



**High Speed Steel  
GROUND THREAD LONG SHANK  
MACHINE SCREWING TAPS**  
For ISO Metric Coarse Pitch Threads

Specifications Conform to :  
IS 6175 : Part 4 : 1991  
Dimensions in mm



Nominal Diameter	Pitch	Thread Length	Overall Length	Shank Dia	Square Size	Nominal Diameter	Pitch	Thread Length	Overall Length	Shank Dia	Square Size
6	1.00	19	89.0	4.5	3.55	27	3.00	45	180.0	20.0	16.0
7	1.00	19	89.0	5.6	4.50	30	3.50	48	183.0	20.0	16.0
8	1.25	22	97.0	6.3	5.00	33	3.50	51	201.0	22.4	18.0
9	1.25	22	97.0	7.1	5.60	36	4.00	57	214.5	25.0	20.0
10	1.50	24	108.0	8.0	6.30	39	4.00	60	225.0	28.0	22.4
11	1.50	25	115.0	8.0	6.30	42	4.50	60	225.0	28.0	22.4
12	1.75	29	119.0	9.0	7.10	45	4.50	67	247.0	31.5	25.0
14	2.00	30	127.0	11.2	9.00	48	5.00	67	247.0	31.5	25.0
16	2.00	32	137.0	12.5	10.00	52	5.00	70	265.0	35.5	28.0
18	2.50	37	149.0	14.0	11.20	56	5.50	70	265.0	35.5	28.0
20	2.50	37	149.0	14.0	11.20	60	5.50	76	293.5	40.0	31.5
22	2.50	38	158.0	16.0	12.50	64	6.00	79	296.5	40.0	31.5
24	3.00	45	172.0	18.0	14.00	68	6.00	79	311.5	45.00	35.5

Manufactured with Straight flutes and a long shank with a driving square for machine tapping.

Type A - 5 Degree Taper Angle with Long Taper Lead.

Type B - 10 Degree Taper Angle with Spiral Point.

Type C - 20 Degree Taper Angle with Shorter Taper Lead.

Type D - 10 Degree Taper Angle without Spiral Point.

Unless otherwise specified the Screwing Taps shall be supplied with tolerance class 6H .



**High Speed Steel**  
**GROUND THREAD LONG SHANK**  
**MACHINE SCREWING TAPS**  
 For ISO Metric Fine Pitch Threads

Specifications Conform to :  
 IS 6175 : Part 4 : 1991  
 Dimensions in mm



Nominal Diameter	Pitch	Thread Length	Overall Length	Shank Dia	Square Size
6	0.75	19	89	4.5	3.55
7	0.75	19	89	5.6	4.50
8	0.75	16	91	6.3	5.00
8	1.00	19	97	6.3	5.00
9	0.75	16	94	7.1	5.60
9	1.00	19	97	7.1	5.60
10	0.75	17	104	8.0	6.30
10	1.00	20	108	8.0	6.30
10	1.25	20	108	8.0	6.30
11	0.75	20	110	8.0	6.30
11	1.00	20	110	8.0	6.30
12	1.00	20	110	9.0	7.10
12	1.25	24	119	9.0	7.10
12	1.50	29	119	9.0	7.10
14	1.00	22	124	11.2	9.00
14	1.25	25	127	11.2	9.00
14	1.50	30	127	11.2	9.00
15	1.00	22	124	11.2	9.00
15	1.50	30	127	11.2	9.00
16	1.00	22	127	12.5	10.00
16	1.50	32	137	12.5	10.00
17	1.00	22	127	12.5	10.00

Nominal Diameter	Pitch	Thread Length	Overall Length	Shank Dia	Square Size
17	1.50	32	137	12.5	10.0
18	1.00	22	135	14.0	11.2
18	1.50	29	142	14.0	11.2
18	2.00	37	149	14.0	11.2
20	1.00	27	140	14.0	11.2
20	1.50	29	142	14.0	11.2
20	2.00	37	149	14.0	11.2
22	1.00	29	149	16.0	12.5
22	1.50	33	153	16.0	12.5
22	2.00	38	158	16.0	12.5
24	1.00	29	157	18.0	14.0
24	1.50	35	172	18.0	14.0
24	2.00	35	172	18.0	14.0
25	1.00	29	157	18.0	14.0
25	1.50	35	163	18.0	14.0
25	2.00	35	163	18.0	14.0
26	1.50	35	163	18.0	14.0
26	2.00	35	163	18.0	14.0
27	1.00	30	165	20.0	16.0
27	1.50	37	172	20.0	16.0
27	2.00	37	172	20.0	16.0
28	1.00	30	165	20.0	16.0



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 Dimensions in mm



Nominal Diameter	Pitch	Thread Length	Overall Length	Shank Dia	Square Size
28	1.5	37	172.0	20.0	16.0
28	2.0	37	172.0	20.0	16.0
30	1.0	30	165.0	20.0	16.0
30	1.5	37	172.0	20.0	16.0
30	2.0	37	172.0	20.0	16.0
30	3.0	48	183.0	20.0	16.0
32	1.5	37	187.0	22.4	18.0
32	2.0	37	187.0	22.4	18.0
33	1.5	37	187.0	22.4	18.0
33	2.0	37	187.0	22.4	18.0
33	3.0	51	201.0	22.4	18.0
35	1.5	39	196.5	25.0	20.0
36	1.5	39	196.5	25.0	20.0
36	2.0	39	196.5	25.0	20.0
36	3.0	57	214.5	25.0	20.0
38	1.5	39	204.0	28.0	22.4
39	1.5	39	204.0	28.0	22.4
39	2.0	39	204.0	28.0	22.4
39	3.0	60	225.0	28.0	22.4
40	1.5	39	204.0	28.0	22.4
40	2.0	39	204.0	28.0	22.4

Nominal Diameter	Pitch	Thread Length	Overall Length	Shank Dia	Square Size
40	3.0	60	225.0	28.0	22.4
42	1.5	39	204.0	28.0	22.4
42	2.0	39	204.0	28.0	22.4
42	3.0	60	225.0	28.0	22.4
42	4.0	60	225.0	28.0	22.4
45	1.5	45	225.0	31.5	25.0
45	2.0	45	225.0	31.5	25.0
45	3.0	67	247.0	31.5	25.0
45	4.0	67	247.0	31.5	25.0
48	1.5	45	225.0	31.5	25.0
48	2.0	45	225.0	31.5	25.0
48	3.0	67	247.0	31.5	25.0
48	4.0	67	247.0	31.5	25.0
50	1.5	45	225.0	31.5	25.0
50	2.0	45	225.0	31.5	25.0
50	3.0	67	247.0	31.5	25.0
52	1.5	45	240.0	35.5	28.0
52	2.0	45	240.0	35.5	28.0
52	3.0	70	265.0	35.5	28.0
52	4.0	70	265.0	35.5	28.0

Type 'A' - 5 Degree Taper Angle with Long Taper Lead.  
 Type 'B' - 10 Degree Taper Angle with Spiral Point.  
 Type 'C' - 20 Degree Taper Angle with Shorter Taper Lead.  
 Type 'D' - 10 Degree Taper Angle without Spiral Point.  
 Unless otherwise specified the Screwing Taps shall be supplied with tolerance class 6H .