

TAPS, DIES & GAGES

| SIZE/ DESCRIPTION | D# | CLASS OF FIT | # FLUTES | ITEM # | | OVERALL LENGTH | THREAD LENGTH | SHANK DIAMETER | SQUARE DIAMETER | SQUARE LENGTH |
|--------------------------|----|-----------------|-------------|--------|--------|---|------------------|-------------------|--------------------|------------------|
| | | | | PLUG | BOTTOM | | | | | |
| M22 X 2.5 | | | | | | <i>Recommended Hole Size Based on 75% Thread = 19.5mm</i> | | | | |
| HAND TAP | 7 | 6H | 4 | 20676 | 20677 | 4.69 | 2.22 | 0.6970 | 0.523 | 0.75 |
| HAND TAP | 4 | 4H | 4 | 20671 | 20672 | 4.69 | 2.22 | 0.6970 | 0.523 | 0.75 |
| L.H. HAND TAP | 7 | 6H | 4 | 20681 | 20682 | 4.69 | 2.22 | 0.6970 | 0.523 | 0.75 |
| R.H. ROUND DIE 50.8mm OD | | | | 13598 | | | | | | |
| GAGE - Taperlock Style | | 6H | | 25133 | | | | | | |
| GAGE - Ring-Go | | 6g | | 25330 | | | | | | |
| GAGE - Ring-NoGo | | 6g | | 25331 | | | | | | |
| M22 X 1.5 | | | | | | <i>Recommended Hole Size Based on 75% Thread = 20.5mm</i> | | | | |
| HAND TAP | 6 | 6H | 4 | 20691 | 20692 | 4.69 | 2.22 | 0.6970 | 0.523 | 0.75 |
| HAND TAP | 3 | 4H | 4 | 20686 | 20687 | 4.69 | 2.22 | 0.6970 | 0.523 | 0.75 |
| L.H. HAND TAP | 6 | 6H | 4 | 20696 | 20697 | 4.69 | 2.22 | 0.6970 | 0.523 | 0.75 |
| +.127mm HAND TAP | 11 | PLATING | 4 | 20701 | 20702 | 4.69 | 2.22 | 0.6970 | 0.523 | 0.75 |
| R.H. ROUND DIE 50.8mm OD | | | | 13600 | | | | | | |
| GAGE - Taperlock Style | | 6H | | 25138 | | | | | | |
| GAGE - Ring-Go | | 6g | | 25335 | | | | | | |
| GAGE - Ring-NoGo | | 6g | | 25336 | | | | | | |
| M24 X 3.0 | | | | | | <i>Recommended Hole Size Based on 75% Thread = 21mm</i> | | | | |
| HAND TAP | 8 | 6H | 4 | 20711 | 20712 | 4.91 | 2.22 | 0.7600 | 0.570 | 0.75 |
| SPIRAL POINT TAP | 8 | 6H | 3 | 21029 | | 4.91 | 2.22 | 0.7600 | 0.570 | 0.75 |
| HAND TAP | 4 | 4H | 4 | 20706 | 20707 | 4.91 | 2.22 | 0.7600 | 0.570 | 0.75 |
| L.H. HAND TAP | 8 | 6H | 4 | 20716 | 20717 | 4.91 | 2.22 | 0.7600 | 0.570 | 0.75 |
| +.127mm HAND TAP | 11 | PLATING | 4 | 20721 | 20722 | 4.91 | 2.22 | 0.7600 | 0.570 | 0.75 |
| TiN COAT / HAND TAP | 8 | 6H | 4 | 55007 | | 4.91 | 2.22 | 0.7600 | 0.570 | 0.75 |
| R.H. ROUND DIE 50.8mm OD | | | | 13604 | | | | | | |
| L.H. ROUND DIE 50.8mm OD | | | | 13605 | | | | | | |
| GAGE - Taperlock Style | | 6H | | 25143 | | | | | | |
| GAGE - Ring-Go | | 6g | | 25340 | | | | | | |
| GAGE - Ring-NoGo | | 6g | | 25341 | | | | | | |
| M24 X 2.0 | | | | | | <i>Recommended Hole Size Based on 75% Thread = 22mm</i> | | | | |
| HAND TAP | 7 | 6H | 4 | 20731 | 20732 | 4.91 | 2.22 | 0.7600 | 0.570 | 0.75 |
| HAND TAP | 4 | 4H | 4 | 20726 | 20727 | 4.91 | 2.22 | 0.7600 | 0.570 | 0.75 |
| L.H. HAND TAP | 7 | 6H | 4 | 20736 | 20737 | 4.91 | 2.22 | 0.7600 | 0.570 | 0.75 |
| R.H. ROUND DIE 50.8mm OD | | | | 13606 | | | | | | |
| L.H. ROUND DIE 50.8mm OD | | | | 13607 | | | | | | |
| GAGE - Taperlock Style | | 6H | | 25148 | | | | | | |
| GAGE - Ring-Go | | 6g | | 25345 | | | | | | |
| GAGE - Ring-NoGo | | 6g | | 25346 | | | | | | |
| M24 X 1.5 | | | | | | <i>Recommended Hole Size Based on 75% Thread = 22.5mm</i> | | | | |
| HAND TAP | 6 | 6H | 4 | 20917 | 20918 | 4.91 | 2.22 | 0.7600 | 0.570 | 0.75 |
| GAGE - Taperlock Style | | 6H | | 21545 | | | | | | |
| GAGE - Ring-Go | | 6g | | 21546 | | | | | | |
| GAGE - Ring-NoGo | | 6g | | 21547 | | | | | | |
| M25 X 1.5 | | | | | | <i>Recommended Hole Size Based on 75% Thread = 23.5mm</i> | | | | |
| HAND TAP | 6 | 6H | 4 | 21031 | 21032 | 5.13 | 2.50 | 0.8000 | 0.600 | 0.81 |
| GAGE - Taperlock Style | | 6H | | 21548 | | | | | | |

| SIZE/ DESCRIPTION | D# | CLASS OF FIT | # FLUTES | ITEM # | | OVERALL LENGTH | THREAD LENGTH | SHANK DIAMETER | SQUARE DIAMETER | SQUARE LENGTH |
|--------------------------|----------|-----------------|-------------|--------------|--------------|---|------------------|-------------------|--------------------|------------------|
| | | | | PLUG | BOTTOM | | | | | |
| M25 X 1.5 | | | | | | <i>See Previous Page for Recommended Hole Size</i> | | | | |
| GAGE - Ring-Go | | 6g | | 21549 | | | | | | |
| GAGE - Ring-NoGo | | 6g | | 21550 | | | | | | |
| M26 X 1.5 | | | | | | <i>Recommended Hole Size Based on 75% Thread = 24.5mm</i> | | | | |
| HAND TAP | 6 | 6H | 6 | 20981 | 20982 | 4.00 | 1.50 | 0.8960 | 0.672 | 0.88 |
| GAGE - Taperlock Style | | 6H | | 21557 | | | | | | |
| GAGE - Ring-Go | | 6g | | 21558 | | | | | | |
| GAGE - Ring-NoGo | | 6g | | 21559 | | | | | | |
| M27 X 3.0 | | | | | | <i>Recommended Hole Size Based on 75% Thread = 24mm</i> | | | | |
| HAND TAP | 8 | 6H | 4 | 20746 | 20747 | 5.13 | 2.50 | 0.8960 | 0.672 | 0.88 |
| HAND TAP | 5 | 4H | 4 | 20741 | 20742 | 5.13 | 2.50 | 0.8960 | 0.672 | 0.88 |
| L.H. HAND TAP | 8 | 6H | 4 | 20751 | 20752 | 5.13 | 2.50 | 0.8960 | 0.672 | 0.88 |
| R.H. ROUND DIE 63.5mm OD | | | | 13614 | | | | | | |
| GAGE - Taperlock Style | | 6H | | 25158 | | | | | | |
| GAGE - Ring-Go | | 6g | | 25350 | | | | | | |
| GAGE - Ring-NoGo | | 6g | | 25351 | | | | | | |
| M27 X 2.0 | | | | | | <i>Recommended Hole Size Based on 75% Thread = 25mm</i> | | | | |
| HAND TAP | 7 | 6H | 4 | 20761 | 20762 | 5.13 | 2.50 | 0.8960 | 0.672 | 0.88 |
| HAND TAP | 5 | 4H | 4 | 20756 | 20757 | 5.13 | 2.50 | 0.8960 | 0.672 | 0.88 |
| R.H. ROUND DIE 63.5mm OD | | | | 13616 | | | | | | |
| GAGE - Taperlock Style | | 6H | | 25163 | | | | | | |
| GAGE - Ring-Go | | 6g | | 25355 | | | | | | |
| GAGE - Ring-NoGo | | 6g | | 25356 | | | | | | |
| M27 X 1.5 | | | | | | <i>Recommended Hole Size Based on 75% Thread = 25.5mm</i> | | | | |
| HAND TAP | 6 | 6H | 6 | 21057 | 21058 | 4.00 | 1.50 | 0.8960 | 0.672 | 0.88 |
| GAGE - Taperlock Style | | 6H | | 21578 | | | | | | |
| GAGE - Ring-Go | | 6g | | 21579 | | | | | | |
| GAGE - Ring-NoGo | | 6g | | 21580 | | | | | | |
| M30 X 3.5 | | | | | | <i>Recommended Hole Size Based on 75% Thread = 26.5mm</i> | | | | |
| HAND TAP | 9 | 6H | 4 | 20776 | 20777 | 5.44 | 2.56 | 1.0210 | 0.766 | 1.00 |
| HAND TAP | 5 | 4H | 4 | 20771 | 20772 | 5.44 | 2.56 | 1.0210 | 0.766 | 1.00 |
| L.H. HAND TAP | 9 | 6H | 4 | 20781 | 20782 | 5.44 | 2.56 | 1.0210 | 0.766 | 1.00 |
| R.H. ROUND DIE 63.5mm OD | | | | 13624 | | | | | | |
| L.H. ROUND DIE 63.5mm OD | | | | 13625 | | | | | | |
| GAGE - Taperlock Style | | 6H | | 25168 | | | | | | |
| GAGE - Ring-Go | | 6g | | 25360 | | | | | | |
| GAGE - Ring-NoGo | | 6g | | 25361 | | | | | | |
| M30 X 2.0 | | | | | | <i>Recommended Hole Size Based on 75% Thread = 26mm</i> | | | | |
| HAND TAP | 7 | 6H | 4 | 20791 | 20792 | 5.44 | 2.56 | 1.0210 | 0.766 | 1.00 |
| HAND TAP | 5 | 4H | 4 | 20786 | 20787 | 5.44 | 2.56 | 1.0210 | 0.766 | 1.00 |
| R.H. ROUND DIE 63.5mm OD | | | | 13626 | | | | | | |
| GAGE - Taperlock Style | | 6H | | 25173 | | | | | | |
| GAGE - Ring-Go | | 6g | | 25365 | | | | | | |
| GAGE - Ring-NoGo | | 6g | | 25366 | | | | | | |
| M30 X 1.5 | | | | | | <i>Recommended Hole Size Based on 75% Thread = 28.5mm</i> | | | | |
| HAND TAP | 6 | 6H | 6 | 20898 | 20899 | 4.00 | 1.50 | 1.0210 | 0.766 | 1.00 |