183	18.3		.7205	20	79	131	
DH451184	18.4		.7244	20	79	131	
DH451185	18.5		.7283	20	79	131	
DH451186	18.6		.7323	20	79	131	
DH451187	18.7		.7362	20	79	131	
DH451188	18.8		.7402	20	79	131	
DH451189	18.9		.7441	20	79	131	

EDP No.	Drill Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal			
TiAIN	D ₁			D ₂	L ₁	L ₂
DH451190	19.0		.7480	20	79	131
DH451048F	19.050	3/4	.7500	20	79	131
DH451191	19.1		.7520	20	79	131
DH451192	19.2		.7559	20	79	131
DH451193	19.3		.7598	20	79	131
DH451194	19.4		.7638	20	79	131
DH451195	19.5		.7676	20	79	131
DH451196	19.6		.7717	20	79	131
DH451197	19.7		.7756	20	79	131
DH451198	19.8		.7795	20	79	131
DH451199	19.9		.7835	20	79	131
DH451200	20.0		.7874	20	79	131

- ▶ See recommended cutting speed on page 47.
- ▶ Other shank types are available upon your request.

TiAIN-COATED SOLID CARBIDE DREAM DRILLS INOX with Coolant Holes

DH452 SERIES



DIN 6537
CARBIDE
h6
m7
140°
20 bar

LONG

5 × D

Page 47

Unit: Metric

EDP No.	Drill Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal			
TiAIN	D1			D2	L1	L2
DH452010	1.0		.0394	3	8	55
DH452011	1.1		.0433	3	12	55
DH452012	1.2		.0472	3	12	55
DH452013	1.3		.0512	3	12	55
DH452014	1.4		.0551	3	12	55
DH452015	1.5		.0591	3	16	55
DH452004F	1.588	1/16	.0625	3	16	55
DH452016	1.6		.0630	3	16	55
DH452017	1.7		.0669	3	16	55
DH452018	1.8		.0709	3	16	55
DH452019	1.9		.0748	3	16	55
DH452005F	1.984	5/64	.0781	3	16	55
DH452020	2.0		.0787	4	21	57
DH452021	2.1		.0827	4	21	57
DH452022	2.2		.0866	4	21	57
DH452023	2.3		.0906	4	21	57
DH452006F	2.381	3/32	.0938	4	21	57
DH452024	2.4		.0945	4	21	57
DH452025	2.5		.0984	4	21	57
DH452026	2.6		.1024	4	21	57
DH452027	2.7		.1063	4	21	57
DH452007F	2.778	7/64	.1094	4	21	57
DH452028	2.8		.1102	4	21	57
DH452029	2.9		.1142	4	21	57
DH452030	3.0		.1181	6	28	66
DH452031	3.1		.1220	6	28	66
DH452008F	3.175	1/8	.1250	6	28	66
DH452032	3.2		.1260	6	28	66
DH452033	3.3		.1299	6	28	66
DH452034	3.4		.1339	6	28	66

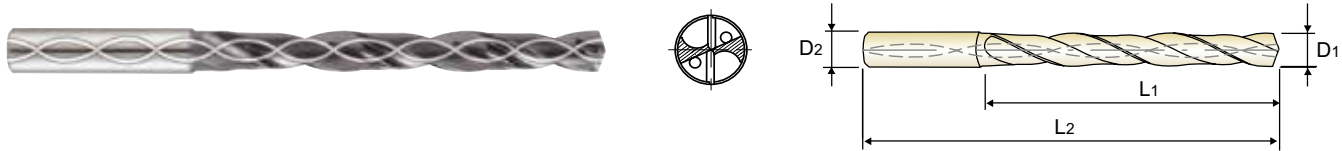
EDP No.	Drill Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal			
TiAIN	D1			D2	L1	L2
DH452035	3.5		.1378	6	28	66
DH452009F	3.572	9/64	.1406	6	28	66
DH452036	3.6		.1417	6	28	66
DH452037	3.7		.1457	6	28	66
DH452038	3.8		.1496	6	36	74
DH452039	3.9		.1535	6	36	74
DH452010F	3.969	5/32	.1563	6	36	74
DH452040	4.0		.1575	6	36	74
DH452041	4.1		.1614	6	36	74
DH452042	4.2		.1654	6	36	74
DH452043	4.3		.1693	6	36	74
DH452011F	4.366	11/64	.1719	6	36	74
DH452044	4.4		.1732	6	36	74
DH452045	4.5		.1772	6	36	74
DH452046	4.6		.1811	6	36	74
DH452047	4.7		.1850	6	36	74
DH452012F	4.763	3/16	.1875	6	36	74
DH452048	4.8		.1890	6	44	82
DH452049	4.9		.1929	6	44	82
DH452050	5.0		.1969	6	44	82
DH452051	5.1		.2008	6	44	82
DH452013F	5.159	13/64	.2031	6	44	82
DH452052	5.2		.2047	6	44	82
DH452053	5.3		.2087	6	44	82
DH452054	5.4		.2126	6	44	82
DH452055	5.5		.2165	6	44	82
DH452014F	5.556	7/32	.2188	6	44	82
DH452056	5.6		.2205	6	44	82
DH452057	5.7		.2244	6	44	82
DH452058	5.8		.2283	6	44	82

NEXT PAGE ►

- See recommended cutting speed on page 47.
- Other shank types are available upon your request.

TiAlN-COATED SOLID CARBIDE DREAM DRILLS INOX with Coolant Holes

DH452 SERIES



Page 47

LONG

5 × D

Unit: Metric

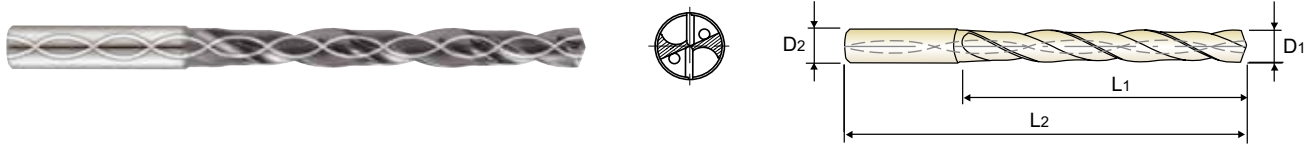
EDP No.	Drill Diameter			Shank Diameter	Flute Length	Overall Length	EDP No.	Drill Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal					Metric	Fractional	Decimal			
TiAlN	D1			D2	L1	L2	TiAlN	D1			D2	L1	L2
DH452059	5.9		.2323	6	44	82	DH452081	8.1		.3189	10	61	103
DH452015F	5.953	15/64	.2344	6	44	82	DH452082	8.2		.3228	10	61	103
DH452060	6.0		.2362	6	44	82	DH452083	8.3		.3268	10	61	103
DH452061	6.1		.2402	8	53	91	DH452021F	8.334	21/64	.3281	10	61	103
DH452062	6.2		.2441	8	53	91	DH452084	8.4		.3307	10	61	103
DH452063	6.3		.2480	8	53	91	DH452017L	8.433	Q	.3320	10	61	103
DH452016F	6.350	1/4	.2500	8	53	91	DH452085	8.5		.3346	10	61	103
DH452064	6.4		.2520	8	53	91	DH452086	8.6		.3386	10	61	103
DH452065	6.5		.2559	8	53	91	DH452087	8.7		.3425	10	61	103
DH452006L	6.528	F	.2570	8	53	91	DH452022F	8.731	11/32	.3438	10	61	103
DH452066	6.6		.2598	8	53	91	DH452088	8.8		.3465	10	61	103
DH452067	6.7		.2638	8	53	91	DH452089	8.9		.3504	10	61	103
DH452017F	6.747	17/64	.2656	8	53	91	DH452090	9.0		.3543	10	61	103
DH452068	6.8		.2677	8	53	91	DH452091	9.1		.3583	10	61	103
DH452069	6.9		.2717	8	53	91	DH452023F	9.128	23/64	.3594	10	61	103
DH452009L	6.909	I	.2720	8	53	91	DH452092	9.2		.3622	10	61	103
DH452070	7.0		.2756	8	53	91	DH452093	9.3		.3661	10	61	103
DH452071	7.1		.2795	8	53	91	DH452021L	9.347	U	.3680	10	61	103
DH452018F	7.144	9/32	.2812	8	53	91	DH452094	9.4		.3701	10	61	103
DH452072	7.2		.2835	8	53	91	DH452095	9.5		.3740	10	61	103
DH452073	7.3		.2874	8	53	91	DH452024F	9.525	3/8	.3750	10	61	103
DH452074	7.4		.2913	8	53	91	DH452096	9.6		.3780	10	61	103
DH452075	7.5		.2953	8	53	91	DH452097	9.7		.3819	10	61	103
DH452019F	7.541	19/64	.2969	8	53	91	DH452098	9.8		.3858	10	61	103
DH452076	7.6		.2992	8	53	91	DH452099	9.9		.3898	10	61	103
DH452077	7.7		.3031	8	53	91	DH452025F	9.922	25/64	.3906	10	61	103
DH452078	7.8		.3071	8	53	91	DH452100	10.0		.3937	10	61	103
DH452079	7.9		.3110	8	53	91	DH452101	10.1		.3976	12	71	118
DH452020F	7.938	5/16	.3125	8	53	91	DH452102	10.2		.4016	12	71	118
DH452080	8.0		.3150	8	53	91	DH452103	10.3		.4055	12	71	118

- ▶ See recommended cutting speed on page 47.
- ▶ Other shank types are available upon your request.

NEXT PAGE ▶

TiAIN-COATED SOLID CARBIDE DREAM DRILLS INOX with Coolant Holes

DH452 SERIES



DIN 6537
CARBIDE
h6
m7
140°
20 bar

LONG
5 × D

Page 47

Unit: Metric

EDP No.	Drill Diameter			Shank Diameter D2	Flute Length L1	Overall Length L2
	Metric	Fractional	Decimal			
TiAIN	D1			D2	L1	L2
DH452026F	10.319	13/32	.4062	12	71	118
DH452104	10.4		.4094	12	71	118
DH452105	10.5		.4134	12	71	118
DH452106	10.6		.4173	12	71	118
DH452107	10.7		.4212	12	71	118
DH452027F	10.716	27/64	.4219	12	71	118
DH452108	10.8		.4252	12	71	118
DH452109	10.9		.4291	12	71	118
DH452110	11.0		.4330	12	71	118
DH452111	11.1		.4370	12	71	118
DH452028F	11.113	7/16	.4375	12	71	118
DH452112	11.2		.4409	12	71	118
DH452113	11.3		.4448	12	71	118
DH452114	11.4		.4488	12	71	118
DH452115	11.5		.4527	12	71	118
DH452029F	11.509	29/64	.4531	12	71	118
DH452116	11.6		.4566	12	71	118
DH452117	11.7		.4606	12	71	118
DH452118	11.8		.4645	12	71	118
DH452119	11.9		.4685	12	71	118
DH452030F	11.906	15/32	.4688	12	71	118
DH452120	12.0		.4724	12	71	118
DH452121	12.1		.4764	14	77	124
DH452122	12.2		.4803	14	77	124
DH452123	12.3		.4843	14	77	124
DH452031F	12.303	31/64	.4844	14	77	124
DH452124	12.4		.4882	14	77	124
DH452125	12.5		.4921	14	77	124
DH452126	12.6		.4961	14	77	124
DH452032F	12.7	1/2	.5000	14	77	124

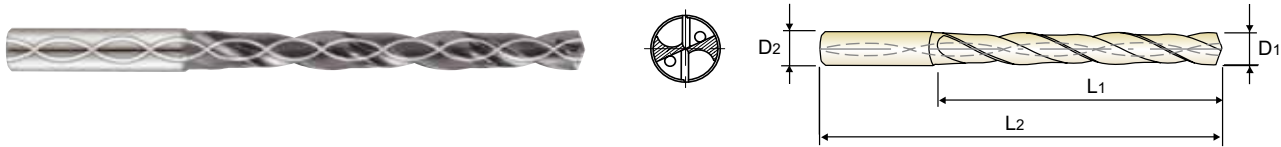
EDP No.	Drill Diameter			Shank Diameter D2	Flute Length L1	Overall Length L2
	Metric	Fractional	Decimal			
TiAIN	D1			D2	L1	L2
DH452128	12.8		.5039	14	77	124
DH452129	12.9		.5079	14	77	124
DH452130	13.0		.5118	14	77	124
DH452131	13.1		.5157	14	77	124
DH452132	13.2		.5197	14	77	124
DH452133	13.3		.5236	14	77	124
DH452134	13.4		.5276	14	77	124
DH452135	13.5		.5314	14	77	124
DH452136	13.6		.5354	14	77	124
DH452137	13.7		.5394	14	77	124
DH452138	13.8		.5433	14	77	124
DH452139	13.9		.5472	14	77	124
DH452140	14.0		.5512	14	77	124
DH452141	14.1		.5551	16	83	133
DH452142	14.2		.5591	16	83	133
DH452036F	14.288	9/16	.5625	16	83	133
DH452143	14.3		.5630	16	83	133
DH452144	14.4		.5669	16	83	133
DH452145	14.5		.5708	16	83	133
DH452146	14.6		.5748	16	83	133
DH452147	14.7		.5787	16	83	133
DH452148	14.8		.5827	16	83	133
DH452149	14.9		.5866	16	83	133
DH452150	15.0		.5905	16	83	133
DH452151	15.1		.5945	16	83	133
DH452152	15.2		.5984	16	83	133
DH452153	15.3		.6024	16	83	133
DH452154	15.4		.6063	16	83	133
DH452155	15.5		.6102	16	83	133
DH452156	15.6		.6142	16	83	133

- ▶ See recommended cutting speed on page 47.
- ▶ Other shank types are available upon your request.

NEXT PAGE ▶

TiAIN-COATED SOLID CARBIDE DREAM DRILLS INOX with Coolant Holes

DH452 SERIES



Page 47

LONG

5 × D

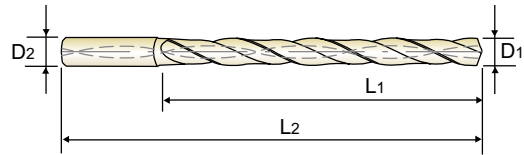
Unit: Metric

EDP No.	Drill Diameter			Shank Diameter	Flute Length	Overall Length	EDP No.	Drill Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal					Metric	Fractional	Decimal			
TiAIN	D1			D2	L1	L2	TiAIN	D1			D2	L1	L2
DH452157	15.7		.6181	16	83	133	DH452179	17.9		.7047	18	93	143
DH452158	15.8		.6220	16	83	133	DH452180	18.0		.7087	18	93	143
DH452040F	15.875	5/8	.6250	16	83	133	DH452181	18.1		.7126	20	101	153
DH452159	15.9		.6260	16	83	133	DH452182	18.2		.7165	20	101	151
DH452160	16.0		.6299	16	83	133	DH452183	18.3		.7205	20	101	151
DH452161	16.1		.6339	18	93	143	DH452184	18.4		.7244	20	101	153
DH452162	16.2		.6378	18	93	143	DH452185	18.5		.7283	20	101	153
DH452163	16.3		.6417	18	93	143	DH452186	18.6		.7323	20	101	151
DH452164	16.4		.6457	18	93	143	DH452187	18.7		.7362	20	101	153
DH452165	16.5		.6495	18	93	143	DH452188	18.8		.7402	20	101	153
DH452166	16.6		.6535	18	93	143	DH452189	18.9		.7441	20	101	153
DH452167	16.7		.6575	18	93	143	DH452190	19.0		.7480	20	101	153
DH452168	16.8		.6614	18	93	143	DH452048F	19.050	3/4	.7500	20	101	153
DH452169	16.9		.6654	18	93	143	DH452191	19.1		.7520	20	101	151
DH452170	17.0		.6692	18	93	143	DH452192	19.2		.7559	20	101	151
DH452171	17.1		.6732	18	93	143	DH452193	19.3		.7598	20	101	151
DH452172	17.2		.6772	18	93	143	DH452194	19.4		.7638	20	101	151
DH452173	17.3		.6811	18	93	143	DH452195	19.5		.7676	20	101	153
DH452174	17.4		.6850	18	93	143	DH452196	19.6		.7717	20	101	151
DH452175	17.5		.6889	18	93	143	DH452197	19.7		.7756	20	101	151
DH452176	17.6		.6929	18	93	143	DH452198	19.8		.7795	20	101	153
DH452177	17.7		.6968	18	93	143	DH452199	19.9		.7835	20	101	151
DH452178	17.8		.7008	18	93	143	DH452200	20.0		.7874	20	101	153

- ▶ See recommended cutting speed on page 47.
- ▶ Other shank types are available upon your request.

TiAIN-COATED SOLID CARBIDE DREAM DRILLS INOX with Coolant Holes

DH453 SERIES



DIN 6537
CARBIDE
h6
m7
140°
20 bar
Page 47

EXTRA LONG

8 × D

Unit: Metric

EDP No.	Drill Diameter			Shank Diameter D ₂	Flute Length L ₁	Overall Length L ₂
	Metric	Fractional	Decimal			
TiAIN	D ₁					
DH453030	3.0		.1181	6	34	72
DH453031	3.1		.1220	6	34	72
DH453008F	3.175	1/8	.1250	6	34	72
DH453032	3.2		.1260	6	34	72
DH453033	3.3		.1299	6	34	72
DH453034	3.4		.1339	6	34	72
DH453229G	3.454	#29	.1360	6	34	72
DH453035	3.5		.1378	6	34	72
DH453009F	3.572	9/64	.1406	6	34	72
DH453036	3.6		.1417	6	34	72
DH453037	3.7		.1457	6	34	72
DH453038	3.8		.1496	6	43	81
DH453039	3.9		.1535	6	43	81
DH453010F	3.969	5/32	.1563	6	43	81
DH453040	4.0		.1575	6	43	81
DH453221G	4.038	#21	.1590	6	43	81
DH453041	4.1		.1614	6	43	81
DH453042	4.2		.1654	6	43	81
DH453043	4.3		.1693	6	43	81
DH453011F	4.366	11/64	.1719	6	43	81
DH453044	4.4		.1732	6	43	81
DH453045	4.5		.1772	6	43	81
DH453046	4.6		.1811	6	43	81
DH453047	4.7		.1850	6	43	81
DH453012F	4.763	3/16	.1875	6	57	95
DH453048	4.8		.1890	6	57	95
DH453049	4.9		.1929	6	57	95
DH453050	5.0		.1969	6	57	95
DH453051	5.1		.2008	6	57	95
DH453013F	5.159	13/64	.2031	6	57	95

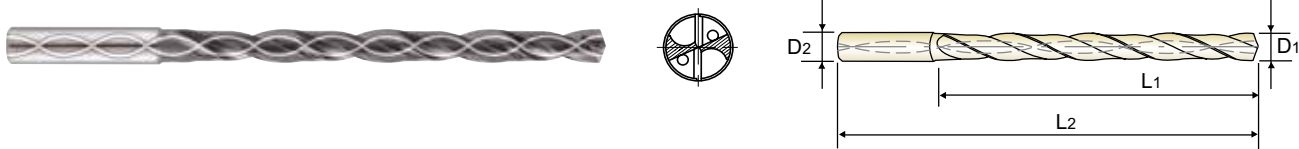
EDP No.	Drill Diameter			Shank Diameter D ₂	Flute Length L ₁	Overall Length L ₂
	Metric	Fractional	Decimal			
TiAIN	D ₁					
DH453052	5.2		.2047	6	57	95
DH453053	5.3		.2087	6	57	95
DH453054	5.4		.2126	6	57	95
DH453055	5.5		.2165	6	57	95
DH453014F	5.556	7/32	.2188	6	57	95
DH453056	5.6		.2205	6	57	95
DH453057	5.7		.2244	6	57	95
DH453058	5.8		.2283	6	57	95
DH453059	5.9		.2323	6	57	95
DH453015F	5.953	15/64	.2344	6	57	95
DH453060	6.0		.2362	6	57	95
DH453061	6.1		.2402	8	76	114
DH453062	6.2		.2441	8	76	114
DH453063	6.3		.2480	8	76	114
DH453016F	6.350	1/4	.2500	8	76	114
DH453064	6.4		.2520	8	76	114
DH453065	6.5		.2559	8	76	114
DH453106L	6.527	F	.2570	8	76	114
DH453066	6.6		.2598	8	76	114
DH453067	6.7		.2638	8	76	114
DH453017F	6.747	17/64	.2656	8	76	114
DH453068	6.8		.2677	8	76	114
DH453069	6.9		.2717	8	76	114
DH453009L	6.909	I	.2720	8	76	114
DH453070	7.0		.2756	8	76	114
DH453071	7.1		.2795	8	76	114
DH453018F	7.144	9/32	.2813	8	76	114
DH453072	7.2		.2835	8	76	114
DH453073	7.3		.2874	8	76	114
DH453074	7.4		.2913	8	76	114

NEXT PAGE ►

- See recommended cutting speed on page 47.
- Other shank types are available upon your request.

TiAIN-COATED SOLID CARBIDE DREAM DRILLS INOX with Coolant Holes

DH453 SERIES



Page 47

EXTRA LONG

8 × D

Unit: Metric

EDP No.	Drill Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal			
TiAIN	D1			D2	L1	L2
DH453075	7.5		.2953	8	76	114
DH453019F	7.541	19/64	.2969	8	76	114
DH453076	7.6		.2992	8	76	114
DH453077	7.7		.3031	8	76	114
DH453078	7.8		.3071	8	76	114
DH453079	7.9		.3110	8	76	114
DH453020F	7.938	5/16	.3125	8	76	114
DH453080	8.0		.3150	8	76	114
DH453081	8.1		.3189	10	95	142
DH453082	8.2		.3228	10	95	142
DH453083	8.3		.3268	10	95	142
DH453021F	8.334	21/64	.3281	10	95	142
DH453084	8.4		.3307	10	95	142
DH453117L	8.432	Q	.3320	10	95	142
DH453085	8.5		.3346	10	95	142
DH453086	8.6		.3386	10	95	142
DH453087	8.7		.3425	10	95	142
DH453022F	8.731	11/32	.3438	10	95	142
DH453088	8.8		.3465	10	95	142
DH453089	8.9		.3504	10	95	142
DH453090	9.0		.3543	10	95	142
DH453091	9.1		.3583	10	95	142
DH453023F	9.128	23/64	.3594	10	95	142
DH453092	9.2		.3622	10	95	142
DH453093	9.3		.3661	10	95	142
DH453121L	9.347	U	.3680	10	95	142
DH453094	9.4		.3701	10	95	142
DH453095	9.5		.3740	10	95	142
DH453024F	9.525	3/8	.3750	10	95	142
DH453096	9.6		.3780	10	95	142

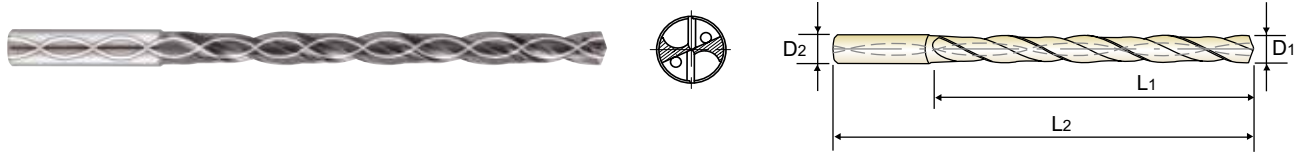
EDP No.	Drill Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal			
TiAIN	D1			D2	L1	L2
DH453097	9.7		.3819	10	95	142
DH453098	9.8		.3858	10	95	142
DH453099	9.9		.3898	10	95	142
DH453025F	9.922	25/64	.3906	10	95	142
DH453100	10.0		.3937	10	95	142
DH453101	10.1		.3976	12	114	162
DH453102	10.2		.4016	12	114	162
DH453103	10.3		.4055	12	114	162
DH453026F	10.319	13/32	.4063	12	114	162
DH453104	10.4		.4094	12	114	162
DH453105	10.5		.4134	12	114	162
DH453106	10.6		.4173	12	114	162
DH453107	10.7		.4212	12	114	162
DH453027F	10.716	27/64	.4219	12	114	162
DH453108	10.8		.4252	12	114	162
DH453109	10.9		.4291	12	114	162
DH453110	11.0		.4330	12	114	162
DH453111	11.1		.4370	12	114	162
DH453028F	11.113	7/16	.4375	12	114	162
DH453112	11.2		.4409	12	114	162
DH453113	11.3		.4448	12	114	162
DH453114	11.4		.4488	12	114	162
DH453115	11.5		.4527	12	114	162
DH453029F	11.509	29/64	.4531	12	114	162
DH453116	11.6		.4566	12	114	162
DH453117	11.7		.4606	12	114	162
DH453118	11.8		.4645	12	114	162
DH453119	11.9		.4685	12	114	162
DH453030F	11.906	15/32	.4688	12	114	162
DH453120	12.0		.4724	12	114	162

- ▶ See recommended cutting speed on page 47.
- ▶ Other shank types are available upon your request.

NEXT PAGE ▶

TiAIN-COATED SOLID CARBIDE DREAM DRILLS INOX with Coolant Holes

DH453 SERIES



DIN 6537
CARBIDE
h6
m7
140°
20 bar
Page 47

EXTRA LONG

8 × D

Unit: Metric

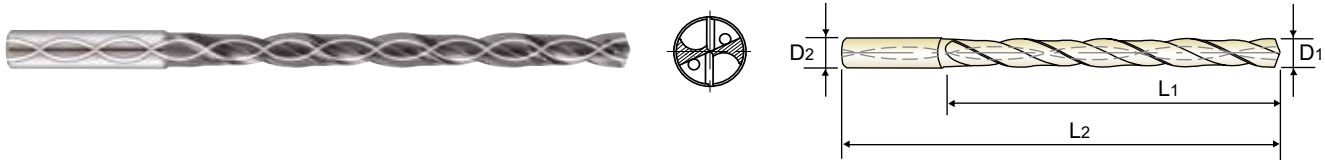
EDP No.	Drill Diameter			Shank Diameter	Flute Length	Overall Length	EDP No.	Drill Diameter			Shank Diameter	Flute Length	Overall Length
	Metric	Fractional	Decimal					Metric	Fractional	Decimal			
TiAIN	D1			D2	L1	L2	TiAIN	D1			D2	L1	L2
DH453121	12.1		.4764	14	133	178	DH453148	14.8		.5827	16	152	203
DH453122	12.2		.4803	14	133	178	DH453149	14.9		.5866	16	152	203
DH453123	12.3		.4843	14	133	178	DH453150	15.0		.5905	16	152	203
DH453031F	12.303	31/64	.4844	14	133	178	DH453151	15.1		.5945	16	152	203
DH453124	12.4		.4882	14	133	178	DH453152	15.2		.5984	16	152	203
DH453125	12.5		.4921	14	133	178	DH453153	15.3		.6024	16	152	203
DH453126	12.6		.4961	14	133	178	DH453154	15.4		.6063	16	152	203
DH453032F	12.7	1/2	.5000	14	133	178	DH453155	15.5		.6102	16	152	203
DH453128	12.8		.5039	14	133	178	DH453156	15.6		.6142	16	152	203
DH453129	12.9		.5079	14	133	178	DH453157	15.7		.6181	16	152	203
DH453130	13.0		.5118	14	133	178	DH453158	15.8		.6220	16	152	203
DH453033F	13.097	33/64	.5156	14	133	178	DH453040F	15.875	5/8	.6250	16	152	203
DH453131	13.1		.5157	14	133	178	DH453159	15.9		.6260	16	152	203
DH453132	13.2		.5197	14	133	178	DH453160	16.0		.6299	16	152	203
DH453133	13.3		.5236	14	133	178	DH453161	16.1		.6339	18	171	222
DH453134	13.4		.5276	14	133	178	DH453162	16.2		.6378	18	171	222
DH453135	13.5		.5314	14	133	178	DH453163	16.3		.6417	18	171	222
DH453136	13.6		.5354	14	133	178	DH453164	16.4		.6457	18	171	222
DH453137	13.7		.5394	14	133	178	DH453165	16.5		.6496	18	171	222
DH453138	13.8		.5433	14	133	178	DH453166	16.6		.6535	18	171	222
DH453139	13.9		.5472	14	133	178	DH453167	16.7		.6575	18	171	222
DH453140	14.0		.5512	14	133	178	DH453168	16.8		.6614	18	171	222
DH453141	14.1		.5551	16	152	203	DH453169	16.9		.6654	18	171	222
DH453142	14.2		.5591	16	152	203	DH453170	17.0		.6693	18	171	222
DH453036F	14.288	9/16	.5625	16	152	203	DH453171	17.1		.6732	18	171	222
DH453143	14.3		.5630	16	152	203	DH453172	17.2		.6772	18	171	222
DH453144	14.4		.5669	16	152	203	DH453173	17.3		.6811	18	171	222
DH453145	14.5		.5709	16	152	203	DH453174	17.4		.6850	18	171	222
DH453146	14.6		.5748	16	152	203	DH453175	17.5		.6890	18	171	222
DH453147	14.7		.5787	16	152	203	DH453176	17.6		.6929	18	171	222

NEXT PAGE ►

- See recommended cutting speed on page 47.
- Other shank types are available upon your request.

TiAIN-COATED SOLID CARBIDE DREAM DRILLS INOX with Coolant Holes

DH453 SERIES



Page 47

EXTRA LONG

8 × D

Unit: Metric

EDP No.	Drill Diameter			Shank Diameter D2	Flute Length		Overall Length L2
	Metric	Fractional	Decimal		L1	L2	
TiAIN	D1			D2	L1	L2	
DH453177	17.7		.6968	18	171	222	
DH453178	17.8		.7008	18	171	222	
DH453179	17.9		.7047	18	171	222	
DH453180	18.0		.7087	18	171	222	
DH453181	18.1		.7126	20	190	243	
DH453182	18.2		.7165	20	190	243	
DH453183	18.3		.7205	20	190	243	
DH453184	18.4		.7244	20	190	243	
DH453185	18.5		.7283	20	190	243	
DH453186	18.6		.7323	20	190	243	
DH453187	18.7		.7362	20	190	243	
DH453188	18.8		.7402	20	190	243	
DH453189	18.9		.7441	20	190	243	

EDP No.	Drill Diameter			Shank Diameter D2	Flute Length		Overall Length L2
	Metric	Fractional	Decimal		L1	L2	
TiAIN	D1			D2	L1	L2	
DH453190	19.0		.7480	20	190	243	
DH453048F	19.050	3/4	.7500	20	190	243	
DH453191	19.1		.7520	20	190	243	
DH453192	19.2		.7559	20	190	243	
DH453193	19.3		.7598	20	190	243	
DH453194	19.4		.7638	20	190	243	
DH453195	19.5		.7677	20	190	243	
DH453196	19.6		.7717	20	190	243	
DH453197	19.7		.7756	20	190	243	
DH453198	19.8		.7795	20	190	243	
DH453199	19.9		.7835	20	190	243	
DH453200	20.0		.7874	20	190	243	

- ▶ See recommended cutting speed on page 47.
- ▶ Other shank types are available upon your request.

RECOMMENDED CUTTING CONDITIONS

DH451 | DH463 | DH714 | DH452 | DH464 | DH715 | DH453 SERIES

WORK MATERIAL			M					
			STAINLESS STEELS			STAINLESS STEELS		
STRENGTH			< 800 N/mm ²			> 800 N/mm ²		
DRILLING SPEED (SFM)			120 ~ 230 ft/min			60 ~ 140 ft/min		
DIAMETER			RPM	FEED	IPR	RPM	FEED	IPR
Metric (mm)	Decimal	Fractional						
1.0	.0394		12000	0.02	.001	6200	0.02	.001
1.5	.0591		9000	0.03	.001	5400	0.02	.001
2.5	.0984		7000	0.04	.002	4200	0.03	.001
3.0	.1181	1/8	7400	0.04	.002	4700	0.02	.001
4.0	.1575	5/32	5600	0.05	.002	3600	0.03	.001
5.0	.1969	13/64	4400	0.05	.002	2800	0.03	.001
6.0	.2362	15/64	3700	0.06	.002	2400	0.04	.002
8.0	.3150	5/16	2800	0.08	.003	1800	0.06	.002
10.0	.3937	25/64	2200	0.10	.004	1400	0.08	.003
12.0	.4724	15/32	1900	0.12	.005	1200	0.10	.004
14.0	.5512	35/64	1600	0.15	.006	1000	0.12	.005
16.0	.6299	5/8	1400	0.20	.008	900	0.15	.006
18.0	.7087	45/64	1250	0.22	.009	800	0.17	.007
20.0	.7874	25/32	1120	0.24	.009	720	0.19	.007

- Recommended to reduce the feed rate as following:
 DH463/DH714/DH451(3xD), DH464/DH715/DH452(5xD) : Feed 100%
 DH453(8xD) : Feed 85%

RPM = rev./min.
 FEED = mm/rev.
 IPR = inch/rev



YG-1 TOOL HOLDERS:
***Engineered to make
working in stainless
painless.***

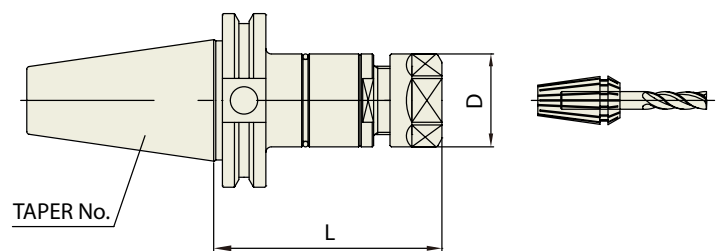
Every cutting tool is only as good as its holder. YG-1 understands your need to meet precision tolerances. So we designed the only tool holder that can make YG-1 taps work even better.

Synchro Tapping ER Chuck

Higher productivity through innovation

Tapping and Synchro tapping ER chucks with AT3 or better accuracy on all shank tapers:

- ▶ AT3 or better accuracy on all shank tapers
- ▶ Absorbs energy at the point of reversal to extend tap life and to improve thread quality
- ▶ For machines with synchronized tapping cycle
- ▶ Tap ER collets (inch and metric)
- ▶ All at an excellent price



ASME B5.50-2009-CAT

Unit : Metric

EDP No.	Taper No.	Model No.	Tap Size	Clamping Range	Nut	D	L
JK060SYT	40	CAT40AD/B-SYTER12-79	M3-M12	3.5-10	ER16	28	79
JK062SYT		CAT40AD/B-SYTER16-85	M3-M16	3.5-10	ER20	35	85
JK064SYT		CAT40AD/B-SYTER20-90	M3-M20	3.5-16	ER25	42	90
JK066SYT		CAT40AD/B-SYTER27-100	M4-M27	3.5-16	ER32	50	100
JK068SYT		CAT40AD/B-SYTER33-105	M4-M33	7-16	ER40	63	105
JL060SYT	50	CAT50AD/B-SYTER12-79	M3-M12	3.5-10	ER16	28	79
JL062SYT		CAT50AD/B-SYTER16-85	M3-M16	3.5-10	ER20	35	85
JL064SYT		CAT50AD/B-SYTER20-90	M3-M20	3.5-16	ER25	42	90
JL066SYT		CAT50AD/B-SYTER27-100	M4-M27	3.5-16	ER32	50	100
JL068SYT		CAT50AD/B-SYTER33-105	M4-M33	7-16	ER40	63	105

- ▶ BT(JIS B6339/MAS-403), HSK(DIN 69893/ISO 12164-1) and STRAIGHT-K are available upon request
- ▶ For details, please contact YG-1

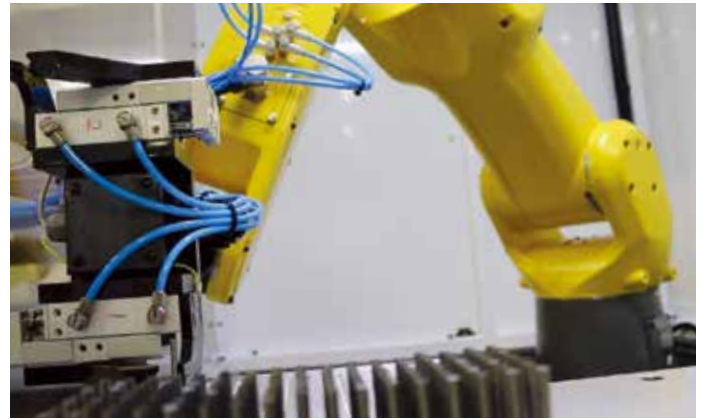
Global leader. Local partner.

The YG-1 Group has four major research and development centers strategically located around the world. These centers leverage YG-1's highest levels of skills and technologies to provide advanced machining solutions to our most demanding customers for challenging applications in every region. Their size and multidisciplinary focus facilitate effective interaction with industry organizations, educational institutions and customers to gain insights from scientific advancements and industry trends. This ensures that our research and development activities closely align with our customers' needs and market requirements.



High-quality products and on-time delivery for worldwide customers.

Since 1982, YG-1 has been committed to quality, innovation and the unique customer experience. Our performance and experience have earned YG-1 the global impression of one of the leading manufacturers of high-quality cutting tool solutions. This global footprint covers over 75 countries, including international logistics centers. And at every location, we pledge to deliver the best products and service available today and every day to every customer.



EUROPE

BELGIUM	FINLAND	ITALY	PORTUGAL	SLOVENIA	THE NETHERLANDS
CROATIA	FRANCE	LITHUANIA	ROMANIA	SPAIN	TURKEY
CZECH REPUBLIC	GERMANY	NORWAY	RUSSIA	SWEDEN	UNITED KINGDOM
DENMARK	HUNGARY	POLAND	SERBIA	SWITZERLAND	

ASIA PACIFIC

AUSTRALIA	INDONESIA	KINGDOM OF SAUDI ARABIA	SINGAPORE	UNITED ARAB EMIRATES
CHINA	ISRAEL	MALAYSIA	SOUTH KOREA	VIETNAM
HONG KONG	JAPAN	PAKISTAN	TAIWAN	
INDIA	PHILIPPINES	THAILAND		

AMERICAS

BRAZIL	CANADA	COLOMBIA	MEXICO	UNITED STATES
--------	--------	----------	--------	---------------

AFRICA

EGYPT	SOUTH AFRICA
-------	--------------



YG-1 CO., LTD.

YG-1 USA

730 Corporate Woods Parkway
Vernon Hills, IL 60061 U.S.A.

Phone: 800-765-8665

Technical Assistance: 888-868-5988

yg1usa.com

YG-1 CANADA INC.

3375 North Service Road, Unit A8
Burlington, Ontario, CANADA L7N 3G2

Phone: +1 905-335-2500

FAX: +1 905-335-4003

Customer Service: orders@yg1.ca

yg1.ca

GLOBAL HEADQUARTERS

211, Sewolcheon-ro, Bupyeong-gu
Incheon, Korea

Phone: +82-32-526-0909

yg1.kr

E-mail: yg1@yg1.kr



Search 'YG-1' on social media outlets

NOTE: The information is provided for reference only. Tool specifications are subject to change without prior notice.

Although we endeavor to supply accurate and timely information, there can be no guarantee to cover every particular application.

YG-1 or publishers are not liable for any damage for use of the information.



세계일류상품

YG1YUSS200520001