

# Thread Forming Taps

## Ground Thread — High Speed Steel

**Thread Forming** taps cold form rather than cut the threads. Advantages include no chips to dispose of, stronger higher quality threads, increased tapping speeds, longer tap life and reduced tap breakage. Recommended for a wide variety of ductile materials.

**Lube Grooves** provide a path for lubrication and act as vents to relieve pressure in blind hole tapping.

**Plug Style** (4 threads tapered) for through holes and blind holes with adequate depth. The longer taper lead is easier starting, requires less torque, produces less burr above the mouth of the tapped hole and increases tool life.

**Bottoming Style** (2 threads tapered) for blind holes.

**Titanium Nitride (TiN) Coating** results in an extremely hard surface with high lubricity for increased tool life, improved thread quality, reduced torque and increased tapping speeds for greater productivity.

## Machine Screw

Taraud façonneur de filets

Machuelo formador de roscas



**Tool Coatings  
Also Available**

**List No. 2105 Bright Finish**  
**List No. 2105G TiN Coated**

**NOTE:** Thread forming taps require a larger **tap drill size** than cutting taps because the material flows during the thread forming process. It may be necessary to experiment to determine the required hole size to produce a specific percent of thread. **Countersinking** before tapping is recommended because the forming process usually displaces material above the mouth of the tapped hole.

**STANDARD PACKAGE** No. 0 thru 1/2" — 12 each  
1/16" thru 3/4" — 3 each  
M3 thru M12 — 12 each  
M14 thru M16 — 3 each  
M18 thru M24 — 1 each

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SIZE	TPI		PITCH DIA. LIMIT	THREAD LENGTH	OAL	NO. OF LUBE GROOVES	PLUG		BOTTOM	
	UNC	UNF					BRIGHT EDP NO.	TIN COATED EDP NO.	BRIGHT EDP NO.	TIN COATED EDP NO.
0	80	—	H2	5/16	15/8	1	—	—	36370	96370
1	64	—	H2	3/8	1 11/16	1	—	—	36371	96371
	—	72	H2	3/8	1 11/16	1	—	—	36372	96372
2	56	—	H2	7/16	1 3/4	1	—	—	36373	96373
	—	—	H3	7/16	1 3/4	1	—	—	36374	96374
	—	64	H2	7/16	1 3/4	1	—	—	36375	96375
	—	64	H3	7/16	1 3/4	1	—	—	36376	96376
3	48	—	H2	1/2	1 13/16	1	—	—	36377	96377
	—	—	H3	1/2	1 13/16	1	—	—	36378	96378
	—	56	H2	1/2	1 13/16	1	—	—	36379	96379
	—	56	H3	1/2	1 13/16	1	—	—	36380	96380
4	40	—	H3	9/16	1 7/8	3	36281	96281	36381	96381
	—	—	H5	9/16	1 7/8	3	36282	96282	36382	96382
	—	48	H3	9/16	1 7/8	3	36283	96283	36383	96383
	—	48	H5	9/16	1 7/8	3	36284	96284	36384	96384
5	40	—	H3	5/8	1 15/16	3	36285	96285	36385	96385
	—	—	H5	5/8	1 15/16	3	36286	96286	36386	96386
	—	44	H3	5/8	1 15/16	3	36287	96287	36387	96387
	—	44	H5	5/8	1 15/16	3	36288	96288	36388	96388
6	32	—	H3	1 1/16	2	3	36289	96289	36389	96389
	—	—	H5	1 1/16	2	3	36290	96290	36390	96390
	—	40	H3	1 1/16	2	3	36291	96291	36391	96391
	—	40	H5	1 1/16	2	3	36292	96292	36392	96392
8	32	—	H3	3/4	2 1/8	3	36293	96293	36393	96393
	—	—	H5	3/4	2 1/8	3	36294	96294	36394	96394
	—	36	H3	3/4	2 1/8	3	36295	96295	36395	96395
	—	36	H5	3/4	2 1/8	3	36296	96296	36396	96396
10	24	—	H4	7/8	2 3/8	4	36297	96297	36397	96397
	—	—	H6	7/8	2 3/8	4	36298	96298	36398	96398
	—	32	H4	7/8	2 3/8	4	36299	96299	36399	96399
	—	32	H6	7/8	2 3/8	4	36300	96300	36400	96400
12	24	—	H4	15/16	2 3/8	4	36301	96301	36401	96401
	—	—	H6	15/16	2 3/8	4	36302	96302	36402	96402
	—	28	H4	15/16	2 3/8	4	36303	96303	36403	96403
	—	28	H6	15/16	2 3/8	4	36304	96304	36404	96404

# Thread Forming Taps

## Fractional

Taraud façonneur de filets

Machuelo formador de roscas

SIZE	TPI		PITCH DIA. LIMIT	THREAD LENGTH	OAL	NO. OF LUBE GROOVES	PLUG		BOTTOM	
	UNC	UNF					BRIGHT EDP NO.	TIN COATED EDP NO.	BRIGHT EDP NO.	TIN COATED EDP NO.
1/4	20	—	H4	1	2½	4	36310	96310	36410	96410
	20	—	H6	1	2½	4	36311	96311	36411	96411
	—	28	H4	1	2½	4	36312	96312	36412	96412
	—	28	H6	1	2½	4	36313	96313	36413	96413
5/16	18	—	H5	1½	2 <sup>23</sup> / <sub>32</sub>	4	36314	96314	36414	96414
	18	—	H7	1½	2 <sup>23</sup> / <sub>32</sub>	4	36315	96315	36415	96415
	—	24	H5	1½	2 <sup>23</sup> / <sub>32</sub>	4	36316	96316	36416	96416
	—	24	H7	1½	2 <sup>23</sup> / <sub>32</sub>	4	36317	96317	36417	96417
3/8	16	—	H5	1¼	2 <sup>15</sup> / <sub>16</sub>	4	36318	96318	36418	96418
	16	—	H7	1¼	2 <sup>15</sup> / <sub>16</sub>	4	36319	96319	36419	96419
	—	24	H5	1¼	2 <sup>15</sup> / <sub>16</sub>	4	36320	96320	36420	96420
	—	24	H7	1¼	2 <sup>15</sup> / <sub>16</sub>	4	36321	96321	36421	96421
7/16	14	—	H5	1 <sup>7</sup> / <sub>16</sub>	3 <sup>3</sup> / <sub>32</sub>	4	36322	96322	36422	96422
	14	—	H8	1 <sup>7</sup> / <sub>16</sub>	3 <sup>3</sup> / <sub>32</sub>	4	36323	96323	36423	96423
	—	20	H5	1 <sup>7</sup> / <sub>16</sub>	3 <sup>3</sup> / <sub>32</sub>	4	36324	96324	36424	96424
	—	20	H8	1 <sup>7</sup> / <sub>16</sub>	3 <sup>3</sup> / <sub>32</sub>	4	36325	96325	36425	96425
1/2	13	—	H5	1 <sup>21</sup> / <sub>32</sub>	3 <sup>3</sup> / <sub>8</sub>	4	36326	96326	36426	96426
	13	—	H8	1 <sup>21</sup> / <sub>32</sub>	3 <sup>3</sup> / <sub>8</sub>	4	36327	96327	36427	96427
	—	20	H5	1 <sup>21</sup> / <sub>32</sub>	3 <sup>3</sup> / <sub>8</sub>	4	36328	96328	36428	96428
	—	20	H8	1 <sup>21</sup> / <sub>32</sub>	3 <sup>3</sup> / <sub>8</sub>	4	36329	96329	36429	96429
9/16	12	—	H7	1 <sup>21</sup> / <sub>32</sub>	3 <sup>19</sup> / <sub>32</sub>	6	36330	96330	36430	96430
	12	—	H10	1 <sup>21</sup> / <sub>32</sub>	3 <sup>19</sup> / <sub>32</sub>	6	36331	96331	36431	96431
	—	18	H7	1 <sup>21</sup> / <sub>32</sub>	3 <sup>19</sup> / <sub>32</sub>	6	36332	96332	36432	96432
	—	18	H10	1 <sup>21</sup> / <sub>32</sub>	3 <sup>19</sup> / <sub>32</sub>	6	36333	96333	36433	96433
5/8	11	—	H7	1 <sup>13</sup> / <sub>16</sub>	3 <sup>13</sup> / <sub>16</sub>	6	36334	96334	36434	96434
	11	—	H10	1 <sup>13</sup> / <sub>16</sub>	3 <sup>13</sup> / <sub>16</sub>	6	36335	96335	36435	96435
	—	18	H7	1 <sup>13</sup> / <sub>16</sub>	3 <sup>13</sup> / <sub>16</sub>	6	36336	96336	36436	96436
	—	18	H10	1 <sup>13</sup> / <sub>16</sub>	3 <sup>13</sup> / <sub>16</sub>	6	36337	96337	36437	96437
3/4	10	—	H7	2	4¼	6	36338	96338	36438	96438
	10	—	H10	2	4¼	6	36339	96339	36439	96439
	—	16	H7	2	4¼	6	36340	96340	36440	96440
	—	16	H10	2	4¼	6	36341	96341	36441	96441

Tool Coatings Also Available

### Metric

SIZE	PITCH	PITCH DIA. LIMIT	THREAD LENGTH	OAL	NO. OF LUBE GROOVES	PLUG		BOTTOM	
						BRIGHT EDP NO.	TIN COATED EDP NO.	BRIGHT EDP NO.	TIN COATED EDP NO.
M3	0.5	D5	¾	1 <sup>15</sup> / <sub>16</sub>	3	36350	96350	36450	96450
M4	0.7	D6	¾	2 <sup>1</sup> / <sub>8</sub>	3	36351	96351	36451	96451
M5	0.8	D7	7 <sup>8</sup> / <sub>16</sub>	2 <sup>3</sup> / <sub>8</sub>	4	36352	96352	36452	96452
M6	1	D8	1	2 <sup>1</sup> / <sub>2</sub>	4	36353	96353	36453	96453
M8	1.25	D9	1 <sup>1</sup> / <sub>8</sub>	2 <sup>23</sup> / <sub>32</sub>	4	36354	96354	36454	96454
M10	1.5	D10	1¼	2 <sup>15</sup> / <sub>16</sub>	4	36355	96355	36455	96455
M12	1.75	D11	1 <sup>21</sup> / <sub>32</sub>	3 <sup>3</sup> / <sub>8</sub>	4	36356	96356	36456	96456
M14	2	D11	1 <sup>21</sup> / <sub>32</sub>	3 <sup>19</sup> / <sub>32</sub>	6	36357	96357	36457	96457
M16	2	D12	1 <sup>13</sup> / <sub>16</sub>	3 <sup>13</sup> / <sub>16</sub>	6	36358	96358	36458	96458
M20	2.5	D12	2	4 <sup>15</sup> / <sub>32</sub>	6	36359	96359	36459	96459