

**High Speed Steel
GROUND THREAD HAND AND
SHORT MACHINE SCREWING TAPS
For ISO Metric Screw Threads**

Specifications Conform to :
IS 6175 : Part 2 : 1992
Dimensions in mm



TABLE I : ISO Metric Screw Threads Coarse Pitch

Nominal Diameter	Pitch	Thread Length	Overall Length	Shank Dia	Square Size
3.0	0.50	11	48	3.15	2.50
4.0	0.70	13	53	4.00	3.15
4.5	0.75	13	53	4.50	3.55
5.0	0.80	16	58	5.00	4.00
6.0	1.00	19	66	6.30	5.00
7.0	1.00	19	66	7.10	5.60
8.0	1.25	22	72	8.00	6.30
9.0	1.25	22	72	9.00	7.10
10.0	1.50	24	80	10.00	8.00

TABLE II : ISO Metric Screw Threads Fine Pitch

Nominal Diameter	Pitch	Thread Length	Overall Length	Shank Dia	Square Size
4.0	0.50	13	53	4.00	3.15
4.5	0.50	13	53	4.50	3.55
5.0	0.50	16	58	5.00	4.00
5.5	0.50	17	62	5.60	4.50
6.0	0.75	19	66	6.30	5.00
7.0	0.75	19	66	7.10	5.60
8.0	0.75	16	66	8.00	6.30
8.0	1.00	19	69	8.00	6.30
9.0	0.75	16	66	9.00	7.10
9.0	1.00	19	69	9.00	7.10
10.0	0.75	17	73	10.00	8.00
10.0	1.00	20	76	10.00	8.00
10.0	1.25	20	76	10.00	8.00

Manufactured with straight flutes and a shank with square for driving.

- 1) Unless otherwise specified, the Screwing taps shall be supplied with tolerance class '6H', non - serial and with Straight flutes.
- 2) Usually supplied in sets consisting of three taps, viz. Taper , Second , Bottoming , for Coarse Pitch and Taper and Bottoming for Fine Pitch.

**High Speed Steel
GROUND THREAD HAND AND
SHORT MACHINE SCREWING TAPS
For ISO Metric Coarse Pitch Threads**

Specifications Conform to :
IS 6175 : Part 3 : 1992
Dimensions in mm



Nominal Diameter	Pitch	Thread Length	Overall Length	Shank Dia	Square Size
11	1.50	25	85	8.0	6.30
12	1.75	29	89	9.0	7.10
14	2.00	30	95	11.20	9.00
16	2.00	32	102	12.50	10.00
18	2.50	37	112	14.00	11.20
20	2.50	37	112	14.00	11.20
22	2.50	38	118	16.00	12.50
24	3.00	45	130	18.00	14.00
27	3.00	45	135	20.00	16.00
30	3.50	48	138	20.00	16.00
33	3.50	51	151	22.40	18.00

Nominal Diameter	Pitch	Thread Length	Overall Length	Shank Dia	Square Size
36	4.00	57	162	25.00	20.00
39	4.00	60	170	28.00	22.40
42	4.50	60	170	28.00	22.40
45	4.50	67	187	31.50	25.00
48	5.00	67	187	31.50	25.00
52	5.00	70	200	35.50	28.00
56	5.50	70	200	35.50	28.00
60	5.50	76	221	40.00	31.50
64	6.00	79	224	40.00	31.50
68	6.00	79	234	45.00	35.50

- 1) Unless otherwise specified, the Screwing taps shall be supplied with tolerance class '6H', non - serial and with Straight flutes.
- 2) Usually supplied in sets consisting of three taps, viz. Taper, Second, Bottoming.



High Speed Steel
GROUND THREAD HAND AND
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 For ISO Metric Fine Pitch Threads

Specifications Conform to :
 IS 6175 : Part 3 : 1992
 Dimensions in mm



Nominal Diameter	Pitch	Thread Length	Overall Length	Shank Dia	Square Size
11	0.75	20	80	8.00	6.30
11	1.00	20	80	8.00	6.30
12	1.00	20	80	9.00	7.10
12	1.25	24	84	9.00	7.10
12	1.50	29	89	9.00	7.10
14	1.00	22	87	11.20	9.00
14	1.25	25	90	11.20	9.00
14	1.50	30	95	11.20	9.00
15	1.00	22	87	11.20	9.00
15	1.50	30	95	11.20	9.00
16	1.00	22	92	12.50	10.00
16	1.50	32	102	12.50	10.00
17	1.00	22	92	12.50	10.00
17	1.50	32	102	12.50	10.00
18	1.00	22	97	14.00	11.20
18	1.50	29	104	14.00	11.20
18	2.00	37	112	14.00	11.20
20	1.00	27	102	14.00	11.20
20	1.50	29	104	14.00	11.20
20	2.00	37	112	14.00	11.20
22	1.00	29	109	16.00	12.50
22	1.50	33	113	16.00	12.50

Nominal Diameter	Pitch	Thread Length	Overall Length	Shank Dia	Square Size
22	2.00	38	118	16.00	12.50
24	1.00	29	114	18.00	14.00
24	1.50	35	120	18.00	14.00
24	2.00	35	120	18.00	14.00
25	1.00	29	114	18.00	14.00
25	1.50	35	120	18.00	14.00
25	2.00	35	120	18.00	14.00
26	1.50	35	120	18.00	14.00
27	1.00	30	120	20.00	16.00
27	1.50	37	127	20.00	16.00
27	2.00	37	127	20.00	16.00
28	1.00	30	120	20.00	16.00
28	1.50	37	127	20.00	16.00
28	2.00	37	127	20.00	16.00
30	1.00	30	120	20.00	16.00
30	1.50	37	127	20.00	16.00
30	2.00	37	127	20.00	16.00
30	3.00	48	138	20.00	16.00
32	1.50	37	137	22.40	18.00
32	2.00	37	137	22.40	18.00
33	1.50	37	137	22.40	18.00
33	2.00	37	137	22.40	18.00

Manufactured with straight flutes and a shank with square for driving.



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Nominal Diameter	Pitch	Thread Length	Overall Length	Shank Dia	Square Size
33	3.0	51	151	22.4	18.0
35	1.5	39	144	25.0	20.0
36	1.5	39	144	25.0	20.0
36	2.0	39	144	25.0	20.0
36	3.0	57	162	25.0	20.0
38	1.5	39	149	28.0	22.4
39	1.5	39	149	28.0	22.4
39	2.0	39	149	28.0	22.4
39	3.0	60	170	28.0	22.4
40	1.5	39	149	28.0	22.4
40	2.0	39	149	28.0	22.4
40	3.0	60	170	28.0	22.4
42	1.5	39	149	28.0	22.4
42	2.0	39	149	28.0	22.4
42	3.0	60	170	28.0	22.4
42	4.0	60	170	28.0	22.4
45	1.5	45	165	31.5	25.0
45	2.0	45	165	31.5	25.0
45	3.0	67	187	31.5	25.0
45	4.0	67	187	31.5	25.0
48	1.5	45	165	31.5	25.0
48	2.0	45	165	31.5	25.0
48	3.0	67	187	31.5	25.0
48	4.0	67	187	31.5	25.0
50	1.5	45	165	31.5	25.0
50	2.0	45	165	31.5	25.0
50	3.0	67	187	31.5	25.0
52	1.5	45	175	35.5	28.0
52	2.0	45	175	35.5	28.0
52	3.0	70	200	35.5	28.0
52	4.0	70	200	35.5	28.0
55	1.5	45	175	35.5	28.0

Nominal Diameter	Pitch	Thread Length	Overall Length	Shank Dia	Square Size
55	2.0	45	175	35.5	28.0
55	3.0	70	200	35.5	28.0
55	4.0	70	200	35.5	28.0
56	1.5	45	175	35.5	28.0
56	2.0	45	175	35.5	28.0
56	3.0	70	200	35.5	28.0
56	4.0	70	200	35.5	28.0
58	1.5	48	193	40.0	31.5
58	2.0	48	193	40.0	31.5
58	3.0	64	209	40.0	31.5
58	4.0	64	209	40.0	31.5
60	1.5	48	193	40.0	31.5
60	2.0	48	193	40.0	31.5
60	3.0	64	209	40.0	31.5
60	4.0	64	209	40.0	31.5
62	1.5	48	193	40.0	31.5
62	2.0	48	193	40.0	31.5
62	3.0	64	209	40.0	31.5
62	4.0	64	209	40.0	31.5
64	1.5	48	193	40.0	31.5
64	2.0	48	193	40.0	31.5
64	3.0	64	209	40.0	31.5
64	4.0	64	209	40.0	31.5
65	1.5	48	193	40.0	31.5
65	2.0	48	193	40.0	31.5
65	3.0	64	209	40.0	31.5
65	4.0	64	209	40.0	31.5
68	1.5	48	203	45.0	35.5
68	2.0	48	203	45.0	35.5
68	3.0	64	219	45.0	35.5
68	4.0	64	219	45.0	35.5
70	1.5	48	203	45.0	35.5



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GROUND THREAD HAND AND
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For ISO Metric Fine Pitch Threads**

Specifications Conform to :
IS 6175 : Part 3 : 1992
Dimensions in mm



Nominal Diameter	Pitch	Thread Length	Overall Length	Shank Dia	Square Size
70	2.0	48	203	45	35.5
70	3.0	64	219	45	35.5
70	4.0	64	219	45	35.5
70	6.0	79	234	45	35.5
72	1.5	48	203	45	35.5
72	2.0	48	203	45	35.5
72	3.0	64	219	45	35.5
72	4.0	64	219	45	35.5
72	6.0	79	234	45	35.5
75	1.5	48	203	45	35.5
75	2.0	48	203	45	35.5
75	3.0	64	219	45	35.5
75	4.0	64	219	45	35.5
76	1.5	51	226	50	40.0
76	2.0	51	226	50	40.0
76	3.0	67	242	50	40.0
76	4.0	67	242	50	40.0
76	6.0	83	258	50	40.0
78	2.0	51	226	50	40.0
80	1.5	51	226	50	40.0
80	2.0	51	226	50	40.0

Nominal Diameter	Pitch	Thread Length	Overall Length	Shank Dia	Square Size
80	3.0	67	242	50	40.0
80	4.0	67	242	50	40.0
80	6.0	83	258	50	40.0
82	2.0	51	226	50	40.0
85	2.0	51	226	50	40.0
85	3.0	67	242	50	40.0
85	4.0	67	242	50	40.0
85	6.0	86	261	50	40.0
90	2.0	51	226	50	40.0
90	3.0	67	242	50	40.0
90	4.0	67	242	50	40.0
90	6.0	86	261	50	40.0
95	2.0	54	244	56	45.0
95	3.0	70	260	56	45.0
95	4.0	70	260	56	45.0
95	6.0	89	279	56	45.0
100	2.0	54	244	56	45.0
100	3.0	70	260	56	45.0
100	4.0	70	260	56	45.0
100	6.0	89	279	56	45.0

