



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

Oversize

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													
M1.4 × 0.3	P1	SPP1.4CX	2.5P	36	5.4	-	24	3	2.5	5	2	1	△
M1.6 × 0.35	P1	SPP1.6DX	2.5P	36	6.3	-	24	3	2.5	5	2	2	△
M1.7 × 0.35	P1	SPP1.7DX	2.5P	36	6.3	-	24	3	2.5	5	2	2	△
M2 × 0.4	P1	SPP2.0EX	2.5P	42	7.2	12	27	3	2.5	5	2	3	△
M2.5 × 0.45	P1	SPP2.5FX	2.5P	46	8.1	14	29	3	2.5	5	2	3	△
M2.6 × 0.45	P1	SPP2.6FX	2.5P	46	8.1	14	29	3	2.5	5	2	3	△
M3 × 0.5	P1	SPP3.0GX											⊙
	P2	SPQ3.0GX	2.5P	46	9	14	26	4	3.2	6	3	3	△
	P3	SPR3.0GX											
3M0.6	P1	SPP3.0HX	2.5P	46	9	14	26	4	3.2	6	3	3	△
M3.5 × 0.6	P1	SPP3.5HX	2.5P	52	11	16	29	5	4	7	3	3	△

SP OX Spiral Fluted Taps, Oxidized

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

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
M4 × 0.7	P2	SPQ4.0IX	2.5P	52	11	17	29	5	4	7	3	3	⊙
	P3	SPR4.0IX											△
	P4	SPS4.0IX											
M4 × 0.5	P1	SPP4.0GX	2.5P	52	9	17	29	5	4	7	3	4	△
M4.5 × 0.5	P1	SPP4.5GX	2.5P	60	9	21	33	5.5	4.5	7	3	4	△
M5 × 0.8	P2	SPQ5.0KX	2.5P	60	13	22	33	5.5	4.5	7	3	3	⊙
	P3	SPR5.0KX											△
	P4	SPS5.0KX											
M6 × 1	P2	SPQ6.0MX	2.5P	62	15	26	33	6	4.5	7	3	3	⊙
	P3	SPR6.0MX											△
	P4	SPS6.0MX											
M6 × 0.75	P2	SPQ6.0JX	2.5P	62	15	26	33	6	4.5	7	3	3	△
M7 × 1	P2	SPQ7.0MX	2.5P	70	19	-	36	6.2	5	8	3	5	△
M8 × 1.25	P2	SPQ8.0NX	2.5P	70	19	-	36	6.2	5	8	3	5	⊙
	P3	SPR8.0NX											△
	P4	SPS8.0NX											
M8 × 1	P2	SPQ8.0MX	2.5P	70	19	-	36	6.2	5	8	3	5	△
M10 × 1.5	P2	SPQ100X	2.5P	75	23	-	38	7	5.5	8	3	5	⊙
M10 × 1.25	P2	SPQ10NX	2.5P	75	23	-	38	7	5.5	8	3	5	△
	P3	SPR10NX											
M10 × 1	P2	SPQ10MX	2.5P	75	23	-	38	7	5.5	8	3	5	△
M12 × 1.75	P2	SPQ12PX	2.5P	82	26	-	42	8.5	6.5	9	3	5	⊙
M12 × 1.5	P2	SPQ120X	2.5P	82	26	-	42	8.5	6.5	9	3	5	△
M12 × 1.25	P2	SPQ12NX	2.5P	82	26	-	42	8.5	6.5	9	3	5	△
M12 × 1	P2	SPQ12MX	2.5P	82	26	-	42	8.5	6.5	9	3	5	△
M14 × 2	P2	SPQ14QX	2.5P	88	26	-	45	10.5	8	11	3	5	△
M14 × 1.5	P2	SPQ140X	2.5P	88	26	-	45	10.5	8	11	3	5	△
M14 × 1	P2	SPQ14MX	2.5P	88	26	-	45	10.5	8	11	3	5	△
M16 × 2	P2	SPQ16QX	2.5P	95	26	-	48	12.5	10	13	3	5	○
M16 × 1.5	P2	SPQ160X	2.5P	95	26	-	48	12.5	10	13	4	5	△
M18 × 2.5	P3	SPR18RX	2.5P	100	33	-	51	14	11	14	4	5	△
M18 × 1.5	P2	SPQ180X	2.5P	100	33	-	51	14	11	14	4	5	△
M20 × 2.5	P3	SPR20RX	2.5P	105	33	-	50	15	12	15	4	6	○
M20 × 1.5	P3	SPR200X	2.5P	105	33	-	50	15	12	15	4	6	△
M22 × 2.5	P3	SPR22RX	2.5P	115	33	-	55	17	13	16	4	6	△
M22 × 1.5	P3	SPR220X	2.5P	115	33	-	55	17	13	16	4	6	△
M24 × 3	P3	SPR24SX	2.5P	120	39	-	55	19	15	18	4	6	△
M24 × 1.5	P3	SPR240X	2.5P	120	39	-	55	19	15	18	4	6	△
M27 × 3	P3	SPR27SX	2.5P	130	39	-	60	20	15	18	4	6	△
M30 × 3.5	P4	SPS30TX	2.5P	135	46	-	62	23	17	20	4	6	△
M30 × 1.5	P3	SPR300X	2.5P	135	46	-	62	23	17	20	4	6	△
M33 × 3.5	P4	SPS33TX	2.5P	145	46	-	67	25	19	22	4	6	△
M36 × 4	P4	SPS36UX	2.5P	155	52	-	71	28	21	24	4	6	△

For Unified Threads

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
No.2-56UNC	P1	SPPUN2EX	2.5P	42	8.1	12	27	3	2.5	5	2	3	△
No.4-40UNC	P1	SPPUN4HX	2.5P	46	9	14	26	4	3.2	6	2	3	△
No.5-40UNC	P1	SPPUN5HX	2.5P	52	11	16	29	5	4	7	3	3	△
No.6-32UNC	P2	SPQUN6JX	2.5P	52	11	16	29	5	4	7	3	3	△
No.8-32UNC	P2	SPQUN8JX	2.5P	60	13	21	33	5.5	4.5	7	3	3	△

SP OX Spiral Fluted Taps, Oxided

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

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
No.10-24UNC	P2	SPQUNAMX	2.5P	60	13	22	33	5.5	4.5	7	3	3	△
No.10-32UNF	P2	SPQUNAJX	2.5P	60	13	22	33	5.5	4.5	7	3	3	△
1/4-20UNC	P2	SPQU04NX	2.5P	62	15	26	33	6	4.5	7	3	3	△
1/4-28UNF	P2	SPQU04KX	2.5P	62	15	26	33	6	4.5	7	3	3	△
5/16-18UNC	P2	SPQU050X	2.5P	70	19	-	36	6.2	5	8	3	5	△
5/16-24UNF	P2	SPQU05MX	2.5P	70	19	-	36	6.2	5	8	3	5	△
3/8-16UNC	P2	SPQU06PX	2.5P	75	23	-	38	7	5.5	8	3	5	△
3/8-24UNF	P2	SPQU06MX	2.5P	75	23	-	38	7	5.5	8	3	5	△
7/16-14UNC	P3	SPRU07QX	2.5P	82	26	-	42	8.5	6.5	9	3	5	△
7/16-20UNF	P2	SPQU07NX	2.5P	82	26	-	42	8.5	6.5	9	3	5	△
1/2-13UNC	P2	SPRU08RX	2.5P	88	26	-	45	10.5	8	11	3	5	△
1/2-20UNF	P2	SPQU08NX	2.5P	88	26	-	45	10.5	8	11	3	5	△
5/8-11UNC	P3	SPRU10UX	2.5P	95	26	-	48	12.5	10	13	3	5	△
5/8-18UNF	P2	SPQU100X	2.5P	95	26	-	48	12.5	10	13	3	5	△
3/4-10UNC	P3	SPRU12VX	2.5P	105	33	-	50	15	12	15	4	6	△
3/4-16UNF	P3	SPRU12PX	2.5P	105	33	-	50	15	12	15	4	6	△
7/8-9UNC	P3	SPRU14WX	2.5P	115	33	-	55	17	13	16	4	6	△
7/8-14UNF	P3	SPRU14QX	2.5P	115	33	-	55	17	13	16	4	6	△
1 -8UNC	P3	SPRU16XX	2.5P	125	39	-	58	19	15	18	4	6	△
1 -12UNF	P3	SPRU16SX	2.5P	125	39	-	58	19	15	18	4	6	△

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
3/16W24	P2	SPQW03MX	2.5P	60	13	21	33	5.5	4.5	7	3	3	△
1/4W20	P2	SPQW04NX	2.5P	62	15	26	33	6	4.5	7	3	3	△
5/16W18	P2	SPQW050X	2.5P	70	19	-	36	6.2	5	8	3	5	△
3/8W16	P2	SPQW06PX	2.5P	75	23	-	38	7	5.5	8	3	5	△
7/16W14	P3	SPRW07QX	2.5P	82	26	-	42	8.5	6.5	9	3	5	△
1/2W12	P3	SPRW08SX	2.5P	88	26	-	45	10.5	8	11	3	5	△
5/8W11	P3	SPRW10UX	2.5P	95	26	-	48	12.5	10	13	3	5	△
3/4W10	P3	SPRW12VX	2.5P	105	33	-	50	15	12	15	4	6	△
7/8W9	P3	SPRW14WX	2.5P	115	33	-	55	17	13	16	4	6	△
1 W8	P3	SPRW16XX	2.5P	125	39	-	58	19	15	18	4	6	△