

## Hand / Machine Taps Information

### Information sur les tarauds machine / manuels



## HISTORY

The FRENCH ENGINEERING WORKS (PTY) LIMITED was established in 1918 to manufacture rock drill spares for the mining industry.

The Swiss origin and technical background of the owner, Herman Moser, instilled a pride in quality and precision which persists to the present day.

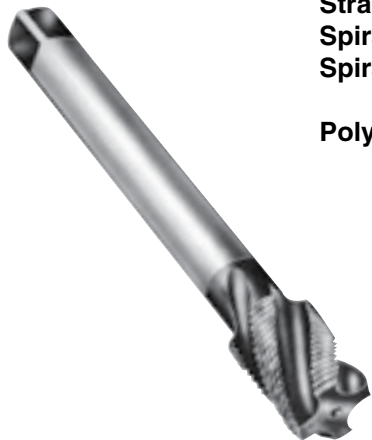
In 1940 taps and threading tools became part of the product range and by 1954, the company was specializing in the manufacture of these tools.

Over eighty years of tap manufacturing experience and development of extensive distribution networks have enabled customers in over 40 countries to benefit from a wide range of tools offered. Modern production facilities and ongoing product development, ensure that the reputation earned over three-quarters of a century will continue to grow.

## STOCK RANGE

\* FEW manufactures a comprehensive range of Threading Tools in various norms laid down by **ISO 529/2284**, **JIS B4430** and **DIN 371/376/374/5156**.

\* Taps are produced in various HIGH SPEED STEELS for both HAND and MACHINE tapping. FEW is one of the first companies in the world to manufacture taps from HSSE-V or M9V.



- Straight Flute** – Standard and Serial sets for Hand Tapping.
- Straight Flute** – Machine Taps for Through or Blind Holes.
- Spiral Point** – Machine Taps for Through Holes.
- Spiral Flute** – Machine Taps for Blind Holes, available in Slow Standard and Fast Helixes.
- Polygon** – A Fluteless Tap for rolling a Threadform in Ductile materials.



FEW also manufactures Long Shank Taps, Pipe Taps, Nut Taps, etc.

Taps in the FEW Standard Range are available in:

- Metric** – M (metric Course) MF (metric Fine).
- American** – UNC, UNF, NC, NF, UNEF, UNS.
- Whitworth** – BSW, BSF, BA, BSC, BSB.
- Pipe** – G (BSP Mechanical), Rp (BSP Leakproof), Rc (Pipe Conical), NPS, NPSF (Dryseal), NPT, NPTF (Dryseal), NGT, API.

## DISTRIBUTION NETWORK

FEW has set up a distribution network of stocking distributors in selected key areas around the world. These distributors carry a broad range of products and therefore ensure speedy service to all parts of the world.



products are distributed in Canada by **SPAENAU INC.**



# Hand / Machine Taps Information

## Information sur les tarauds machine / manuels

### HSS STANDARD STOCK RANGE

**STD. SET  
TYPE 0420**

Taper + Second + Bottom



The Standard Set generally comprises of taper, second and bottom taps which can also be ordered and used individually. These taps are used for all normal hand and machine tapping. Fine threads - 2 per set (taper + bottom) except where stated. Sets of 3 available by special request.

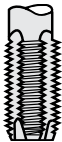
**SER. SET  
TYPE 0720**

No. 1 + No. 2 + Bottom



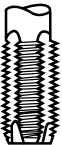
Serial Taps are also known as progressive taps and are recommended for precision hand tapping long through holes and blind holes in tough materials. Serial taps are sold only in sets, and are not suitable for machine use. Fine threads - 2 per set except where stated.

**STD. S.P.  
TYPE 1221**



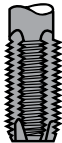
Spiral Point Taps are also known as Gun Nose and are used for machine tapping of deep and normal through holes. The black "steam temper" surface treatment facilitates the tapping of steels which are prone to cold welding.

**STD. B.F. S.P.  
TYPE 1220**



Bright finish, Spiral Point Taps have no surface treatment and are normally used for the tapping of through holes in non-ferrous materials.

**TiN S.P.  
TYPE 1223**



Titanium Nitride Spiral Point Taps are used for through holes in abrasive materials, or where higher tapping speeds and longer tool life are required.

**NI BOTT  
TYPE 0322**



These Bottom Taps have been nitrided for maximum abrasion resistance. They are mainly used in the tapping of short chipping cast iron and other abrasive materials.

**TiN BOT  
TYPE 0323**



Developed for use in production application where abrasive short chipping materials such as cast iron are being tapped. Higher tapping speeds reduce cycle times whilst abrasion resistance is increased, thus improving production rates.

**STD. S.F.  
TYPE 4221**



Spiral Flute Taps are used in blind holes where chip disposal becomes a problem. The black "steam temper" surface treatment facilitates the tapping of steels which are prone to cold welding.

**STD. B.F. S.F.  
TYPE 4220**



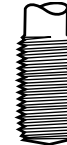
Bright finish, Spiral Flute Taps have no surface treatment and are normally used for the tapping of blind holes in non-ferrous metals.

**TiN S.F.  
TYPE 4223**



Titanium Nitride Spiral Flute Taps are used for blind holes in abrasive materials, or where higher tapping speeds and longer tool life are required.

**STD. P. POLYGON  
TYPE 6220**



These are Fluteless Taps which are primarily used for the chipless threading of through holes in aluminum, brass, copper and other ductile materials. Tapping drill size is very important.

**B + O/G POLYGON  
TYPE 7220**



These Polygon Taps have oil grooves to facilitate lubrication in the forming of threads in deep or blind holes in ductile materials.

**CLOSE  
FIT  
TAPS**

Generally available in straight flute, SP or SF form, these tools are used when tapping to tighter tolerances (e.g. **Metric** 4H UNIFIED 1B or WHITWORTH Close Fit). Because these taps have a reduced effective diameter, they may also be used where oversizing is a problem.

**FREE  
FIT  
TAPS**

Generally available in straight flute, SP or SF form, these taps are used when looser threads are required. (e.g. **Metric** 7H / 6G, UNIFIED 3B or WHITWORTH Free Fit.). Because these taps have a larger wear allowance, they are also occasionally used where maximum tool life is required in abrasive applications.

**L.H.  
TAPS**

Left Hand taps are stocked in most popular sizes and are sold in sets up to **12 mm** or 1/2". Larger diameters are available in single taps.

# Hand / Machine Taps Information

Information sur les tarauds machine / manuels

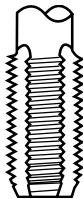


## SPECIAL GEOMETRY MACHINE TAPS

### STRAIGHT FLUTE MACHINE TAPS

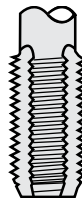
#### STR. FL. BRASS (Din Form C)

Straight Flute Tap with a modified rake angle and 15° lead suitable for threading short chipping brass.



#### STR. FL. NITRIDE (Din Form C)

Straight Flute Tap with modified rake angle 15° lead and nitrided surface treatment for cast iron and other abrasive short chipping materials.



#### STR. FL. TIN (Din Form C)

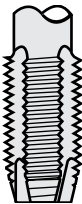
Straight Flute Tap with modified rake angle, 15° lead and TiN coating suitable for cast iron and other abrasive short chipping materials.



### SPIRAL POINT TAPS (DIN FORM B) - SPECIAL GEOMETRY

#### TYPE 1222 HR HR SP

The High Resistance Spiral Point has been designed with special geometry to cut threads in normal and deep through holes in high resistance steels of over 1000 N/mm<sup>2</sup>.



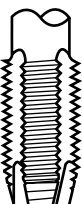
#### TYPE 1221 IN STAINLESS STEEL SP

The Stainless Steel Spiral Point Tap as been designed with special geometry to cut threads in normal and deep through holes in tough stainless steels and high alloyed tool steels which have a tendency to "close" after threading.



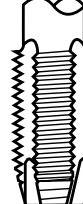
#### TYPE 1220 AL ALU SP

The Aluminum Spiral Point has been designed with special geometry and wide flutes for tapping through soft holes in ductile aluminums, light metals and plastics with long chips.



#### TYPE 1220 AS AL-SI SP

The geometry of this Spiral Point is suitable for threading through holes in tough aluminum alloys with silicon content greater than 10%, and non-ferrous metals which have a tendency to "close" after threading.



### SLOW SPIRAL FLUTE TAPS (~15°)

#### TYPE 3220 BF SF 15°

Bright Finish 15° Spiral Flute Taps are suitable for tapping blind holes in tougher non-ferrous materials with medium to long chips, or steels up to 1000 N/mm<sup>2</sup> where cold welding does not pose a problem.



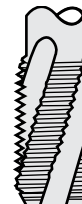
#### TYPE 5220 AS AL-SI SF

Steam Tempered 15° Spiral Flute Taps are suitable for tapping blind holes in tough steels up to 1000 N/mm<sup>2</sup> where cold welding occurs. Supplied as standard where surface treatment is not specified.



#### TYPE 3223 TIN SF 15°

Titanium Nitrided 15° Spiral Flute Taps are suitable for tapping blind holes in tough, abrasive materials where higher tapping speeds or longer tool life are required.



### FAST SPIRAL FLUTE TAPS (~40°) - SPECIAL GEOMETRY

#### TYPE 5220 AL ALU SF

The Aluminum Spiral Flute has high helix with special geometry and wide flutes adapted for tapping blind holes in soft ductile aluminums and plastics with long chips.



#### TYPE 5220 AS AL-SI SF

The special geometry of this High Helix Special Flute Tap is adapted for threading blind holes in tough aluminum alloys with silicon content greater than 10% and non-ferrous metals which have a tendency to "close" after threading.



#### TYPE 5222 HR HR SF

The High Resistance Spiral Flute Tap has high helix and special geometry adapted to cut threads in blind holes in high resistance steels of over 1000 N/mm<sup>2</sup>.



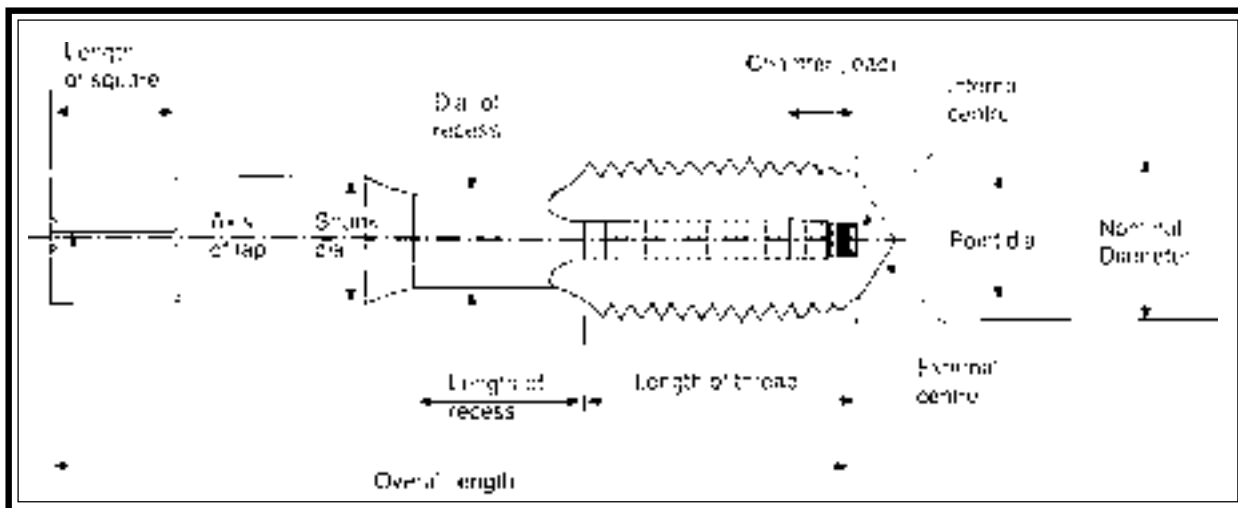
#### TYPE 5221 IN STAINLESS STEEL SF

The Stainless Steel Spiral Flute Tap has high helix and special geometry adapted to cut threads in blind holes in tough stainless steels and steels which have a tendency to "close" after threading.



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## Tap Terminology Terminologie de taraud



### SURFACE TREATMENT

When choosing lubricant and type of tap to suit a particular application, the life of the tap can be further prolonged by selecting the correct surface treatment.

#### 1. BRIGHT FINISH (BF) - SPAENAUR carries Bright Finish in stock.

This is a ground finish without any further surface treatment. Used mainly for non-ferrous metals or steels which do not cold weld.

#### 2. STEAM TEMPERED (ST)

This is an oxide treatment which is recognizable by its deep blue/black finish. This treatment produces tiny pitmarks on the surface of the tap, too small to be seen with the naked eye. These indentations help to capture and retain the lubricant, thus reducing torque and discouraging cold welding. Used in a wide variety of applications where build-up can cause problems, e.g. mild steel and all highly alloyed ferrous materials, including stainless steels. Machine taps are supplied with a Steam Tempered finish, unless an alternative is specified.

*The following taps are available upon request, price on application:*

#### 3. NITRIDED (NI)

This treatment hardens the surface of the tool and gives it a mottled grey/black finish. This extra skin hardness gives better tool life in the more abrasive shorter-chipping materials such as cast iron and certain types of bronze, high Si aluminum alloys and plastic. This treatment can cause brittleness and should be used with care.

#### 4. DOUBLE TREATMENT (DT)

This combination of Steam Tempering and Nitriding is used mainly for nut taps and taps for special application where the qualities of abrasion resistance and lubrication adherence are most beneficial.

#### 5. TITANIUM CARBIDE NITRIDE (TIN)

A Physical Vapour Deposition (PVD) process imparting a shiny golden finish to the tool surface. Features are high surface hardness (equivalent to RC80-85) with good abrasion resistance allowing for prolonged tool life. A low coefficient of friction results in reduced torque, temperature and cold welding, thus allowing for greater tool speeds.

#### 6. TITANIUM CARBIDE NITRIDE (TiCN)

Another PVD process imparting a harder surface than TIN. Suitable for abrasive applications and for high tensile materials.

Taps / Dies / Tap Sets

Inch

Tarauds / Filières / Jeux de tarauds

Pouce

**TAPS**

**HIGH SPEED STEEL  
GROUND THREAD  
Right Hand Threads**

**INCH Sizes  
U.N.C. (Coarse)  
and  
U.N.F. (Fine)**

TAPS ARE AVAILABLE SINGLE OR IN SETS:

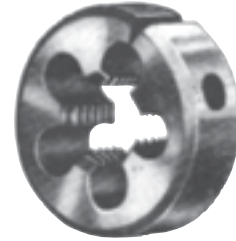
No. 1  
STARTING TAP



No. 2  
MIDDLE TAP



No. 3  
FINISHING TAP



**DIES**

**HIGH SPEED  
STEEL**

Dies split or solid, our option.

Note: Taps No. 1, No. 2, & No. 3 are commonly referred to as TAPER, PLUG, & BOTTOMING TAPS.

■Shown are ANSI 94.9 dimensions for Square End. May also be supplied to ISO 529 at our option.

**TAPS and TAP SETS**

(Dia.) SIZE	THREADS per inch		DRILL		#1	#2	#3	Set of 3	Tap	DIES	Die O.D.
	U.N.C.	U.N.F.	Size	Dec.	Starting Tap SPAENAUR No.	Middle Tap SPAENAUR No.	Finishing Tap SPAENAUR No.	Taps SPAENAUR No.	Square End A/F		
0		80	3/64	.047	874-100	874-200	874-300	874-400	.110	878-100	13/16"
1	64		#53	.060	874-101	874-201	874-301	874-401		878-101	
1		72	#53	.060	874-102	874-202	874-302	874-402		878-102	
2	56		#50	.070	874-103	874-203	874-303	874-403		878-103	
2		64	#50	.070	874-104	874-204	874-304	874-404		878-104	
3	48		#47	.079	874-105	874-205	874-305	874-405		878-105	
3		56	#46	.081	874-106	874-206	874-306	874-406		878-106	
4	40		#44	.086	874-107	874-207	874-307	874-407		878-107	
4		48	#43	.089	874-108	874-208	874-308	874-408		878-108	
4	36	(N.S.)			874-109	874-209	874-309	874-409		878-108	
5	40		#40	.098	874-110	874-210	874-310	874-410		878-110	
5		44	#38	.102	874-111	874-T18-1W	874-311	874-411		878-111	
6	32		#37	.104	874-112	874-212	874-312	874-412	878-112		
6		40	#34	.111	874-113	874-213	874-313	874-413	878-112		
8	32		#29	.136	874-114	874-214	874-314	874-414	.131	878-114	
8		36	#29	.136	874-115	874-215	874-315	874-415		878-115	
10	24		#25	.150	874-116	874-216	874-316	874-416	.152	878-116	
10		32	#21	.159	874-117	874-217	874-317	874-417		878-117	
12	24		#16	.177	874-T07-1M	874-218	874-318	874-T05-1K	.165	878-118	
12		28	#14	.182	874-119	874-219	874-319	874-419		878-119	
1/4"	20		#7	.201	874-120	874-220	874-320	874-420	.191	878-120	
1/4"		28	#3	.213	874-121	874-T13-1Y	874-321	874-421		878-121	
5/16"	18		F	.257	874-122	874-222	874-322	874-422	.238	878-K03-1T	
5/16"		24	I	.272	874-123	874-223	874-323	874-423		878-123	
3/8"	16		5/16	.313	874-T01-1Y	874-224	874-324	874-424	.286	878-K15-1T	
3/8"		24	Q	.332	874-125	874-225	874-325	874-425		878-125	
7/16"	14		23/64	.359	874-126	874-226	874-326	874-426	.242	878-126	
7/16"		20	25/64	.391	874-127	874-227	874-327	874-427		878-127	
1/2"	13		27/64	.422	874-128	874-228	874-328	874-428	.275	▲878-K09-2P	
1/2"		20	29/64	.453	874-129	874-229	874-329	874-429		878-K07-2X	
9/16"	12		31/64	.484	874-130	874-230	874-330	874-430	.322	878-130	
9/16"		18	1/2	.500	874-131	874-231	874-331	874-431		878-131	
5/8"	11		17/32	.531	874-132	874-232	874-332	874-432	.360	878-132	
5/8"		18	9/16	.563	874-133	874-233	874-333	874-433		878-K06-1M	
11/16"	11		19/32	.594	874-134	874-234	874-334	874-434	.406		
11/16"		16	5/8	.625	874-135	874-235	874-335	874-435			

Continued on next page...

PKG QTY. 1

PKG QTY. 1  
1 Set

PKG QTY. 1

See page P56 for LEFT HAND THREAD SIZES.  
For British Taps and Dies, see page B255

▲1-1/2" DIE O.D.

CATALOG 14

SPAENAUR

Inch

Taps / Dies / Tap Sets

Pouce

Tarauds / Filières / Jeux de tarauds

# TAPS

**HIGH SPEED STEEL  
GROUND THREAD**

**Right Hand Threads**

**INCH Sizes  
U.N.C. (Coarse)  
and  
U.N.F. (Fine)**

...continued from previous page.

TAPS ARE AVAILABLE SINGLE OR IN SETS:

No. 1  
STARTING TAP



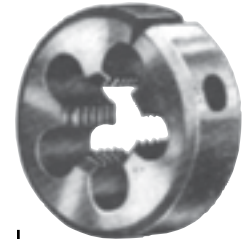
No. 2  
MIDDLE TAP



No. 3  
FINISHING TAP



Note: Taps No. 1, No. 2, & No. 3 are commonly referred to as TAPER, PLUG, & BOTTOMING TAPS.



# DIES

**HIGH SPEED  
STEEL**

Dies split or solid, our option.

## TAPS and TAP SETS

(Dia.) SIZE	THREADS per inch		DRILL		#1 Starting Tap SPAENAUR No.	#2 Middle Tap SPAENAUR No.	#3 Finishing Tap SPAENAUR No.	Set of 3 Taps SPAENAUR No.	Tap Square End A/F	DIES SPAENAUR No.	Die O.D.
	U.N.C.	U.N.F.	Size	Dec.							
3/4"	10		21/32	.656	874-136	874-236	874-336	874-436	.442	878-136	2"
3/4"		16	11/16	.688	874-137	874-237	874-337	874-437		878-137	
7/8"	9		49/64	.766	874-138	874-238	874-338	874-438	.523	878-138	
7/8"		14	13/16	.813	874-139	874-239	874-339	874-439		878-139	
1"	8		7/8	.875	874-140	874-240	874-340	874-440	.600	878-140	
1"		12	29/32	.906	874-141	874-241	874-341	874-441		878-141	
1"		14	15/16	.938	874-142	874-242	874-342	874-442		878-142	
1-1/16"		12	—	—	—	—	—	—	—	878-200	2-1/2"
1-1/8"	7		63/64	.984	874-143	874-243	874-343	874-443	.672		
1-1/8"		12	1-3/64	1.047	874-144	874-244	874-344	874-444			
1-1/4"	7		1-3/32	1.094	874-145	874-245	874-345	874-445	.766		
1-1/4"		12	1-11/64	1.172	874-146	874-246	874-346	874-446			
1-3/8"	6		1-13/64	1.203	874-147	874-247	874-347	874-447	.831		
1-3/8"		12	1-19/64	1.297	874-148	874-248	874-348	874-448			
1-1/2"	6		1-21/64	1.328	874-149	874-249	874-349	874-449	.925		
1-1/2"		12	1-27/64	1.422	874-150	874-250	874-350	874-450			
1-3/4"	5		1-35/64	1.547	874-151	874-251	874-351	874-451	1.072		
2"	4-1/2"		1-25/32	1.781	874-152	874-252	874-352	874-452	1.233		
								INDIVIDUAL PKG QTY. 1	SETS PKG QTY. 1	PKG QTY 1	



## Inch Size - High Speed TAP SETS (Right Hand)

Strong case protects cutting edges of taps and against dirt and corrosion. Keeps the taps together so they are there when you need them!

### U.N.C. - Coarse Thread

Spaenaur No. 874-480 8-32 to 1/2"-13

Spaenaur No. 874-T08-1X #6 to 1/2"

### U.N.F. - Fine Thread

Spaenaur No. 874-481 8-36 to 1/2"-20

Spaenaur No. 874-T09-1A #6 to 1/2"

### SETS - PKG QTY. 1

Spaenaur No. 874-480 & 874-481 have wooden cases. These sets contain Starting, Middle & Finishing Taps for each of 7 sizes in set.

Spaenaur No. 874-T08-1X & 874-T09-1A have metal cases. These sets contain Starting, Middle & Finishing Taps for each of 6 sizes in set.



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## MINIATURE TAPS

ASME B18.6.3



PKG QTY. 1

## PRECISION-GROUND TAPS High Speed Steel

Spaenaur No. 875-251 Size 00-90

Spaenaur No. 875-253 Size 000-120

See page B13 for Miniature  
Screw Sizes 00-90 and 000-120.

Taps / Dies

Inch and Metric

Tarauds / Filières

Pouce et Métrique

# SHORT HAND & MACHINE TAPS LEFT HAND THREADS

HIGH SPEED STEEL  
GROUND THREAD

INCH Sizes  
**U.N.C. (Coarse)**  
and  
**U.N.F. (Fine)**

No. 1  
STARTING TAP  
(Taper)



No. 2  
MIDDLE TAP  
(Plug)



No. 3  
FINISHING TAP  
(Bottoming)



**DIES**

HIGH SPEED  
STEEL

Dies split or solid,  
our option.

Taps are available singly or in sets of 2 or 3.

(Dia.) SIZE	THREADS per inch		DRILL		SPAENAUR No's					Tap Square End A/F(approx.)	DIES Left Hand Threads	
	U.N.C.	U.N.F.	Size or Number	Dec.	#1 Starting Tap (Taper)	#2 Middle Tap (Plug)	#3 Finishing Tap (Bottom)	Set of 2 (Taper and Bottoming)	Set of 3 Taps		SPAENAUR No.	Die O.D
1/4"	20		#7	.201"	-	-	-	-	874-1703	.197"	878-207	1"
1/4"		28	#3	.213"	-	874-1749	-	874-1713	-	.197"	878-202	1"
5/16"	18		F	.257"	-	-	-	-	874-1704	.248"	878-208	1"
5/16"		24	I	.272"	-	874-1750	874-1666	874-1714	-	.248"	878-201	1"
3/8"	16		5/16"	.313"	-	-	-	-	874-1705	.315"	878-209	1"
3/8"		24	Q	.332"	-	-	-	874-1715	-	.315"	878-K16-1K	1"
7/16"	14		23/64"	.359"	-	-	-	-	874-1706	.248"	-	-
7/16"		20	25/64"	.391"	-	-	-	874-1716	-	.248"	-	-
1/2"	13		27/64"	.422"	-	-	-	-	874-1707	.280"	878-210	1-1/2"
1/2"		20	29/64"	.453"	-	-	-	874-1717	-	.280"	878-204	1-1/2"
9/16"	12		31/64"	.484"	874-1723	874-1724	874-1725	-	874-1708	.354"	-	-
9/16"		18	1/2"	.500"	-	874-1738	874-1739	874-1718	-	.354"	-	-
5/8"	11		17/32"	.531"	874-1726	874-1727	874-1728	-	874-1709	.394"	878-211	1-1/2"
5/8"		18	9/16"	.563"	-	874-1740	874-1741	874-1719	-	.394"	878-205	1-1/2"
3/4"	10		21/32"	.656"	874-1729	874-1730	874-1731	-	874-1710	.441"	878-212	2"
3/4"		16	11/16"	.688"	-	874-1742	874-1743	874-1720	-	.441"	878-206	2"
7/8"	9		49/64"	.766"	874-1732	874-1733	874-1734	-	874-1711	.492"	-	-
7/8"		14	13/16"	.813"	-	874-1744	874-1745	874-1721	-	.492"	-	-
1"	8		7/8"	.875"	874-1735	874-1736	874-1737	-	874-1712	.551"	-	-
1"		12	29/32"	.906"	-	874-1746	874-1747	874-1722	-	.551"	-	-
					PKG QTY. 1 Only			PKG QTY. 1 Set		PKG QTY. 1		

## SHORT MACHINE TAPS - Spiral Point

High Speed Steel - Steam Tempered

U.N.C. (Coarse) and U.N.F. (Fine) INCH THREADS

RIGHT HAND THREADS

(All other dimensions in millimetres.)



(Dia.) SIZE Inch	U.N.C. Coarse		U.N.F. Fine		Normal Dia. mm	Shank Dia. mm	Thread Lgth. (max.) mm	Overall Length mm	Square A/F mm
	Threads Per Inch	SPAENAUR No.	Threads Per Inch	SPAENAUR No.					
4	40	874-465	-	-	2.845	3.15	11	48	2.5
5	40	874-466	-	-	3.175	3.15	11	48	2.5
6	32	874-467	40	874-474	3.505	3.55	13	50	2.8
8	32	874-468	36	874-475	4.166	4.5	13	53	3.55
10	24	874-469	32	874-476	4.826	5.0	16	58	4.0
12	24	874-470	28	874-477	5.486	5.6	17	62	4.5
1/4"	20	874-471	28	874-478	6.350	6.3	19	66	5.0
5/16"	18	874-472	24	874-479	7.938	8.0	22	72	6.3
3/8"	16	874-473	24	874-482	9.525	10.0	24	80	8.0

All Taps - PKG QTY. 1

Inch and **Metric**

## Die Stocks / Tap Wrench Holder / Tap / Threading Tool Kits

Pouce et **Métrique**

Porte-filières / Manches de clés à tarauder / Taraud / Kits d'outils de filetage

### DIE STOCKS FOR ROUND SPLIT DIES

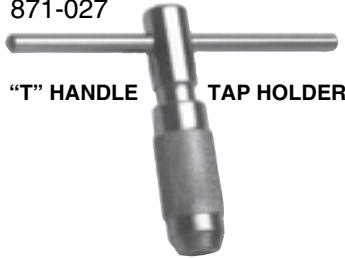
Will fit **Metric** and Inch Dies  
as featured on pages P54 - P56 & P66



PKG QTY. 1

SPAENAUR No.	Approx. LENGTH		O.D. OF DIES
	Inch	mm	
877-022	7-1/8"	180 mm	13/16"
877-023	8-1/2"	216 mm	1"
877-024	10"	254 mm	1-5/16"
877-C11-1Y	12-1/4"	311 mm	1-1/2"
877-026	20"	508 mm	2"

871-027



"T" HANDLE TAP HOLDER

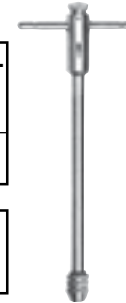
PKG QTY. 1

### T-TYPE TAP WRENCHES

SPAENAUR No.	Approx. LENGTH		For Thread Dia. CAPACITY (IN INCHES)
	Inch	mm	
877-027	2-3/4"	70 mm	1/8" - 1/4"

877-C14-1T	10"	250 mm	1/8" - 1/4"
877-065	11-3/4"	300 mm	7/32" - 1/2"

877-C14-1T  
877-065



Polished chrome and black finish.

#### LONG SHANK RATCHET "T" HANDLE TAP HOLDER

With 2-jaw knurled chuck & slip handle.

Long shank permits tapping in difficult places often encountered in machine repair work.

### STRAIGHT TAP WRENCHES



SPAENAUR No.	RANGE CAPACITY		
	Inch	Metric	Pipe
877-027	1/16" - 1/4"	M1 - M8	—
877-C20-1X	5/32" - 1/2"	M4 - M12	1/8" - 1/4"
877-C21-1A	1/4" - 3/4"	M6 - M20	1/8" - 3/8"
877-C22-1P	7/16" - 1"	M11 - M27	1/8" - 1/2"
877-C23-1Y	3/4" - 1-1/2"	M18 - M42	3/8" - 1-1/4"
877-C24-1C	1" - 2-1/8"	M25 - M50	3/4" - 2"
877-C25-1N	1-1/4" - 2-1/2"	M32 - M63	1" - 2-1/2"

PKG QTY. 1

### INCH and **METRIC** THREADING TOOL KITS

High Speed Steel supplied in strong wooden cases.

Each set contains: 1 set of 2 taps per size (taper and bottom) and 1 corresponding die and appropriate tap wrench

SPAENAUR No.	Thread Form	Size	Tap Wrenches	Die Stocks
878-193	UNC	1/4, 5/16, 3/8, 7/16, 1/2"	No. 2	1", 1-5/16"
878-194	UNF	1/4, 5/16, 3/8, 7/16, 1/2"	No. 2	1", 1-5/16"
878-K14-1N	UNC	1/4, 5/16, 3/8, 7/16, 1/2, 5/8, 3/4"	No. 2, 3	1", 1-5/16", 2"
878-196	UNF	1/4, 5/16, 3/8, 7/16, 1/2, 5/8, 3/4"	No. 2, 3	1", 1-5/16", 2"
878-197	UNC	1/4, 5/16, 3/8, 7/16, 1/2, 5/8, 9/16, 3/4, 7/8, 1"	No. 2, 4	1-1/2", 2"
878-198	UNF	1/4, 5/16, 3/8, 7/16, 1/2, 5/8, 3/4, 7/8, 1"	No. 2, 4	1", 1-5/16", 2"
878-672	MM Coarse	M2, M2.5, M3, M3.5, M4, M5, M6	No. 1	13/16"
878-673	MM Coarse	M6, M7, M8, M9, M10, M11, M12	No. 2	1", 1-5/16"
878-674	MM Coarse	M6, M8, M10, M12, M14, M16, M18, M20, M22, M24	No. 2, 4	1", 1-5/16", 2"



PKG QTY. 1



**Dies / Rethreading Die Sets**

Inch and Metric

Filières / Jeux d'écrous-filières

Pouce et Métrique

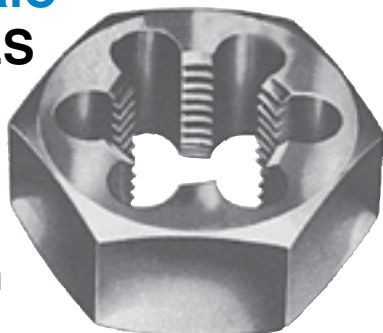
**METRIC SIZES**

**HIGH SPEED STEEL ISO METRIC HEXAGON RETHREADING DIES STANDARD PITCH - RIGHT HAND**

FOR REPAIRING DAMAGED OR RUSTY THREADS

Metric COARSE Thread

PKG QTY. 1



SPAENAUR No.	METRIC SIZE and PITCH	SPAENAUR No.	METRIC SIZE and PITCH
878-640	M6 x 1.0	878-647	M14 x 2.0
878-641	M7 x 1.0	878-648	M16 x 2.0
878-642	M8 x 1.25	878-649	M18 x 2.5
878-643	M9 x 1.25	878-650	M20 x 2.5
878-K12-1Y	M10 x 1.5	878-651	M22 x 2.5
878-645	M11 x 1.5	878-652	M24 x 3.0
878-646	M12 x 1.75		

**High Speed Steel - HEXAGON RETHREADING DIES U.N.C. or U.N.F. - Right Hand**

**INCH SIZES**



FOR REPAIRING DAMAGED OR RUSTY THREADS

PKG QTY. 1

U.N.C. COARSE		U.N.F. FINE	
SPAENAUR No.	SIZE	SPAENAUR No.	SIZE
878-160	1/4"-20	878-175	1/4"-28
878-161	5/16"-18	878-176	5/16"-24
878-162	3/8"-16	878-177	3/8"-24
878-163	7/16"-14	878-178	7/16"-20
878-164	1/2"-13	878-179	1/2"-20
878-165	9/16"-12	878-180	9/16"-18
878-166	5/8"-11	878-181	5/8"-18
878-167	11/16"-11(NS)	878-182	11/16"-16(NS)
878-168	3/4"-10	878-183	3/4"-16
878-169	7/8"-9	878-184	7/8"-14
878-170	1"-8	878-185	1"-12
878-172	1-1/4"-7	878-190	1"-14(NS)
878-174	1-1/2"-6	878-K08-1A	1-1/8"-12
878-199	2"-4-1/2	878-187	1-1/4"-12
		878-188	1-3/8"-12
		878-189	1-1/2"-12

**Inch and Metric HEXAGON RETHREADING DIES in wooden cased sets**

High Speed Steel Rethreading Dies



SPAENAUR No. <b>878-671</b>	SPAENAUR No. <b>878-191</b>	SPAENAUR No. <b>878-192</b>
Metric Coarse Thread 10 Dies	Inch - U.N.C. Coarse Thread 10 Dies	Inch - U.N.F. Fine Thread 11 Dies
M6 x 1 mm	1/4"-20	1/4"-28
M8 x 1.25 mm	5/16"-18	5/16"-24
M10 x 1.5 mm	3/8"-16	3/8"-24
M12 x 1.75 mm	7/16"-14	7/16"-20
M14 x 2 mm	1/2"-13	1/2"-20
M16 x 2 mm	9/16"-12	9/16"-18
M18 x 2.5 mm	5/8"-11	5/8"-18
M20 x 2.5 mm	3/4"-10	3/4"-16
M22 x 2.5 mm	7/8"-9	7/8"-14
M24 x 3 mm	1"-8	1"-12
		1"-14NS

PKG QTY. 1

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# STRAIGHT FLUTE METRIC TAPS

Straight Flute Taps are available single or in sets.

**ISO 529**

**METRIC COARSE THREAD  
RIGHT HAND  
HIGH SPEED STEEL  
GROUND THREAD**



No. 1 STARTING TAP

No. 2 MIDDLE TAP

No. 3 FINISHING TAP



Spiral Flute



Spiral Point

Note: Taps No. 1, No. 2 & No. 3 are commonly referred to as TAPER, PLUG & BOTTOMING TAPS.

Nominal DIA. mm	PITCH mm	Tap Square End A/F mm	Recommended DRILL mm	#1 Starting Tap SPAENAUR No.	#2 Middle Tap SPAENAUR No.	#3 Finishing Tap SPAENAUR No.	Set of 3 Taps SPAENAUR No.	Spiral Point SPAENAUR No.	Spiral Flute SPAENAUR No.
M1	0.25	2	0.75	874-1193	874-1207	874-1220	874-1179	—	—
M1.1	0.25	2	0.85	—	—	874-1221	874-1180	—	—
M1.2	0.25	2	0.95	874-1195	874-1209	874-1222	874-1181	—	—
M1.4	0.3	2	1.1	874-1196	874-1210	874-1223	874-1182	—	—
M1.5	0.35	2	1.1	874-1233	874-1243	874-1241	874-1177	—	—
M1.6	0.35	2	1.25	874-600	874-700	874-800	874-900	—	—
M1.7	0.35	2	1.35	874-601	874-701	874-801	874-901	—	—
M1.8	0.35	2	1.45	—	874-1211	—	—	—	—
M2	0.4	2	1.6	874-602	874-702	874-802	874-902	874-T17-1K	—
M2.2	0.45	2.24	1.75	874-1198	874-1212	874-1225	874-1184	—	—
M2.3	0.4	2.24	1.9	874-603	874-703	874-803	874-903	—	—
M2.5	0.45	2.24	2.05	874-T15-1N	874-704	874-804	874-T03-1N	874-1486	—
M2.6	0.45	2.24	2.15	874-605	874-705	874-805	874-905	—	—
M3	0.5	2.5	2.5	874-T22-1X	874-706	874-806	874-T04-1T	874-1487	874-1507
M3.5	0.6	2.8	2.9	874-607	874-707	874-807	874-907	874-1488	—
M4	0.7	3.15	3.3	874-608	874-708	874-808	874-908	874-1489	874-1508
M4	0.75	3.15	3.25	—	874-1247	—	—	—	—
M4.5	0.75	3.55	3.75	874-609	874-709	874-809	874-909	874-1490	—
M5	0.8	4	4.2	874-610	874-710	874-810	874-910	874-1491	874-1509
M5.5	0.9	4.5	4.6	—	—	874-1246	874-1178	—	—
M6	1.0	5	5	874-611	874-711	874-811	874-911	874-1492	874-1510
M6.3	1.0	—	5.3	874-612	874-712	874-812	874-912	—	—
M7	1.0	5.6	6	874-613	874-T10-1X	874-813	874-913	874-1493	—
M8	1.25	6.3	6.75	874-614	874-T24-1P	874-814	874-914	874-1494	874-1511
M9	1.25	7.1	7.75	874-615	874-715	874-815	874-915	—	—
M10	1.5	8	8.5	874-616	874-716	874-816	874-916	874-1495	874-1512
M11	1.5	6.3	9.5	874-1199	874-1213	874-1226	874-1185	—	—
M12	1.75	7.1	10.2	874-617	874-T20-1W	874-817	874-917	874-1496	874-1513
M14	2.0	9	12	874-618	874-718	874-T23-1A	874-918	874-1497	874-1514
M16	2.0	10	14	874-619	874-719	874-819	874-919	874-1498	874-1515
M18	2.5	11.2	15.5	874-620	874-720	874-820	874-920	874-1499	874-1516
M20	2.5	11.2	17.5	874-621	874-721	874-821	874-921	874-1500	874-1517
M22	2.5	12.5	19.5	874-622	874-722	874-822	874-922	874-1501	874-1518
M24	3.0	14	21	874-623	874-723	874-823	874-923	874-1502	874-1519
M27	3.0	16	24	874-624	874-724	874-824	874-924	874-1503	—
M30	3.5	16	26.5	874-625	874-725	874-825	874-925	874-1504	874-1520
M33	3.5	18	29.5	874-1200	874-1214	874-1227	874-1187	874-1505	—
M36	4.0	20	32	874-626	874-726	874-826	874-926	874-1506	—
M39	4.0	22.4	35	874-1201	874-1215	874-1228	874-1188	—	—
M42	4.5	22.4	37.5	874-1203	874-1216	874-1229	874-1189	—	—
M45	4.5	25	40.5	874-1204	874-1217	874-1230	874-1190	—	—
M48	5.0	25	43	874-1205	874-1218	874-1231	874-1191	—	—
M52	5.0	28	47	874-1206	874-1219	874-1232	874-1192	—	—
M64	6	31.5	58	—	874-1240	—	—	—	—

All Taps - PKG QTY. 1

**STRAIGHT FLUTE  
METRIC TAPS**

**ISO 529**

**METRIC FINE THREAD  
RIGHT HAND  
HIGH SPEED STEEL  
GROUND THREAD**

Straight Flute Taps are available single or in sets.



No. 1 STARTING TAP

No. 2 MIDDLE TAP

No. 3 FINISHING TAP



Spiral Point

Note: Taps No. 1, No. 2 & No. 3 are commonly referred to as TAPER, PLUG & BOTTOMING TAPS.

Nominal DIA. mm	PITCH mm	Tap Square End A/F mm	Recommended DRILL mm	#1 Starting Tap SPAENAUR No.	#2 Middle Tap SPAENAUR No.	#3 Finishing Tap SPAENAUR No.	Set of 2 Taps SPAENAUR No.	Spiral Point SPAENAUR No.
M2	0.25	2	1.75	874-1300	—	874-1256	874-518	—
M2.2	0.25	2.24	1.95	—	—	—	874-500	—
M2.5	0.35	2.24	2.15	874-1301	—	874-1257	874-951	—
M3	0.35	2.5	2.65	874-1302	—	874-1258	874-952	—
M3.5	0.35	2.8	3.15	—	—	874-1259	874-501	—
M4	0.5	3.15	3.5	874-1303	—	874-1260	874-953	—
M5	0.5	4	4.5	874-1304	—	874-1261	874-954	—
M5	0.75	4	4.25	874-1645	874-1248	874-1262	874-503	874-1521
M6	0.5	5	5.5	874-1305	—	874-1263	874-1141	—
M6	0.75	5	5.25	874-1306	—	874-1264	874-1142	874-1523
M7	0.75	5.6	6.25	874-1661	874-1662	874-1663	874-504	—
M8	0.75	6.3	7.25	874-1307	874-1249	874-1265	874-1143	—
M8	1.0	6.3	7	874-1308	874-1242	874-1266	874-1144	874-1524
M9	1.0	7.1	8	—	—	—	874-505	—
M10	0.75	8	9.25	874-1309	—	874-1267	874-1145	—
M10	1.0	8	9	874-1310	—	874-1268	874-1146	874-1525
M10	1.25	8	8.75	874-1311	—	874-1269	874-1147	874-1526
M11	1.0	6.30	10	874-1659	—	874-1270	874-506	—
M11	1.25	6.30	9.75	874-1312	—	874-1271	874-1148	—
M12	1.0	7.1	11	874-1313	—	874-1272	874-1149	—
M12	1.25	7.1	10.75	874-1314	874-1250	874-T19-1M	874-1150	874-1650
M12	1.5	7.1	10.5	874-T14-1C	—	874-1274	874-1151	874-1527
M14	1.0	9	13	—	874-1251	874-1275	874-507	—
M14	1.25	1.25	12.75	874-1316	874-1252	874-1276	874-1153	874-1528
M14	1.5	9	12.5	874-1317	—	874-1277	874-1154	874-1529
M16	1.0	10	15	874-1318	874-1253	874-1278	874-1155	—
M16	1.5	10	14.5	874-1319	—	874-T21-1M	874-1156	874-1530
M18	1.0	11.2	17.0	874-1667	—	—	—	—
M18	1.25	11.2	16.75	874-1320	—	—	874-509	—
M18	1.5	11.2	16.50	874-1321	—	874-1280	874-1157	874-1531
M18	2.0	11.2	16	874-1322	—	874-1281	874-1158	—
M20	1.0	11.2	19	874-1323	—	874-1282	874-1159	—
M20	1.5	11.2	18.5	874-1324	—	874-T11-1A	874-1160	874-1532
M20	2.0	11.2	18	874-1325	—	874-1284	874-1161	—
M22	1.5	12.5	20.5	874-1326	874-1660	874-1285	874-1162	—
M22	2.0	12.2	20	874-1327	—	874-1286	874-1163	—
M24	1.5	14	22.5	874-1328	—	874-1287	874-1164	874-554
M24	2.0	14	22	874-1329	—	874-1288	874-1165	—
M26	1.5	14.5	24.5	874-008	874-009	—	—	—
M27	1.5	16	25.5	874-1330	—	874-1289	874-1166	—
M27	2.0	16	25	874-1331	—	874-1290	874-1167	—
M28	1.5	16	26.5	874-1332	—	874-1291	874-1168	—
M30	1.5	16	28.5	874-1333	—	874-1292	874-1169	—
M30	2.0	16	28	874-1334	874-T16-1T	874-1293	874-1170	—
M30	3.0	16	27	874-1335	—	874-1294	874-1171	—
M32	1.5	16	30.5	—	874-535	—	874-516	—
M33	1.5	18	31.5	874-1336	874-1254	874-1295	874-1172	—
M33	2.0	18	31	874-1337	—	874-1296	874-1173	—
M34	1.5	18	32.5	874-1640	—	874-1641	—	—
M36	1.5	20	34.5	874-1338	—	874-1297	874-1174	—
M36	2.0	20	34	874-1339	—	874-1298	874-1175	—
M36	3.0	20	33	874-1340	874-1152	874-1299	874-1176	—
M38	1.5	22.4	36.5	—	874-1255	—	—	—

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CATALOG 14

SPAENAUR

**STRAIGHT FLUTE  
METRIC TAPS**

**ISO 529**

**METRIC COARSE THREAD  
LEFT HAND  
HIGH SPEED STEEL  
GROUND THREAD**

Straight Flute Taps are available single or in sets.



No. 1 STARTING TAP

No. 2 MIDDLE TAP

No. 3 FINISHING TAP

Note: Taps No. 1, No. 2 & No. 3 are commonly referred to as TAPER, PLUG & BOTTOMING TAPS.

**All Taps - PKG QTY. 1**

Nominal DIA. mm	PITCH mm	Tap Square End A/F mm	Recommended DRILL mm	#1 Starting Tap SPAENAUR No.	#2 Middle Tap SPAENAUR No.	#3 Finishing Tap SPAENAUR No.	Set of 3 Taps SPAENAUR No.
M3	0.5	2.5	2.5	874-1341	874-1353	874-1363	874-1388
M4	0.7	3.15	3.3	874-1342	874-1354	874-1364	874-1389
M5	0.8	4	4.2	874-1343	874-1355	874-1365	874-1390
M6	1.0	5	5	874-1344	874-1356	874-1366	874-1391
M8	1.25	6.3	6.75	874-1345	874-1357	874-1367	874-1392
M10	1.5	8	8.5	874-1346	874-1358	874-1368	874-1393
M12	1.75	7.1	10.2	874-1347	874-1359	874-1369	874-1394
M14	2.0	9	12	874-1348	—	874-1370	—
M16	2.0	10	14	874-1349	874-1360	874-1371	874-1395
M18	2.5	11.2	15.5	874-1350	—	—	—
M20	2.5	11.2	17.5	874-1351	874-1361	874-1372	874-1396
M24	3.0	14	21	874-1352	874-1362	874-1373	874-1397

**LEFT HAND METRIC FINE THREAD**

Nominal DIA. mm	PITCH mm	Tap Square End A/F mm	Recommended DRILL mm	#1 Starting Tap SPAENAUR No.	#2 Middle Tap SPAENAUR No.	#3 Finishing Tap SPAENAUR No.	Set of 2 Taps SPAENAUR No.
M8	1.0	6.3	7	—	—	874-1625	874-1376
M10	1.0	8	9	—	—	874-1382	—
M12	1.0	7.1	11	874-1652	874-1653	—	—
M12	1.5	7.1	10.5	—	—	874-1383	874-1378
M14	1.5	9	12.5	—	—	874-1374	—
M16	1.5	10	14.5	—	—	874-1384	874-1379
M20	1.5	11.2	18.5	—	—	874-1385	874-1380
M24	1.5	14	22.5	—	874-1387	874-1386	874-1381



## METRIC SPIRAL POINT, LONG REDUCED SHANK MACHINE TAPS

### DIN 376

**METRIC COARSE THREAD**  
**RIGHT HAND**  
**HIGH SPEED STEEL**  
**GROUND THREAD**



Spiral Point

Nominal DIA. mm	PITCH mm	Approx. Overall Lgth. mm	Thread Length (Max.) mm	Tap Square End A/F mm	Recom. DRILL mm	Spiral Point SPAENAUR No.
M3.5	0.6	56	13	2.1	2.9	874-1573
M4	0.7	63	13	2.1	3.3	874-1574
M5	0.8	70	16	2.7	4.2	874-1575
M6	1.0	80	19	3.4	5	874-1576
M7	1.0	80	19	4.3	6	874-1577
M8	1.25	90	22	4.9	6.75	874-1578
M10	1.5	100	24	5.5	8.5	874-1580
M12	1.75	110	29	7	10.2	874-1582
M14	2.0	110	30	9	12	874-1583
M16	2.0	110	32	9	14	874-1584
M18	2.5	125	37	11	15.5	874-1585
M20	2.5	140	37	12	17.5	874-1586
M22	2.5	140	38	14.5	19.5	874-1587
M24	3.0	160	45	14.5	21	874-1588

## METRIC SPIRAL POINT, LONG REDUCED SHANK MACHINE TAPS

### DIN 374

**METRIC FINE THREAD**  
**RIGHT HAND**  
**HIGH SPEED STEEL**  
**GROUND THREAD**



Spiral Point



Spiral Flute

Nominal DIA. mm	PITCH mm	Approx. Overall Lgth. mm	Thread Length (Max.) mm	Tap Square End A/F mm	Recom. DRILL mm	Spiral Point SPAENAUR No.	Spiral Flute SPAENAUR No.
M6	0.75	80	14	3.4	5.25	—	874-1549
M8	1.0	90	22	4.9	7	874-1565	874-1550
M10	1.0	90	20	5.5	9	874-1566	874-1551
M10	1.25	100	24	5.5	8.75	874-1567	874-1552
M12	1.25	100	22	7	10.75	—	874-1553
M12	1.5	100	22	7	10.5	874-1568	874-1554
M14	1.25	100	22	9	12.75	—	874-1555
M14	1.5	100	22	9	12.5	874-1569	874-1556
M16	1.5	100	22	9	14.5	874-1570	874-1557
M20	1.5	125	25	12	18.5	874-1571	874-1558
M24	1.5	140	28	14.5	22.5	—	874-1559

P

**PARALLEL THREAD PIPE TAP, 55° THREAD ANGLE  
BSP MECHANICAL JOINT TYPE G - RIGHT HAND  
STRAIGHT FLUTE FINISHING TAPS  
HIGH SPEED STEEL  
GROUND THREAD**



Dies split or solid, our option.

#3 Finishing Taps SPAENAUR No.	SIZE Inch	PITCH TPI	Tap Square End A/F (mm)	Recommended Drill (mm)	*ROUND DIES SPAENAUR No.	Die O.D. (mm)	Thick- ness (mm)
874-1457	G 1/8	28	6.3	8.8	878-924	30	11
874-1458	G 1/4	19	8	11.8	878-925	38	10
874-T12-1P	G 3/8	19	10	15.25	878-926	45	14
874-1460	G 1/2	14	12.5	19	878-927	45	14
874-1461	G 5/8	14	14	21	878-928	55	16
874-1462	G 3/4	14	16	24.5	878-929	55	16
874-1463	G 7/8	14	18	28.25	878-930	65	18
874-1464	G 1	11	20	30.50	878-931	65	18

\*These dies are suitable for BSP Type G and Type RP threads.

PKG QTY. 1

**PARALLEL THREAD PIPE TAP, 55° THREAD ANGLE  
BSP LEAK PROOF JOINT TYPE RP - RIGHT HAND  
STRAIGHT FLUTE FINISHING TAPS  
HIGH SPEED STEEL  
GROUND THREAD**

#3 Finishing Taps SPAENAUR No.	SIZE Inch	PITCH TPI	Tap Square End A/F (mm)	Recommended DRILL (mm)
874-1465	RP 1/8	28	6.3	8.6
874-1466	RP 1/4	19	8	11.5
874-1467	RP 3/8	19	10	15
874-1468	RP 1/2	14	12.5	18.5
874-1469	RP 3/4	14	16	24
874-1470	RP 1	11	20	30.50

For dies see above.

PKG QTY. 1

Taps / Dies

Inch and Metric

Tarauds / Filières

Pouce et Métrique

**CONICAL THREAD PIPE TAP, 55° THREAD ANGLE  
BSPT 1:16 TAPER TYPE RC - RIGHT HAND**

**HIGH SPEED STEEL  
GROUND THREAD**



**TAPERED THREAD**



PKG QTY. 1

Dies split or solid, our option.

SIZE Inch	PITCH TPI	Tap Square End A/F (mm)	Recommended DRILL (mm)	#2 Middle Tap SPAENAUR No.	#3 Finishing Tap SPAENAUR No.	ROUND DIES SPAENAUR No.	Die O.D. (mm)	THICK- NESS (mm)
RC 1/8	28	6.3	8.6	874-387	874-1471	878-932	30	11
RC 1/4	19	8	11.5	874-386	874-1472	878-933	38	14
RC 3/8	19	10	15	874-007	874-1473	878-934	45	14
RC 1/2	14	12.5	18.5	—	874-1474	—	45	18
RC 3/4	14	16	24	—	874-1475	878-936	55	22
RC 1	11	20	30.50	—	874-1476	878-937	65	25

RC Thread is a designation of British Standard Pipe Taper.

**GERMAN PIPE THREAD TYPE PG  
CONDUIT PARALLEL, 80° THREAD ANGLE**

**RIGHT HAND FINISHING TAPS**

**HIGH SPEED STEEL  
GROUND THREAD**



PKG QTY. 1

#1 Starting Taps SPAENAUR No.	#3 Finishing Taps SPAENAUR No.	SIZE (Diameter mm)	Recommended DRILL (mm)	PITCH TPI	ROUND DIES SPAENAUR No.	Die O.D. (mm)	THICK- NESS (mm)
874-1668	874-1477	PG-7 (12.5)	11.3	20	878-938	38	10
874-1669	874-1478	PG-9 (15.2)	13.75	18	878-939	38	10
874-1670	874-1479	PG-11 (18.6)	17.3	18	878-940	45	14
874-1671	874-1480	PG-13.5 (20.4)	19	18	878-941	45	14
874-1672	874-1481	PG-16 (22.5)	21	18	878-942	55	16
874-1673	874-1482	PG-21 (28.3)	27.5	16	878-943	65	18
874-1674	874-1483	PG-29 (37)	36	16	878-944	65	18
874-1675	874-1484	PG-36 (47)	46	16	878-945	90	22

PG is Technical Standard created in Germany. It refers to the thread used to join pieces of electrical conduit and cable glands.

P

CATALOG 14

SPAENAUR

**METRIC HAND TAPS ONLY**  
**STRAIGHT FLUTE - RIGHT HAND**  
**METRIC COARSE THREAD**  
**HIGH SPEED STEEL**  
**GROUND THREAD**



Straight flute taps with a progressive thread form on each successive tap. Serial sets are suitable for deep through and blind holes, and are recommended for precision tapping in tough materials. Three taps per set. These taps should not be used individually or by machine.

Set of 3 Taps SPAENAUR No.	PITCH mm	Tap Square End A/F	Recommended DRILL mm	Nominal DIA. mm
874-1534	0.5	2.5	2.5	M3
874-1535	0.7	3.15	3.3	M4
874-1536	0.8	4	4.2	M5
874-1537	1.0	5	5	M6
874-1546	1.0	5.6	6	M7
874-1538	1.25	6.3	6.75	M8
874-1547	1.25	7.1	7.75	M9
874-1539	1.5	8	8.5	M10
874-1548	1.5	6.3	9.5	M11
874-1186	1.75	7.1	10.2	M12
874-1540	2.0	9	12	M14
874-1541	2.0	10	14	M16
874-1542	2.5	11.2	15.5	M18
874-1543	2.5	11.2	17.5	M20
874-1544	2.5	12.5	19.5	M22
874-1545	3.0	14	21	M24

All Serial Sets - PKG QTY. 1



Dies

Inch and Metric

Filières

Pouce et Métrique



**METRIC ROUND DIES WITH INCH O.D.**

**RIGHT HAND  
METRIC COARSE THREAD  
HIGH SPEED STEEL  
GROUND THREAD**

Dies split or solid, our option.

SPAENAUR No.	SIZE mm	PITCH mm	O.D. Inch	THICKNESS Inch
878-600	M1.6	0.35	13/16"	1/4"
878-601	M1.7	0.35	13/16"	1/4"
878-602	M2	0.4	13/16"	1/4"
878-603	M2.3	0.4	13/16"	1/4"
878-604	M2.5	0.45	13/16"	1/4"
878-605	M2.6	0.45	13/16"	1/4"
878-606	M3	0.5	13/16"	1/4"
878-607	M3.5	0.6	13/16"	1/4"
878-608	M4	0.7	13/16"	1/4"
878-609	M4.5	0.75	13/16"	1/4"
878-K05-1W	M5	0.8	13/16"	1/4"
878-611	M6	1.0	13/16"	1/4"
878-612	M6.3	1.0	13/16"	1/4"
878-K10-1A	M8	1.25	1"	3/8"
878-615	M9	1.25	1"	3/8"
878-616	M10	1.5	1"	3/8"
878-617	M12	1.75	1-5/16"	7/16"
878-695	M12	1.75	2"	5/8"
878-618	M14	2.0	1-1/2"	1/2"
878-696	M14	2.0	2"	5/8"
878-619	M16	2.0	1-1/2"	1/2"
878-697	M16	2.0	2"	5/8"
878-K02-1N	M18	2.5	2"	5/8"
878-621	M20	2.5	2"	5/8"
878-622	M22	2.5	2"	5/8"
878-623	M24	3.0	2"	5/8"

**METRIC ROUND DIES**

**RIGHT HAND  
METRIC COARSE THREAD  
HIGH SPEED STEEL  
GROUND THREAD**

**DIN 223**

SPAENAUR No.	SIZE mm	PITCH mm	O.D. mm	THICKNESS mm
878-712	M1	0.25	16	5
878-713	M1.1	0.25	16	5
878-714	M1.2	0.25	16	5
878-715	M1.4	0.3	16	5
878-716	M1.6	0.35	16	5
878-815	M1.7	0.35	16	5
878-717	M1.8	0.35	16	5
878-718	M2	0.4	16	5
878-719	M2.2	0.45	16	5
878-817	M2.3	0.4	16	5
878-720	M2.5	0.45	16	5
878-816	M2.6	0.45	16	5
878-721	M3	0.5	20	5
878-755	M3	0.5	25	9
878-722	M3.5	0.6	20	5
878-723	M4	0.7	20	5
878-756	M4	0.7	25	9
878-724	M4.5	0.75	20	7
878-725	M5	0.8	20	7
878-819	M5.5	0.90	20	7
878-726	M6	1.0	20	7
878-758	M6	1.0	25	9
878-727	M7	1.0	25	9
878-728	M8	1.25	25	9
878-729	M9	1.25	25	9
878-760	M10	1.5	25	9
878-730	M10	1.5	30	11
878-731	M11	1.5	30	11
878-761	M12	1.75	25	9
878-732	M12	1.75	38	14
878-762	M12	1.75	45	18
878-733	M14	2.0	38	14
878-763	M14	2.0	45	18
878-734	M16	2.0	45	18
878-735	M18	2.5	45	18
878-736	M20	2.5	45	18
878-737	M22	2.5	55	22
878-768	M24	3.0	45	18
878-738	M24	3.0	55	22
878-739	M27	3.0	65	25
878-740	M30	3.5	65	25
878-741	M33	3.5	65	25
878-965	M36	4.0	65	20
878-742	M36	4.0	65	25
878-743	M39	4.0	75	30
878-744	M42	4.5	75	30
878-745	M45	4.5	90	36
878-746	M48	5.0	90	36
878-747	M52	5.0	90	36

All Dies - PKG QTY. 1

CATALOG 14

SPAENAUR

# RIGHT HAND DIES



**DIN 223**

## METRIC FINE AND COARSE THREAD

Dies split or solid, our option.

...Continued

### METRIC FINE THREAD HIGH SPEED STEEL GROUND THREAD

SPAENAUR No.	SIZE mm	PITCH mm	O.D. mm	THICKNESS mm
878-821	M3	0.35	20	5
878-822	M3.5	0.35	20	5
878-839	M4	0.5	20	5
878-825	M5	0.75	20	7
878-840	M5	0.5	20	5
878-841	M6	0.5	20	5
878-842	M6	0.75	20	7
878-824	M7	0.75	25	9
878-843	M8	0.75	25	9
878-844	M8	1.0	25	9
878-826	M9	1.0	25	9
878-845	M10	0.75	30	11
878-846	M10	1.0	30	11
878-847	M10	1.25	30	11
878-827	M11	1.0	30	11
878-848	M11	1.25	30	11
878-849	M12	1.0	38	10
878-850	M12	1.25	38	10
878-851	M12	1.5	38	10
878-624	M14	1.0	38	10
878-852	M14	1.25	38	10
878-853	M14	1.5	38	10
878-854	M16	1.0	45	14
878-828	M16	1.25	45	14

Continued...

SPAENAUR No.	SIZE mm	PITCH mm	O.D. mm	THICKNESS mm
878-855	M16	1.5	45	14
878-829	M18	1.25	45	14
878-856	M18	1.5	45	14
878-857	M18	2.0	45	14
878-858	M20	1.0	45	14
878-859	M20	1.5	45	14
878-860	M20	2.0	45	14
878-830	M22	1.0	55	16
878-861	M22	1.5	55	16
878-862	M22	2.0	55	16
878-863	M24	1.5	55	16
878-864	M24	2.0	55	16
878-831	M26	1.5	65	18
878-865	M27	1.5	65	18
878-866	M27	2.0	65	18
878-867	M28	1.5	65	18
878-868	M30	1.5	65	18
878-869	M30	2.0	65	18
878-870	M30	3.0	65	18
878-832	M32	1.5	65	18
878-871	M33	1.5	65	18
878-872	M33	2.0	65	18
878-833	M34	1.5	65	18
878-834	M35	2.0	65	18
878-873	M36	1.5	65	18
878-874	M36	2.0	65	18
878-875	M36	3.0	65	18
878-835	M38	1.5	75	20

All Dies - PKG QTY. 1



# LEFT HAND DIES

Dies split or solid, our option.

## METRIC COARSE THREAD HIGH SPEED STEEL GROUND THREAD

SPAENAUR No.	SIZE mm	PITCH mm	O.D. mm	THICKNESS mm
878-675	M4	0.7	20	5
878-676	M5	0.8	20	7
878-677	M6	1.0	20	7
878-678	M8	1.25	25	9
878-679	M10	1.5	30	11
878-680	M12	1.75	38	14
878-681	M14	2.0	38	14
878-682	M16	2.0	45	18
878-683	M18	2.5	45	18
878-684	M20	2.5	45	18
878-685	M24	3.0	55	22

## METRIC FINE THREAD HIGH SPEED STEEL GROUND THREAD

SPAENAUR No.	SIZE mm	PITCH mm	O.D. mm	THICKNESS mm
878-686	M8	1.0	25	9
878-687	M10	1.0	30	11
878-688	M12	1.5	38	10
878-625	M14	1.5	38	10
878-689	M16	1.5	45	14
878-690	M18	1.5	45	14
878-134	M20	1.5	45	14
878-135	M32	1.5	63.5	19

All Dies - PKG QTY. 1



For Stud Extractors, Screw Extractors,  
Nut Splitters See Pages N15-16



P

**METRIC RIGHT HAND DIES**

**DIN 382**

**METRIC COARSE THREAD  
HIGH SPEED STEEL  
GROUND THREAD**



**DIN 382**

**METRIC FINE THREAD  
HIGH SPEED STEEL  
GROUND THREAD**

SPAENAUR No.	SIZE mm	PITCH mm	A/F mm	THICKNESS mm
878-769	M3	0.5	19	5
878-770	M3.5	0.6	19	5
878-771	M4	0.7	19	5
878-789	M4.5	0.75	19	7
878-772	M5	0.8	19	7
878-653	M6	1.0	19	7
878-654	M7	1.0	22	9
878-655	M8	1.25	22	9
878-656	M9	1.25	22	9
878-657	M10	1.5	27	11
878-658	M12	1.75	36	14
878-659	M14	2.0	36	14
878-660	M16	2.0	41	18
878-661	M18	2.5	41	18
878-662	M20	2.5	41	18
878-663	M22	2.5	50	22
878-664	M24	3.0	50	22
878-773	M27	3.0	60	25
878-774	M30	3.5	60	25
878-775	M33	3.5	60	25
878-776	M36	4.0	60	25
878-777	M39	4.0	70	30
878-778	M42	4.5	70	30
878-779	M45	4.5	85	36
878-780	M48	5.0	85	36
878-781	M52	5.0	85	36
878-878	M3	0.35	19	5
878-879	M4	0.5	19	5
878-880	M5	0.5	19	5
878-881	M6	0.5	19	5
878-882	M6	0.75	19	7
878-883	M8	0.75	22	9
878-884	M8	1.0	22	9
878-626	M9	1.0	22	9
878-961	M10	0.75	27	11
878-885	M10	1.0	27	11

SPAENAUR No.	SIZE mm	PITCH mm	A/F mm	THICKNESS mm
878-886	M10	1.25	27	11
878-915	M11	1.0	27	11
878-887	M11	1.25	27	11
878-888	M12	1.0	36	10
878-889	M12	1.25	36	10
878-890	M12	1.5	36	10
878-891	M14	1.25	36	10
878-892	M14	1.5	36	10
878-893	M16	1.0	41	14
878-916	M16	1.25	41	14
878-894	M16	1.5	41	14
878-917	M18	1.25	41	14
878-895	M18	1.5	41	14
878-896	M18	2.0	41	14
878-897	M20	1.0	41	14
878-898	M20	1.5	41	14
878-899	M20	2.0	41	14
878-900	M22	1.5	50	16
878-901	M22	2.0	50	16
878-902	M24	1.5	50	16
878-903	M24	2.0	50	16
878-904	M27	1.5	60	18
878-905	M27	2.0	60	18
878-906	M28	1.5	60	18
878-907	M30	1.5	60	18
878-908	M30	2.0	60	18
878-909	M30	3.0	60	18
878-918	M32	1.5	60	18
878-910	M33	1.5	60	18
878-911	M33	3.0	60	18
878-919	M34	1.5	60	18
878-920	M35	1.5	60	18
878-912	M36	1.5	60	18
878-913	M36	2.0	60	18
878-914	M36	3.0	60	18

All Dies - PKG QTY. 1

Tap Sets / Threading Sets / Kits / Tools

Metric

Jeux de tarauds / Jeux de taraudage / Kits / Outils

Métrique



Example of Set in Wooden Box

**METRIC COARSE AND FINE THREAD TAP AND DIE SETS**

- Wide selection of taps, dies and related holders.
- Put up in sturdy containers.
- Organization made easy!



Example of Set in Metal Box

**METRIC COARSE THREAD TAP SETS**

High Speed Steel, Ground Thread

**Spenaaur No. 874-950**

In a wooden box containing one starting, middle and finishing tap in each of the following sizes: M3, M4, M5, M6, M8, M10 and M12.

**Spenaaur No. 874-1600**

FEW Tap Set in a metal case containing one starting, middle and finishing tap in each of the following sizes: M3, M4, M5, M6, M8, M10, and M12.

**METRIC COARSE THREAD SERIAL TAP AND DIE SETS**

High Speed Steel, Ground Thread

**Spenaaur No. 874-1589**

In a metal index box containing one starting, middle and finishing tap in each of the following sizes: M3, M4, M5, M6, M8, M10 and M12.

**Spenaaur No. 874-1602**

Taps and Drills in a plastic box containing one starting, middle and finishing tap in each of the following sizes: M3, M4, M5, M6, M8, M10 and M12 and one bar type tap handle.

One drill in each of the following sizes: 2.5 mm, 3.3 mm, 4.2 mm, 5 mm, 6.8 mm, 8.5 and 10.2 mm.

**Spenaaur No. 878-949**

In wooden box containing one starting, middle and finishing tap and one round die in each of the of the following sizes: M3, M4, M5, M6, M8, M10, M12, M14, M16, M18, M20, M22, and M24.

Set also includes tap handles and die holders.

**Spenaaur No. 878-967**

In plastic box containing one starting, middle and finishing tap and one round die in each of the following sizes: M3, M4, M5, M6, M8, M10 and M12.

Set also includes two tap handles, five die holder and one slotted screwdriver.

All Sets - PKG QTY. 1

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