

Segment : 1E



Overall length	Thread length	Threadless length	Shank length	Shank dia.	Size of square	Length of square
L	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
For Metric Threads													
<b>M3 × 0.5</b>	P2	POQ3.0G--L	5P	46	9	14	26	4	3.2	6	3	1	△
<b>M4 × 0.7</b>	P2	POQ4.0I--L	5P	52	11	17	29	5	4	7	3	1	△
<b>M5 × 0.8</b>	P2	POQ5.0K--L	5P	60	13	22	33	5.5	4.5	7	3	1	△
<b>M6 × 1</b>	P2	POQ6.0M--L	5P	62	15	26	33	6	4.5	7	3	1	△
<b>M8 × 1.25</b>	P3	POR8.0N--L	5P	70	19	-	36	6.2	5	8	3	2	△
<b>M8 × 1</b>	P3	POR8.0M--L	5P	70	19	-	36	6.2	5	8	3	2	△
<b>M10 × 1.5</b>	P3	POR0100--L	5P	75	23	-	38	7	5.5	8	3	2	△
<b>M10 × 1.25</b>	P3	POR010N--L	5P	75	23	-	38	7	5.5	8	3	2	△
<b>M10 × 1</b>	P3	POR010M--L	5P	75	23	-	38	7	5.5	8	3	2	△
<b>M12 × 1.75</b>	P4	POS012P--L	5P	82	26	-	42	8.5	6.5	9	3	2	△
<b>M12 × 1.5</b>	P3	POR0120--L	5P	82	26	-	42	8.5	6.5	9	3	2	△
<b>M12 × 1.25</b>	P4	POS012N--L	5P	82	26	-	42	8.5	6.5	9	3	2	△
<b>M14 × 2</b>	P4	POS0140--L	5P	88	26	-	45	10.5	8	11	3	2	△
<b>M14 × 1.5</b>	P3	POR0140--L	5P	88	26	-	45	10.5	8	11	3	2	△
<b>M16 × 2</b>	P4	POS0160--L	5P	95	26	-	48	12.5	10	13	3	2	△
<b>M16 × 1.5</b>	P3	POR0160--L	5P	95	26	-	48	12.5	10	13	3	2	△
<b>M18 × 2.5</b>	P4	POS018R--L	5P	100	33	-	51	14	11	14	3	2	△
<b>M18 × 1.5</b>	P4	POS0180--L	5P	100	33	-	51	14	11	14	3	2	△
<b>M20 × 2.5</b>	P4	POS020R--L	5P	105	33	-	50	15	12	15	3	3	△
<b>M20 × 1.5</b>	P4	POS0200--L	5P	105	33	-	50	15	12	15	3	3	△
<b>M22 × 2.5</b>	P4	POS022R--L	5P	115	33	-	55	17	13	16	3	3	△
<b>M22 × 1.5</b>	P4	POS0220--L	5P	115	33	-	55	17	13	16	3	3	△
<b>M24 × 3</b>	P4	POS024S--L	5P	120	39	-	55	19	15	18	3	3	△

# PO LH Spiral Pointed Taps for Left Hand Threads

Overall length	Thread length	Thread/Flute length	Shank length	Shank dia.	Size of square	Length of square
L	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
<b>M24 × 1.5</b>	P4	POS0240--L	5P	120	39	-	55	19	15	18	3	3	△
<b>M27 × 3</b>	P4	POS027S--L	5P	130	39	-	60	20	15	18	4	3	△
<b>M27 × 1.5</b>	P4	POS0270--L	5P	130	39	-	60	20	15	18	4	3	△
<b>M30 × 3.5</b>	P5	POT030T--L	5P	135	46	-	62	23	17	20	4	3	△
<b>M30 × 1.5</b>	P4	POS0300--L	5P	135	46	-	62	23	17	20	4	3	△

## 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
<b>1/4-20UNC</b>	P2	POQU04N--L	5P	62	15	26	33	6	4.5	7	3	1	△
<b>1/4-28UNF</b>	P2	POQU04K--L	5P	62	15	26	33	6	4.5	7	3	1	△
<b>5/16-18UNC</b>	P3	PORU050--L	5P	70	19	-	36	6.2	5	8	3	2	△
<b>5/16-24UNF</b>	P2	POQU05M--L	5P	70	19	-	36	6.2	5	8	3	2	△
<b>3/8-16UNC</b>	P3	PORU06P--L	5P	75	23	-	38	7	5.5	8	3	2	△
<b>3/8-24UNF</b>	P2	POQU06M--L	5P	75	23	-	38	7	5.5	8	3	2	△
<b>7/16-14UNC</b>	P3	PORU07Q--L	5P	82	26	-	42	8.5	6.5	9	3	2	△
<b>7/16-20UNF</b>	P3	PORU07N--L	5P	82	26	-	42	8.5	6.5	9	3	2	△
<b>1/2-13UNC</b>	P3	PORU08R--L	5P	88	26	-	45	10.5	8	11	3	2	△
<b>1/2-20UNF</b>	P3	PORU08N--L	5P	88	26	-	45	10.5	8	11	3	2	△

## 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
<b>1/4W20</b>	P3	PORW04N--L	5P	62	15	26	33	6	4.5	7	3	1	△
<b>5/16W18</b>	P3	PORW050--L	5P	70	19	-	36	6.2	5	8	3	2	△
<b>3/8W16</b>	P3	PORW06P--L	5P	75	23	-	38	7	5.5	8	3	2	△
<b>1/2W12</b>	P3	PORW08S--L	5P	88	26	-	45	10.5	8	11	3	2	△
<b>5/8W11</b>	P3	PORW10U--L	5P	95	26	-	48	12.5	10	13	3	2	△
<b>3/4W10</b>	P4	POSW12V--L	5P	105	33	-	50	15	12	15	3	3	△