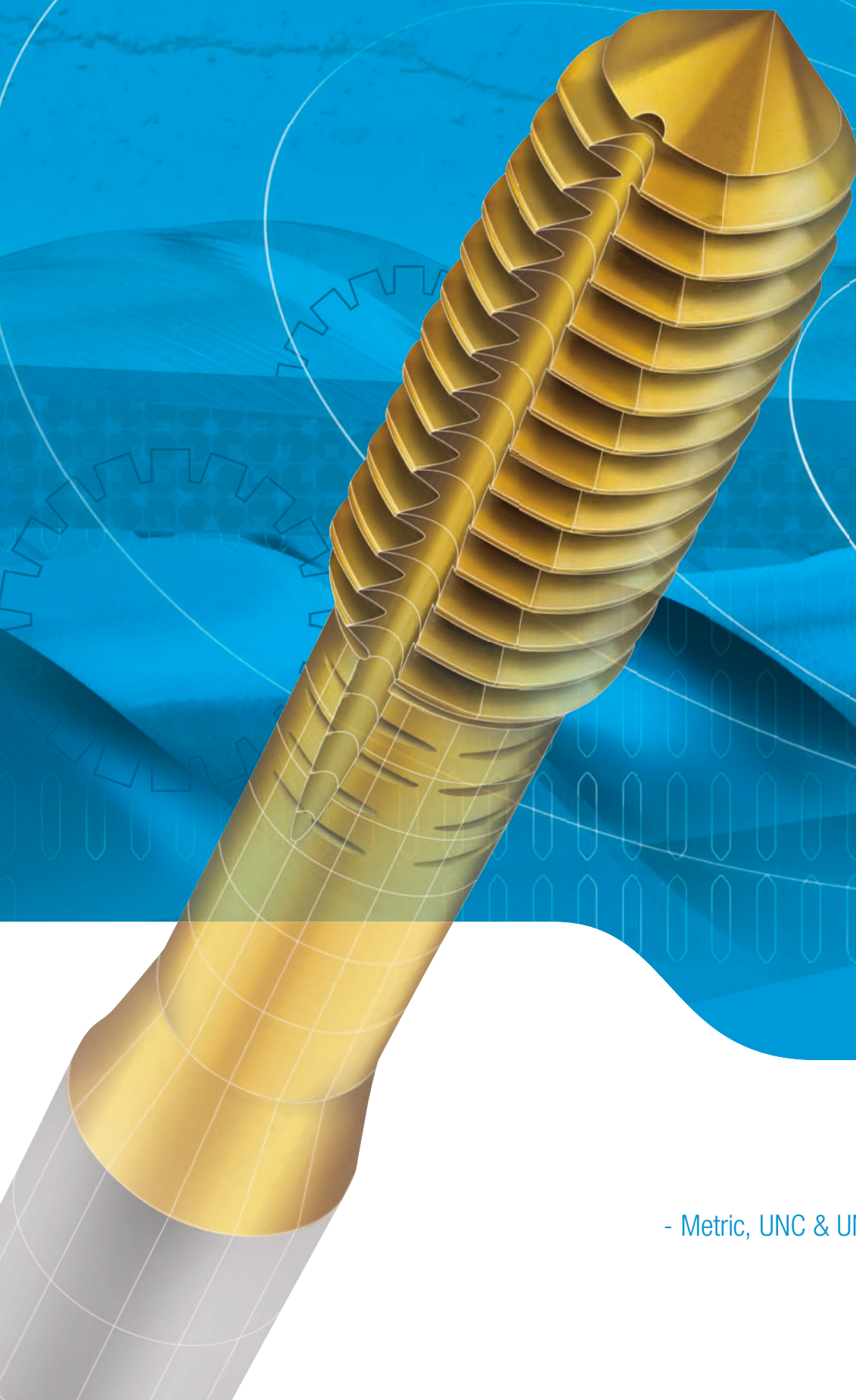


JIS TAPS



Taps-JIS

- *Roll Taps*

- SP & PO machine taps

- Metric, UNC & UNF standard thread forms

^ 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.

FOR THREAD FORMING		
286	288	286
299	300	
303	304	
		
T514	T520	T629
T526	T662	
T538	T544	
HSS Co.8	HSS Co.8	PM-HSSE V3
TiN	TiN	TiCN
N		NH
≤ 3xØ		

FOR TAPPING BLIND & THROUGH HOLES	
298	298
	
T294	T296
SPM	VHM
TCN	
XH	VH
≤ 1.5x0	

ISO	VDI ¹⁾ 3323	Material		Condition	HB	N/mm²	Tapping Depth		
P	1	Steel - Non-alloy, cast & free cutting	~ 0.15 %C	A	125	440	●	●	●
	2		~ 0.45 %C	A	190	640	●	●	●
	3		~ 0.75 %C	QT	250	840	○	○	●
	4			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				
	12	Steel - Corrosion resistant & cast	Ferritic / Martensitic	A	200	680	○	○	●
	13		Martensitic	QT	240	810			
M	14.1	Stainless Steel	Austenitic	AH	180	610	●	●	●
	14.2		Duplex		250	840	●	●	●
	14.3		Precipitation Hardening		250	840			
K	15	Cast Iron - Grey (GG)	Ferritic / Pearlitic		180	610			
	16		Pearlitic		260	880			
	17	Cast Iron - Nodular (GGG)	Ferritic		160	570			
	18		Pearlitic		250	840			
	19	Cast Iron - Malleable	Ferritic		130	460			○
	20		Pearlitic		230	780			
N	21	Aluminum & Magnesium - wrought alloy	Non Heat Treatable		60	210	●	●	●
	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							
	30	Non-metallic - Hard rubber, wood etc.							
S	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							
H	38.1	Hardened steel		HT	45 HRC				
	38.2			HT	55 HRC				
	39.1			HT	58 HRC				
	39.2			HT	62 HRC				
	40			Cast Iron	Chilled	C	400	1350	
	41	HT	55 HRC						

[illegible]

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

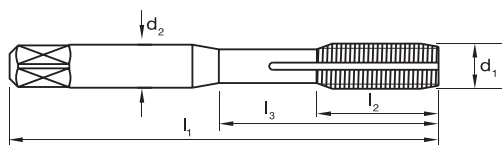
● Optimal ○ Effective

[illegible]

FOR TAPPING BLIND HOLES											
292		292		293	294	295		296	297		
302		302									
306		306									
T503	T606	T504	T607	T609	T690	T570	T611	T575	T577		
T618		T619									
T625		T626									
HSSE V3								PM-HSSE V3	PM-HSS Co		
Brt		Blu		Brt	Blu		Blu	Brt			
N				Al	VA	VADH		NH	H		
≤ 2.5xØ				≤ 3xØ				≤ 2.5xØ	≤ 1.5xØ		
										VDI 3323	ISO
●		●		○	●	●				1	P
●		●		○	●	●				2	
○		●			○	○		●	○	3	
○		●			○	○		●	○	4	
		○						○	○	5	
●		●		○	●	●				6	
○		●			○	○		●	○	7	
		○						○	●	8	
									●	9	
○		●						○	○	10	
									●	11	
		○			○	○		○	○	12	
									○	13	
		○			●	●		○		14.1	M
		○			●	●		○		14.2	
		○			○	○		○	○	14.3	
○		○						○	○	15	K
○		○						○	○	16	
○		○						○	●	17	
○		○						○	○	18	
○		○						○	●	19	
○		○						○	○	20	
●				●						21	N
●				●						22	
○				○						23	
○				○						24	
									○	25	
○				○						26	
○									○	27	
				○						28	
										29	
										30	
										31	S
										32	
										33	
										34	
										35	
										36	
										37.1	
										37.2	
										37.3	
										37.4	
										37.5	
									○	38.1	H
										38.2	
										39.1	
								○	○	39.2	
										40	
										41	

suttontools

- For cold forming of threads in materials with good flow characteristics
- N-Suitable for material with >10% elongation
- NH-Suitable for materials with restricted ductility up to $2 \times d_1$
- P lead for through holes
- Depths up to approx. $3 \times d_1$

[illegible][illegible]

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

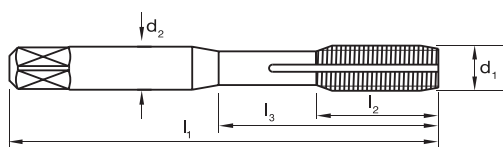
- Available on request as special manufacture. Subject to lead time.

* For style specifications refer to the Technical Information section at the back of this catalogue



Catalogue Code	T514	T629
Discount Group	D0614	D0614
Material	HSS Co.8	PM-HSSE V3
Surface Finish	<i>TiN</i>	<i>TiCN</i>
Sutton Designation	N	NH
Geometry	1 Coolant Groove M3+	1 Coolant Groove M3+
Lead	4 x P	4 x P

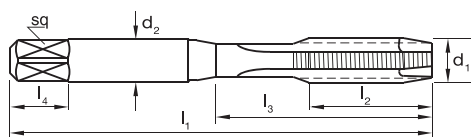
- For cold forming of threads in materials with good flow characteristics
- Suitable for material with >10% elongation
- B lead for blind holes
- Depths up to approx. $3 \times d$

[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																																														
T521	●	●	○	○			○					○		●	●								●	●		○		●	○	○																																																																	
P	Steel													M	Stainless Steel		K	Cast Iron					N	Non-Ferrous Metals										S	Titanium & Super Alloys										H	Hard Materials																																																	
																																													●	Optimal		○	Effective																																														

suttontools

- General purpose use
- Suitable for materials up to 1000 N/mm²
- Through holes
- Depths up to 3 x d₁



Catalogue Code	T499	T500
Discount Group	D0602	D0602
Material	HSSE V3	HSSE V3
Surface Finish	<i>Brt</i>	<i>Blu</i>
Sutton Designation	N	N
Geometry		
Lead	5 x P	5 x P

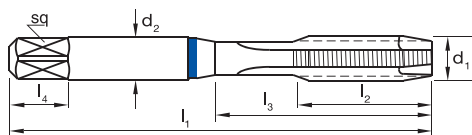
[illegible][illegible]

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

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

* For style specifications refer to the Technical Information section at the back of this catalogue.

- Use in stainless steels and high strength steels
- Suitable for materials up to 850 N/mm²
- Through holes
- Depths up to 3 x d₁



Size Ref.	d ₁	Pitch	Limit	Style*	l ₁	l ₂	l ₃	d ₂	sq	z	drill Ø	Item #
0100	M 1	x 0.25		1	30	7	-	3.0	2.5	2	0.75	•
0120	M 1.2	x 0.25		1	32	8	-	3.0	2.5	2	0.95	•
0140	M 1.4	x 0.3		1	34	9	-	3.0	2.5	2	1.1	•
0160	M 1.6	x 0.35		1	36	10	-	3.0	2.5	2	1.25	•
0200	M 2	x 0.4	P2	1	40	12	-	3.0	2.5	2	1.6	T548 0200
0300	M 3	x 0.5	P3	2	46	11	19	4.0	3.2	3	2.5	T548 0300
0400	M 4	x 0.7	P3	2	52	13	21	5.0	4.0	3	3.3	T548 0400
0500	M 5	x 0.8	P3	2	60	16	24	5.5	4.5	3	4.2	T548 0500
0600	M 6	x 1	P2	2	62	19	28	6.0	4.5	3	5.0	T548 0600
0800	M 8	x 1.25	P3	3	70	22		6.2	5.0	3	6.8	T548 0800
1000	M 10	x 1.5	P3	3	75	24		7.0	5.5	3	8.5	T548 1000
1200	M 12	x 1.75	P3	3	82	29		8.5	6.5	3	10.2	T548 1200
1400	M 14	x 2	P4	3	88	30		10.5	8.0	3	12.0	T548 1400
1600	M 16	x 2	P4	3	95	32		12.5	10.0	4	14.0	T548 1600
1800	M 18	x 2.5	P4	3	100	37		14.0	11.0	4	15.5	T548 1800
2000	M 20	x 2.5	P4	3	105	37		15.0	12.0	4	17.5	T548 2000

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
T548	●	●	●	○			●	○					○	●	●	○																																	

P Steel

M Stainless Steel

K Cast Iron

N Non-Ferrous Metals

S Titanium & Super Alloys

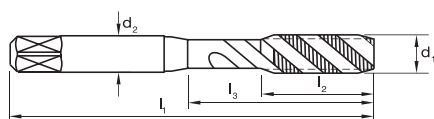
H Hard Materials

● Optimal

○ Effective

suttontools

- General purpose use
- Suitable for materials up to 1000 N/mm²
- Blind holes
- Depths up to 2.5 x d₁



Catalogue Code		
Discount Group	D0602	D0602
Material	HSSE V3	HSSE V3
Surface Finish	<i>Brt</i>	<i>Blu</i>
Sutton Designation	N	N
Geometry	R40	R40
Lead	2.5 x P	2.5 x P

Size Ref.	Lead											2.3 x P		2.5 x P	
	d ₁	Pitch	Limit	Style'	I ₁	I ₂	I ₃	d ₂	sq	z	drill Ø	Item #	Item #		
	With Point											T503	T504		
0100	M 1	x 0.25	P1	1	30	7	-	3.0	2.5	2	0.75	T503 0100	•		
0110	M 1.1	x 0.25	P1	1	32	8	-	3.0	2.5	2	0.85	T503 0110	•		
0120	M 1.2	x 0.25	P1	1	32	8	-	3.0	2.5	2	0.95	T503 0120	•		
0140	M 1.4	x 0.3	P1	1	34	9	-	3.0	2.5	2	1.1	T503 0140	•		
0160	M 1.6	x 0.35	P1	1	36	10	-	3.0	2.5	2	1.25	T503 0160	•		
0170	M 1.7	x 0.35	P1	1	36	11	-	3.0	2.5	2	1.35	T503 0170	•		
0180	M 1.8	x 0.35	P1	1	36	11	-	3.0	2.5	2	1.45	T503 0180	•		
0200	M 2	x 0.4	P2	1	40	12	15	3.0	2.5	2	1.60	T503 0200	T504 0200		
0220	M 2.2	x 0.45	P2	1	42	13	15	3.0	2.5	2	1.75	T503 0220	T504 0220		
0230	M 2.3	x 0.4	P2	1	42	13	15	3.0	2.5	2	1.9	T503 0230	T504 0230		
0250	M 2.5	x 0.45	P2	1	44	14	16	3.0	2.5	2	2.05	T503 0250	T504 0250		
0260	M 2.6	x 0.45	P2	1	44	14	16	3.0	2.5	2	2.15	T503 0260	T504 0260		
0300	M 3	x 0.5	P2	2	46	11	18	4.0	3.2	3	2.5	T503 0300	T504 0300		
0350	M 3.5	x 0.6	P1	2	48	13	20	4.0	3.2	3	2.9	T503 0350	T504 0350		
0400	M 4	x 0.7	P2	2	52	13	20	5.0	4.0	3	3.3	T503 0400	T504 0400		
0500	M 5	x 0.8	P2	2	60	16	25	5.5	4.5	3	4.2	T503 0500	T504 0500		
0600	M 6	x 1	P2	2	62	19	28	6.0	4.5	3	5.0	T503 0600	T504 0600		
	Without Point											T606	T607		
0700	M 7	x 1	P2	3	65	22	-	6.2	5.0	3	6.0	T606 0700	T607 0700		
0800	M 8	x 1.25	P2	3	70	22	-	6.2	5.0	3	6.8	T606 0800	T607 0800		
1006	MF 10	x 1.25	P2	3	75	24	-	7.0	5.5	3	8.5	T606 1006	T607 1006		
1000	M 10	x 1.5	P2	3	75	24	-	7.0	5.5	3	8.8	T606 1000	T607 1000		
1200	M 12	x 1.75	P2	3	82	29	-	8.5	6.5	3	10.2	T606 1200	T607 1200		
1400	M 14	x 2	P2	3	88	30	-	10.5	8.0	3	12.0	T606 1400	T607 1400		
1600	M 16	x 2	P2	3	95	32	-	12.5	10.0	4	14.0	T606 1600	T607 1600		
1800	M 18	x 2.5	P3	3	100	37	-	14.0	11.0	4	15.5	T606 1800	T607 1800		
2000	M 20	x 2.5	P3	3	105	37	-	15.0	12.0	4	17.5	T606 2000	T607 2000		
2200	M 22	x 2.5	P3	3	115	38	-	17.0	13.0	4	19.5	T606 2200	T607 2200		
2400	M 24	x 3	P3	3	120	45	-	19.0	15.0	4	21.0	T606 2400	T607 2400		

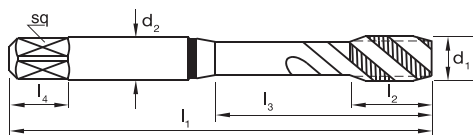
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P Steel **M** Stainless Steel **K** Cast Iron **N** Non-Ferrous Metals **S** Titanium & Super Alloys **H** Hard Materials

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

* For style specifications refer to the Technical Information section at the back of this catalogue.

- Suitable for use in wrought aluminium and low silicon aluminium
- Blind holes
- Depths up to $3 \times d_1$

[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
T609	○	○				○																	●	●	○	○		○		○																			

P Steel

M Stainless Steel

K Cast Iron

N Non-Ferrous Metals

S Titanium & Super Alloys

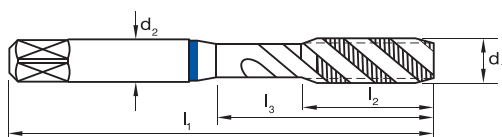
H Hard Materials

● Optimal

○ Effective

suttontools

- Standard thread length for better guidance properties
- Use in stainless steels and high strength steels up to 850N/mm²
- Blind holes
- Depths up to approx. 3 x d₁
- Can be used on conventional tapping machines



Catalogue Code	T690
Discount Group	D0602
Material	HSSE V3
Surface Finish	Blu
Sutton Designation	VA
Geometry	R45
Lead	2.5 x P

Size Ref.	d ₁	Pitch	Limit	Style*	l ₁	l ₂	l ₃	d ₂	sq	z	drill Ø	Item #
With Point												
0100	M 1	x 0.25	P1	1	30	7	-	3.0	2.5	2	0.75	•
0120	M 1.2	x 0.25	P1	1	32	8	-	3.0	2.5	2	0.95	•
0140	M 1.4	x 0.3	P1	1	34	9	-	3.0	2.5	2	1.1	•
0160	M 1.6	x 0.35	P1	1	36	10	-	3.0	2.5	2	1.25	•
0200	M 2	x 0.4	P2	1	40	12	16	3.0	2.5	2	1.60	•
0250	M 2.5	x 0.45	P2	1	44	14	16	3.0	2.5	2	2.05	•
0300	M 3	x 0.5	P2	2	46	11	19	4.0	3.2	3	2.5	T690 0300
0400	M 4	x 0.7	P2	2	52	13	21	5.0	4.0	3	3.3	T690 0400
0500	M 5	x 0.8	P2	2	60	16	24	5.5	4.5	3	4.2	T690 0500
0600	M 6	x 1	P2	2	62	19	28	6.0	4.5	3	5.0	T690 0600
Without Point												
0200	M 2	x 0.4	P2	4	40	12	16	3.0	2.5	2	1.60	•
0250	M 2.5	x 0.45	P2	4	44	14	16	3.0	2.5	2	2.05	•
0300	M 3	x 0.5	P2	5	46	11	19	4.0	3.2	3	2.5	•
0400	M 4	x 0.7	P2	5	52	13	21	5.0	4.0	3	3.3	•
0500	M 5	x 0.8	P2	5	60	16	24	5.5	4.5	3	4.2	•
0600	M 6	x 1	P2	5	62	19	28	6.0	4.5	3	5.0	•
0800	M 8	x 1.25	P2	3	70	22	-	6.2	5.0	3	6.8	T690 0800
1000	M 10	x 1.5	P2	3	75	24	-	7.0	5.5	3	8.8	T690 1000
1200	M 12	x 1.75	P2	3	82	29	-	8.5	6.5	3	10.2	•
1400	M 14	x 2	P2	3	88	30	-	10.5	8.0	3	12.0	•
1600	M 16	x 2	P2	3	95	32	-	12.5	10.0	4	14.0	•
1800	M 18	x 2.5	P3	3	100	37	-	14.0	11.0	4	15.5	•
2000	M 20	x 2.5	P3	3	105	37	-	15.0	12.0	4	17.5	•

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		
T690	●	●	●	○		●	○					○		●	●	○																																			
P	Steel			M	Stainless Steel			K	Cast Iron			N	Non-Ferrous Metals			S	Titanium & Super Alloys			H	Hard Materials													●	Optimal		○	Effective													

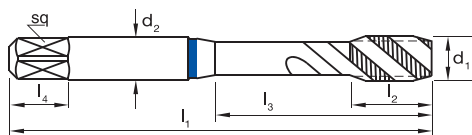
P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials

• Optimal ○ Effective

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

* For style specifications refer to the Technical Information section at the back of this catalogue.

- Use in stainless steels and high strength steels up to 850N/mm²
- VADH-Suitable for controlled tapping in deep holes
- Suitable for synchronous tapping in machine operations
- Blind holes
- Depths up to approx. $3 \times d_t$



Catalogue Code		
Discount Group		D0602
Material		HSSE V3
Surface Finish		<i>Blu</i>
Sutton Designation		VADH
Geometry		R45
Lead		2.5 x P



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
T570	●	●	●	○			●	○					○	●	●	○																																	

P Steel

M Stainless Steel

K Cast Iron

N Non-Ferrous Metals

S Titanium & Super Alloys

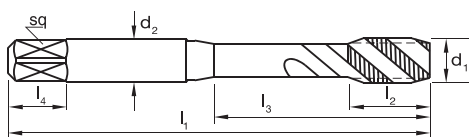
H Hard Materials

● Optimal

○ Effective

suttontools

- Suitable for harder short clipping materials up to 42 HRC
- Blind holes
- Depths up to 2.5 x d₁



Catalogue Code	T575
Discount Group	D0602
Material	PM-HSSE V3
Surface Finish	<i>Blu</i>
Colour Ring & Application	NH
Geometry	R40
Lead	2.5 x P

[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
T575				●	●	○		●	○		○		○	○	○	○	○	○	○	○	○	○																									○		

P Steel

M Stainless Steel

K Cast Iron

N Non-Ferrous Metals

S Titanium & Super Alloys

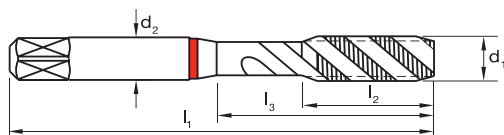
H Hard Materials

● Optimal

○ Effective

suttontools

-



Size Ref.	d ₁	Pitch	Limit	Style*	l ₁	l ₂	l ₃	d ₂	sq	z	drill Ø	Item #
0300	M 3	x 0.5	P3	2	46	11	19	4.0	3.2	3	2.5	T577 0300
0400	M 4	x 0.7	P3	2	52	13	21	5.0	4.0	3	3.3	T577 0400
0500	M 5	x 0.8	P3	2	60	16	24	5.5	4.5	3	4.2	T577 0500
0600	M 6	x 1	P2	2	62	19	28	6.0	4.5	3	5.0	T577 0600

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
T577																																																	

P Steel

M Stainless Steel

K Cast Iron

N Non-Ferrous Metals

S Titanium & Super Alloys

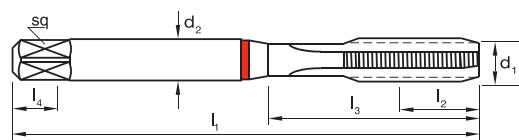
H Hard Materials

● Optimal

○ Effective

suttontools

- XH, use in hardened steels 42-52 HR_c
- VH, use in hardened steels 50-60 HR_c
- Through & blind holes
- Depths up to approx. 1.5 x d₁



Catalogue Code

Discount Group

Material

Surface Finish

Sutton Designation

Geometry

Lead

Size Ref.	d ₁	Pitch	Limit	Style*	l ₁	l ₂	l ₃	d ₂	sq	z	drill Ø
0300	M 3	x 0.5	6HX	2	46	11	19	3.5	2.7	4	2.55
0400	M 4	x 0.7	6HX	2	52	13	21	4.5	3.4	4	3.4
0500	M 5	x 0.8	6HX	2	60	16	24	6.0	4.9	4	4.3
0600	M 6	x 1	6HX	2	62	19	28	6.0	4.9	4	5.1
0800	M 8	x 1.25	6HX	3	70	22	-	6.0	4.9	5	6.9
1000	M 10	x 1.5	6HX	3	75	24	-	7.0	5.5	5	8.6
1200	M 12	x 1.75	6HX	3	82	29	-	9.0	7.0	5	10.3
1600	M 16	x 2	6HX	3	95	32	-	12.0	9.0	5	14.1
2000	M 20	x 2.5	6HX	3	105	37	-	16.0	12.0	5	17.7



T294	T295	T296	T297
D0610	D0610	D0414	D0414
SPM	SPM	VHM	VHM
TICN	TICN	TICN	TICN
XH	XH	VH	VH
Special Relief	Special Relief	Special Relief	Special Relief
3 x P	5 x P	Form C / 3 x P	Form D / 5 x P

Item #	Item #	Item #	Item #
T294 0300	T295 0300	T296 0300	T297 0300
T294 0400	T295 0400	T296 0400	T297 0400
T294 0500	T295 0500	T296 0500	T297 0500
T294 0600	T295 0600	T296 0600	T297 0600
T294 0800	T295 0800	T296 0800	T297 0800
T294 1000	T295 1000	T296 1000	T297 1000
T294 1200	T295 1200	T296 1200	T297 1200
T294 1600	T295 1600	•	T297 1600
T294 2000	T295 2000	•	T297 2000

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
T294					○		○		●	○	●	○	●					○		○		○								○														●					
T295					○		○		○	○	○	○	○					○		○		○								○														●					
T296					○		○		○	○	○	○	○					○		○		○								○														●	●		●		
T297					○		○		○	○	○	○	○					○		○		○								○														●	●	●	●		●

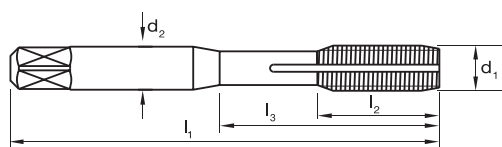
P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials

● Optimal ○ Effective

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

* For style specifications refer to the Technical Information section at the back of this catalogue.

- For cold forming of threads in materials with good flow characteristics
- Suitable for material with >10% elongation
- Through or blind holes
- Depths up to approx. $3 \times d$

[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
T526	●	●	●	○			○					○		●	●								●	●	○	○	●	○	○																				

P Steel

M Stainless Steel

K Cast Iron

N Non-Ferrous Metals

S Titanium & Super Alloys

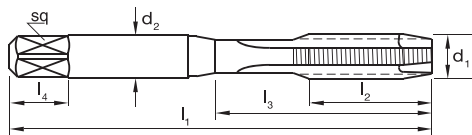
H Hard Materials

● Optimal

○ Effective

suttontools

- 



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	
T615	●	●	●	●	●	●	○				○						○		○	○	○	○	●	●	●	○		○	○																					
T616	●	●	●	●	○	○	○	○	○	○	○	○		○	○	○						○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

P Steel

M Stainless Steel

K Cast Iron

N Non-Ferrous Metals

S Titanium & Super Alloys

H Hard Materials

● Optimal

○ Effective

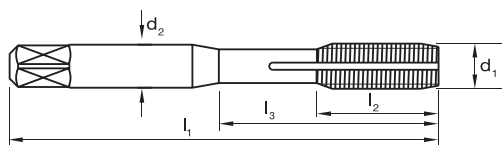
● Optimal ○ Effective



Catalogue Code	T615	T616
Discount Group	D0602	D0602
Material	HSSE V3	HSSE V3
Surface Finish	<i>Brt</i>	<i>Blu</i>
Sutton Designation	N	N
Geometry		
Lead	5 x P	5 x P

suttontools

- For cold forming of threads in materials with good flow characteristics
- Suitable for material with >10% elongation
- Through or blind holes
- Depths up to approx. $3 \times d$



Catalogue Code	D0614	
Discount Group		
Material		HSS Co.8
Surface Finish		TIN
Sutton Designation		N
Geometry	Multi Coolant Groove	
Lead	2P & 4P	

[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
T544	●	●	●	○		○						○		●	●								●	●	○	○		●	○	○																			

P

Steel

M

Stainless Steel

K

Cast Iron

N

Non-Ferrous Metals

S

Titanium & Super Alloys

H

Hard Materials

●

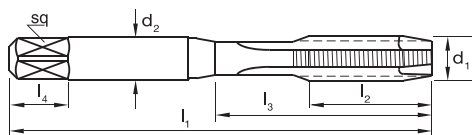
Optimal

○

Effective

suttontools

- 



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	
T621	●	●	●	○			●	○			○						○	○	○	○	○	○	●	●	○	○		○	○																					
T622	●	●	●	○			●	○			○						○	○	○	○	○	○	○	○	○	○																								

P Steel

M Stainless Steel

K Cast Iron

N Non-Ferrous Metals

S Titanium & Super Alloys

H Hard Materials

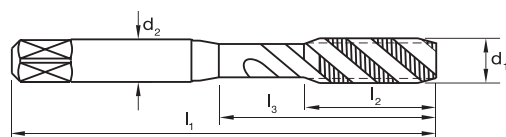
● Optimal

○ Effective



suttontools

- General purpose use, materials up to approx. 1000 N/mm²
- Blind holes
- Suitable for machine operations
- Depths up to approx. 2.5 x d.



Catalogue Code	T625	T626
Discount Group	D0602	D0602
Material	HSSE V3	HSSE V3
Surface Finish	<i>Brt</i>	<i>Blu</i>
Sutton Designation	N	N
Geometry	R40	R40
Lead	5 x P	5 x P

[illegible][illegible]

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

● Optimal ○ Effective

* For style specifications refer to the Technical Information section at the back of this catalogue.