

Segment : 1C

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
For Metric Threads													
M3 × 0.5	P1	SCPP3.0G	2.5P	46	9	14	26	4	3.2	6	3	1	○
M4 × 0.7	P2	SCPQ4.0I	2.5P	52	11	17	29	5	4	7	3	1	○
M5 × 0.8	P2	SCPQ5.0K	2.5P	60	13	22	33	5.5	4.5	7	3	1	○
M6 × 1	P2	SCPQ6.0M	2.5P	62	15	26	33	6	4.5	7	3	1	○
M8 × 1.25	P2	SCMQ8.0N	2.5P	70	19	-	36	6.2	5	8	3	2	○
M8 × 1	P2	SCMQ8.0M	2.5P	70	19	-	36	6.2	5	8	3	2	△
M10 × 1.5	P2	SCMQ0100	2.5P	75	23	-	38	7	5.5	8	3	2	○
M10 × 1.25	P2	SCMQ010N	2.5P	75	23	-	38	7	5.5	8	3	2	△
M10 × 1	P2	SCMQ010M	2.5P	75	23	-	38	7	5.5	8	3	2	△
M12 × 1.75	P2	SCMQ012P	2.5P	82	26	-	42	8.5	6.5	9	3	2	○
M12 × 1.5	P2	SCMQ0120	2.5P	82	26	-	42	8.5	6.5	9	3	2	△
M12 × 1.25	P2	SCMQ012N	2.5P	82	26	-	42	8.5	6.5	9	3	2	△
M12 × 1	P2	SCMQ012M	2.5P	82	26	-	42	8.5	6.5	9	3	2	△
M14 × 2	P2	SCMQ014Q	2.5P	88	26	-	45	10.5	8	11	3	2	△
M14 × 1.5	P2	SCMQ0140	2.5P	88	26	-	45	10.5	8	11	3	2	△
M14 × 1.25	P2	SCMQ014N	2.5P	88	26	-	45	10.5	8	11	3	2	△
M14 × 1	P2	SCMQ014M	2.5P	88	26	-	45	10.5	8	11	3	2	△
M16 × 2	P2	SCMQ016Q	2.5P	95	26	-	48	12.5	10	13	3	2	○
M16 × 1.5	P2	SCMQ0160	2.5P	95	26	-	48	12.5	10	13	3	2	△
M16 × 1	P2	SCMQ016M	2.5P	95	26	-	48	12.5	10	13	3	2	△
M18 × 2.5	P3	SCMR018R	2.5P	100	33	-	51	14	11	14	4	2	△
M18 × 2	P3	SCMR018Q	2.5P	100	33	-	51	14	11	14	4	2	△
M18 × 1.5	P2	SCMQ0180	2.5P	100	33	-	51	14	11	14	4	2	△

Overall length	Chamfer+ full thread	Thread length	Thread+neck length	Shank length	Shank dia.	Size of square	Length of square
L	lt	ℓ	ℓn	ℓs	Ds	K	ℓk

HC+SP/HC-SP Spiral Fluted Taps for High Carbon Steels

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M18 × 1	P2	SCMQ018M	2.5P	100	18	-	51	14	11	14	4	2	△
M20 × 2.5	P3	SCMR020R	2.5P	105	33	-	50	15	12	15	4	3	○
M20 × 2	P3	SCMR020Q	2.5P	105	33	-	50	15	12	15	4	3	△
M20 × 1.5	P3	SCMR0200	2.5P	105	33	-	50	15	12	15	4	3	△
M20 × 1	P2	SCMQ020M	2.5P	105	18	-	50	15	12	15	4	3	△
M22 × 2.5	P3	SCMR022R	2.5P	115	33	-	55	17	13	16	4	3	△
M22 × 2	P3	SCMR022Q	2.5P	115	33	-	55	17	13	16	4	3	△
M22 × 1.5	P3	SCMR0220	2.5P	115	33	-	55	17	13	16	4	3	△
M24 × 3	P3	SCMR024S	2.5P	120	39	-	55	19	15	18	4	3	△
M24 × 2	P3	SCMR024Q	2.5P	120	39	-	55	19	15	18	4	3	△
M24 × 1.5	P3	SCMR0240	2.5P	120	39	-	55	19	15	18	4	3	△
M25 × 1.5	P3	SCMR0250	2.5P	125	39	-	58	19	15	18	4	3	△
M26 × 1.5	P3	SCMR0260	2.5P	130	39	-	60	20	15	18	4	3	△
M27 × 3	P3	SCMR027S	2.5P	130	39	-	60	20	15	18	4	3	△
M27 × 1.5	P3	SCMR0270	2.5P	130	39	-	60	20	15	18	4	3	△
M28 × 1.5	P3	SCMR0280	2.5P	135	46	-	62	23	17	20	4	3	△
M30 × 3.5	P4	SCMS030T	2.5P	135	46	-	62	23	17	20	4	3	△
M30 × 1.5	P3	SCMR0300	2.5P	135	46	-	62	23	17	20	4	3	△

For Whitworth Threads

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
1/4W20	P2	SCMQW04N	2.5P	62	15	26	33	6	4.5	7	3	1	△
5/16W18	P2	SCMQW050	2.5P	70	19	-	36	6.2	5	8	3	2	△
3/8W16	P2	SCMQW06P	2.5P	75	23	-	38	7	5.5	8	3	2	△
1/2W12	P3	SCMRW08S	2.5P	88	26	-	45	10.5	8	11	3	2	△
5/8W11	P3	SCMRW10U	2.5P	95	26	-	48	12.5	10	13	3	2	△
3/4W10	P3	SCMRW12V	2.5P	105	33	-	50	15	12	15	4	3	△
7/8W9	P3	SCMRW14W	2.5P	115	33	-	55	17	13	16	4	3	△
1 W8	P3	SCMRW16X	2.5P	125	39	-	58	19	15	18	4	3	△