

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
4M0.75	P2	SUPQ4.0J	2.5P	52	11	17	29	5	4	7	3	3	△
M5 × 0.8	P2	SUPQ5.0K	2.5P	60	13	22	33	5.5	4.5	7	3	3	⊗
	P3	SUPR5.0K											△
	P4	SUPS5.0K											
5M0.9	P2	SUPQ5.0L	2.5P	60	13	22	33	5.5	4.5	7	3	3	△
M6 × 1	P2	SUPQ6.0M	2.5P	62	15	26	33	6	4.5	7	3	3	⊗
	P3	SUPR6.0M											△
	P4	SUPS6.0M											
M6 × 0.75	P2	SUMQ6.0J	2.5P	62	15	26	33	6	4.5	7	3	3	△
M8 × 1.25	P2	SUMQ8.0N	2.5P	70	19	-	36	6.2	5	8	3	4	⊗
	P3	SUMR8.0N											△
	P4	SUMS8.0N											
M8 × 1	P2	SUMQ8.0M	2.5P	70	19	-	36	6.2	5	8	3	4	△
M8 × 0.75	P2	SUMQ8.0J	2.5P	70	19	-	36	6.2	5	8	3	4	△
M10 × 1.5	P2	SUMQ0100	2.5P	75	23	-	38	7	5.5	8	3	4	⊗
	P3	SUMR0100											△
	P4	SUMS0100											
M10 × 1.25	P2	SUMQ010N	2.5P	75	23	-	38	7	5.5	8	3	4	○
	P3	SUMR010N											△
	P4	SUMS010N											
M10 × 1	P2	SUMQ010M	2.5P	75	23	-	38	7	5.5	8	3	4	△
	P4	SUMS010M											
M12 × 1.75	P2	SUMQ012P	2.5P	82	26	-	42	8.5	6.5	9	3	4	⊗
	P3	SUMR012P											△
	P4	SUMS012P											
M12 × 1.5	P2	SUMQ0120	2.5P	82	26	-	42	8.5	6.5	9	3	4	○
	P3	SUMR0120											△
	P4	SUMS0120											
M12 × 1.25	P2	SUMQ012N	2.5P	82	26	-	42	8.5	6.5	9	3	4	○
	P3	SUMR012N											△
M12 × 1	P2	SUMQ012M	2.5P	82	26	-	42	8.5	6.5	9	3	4	△
M14 × 2	P2	SUMQ014Q	2.5P	88	26	-	45	10.5	8	11	3	4	○
	P3	SUMR014Q											△
	P4	SUMS014Q											
M14 × 1.5	P2	SUMQ0140	2.5P	88	26	-	45	10.5	8	11	3	4	○
	P4	SUMS0140											△
M14 × 1	P2	SUMQ014M	2.5P	88	26	-	45	10.5	8	11	3	4	△
M16 × 2	P2	SUMQ016Q	2.5P	95	26	-	48	12.5	10	13	3	4	⊗
	P3	SUMR016Q											△
	P4	SUMS016Q											
M16 × 1.5	P2	SUMQ0160	2.5P	95	26	-	48	12.5	10	13	3	4	○
	P4	SUMS0160											△
M18 × 2.5	P3	SUMR018R	2.5P	100	33	-	51	14	11	14	4	4	○
	P4	SUMS018R											△
M18 × 1.5	P2	SUMQ0180	2.5P	100	33	-	51	14	11	14	4	4	○
	P4	SUMS0180											△
M20 × 2.5	P3	SUMR020R	2.5P	105	33	-	50	15	12	15	4	5	⊗
	P4	SUMS020R											△
M20 × 1.5	P3	SUMR0200	2.5P	105	33	-	50	15	12	15	4	5	○
	P4	SUMS0200											△

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
4M0.75	P2	SUPQ4.0J	2.5P	52	11	17	29	5	4	7	3	3	△
M5 × 0.8	P2	SUPQ5.0K	2.5P	60	13	22	33	5.5	4.5	7	3	3	⊗
	P3	SUPR5.0K											△
	P4	SUPS5.0K											
5M0.9	P2	SUPQ5.0L	2.5P	60	13	22	33	5.5	4.5	7	3	3	△
M6 × 1	P2	SUPQ6.0M	2.5P	62	15	26	33	6	4.5	7	3	3	⊗
	P3	SUPR6.0M											△
	P4	SUPS6.0M											
M6 × 0.75	P2	SUMQ6.0J	2.5P	62	15	26	33	6	4.5	7	3	3	△
M8 × 1.25	P2	SUMQ8.0N	2.5P	70	19	-	36	6.2	5	8	3	4	⊗
	P3	SUMR8.0N											△
	P4	SUMS8.0N											
M8 × 1	P2	SUMQ8.0M	2.5P	70	19	-	36	6.2	5	8	3	4	△
M8 × 0.75	P2	SUMQ8.0J	2.5P	70	19	-	36	6.2	5	8	3	4	△
M10 × 1.5	P2	SUMQ0100	2.5P	75	23	-	38	7	5.5	8	3	4	⊗
	P3	SUMR0100											△
	P4	SUMS0100											
M10 × 1.25	P2	SUMQ010N	2.5P	75	23	-	38	7	5.5	8	3	4	○
	P3	SUMR010N											△
	P4	SUMS010N											
M10 × 1	P2	SUMQ010M	2.5P	75	23	-	38	7	5.5	8	3	4	△
	P4	SUMS010M											
M12 × 1.75	P2	SUMQ012P	2.5P	82	26	-	42	8.5	6.5	9	3	4	⊗
	P3	SUMR012P											△
	P4	SUMS012P											
M12 × 1.5	P2	SUMQ0120	2.5P	82	26	-	42	8.5	6.5	9	3	4	○
	P3	SUMR0120											△
	P4	SUMS0120											
M12 × 1.25	P2	SUMQ012N	2.5P	82	26	-	42	8.5	6.5	9	3	4	○
	P3	SUMR012N											△
M12 × 1	P2	SUMQ012M	2.5P	82	26	-	42	8.5	6.5	9	3	4	△
M14 × 2	P2	SUMQ014Q	2.5P	88	26	-	45	10.5	8	11	3	4	○
	P3	SUMR014Q											△
	P4	SUMS014Q											
M14 × 1.5	P2	SUMQ0140	2.5P	88	26	-	45	10.5	8	11	3	4	○
	P4	SUMS0140											△
M14 × 1	P2	SUMQ014M	2.5P	88	26	-	45	10.5	8	11	3	4	△
M16 × 2	P2	SUMQ016Q	2.5P	95	26	-	48	12.5	10	13	3	4	⊗
	P3	SUMR016Q											△
	P4	SUMS016Q											
M16 × 1.5	P2	SUMQ0160	2.5P	95	26	-	48	12.5	10	13	3	4	○
	P4	SUMS0160											△
M18 × 2.5	P3	SUMR018R	2.5P	100	33	-	51	14	11	14	4	4	○
	P4	SUMS018R											△
M18 × 1.5	P2	SUMQ0180	2.5P	100	33	-	51	14	11	14	4	4	○
	P4	SUMS0180											△
M20 × 2.5	P3	SUMR020R	2.5P	105	33	-	50	15	12	15	4	5	⊗
	P4	SUMS020R											△
M20 × 1.5	P3	SUMR0200	2.5P	105	33	-	50	15	12	15	4	5	○
	P4	SUMS0200											△

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

SU+SP/SU-SP Spiral Fluted Taps for Stainless Steels

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
M22 × 2.5	P3	SUMR022R	2.5P	115	33	-	55	17	13	16	4	5	○
	P4	SUMS022R											△
	P5	SUMT022R											
M22 × 1.5	P3	SUMR0220	2.5P	115	33	-	55	17	13	16	4	5	△
	P4	SUMS0220											
M24 × 3	P3	SUMR024S	2.5P	120	39	-	55	19	15	18	4	5	○
	P4	SUMS024S											△
	P5	SUMT024S											
M24 × 1.5	P3	SUMR0240	2.5P	120	39	-	55	19	15	18	4	5	△
	P4	SUMS0240											
M27 × 3	P3	SUMR027S	2.5P	130	39	-	60	20	15	18	4	5	△
M27 × 1.5	P3	SUMR0270	2.5P	130	39	-	60	20	15	18	4	5	△
M30 × 3.5	P4	SUMS030T	2.5P	135	46	-	62	23	17	20	4	5	△
M30 × 1.5	P3	SUMR0300	2.5P	135	46	-	62	23	17	20	4	5	△
M33 × 3.5	P4	SUMS033T	2.5P	145	46	-	67	25	19	22	4	5	△
M36 × 4	P4	SUMS036U	2.5P	155	52	-	71	28	21	24	4	5	△
M39 × 4	P4	SUMS039U	2.5P	165	52	-	76	30	23	26	4	5	△
M42 × 4.5	P4	SUMS042V	2.5P	175	59	-	81	32	26	30	4	5	△
M42 × 1.5	P3	SUMR0420	2.5P	175	27	-	81	32	26	30	4	5	△
M45 × 4.5	P4	SUMS045V	2.5P	180	59	-	83	35	26	30	4	5	△
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	SUMPUN2E	2.5P	42	8.1	12	27	3	2.5	5	2	3	△
No.3-48UNC	P1	SUMPUN3F	2.5P	46	8.1	14	29	3	2.5	5	2	3	△
No.4-40UNC	P1	SUMPUN4H	2.5P	46	9	14	26	4	3.2	6	2	3	△
No.4-48UNF	P1	SUMPUN4F	2.5P	46	9	14	26	4	3.2	6	2	3	△
No.5-40UNC	P1	SUMPUN5H	2.5P	52	11	16	29	5	4	7	3	3	△
No.5-44UNF	P1	SUMPUN5G	2.5P	52	11	16	29	5	4	7	3	3	△
No.6-32UNC	P2	SUMQUN6J	2.5P	52	11	16	29	5	4	7	3	3	△
No.6-40UNF	P1	SUMPUN6H	2.5P	52	11	16	29	5	4	7	3	3	△
No.8-32UNC	P2	SUMQUN8J	2.5P	60	13	21	33	5.5	4.5	7	3	3	△
No.8-36UNF	P2	SUMQUN8I	2.5P	60	13	21	33	5.5	4.5	7	3	3	△
No.10-24UNC	P2	SUMQUNAM	2.5P	60	13	22	33	5.5	4.5	7	3	3	△
No.10-32UNF	P2	SUMQUNAJ	2.5P	60	13	22	33	5.5	4.5	7	3	3	△
1/4-20UNC	P2	SUMQU04N	2.5P	62	15	26	33	6	4.5	7	3	3	△
1/4-28UNF	P2	SUMQU04K	2.5P	62	15	26	33	6	4.5	7	3	3	△
5/16-18UNC	P2	SUMQU050	2.5P	70	19	-	36	6.2	5	8	3	4	△
5/16-24UNF	P2	SUMQU05M	2.5P	70	19	-	36	6.2	5	8	3	4	△
3/8-16UNC	P2	SUMQU06P	2.5P	75	23	-	38	7	5.5	8	3	4	△
3/8-24UNF	P2	SUMQU06M	2.5P	75	23	-	38	7	5.5	8	3	4	△
7/16-14UNC	P3	SUMRU07Q	2.5P	82	26	-	42	8.5	6.5	9	3	4	△
7/16-20UNF	P2	SUMQU07N	2.5P	82	26	-	42	8.5	6.5	9	3	4	△
1/2-13UNC	P3	SUMRU08R	2.5P	88	26	-	45	10.5	8	11	3	4	△
1/2-20UNF	P2	SUMQU08N	2.5P	88	26	-	45	10.5	8	11	3	4	△
5/8-11UNC	P3	SUMRU10U	2.5P	95	26	-	48	12.5	10	13	3	4	△
5/8-18UNF	P2	SUMQU100	2.5P	95	26	-	48	12.5	10	13	3	4	△
3/4-10UNC	P3	SUMRU12V	2.5P	105	33	-	50	15	12	15	4	5	△
3/4-16UNF	P3	SUMRU12P	2.5P	105	33	-	50	15	12	15	4	5	△
7/8-9UNC	P3	SUMRU14W	2.5P	115	33	-	55	17	13	16	4	5	△
7/8-14UNF	P3	SUMRU14Q	2.5P	115	33	-	55	17	13	16	4	5	△

SU+SP/SU-SP Spiral Fluted Taps for Stainless Steels

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
1 -8UNC	P3	SUMRU16X	2.5P	125	39	-	58	19	15	18	4	5	△
1 -12UNF	P3	SUMRU16S	2.5P	125	39	-	58	19	15	18	4	5	△
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	SUMQW03M	2.5P	60	13	21	33	5.5	4.5	7	3	3	△
1/4W20	P2	SUMQW04N	2.5P	62	15	26	33	6	4.5	7	3	3	△
5/16W18	P2	SUMQW05O	2.5P	70	19	-	36	6.2	5	8	3	4	△
3/8W16	P2	SUMQW06P	2.5P	75	23	-	38	7	5.5	8	3	4	△
7/16W14	P3	SUMRW07Q	2.5P	82	26	-	42	8.5	6.5	9	3	4	△
1/2W12	P3	SUMRW08S	2.5P	88	26	-	45	10.5	8	11	3	4	△
9/16W12	P3	SUMRW09S	2.5P	95	26	-	48	12.5	10	13	3	4	△
5/8W11	P3	SUMRW10U	2.5P	95	26	-	48	12.5	10	13	3	4	△
3/4W10	P3	SUMRW12V	2.5P	105	33	-	50	15	12	15	4	5	△
7/8W9	P3	SUMRW14W	2.5P	115	33	-	55	17	13	16	4	5	△
1 W8	P3	SUMRW16X	2.5P	125	39	-	58	19	15	18	4	5	△