

**CNC Spiral Flute**  
Steels and Stainless Steels

*Spiral Flute Taps for Blind Holes*

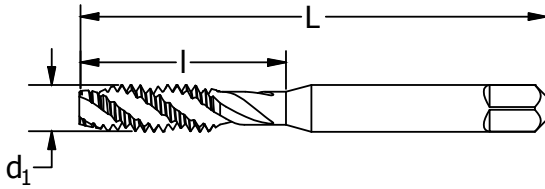


Style: **SFS**



**P** **M**

**Note**  
Tapping speeds - see page 39-41.



diameter & pitch	thread form	d <sub>1</sub> in	number of flutes	H-limit	L in	I in	order number
10-32	UNF	.1900	3	H3	2.375	.875	330465
1/4-20	UNC	.2500	3	H3	2.500	1.000	330466
1/4-20	UNC	.2500	3	H5	2.500	1.000	330489
5/16-18	UNC	.3125	3	H3	2.719	1.125	330468
5/16-18	UNC	.3125	3	H5	2.719	1.125	330490
3/8-16	UNC	.3750	3	H3	2.938	1.250	330470
3/8-16	UNC	.3750	3	H5	2.938	1.250	330491
1/2-13	UNC	.5000	3	H3	3.375	1.656	330474
1/2-13	UNC	.5000	3	H5	3.375	1.656	330494
1/2-20	UNF	.5000	3	H5	3.375	1.656	330495
5/8-11	UNC	.6250	4	H3	3.813	1.813	330478
5/8-11	UNC	.6250	4	H5	3.813	1.813	330496

**Metric - CNC Spiral Flute**  
Steels and Stainless Steels

Style: **SFS**

diameter & pitch	d <sub>1</sub> mm	number of flutes	D-limit	L in	I in	order number
M4 x 0.7	4.00	3	D4	2.125	.750	330498
M5 x 0.8	5.00	3	D4	2.375	.875	330499
M6 x 1	6.00	3	D5	2.500	1.000	330502
M8 x 1.25	8.00	3	D5	2.719	1.125	330503
M10 x 1.5	10.00	3	D6	2.938	1.250	330504
M12 x 1.75	12.00	3	D6	3.375	1.656	330505



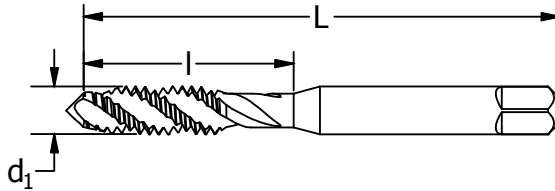
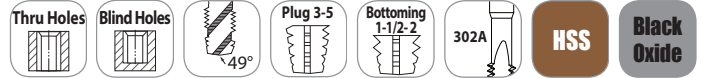
## Spiral Flute Taps for Blind Holes

Style: **SFHD**

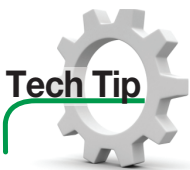
**Spiral Flute  
CNC Heavy-Duty**



**Note**  
Tapping speeds - see  
page 39-41.



diameter & pitch	thread form	d <sub>1</sub> in	number of flutes	H-limit	L in	l in	order number	
							plug Black Oxide	bottoming Black Oxide
6-32	UNC	.1380	3	H3	2.000	.688	281957	282005
8-32	UNC	.1640	3	H3	2.125	.750	282054	282104
10-24	UNC	.1900	3	H3	2.375	.875	282062	282120
10-32	UNF	.1900	3	H3	2.375	.875	282153	282203
1/4-20	UNC	.2500	3	H3	2.500	1.000	282252	282302
1/4-28	UNF	.2500	3	H3	2.500	1.000	282351	282401
5/16-18	UNC	.3125	3	H3	2.719	1.125	282450	282501
5/16-24	UNF	.3125	3	H3	2.719	1.125	282468	282526
3/8-16	UNC	.3750	3	H3	2.938	1.250	282559	282609
3/8-24	UNF	.3750	3	H3	2.938	1.250	282567	282625
1/2-13	UNC	.5000	3	H3	3.375	1.656	282757	282807
1/2-20	UNF	.5000	3	H3	3.375	1.656	282765	282823



### Tech Tip

#### Ground Thread Tap Limits

All standard ground thread taps made to USCTI Tables 327 and 329 will be marked **G** to designate ground thread. **G** will be followed by **H** to designate above basic or **L** for below basic and a numeral to designate the pitch diameter limits. For example: **G H3** indicates a ground thread tap with pitch diameter limits .0010" to .0015" over basic. See table at right.

For taps over 1-1/2" diameter with H or L limit numbers, divide the H or L limit number by 2 to get the amount (in thousandths of an inch) the maximum tap pitch diameter is over basic for the H series or under basic for the L series. In H series taps, the tolerance shown in USCTI Table 331, Column D, subtracted from the maximum pitch diameter will give the minimum pitch diameter. In L series taps the tolerance shown in Table 331, Column D, added to the minimum pitch diameter will give the maximum pitch diameter. These taps will be marked with the appropriate H or L limit number.

#### Pitch Diameter Limits

##### for taps through 1" diameter

- L1 = basic to basic - .0005
- H1 = basic to basic + .0005
- H2 = basic + .0005 to basic + .0010
- H3 = basic + .0010 to basic + .0015
- H4 = basic + .0015 to basic + .0020
- H5 = basic + .0020 to basic + .0025
- H6 = basic + .0025 to basic + .0030

##### for taps over 1" diameter through 1-1/2" diameter

- H4 = basic + .0010 to basic + .0020

Machine Taps  
Spiral Point Taps  
Spiral Flute Taps  
Thread Forming Taps  
Pipe Taps  
Dies  
Technical Info  
Sets  
Index

**General Purpose Spiral Flute**  
High-Spiral

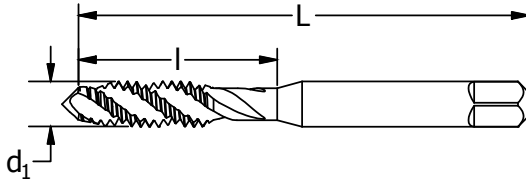
*Spiral Flute Taps for Blind Holes*



Style: **SFGP**



**Note**  
Tapping speeds - see page 39-41.



diameter & pitch	thread form	d <sub>1</sub> in	number of flutes	H-limit	L in	I in	order number			
							plug		bottoming	
							Bright	TiN	Bright	TiN
4-40	UNC	.1120	2	H2	1.875	.563	367149	—	367156	330202
6-32	UNC	.1380	2	H3	2.000	.688	367222	330193	367230	330203
8-32	UNC	.1640	3	H3	2.125	.750	367263	330194	367271	330204
10-24	UNC	.1900	3	H3	2.375	.875	367305	330195	367313	—
10-32	UNF	.1900	3	H3	2.375	.875	367321	330196	367339	330205
1/4-20	UNC	.2500	3	H3	2.500	1.000	367909	—	367917	367913
1/4-28	UNF	.2500	3	H3	2.500	1.000	367925	—	367933	—
5/16-18	UNC	.3125	3	H3	2.719	1.125	367941	—	367958	—
5/16-24	UNF	.3125	3	H3	2.719	1.125	367966	—	367974	—
3/8-16	UNC	.3750	3	H3	2.938	1.250	367982	—	367990	—
3/8-24	UNF	.3750	3	H3	2.938	1.250	368006	—	368014	—
1/2-13	UNC	.5000	3	H3	3.375	1.656	368063	—	368071	—
1/2-20	UNF	.5000	3	H3	3.375	1.656	368089	—	368097	—

**Metric - Gen Purpose Spiral Flute**  
High-Spiral

Style: **SFGP**

diameter & pitch	d <sub>1</sub> mm	number of flutes	D-limit	L in	I in	order number			
						plug		bottoming	
						Bright	TiCN	Bright	TiCN
M3 x 0.5	3.00	2	D3	1.938	.625	366110	—	366112	330206
M4 x 0.7	4.00	3	D4	2.125	.750	366130	330197	366132	330207
M5 x 0.8	5.00	3	D4	2.375	.875	366140	330198	366142	330208
M6 x 1.0	6.00	3	D5	2.500	1.000	366150	330199	366152	330209
M8 x 1.25	8.00	3	D5	2.719	1.125	366160	330200	366162	330210
M10 x 1.5	10.00	3	D6	2.938	1.250	366170	330201	366172	330211
M12 x 1.75	12.00	3	D6	3.375	1.656	366180	—	366182	—