

HAND TAPS



Taps - Hand

Reliable, precision threading

- M, MF
- UNC, UNF, UNEF, UN, UNS
- BSW, BSF, BA, BSB
- Rc (BSP I), Rp (BSPPL), Pg Series, G (BSPF)
- NPT, NPTF, NPSF

special taps express delivery service...

SUPA FAST



Sutton Tools has a dedicated production facility for express delivery service on special taps.

With our state of the art CNC grinding equipment almost any profile can be achieved.

- Straight Flute Taps M1 to M127
- Spiral & Gun Taps M1 to M52

All Thread Forms:

Metric, MJ, UN, UNJC, UNJF, Pg, Whit, Rope forms & Acme and more!!

Surface Finishes and Treatments:

- All latest PVD coatings available

Contact our sales team for more information.



www.sutton.com.au

BSF, BA, BSB (Brass)

G (BSPF)

Rc (BSPT), Rp (BSPPL), Pg, NPT, NPTF, NPSF

ISO	VDI	Material Group	Sutton
P	A	Steel	N
M	R	Stainless Steel	VA
K	F	Cast Iron	GG
N	N	Non-Ferrous Metals, Aluminiums & Coppers	Al W
S	S	Titaniums & Super Alloys	Ti
H	H	Hard Materials (≥ 45 HRC)	Ni

^ VDI 3323 material groups can also be determined by referring to the material cross reference listing in the application guide at the back of this catalogue.

138	140	139	140			
MF	141	142				
UNC	143	145	144			
UNF	146	148	147			
BSW	151	153	152			
	154					
	155	156				
	157			157	157	158



Material
Surface Finish
Sutton Designation
Tapping Depth
Limit & Nut Tolerance

HSS			
BrT	TiN	BrT	TiN
N			
≤ 1xØ			
ISO 2 / 6H			
Z3			
-			

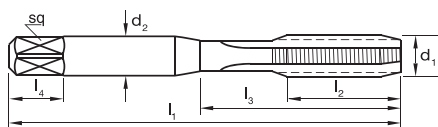
ISO	VDI [^] 3323	Material	Condition	HB	N/mm²							
P	1	Steel - Non-alloy, cast & free cutting	~ 0.15 %C	A	125	440	●	●	●	●	●	●
	2		~ 0.45 %C	A	190	640	●	●	●	●	●	●
	3			QT	250	840	●	●	●	●	●	●
	4		~ 0.75 %C	A	270	910	●	●	●	●	●	●
	5			QT	300	1010			○		○	
	6	Steel - Low alloy & cast < 5% of alloying elements		A	180	610	●	●	●	●	●	●
	7			QT	275	930	○	○	●	○	●	○
	8			QT	300	1010			○		○	
	9			QT	350	1180						
	10	Steel - High alloy, cast & tool		A	200	680			○		○	
	11			HT	325	1100						
M	12	Steel - Corrosion resistant & cast	Ferritic / Martensitic	A	200	680			○			
	13		Martensitic	QT	240	810						
	14.1	Stainless Steel	Austenitic	AH	180	610			○		○	○
K	14.2		Duplex		250	840						
	14.3		Precipitation Hardening		250	840						
	15	Cast Iron - Grey (GG)	Ferritic / Pearlitic		180	610	○	○	○	○	○	○
N	16	Cast Iron - Nodular (GGG)	Pearlitic		260	880						
	17		Ferritic		160	570	○	○	○	○	○	○
	18	Cast Iron - Malleable	Pearlitic		250	840						
	19		Ferritic		130	460	○	○	○	○	○	○
S	20		Pearlitic		230	780						
	21	Aluminum & Magnesium - wrought alloy	Non Heat Treatable		60	210	○	○	○	○	○	○
	22		Heat Treatable	AH	100	360	○	○	○	○	○	○
	23	Aluminum & Magnesium - cast alloy ≤12% Si	Non Heat Treatable		75	270	○	○	○	○	○	○
	24		Heat Treatable	AH	90	320	○	○	○	○	○	○
	25	Al & Mg - cast alloy >12% Si	Non Heat Treatable		130	460						
	26	Copper & Cu alloys (Brass/Bronze)	Free cutting, Pb > 1%		110	390	○	○	○	○	○	○
	27		Brass (CuZn, CuSnZn)		90	320			○		○	○
	28		Bronze (CuSn)		100	360	○	○	○	○	○	○
	29	Non-metallic - Thermosetting & fiber-reinforced plastics										
H	30	Non-metallic - Hard rubber, wood etc.										
	31	High temp. alloys	Fe based	A	200	680						
	32			AH	280	950						
	33		Ni / Co based	A	250	840						
	34			AH	350	1180						
	35			C	320	1080						
	36	Titanium & Ti alloys	CP Titanium		400 MPa							
	37.1		Alpha alloys		860 MPa							
	37.2		Alpha / Beta alloys	A	960 MPa							
	37.3			AH	1170 MPa							
	37.4		Beta alloys	A	830 MPa							
	37.5			AH	1400 MPa							
	38.1	Hardened steel		HT	45 HRC							
	38.2			HT	55 HRC							
	39.1			HT	58 HRC							
	39.2			HT	62 HRC							
H	40	Cast Iron	Chilled	C	400	1350						
	41			HT	55 HRC							

Condition: A (Annealed), AH (Age Hardened), C (Cast), HT (Hardened & Tempered), QT (Quenched & Tempered)

Hand Taps Metric, Straight Flute, N

suttontools

- General purpose use
- Suitable for materials up to 1000N/mm²
- Through & blind holes
- Suitable for both hand and machine operations
- Depths up to approx. 1 x d₁



Catalogue Code

Discount Group

Material

Surface Finish

Sutton Designation

Geometry

Chamfer

Limit & Nut Tolerance

Size Ref.	d ₁	Pitch	L ₁	L ₂	L ₃	d ₂	sq	L ₄	z	drill Ø
0200	M2	x 0.40	41	8	-	2.50	2.00	4	3	1.6
0250	M2.5	x 0.45	45	10	-	2.80	2.24	5	3	2.05
0300	M3	x 0.50	48	11	15	3.15	2.50	5	3	2.5
0350	M3.5	x 0.60	50	13	17.5	3.55	2.80	5	3	2.9
0400	M4	x 0.70	53	13	18	4.00	3.15	6	3	3.3
0450	M4.5	x 0.75	53	13	19	4.50	3.55	6	3	3.7
0500	M5	x 0.80	58	16	22	5.00	4.00	7	3	4.2
0600	M6	x 1.00	66	19	26	6.30	5.00	8	3	5.0
0700	M7	x 1.00	66	19	26	7.10	5.60	8	4	6.0
0800	M8	x 1.25	72	22	30	8.00	6.30	9	4	6.8
0900	M9	x 1.25	72	22	31	9.00	7.10	10	4	7.8
1000	M10	x 1.50	80	24	34	10.00	8.00	11	4	8.5
1100	M11	x 1.50	85	25	-	8.00	6.30	9	4	9.5
1200	M12	x 1.75	89	29	-	9.00	7.10	10	4	10.2
1400	M14	x 2.00	95	30	-	11.20	9.00	12	4	12.0
1600	M16	x 2.00	102	32	-	12.50	10.00	13	4	14.0
1800	M18	x 2.50	112	37	-	14.00	11.20	14	4	15.5
2000	M20	x 2.50	112	37	-	14.00	11.20	14	4	17.5
2200	M22	x 2.50	118	38	-	16.00	12.50	16	4	19.5
2400	M24	x 3.00	130	45	-	18.00	14.00	18	4	21.0
2700	M27	x 3.00	135	45	-	20.00	16.00	20	4	24.0
3000	M30	x 3.50	138	48	-	20.00	16.00	20	4	26.5
3300	M33	x 3.50	151	51	-	22.40	18.00	22	4	29.5
3600	M36	x 4.00	162	57	-	25.00	20.00	24	4	32.0
3900	M39	x 4.00	170	60	-	28.00	22.40	26	4	35.0
4200	M42	x 4.50	170	60	-	28.00	22.40	26	4	37.5
4500	M45	x 4.50	187	67	-	31.50	25.00	28	4	40.5
4800	M48	x 5.00	187	67	-	31.50	25.00	28	4	43.0
5200	M52	x 5.00	200	70	-	35.50	28.00	31	4	47.0

Tap & Drill Sets

0014

14 piece set (intermediate)

Taps: M3, M4, M5, M6, M8, M10, M12
Drills: 2.5, 3.3, 4.2, 5.0, 6.8, 8.5, 10.2mm

SDT1

28 piece set (taper, inter, bott) (Discount Group Z0304)

Taps: M3, M4, M5, M6, M8, M10, M12
Drills: 2.5, 3.3, 4.2, 5.0, 6.8, 8.5, 10.2mm



T385 0014



T901 SDT1



T384	T385	T386	T901
D0702	D0702	D0702	D0702
HSS	HSS	HSS	HSS
Brt	Brt	Brt	Brt
N	N	N	N
-	-	-	-
Taper	Intermediate	Bottoming	Set
ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H

Item #	Item #	Item #	Item #
T384 0200	T385 0200	T386 0200	T901 0200
T384 0250	T385 0250	T386 0250	T901 0250
T384 0300	T385 0300	T386 0300	T901 0300
T384 0350	T385 0350	T386 0350	T901 0350
T384 0400	T385 0400	T386 0400	T901 0400
T384 0450	T385 0450	T386 0450	T901 0450
T384 0500	T385 0500	T386 0500	T901 0500
T384 0600	T385 0600	T386 0600	T901 0600
T384 0700	T385 0700	T386 0700	T901 0700
T384 0800	T385 0800	T386 0800	T901 0800
T384 0900	T385 0900	T386 0900	T901 0900
T384 1000	T385 1000	T386 1000	T901 1000
T384 1100	T385 1100	T386 1100	T901 1100
T384 1200	T385 1200	T386 1200	T901 1200
T384 1400	T385 1400	T386 1400	T901 1400
T384 1600	T385 1600	T386 1600	T901 1600
T384 1800	T385 1800	T386 1800	T901 1800
T384 2000	T385 2000	T386 2000	T901 2000
T384 2200	T385 2200	T386 2200	T901 2200
T384 2400	T385 2400	T386 2400	T901 2400
T384 2700	T385 2700	T386 2700	•
T384 3000	T385 3000	T386 3000	•
T384 3300	T385 3300	T386 3300	•
T384 3600	T385 3600	T386 3600	•
T384 3900	T385 3900	T386 3900	•
T384 4200	T385 4200	T386 4200	•
T384 4500	T385 4500	T386 4500	•
T384 4800	T385 4800	T386 4800	•
T384 5200	T385 5200	T386 5200	•

ISO	P													M			K					N										S										H							
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T384	●	●	●	●		●	○										○		○		○		○	○	○	○		○																					
P	Steel			M	Stainless Steel			K	Cast Iron			N	Non-Ferrous Metals			S	Titanium & Super Alloys			H	Hard Materials															●	Optimal		○	Effective									

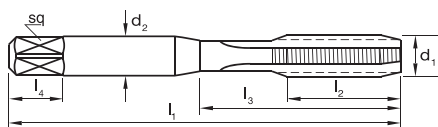
P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials

• Optimal ○ Effective

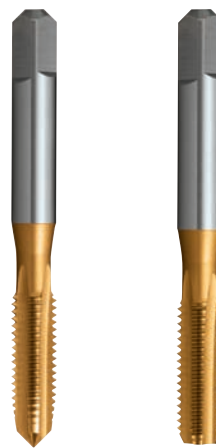
• Available on request as special manufacture. Subject to lead time.

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ISO	P													M			K					N										S										H							
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T387	●	●	●	●	●	●	●	○		○		○		○		○	○	○	○	○	○		○	○	○	○	○	○	○	○	○																		
P Steel	M Stainless Steel			K Cast Iron			N Non-Ferrous Metals			S Titanium & Super Alloys			H Hard Materials																					● Optimal	○ Effective														

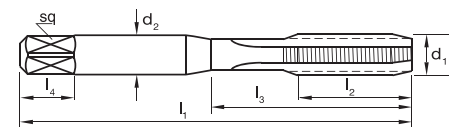


Catalogue Code	T387	T388
Discount Group	D0706	D0706
Material	HSS	HSS
Surface Finish	<i>TIN</i>	<i>TIN</i>
Sutton Designation	N	N
Geometry	-	-
Chamfer	Intermediate	Bottoming
Limit & Nut Tolerance	ISO 2 / 6H	ISO 2 / 6H

Hand Taps Metric, Straight Flute, N, Left Hand

suttontools

- General purpose use
- Suitable for materials up to 1000N/mm²
- Through & blind holes
- Suitable for both hand and machine operations
- Depths up to approx. 1 x d₁



Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø
0300	M3	x 0.50	48	11	15	3.15	2.50	5	3	2.5
0400	M4	x 0.70	53	13	18	4.00	3.15	6	3	3.3
0500	M5	x 0.80	58	16	22	5.00	4.00	7	3	4.2
0600	M6	x 1.00	66	19	26	6.30	5.00	8	3	5.0
0800	M8	x 1.25	72	22	30	8.00	6.30	9	4	6.8
1000	M10	x 1.50	80	24	34	10.00	8.00	11	4	8.5
1200	M12	x 1.75	89	29	-	9.00	7.10	10	4	10.2
1400	M14	x 2.00	95	30	-	11.20	9.00	12	4	12.0
1600	M16	x 2.00	102	32	-	12.50	10.00	13	4	14.0
1800	M18	x 2.50	112	37	-	14.00	11.20	14	4	15.5
2000	M20	x 2.50	112	37	-	14.00	11.20	14	4	17.5

Catalogue Code

Discount Group

Material

Surface Finish

Sutton Designation

Geometry

Chamfer

Limit & Nut Tolerance

T389

D0702

HSS

Brt

N

Left Hand

Taper

ISO 2 / 6H LH

T390

D0702

HSS

Brt

N

Left Hand

Intermediate

ISO 2 / 6H LH

T391

D0702

HSS

Brt

N

Left Hand

Bottoming

ISO 2 / 6H LH

Item #

T389 0300

T389 0400

T389 0500

T389 0600

T389 0800

T389 1000

T389 1200

T389 1400

T389 1600

T389 1800

T389 2000

Item #

T390 0300

T390 0400

T390 0500

T390 0600

T390 0800

T390 1000

T390 1200

T390 1400

T390 1600

T390 1800

T390 2000

Item #

T391 0300

T391 0400

T391 0500

T391 0600

T391 0800

T391 1000

T391 1200

T391 1400

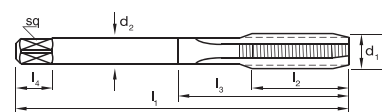
T391 1600

T391 1800

T391 2000

Hand Taps Metric, Straight Flute, Oversize

- Oversize allowance to suit components for galvanize plating
- General purpose use, materials up to 1000N/mm²
- Through & blind holes
- Suitable for both hand and machine operations
- Depths up to approx 1 x d₁
- Taper and inter leads available on request



Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø
1000	M10+0.4	x 1.5	85	25	-	8.0	6.3	9.0	4	8.9
1200	M12+0.4	x 1.75	89	29	-	9.0	7.1	10.0	4	10.6
1600	M16+0.4	x 2.0	112	37	-	12.5	10.0	13.0	4	14.4
2000	M20+0.4	x 2.5	118	38	-	16.0	12.5	16.0	4	17.9
2400	M24+0.45	x 3.0	130	45	-	18.0	14.0	18.0	4	21.5



Item #

T392

T392 1000

T392 1200

T392 1600

T392 2000

T392 2400

ISO	P													M	K					N										S										H																		
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41									
T389	●	●	●	●		●	○										○		○		○		○	○	○		○		○																													
P	Steel			M	Stainless Steel			K	Cast Iron			N	Non-Ferrous Metals			S	Titanium & Super Alloys			H	Hard Materials												●	Optimal												○	Effective											

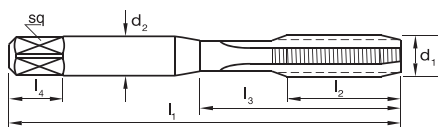
P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials

● Optimal ○ Effective

Hand Taps Metric Fine, Straight Flute, N

suttontools

- General purpose use
- Suitable for materials up to 1000N/mm²
- Through & blind holes
- Suitable for both hand and machine operations
- Depths up to approx. 1 x d₁



Catalogue Code
Discount Group
Material
Surface Finish
Sutton Designation
Geometry
Chamfer
Limit & Nut Tolerance

T401	T402	T403	T902
D0702	D0702	D0702	D0702
HSS	HSS	HSS	HSS
Brt	Brt	Brt	Brt
N	N	N	N
-	-	-	-
Taper	Intermediate	Bottoming	Set
ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H

Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #	Item #	Item #	Item #
0503	MF 5	x 0.50	58	16	22	5.0	4.0	7	4	4.5	•	•	T403 0503	•
0604	MF 6	x 0.75	66	19	26	6.3	5.0	8	4	5.3	•	•	T403 0604	T902 0604
0805	MF 8	x 1.0*	72	22	30	8.0	6.3	9	4	7.0	T401 0805	T402 0805	T403 0805	T902 0805
0804	MF 8	x 0.75	72	22	30	8.0	6.3	9	4	7.3	•	•	T403 0804	T902 0804
1004	MF 10	x 0.75	80	24	34	10.0	8.0	11	4	9.3	•	•	T403 1004	•
1005	MF 10	x 1.00†	80	24	34	10.0	8.0	11	4	9.0	T401 1005	T402 1005	T403 1005	T902 1005
1006	MF 10	x 1.25*	80	24	34	10.0	8.0	11	4	8.8	T401 1006	T402 1006	T403 1006	T902 1006
1205	MF 12	x 1.00	89	29	-	9.0	7.1	10	4	11.0	T401 1205	T402 1205	T403 1205	•
1206	MF 12	x 1.25	89	29	-	9.0	7.1	10	4	10.8	T401 1206	T402 1206	T403 1206	T902 1206
1207	MF 12	x 1.5*	89	29	-	9.0	7.1	10	4	10.5	T401 1207	T402 1207	T403 1207	T902 1207
1405	MF 14	x 1.00	95	30	-	11.2	9.0	12	4	13.0	•	•	T403 1405	•
1406	MF 14	x 1.25†	95	30	-	11.2	9.0	12	4	12.8	T401 1406	T402 1406	T403 1406	T902 1406
1407	MF 14	x 1.5*	95	30	-	11.2	9.0	12	4	12.5	T401 1407	T402 1407	T403 1407	T902 1407
1605	MF 16	x 1.00	102	32	-	12.5	10.0	13	4	15.0	•	•	T403 1605	•
1606	MF 16	x 1.25	102	32	-	12.5	10.0	13	4	14.8	•	•	T403 1606	•
1607	MF 16	x 1.5*	102	32	-	12.5	10.0	13	4	14.5	T401 1607	T402 1607	T403 1607	T902 1607
1806	MF 18	x 1.25	112	37	-	14.0	11.2	14	4	16.8	•	•	T403 1806	•
1807	MF 18	x 1.5*	112	37	-	14.0	11.2	14	4	16.5	T401 1807	T402 1807	T403 1807	T902 1807
2006	MF 20	x 1.25	112	37	-	14.0	11.2	14	4	18.8	•	•	T403 2006	•
2007	MF 20	x 1.5**	112	37	-	14.0	11.2	14	4	18.5	T401 2007	T402 2007	T403 2007	T902 2007
2008	MF 20	x 2.0*	112	37	-	14.0	11.2	14	4	18.0	•	•	T403 2008	•
2207	MF 22	x 1.50	118	38	-	16.0	12.5	16	4	20.5	T401 2207	T402 2207	T403 2207	T902 2207
2208	MF 22	x 2.00	118	38	-	16.0	12.5	16	4	20.0	•	•	T403 2208	•
2407	MF 24	x 1.50	130	45	-	18.0	14.0	18	4	22.5	•	•	T403 2407	•
2408	MF 24	x 2.0*	130	45	-	18.0	14.0	18	4	22.0	T401 2408	T402 2408	T403 2408	T902 2408
2507	MF 25	x 1.5**	130	45	-	18.0	14.0	18	4	23.5	T401 2507	T402 2507	T403 2507	•
2708	MF 27	x 2.00	135	45	-	20.0	16.0	20	4	25.0	•	•	T403 2708	•
3007	MF 30	x 1.50	138	48	-	20.0	16.0	20	4	28.5	T401 3007	T402 3007	T403 3007	•
3008	MF 30	x 2.00	138	48	-	20.0	16.0	20	4	28.0	T401 3008	T402 3008	T403 3008	•
3207	MF 32	x 1.5**	151	51	-	22.4	18.0	22	4	30.5	T401 3207	T402 3207	T403 3207	•
4007	MF 40	x 1.5**	170	60	-	28.0	22.4	26	4	38.5	T401 4007	T402 4007	T403 4007	•
Spark Plug														
1005	MF 10	x 1.00	80	24	34	10.0	8.0	11	4	9.0	T401 1005	T402 1005	T403 1005	T902 1005
1206	MF 12	x 1.25	89	29	-	9.0	7.1	10	4	10.8	T401 1206	T402 1206	T403 1206	T902 1206
1406	MF 14	x 1.25	95	30	-	11.2	9.0	12	4	12.8	T401 1406	T402 1406	T403 1406	T902 1406
1807	MF 18	x 1.50	112	37	-	14.0	11.2	14	4	16.5	T401 1807	T402 1807	T403 1807	T902 1807

ISO	P													M	K				N											S										H									
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T401	●	●	●	●	●	○											○	○	○	○	○		○	○	○	○	○	○	○																				
P Steel	M Stainless Steel	K Cast Iron	N Non-Ferrous Metals	S Titanium & Super Alloys	H Hard Materials																																												
																																									● Optimal	○ Effective							

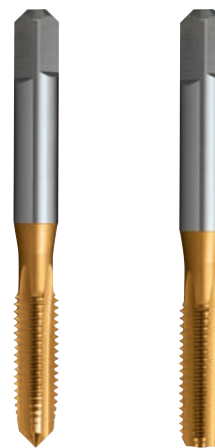
P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials

• Optimal ○ Effective

Hand Taps Metric Fine, Straight Flute, N

suttontools

- General purpose use
- Suitable for materials up to 1000N/mm²
- Through & blind holes
- Suitable for both hand and machine operations
- Depths up to approx. 1 x d₁



Catalogue Code	T404	T405
Discount Group	D0706	D0706
Material	HSS	HSS
Surface Finish	TiN	TiN
Sutton Designation	N	N
Geometry	-	-
Chamfer	Intermediate	Bottoming
Limit & Nut Tolerance	ISO 2 / 6H	ISO 2 / 6H

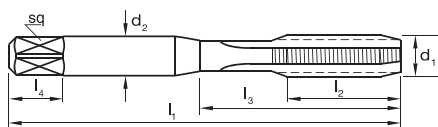
Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #	Item #
0503	MF5	x 0.50	58	16	22	5.0	4.0	7	4	4.5	•	•
0604	MF6	x 0.75	66	19	26	6.3	5.0	8	4	5.3	•	•
0804	MF8	x 0.75	72	22	30	8.0	6.3	9	4	7.3	•	•
0805	MF8	x 1.0*	72	22	30	8.0	6.3	9	4	7.0	T404 0805	T405 0805
1004	MF10	x 0.75	80	24	34	10.0	8.0	11	4	9.3	•	•
1005	MF10	x 1.00†	80	24	34	10.0	8.0	11	4	9.0	T404 1005	T405 1005
1006	MF10	x 1.25*	80	24	34	10.0	8.0	11	4	8.8	T404 1006	T405 1006
1205	MF12	x 1.00	89	29	-	9.0	7.1	10	4	11.0	•	•
1206	MF12	x 1.25	89	29	-	9.0	7.1	10	4	10.8	T404 1206	T405 1206
1207	MF12	x 1.5*	89	29	-	9.0	7.1	10	4	10.5	T404 1207	T405 1207
1405	MF14	x 1.00	95	30	-	11.2	9.0	12	4	13.0		•
1406	MF14	x 1.25†	95	30	-	11.2	9.0	12	4	12.8	T404 1406	T405 1406
1407	MF14	x 1.5*	95	30	-	11.2	9.0	12	4	12.5	T404 1407	T405 1407
1605	MF16	x 1.00	102	32	-	12.5	10.0	13	4	15.0		•
1606	MF16	x 1.25	102	32	-	12.5	10.0	13	4	14.8		•
1607	MF16	x 1.5*	102	32	-	12.5	10.0	13	4	14.5	•	T405 1607
1806	MF18	x 1.25	112	37	-	14.0	11.2	14	4	16.8		•
1807	MF18	x 1.5*	112	37	-	14.0	11.2	14	4	16.5	•	•
2006	MF20	x 1.25	112	37	-	14.0	11.2	14	4	18.8		•
2007	MF20	x 1.5**	112	37	-	14.0	11.2	14	4	18.5	•	•
2008	MF20	x 2.0*	112	37	-	14.0	11.2	14	4	18.0		•
2207	MF22	x 1.50	118	38	-	16.0	12.5	16	4	20.5	•	•
2208	MF22	x 2.00	118	38	-	16.0	12.5	16	4	20.0		•
2407	MF24	x 1.50	130	45	-	18.0	14.0	18	4	22.5		•
2408	MF24	x 2.0*	130	45	-	18.0	14.0	18	4	22.0	•	•
2507	MF25	x 1.5**	130	45	-	18.0	14.0	18	4	23.5	•	•
2708	MF27	x 2.00	135	45	-	20.0	16.0	20	4	25.0		•
3007	MF30	x 1.50	138	48	-	20.0	16.0	20	4	28.5	•	
3008	MF30	x 2.00	138	48	-	20.0	16.0	20	4	28.0	•	•
3207	MF32	x 1.5**	151	51	-	22.4	18.0	22	4	30.5	•	•
4007	MF40	x 1.5**	170	60	-	28.0	22.4	26	4	38.5	•	•
	Spark Plug											
1005	MF10	x 1.00	80	24	34	10.0	8.0	11	4	9.0	T404 1005	T405 1005
1206	MF12	x 1.25	89	29	-	9.0	7.1	10	4	10.8	T404 1206	T405 1206
1406	MF14	x 1.25	95	30	-	11.2	9.0	12	4	12.8	T404 1406	T405 1406
1807	MF18	x 1.50	112	37	-	14.0	11.2	14	4	16.5		

ISO	P													M	K					N										S										H										
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41	
T404	●	●	●	●		●	●	○		○		○		○			○		○		○			○	○	○			○	○	○																			
P	Steel		M Stainless Steel											K Cast Iron					N Non-Ferrous Metals										S Titanium & Super Alloys										H Hard Materials										●	○

• Optimal ○ Effective

suttontools

-
- ISO 529
- UNC
- 60°



ISO	P													M		K					N										S										H								
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T414	●	●	●	●		●	○										○		○		○		○	○	○	○	○		○		○																		

P

Steel

M

Stainless Steel

K

Cast Iron

N

Non-Ferrous Metals

S

Titanium & Super Alloys

H

Hard Materials

●

Optimal

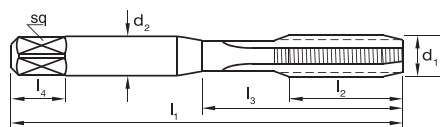
○

Effective

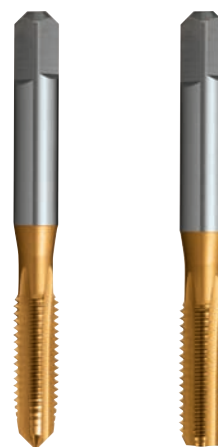


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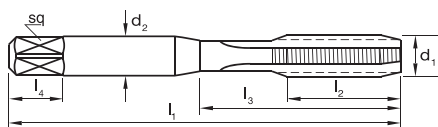
ISO	P													M			K						N										S										H												
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41						
T417	●	●	●	●	○	●	●	○		○		○	○	14.1			○		○	○	○	○	○	○	○	○	○	○	○	○	○																								
P Steel	M Stainless Steel			K Cast Iron			N Non-Ferrous Metals			S Titanium & Super Alloys			H Hard Materials																																										
																																														● Optimal ○ Effective									



Catalogue Code	T417	T418
Discount Group	D0706	D0706
Material	HSS	HSS
Surface Finish	<i>TiN</i>	<i>TiN</i>
Sutton Designation	N	N
Geometry	-	-
Chamfer	Intermediate	Bottoming
Nut Tolerance	2B	2B

suttontools

-
- ISO 529
- 60°
- UNC



ISO	P													M		K				N								S								H													
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T419	●	●	●	●		●	○										○		○		○		○	○	○		○		○																				

P Steel

M Stainless Steel

K Cast Iron

N Non-Ferrous Metals

S Titanium & Super Alloys

H Hard Materials

● Optimal

○ Effective

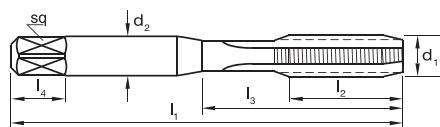


Catalogue Code	T419	T420	T421
Discount Group	D0702	D0702	D0702
Material	HSS	HSS	HSS
Surface Finish	<i>Brt</i>	<i>Brt</i>	<i>Brt</i>
Sutton Designation	N	N	N
Geometry	Left Hand	Left Hand	Left Hand
Chamfer	Taper	Intermediate	Bottoming
Nut Tolerance	2B LH	2B LH	2B LH



suttontools

- ISO 529                                                      

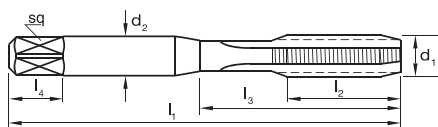


Size Ref.	d ₁	TPI	I ₁	I ₂	I ₃	d ₂	sq	I ₄	z	drill Ø	Item #	Item #	Item #	Item #
0251	#3	56	45	10	-	2.80	2.24	5	3	2.1	T431 0251	T432 0251	T433 0251	●
0284	#4	48	48	15	14.5	3.15	2.50	5	3	2.35	T431 0284	T432 0284	T433 0284	T904 0284
0318	#5	44	48	15	15	3.15	2.50	5	3	2.65	T431 0318	T432 0318	T433 0318	T904 0318
0351	#6	40	50	17	17.5	3.55	2.80	5	3	2.9	T431 0351	T432 0351	T433 0351	T904 0351
0417	#8	36	53	13	17	4.50	3.55	6	3	3.5	T431 0417	T432 0417	T433 0417	T904 0417
0483	#10	32	58	16	22	5.00	4.00	7	3	4.1	T431 0483	T432 0483	T433 0483	T904 0483
0549	#12	28	62	17	23	5.60	4.50	7	3	4.6	T431 0549	T432 0549	T433 0549	T904 0549
0476	3/16	32 (UNS)	58	16	22	5.00	4.00	7	3	4.0	T431 0476	T432 0476	T433 0476	T904 0476
0635	1/4	28	66	19	25	6.30	5.00	8	3	5.5	T431 0635	T432 0635	T433 0635	T904 0635
0794	5/16	24	72	22	30	8.00	6.30	9	4	6.9	T431 0794	T432 0794	T433 0794	T904 0794
0953	3/8	24	80	24	33	10.00	8.00	11	4	8.5	T431 0953	T432 0953	T433 0953	T904 0953
1111	7/16	20	85	25	-	8.00	6.30	9	4	9.8	T431 1111	T432 1111	T433 1111	T904 1111
1270	1/2	20	89	29	-	9.00	7.10	10	4	11.5	T431 1270	T432 1270	T433 1270	T904 1270
1429	9/16	18	95	30	-	11.20	9.00	12	4	12.8	T431 1429	T432 1429	T433 1429	T904 1429
1588	5/8	18	102	32	-	12.50	10.00	13	4	14.5	T431 1588	T432 1588	T433 1588	T904 1588
1905	3/4	16	112	37	-	14.00	11.20	14	4	17.5	T431 1905	T432 1905	T433 1905	T904 1905
2223	7/8	14	118	38	-	16.00	12.50	16	4	20.5	T431 2223	T432 2223	T433 2223	T904 2223
2540	1	12	130	45	-	18.00	14.00	18	4	23.5	T431 2540	T432 2540	T433 2540	T904 2540
2541	1	14 (UNS)	130	45	-	18.00	14.00	18	4	24.0	T431 2541	T432 2541	T433 2541	T904 2541
2858	1-1/8	12	138	48	-	20.00	16.00	20	4	26.5	T431 2858	T432 2858	T433 2858	●
3175	1-1/4	12	151	51	-	22.40	18.00	22	4	29.5	T431 3175	T432 3175	T433 3175	●
3810	1-1/2	12	170	60	-	28.00	22.40	26	4	36.0	T431 3810	T432 3810	T433 3810	●

ISO	P													M	K						N										S										H								
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T431	●	●	●	●		●	○										○		○		○			○	○	○	○		○		○																		
P	Steel			M	Stainless Steel			K	Cast Iron			N	Non-Ferrous Metals			S	Titanium & Super Alloys			H	Hard Materials																							●	Optimal		○	Effective	

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ISO	P													M		K				N										S										H									
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T434	●	●	●	●	●	●	○			○		○		○			○		○		○		○	○	○	○	○	○	○	○																			

P

Steel

M

Stainless Steel

K

Cast Iron

N

Non-Ferrous Metals

S

Titanium & Super Alloys

H

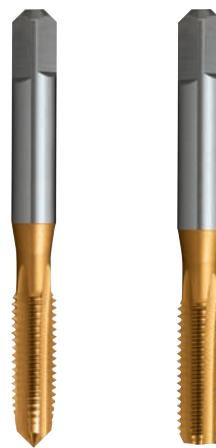
Hard Materials

●

Optimal

○

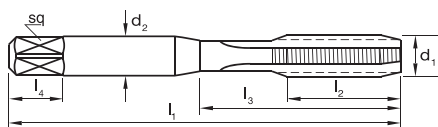
Effective



Catalogue Code	T434	T435
Discount Group	D0706	D0706
Material	HSS	HSS
Surface Finish	<i>TIN</i>	<i>TIN</i>
Sutton Designation	N	N
Geometry	-	-
Chamfer	Intermediate	Bottoming
Nut Tolerance	2B	2B

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[illegible]

ISO	P													M	K								N										S										H						
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T445	●	●	●	●		●	○										○	○	○	○	○		○	○	○	○		○		○																			

P Steel

M Stainless Steel

K Cast Iron

N Non-Ferrous Metals

S Titanium & Super Alloys

H Hard Materials

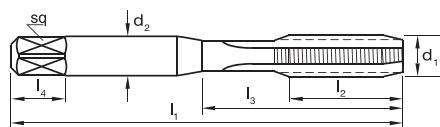
● Optimal

○ Effective

- Available on request as special manufacture. Subject to lead time.

suttontools

- ISO 529
- 60° UN



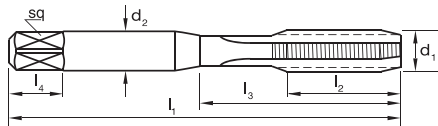
Catalogue Code	T448	T449	T450	T910
Discount Group	D0702	D0702	D0702	D0702
Material	HSS	HSS	HSS	HSS
Surface Finish	<i>Brt</i>	<i>Brt</i>	<i>Brt</i>	<i>Brt</i>
Sutton Designation	N	N	N	N
Geometry	Extra Fine	Extra Fine	Extra Fine	Extra Fine
Chamfer	Taper	Intermediate	Bottoming	Set
Limit & Nut Tolerance	GH8/2B	GH8/2B	GH8/2B	GH8/2B

[illegible]

ISO	P													M	K						N										S										H								
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T448	●	●	●	●		●	○										○		○		○			○	○	○	○		○																				
P Steel	M Stainless Steel	K Cast Iron	N Non-Ferrous Metals	S Titanium & Super Alloys	H Hard Materials																																												
																																									● Optimal	○ Effective							

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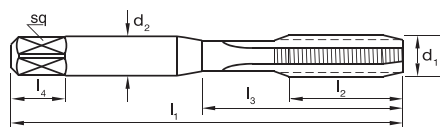
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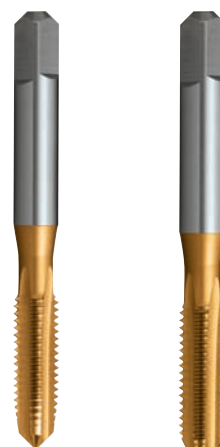
ISO	P													M		K				N										S							H												
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T451	●	●	●	●		●	○										○		○		○		○	○	○	○	○	○	○	○	○	○																	
P Steel	M Stainless Steel				K Cast Iron				N Non-Ferrous Metals				S Titanium & Super Alloys							H Hard Materials														● Optimal	○ Effective														

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ISO	P													M			K						N										S										H						
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T454	●	●	●	●	○	●	●	○		○		○	○	14.1			○		○	○	○	○	○	○	○	○	○	○	○	○	○																		
P Steel	M Stainless Steel			K Cast Iron			N Non-Ferrous Metals			S Titanium & Super Alloys			H Hard Materials																				● Optimal	○ Effective															

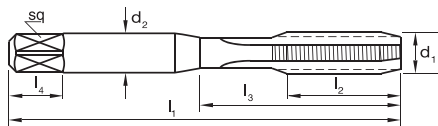


Catalogue Code	T454	T455
Discount Group	D0706	D0706
Material	HSS	HSS
Surface Finish	<i>TiN</i>	<i>TiN</i>
Sutton Designation	N	N
Geometry	-	-
Chamfer	Intermediate	Bottoming
Limit & Nut Tolerance	Z3 Medium	Z3 Medium

152

suttontools

-
- Technical drawing of a screw thread showing three different thread profiles: ISO 529, BSW, and 55°. The ISO 529 profile is shown on the left, followed by the BSW profile, and the 55° profile on the right. The 55° profile is labeled with '55°' and 'BSW'.



Size Ref.	d ₁	TPI	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #
0635	1/4	20	66	19	25	6.30	5.00	8	3	5.1	T456 0635
0794	5/16	18	72	22	30	8.00	6.30	9	4	6.5	T456 0794
0953	3/8	16	80	24	33	10.00	8.00	11	4	7.9	T456 0953
1111	7/16	14	85	25	-	8.00	6.30	9	4	9.3	T456 1111
1270	1/2	12	89	29	-	9.00	7.10	10	4	10.5	T456 1270
1429	9/16	12	95	30	-	11.20	9.00	12	4	12.1	T456 1429
1588	5/8	11	102	32	-	12.50	10.00	13	4	13.5	T456 1588
1905	3/4	10	112	37	-	14.00	11.20	14	4	16.25	T456 1905

ISO	P													M		K					N										S										H								
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T456	●	●	●	●		●	○										○		○		○		○	○	○	○		○		○																			

P

Steel

M

Stainless Steel

K

Cast Iron

N

Non-Ferrous Metals

S

Titanium & Super Alloys

H

Hard Materials

●

Optimal

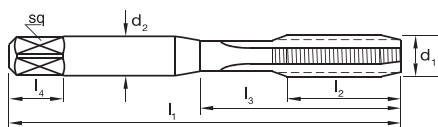
○

Effective

Hand Taps BSF, BA & BSB, Straight Flute, N

suttontools

- General purpose use
- Suitable for materials up to 1000N/mm²
- Through & blind holes
- Suitable for both hand and machine operations
- Depths up to approx. 1 x d₁



Catalogue Code

Discount Group

Material

Surface Finish

Sutton Designation

Geometry

Chamfer

Limit & Nut Tolerance

Size Ref.	d ₁	TPI	L ₁	L ₂	L ₃	d ₂	sq	L ₄	z	drill Ø
BSF										
0476	3/16	32	58	16	22	5.00	4.00	7	3	4.0
0635	1/4	26	66	19	25	6.30	5.00	8	3	5.3
0794	5/16	22	72	22	30	8.00	6.30	9	4	6.8
0953	3/8	20	80	24	33	10.00	8.00	11	4	8.3
1111	7/16	18	85	25	-	8.00	6.30	9	4	9.8
1270	1/2	16	89	29	-	9.00	7.10	10	4	11.0
1429	9/16	16	95	30	-	11.20	9.00	12	4	12.7
1588	5/8	14	102	32	-	12.50	10.00	13	4	14.0
1905	3/4	12	112	37	-	14.00	11.20	14	4	16.75
2223	7/8	11	118	38	-	16.00	12.50	16	4	19.75
2540	1	10	130	45	-	18.00	14.00	18	4	22.75

BA										
0600	0	1	66	19	26	6.30	5.00	8	3	5.1
0530	1	0.90	62	17	23	5.60	4.50	7	3	4.5
0470	2	0.81	58	16	22	5.00	4.00	7	3	4.0
0410	3	0.73	53	13	18	4.50	3.55	6	3	3.4
0360	4	0.66	50	17	-	3.55	2.80	5	3	3.0
0320	5	0.59	48	15	-	3.15	2.50	5	3	2.65
0280	6	0.53	48	15	-	3.15	2.50	5	3	2.3
0250	7	0.48	45	10	-	2.80	2.24	5	3	2.05
0220	8	0.43	45	10	-	2.80	2.24	5	3	1.8
0190	9	0.39	41	8	-	2.50	2.00	4	3	1.55
0170	10	0.35	41	8	-	2.50	2.00	4	3	1.4

BSB - Brass Series										
0635	1/4	26(BSF)	66	19	25	6.30	5.00	8	3	5.2
0794	5/16*	26	72	22	30	8.00	6.30	9	4	6.8
0953	3/8*	26	80	24	33	10.00	8.00	11	4	8.4
1111	7/16*	26	85	25	-	8.00	6.30	9	4	10.0
1270	1/2*	26	89	29	-	9.00	7.10	10	4	11.6
1429	9/16*	26	95	30	-	11.20	9.00	12	4	13.2
1588	5/8*	26	102	32	-	12.50	10.00	13	4	14.8
1905	3/4*	26	112	37	-	14.00	11.20	14	4	18.0
2223	7/8*	26	118	38	-	16.00	12.50	16	4	20.8
2540	1*	26	130	45	-	18.00	14.00	18	4	24.3

D0702	D0702	D0702	D0702
HSS	HSS	HSS	HSS
BrT	BrT	BrT	BrT
N	N	N	N
-	-	-	-
Taper	Intermediate	Bottoming	Set
Z3 Medium	Z3 Medium	Z3 Medium	Z3 Medium

Item #	Item #	Item #	Item #
T466	T467	T468	T906
T466 0476	T467 0476	T468 0476	T906 0476
T466 0635	T467 0635	T468 0635	T906 0635
T466 0794	T467 0794	T468 0794	T906 0794
T466 0953	T467 0953	T468 0953	T906 0953
T466 1111	T467 1111	T468 1111	T906 1111
T466 1270	T467 1270	T468 1270	T906 1270
T466 1429	T467 1429	T468 1429	•
T466 1588	T467 1588	T468 1588	•
T466 1905	T467 1905	T468 1905	•
T466 2223	T467 2223	T468 2223	•
T466 2540	T467 2540	T468 2540	•

T469	T470	T471	T907
T469 0600	T470 0600	T471 0600	•
T469 0530	T470 0530	T471 0530	T907 0530
T469 0470	T470 0470	T471 0470	T907 0470
T469 0410	T470 0410	T471 0410	T907 0410
T469 0360	T470 0360	T471 0360	T907 0360
T469 0320	T470 0320	T471 0320	T907 0320
T469 0280	T470 0280	T471 0280	T907 0280
T469 0250	T470 0250	T471 0250	T907 0250
T469 0220	T470 0220	T471 0220	T907 0220
T469 0190	T470 0190	T471 0190	T907 0190
T469 0170	T470 0170	T471 0170	T907 0170

T472	T473	T474	T908
T466 0635	T467 0635	T468 0635	T906 0635
T472 0794	T473 0794	T474 0794	T908 0794
T472 0953	T473 0953	T474 0953	T908 0953
T472 1111	T473 1111	T474 1111	T908 1111
T472 1270	T473 1270	T474 1270	T908 1270
•	•	T474 1429	•
•	•	T474 1588	•
•	•	T474 1905	•
•	•	T474 2223	•
•	•	T474 2540	•

ISO	P													M		K					N										S										H								
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T466	●	●	●	●	●	○											○	○	○	○	○		○	○	○	○	○	○	○																				
P	Steel			M	Stainless Steel			K	Cast Iron			N	Non-Ferrous Metals			S	Titanium & Super Alloys			H	Hard Materials													●	Optimal		○	Effective											

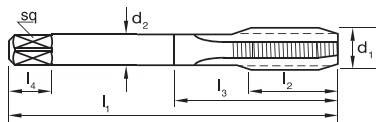
P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials

• Optimal ○ Effective

• Available on request as special manufacture. Subject to lead time. * Limit & Nut Tolerance = Z4

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[illegible]

ISO	P													M	K								N										S										H						
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T479	●	●	●	●		●	○										○	○	○	○	○		○	○	○	○	○	○	○																				

P Steel

M Stainless Steel

K Cast Iron

N Non-Ferrous Metals

S Titanium & Super Alloys

H Hard Materials

● Optimal

○ Effective

- Available on request as special manufacture. Subject to lead time.

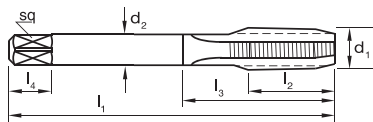


Catalogue Code	T482	T483
Discount Group	D0706	D0706
Material	HSS	HSS
Surface Finish	<i>TIN</i>	<i>TIN</i>
Sutton Designation	N	N
Geometry	-	-
Chamfer	Intermediate	Bottoming
Limit	Z3	Z3
	Item #	Item #

Hand Taps Pipe, Rc (BSPT), Straight Flute

suttontools

- General purpose use
- Suitable for materials up to 1000N/mm²
- Through & blind holes
- Suitable for both hand and machine operations
- Taper pipe reamer recommended prior to tapping Rc (BSPT) thread forms



Catalogue Code	T475	T476
Discount Group	D0702	D0706
Material	HSS	HSS
Surface Finish	Brt	TiN
Sutton Designation	N	N
Geometry	-	-
Chamfer	Bottoming	Bottoming
Limit & Nut Tolerance	To Suit	To Suit
	Item #	Item #
	T475 0973	T476 0973
	T475 1316	T476 1316
	T475 1666	T476 1666
	T475 2096	T476 2096
	T475 2644	•
	T475 3325	•
	T475 4191	•
	T475 4780	•
	T475 5961	•

Size Ref.	d ₁	TPI	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø
Rc (BSPT) 1:16 Taper Rate										
0973	1/8	28	59	15	-	8.0	6.3	9	4	8.4
1316	1/4	19	67	19	-	10.0	8.0	11	4	10.8
1666	3/8	19	75	21	-	12.5	10.0	13	4	14.5
2096	1/2	14	87	26	-	16.0	12.5	16	4	18.0
2644	3/4	14	96	28	-	20.0	16.0	20	4	23.0
3325	1	11	109	33	-	25.0	20.0	24	5	29.0
4191	1-1/4	11	119	36	-	31.5	25.0	28	5	38.0
4780	1-1/2	11	125	37	-	35.5	28.0	31	7	44.0
5961	2	11	140	41	-	40.0	31.5	34	7	55.0

Hand Taps Pipe, Rp & Pg Series, Straight Flute

- General Purpose use for materials up to approx. 1000 N/mm²
- Through & blind holes
- Suitable for both hand and machine operations



Size Ref.	d ₁	TPI	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Nominal OD	Item #
Rp Series (BSPPL) Sealing Pipe Thread Parallel												T477
0973	1/8	28	59	15	-	8.0	6.3	9	4	8.6	-	T477 0973
1316	1/4	19	67	19	-	10.0	8.0	11	4	11.5	-	T477 1316
1666	3/8	19	75	21	-	12.5	10.0	13	4	15.0	-	T477 1666
2096	1/2	14	87	26	-	16.0	12.5	16	4	18.5	-	T477 2096
2644	3/4	14	96	28	-	20.0	16.0	20	4	24.0	-	T477 2644
3325	1	11	109	33	-	25.0	20.0	24	4	30.2	-	T477 3325
4191	1-1/4	11	119	36	-	31.5	25.0	28	4	39.0	-	T477 4191
4780	1-1/2	11	125	37	-	35.5	28.0	31	4	45.0	-	T477 4780
5961	2	11	140	41	-	40.0	31.5	34	4	56.4	-	T477 5961
Pg – Steel Conduit (Armour Pipe)												T478
1250	Pg 7	20	89	29	-	9	7.1	10	4	11.3	12.5	T478 1250
1520	Pg 9	18	102	32	-	12.5	10	12	4	13.9	15.2	T478 1520
1860	Pg 11	18	112	37	-	14	11.2	14	4	17.3	18.6	T478 1860
2040	Pg 13.5	18	118	38	-	16	12.5	16	4	19.1	20.4	T478 2040
2250	Pg 16	18	118	38	-	16	12.5	16	4	21.2	22.5	T478 2250
2830	Pg 21	16	138	48	-	20	16	20	4	26.8	28.3	T478 2830

ISO	P													M			K			N										S										H									
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T475	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
T476	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
T477	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•

P Steel **M** Stainless Steel **K** Cast Iron **N** Non-Ferrous Metals **S** Titanium & Super Alloys **H** Hard Materials

• Optimal ○ Effective

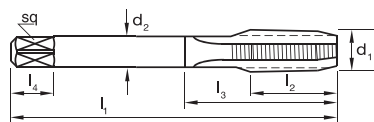
• Available on request as special manufacture. Subject to lead time.

Rc, Rp, Pg

Hand Taps Pipe, National Series

suttontools

- General purpose use, materials up to approx. 1000 N/mm²
- Suitable for both hand and machine operations
- Taper pipe reamer recommended prior to tapping



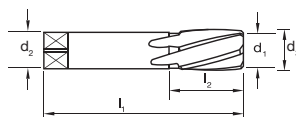
Catalogue Code	D0702
Discount Group	HSS
Material	Colour Temp
Surface Finish	N
Sutton Designation	-
Geometry	Bottoming
Chamfer	Refer Limit
Limit & Nut Tolerance	Item #

Size Ref.	d ₁	TPI	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	Limit drill Ø	Item #	
NPSF (Dryseal Straight)											T486	
1029	1/8	27	54	19	-	11.11	8.33	9.5	4	GH3	8.6	T486 1029
1372	1/4	18	62	27	-	14.29	10.70	11.1	4	GH4	11.3	T486 1372
1715	3/8	18	65	27	-	17.78	13.49	12.7	4	GH4	14.5	T486 1715
2134	1/2	14	79	35	-	17.46	13.08	15.9	4	GH5	18.0	T486 2134
NPT (National Pipe Taper) 15° Chamfer (1:16 Taper Rate)											T487	
1029	1/8	27	54	19	-	11.11	8.33	9.5	4	-	8.2	T487 1029
1372	1/4	18	62	27	-	14.29	10.70	11.1	4	-	10.8	T487 1372
1715	3/8	18	65	27	-	17.78	13.49	12.7	4	-	14.0	T487 1715
2134	1/2	14	79	35	-	17.46	13.08	15.9	4	-	17.5	T487 2134
2667	3/4	14	82	35	-	23.00	17.25	17.5	4	-	23.0	T487 2667
3340	1	11-1/2	95	44.5	-	28.60	21.40	20.6	5	-	28.5	T487 3340
4216	1-1/4	11-1/2	102	44.5	-	33.30	25.00	23.8	5	-	37.0	T487 4216
NPTF (Dryseal Taper) 15° Chamfer (1:16 Taper Rate)											T488	
1029	1/8	27	54	19	-	11.11	8.33	9.5	4	-	8.2	T488 1029
1372	1/4	18	62	27	-	14.29	10.70	11.1	4	-	10.8	T488 1372
1715	3/8	18	65	27	-	17.78	13.49	12.7	4	-	14.0	T488 1715
2134	1/2	14	79	35	-	17.46	13.08	15.9	4	-	17.50	T488 2134

Hand Reamers Taper Pipe

- Used prior to tapping
- For Rc (BSPT), NPT & NPTF tapered threads
- Prolongs tap life, especially in tough materials

Discount Group: B0302



Size Ref.	Size	d ₁	l ₁	l ₂	d ₃	d ₂	z	Item #
								R108
0803	1/8	.316	2-11/32	19/32	.353	.315	6	R108 0803
1031	1/4	.406	2-21/32	25/32	.453	.394	6	R108 1031
1372	3/8	.540	2-31/32	7/8	.592	.492	6	R108 1372
1689	1/2	.665	3-7/16	1-1/32	.729	.630	6	R108 1689
2225	3/4	.876	3-25/32	1-1/8	.945	.787	6	R108 2225
2802	1	1.103	4-5/16	1-5/16	1.184	.984	6	R108 2802
3668	1-1/4	1.444	4-11/16	1-7/16	1.529	1.240	6	R108 3668
4277	1-1/2	1.684	4-15/16	1-5/8	1.775	1.398	8	R108 4277
5484	2	2.159	5-17/32	1-5/8	2.260	1.575	8	R108 5484

ISO	P													M			K							N										S										H					
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T486	●	●	●	●	●	○								○			○		○		○		○	○	○	○	○	○	○	○	○																		
R108	●	●	●	●	○	○	○			○		○					●	○	○	○	○	○	○	○	○	○	○	○	○	○	○																		○

P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials

● Optimal ○ Effective