					Overall length	Chamfer-		Threa	d+Neck righ	Shank length	Shank dia.	Size of square	Length of square
Oversize					L	lt	l	1	?n	ls	Ds	ĸ	lk
egment:1C			1 1	1		1000			1		I.c.	1	
Size	Class	Code	Chamfer	L (mm)	l (mm)	ln (mm)	(mm)	Ds (mm)	K (mm)	£k (mm)	No. of flutes	Туре	Stock
For Metric Threads									1				
M1.4 × 0.3	P1	SUMP1.4C	2.5P	36	5.4	-	24	3	2.5	5	2	1	
	P1	SUMP1.7D	2.50	36	6.3		24	3	2.5	5	2	2	
M1.7 × 0.35	P2	SUMQ1.7D	2.5P	30	0.3	100	24	3	2.0	Э	2	2	Δ
	P1	SUPP2.0E		42								3	0
M2 × 0.4	P2	SUPQ2.0E	2.5P		7.2	12	27	3	2.5	5	2		
	P3	SUPR2.0E											
M2.3 × 0.4	P1	SUPP2.3E	2.5P	42						5	2	3	
	P2	SUPQ2.3E			7.2	12	27	3	2.5				
	P3	SUPR2.3E											
M2.5 × 0.45	P1	SUPP2.5F										3	0
	P2	SUPQ2.5F	2.5P	46	8.1	14	29	3	2.5	5	2		
	P3	SUPR2.5F											
	P1	SUPP2.6F	2.5P	46	8.1								0
M2.6 × 0.45	P2	SUPQ2.6F				14	29	3	2.5	5	2	3	
	P3	SUPR2.6F											Δ
	P1	SUPP3.0G		46								3	0
M3 × 0.5	P2	SUPQ3.0G	2.5P		9	14	26	4	3.2	6	3		
	P3	SUPR3.0G											
3M0.6	P1	SUPP3.0H	2.5P	46	9	14	26	4	3.2	6	3	3	
	P1	SUPP3.5H	0.50	50		10	-						
M3.5 × 0.6	P3	SUPR3.5H	2.5P	52	11	16	29	5	4	7	3	3	
	P2	SUPQ4.0I											0
M4 × 0.7	P3	SUPR4.0I	2.5P	52	11	17	29	5	4	7	3	3	
	P4	SUPS4.0I											Δ

Size	Class	Code	Chamfer	(mm)	(mm)	¢n (mm)	LS (mm)	Ds (mm)	K (mm)	Lk (mm)	No. of flutes	Type	Stoc
4M0.75	P2	SUPQ4.0J	2.5P	52	11	17	29	5	4	7	3	3	
	P2	SUPQ5.0K											0
$M5 \times 0.8$	P3	SUPR5.0K	2.5P	60	13	22	33	5.5	4.5	7	3	3	
	P4	SUPS5.0K											
5M0.9	P2	SUPQ5.0L	2.5P	60	13	22	33	5.5	4.5	7	3	3	
	P2	SUPQ6.0M											0
$M6 \times 1$	P3	SUPR6.0M	2.5P	62	15	26	33	6	4.5	7	3	3	
	P4	SUPS6.0M	1								_		
$M6 \times 0.75$	P2	SUMQ6.0J	2.5P	62	15	26	33	6	4.5	7	3	3	
	P2	SUMQ8.0N											0
M8 × 1.25	P3	SUMR8.0N	2.5P	70	19	•	36	6.2	5	8	3	4	
	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	
	P2	SUMQ0100											0
M10 × 1.5	P3	SUMR0100	2.5P	75	23	•	38	7	5.5	8	3	4	
	P4	SUMS0100											
	P2	SUMQ010N		75					5.5				0
M10 × 1.25	P3	SUMR010N	2.5P		23	-	38	7		8	3	4	
	P4	SUMS010N											Δ
M10 × 1	P2	SUMQ010M		75				7	5.5	8			
	P4	SUMS010M	2.5P		23	•	38				3	4	
M12 × 1.75	P2	SUMQ012P			1			8.5	6.5	9	3		0
	P3	SUMR012P	2.5P	82	26	-	42					4	
	P4	SUMS012P											
M12 × 1.5	P2	SUM00120						8.5		9	3	4	0
	P3	SUMR0120	2.5P	82	26		42		6.5				
	P4	SUMS0120							0.12		1.0		
	P2	SUMQ012N	1.000	82			1.1.1.1		1.00			1.00	0
M12 × 1.25	P3	SUMR012N	2.5P		26		42	8.5	6.5	9	3	4	Δ
M12 × 1	P2	SUMQ012M	2.5P	82	26		42	8.5	6.5	9	3	4	Δ
	P2	SUMQ014Q	2.01	02	20			0.0	0.0			-	
M14×2	P3	SUMR014Q	2.5P	88	26	•	45	45 10.5	8	11	3	4	0
W14 ^ 2	P4	SUMS014Q			20		40						
	-				-								~
M14 × 1.5	P2	SUMQ0140	2.5P	88	26		45	10.5	5 8	11	3	4	0
	P4	SUMS0140											
M14×1	P2	SUMQ014M	2.5P	88	26	•	45	10.5	8	11	3	4	
	P2	SUMQ016Q										1022	0
M16 × 2	P3	SUMR016Q	2.5P	95	26	•	48	12.5	10	13	3	4	
	P4	SUMS016Q									_		
M16 × 1.5	P2	SUMQ0160	2.5P	95	26		48	12.5	10	13	3	4	0
	P4	SUMS0160							10				
M18 × 2.5	P3	SUMR018R	2.5P	100	33	14	51	14	11	14	4	4	0
	P4	SUMS018R					-						
M18 × 1.5	P2	SUMQ0180	2.5P	100	33		51	14	11	14	4	4	0
	P4	SUMS0180	E.VI	100				14	п			-	
$M20 \times 2.5$	P3	SUMR020R	2.5P	105	33		50	15	12	15	4	5	0
120 ~ 2.0	P4	SUMS020R	2.01	100	33		50		12	10		3	
	P3	SUMR0200	2.5P	105	33		50	15	12	15	4	5	0
$M20 \times 1.5$	P4	SUMS0200	2.5P	100	33	•	50) 15	12	15	•	5	

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

Overall	Chamfer+	Thread	Thread+Neck	Shank	Shank	Size of	Length of
length	full thread	length	length	length	dia.	square	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)	(mm)	ln (mm)	LS (mm)	Ds (mm)	K (mm)	£k (mm)	No. of flutes	Туре	Stock
a and the state of the second second	P3	SUMR022R											0
M22 × 2.5	P4	SUMS022R	2.5P	115	33		55	17	13	16	4	5	
	P5	SUMT022R											
	P3	SUMR0220						14					
M22 × 1.5	P4	SUMS0220	2.5P	115	33		55	17	13	16	4	5	
	P3	SUMR024S											0
$M24 \times 3$	P4	SUMS024S	2.5P	120	39		55	19	15	18	4	5	
	P5	SUMT024S											
	P3	SUMR0240											
M24 × 1.5	P4	SUMS0240	2.5P	120	39	•	55	19	15	18	4	5	
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	
	P4	SUMS033T	2.5P	145	46		67	25	19	22	4	5	
M33 × 3.5				-							4	5	
M36 × 4	P4	SUMS036U	2.5P	155	52	•	71	28	21	24			
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	
or Unified Threads													
Size	Class	Code	Chamfer	(mm)	(mm)	ln (mm)	LS (mm)	Ds (mm)	K (mm)	£k (mm)	No. of flutes	Туре	Stoc
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	
	P2	SUMQUO6P	2.5P	75	23		38	7	5.5	8	3	4	
3/8-16UNC	P2 P2	SUMQU06P SUMQU06M	2.5P	75	23	•	30	7	5.5	8	3	4	-
3/8-24UNF						•							
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	SUMQUO8N	2.5P	88	26	•	45	10.5	8	11	3	4	
	P3	SUMRU10U	2.5P	95	26	•	48	12.5	10	13	3	4	
5/8-11UNC		SUMQU100	2.5P	95	26	1.0	48	12.5	10	13	3	4	
5/8-18UNF	P2												
5/8-18UNF 3/4-10UNC	P3	SUMRU12V	2.5P	105	33	-	50	15	12	15	4	5	
5/8-18UNF			2.5P 2.5P	105 105	33 33	•	50 50	15 15	12 12	15 15	4	5 5	
5/8-18UNF 3/4-10UNC	P3	SUMRU12V	-										

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)	¢k (mm)	No. of flutes	Туре	Stock
1 -8UNC	P3	SUMRU16X	2.5P	125	39	•	58	19	15	18	4	5	Δ
1 -12UNF	P3	SUMRU16S	2.5P	125	39	- 14 C	58	19	15	18	4	5	
For Whitworth Th	reads												
Size	Class	Code	Chamfer	L (mm)	l (mm)	ln (mm)	LS (mm)	Ds (mm)	K (mm)	£k (mm)	No. of flutes	Туре	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	Δ
5/16W18	P2	SUMQW050	2.5P	70	19		36	6.2	5	8	3	4	Δ
3/8W16	P2	SUMQW06P	2.5P	75	23	•	38	7	5.5	8	3	4	Δ
7/16W14	P3	SUMRW07Q	2.5P	82	26	-	42	8.5	6.5	9	3	4	Δ
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	Δ
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	Δ
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	