

suttontools

ISO TAPS

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



Special Taps Express Delivery Service...

Sutton Tools is a leading international Manufacturer of specialist cutting tools and is renowned for producing high performance, precision cutting tools specifically designed to individual customer requirements.

With comprehensive customer service and warehouse facilities, our Express Delivery Service enables us to meet your requirements more efficiently than ever before.

All Thread Forms
UN, Metric, UNJC, UNJF, MJ, UH, Pg,
Whit, Rope forms & Acme and more!!

With our state of the art CNC grinding equipment almost any profile can be achieved. Feel free to discuss these with our Tech team.

Within 24 hours*
- Straight Flute Taps M3 to M127
- Spiral Taps M3 to M36

Within 48 Hours*
- Gun Taps M3 to M36

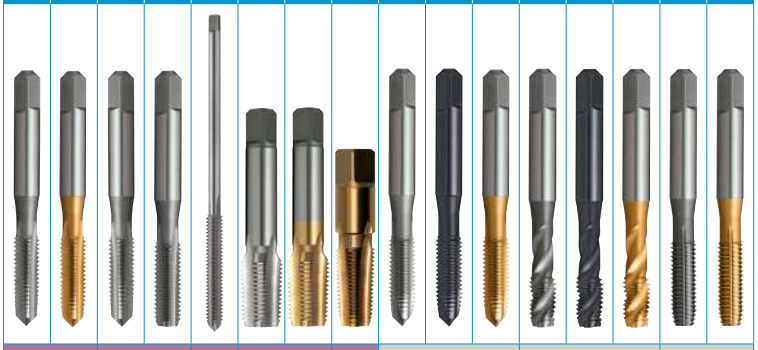
Within 5 Working Days*
Surface Finishes and Treatments:
- Steam Oxide
- Gas Nitride
- Titanium Nitride
- Chromium Nitride
- Titanium Carbo-Nitride
- Titanium Aluminum Nitride

*For orders received prior to 12pm (Australian Eastern Standard Time)

ISO Taps Finder

suttontools

Page M	68	70	71	72					73	73	74	75	75	76	77	77
MF	78	80							81	81	82	83		83		
UNC	84	86	87		94				89	89	90	91	91	92	93	93
UNF	95	97	98						102	102	103	104		104	105	
BSW	108	110	111		117				112	112	113	114	114	115	116	116
BSF, BA, BSB (Brass)	118															
G (BSPF)	120	122							120			121				
Rc (BSPT), Rp (BSPPL), Pg, NPT, NPTF, NPSF	123					123	123	124								



ISO	VDI	Material Group	Sutton	
P	A	Steel	N	UNI
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	Ni
H	H	Hard Materials (≥ 45 HRC)	H	

^ 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 expert tooling recommendations, go to:
www.suttontools.com/expert-tool-selector

Material	HSS		HSS		HSS	HSS			HSSE			HSSE			HSSE	
Surface Finish	Brt	TiN	Brt		Brt	Brt	TiN	Colour Temp	Brt	Blu	TiN	Brt	Blu	TiN	Brt	TiN
Sutton Designation	N		N-LH	0/Size	Nut	N		N	N			N			N	
Tapping Depth	≤ 1xØ		≤ 1xØ		≤ 2xØ	-		-	≤ 3xØ			≤ 2.5xØ			≤ 1.5xØ	

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																
	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	○	○	○	○	○	○	○	○	○		○	○		○	●	●
	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																				
	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																	

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

Section Finder

ISO Taps Metric, Straight Flute, N

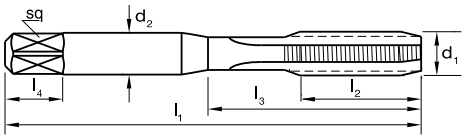
suttontools

- 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 d_1









	T384	T385
Catalogue Code	T384	T385
Discount Group	D0702	D0702
Material	HSS	HSS
Surface Finish	*Brt*	*Brt*
Sutton Designation	N	N
Geometry	-	-
Chamfer	Taper	Intermediate
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 #
0200	M 2	x 0.4	41	8	-	2.50	2.00	4	3	1.6	T384 0200	T385 0200
0250	M 2.5	x 0.45	45	10	-	2.80	2.24	5	3	2.05	T384 0250	T385 0250
0300	M 3	x 0.5	48	11	15	3.15	2.50	5	3	2.5	T384 0300	T385 0300
0350	M 3.5	x 0.6	50	13	17.5	3.55	2.80	5	3	2.9	T384 0350	T385 0350
0400	M 4	x 0.7	53	13	18	4.00	3.15	6	3	3.3	T384 0400	T385 0400
0450	M 4.5	x 0.75	53	13	19	4.50	3.55	6	3	3.7	T384 0450	T385 0450
0500	M 5	x 0.8	58	16	22	5.00	4.00	7	3	4.2	T384 0500	T385 0500
0600	M 6	x 1	66	19	26	6.30	5.00	8	3	5.0	T384 0600	T385 0600
0700	M 7	x 1	66	19	26	7.10	5.60	8	4	6.0	T384 0700	T385 0700
0800	M 8	x 1.25	72	22	30	8.00	6.30	9	4	6.8	T384 0800	T385 0800
0900	M 9	x 1.25	72	22	31	9.00	7.10	10	4	7.8	T384 0900	T385 0900
1000	M 10	x 1.5	80	24	34	10.00	8.00	11	4	8.5	T384 1000	T385 1000
1100	M 11	x 1.5	85	25	-	8.00	6.30	9	4	9.5	T384 1100	T385 1100
1200	M 12	x 1.75	89	29	-	9.00	7.10	10	4	10.2	T384 1200	T385 1200
1400	M 14	x 2	95	30	-	11.20	9.00	12	4	12.0	T384 1400	T385 1400
1600	M 16	x 2	102	32	-	12.50	10.00	13	4	14.0	T384 1600	T385 1600
1800	M 18	x 2.5	112	37	-	14.00	11.20	14	4	15.5	T384 1800	T385 1800
2000	M 20	x 2.5	112	37	-	14.00	11.20	14	4	17.5	T384 2000	T385 2000
2200	M 22	x 2.5	118	38	-	16.00	12.50	16	4	19.5	T384 2200	T385 2200
2400	M 24	x 3	130	45	-	18.00	14.00	18	4	21.0	T384 2400	T385 2400
2700	M 27	x 3	135	45	-	20.00	16.00	20	4	24.0	T384 2700	T385 2700
3000	M 30	x 3.5	138	48	-	20.00	16.00	20	4	26.5	T384 3000	T385 3000
3300	M 33	x 3.5	151	51	-	22.40	18.00	22	4	29.5	T384 3300	T385 3300
3600	M 36	x 4	162	57	-	25.00	20.00	24	4	32.0	T384 3600	T385 3600
3900	M 39	x 4	170	60	-	28.00	22.40	26	4	35.0	T384 3900	T385 3900
4200	M 42	x 4.5	170	60	-	28.00	22.40	26	4	37.5	T384 4200	T385 4200
4500	M 45	x 4.5	187	67	-	31.50	25.00	28	4	40.5	T384 4500	T385 4500
4800	M 48	x 5	187	67	-	31.50	25.00	28	4	43.0	T384 4800	T385 4800
5200	M 52	x 5	200	70	-	35.50	28.00	31	4	47.0	T384 5200	T385 5200
	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											T385 0014



T385 0014

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	●	●	●	●		●	○										○		○		○		○	○	○	○		○		○																				
T385	●	●	●	●		●	○										○		○		○		○	○	○	○		○		○																				

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

● Optimal ○ Effective

M Finder

ISO Taps Metric, Straight Flute, N

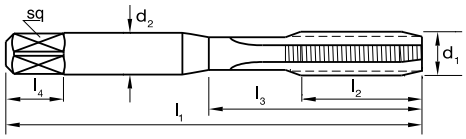
suttontools

- 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 d_1





ISO 529 | 60° M



Catalogue Code	T386	T901
Discount Group	D0702	D0702
Material	HSS	HSS
Surface Finish	*Brt*	*Brt*
Sutton Designation	N	N
Geometry	-	-
Chamfer	Bottoming	Set
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 #
0200	M 2	x 0.4	41	8	-	2.50	2.00	4	3	1.6	T386 0200	T901 0200
0250	M 2.5	x 0.45	45	10	-	2.80	2.24	5	3	2.05	T386 0250	T901 0250
0300	M 3	x 0.5	48	11	15	3.15	2.50	5	3	2.5	T386 0300	T901 0300
0350	M 3.5	x 0.6	50	13	17.5	3.55	2.80	5	3	2.9	T386 0350	T901 0350
0400	M 4	x 0.7	53	13	18	4.00	3.15	6	3	3.3	T386 0400	T901 0400
0450	M 4.5	x 0.75	53	13	19	4.50	3.55	6	3	3.7	T386 0450	T901 0450
0500	M 5	x 0.8	58	16	22	5.00	4.00	7	3	4.2	T386 0500	T901 0500
0600	M 6	x 1	66	19	26	6.30	5.00	8	3	5.0	T386 0600	T901 0600
0700	M 7	x 1	66	19	26	7.10	5.60	8	4	6.0	T386 0700	T901 0700
0800	M 8	x 1.25	72	22	30	8.00	6.30	9	4	6.8	T386 0800	T901 0800
0900	M 9	x 1.25	72	22	31	9.00	7.10	10	4	7.8	T386 0900	T901 0900
1000	M 10	x 1.5	80	24	34	10.00	8.00	11	4	8.5	T386 1000	T901 1000
1100	M 11	x 1.5	85	25	-	8.00	6.30	9	4	9.5	T386 1100	T901 1100
1200	M 12	x 1.75	89	29	-	9.00	7.10	10	4	10.2	T386 1200	T901 1200
1400	M 14	x 2	95	30	-	11.20	9.00	12	4	12.0	T386 1400	T901 1400
1600	M 16	x 2	102	32	-	12.50	10.00	13	4	14.0	T386 1600	T901 1600
1800	M 18	x 2.5	112	37	-	14.00	11.20	14	4	15.5	T386 1800	T901 1800
2000	M 20	x 2.5	112	37	-	14.00	11.20	14	4	17.5	T386 2000	T901 2000
2200	M 22	x 2.5	118	38	-	16.00	12.50	16	4	19.5	T386 2200	T901 2200
2400	M 24	x 3	130	45	-	18.00	14.00	18	4	21.0	T386 2400	T901 2400
2700	M 27	x 3	135	45	-	20.00	16.00	20	4	24.0	T386 2700	•
3000	M 30	x 3.5	138	48	-	20.00	16.00	20	4	26.5	T386 3000	•
3300	M 33	x 3.5	151	51	-	22.40	18.00	22	4	29.5	T386 3300	•
3600	M 36	x 4	162	57	-	25.00	20.00	24	4	32.0	T386 3600	•
3900	M 39	x 4	170	60	-	28.00	22.40	26	4	35.0	T386 3900	•
4200	M 42	x 4.5	170	60	-	28.00	22.40	26	4	37.5	T386 4200	•
4500	M 45	x 4.5	187	67	-	31.50	25.00	28	4	40.5	T386 4500	•
4800	M 48	x 5	187	67	-	31.50	25.00	28	4	43.0	T386 4800	•
5200	M 52	x 5	200	70	-	35.50	28.00	31	4	47.0	T386 5200	•
	Tap & Drill Sets											
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											T901 SDT1



T901 SDT1

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
T386	●	●	●	●		●	○										○		○		○		○	○	○	○		○		○																				
T901	●	●	●	●		●	○										○		○		○		○	○	○	○		○		○																				

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

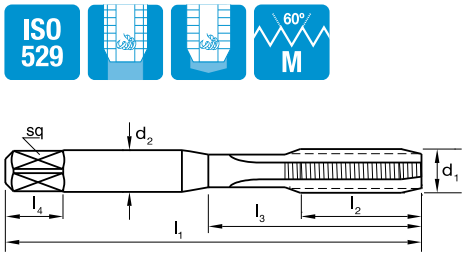
● Optimal ○ Effective

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

ISO 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 d_1







Catalogue Code	T387	T388
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 #
0200	M 2	x 0.4	41	8	-	2.50	2.00	4	3	1.6	T387 0200*	T388 0200*
0250	M 2.5	x 0.45	45	10	-	2.80	2.24	5	3	2.05	•	•
0300	M 3	x 0.5	48	11	-	3.15	2.50	5	3	2.5	T387 0300*	T388 0300*
0350	M 3.5	x 0.6	50	13	-	3.55	2.80	5	3	2.9	T387 0350*	
0400	M 4	x 0.7	53	13	-	4.00	3.15	6	3	3.3	T387 0400*	
0450	M 4.5	x 0.75	53	13	19	4.50	3.55	6	3	3.7	•	•
0500	M 5	x 0.8	58	16	22	5.00	4.00	7	3	4.2	T387 0500	T388 0500*
0600	M 6	x 1	66	19	26	6.30	5.00	8	3	5.0	T387 0600	
0700	M 7	x 1	66	19	26	7.10	5.60	8	4	6.0	•	
0800	M 8	x 1.25	72	22	30	8.00	6.30	9	4	6.8	T387 0800*	T388 0800*
0900	M 9	x 1.25	72	22	31	9.00	7.10	10	4	7.8	•	•
1000	M 10	x 1.5	80	24	34	10.00	8.00	11	4	8.5		T388 1000*
1100	M 11	x 1.5	85	25	-	8.00	6.30	9	4	9.5	•	•
1200	M 12	x 1.75	89	29	-	9.00	7.10	10	4	10.2	T387 1200*	
1600	M 16	x 2	102	32	-	12.50	10.00	13	4	14.0	T387 1600*	
2200	M 22	x 2.5	118	38	-	16.00	12.50	16	4	19.5	•	•
2400	M 24	x 3	130	45	-	18.00	14.00	18	4	21.0	•	•
2700	M 27	x 3	135	45	-	20.00	16.00	20	4	24.0	•	•
3000	M 30	x 3.5	138	48	-	20.00	16.00	20	4	26.5	•	•
3300	M 33	x 3.5	151	51	-	22.40	18.00	22	4	29.5	•	•
3600	M 36	x 4	162	57	-	25.00	20.00	24	4	32.0	•	•
3900	M 39	x 4	170	60	-	28.00	22.40	26	4	35.0	•	•
4200	M 42	x 4.5	170	60	-	28.00	22.40	26	4	37.5	•	•
4500	M 45	x 4.5	187	67	-	31.50	25.00	28	4	40.5	•	•
4800	M 48	x 5	187	67	-	31.50	25.00	28	4	43.0	•	•
5200	M 52	x 5	200	70	-	35.50	28.00	31	4	47.0	•	•

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	●	●	●	●	○	●	●	○		○		○		○			○		○		○		○	○	○	○		○	○	○																		
T388	●	●	●	●	○	●	●	○		○		○		○			○		○		○		○	○	○	○		○	○	○																		

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

● Optimal ○ Effective

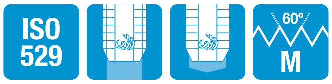
M Finder

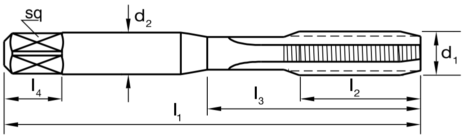
*Not available once current stock is depleted. • Available on request as special manufacture. Subject to lead time.

ISO 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 d_1









Catalogue Code	T389	T390
Discount Group	D0702	D0702
Material	HSS	HSS
Surface Finish	*Brt*	*Brt*
Sutton Designation	**N**	**N**
Geometry	Left Hand	Left Hand
Chamfer	**Taper**	**Intermediate**
Limit & Nut Tolerance	ISO 2 / 6H LH	ISO 2 / 6H LH

Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
0300	M 3	x 0.5	48	11	15	3.15	2.50	5	3	2.5	T389 0300	T390 0300
0400	M 4	x 0.7	53	13	18	4.00	3.15	6	3	3.3	T389 0400	T390 0400
0500	M 5	x 0.8	58	16	22	5.00	4.00	7	3	4.2	T389 0500	T390 0500
0600	M 6	x 1	66	19	26	6.30	5.00	8	3	5.0	T389 0600	T390 0600
0800	M 8	x 1.25	72	22	30	8.00	6.30	9	4	6.8	T389 0800	T390 0800
1000	M 10	x 1.5	80	24	34	10.00	8.00	11	4	8.5	T389 1000	T390 1000
1200	M 12	x 1.75	89	29	-	9.00	7.10	10	4	10.2	T389 1200	T390 1200
1400	M 14	x 2	95	30	-	11.20	9.00	12	4	12.0	T389 1400	T390 1400
1600	M 16	x 2	102	32	-	12.50	10.00	13	4	14.0	T389 1600	T390 1600
1800	M 18	x 2.5	112	37	-	14.00	11.20	14	4	15.5	T389 1800	T390 1800
2000	M 20	x 2.5	112	37	-	14.00	11.20	14	4	17.5	T389 2000	T390 2000

ISO	P													M		
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3
T389	●	●	●	●		●	○									
T390	●	●	●	●		●	○									

ISO	K						N									
VDI 3323	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30
T389	○		○		○		○	○	○	○		○		○		
T390	○		○		○		○	○	○	○		○		○		

ISO	S											H					
VDI 3323	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																	
T390																	

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

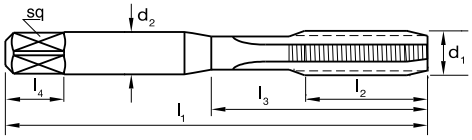
● Optimal ○ Effective

ISO 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 d_1





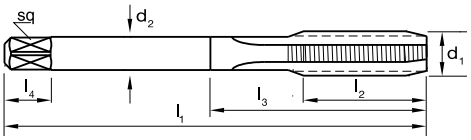
Catalogue Code	T391
Discount Group	D0702
Material	HSS
Surface Finish	*Brt*
Sutton Designation	N
Geometry	Left Hand
Chamfer	Bottoming
Limit & Nut Tolerance	ISO 2 / 6H LH

Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #
0300	M 3	x 0.5	48	11	15	3.15	2.50	5	3	2.5	T391 0300
0400	M 4	x 0.7	53	13	18	4.00	3.15	6	3	3.3	T391 0400
0500	M 5	x 0.8	58	16	22	5.00	4.00	7	3	4.2	T391 0500
0600	M 6	x 1	66	19	26	6.30	5.00	8	3	5.0	T391 0600
0800	M 8	x 1.25	72	22	30	8.00	6.30	9	4	6.8	T391 0800
1000	M 10	x 1.5	80	24	34	10.00	8.00	11	4	8.5	T391 1000
1200	M 12	x 1.75	89	29	-	9.00	7.10	10	4	10.2	T391 1200
1400	M 14	x 2	95	30	-	11.20	9.00	12	4	12.0	T391 1400
1600	M 16	x 2	102	32	-	12.50	10.00	13	4	14.0	T391 1600
1800	M 18	x 2.5	112	37	-	14.00	11.20	14	4	15.5	T391 1800
2000	M 20	x 2.5	112	37	-	14.00	11.20	14	4	17.5	T391 2000

ISO 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 d_1
- 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	Item #
											T392
1000	M10 +0.4	x 1.5	85	25	-	8.0	6.3	9.0	4	8.9	T392 1000
1200	M12 +0.4	x 1.75	89	29	-	9.0	7.1	10.0	4	10.6	T392 1200
1600	M16 +0.4	x 2	112	37	-	12.5	10.0	13.0	4	14.4	T392 1600
2000	M20 +0.4	x 2.5	118	38	-	16.0	12.5	16.0	4	17.9	T392 2000
2400	M24 +0.45	x 3	130	45	-	18.0	14.0	18.0	4	21.5	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
T391	●	●	●	●		●	○										○		○		○		○	○	○	○		○		○																			
T392	●	●	●	●		●	○										○		○		○		○	○	○	○		○		○																			

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

● Optimal ○ Effective

ISO Taps Metric, Gun, N

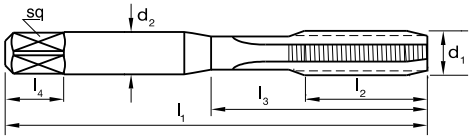
suttontools

- General purpose use
- Suitable for materials up to 1000N/mm²
- Through holes
- Depths up to approx. 3 x d_1

ISO 529 | 60° | M







	T393	T394
Catalogue Code	T393	T394
Discount Group	D0702	D0702
Material	HSSE	HSSE
Surface Finish	*Brt*	*Blu*
Sutton Designation	N	N
Geometry	-	-
Chamfer	Intermediate	Intermediate
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 #
0250	M 2.5	x 0.45	45	10	-	2.80	2.24	5	3	2.05	T393 0250	T394 0250
0300	M 3	x 0.5	48	11	15	3.15	2.50	5	3	2.5	T393 0300	T394 0300
0350	M 3.5	x 0.6	50	13	17.5	3.55	2.80	5	3	2.9	T393 0350	T394 0350
0400	M 4	x 0.7	53	13	18	4.00	3.15	6	3	3.3	T393 0400	T394 0400
0500	M 5	x 0.8	58	16	22	5.00	4.00	7	3	4.2	T393 0500	T394 0500
0600	M 6	x 1	66	19	26	6.30	5.00	8	3	5.0	T393 0600	T394 0600
0800	M 8	x 1.25	72	22	30	8.00	6.30	9	3	6.8	T393 0800	T394 0800
1000	M 10	x 1.5	80	24	34	10.00	8.00	11	3	8.5	T393 1000	T394 1000
1200	M 12	x 1.75	89	29	-	9.00	7.10	10	3	10.2	T393 1200	T394 1200
1400	M 14	x 2	95	30	-	11.20	9.00	12	3	12.0	T393 1400	T394 1400
1600	M 16	x 2	102	32	-	12.50	10.00	13	3	14.0	T393 1600	T394 1600
1800	M 18	x 2.5	112	37	-	14.00	11.20	14	4	15.5	T393 1800	T394 1800
2000	M 20	x 2.5	112	37	-	14.00	11.20	14	4	17.5	T393 2000	T394 2000
2200	M 22*	x 2.5	118	38	-	16.00	12.50	16	4	19.5	•	T394 2200
2400	M 24*	x 3	130	45	-	18.00	14.00	18	4	21.0	•	T394 2400
3000	M 30*	x 3.5	138	48	-	20.00	16.00	20	4	26.5	•	T394 3000

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
T393	●	●	○	○		●	○							○	○				○	○	○		○	○	○	○		●	○																	○	
T394	●	●	●	●		●	○					○		○	○				○	○	○																									○	

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

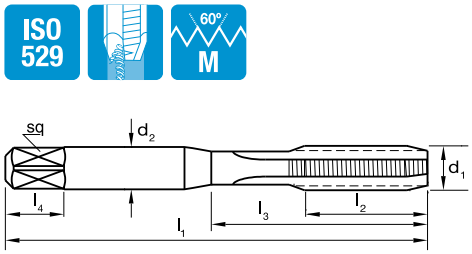
● Optimal ○ Effective

*HSS >20mm • Available on request as special manufacture. Subject to lead time.

suttontools

- General purpose use
- Suitable for materials up to 1000N/mm²
- Through holes
- Depths up to approx. 3 x d_1





Catalogue Code	T395
Discount Group	D0706
Material	HSSE
Surface Finish	TiN
Sutton Designation	N
Geometry	-
Chamfer	Intermediate
Limit & Nut Tolerance	ISO 2 / 6H

Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #
0250	M 2.5	x 0.45	45	10	-	2.80	2.24	5	3	2.05	•
0300	M 3	x 0.5	48	11	15	3.15	2.50	5	3	2.5	T395 0300
0350	M 3.5	x 0.6	50	13	17.5	3.55	2.80	5	3	2.9	T395 0350
0400	M 4	x 0.7	53	13	18	4.00	3.15	6	3	3.3	T395 0400
0500	M 5	x 0.8	58	16	22	5.00	4.00	7	3	4.2	T395 0500
0600	M 6	x 1	66	19	26	6.30	5.00	8	3	5.0	T395 0600
0800	M 8	x 1.25	72	22	30	8.00	6.30	9	3	6.8	T395 0800
1000	M 10	x 1.5	80	24	34	10.00	8.00	11	3	8.5	T395 1000
1200	M 12	x 1.75	89	29	-	9.00	7.10	10	3	10.2	T395 1200
1400	M 14	x 2	95	30	-	11.20	9.00	12	3	12.0	•
1600	M 16	x 2	102	32	-	12.50	10.00	13	3	14.0	T395 1600
1800	M 18	x 2.5	112	37	-	14.00	11.20	14	4	15.5	T395 1800
2000	M 20	x 2.5	112	37	-	14.00	11.20	14	4	17.5	T395 2000
2200	M 22*	x 2.5	118	38	-	16.00	12.50	16	4	19.5	•
2400	M 24*	x 3	130	45	-	18.00	14.00	18	4	21.0	•
3000	M 30*	x 3.5	138	48	-	20.00	16.00	20	4	26.5	•

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
T395	●	●	●	●	○	●	●	○		○		○	○	○	○				○	○	○		○	○	○	○	○	○	○																			○	

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

● Optimal ○ Effective

*HSS >20mm • Available on request as special manufacture. Subject to lead time.

ISO Taps Metric, Spiral Flute, N

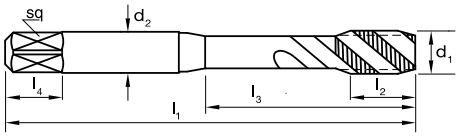
suttontools

- General purpose use
- Suitable for materials up to 1000N/mm²
- Blind holes
- Depths up to approx. 2.5 x d_1

ISO 529 | DIN 2197 | 60° M







	T397	T396
Catalogue Code	T397	T396
Discount Group	D0702	D0702
Material	HSSE	HSSE
Surface Finish	*Brt*	*Blu*
Sutton Designation	N	N
Geometry	-	-
Chamfer	Bottoming	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 #
0250	M 2.5	x 0.45	45	5	-	2.80	2.24	5	2	2.05	T397 0250	•
0300	M 3	x 0.5	48	6	15	3.15	2.50	5	3	2.5	T397 0300	T396 0300
0350	M 3.5	x 0.6	50	6	17.5	3.55	2.80	5	3	2.9	T397 0350	T396 0350
0400	M 4	x 0.7	53	7	18	4.00	3.15	6	3	3.3	T397 0400	T396 0400
0500	M 5	x 0.8	58	8	22	5.00	4.00	7	3	4.2	T397 0500	T396 0500
0600	M 6	x 1	66	10	26	6.30	5.00	8	3	5.0	T397 0600	T396 0600
0800	M 8	x 1.25	72	13	30	8.00	6.30	9	3	6.8	T397 0800	T396 0800
1000	M 10	x 1.5	80	15	34	10.00	8.00	11	3	8.5	T397 1000	T396 1000
1200	M 12	x 1.75	89	18	-	9.00	7.10	10	3	10.2	T397 1200	T396 1200
1400	M 14	x 2	95	20	-	11.20	9.00	12	3	12.0	T397 1400	T396 1400
1600	M 16	x 2	102	20	-	12.50	10.00	13	3	14.0	T397 1600	T396 1600
1800	M 18	x 2.5	112	25	-	14.00	11.20	14	4	15.5	T397 1800	T396 1800
2000	M 20	x 2.5	112	25	-	14.00	11.20	14	4	17.5	T397 2000	T396 2000
2200	M 22*	x 2.5	118	38	-	16.00	12.50	16	4	19.5	T397 2200	T396 2200
2400	M 24*	x 3	130	45	-	18.00	14.00	18	4	21.0	T397 2400	T396 2400
3000	M 30*	x 3.5	138	48	-	20.00	16.00	20	4	26.5	T397 3000	T396 3000

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
T397	●	●	○	○		●								○	○				○	○			○	○	○	○		●	○	○																		○	
T396	●	●	●	●		●	○					○		○	○				○	○			○	○	○	○		●	○	○																		○	

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

● Optimal ○ Effective

*HSS >20mm • Available on request as special manufacture. Subject to lead time.

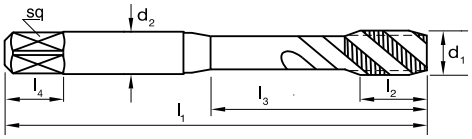
ISO Taps Metric, Spiral Flute, N

suttontools

- General purpose use
- Suitable for materials up to 1000N/mm²
- Blind holes
- Depths up to approx. 2.5 x d_1



ISO 529 | 60° M



Catalogue Code	**T398**
Discount Group	D0706
Material	**HSSE**
Surface Finish	***TiN***
Sutton Designation	**N**
Geometry	-
Chamfer	**Bottoming**
Limit & Nut Tolerance	ISO 2 / 6H

Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #
0250	**M 2.5**	x 0.45	45	5	-	2.80	2.24	5	2	2.05	•
0300	**M 3**	x 0.5	48	6	15	3.15	2.50	5	3	2.5	T398 0300
0350	**M 3.5**	x 0.6	50	6	17.5	3.55	2.80	5	3	2.9	•
0400	**M 4**	x 0.7	53	7	18	4.00	3.15	6	3	3.3	T398 0400
0500	**M 5**	x 0.8	58	8	22	5.00	4.00	7	3	4.2	T398 0500
0600	**M 6**	x 1	66	10	26	6.30	5.00	8	3	5.0	T398 0600
0800	**M 8**	x 1.25	72	13	30	8.00	6.30	9	3	6.8	T398 0800
1000	**M 10**	x 1.5	80	15	34	10.00	8.00	11	3	8.5	T398 1000
1200	**M 12**	x 1.75	89	18	-	9.00	7.10	10	3	10.2	T398 1200
1400	**M 14**	x 2	95	20	-	11.20	9.00	12	3	12.0	•
1600	**M 16**	x 2	102	20	-	12.50	10.00	13	3	14.0	T398 1600
1800	**M 18**	x 2.5	112	25	-	14.00	11.20	14	4	15.5	T398 1800
2000	**M 20**	x 2.5	112	25	-	14.00	11.20	14	4	17.5	T398 2000
2200	**M 22***	x 2.5	118	38	-	16.00	12.50	16	4	19.5	•
2400	**M 24***	x 3	130	45	-	18.00	14.00	18	4	21.0	•
3000	**M 30***	x 3.5	138	48	-	20.00	16.00	20	4	26.5	•

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
T398	●	●	●	●	○	●	●	○		○		○	○	○	○				○	○			○	○	○	○	○		○																			○	

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

● Optimal ○ Effective

*HSS >20mm • Available on request as special manufacture. Subject to lead time.

ISO Taps Metric, Forming, Single Coolant Groove

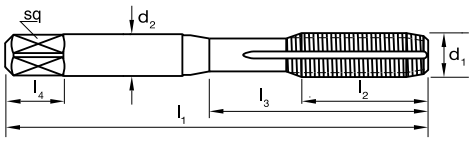
suttontools

- For cold forming of threads in materials with good flow characteristics
- Through or blind holes
- Depths up to approx. 1.5 x d_1
- TiN for longer tool life





ISO 529



Catalogue Code	T399	T400
Discount Group	D0702	D0706
Material	HSSE	HSSE
Surface Finish	*Brt*	*TiN*
Sutton Designation	N	N
Geometry	Single Coolant Groove ≥ M3	Single Coolant Groove ≥ M3
Chamfer	Short	Short
Limit & Nut Tolerance	GH4 / 6H	GH4 / 6H

Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
0250	M 2.5	x 0.45	45	10	-	2.80	2.24	5	-	2.3	T399 0250	•
0300	M 3	x 0.5	48	11	15	3.15	2.50	5	-	2.8	T399 0300	T400 0300
0350	M 3.5	x 0.6	50	13	17.5	3.55	2.80	5	-	3.2	T399 0350	•
0400	M 4	x 0.7	53	13	18	4.00	3.15	6	-	3.7	T399 0400	T400 0400
0500	M 5	x 0.8	58	16	22	5.00	4.00	7	-	4.6	T399 0500	T400 0500
0600	M 6	x 1	66	19	26	6.30	5.00	8	-	5.5	T399 0600	T400 0600
0800	M 8	x 1.25	72	22	30	8.00	6.30	9	-	7.4	T399 0800	•
1000	M 10	x 1.5	80	24	34	10.00	8.00	11	-	9.3	T399 1000	•
1200	M 12	x 1.75	89	29	-	9.00	7.10	10	-	11.2	T399 1200	•
											T637	
1005	MF 10	x 1	80	24	34	10.00	8.00	11	-	9.5	T637 1005	•
1206	MF 12	x 1.25	89	29	-	9.00	7.00	10	-	11.4	T637 1206	•

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
T399	●	●	○	○		●																	●	●	●	●		●		○																		
T400	●	●	○	○		●	○							○									●	●	○	○		●		○																		

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.

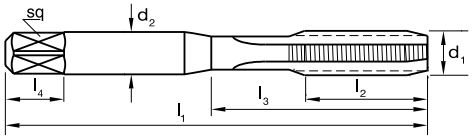
ISO Taps Metric Fine, Straight Flute, N

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 d_1







	T401	T402
Catalogue Code	T401	T402
Discount Group	D0702	D0702
Material	HSS	HSS
Surface Finish	*Brt*	*Brt*
Sutton Designation	N	N
Geometry	-	-
Chamfer	Taper	Intermediate
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	MF 5	x 0.5	58	16	22	5.0	4.0	7	4	4.5	•	•
0604	MF 6	x 0.75	66	19	26	6.3	5.0	8	4	5.3	•	•
0805	MF 8	x 1*	72	22	30	8.0	6.3	9	4	7.0	T401 0805	T402 0805
0804	MF 8	x 0.75	72	22	30	8.0	6.3	9	4	7.3	•	•
1004	MF 10	x 0.75	80	24	34	10.0	8.0	11	4	9.3	•	•
1005	MF 10	x 1†	80	24	34	10.0	8.0	11	4	9.0	T401 1005	T402 1005
1006	MF 10	x 1.25*	80	24	34	10.0	8.0	11	4	8.8	T401 1006	T402 1006
1205	MF 12	x 1	89	29	-	9.0	7.1	10	4	11.0	T401 1205	T402 1205
1206	MF 12	x 1.25	89	29	-	9.0	7.1	10	4	10.8	T401 1206	T402 1206
1207	MF 12	x 1.5*	89	29	-	9.0	7.1	10	4	10.5	T401 1207	T402 1207
1405	MF 14	x 1	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	T401 1406	T402 1406
1407	MF 14	x 1.5*	95	30	-	11.2	9.0	12	4	12.5	T401 1407	T402 1407
1605	MF 16	x 1	102	32	-	12.5	10.0	13	4	15.0	•	•
1606	MF 16	x 1.25	102	32	-	12.5	10.0	13	4	14.8	•	•
1607	MF 16	x 1.5*	102	32	-	12.5	10.0	13	4	14.5	T401 1607	T402 1607
1806	MF 18	x 1.25	112	37	-	14.0	11.2	14	4	16.8	•	•
1807	MF 18	x 1.5*	112	37	-	14.0	11.2	14	4	16.5	T401 1807	T402 1807
2006	MF 20	x 1.25	112	37	-	14.0	11.2	14	4	18.8	•	•
2007	MF 20	x 1.5**	112	37	-	14.0	11.2	14	4	18.5	T401 2007	T402 2007
2008	MF 20	x 2*	112	37	-	14.0	11.2	14	4	18.0	•	•
2207	MF 22	x 1.5	118	38	-	16.0	12.5	16	4	20.5	T401 2207	T402 2207
2208	MF 22	x 2	118	38	-	16.0	12.5	16	4	20.0	•	•
2407	MF 24	x 1.5	130	45	-	18.0	14.0	18	4	22.5	•	•
2408	MF 24	x 2*	130	45	-	18.0	14.0	18	4	22.0	T401 2408	T402 2408
2507	MF 25	x 1.5**	130	45	-	18.0	14.0	18	4	23.5	T401 2507	T402 2507
2708	MF 27	x 2	135	45	-	20.0	16.0	20	4	25.0	•	•
3007	MF 30	x 1.5	138	48	-	20.0	16.0	20	4	28.5	T401 3007	T402 3007
3008	MF 30	x 2	138	48	-	20.0	16.0	20	4	28.0	T401 3008	T402 3008
3207	MF 32	x 1.5**	151	51	-	22.4	18.0	22	4	30.5	T401 3207	T402 3207
4007	MF 40	x 1.5**	170	60	-	28.0	22.4	26	4	38.5	T401 4007	T402 4007
	Spark Plug											
1005	MF 10	x 1†	80	24	34	10.0	8.0	11	4	9.0	T401 1005	T402 1005
1206	MF 12	x 1.25	89	29	-	9.0	7.1	10	4	10.8	T401 1206	T402 1206
1406	MF 14	x 1.25†	95	30	-	11.2	9.0	12	4	12.8	T401 1406	T402 1406
1807	MF 18	x 1.5	112	37	-	14.0	11.2	14	4	16.5	T401 1807	T402 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	●	●	●	●		●	○										○		○		○		○	○	○	○		○		○																					
T402	●	●	●	●		●	○										○		○		○		○	○	○	○		○		○																					

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

● Optimal ○ Effective

* Alternative Metric Fine ** Conduit Metric • Available on request as special manufacture. Subject to lead time. † Limit & Nut Tolerance: ISO 1 / 4H

ISO Taps Metric Fine, Straight Flute, N

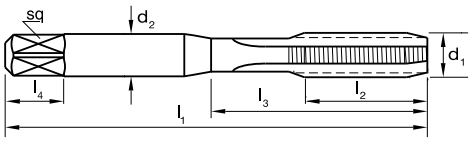
suttontools

- 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 d_1





ISO 529 | 60° MF



Catalogue Code	T403	T902
Discount Group	D0702	D0702
Material	HSS	HSS
Surface Finish	*Brt*	*Brt*
Sutton Designation	N	N
Geometry	-	-
Chamfer	Bottoming	Set
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	MF 5	x 0.5	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	•
0805	MF 8	x 1*	72	22	30	8.0	6.3	9	4	7.0	T403 0805	T902 0805
0804	MF 8	x 0.75	72	22	30	8.0	6.3	9	4	7.3	T403 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†	80	24	34	10.0	8.0	11	4	9.0	T403 1005	T902 1005
1006	MF 10	x 1.25*	80	24	34	10.0	8.0	11	4	8.8	T403 1006	T902 1006
1205	MF 12	x 1	89	29	-	9.0	7.1	10	4	11.0	T403 1205	•
1206	MF 12	x 1.25	89	29	-	9.0	7.1	10	4	10.8	T403 1206	T902 1206
1207	MF 12	x 1.5*	89	29	-	9.0	7.1	10	4	10.5	T403 1207	T902 1207
1405	MF 14	x 1	95	30	-	11.2	9.0	12	4	13.0	T403 1405	•
1406	MF14	x 1.25†	95	30	-	11.2	9.0	12	4	12.8	T403 1406	T902 1406
1407	MF 14	x 1.5*	95	30	-	11.2	9.0	12	4	12.5	T403 1407	T902 1407
1605	MF 16	x 1	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	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	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	T403 2007	T902 2007
2008	MF 20	x 2*	112	37	-	14.0	11.2	14	4	18.0	T403 2008	•
2207	MF 22	x 1.5	118	38	-	16.0	12.5	16	4	20.5	T403 2207	T902 2207
2208	MF 22	x 2	118	38	-	16.0	12.5	16	4	20.0	T403 2208	•
2407	MF 24	x 1.5	130	45	-	18.0	14.0	18	4	22.5	T403 2407	•
2408	MF 24	x 2*	130	45	-	18.0	14.0	18	4	22.0	T403 2408	T902 2408
2507	MF 25	x 1.5**	130	45	-	18.0	14.0	18	4	23.5	T403 2507	•
2708	MF 27	x 2	135	45	-	20.0	16.0	20	4	25.0	T403 2708	•
3007	MF 30	x 1.5	138	48	-	20.0	16.0	20	4	28.5	T403 3007	•
3008	MF 30	x 2	138	48	-	20.0	16.0	20	4	28.0	T403 3008	•
3207	MF 32	x 1.5**	151	51	-	22.4	18.0	22	4	30.5	T403 3207	•
4007	MF 40	x 1.5**	170	60	-	28.0	22.4	26	4	38.5	T403 4007	•
	Spark Plug											
1005	MF 10	x 1†	80	24	34	10.0	8.0	11	4	9.0	T403 1005	T902 1005
1206	MF 12	x 1.25	89	29	-	9.0	7.1	10	4	10.8	T403 1206	T902 1206
1406	MF 14	x 1.25†	95	30	-	11.2	9.0	12	4	12.8	T403 1406	T902 1406
1807	MF 18	x 1.5	112	37	-	14.0	11.2	14	4	16.5	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
T403	●	●	●	●		●	○										○		○		○		○	○	○	○		○		○																				
T902	●	●	●	●		●	○										○		○		○		○	○	○	○		○		○																				

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

● Optimal ○ Effective

* Alternative Metric Fine ** Conduit Metric • Available on request as special manufacture. Subject to lead time. † Limit & Nut Tolerance: ISO 1 / 4H

MF Finder

ISO Taps Metric Fine, Straight Flute, N

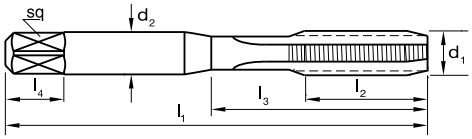
suttontools

- 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 d_1









	T404	T405
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	MF 5	x 0.5	58	16	22	5.0	4.0	7	4	4.5	•	•
0604	MF 6	x 0.75	66	19	26	6.3	5.0	8	4	5.3	•	•
0804	MF 8	x 0.75	72	22	30	8.0	6.3	9	4	7.3	•	•
1004	MF 10	x 0.75	80	24	34	10.0	8.0	11	4	9.3	•	•
1005	MF 10	x 1†	80	24	34	10.0	8.0	11	4	9.0		T405 1005*
1205	MF 12	x 1	89	29	-	9.0	7.1	10	4	11.0	•	•
1405	MF 14	x 1	95	30	-	11.2	9.0	12	4	13.0		•
1605	MF 16	x 1	102	32	-	12.5	10.0	13	4	15.0		•
1606	MF 16	x 1.25	102	32	-	12.5	10.0	13	4	14.8		•
1607	MF 16	x 1.5^	102	32	-	12.5	10.0	13	4	14.5	•	T405 1607*
1806	MF 18	x 1.25	112	37	-	14.0	11.2	14	4	16.8		•
1807	MF 18	x 1.5^	112	37	-	14.0	11.2	14	4	16.5	•	•
2006	MF 20	x 1.25	112	37	-	14.0	11.2	14	4	18.8		•
2007	MF 20	x 1.5^^	112	37	-	14.0	11.2	14	4	18.5	•	•
2008	MF 20	x 2^	112	37	-	14.0	11.2	14	4	18.0		•
2207	MF 22	x 1.5	118	38	-	16.0	12.5	16	4	20.5	•	•
2208	MF 22	x 2	118	38	-	16.0	12.5	16	4	20.0		•
2407	MF 24	x 1.5	130	45	-	18.0	14.0	18	4	22.5		•
2408	MF 24	x 2*	130	45	-	18.0	14.0	18	4	22.0	•	•
2507	MF 25	x 1.5^^	130	45	-	18.0	14.0	18	4	23.5	•	•
2708	MF 27	x 2	135	45	-	20.0	16.0	20	4	25.0		•
3007	MF 30	x 1.5	138	48	-	20.0	16.0	20	4	28.5	•	
3008	MF 30	x 2	138	48	-	20.0	16.0	20	4	28.0	•	•
3207	MF 32	x 1.5^^	151	51	-	22.4	18.0	22	4	30.5	•	•
4007	MF 40	x 1.5^^	170	60	-	28.0	22.4	26	4	38.5	•	•
	Spark Plug											
1005	MF 10	x 1†	80	24	34	10.0	8.0	11	4	9.0		T405 1005*

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	●	●	●	●	○	●	●	○		○		○		○			○		○		○		○	○	○	○		○	○	○																		
T405	●	●	●	●	○	●	●	○		○		○		○			○		○		○		○	○	○	○		○	○	○																		

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

● Optimal ○ Effective

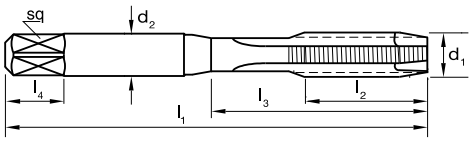
*Not available once current stock is depleted. • Available on request as special manufacture. Subject to lead time.
^ Alternative Metric Fine ^^ Conduit Metric † Limit & Nut Tolerance: ISO 1 / 4H

ISO Taps Metric Fine, Gun, N

suttontools

- General purpose use
- Suitable for materials up to 1000N/mm²
- Through holes
- Depths up to approx. 3 x d_1

ISO 529 | 60° MF







	T406	T407
Catalogue Code	T406	T407
Discount Group	D0702	D0702
Material	HSSE	HSSE
Surface Finish	*Brt*	*Blu*
Sutton Designation	N	N
Geometry	-	-
Chamfer	Intermediate	Intermediate
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	MF 5	x 0.5	58	16	22	5.0	4.0	7	3	4.5	•	T407 0503
0604	MF 6	x 0.75	66	19	26	6.3	5.0	8	3	5.3	•	T407 0604
0805	MF 8	x 1	72	22	30	8.0	6.3	9	3	7.0	T406 0805	T407 0805
1005	MF 10	x 1	80	24	34	10.0	8.0	11	3	9.0	•	T407 1005
1006	MF 10	x 1.25	80	24	34	10.0	8.0	11	3	8.8	T406 1006	T407 1006
1206	MF 12	x 1.25	89	29	-	9.0	7.1	10	3	10.8	•	T407 1206
1207	MF 12	x 1.5	89	29	-	9.0	7.1	10	3	10.5	T406 1207	T407 1207
1407	MF 14	x 1.5	95	30	-	11.2	9.0	12	3	12.5	•	T407 1407
1607	MF 16	x 1.5	102	32	-	12.5	10.0	13	3	14.5	•	T407 1607
1807	MF 18	x 1.5	112	37	-	14.0	11.2	14	4	16.5	•	T407 1807
2007	MF 20	x 1.5	112	37	-	14.0	11.2	14	4	18.5	•	T407 2007
2207	MF 22	x 1.5	118	38	-	16.0	12.5	16	4	20.5	•	T407 2207

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
T406	●	●	○	○		●	○							○	○				○	○	○		○	○	○	○		●	○																	○	
T407	●	●	●	●		●	○					○		○	○				○	○	○																									○	

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.

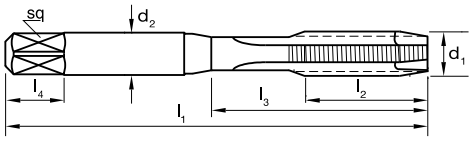
ISO Taps Metric Fine, Gun, N

suttontools

- General purpose use
- Suitable for materials up to 1000N/mm²
- Through holes
- Depths up to approx. 3 x d_1



ISO 529 | 60° MF



Catalogue Code	**T408**
Discount Group	D0706
Material	**HSSE**
Surface Finish	***TiN***
Sutton Designation	**N**
Geometry	-
Chamfer	**Intermediate**
Limit & Nut Tolerance	ISO 2 / 6H

Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #
0503	**MF 5**	x 0.5	58	16	22	5.0	4.0	7	3	4.5	•
0604	**MF 6**	x 0.75	66	19	26	6.3	5.0	8	3	5.3	•
0805	**MF 8**	x 1	72	22	30	8.0	6.3	9	3	7.0	T408 0805
1005	**MF 10**	x 1	80	24	34	10.0	8.0	11	3	9.0	•
1006	**MF 10**	x 1.25	80	24	34	10.0	8.0	11	3	8.8	T408 1006
1206	**MF 12**	x 1.25	89	29	-	9.0	7.1	10	3	10.8	•
1207	**MF 12**	x 1.5	89	29	-	9.0	7.1	10	3	10.5	T408 1207
1407	**MF 14**	x 1.5	95	30	-	11.2	9.0	12	3	12.5	•
1607	**MF 16**	x 1.5	102	32	-	12.5	10.0	13	3	14.5	•
1807	**MF 18**	x 1.5	112	37	-	14.0	11.2	14	4	16.5	•
2007	**MF 20**	x 1.5	112	37	-	14.0	11.2	14	4	18.5	•
2207	**MF 22**	x 1.5	118	38	-	16.0	12.5	16	4	20.5	•

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
T408	●	●	●	●	○	●	●	○		○		○	○	○	○				○	○	○		○	○	○	○	○	○	○																			○	

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.

ISO Taps Metric Fine, Spiral Flute, N

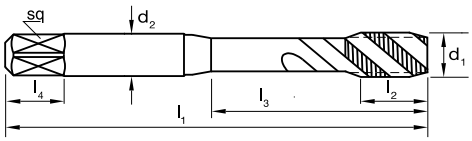
suttontools

- General purpose use
- Suitable for materials up to 1000N/mm²
- Blind holes
- Depths up to approx. 2.5 x d_1

ISO 529 | DIN 2197 | 60° MF







	T409	T411
Catalogue Code	T409	T411
Discount Group	D0702	D0706
Material	HSSE	HSSE
Surface Finish	*Brt*	*TiN*
Sutton Designation	N	N
Geometry	-	-
Chamfer	Bottoming	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	MF 5	x 0.5	58	16	22	5.0	4.0	7	3	4.5	T409 0503	•
0604	MF 6	x 0.75	66	19	26	6.3	5.0	8	3	5.3	T409 0604	•
0805	MF 8	x 1	72	22	30	8.0	6.3	9	3	7.0	T409 0805	T411 0805
1005	MF 10	x 1	80	24	34	10.0	8.0	11	3	9.0	T409 1005	•
1006	MF 10	x 1.25	80	24	34	10.0	8.0	11	3	8.8	T409 1006	T411 1006
1206	MF 12	x 1.25	89	29	-	9.0	7.1	10	3	10.8	T409 1206	•
1207	MF 12	x 1.5	89	29	-	9.0	7.1	10	3	10.5	T409 1207	T411 1207
1406	MF 14	x 1.25	95	30	-	11.2	9.0	12	3	12.8	T409 1406	•
1407	MF 14	x 1.5	95	30	-	11.2	9.0	12	3	12.5	T409 1407	•
1607	MF 16	x 1.5	102	32	-	12.5	10.0	13	3	14.5	T409 1607	•
1807	MF 18	x 1.5	112	37	-	14.0	11.2	14	4	16.5	T409 1807	•
2007	MF 20	x 1.5	112	37	-	14.0	11.2	14	4	18.5	T409 2007	•
2207	MF 22	x 1.5	118	38	-	16.0	12.5	16	4	20.5	T409 2207	•

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
T409	●	●	○	○		●								○	○				○	○			○	○	○	○		●	○	○																		○	
T411	●	●	●	●	○	●	●	○		○		○	○	○	○				○	○			○	○	○	○	○		○																		○	

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.

ISO Taps UNC, Straight Flute, N

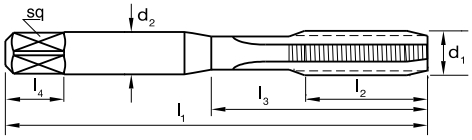
suttontools

- 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 d_1





ISO 529 | 60° UNC



	T414	T415
Catalogue Code	T414	T415
Discount Group	D0702	D0702
Material	HSS	HSS
Surface Finish	*Brt*	*Brt*
Sutton Designation	N	N
Geometry	-	-
Chamfer	Taper	Intermediate
Limit & Nut Tolerance	2B	2B

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	Limit	Item #	Item #
0251	#3	48	45	10	-	2.80	2.24	5	3	GH2	T414 0251	T415 0251
0284	#4	40	48	15	14.5	3.15	2.50	5	3	GH2	T414 0284	T415 0284
0318	#5	40	48	15	15	3.15	2.50	5	3	GH2	T414 0318	T415 0318
0351	#6	32	50	17	17.5	3.55	2.80	5	3	GH3	T414 0351	T415 0351
0417	#8	32	53	13	17	4.50	3.55	6	3	GH3	T414 0417	T415 0417
0476	3/16	24 (UNS)	58	16	22	5.00	4.00	7	3	GH4	T414 0476	T415 0476
0483	#10	24	58	16	22	5.00	4.00	7	3	GH4	T414 0483	T415 0483
0549	#12	24	62	17	23	5.60	4.50	7	3	GH4	T414 0549	T415 0549
0635	1/4	20	66	19	25	6.30	5.00	8	3	GH4	T414 0635	T415 0635
0636	1/4^	20	66	19	25	6.30	5.00	8	3	GH3	•	•
0794	5/16^	18	72	22	30	8.00	6.30	9	4	GH5	T414 0794	T415 0794
0953	3/8	16	80	24	33	10.00	8.00	11	4	GH5	T414 0953	T415 0953
1111	7/16	14	85	25	-	8.00	6.30	9	4	GH3	T414 1111	T415 1111
1270	1/2	13	89	29	-	9.00	7.10	10	4	GH6	T414 1270	T415 1270
1429	9/16	12	95	30	-	11.20	9.00	12	4	GH6	T414 1429	T415 1429
1588	5/8	11	102	32	-	12.50	10.00	13	4	GH6	T414 1588	T415 1588
1905	3/4	10	112	37	-	14.00	11.20	14	4	GH7	T414 1905	T415 1905
2223	7/8	9	118	38	-	16.00	12.50	16	4	GH7	T414 2223	T415 2223
2540	1	8	130	45	-	18.00	14.00	18	4	GH7	T414 2540	T415 2540
2858	1-1/8	7	138	48	-	20.00	16.00	20	4	GH8	T414 2858	T415 2858
3175	1-1/4	7	151	51	-	22.40	18.00	22	4	GH8	T414 3175	T415 3175
3810	1-1/2	6	170	60	-	28.00	22.40	26	4	GH8	T414 3810	T415 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
T414	●	●	●	●		●	○										○		○		○		○	○	○	○		○		○																					
T415	●	●	●	●		●	○										○		○		○		○	○	○	○		○		○																					

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

● Optimal ○ Effective

UNC Finder

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

ISO Taps UNC, Straight Flute, N

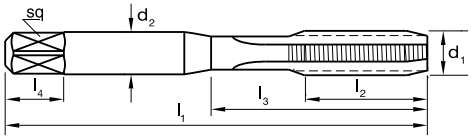
suttontools

- 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 d_1





ISO 529 | 60° UNC



	T416	T903
Catalogue Code	T416	T903
Discount Group	D0702	D0702
Material	HSS	HSS
Surface Finish	*Brt*	*Brt*
Sutton Designation	N	N
Geometry	-	-
Chamfer	Bottoming	Set
Limit & Nut Tolerance	2B	2B

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	Limit	Item #	Item #
0251	#3	48	45	10	-	2.80	2.24	5	3	GH2	T416 0251	•
0284	#4	40	48	15	14.5	3.15	2.50	5	3	GH2	T416 0284	T903 0284
0318	#5	40	48	15	15	3.15	2.50	5	3	GH2	T416 0318	T903 0318
0351	#6	32	50	17	17.5	3.55	2.80	5	3	GH3	T416 0351	T903 0351
0417	#8	32	53	13	17	4.50	3.55	6	3	GH3	T416 0417	T903 0417
0476	3/16	24 (UNS)	58	16	22	5.00	4.00	7	3	GH4	T416 0476	T903 0476
0483	#10	24	58	16	22	5.00	4.00	7	3	GH4	T416 0483	T903 0483
0549	#12	24	62	17	23	5.60	4.50	7	3	GH4	T416 0549	T903 0549
0635	1/4	20	66	19	25	6.30	5.00	8	3	GH4	T416 0635	T903 0635
0636	1/4^	20	66	19	25	6.30	5.00	8	3	GH3	T416 0636	•
0794	5/16^	18	72	22	30	8.00	6.30	9	4	GH5	T416 0794	T903 0794
0795	5/16	18	72	22	30	8.00	6.30	9	4	GH3	T416 0795	•
0953	3/8	16	80	24	33	10.00	8.00	11	4	GH5	T416 0953	T903 0953
1111	7/16	14	85	25	-	8.00	6.30	9	4	GH3	T416 1111	T903 1111
1270	1/2	13	89	29	-	9.00	7.10	10	4	GH6	T416 1270	T903 1270
1429	9/16	12	95	30	-	11.20	9.00	12	4	GH6	T416 1429	T903 1429
1588	5/8	11	102	32	-	12.50	10.00	13	4	GH6	T416 1588	T903 1588
1905	3/4	10	112	37	-	14.00	11.20	14	4	GH7	T416 1905	T903 1905
2223	7/8	9	118	38	-	16.00	12.50	16	4	GH7	T416 2223	T903 2223
2540	1	8	130	45	-	18.00	14.00	18	4	GH7	T416 2540	T903 2540
2858	1-1/8	7	138	48	-	20.00	16.00	20	4	GH8	T416 2858	•
3175	1-1/4	7	151	51	-	22.40	18.00	22	4	GH8	T416 3175	T903 3175
3810	1-1/2	6	170	60	-	28.00	22.40	26	4	GH8	T416 3810	T903 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
T416	●	●	●	●		●	○										○		○		○		○	○	○	○		○		○																				
T903	●	●	●	●		●	○										○		○		○		○	○	○	○		○		○																				

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

● Optimal ○ Effective

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

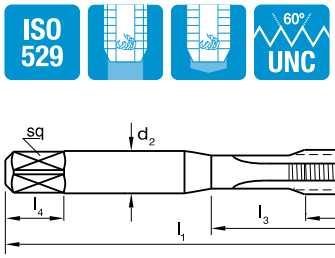
ISO Taps UNC, Straight Flute, N

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 d_1







	T417	T418
Catalogue Code	T417	T418
Discount Group	D0706	D0706
Material	HSS	HSS
Surface Finish	*TiN*	*TiN*
Sutton Designation	N	N
Geometry	-	-
Chamfer	Intermediate	Bottoming
Limit & Nut Tolerance	2B	2B

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	Limit	drill Ø	Item #	Item #
0251	#3	48	45	10	-	2.80	2.24	5	3	GH2	2.1	•	•
0284	#4	40	48	15	14.5	3.15	2.50	5	3	GH2	2.3	•	•
0318	#5	40	48	15	15	3.15	2.50	5	3	GH2	2.6	•	•
0351	#6	32	50	17	17.5	3.55	2.80	5	3	GH3	2.8	T417 0351*	T418 0351*
0476	3/16	24 (UNS)	58	16	22	5.00	4.00	7	3	GH4	3.7	•	•
0483	#10	24	58	16	22	5.00	4.00	7	3	GH4	3.8		T418 0483*
0549	#12	24	62	17	23	5.60	4.50	7	3	GH4	4.5	•	•
0635	1/4	20	66	19	25	6.30	5.00	8	3	GH4	5.1	T417 0635*	T418 0635*
0636	1/4^	20	66	19	25	6.30	5.00	8	3	GH3	5.1		•
0794	5/16^	18	72	22	30	8.00	6.30	9	4	GH3	6.6		•
0795	5/16	18	72	22	30	8.00	6.30	9	4	GH5	6.6	T417 0794*	
0953	3/8	16	80	24	33	10.00	8.00	11	4	GH5	8.0	T417 0953*	
1429	9/16	12	95	30	-	11.20	9.00	12	4	GH6	12.2	•	•
1588	5/8	11	102	32	-	12.50	10.00	13	4	GH6	13.5	T417 1588*	T418 1588*
1905	3/4	10	112	37	-	14.00	11.20	14	4	GH7	16.5	T417 1905*	T418 1905*
2223	7/8	9	118	38	-	16.00	12.50	16	4	GH7	19.5	•	•
2540	1	8	130	45	-	18.00	14.00	18	4	GH7	22.2	•	•
2858	1-1/8	7	138	48	-	20.00	16.00	20	4	GH8	25.0	•	•
3175	1-1/4	7	151	51	-	22.40	18.00	22	4	GH8	28.0	•	•
3810	1-1/2	6	170	60	-	28.00	22.40	26	4	GH8	34.0	•	•

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	●	●	●	●	○	●	●	○		○		○		○			○		○		○		○	○	○	○		○	○	○																		
T418	●	●	●	●	○	●	●	○		○		○		○			○		○		○		○	○	○	○		○	○	○																		

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

● Optimal ○ Effective

*Not available once current stock is depleted. • Available on request as special manufacture. Subject to lead time. ^ Alternative Limit

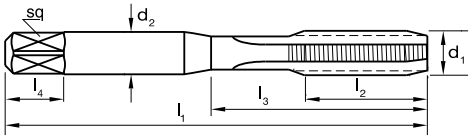
ISO Taps UNC, Straight Flute, N, Left Hand

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 d_1







Catalogue Code	T419	T420
Discount Group	D0702	D0702
Material	HSS	HSS
Surface Finish	*Brt*	*Brt*
Sutton Designation	N	N
Geometry	Left Hand	Left Hand
Chamfer	Taper	Intermediate
Nut Tolerance	2B LH	2B LH

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	Limit	drill Ø	Item #	Item #
0635	1/4	20	66	19	25	6.30	5.00	8	3	GH4	5.1	T419 0635	T420 0635
0794	5/16	18	72	22	30	8.00	6.30	9	4	GH5	6.6	T419 0794	T420 0794
0953	3/8	16	80	24	33	10.00	8.00	11	4	GH5	8.0	T419 0953	T420 0953
1111	7/16	14	85	25	-	8.00	6.30	9	4	GH5	9.4	T419 1111	T420 1111
1270	1/2	13	89	29	-	9.00	7.10	10	4	GH6	10.8	T419 1270	T420 1270
1429	9/16	12	95	30	-	11.20	9.00	12	4	GH6	12.2	T419 1429	T420 1429
1588	5/8	11	102	32	-	12.50	10.00	13	4	GH6	13.5	T419 1588	T420 1588
1905	3/4	10	112	37	-	14.00	11.20	14	4	GH7	16.5	T419 1905	T420 1905
2223	7/8	9	118	38	-	16.00	12.50	16	4	GH7	19.5	•	•
2540	1	8	130	45	-	18.00	14.00	18	4	GH7	22.2	•	•
2858	1-1/8	7	138	48	-	20.00	16.00	20	4	GH8	25.0	•	•
3175	1-1/4	7	151	51	-	22.40	18.00	22	4	GH8	28.0	•	•
3810	1-1/2	6	170	60	-	28.00	22.40	26	4	GH8	34.0	•	•

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	●	●	●	●		●	○										○		○		○		○	○	○	○		○		○																			
T420	●	●	●	●		●	○										○		○		○		○	○	○	○		○		○																			

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

● Optimal ○ Effective

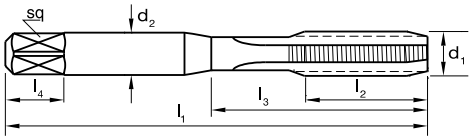
• Available on request as special manufacture. Subject to lead time.

ISO Taps UNC, 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 d_1





Catalogue Code	**T421**
Discount Group	D0702
Material	**HSS**
Surface Finish	***Brt***
Sutton Designation	**N**
Geometry	Left Hand
Chamfer	**Bottoming**
Nut Tolerance	2B LH

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	Limit drill Ø		Item #
0635	1/4	20	66	19	25	6.30	5.00	8	3	GH4	5.1	T421 0635
0794	5/16	18	72	22	30	8.00	6.30	9	4	GH5	6.6	T421 0794
0953	3/8	16	80	24	33	10.00	8.00	11	4	GH5	8.0	T421 0953
1111	7/16	14	85	25	-	8.00	6.30	9	4	GH5	9.4	T421 1111
1270	1/2	13	89	29	-	9.00	7.10	10	4	GH6	10.8	T421 1270
1429	9/16	12	95	30	-	11.20	9.00	12	4	GH6	12.2	T421 1429
1588	5/8	11	102	32	-	12.50	10.00	13	4	GH6	13.5	T421 1588
1905	3/4	10	112	37	-	14.00	11.20	14	4	GH7	16.5	T421 1905
2223	7/8	9	118	38	-	16.00	12.50	16	4	GH7	19.5	•
2540	1	8	130	45	-	18.00	14.00	18	4	GH7	22.2	•
2858	1-1/8	7	138	48	-	20.00	16.00	20	4	GH8	25.0	•
3175	1-1/4	7	151	51	-	22.40	18.00	22	4	GH8	28.0	•
3810	1-1/2	6	170	60	-	28.00	22.40	26	4	GH8	34.0	•

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
T421	●	●	●	●		●	○										○		○		○		○	○	○	○		○		○																			

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

● Optimal ○ Effective

UNC Finder

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

ISO Taps UNC, Gun, N

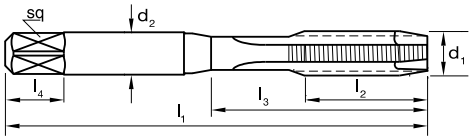
suttontools

- General purpose use
- Suitable for materials up to 1000N/mm²
- Through holes
- Depths up to approx. 3 x d_1

ISO 529 | 60° UNC







Catalogue Code	T422	T423
Discount Group	D0702	D0702
Material	HSSE	HSSE
Surface Finish	*Brt*	*Blu*
Sutton Designation	N	N
Geometry	-	-
Chamfer	Intermediate	Intermediate
Nut Tolerance	2B	2B

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	Limit drill Ø		Item #	Item #
0284	#4	40	48	15	14.5	3.15	2.50	5	2	GH2	2.3	T422 0284	T423 0284
0351	#6	32	50	17	17.5	3.55	2.80	5	3	GH3	2.8	T422 0351	T423 0351
0417	#8	32	53	13	18	4.50	3.55	6	3	GH3	3.4	T422 0417	T423 0417
0483	#10	24	58	16	22	5.00	4.00	7	3	GH4	3.8	T422 0483	T423 0483
0549	#12	24	62	17	23	5.60	4.50	7	3	GH4	4.5	•	T423 0549
0635	1/4	20	66	19	25	6.30	5.00	8	3	GH4	5.1	T422 0635	T423 0635
0794	5/16	18	72	22	30	8.00	6.30	9	3	GH5	6.6	T422 0794	T423 0794
0953	3/8	16	80	24	33	10.00	8.00	11	3	GH5	8.0	T422 0953	T423 0953
1111	7/16	14	85	25	-	8.00	6.30	9	3	GH5	9.4	T422 1111	T423 1111
1270	1/2	13	89	29	-	9.00	7.10	10	3	GH6	10.8	T422 1270	T423 1270
1588	5/8	11	102	32	-	12.50	10.00	13	3	GH6	13.5	T422 1588	T423 1588
1905	3/4	10	112	37	-	14.00	11.20	14	4	GH7	16.5	T422 1905	T423 1905
2223	7/8	9	118	38	-	16.00	12.50	16	4	GH7	19.5	•	T423 2223
2540	1	8	130	45	-	18.00	14.00	18	4	GH7	22.2	•	T423 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
T422	●	●	○	○		●	○							○	○				○	○	○		○	○	○	○		●	○																		○	
T423	●	●	●	●		●	○					○		○	○				○	○	○																										○	

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

● Optimal ○ Effective

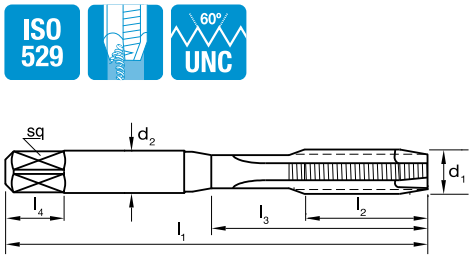
• Available on request as special manufacture. Subject to lead time.

ISO Taps UNC, Gun, N

suttontools

- General purpose use
- Suitable for materials up to 1000N/mm²
- Through holes
- Depths up to approx. 3 x d_1





Catalogue Code	**T424**
Discount Group	D0706
Material	**HSSE**
Surface Finish	***TiN***
Sutton Designation	**N**
Geometry	-
Chamfer	**Intermediate**
Nut Tolerance	2B

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	Limit drill Ø		Item #
0284	#4	40	48	15	14.5	3.15	2.50	5	2	GH2	2.3	•
0351	#6	32	50	17	17.5	3.55	2.80	5	3	GH3	2.8	T424 0351
0417	#8	32	53	13	18	4.50	3.55	6	3	GH3	3.4	T424 0417
0483	#10	24	58	16	22	5.00	4.00	7	3	GH4	3.8	T424 0483
0549	#12	24	62	17	23	5.60	4.50	7	3	GH4	4.5	•
0635	1/4	20	66	19	25	6.30	5.00	8	3	GH4	5.1	T424 0635
0794	5/16	18	72	22	30	8.00	6.30	9	3	GH5	6.6	T424 0794
0953	3/8	16	80	24	33	10.00	8.00	11	3	GH5	8.0	T424 0953
1111	7/16	14	85	25	-	8.00	6.30	9	3	GH5	9.4	•
1270	1/2	13	89	29	-	9.00	7.10	10	3	GH6	10.8	T424 1270
1588	5/8	11	102	32	-	12.50	10.00	13	3	GH6	13.5	T424 1588
1905	3/4	10	112	37	-	14.00	11.20	14	4	GH7	16.5	T424 1905
2223	7/8	9	118	38	-	16.00	12.50	16	4	GH7	19.5	•
2540	1	8	130	45	-	18.00	14.00	18	4	GH7	22.2	•

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
T424	●	●	●	●	○	●	●	○		○		○	○	○	○				○	○	○		○	○	○	○	○	○	○																			○	

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

● Optimal ○ Effective

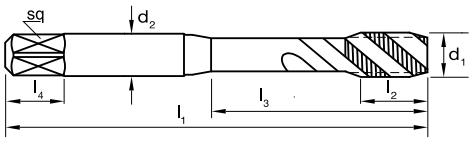
• Available on request as special manufacture. Subject to lead time.

ISO Taps UNC, Spiral Flute, N

suttontools

- General purpose use
- Suitable for materials up to 1000N/mm²
- Blind holes
- Depths up to approx. 2.5 x d_1

ISO 529 | DIN 2197 | 60° UNC







	T425	T426
Catalogue Code	T425	T426
Discount Group	D0702	D0702
Material	HSSE	HSSE
Surface Finish	*Brt*	*Blu*
Sutton Designation	N	N
Geometry	-	-
Chamfer	Bottoming	Bottoming
Nut Tolerance	2B	2B

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	Limit drill Ø		Item #	Item #
0218	#2	56	41	8	-	2.5	2.0	-	2	GH2	1.85	T425 0218	•
0284	#4	40	48	6	-	3.15	2.50	5	3	GH2	2.3	T425 0284	•
0351	#6	32	50	6	-	3.55	2.80	5	3	GH3	2.8	T425 0351	•
0417	#8	32	53	8	18	4.50	3.55	6	3	GH3	3.4	T425 0417	•
0483	#10	24	58	11	22	5.00	4.00	7	3	GH4	3.8	T425 0483	•
0635	1/4	20	66	10	25	6.30	5.00	8	3	GH4	5.1	T425 0635	T426 0635
0794	5/16	18	72	13	30	8.00	6.30	9	3	GH5	6.6	T425 0794	T426 0794
0953	3/8	16	80	16	33	10.00	8.00	11	3	GH5	8.0	T425 0953	T426 0953
1111	7/16	14	85	18	-	8.00	6.30	9	3	GH5	9.4	T425 1111	T426 1111
1270	1/2	13	89	20	-	9.00	7.10	10	3	GH6	10.8	T425 1270	T426 1270
1588	5/8	11	102	20	-	12.50	10.00	13	3	GH6	13.5	T425 1588	T426 1588
1905	3/4	10	112	25	-	14.00	11.20	14	4	GH7	16.5	T425 1905	T426 1905
2223	7/8	9	118	38	-	16.00	12.50	16	4	GH7	19.5	T425 2223	•
2540	1	8	130	45	-	18.00	14.00	18	4	GH7	22.2	T425 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
T425	●	●	○	○		●								○	○				○	○			○	○	○	○		●	○	○																	○	
T426	●	●	●	●		●	○					○		○	○				○	○																											○	

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

● Optimal ○ Effective

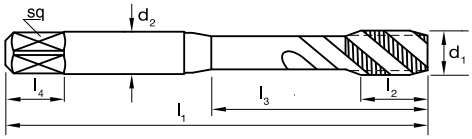
• Available on request as special manufacture. Subject to lead time.

ISO Taps UNC, Spiral Flute, N

suttontools

- General purpose use
- Suitable for materials up to 1000N/mm²
- Blind holes
- Depths up to approx. 2.5 x d_1





Catalogue Code	**T427**
Discount Group	D0706
Material	**HSSE**
Surface Finish	***TiN***
Sutton Designation	**N**
Geometry	-
Chamfer	**Bottoming**
Nut Tolerance	2B

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	Limit drill Ø		Item #
0218	#2	56	41	8	-	2.5	2.0	-	2	GH2	1.85	•
0284	#4	40	48	6	-	3.15	2.50	5	3	GH2	2.3	•
0351	#6	32	50	6	-	3.55	2.80	5	3	GH3	2.8	•
0417	#8	32	53	8	18	4.50	3.55	6	3	GH3	3.4	•
0483	#10	24	58	11	22	5.00	4.00	7	3	GH4	3.8	T427 0483
0635	1/4	20	66	10	25	6.30	5.00	8	3	GH4	5.1	T427 0635
0794	5/16	18	72	13	30	8.00	6.30	9	3	GH5	6.6	T427 0794
0953	3/8	16	80	16	33	10.00	8.00	11	3	GH5	8.0	T427 0953
1111	7/16	14	85	18	-	8.00	6.30	9	3	GH5	9.4	T427 1111
1270	1/2	13	89	20	-	9.00	7.10	10	3	GH6	10.8	T427 1270
1588	5/8	11	102	20	-	12.50	10.00	13	3	GH6	13.5	T427 1588
1905	3/4	10	112	25	-	14.00	11.20	14	4	GH7	16.5	T427 1905
2223	7/8	9	118	38	-	16.00	12.50	16	4	GH7	19.5	•
2540	1	8	130	45	-	18.00	14.00	18	4	GH7	22.2	•

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
T427	●	●	●	●	○	●	●	○		○		○	○	○	○				○	○			○	○	○	○	○		○																			○	

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.

ISO Taps UNC, Forming, Single Coolant Groove

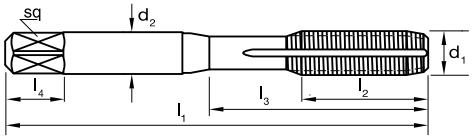
suttontools

- For cold forming of threads in materials with good flow characteristics
- Through or blind holes
- Depths up to approx. 1.5 x d_1
- TiN for longer tool life





ISO 529 | 60° UNC



Catalogue Code	T428	T429
Discount Group	D0702	D0706
Material	HSSE	HSSE
Surface Finish	*Brt*	*TiN*
Sutton Designation	N	N
Geometry	Single Coolant Groove	Single Coolant Groove
Chamfer	Short	Short
Nut Tolerance	2B	2B

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	Limit drill Ø		Item #	Item #
0318	#5	40	48	15	15	3.15	2.50	5	-	GH5	2.9	T428 0318	•
0351	#6	32	50	17	17.5	3.55	2.80	5	-	GH6	3.2	T428 0351	T429 0351
0417	#8	32	53	13	18	4.50	3.55	6	-	GH6	3.8	T428 0417	T429 0417
0483	#10	24	58	16	22	5.00	4.00	7	-	GH6	4.4	T428 0483	T429 0483
0635	1/4	20	66	19	25	6.30	5.00	8	-	GH7	5.8	T428 0635	T429 0635
0794	5/16	18	72	22	30	8.00	6.30	9	-	GH7	7.3	T428 0794	•
0953	3/8	16	80	24	33	10.00	8.00	11	-	GH7	8.8	T428 0953	•
1270	1/2	13	89	29	-	9.00	7.10	10	-	GH8	11.7	T428 1270	•

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
T428	●	●	○	○		●																	●	●	●	●		●		○																					
T429	●	●	○	○		●	○							○									●	●	○	○		●		○																					

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.

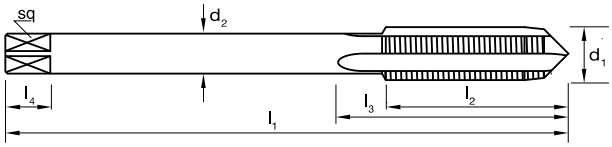
ISO Taps UNC, Machine Nut, Long Shank

suttontools

- Suited to long reach applications
- Suitable for materials up to 1000N/mm²
- Through holes
- Depths up to approx. 2 x d_1



BS 949 | 60° UNC



Catalogue Code	**T430**
Discount Group	D0702
Material	**HSS**
Surface Finish	***Brt***
Sutton Designation	**Nut**
Geometry	Extra Length
Chamfer	**Bottoming**
Nut Tolerance	2B

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	Limit drill Ø		Item #
0635	1/4	20	110	38	-	4.5	3.55	6	4	GH4	5.1	T430 0635
0794	5/16	18	125	43	-	6	4.5	7	4	GH5	6.6	T430 0794
0953	3/8	16	140	48	-	7	5.6	8	4	GH5	8.0	T430 0953
1270	1/2	13	180	59	-	9.5	7.5	10	4	GH6	10.8	T430 1270

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
T430	●	●	●	●		●	○							○			○		○		○		○	○	○	○		○		○																				

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

● Optimal ○ Effective

UNC Finder

ISO Taps UNF, Straight Flute, N

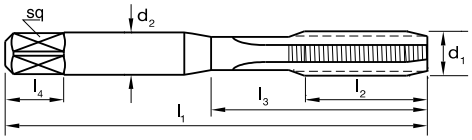
suttontools

- 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 d_1

ISO 529 | 60° UNF







	T431	T432
Catalogue Code	T431	T432
Discount Group	D0702	D0702
Material	HSS	HSS
Surface Finish	*Brt*	*Brt*
Sutton Designation	N	N
Geometry	-	-
Chamfer	Taper	Intermediate
Nut Tolerance	2B	2B

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
0251	#3	56	45	10	-	2.80	2.24	5	3	2.1	T431 0251	T432 0251
0284	#4	48	48	15	14.5	3.15	2.50	5	3	2.35	T431 0284	T432 0284
0318	#5	44	48	15	15	3.15	2.50	5	3	2.65	T431 0318	T432 0318
0351	#6	40	50	17	17.5	3.55	2.80	5	3	2.9	T431 0351	T432 0351
0417	#8	36	53	13	17	4.50	3.55	6	3	3.5	T431 0417	T432 0417
0476	3/16	32 (UNS)	58	16	22	5.00	4.00	7	3	4.0	T431 0476	T432 0476
0483	#10	32	58	16	22	5.00	4.00	7	3	4.1	T431 0483	T432 0483
0549	#12	28	62	17	23	5.60	4.50	7	3	4.6	T431 0549	T432 0549
0635	1/4	28	66	19	25	6.30	5.00	8	3	5.5	T431 0635	T432 0635
0794	5/16	24	72	22	30	8.00	6.30	9	4	6.9	T431 0794	T432 0794
0953	3/8	24	80	24	33	10.00	8.00	11	4	8.5	T431 0953	T432 0953
1111	7/16	20	85	25	-	8.00	6.30	9	4	9.8	T431 1111	T432 1111
1270	1/2	20	89	29	-	9.00	7.10	10	4	11.5	T431 1270	T432 1270
1429	9/16	18	95	30	-	11.20	9.00	12	4	12.8	T431 1429	T432 1429
1588	5/8	18	102	32	-	12.50	10.00	13	4	14.5	T431 1588	T432 1588
1905	3/4	16	112	37	-	14.00	11.20	14	4	17.5	T431 1905	T432 1905
2223	7/8	14	118	38	-	16.00	12.50	16	4	20.5	T431 2223	T432 2223
2540	1	12	130	45	-	18.00	14.00	18	4	23.5	T431 2540	T432 2540
2541	1	14 (UNS)	130	45	-	18.00	14.00	18	4	24.0	T431 2541	T432 2541
2858	1-1/8	12	138	48	-	20.00	16.00	20	4	26.5	T431 2858	T432 2858
3175	1-1/4	12	151	51	-	22.40	18.00	22	4	29.5	T431 3175	T432 3175
3810	1-1/2	12	170	60	-	28.00	22.40	26	4	36.0	T431 3810	T432 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	●	●	●	●		●	○										○		○		○		○	○	○	○		○		○																				
T432	●	●	●	●		●	○										○		○		○		○	○	○	○		○		○																				

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

● Optimal ○ Effective

UNF Finder

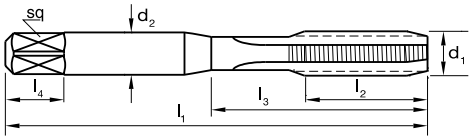
ISO Taps UNF, Straight Flute, N

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 d_1







	T433	T904
Catalogue Code	T433	T904
Discount Group	D0702	D0702
Material	HSS	HSS
Surface Finish	*Brt*	*Brt*
Sutton Designation	N	N
Geometry	-	-
Chamfer	Bottoming	Set
Nut Tolerance	2B	2B

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
0251	#3	56	45	10	-	2.80	2.24	5	3	2.1	T433 0251	•
0284	#4	48	48	15	14.5	3.15	2.50	5	3	2.35	T433 0284	T904 0284
0318	#5	44	48	15	15	3.15	2.50	5	3	2.65	T433 0318	T904 0318
0351	#6	40	50	17	17.5	3.55	2.80	5	3	2.9	T433 0351	T904 0351
0417	#8	36	53	13	17	4.50	3.55	6	3	3.5	T433 0417	T904 0417
0476	3/16	32 (UNS)	58	16	22	5.00	4.00	7	3	4.0	T433 0476	T904 0476
0483	#10	32	58	16	22	5.00	4.00	7	3	4.1	T433 0483	T904 0483
0549	#12	28	62	17	23	5.60	4.50	7	3	4.6	T433 0549	T904 0549
0635	1/4	28	66	19	25	6.30	5.00	8	3	5.5	T433 0635	T904 0635
0794	5/16	24	72	22	30	8.00	6.30	9	4	6.9	T433 0794	T904 0794
0953	3/8	24	80	24	33	10.00	8.00	11	4	8.5	T433 0953	T904 0953
1111	7/16	20	85	25	-	8.00	6.30	9	4	9.8	T433 1111	T904 1111
1270	1/2	20	89	29	-	9.00	7.10	10	4	11.5	T433 1270	T904 1270
1429	9/16	18	95	30	-	11.20	9.00	12	4	12.8	T433 1429	T904 1429
1588	5/8	18	102	32	-	12.50	10.00	13	4	14.5	T433 1588	T904 1588
1905	3/4	16	112	37	-	14.00	11.20	14	4	17.5	T433 1905	T904 1905
2223	7/8	14	118	38	-	16.00	12.50	16	4	20.5	T433 2223	T904 2223
2540	1	12	130	45	-	18.00	14.00	18	4	23.5	T433 2540	T904 2540
2541	1	14 (UNS)	130	45	-	18.00	14.00	18	4	24.0	T433 2541	T904 2541
2858	1-1/8	12	138	48	-	20.00	16.00	20	4	26.5	T433 2858	•
3175	1-1/4	12	151	51	-	22.40	18.00	22	4	29.5	T433 3175	•
3810	1-1/2	12	170	60	-	28.00	22.40	26	4	36.0	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
T433	●	●	●	●		●	○										○		○		○		○	○	○	○		○		○																			
T904	●	●	●	●		●	○										○		○		○		○	○	○	○		○		○																			

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.

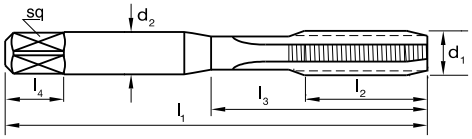
ISO Taps UNF, Straight Flute, N

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 d_1







	T434	T435
Catalogue Code	T434	T435
Discount Group	D0706	D0706
Material	HSS	HSS
Surface Finish	*TiN*	*TiN*
Sutton Designation	N	N
Geometry	-	-
Chamfer	Intermediate	Bottoming
Nut Tolerance	2B	2B

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	Limit drill Ø		Item #	Item #
0251	#3	56	45	10	-	2.80	2.24	5	3	GH2	2.1	•	•
0284	#4	48	48	15	14.5	3.15	2.50	5	3	GH2	2.35	•	•
0318	#5	44	48	15	15	3.15	2.50	5	3	GH2	2.65	•	•
0351	#6	40	50	17	17.5	3.55	2.80	5	3	GH2	2.9	•	•
0417	#8	36	53	13	18	4.50	3.55	6	3	GH2	3.5	•	•
0476	3/16	32 (UNS)	58	16	22	5.00	4.00	7	3	GH3	4.0	•	•
0549	#12	28	62	17	23	5.60	4.50	7	3	GH3	4.6	•	•
0635	1/4	28	66	19	25	6.30	5.00	8	3	GH3	5.5		T435 0635*
1429	9/16	18	95	30	-	11.20	9.00	12	4	GH5	12.8	•	•
1905	3/4	16	112	37	-	14.00	11.20	14	4	GH6	17.5		T435 1905*
2223	7/8	14	118	38	-	16.00	12.50	16	4	GH6	20.5	•	•
2540	1	12	130	45	-	18.00	14.00	18	4	GH7	23.5	•	•
2541	1	14 (UNS)	130	45	-	18.00	14.00	18	4	GH5	24.0	•	•
2858	1-1/8	12	138	48	-	20.00	16.00	20	4	GH7	26.5	•	•
3175	1-1/4	12	151	51	-	22.40	18.00	22	4	GH7	29.5	•	•
3810	1-1/2	12	170	60	-	28.00	22.40	26	4	GH7	36.0	•	•

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	●	●	●	●	○	●	●	○		○		○		○			○		○		○		○	○	○	○		○	○	○																		
T435	●	●	●	●	○	●	●	○		○		○		○			○		○		○		○	○	○	○		○	○	○																		

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

● Optimal ○ Effective

*Not available once current stock is depleted. • Available on request as special manufacture. Subject to lead time.

ISO Taps UNF, Straight Flute, N, Left Hand

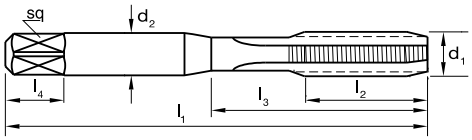
suttontools

- 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 d_1





ISO 529 | 60° UNF



	T436	T437
Catalogue Code	T436	T437
Discount Group	D0702	D0702
Material	HSS	HSS
Surface Finish	*Brt*	*Brt*
Sutton Designation	N	N
Geometry	Left Hand	Left Hand
Chamfer	Taper	Intermediate
Nut Tolerance	2B LH	2B LH

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	Limit	drill Ø	Item #	Item #
0635	1/4	28	66	19	25	6.30	5.00	8	3	GH3	5.5	T436 0635	T437 0635
0794	5/16	24	72	22	30	8.00	6.30	9	4	GH4	6.9	T436 0794	T437 0794
0953	3/8	24	80	24	33	10.00	8.00	11	4	GH4	8.5	T436 0953	T437 0953
1111	7/16	20	85	25	-	8.00	6.30	9	4	GH5	9.8	T436 1111	T437 1111
1270	1/2	20	89	29	-	9.00	7.10	10	4	GH5	11.5	T436 1270	T437 1270
1429	9/16	18	95	30	-	11.20	9.00	12	4	GH5	12.8	T436 1429	T437 1429
1588	5/8	18	102	32	-	12.50	10.00	13	4	GH5	14.5	T436 1588	T437 1588
1905	3/4	16	112	37	-	14.00	11.20	14	4	GH6	17.5	T436 1905	T437 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
T436	●	●	●	●		●	○										○		○		○		○	○	○	○		○		○																					
T437	●	●	●	●		●	○										○		○		○		○	○	○	○		○		○																					

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

● Optimal ○ Effective

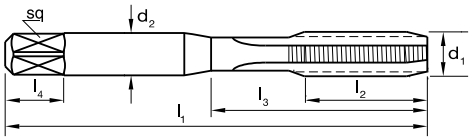
ISO Taps UNF, Straight Flute, N, Left Hand

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 d_1



ISO 529 | 60° UNF



Catalogue Code	**T438**
Discount Group	D0702
Material	**HSS**
Surface Finish	***Brt***
Sutton Designation	**N**
Geometry	Left Hand
Chamfer	**Bottoming**
Nut Tolerance	2B LH

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	Limit drill Ø		Item #
0635	1/4	28	66	19	25	6.30	5.00	8	3	GH3	5.5	T438 0635
0794	5/16	24	72	22	30	8.00	6.30	9	4	GH4	6.9	T438 0794
0953	3/8	24	80	24	33	10.00	8.00	11	4	GH4	8.5	T438 0953
1111	7/16	20	85	25	-	8.00	6.30	9	4	GH5	9.8	T438 1111
1270	1/2	20	89	29	-	9.00	7.10	10	4	GH5	11.5	T438 1270
1429	9/16	18	95	30	-	11.20	9.00	12	4	GH5	12.8	T438 1429
1588	5/8	18	102	32	-	12.50	10.00	13	4	GH5	14.5	T438 1588
1905	3/4	16	112	37	-	14.00	11.20	14	4	GH6	17.5	T438 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
T438	●	●	●	●		●	○										○		○		○		○	○	○	○		○		○																				

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

● Optimal ○ Effective

UNF Finder

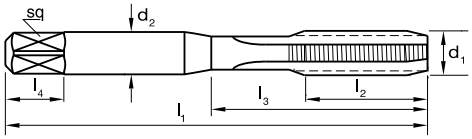
ISO Taps UNEF, Straight Flute, N

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 d_1







	T445	T446
Catalogue Code	T445	T446
Discount Group	D0702	D0702
Material	HSS	HSS
Surface Finish	*Brt*	*Brt*
Sutton Designation	N	N
Geometry	Extra Fine	Extra Fine
Chamfer	Taper	Intermediate
Nut Tolerance	2B	2B

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	Limit drill Ø		Item #	Item #
	UNEF Series												
0635	1/4	32	66	19	25	6.30	5.00	8	3	GH3	5.6	T445 0635	T446 0635
0794	5/16	32	72	22	30	8.00	6.30	9	4	GH4	7.2	T445 0794	T446 0794
0953	3/8	32	80	24	33	10.00	8.00	11	4	GH4	8.8	T445 0953	T446 0953
1270	1/2	28	89	29	-	9.00	7.10	10	4	GH5	11.8	T445 1270	T446 1270
1588	5/8	24	102	32	-	12.50	10.00	13	4	GH5	14.75	T445 1588	T446 1588
1905	3/4	20	112	37	-	14.00	11.20	14	4	GH6	18.0	T445 1905	T446 1905
2540	1	20	130	45	-	18.00	14.00	18	4	GH7	24.2	T445 2540	T446 2540
	Tyre Valve Tap (UNS)												
0533	5V1	36	62	17	23	5.60	4.50	7	3		4.6	•	•
	Stitching Tap												
0655	#1		64	36	-	8.08	6.15	9.5	4		5.0	•	•

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	●	●	●	●		●	○										○		○		○		○	○	○	○		○		○																			
T446	●	●	●	●		●	○										○		○		○		○	○	○	○		○		○																			

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

● Optimal ○ Effective

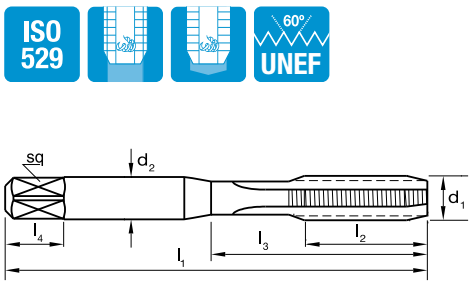
• Available on request as special manufacture. Subject to lead time.

ISO Taps UNEF, 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 d_1





Catalogue Code	**T447**
Discount Group	D0702
Material	**HSS**
Surface Finish	***Brt***
Sutton Designation	**N**
Geometry	Extra Fine
Chamfer	**Bottoming**
Nut Tolerance	2B

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	Limit drill Ø		Item #
	UNEF Series											
0635	**1/4**	32	66	19	25	6.30	5.00	8	3	GH3	5.6	T447 0635
0794	**5/16**	32	72	22	30	8.00	6.30	9	4	GH4	7.2	T447 0794
0953	**3/8**	32	80	24	33	10.00	8.00	11	4	GH4	8.8	T447 0953
1270	**1/2**	28	89	29	-	9.00	7.10	10	4	GH5	11.8	T447 1270
1588	**5/8**	24	102	32	-	12.50	10.00	13	4	GH5	14.75	T447 1588
1905	**3/4**	20	112	37	-	14.00	11.20	14	4	GH6	18.0	T447 1905
2540	**1**	20	130	45	-	18.00	14.00	18	4	GH7	24.2	T447 2540
	Tyre Valve Tap (UNS)											**T489**
0533	**5V1**	36	62	17	23	5.60	4.50	7	3		4.6	T489 0533
	Stitching Tap											**T490**
0655	**#1**		64	36	-	8.08	6.15	9.5	4		5.0	T490 0655

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
T447	●	●	●	●		●	○										○		○		○		○	○	○	○		○		○																				
T489	●	●	●	●		●	○										○		○		○		○	○	○	○		○		○																				
T490	●	●	●	●		●	○										○		○		○		○	○	○	○		○		○																				

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

● Optimal ○ Effective

UNEF Finder

ISO Taps UNF, Gun, N

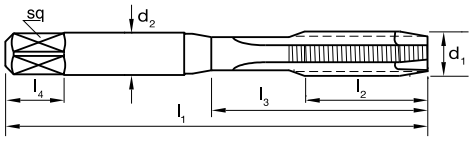
suttontools

- General purpose use
- Suitable for materials up to 1000N/mm²
- Through holes
- Depths up to approx. 3 x d_1





ISO 529 | 60° UNF



	T439	T440
Catalogue Code	T439	T440
Discount Group	D0702	D0702
Material	HSSE	HSSE
Surface Finish	*Brt*	*Blu*
Sutton Designation	N	N
Geometry	-	-
Chamfer	Intermediate	Intermediate
Nut Tolerance	2B	2B

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	Limit	drill Ø	Item #	Item #
0483	#10	32	58	16	22	5.00	4.00	7	3	GH3	4.1	T439 0483	T440 0483
0635	1/4	28	66	19	25	6.30	5.00	8	3	GH3	5.5	T439 0635	T440 0635
0794	5/16	24	72	22	30	8.00	6.30	9	3	GH4	6.9	T439 0794	T440 0794
0953	3/8	24	80	24	33	10.00	8.00	11	3	GH4	8.5	T439 0953	T440 0953
1111	7/16	20	85	25	-	8.00	6.30	9	3	GH5	9.8	T439 1111	T440 1111
1270	1/2	20	89	29	-	9.00	7.10	10	3	GH5	11.5	T439 1270	T440 1270
1588	5/8	18	102	32	-	12.50	10.00	13	3	GH5	12.8	T439 1588	T440 1588
1905	3/4	16	112	37	-	14.00	11.20	14	4	GH6	17.5	T439 1905	T440 1905
2223	7/8	14	118	38	-	16.00	12.50	16	4	GH6	20.5	•	T440 2223
2540	1	12	130	45	-	18.00	14.00	18	4	GH7	23.5	•	T440 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
T439	●	●	○	○		●	○							○	○				○	○	○		○	○	○	○		●	○																			○	
T440	●	●	●	●		●	○					○		○	○				○	○	○																												○	

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

● Optimal ○ Effective

UNF Finder

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

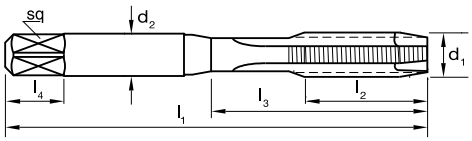
ISO Taps UNF, Gun, N

suttontools

- General purpose use
- Suitable for materials up to 1000N/mm²
- Through holes
- Depths up to approx. 3 x d_1



ISO 529 | 60° UNF



Catalogue Code	**T441**
Discount Group	D0706
Material	**HSSE**
Surface Finish	***TiN***
Sutton Designation	**N**
Geometry	-
Chamfer	**Intermediate**
Nut Tolerance	2B

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	Limit drill Ø		Item #
0483	#10	32	58	16	22	5.00	4.00	7	3	GH3	4.1	T441 0483
0635	1/4	28	66	19	25	6.30	5.00	8	3	GH3	5.5	T441 0635
0794	5/16	24	72	22	30	8.00	6.30	9	3	GH4	6.9	T441 0794
0953	3/8	24	80	24	33	10.00	8.00	11	3	GH4	8.5	T441 0953
1111	7/16	20	85	25	-	8.00	6.30	9	3	GH5	9.8	•
1270	1/2	20	89	29	-	9.00	7.10	10	3	GH5	11.5	T441 1270
1588	5/8	18	102	32	-	12.50	10.00	13	3	GH5	12.8	T441 1588
1905	3/4	16	112	37	-	14.00	11.20	14	4	GH6	17.5	T441 1905
2223	7/8	14	118	38	-	16.00	12.50	16	4	GH6	20.5	•
2540	1	12	130	45	-	18.00	14.00	18	4	GH7	23.5	•

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
T441	●	●	●	●	○	●	●	○		○		○	○	○	○				○	○	○		○	○	○	○	○	○	○																	○	

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.

ISO Taps UNF, Spiral Flute, N

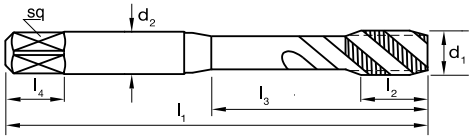
suttontools

- General purpose use
- Suitable for materials up to 1000N/mm²
- Blind holes
- Depths up to approx. 2.5 x d_1





ISO 529 | 60° UNF



	T442	T443
Catalogue Code	T442	T443
Discount Group	D0702	D0706
Material	HSSE	HSSE
Surface Finish	*Brt*	*TiN*
Sutton Designation	N	N
Geometry	-	-
Chamfer	Bottoming	Bottoming
Nut Tolerance	2B	2B

Size Ref	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	Limit	drill Ø	Item #	Item #
0483	#10	32	58	11	22	5.00	4.00	7	3	GH3	4.1	T442 0483	T443 0483
0635	1/4	28	66	10	25	6.30	5.00	8	3	GH3	5.5	T442 0635	T443 0635
0794	5/16	24	72	13	30	8.00	6.30	9	3	GH4	6.9	T442 0794	T443 0794
0953	3/8	24	80	16	33	10.00	8.00	11	3	GH4	8.5	T442 0953	T443 0953
1111	7/16	20	85	18	-	8.00	6.30	9	3	GH5	9.8	T442 1111	•
1270	1/2	20	89	20	-	9.00	7.10	10	3	GH5	11.5	T442 1270	T443 1270
1588	5/8	18	102	20	-	12.50	10.00	13	3	GH5	12.8	T442 1588	T443 1588
1905	3/4	16	112	25	-	14.00	11.20	14	4	GH6	17.5	T442 1905	T443 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
T442	●	●	○	○		●								○	○				○	○			○	○	○	○		●	○	○																			○	
T443	●	●	●	●	○	●	●	○		○		○	○	○	○				○	○			○	○	○	○	○		○																			○	

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.

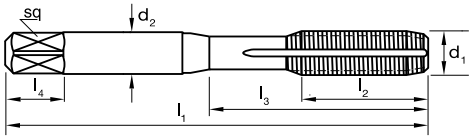
ISO Taps UNF, Forming, Single Coolant Groove

suttontools

- For cold forming of threads in materials with good flow characteristics
- Through or blind holes
- Depths up to approx. 1.5 x d_1



ISO 529 | 60° UNF



Catalogue Code	T444
Discount Group	D0702
Material	HSSE
Surface Finish	*Brt*
Sutton Designation	N
Geometry	Single Coolant Groove
Chamfer	Short
Nut Tolerance	2B

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	Limit drill Ø		Item #
0635	1/4	28	66	19	25	6.30	5.00	7	-	GH7	6.0	T444 0635
0794	5/16	24	72	22	30	8.00	6.30	8	-	GH7	7.5	T444 0794
0953	3/8	24	80	24	33	10.00	8.00	9	-	GH7	9.0	T444 0953
1270	1/2	20	89	29	-	9.00	7.10	10	-	GH8	12.1	T444 1270

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
T444	●	●	○	○		●																	●	●	●	●		●		○																		

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

● Optimal ○ Effective

UNF Finder

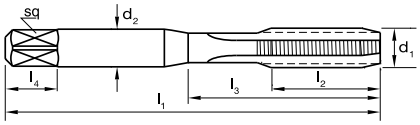
ISO Taps 8UN, Straight Flute, N

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 d_1







	T448	T449
Catalogue Code	T448	T449
Discount Group	D0702	D0702
Material	HSS	HSS
Surface Finish	*Brt*	*Brt*
Sutton Designation	N	N
Geometry	Extra Fine	Extra Fine
Chamfer	Taper	Intermediate
Limit & Nut Tolerance	GH8/2B	GH8/2B

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
2858	1-1/8	8	138	48	-	20.00	16.00	20	4	25.5	T448 2858	T449 2858
3175	1-1/4	8	151	51	-	22.40	18.00	22	4	28.5	T448 3175	T449 3175
3493	1-3/8	8	162	57	-	25.00	20.00	24	4	31.75	T448 3493	T449 3493
3810	1-1/2	8	170	60	-	28.00	22.40	26	4	35.0	T448 3810	T449 3810
4128	1-5/8	8	170	60	-	28.00	22.40	26	4	38.0	T448 4128	T449 4128
4445	1-3/4	8	187	67	-	31.50	25.00	28	4	41.5	T448 4445	T449 4445
4763	1-7/8	8	187	67	-	31.50	25.00	28	4	44.5	T448 4763	T449 4763
5080	2	8	200	70	-	35.50	28.00	31	4	47.5	T448 5080	T449 5080
6033	2-3/8	8	221	76	-	40.00	31.50	34	6	57.15	•	•

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	●	●	●	●		●	○										○		○		○		○	○	○	○		○		○																					
T449	●	●	●	●		●	○										○		○		○		○	○	○	○		○		○																					

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

● Optimal ○ Effective

8UN Finder

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

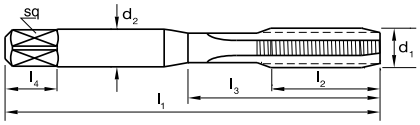
ISO Taps 8UN, Straight Flute, N

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 d_1







Catalogue Code	T450	T910
Discount Group	D0702	D0702
Material	HSS	HSS
Surface Finish	*Brt*	*Brt*
Sutton Designation	N	N
Geometry	Extra Fine	Extra Fine
Chamfer	Bottoming	Set
Limit & Nut Tolerance	GH8/2B	GH8/2B

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
2858	1-1/8	8	138	48	-	20.00	16.00	20	4	25.5	T450 2858	T910 2858
3175	1-1/4	8	151	51	-	22.40	18.00	22	4	28.5	T450 3175	T910 3175
3493	1-3/8	8	162	57	-	25.00	20.00	24	4	31.75	T450 3493	T910 3493
3810	1-1/2	8	170	60	-	28.00	22.40	26	4	35.0	T450 3810	T910 3810
4128	1-5/8	8	170	60	-	28.00	22.40	26	4	38.0	T450 4128	T910 4128
4445	1-3/4	8	187	67	-	31.50	25.00	28	4	41.5	T450 4445	T910 4445
4763	1-7/8	8	187	67	-	31.50	25.00	28	4	44.5	T450 4763	T910 4763
5080	2	8	200	70	-	35.50	28.00	31	4	47.5	T450 5080	T910 5080
6033	2-3/8	8	221	76	-	40.00	31.50	34	6	57.15	•	•

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
T450	●	●	●	●		●	○										○		○		○		○	○	○	○		○		○																					
T910	●	●	●	●		●	○										○		○		○		○	○	○	○		○		○																					

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.

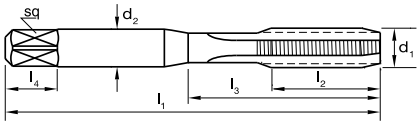
ISO Taps BSW, Straight Flute, N

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 d_1







	T451	T452
Catalogue Code	T451	T452
Discount Group	D0702	D0702
Material	HSS	HSS
Surface Finish	*Brt*	*Brt*
Sutton Designation	N	N
Geometry	-	-
Chamfer	Taper	Intermediate
Limit & Nut Tolerance	Z3 Medium	Z3 Medium

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
0238	3/32	48(WHIT)	45	10	-	2.80	2.24	5	3	1.85	T451 0238	T452 0238
0318	1/8	40	48	15	15	3.15	2.50	5	3	2.55	T451 0318	T452 0318
0397	5/32	32(WHIT)	53	17	17	4.00	3.15	6	3	3.2	T451 0397	T452 0397
0476	3/16	24	58	16	22	5.00	4.00	7	3	3.7	T451 0476	T452 0476
0556	7/32	24(WHIT)	62	17	23	5.60	4.50	7	3	4.5	T451 0556	T452 0556
0635	1/4	20	66	19	25	6.30	5.00	8	3	5.1	T451 0635	T452 0635
0794	5/16	18	72	22	30	8.00	6.30	9	4	6.5	T451 0794	T452 0794
0953	3/8	16	80	24	33	10.00	8.00	11	4	7.9	T451 0953	T452 0953
1111	7/16	14	85	25	-	8.00	6.30	9	4	9.3	T451 1111	T452 1111
1270	1/2	12	89	29	-	9.00	7.10	10	4	10.5	T451 1270	T452 1270
1429	9/16	12	95	30	-	11.20	9.00	12	4	12.1	T451 1429	T452 1429
1588	5/8	11	102	32	-	12.50	10.00	13	4	13.5	T451 1588	T452 1588
1905	3/4	10	112	37	-	14.00	11.20	14	4	16.25	T451 1905	T452 1905
2223	7/8	9	118	38	-	16.00	12.50	16	4	19.25	T451 2223	T452 2223
2540	1	8	130	45	-	18.00	14.00	18	4	22.0	T451 2540	T452 2540
2858	1-1/8	7	138	48	-	20.00	16.00	20	4	24.75	T451 2858	T452 2858
3175	1-1/4	7	151	51	-	22.40	18.00	22	4	28.0	T451 3175	T452 3175
3810	1-1/2	6	170	60	-	28.00	22.40	26	4	33.5	T451 3810	T452 3810
4445	1-3/4	5	187	67	-	31.50	25.00	28	4	39.0	T451 4445	T452 4445
5080	2	4-1/2	200	70	-	35.50	28.00	31	4	44.5	T451 5080	T452 5080

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	●	●	●	●		●	○										○		○		○		○	○	○	○		○		○																				
T452	●	●	●	●		●	○										○		○		○		○	○	○	○		○		○																				

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

● Optimal ○ Effective

BSW Finder

ISO Taps BSW, Straight Flute, N

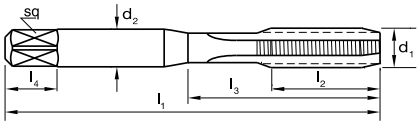
suttontools

- 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 d_1





ISO 529 | 55° BSW



Catalogue Code	T453	T905
Discount Group	D0702	D0702
Material	HSS	HSS
Surface Finish	*Brt*	*Brt*
Sutton Designation	N	N
Geometry	-	-
Chamfer	Bottoming	Set
Limit & Nut Tolerance	Z3 Medium	Z3 Medium

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
0238	3/32	48(WHIT)	45	10	-	2.80	2.24	5	3	1.85	T453 0238	T905 0238
0318	1/8	40	48	15	15	3.15	2.50	5	3	2.55	T453 0318	T905 0318
0397	5/32	32(WHIT)	53	17	17	4.00	3.15	6	3	3.2	T453 0397	T905 0397
0476	3/16	24	58	16	22	5.00	4.00	7	3	3.7	T453 0476	T905 0476
0556	7/32	24(WHIT)	62	17	23	5.60	4.50	7	3	4.5	T453 0556	T905 0556
0635	1/4	20	66	19	25	6.30	5.00	8	3	5.1	T453 0635	T905 0635
0794	5/16	18	72	22	30	8.00	6.30	9	4	6.5	T453 0794	T905 0794
0953	3/8	16	80	24	33	10.00	8.00	11	4	7.9	T453 0953	T905 0953
1111	7/16	14	85	25	-	8.00	6.30	9	4	9.3	T453 1111	T905 1111
1270	1/2	12	89	29	-	9.00	7.10	10	4	10.5	T453 1270	T905 1270
1429	9/16	12	95	30	-	11.20	9.00	12	4	12.1	T453 1429	T905 1429
1588	5/8	11	102	32	-	12.50	10.00	13	4	13.5	T453 1588	T905 1588
1905	3/4	10	112	37	-	14.00	11.20	14	4	16.25	T453 1905	T905 1905
2223	7/8	9	118	38	-	16.00	12.50	16	4	19.25	T453 2223	T905 2223
2540	1	8	130	45	-	18.00	14.00	18	4	22.0	T453 2540	T905 2540
2858	1-1/8	7	138	48	-	20.00	16.00	20	4	24.75	T453 2858	•
3175	1-1/4	7	151	51	-	22.40	18.00	22	4	28.0	T453 3175	•
3810	1-1/2	6	170	60	-	28.00	22.40	26	4	33.5	T453 3810	•
4445	1-3/4	5	187	67	-	31.50	25.00	28	4	39.0	T453 4445	•
5080	2	4-1/2	200	70	-	35.50	28.00	31	4	44.5	T453 5080	•

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
T453	●	●	●	●		●	○										○		○		○		○	○	○	○		○		○																				
T905	●	●	●	●		●	○										○		○		○		○	○	○	○		○		○																				

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.

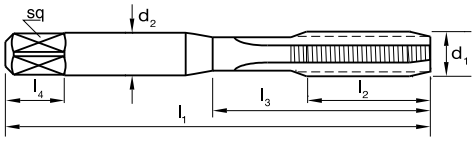
ISO Taps BSW, Straight Flute, N

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 d_1







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

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
0238	3/32	48(WHIT)	45	10	-	2.80	2.24	5	3	1.85	•	•
0318	1/8	40	48	15	15	3.15	2.50	5	3	2.55		T455 0318*
0556	7/32	24(WHIT)	62	17	23	5.60	4.50	7	3	4.5	•	•
1270	1/2	12	89	29	-	9.00	7.10	10	4	10.5	T454 1270*	T455 1270*
1429	9/16	12	95	30	-	11.20	9.00	12	4	12.1	•	•
2223	7/8	9	118	38	-	16.00	12.50	16	4	19.25	•	•
2540	1	8	130	45	-	18.00	14.00	18	4	22.0	•	•
2858	1-1/8	7	138	48	-	20.00	16.00	20	4	24.75	•	•
3175	1-1/4	7	151	51	-	22.40	18.00	22	4	28.0	•	•
3810	1-1/2	6	170	60	-	28.00	22.40	26	4	33.5	•	•
4445	1-3/4	5	187	67	-	31.50	25.00	28	4	39.0	•	•
5080	2	4-1/2	200	70	-	35.50	28.00	31	4	44.5	•	•

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
T454	●	●	●	●	○	●	●	○		○		○		○			○		○		○		○	○	○	○		○	○	○																		
T455	●	●	●	●	○	●	●	○		○		○		○			○		○		○		○	○	○	○		○	○	○																		

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

● Optimal ○ Effective

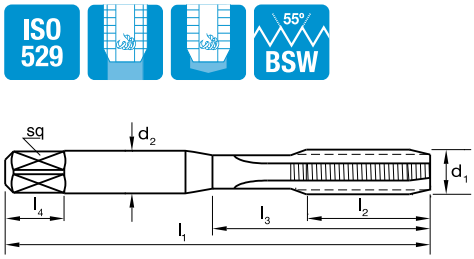
*Not available once current stock is depleted. • Available on request as special manufacture. Subject to lead time.

ISO Taps BSW, 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 d_1





Catalogue Code	T456
Discount Group	D0702
Material	HSS
Surface Finish	*Brt*
Sutton Designation	N
Geometry	Left Hand
Chamfer	**Bottoming**
Limit & Nut Tolerance	Z3 LH Medium

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

BSW Finder

ISO Taps BSW, Gun, N

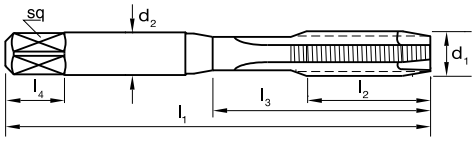
suttontools

- General purpose use
- Suitable for materials up to 1000N/mm²
- Through holes
- Depths up to approx. 3 x d_1





ISO 529 | 55° BSW



	T457	T458
Catalogue Code	T457	T458
Discount Group	D0702	D0702
Material	HSSE	HSSE
Surface Finish	*Brt*	*Blu*
Sutton Designation	N	N
Geometry	-	-
Chamfer	Intermediate	Intermediate
Limit & Nut Tolerance	Z3 Medium	Z3 Medium

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
0318	1/8	40	48	15	15	3.15	2.50	5	3	2.55	T457 0318	T458 0318
0397	5/32	32(WHIT)	53	17	17	4.00	3.15	6	3	3.2	T457 0397	T458 0397
0476	3/16	24	58	16	22	5.00	4.00	7	3	3.7	T457 0476	T458 0476
0635	1/4	20	66	19	25	6.30	5.00	8	3	5.1	T457 0635	T458 0635
0794	5/16	18	72	22	30	8.00	6.30	9	3	6.5	T457 0794	T458 0794
0953	3/8	16	80	24	33	10.00	8.00	11	3	7.9	T457 0953	T458 0953
1111	7/16	14	85	25	-	8.00	6.30	9	3	9.3	T457 1111	T458 1111
1270	1/2	12	89	29	-	9.00	7.10	10	3	10.5	T457 1270	T458 1270
1588	5/8	11	102	32	-	12.50	10.00	13	3	13.5	T457 1588	T458 1588
1905	3/4	10	112	37	-	14.00	11.20	14	4	16.25	T457 1905	T458 1905
2223	7/8	9	118	38	-	16.00	12.50	16	4	19.25	•	T458 2223
2540	1	8	130	45	-	18.00	14.00	18	4	22.0	•	T458 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
T457	●	●	○	○		●	○							○	○				○	○	○		○	○	○	○		●	○																			○	
T458	●	●	●	●		●	○					○		○	○				○	○	○																											○	

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.

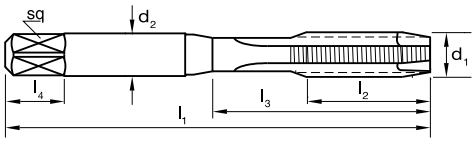
ISO Taps BSW, Gun, N

suttontools

- General purpose use
- Suitable for materials up to 1000N/mm²
- Through holes
- Depths up to approx. 3 x d_1



ISO 529 | 55° BSW



Catalogue Code	**T459**
Discount Group	D0706
Material	**HSSE**
Surface Finish	***TiN***
Sutton Designation	**N**
Geometry	-
Chamfer	**Intermediate**
Limit & Nut Tolerance	Z3 Medium

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #
0318	1/8	40	48	15	15	3.15	2.50	5	3	2.55	T459 0318
0397	5/32	32(WHIT)	53	17	17	4.00	3.15	6	3	3.2	T459 0397
0476	3/16	24	58	16	22	5.00	4.00	7	3	3.7	T459 0476
0635	1/4	20	66	19	25	6.30	5.00	8	3	5.1	T459 0635
0794	5/16	18	72	22	30	8.00	6.30	9	3	6.5	T459 0794
0953	3/8	16	80	24	33	10.00	8.00	11	3	7.9	T459 0953
1111	7/16	14	85	25	-	8.00	6.30	9	3	9.3	•
1270	1/2	12	89	29	-	9.00	7.10	10	3	10.5	T459 1270
1588	5/8	11	102	32	-	12.50	10.00	13	3	13.5	T459 1588
1905	3/4	10	112	37	-	14.00	11.20	14	4	16.25	T459 1905
2223	7/8	9	118	38	-	16.00	12.50	16	4	19.25	•
2540	1	8	130	45	-	18.00	14.00	18	4	22.0	•

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
T459	●	●	●	●	○	●	●	○		○		○	○	○	○				○	○	○		○	○	○	○	○	○	○																			○	

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.

BSW Finder

ISO Taps BSW, Spiral Flute, N

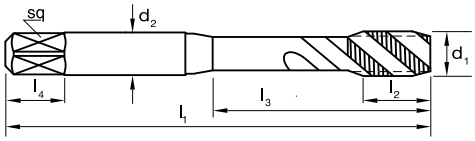
suttontools

- General purpose use
- Suitable for materials up to 1000N/mm²
- Blind holes
- Depths up to approx. 2.5 x d_1





ISO 529 | 55° BSW



	T460	T461
Catalogue Code	T460	T461
Discount Group	D0702	D0702
Material	HSSE	HSSE
Surface Finish	*Brt*	*Blu*
Sutton Designation	N	N
Geometry	-	-
Chamfer	Bottoming	Bottoming
Limit & Nut Tolerance	Z3 Medium	Z3 Medium

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
0318	1/8	40	48	6	15	3.15	2.50	5	3	2.55	T460 0318	•
0397	5/32	32(WHIT)	53	7	17	4.00	3.15	6	3	3.2	T460 0397	•
0476	3/16	24	58	11	22	5.00	4.00	7	3	3.7	T460 0476	•
0635	1/4	20	66	10	25	6.30	5.00	8	3	5.1	T460 0635	T461 0635
0794	5/16	18	72	13	30	8.00	6.30	9	3	6.5	T460 0794	T461 0794
0953	3/8	16	80	16	33	10.00	8.00	11	3	7.9	T460 0953	T461 0953
1111	7/16	14	85	18	-	8.00	6.30	9	3	9.3	T460 1111	T461 1111
1270	1/2	12	89	20	-	9.00	7.10	10	3	10.5	T460 1270	T461 1270
1588	5/8	11	102	20	-	12.50	10.00	13	3	13.5	T460 1588	T461 1588
1905	3/4	10	112	25	-	14.00	11.20	14	4	16.25	T460 1905	T461 1905
2223	7/8	9	118	28	-	16.00	12.50	16	4	19.25	T460 2223	•
2540	1	8	130	35	-	18.00	14.00	18	4	22.0	T460 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
T460	●	●	○	○		●								○	○				○	○			○	○	○	○		●	○	○																		○	
T461	●	●	●	●		●	○					○		○	○				○	○																													○	

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

● Optimal ○ Effective

BSW Finder

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

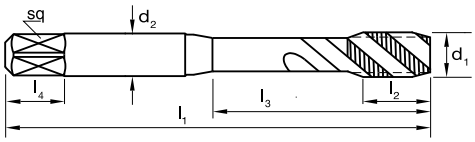
ISO Taps BSW, Spiral Flute, N

suttontools

- General purpose use
- Suitable for materials up to 1000N/mm²
- Blind holes
- Depths up to approx. 2.5 x d_1

ISO 529 | DIN 2197 | 55° BSW





Catalogue Code	**T462**
Discount Group	D0706
Material	**HSSE**
Surface Finish	***TiN***
Sutton Designation	**N**
Geometry	-
Chamfer	**Bottoming**
Limit & Nut Tolerance	Z3 Medium

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #
0318	1/8	40	48	6	15	3.15	2.50	5	3	2.55	•
0397	5/32	32(WHIT)	53	7	17	4.00	3.15	6	3	3.2	•
0476	3/16	24	58	11	22	5.00	4.00	7	3	3.7	T462 0476
0635	1/4	20	66	10	25	6.30	5.00	8	3	5.1	T462 0635
0794	5/16	18	72	13	30	8.00	6.30	9	3	6.5	T462 0794
0953	3/8	16	80	16	33	10.00	8.00	11	3	7.9	T462 0953
1111	7/16	14	85	18	-	8.00	6.30	9	3	9.3	•
1270	1/2	12	89	20	-	9.00	7.10	10	3	10.5	T462 1270
1588	5/8	11	102	20	-	12.50	10.00	13	3	13.5	T462 1588
1905	3/4	10	112	25	-	14.00	11.20	14	4	16.25	•
2223	7/8	9	118	28	-	16.00	12.50	16	4	19.25	•
2540	1	8	130	35	-	18.00	14.00	18	4	22.0	•

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
T462	●	●	●	●	○	●	●	○		○		○	○	○	○				○	○			○	○	○	○	○		○																		○	

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.

ISO Taps BSW, Forming, Single Coolant Groove

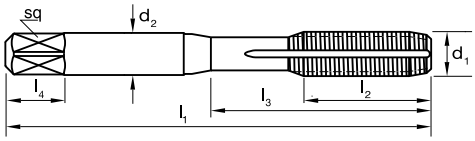
suttontools

- For cold forming of threads in materials with good flow characteristics
- Through or blind holes
- Depths up to approx. 1.5 x d_1
- TiN for longer tool life





ISO 529 | 55° BSW



Catalogue Code	T463	T464
Discount Group	D0702	D0706
Material	HSSE	HSSE
Surface Finish	*Brt*	*TiN*
Sutton Designation	N	N
Geometry	Single Coolant Groove	Single Coolant Groove
Chamfer	Short	Short
Limit & Nut Tolerance	Z3 Medium	Z3 Medium

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
0318	1/8	40	48	15	15	3.15	2.50	5	-	2.9	T463 0318	•
0397	5/32	32(WHIT)	53	17	17	4.00	3.15	6	-	3.6	T463 0397	T464 0397
0476	3/16	24	58	16	22	5.00	4.00	7	-	4.3	T463 0476	T464 0476
0635	1/4	20	66	19	25	6.30	5.00	8	-	5.8	T463 0635	•
0794	5/16	18	72	22	30	8.00	6.30	9	-	7.3	T463 0794	•
0953	3/8	16	80	24	33	10.00	8.00	11	-	8.8	T463 0953	•

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
T463	●	●	○	○		●																	●	●	●	●		●		○																				
T464	●	●	○	○		●	○							○									●	●	○	○		●		○																				

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.

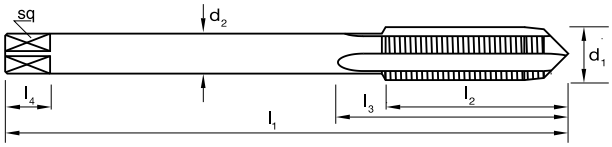
ISO Taps BSW, Machine Nut, Long Shank

suttontools

- Suited to long reach applications
- Suitable for materials up to 1000N/mm²
- Through holes
- Depths up to approx. 2 x d_1



BS 949 | 55° BSW



Catalogue Code	T465
Discount Group	D0702
Material	HSS
Surface Finish	*Brt*
Sutton Designation	Nut
Geometry	-
Chamfer	Bottoming
Limit & Nut Tolerance	Z3 Medium

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #
0635	1/4	20	110	38	-	4.5	3.55	6	4	5.1	T465 0635
0794	5/16	18	125	43	-	6	4.5	7	4	6.5	T465 0794
0953	3/8	16	140	48	-	7	5.6	8	4	7.9	T465 0953
1270	1/2	12	180	59	-	9.5	7.5	10	4	10.5	T465 1270
1588	5/8	11	200	70	-	12.5	10.0	13	4	13.5	T465 1588
1905	3/4	10	250	76	-	14	11.2	14	4	16.25	T465 1905
2540	1	8	280	95	-	18	14.0	18	4	22.0	T465 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
T465	●	●	●	●		●	○							○			○		○		○		○	○	○	○		○		○																			

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

● Optimal ○ Effective

BSW Finder

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

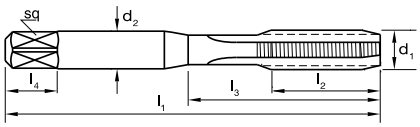
suttontools

- 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 d_1





ISO 529 | 55° BSF | 47.5° BA | 55° BSB



	T466	T467
Catalogue Code	T466	T467
Discount Group	D0702	D0702
Material	HSS	HSS
Surface Finish	*Brt*	*Brt*
Sutton Designation	N	N
Geometry	-	-
Chamfer	Taper	Intermediate
Limit & Nut Tolerance	Z3 Medium	Z3 Medium

BSF Finder

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
	BSF											
0476	3/16	32	58	16	22	5.00	4.00	7	3	4.0	T466 0476	T467 0476
0635	1/4	26	66	19	25	6.30	5.00	8	3	5.3	T466 0635	T467 0635
0794	5/16	22	72	22	30	8.00	6.30	9	4	6.8	T466 0794	T467 0794
0953	3/8	20	80	24	33	10.00	8.00	11	4	8.3	T466 0953	T467 0953
1111	7/16	18	85	25	-	8.00	6.30	9	4	9.8	T466 1111	T467 1111
1270	1/2	16	89	29	-	9.00	7.10	10	4	11.0	T466 1270	T467 1270
1429	9/16	16	95	30	-	11.20	9.00	12	4	12.7	T466 1429	T467 1429
1588	5/8	14	102	32	-	12.50	10.00	13	4	14.0	T466 1588	T467 1588
1905	3/4	12	112	37	-	14.00	11.20	14	4	16.75	T466 1905	T467 1905
2223	7/8	11	118	38	-	16.00	12.50	16	4	19.75	T466 2223	T467 2223
2540	1	10	130	45	-	18.00	14.00	18	4	22.75	T466 2540	T467 2540
	BSB										T472	T473
0635	1/4	26(BSF)	66	19	25	6.30	5.00	8	3	5.2	T466 0635	T467 0635
0794	5/16*	26	72	22	30	8.00	6.30	9	4	6.8	T472 0794	T473 0794
0953	3/8*	26	80	24	33	10.00	8.00	11	4	8.4	T472 0953	T473 0953
1111	7/16*	26	85	25	-	8.00	6.30	9	4	10.0	T472 1111	T473 1111
1270	1/2*	26	89	29	-	9.00	7.10	10	4	11.6	T472 1270	T473 1270
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	•	•
	BA										T469	T470
0600	0	1	66	19	26	6.30	5.00	8	3	5.1	T469 0600	T470 0600
0530	1	0.9	62	17	23	5.60	4.50	7	3	4.5	T469 0530	T470 0530
0470	2	0.81	58	16	22	5.00	4.00	7	3	4.0	T469 0470	T470 0470
0410	3	0.73	53	13	18	4.50	3.55	6	3	3.4	T469 0410	T470 0410
0360	4	0.66	50	17	-	3.55	2.80	5	3	3.0	T469 0360	T470 0360
0320	5	0.59	48	15	-	3.15	2.50	5	3	2.65	T469 0320	T470 0320
0280	6	0.53	48	15	-	3.15	2.50	5	3	2.3	T469 0280	T470 0280
0250	7	0.48	45	10	-	2.80	2.24	5	3	2.05	T469 0250	T470 0250
0220	8	0.43	45	10	-	2.80	2.24	5	3	1.8	T469 0220	T470 0220
0190	9	0.39	41	8	-	2.50	2.00	4	3	1.55	T469 0190	T470 0190
0170	10	0.35	41	8	-	2.50	2.00	4	3	1.4	T469 0170	T470 0170

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 / T467	●	●	●	●		●	○										○		○		○		○	○	○	○		○		○																					
T472 / T473	●	●	●	●		●	○										○		○		○		○	○	○	○		○		○																					
T469 / T470	●	●	●	●		●	○										○		○		○		○	○	○	○		○		○																					

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

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

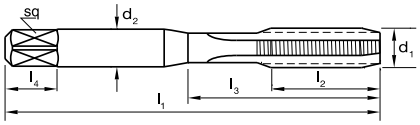
suttontools

- 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 d_1





ISO 529 | 55° BSF | 47.5° BA | 55° BSB



Catalogue Code	T468	T906
Discount Group	D0702	D0702
Material	HSS	HSS
Surface Finish	*Brt*	*Brt*
Sutton Designation	N	N
Geometry	-	-
Chamfer	Bottoming	Set
Limit & Nut Tolerance	Z3 Medium	Z3 Medium

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
	BSF											
0476	3/16	32	58	16	22	5.00	4.00	7	3	4.0	T468 0476	T906 0476
0635	1/4	26	66	19	25	6.30	5.00	8	3	5.3	T468 0635	T906 0635
0794	5/16	22	72	22	30	8.00	6.30	9	4	6.8	T468 0794	T906 0794
0953	3/8	20	80	24	33	10.00	8.00	11	4	8.3	T468 0953	T906 0953
1111	7/16	18	85	25	-	8.00	6.30	9	4	9.8	T468 1111	T906 1111
1270	1/2	16	89	29	-	9.00	7.10	10	4	11.0	T468 1270	T906 1270
1429	9/16	16	95	30	-	11.20	9.00	12	4	12.7	T468 1429	•
1588	5/8	14	102	32	-	12.50	10.00	13	4	14.0	T468 1588	•
1905	3/4	12	112	37	-	14.00	11.20	14	4	16.75	T468 1905	•
2223	7/8	11	118	38	-	16.00	12.50	16	4	19.75	T468 2223	•
2540	1	10	130	45	-	18.00	14.00	18	4	22.75	T468 2540	•
	BSB										T474	T908
0635	1/4	26(BSF)	66	19	25	6.30	5.00	8	3	5.2	T468 0635	T906 0635
0794	5/16*	26	72	22	30	8.00	6.30	9	4	6.8	T474 0794	T908 0794
0953	3/8*	26	80	24	33	10.00	8.00	11	4	8.4	T474 0953	T908 0953
1111	7/16*	26	85	25	-	8.00	6.30	9	4	10.0	T474 1111	T908 1111
1270	1/2*	26	89	29	-	9.00	7.10	10	4	11.6	T474 1270	T908 1270
1429	9/16*	26	95	30	-	11.20	9.00	12	4	13.2	T474 1429	•
1588	5/8*	26	102	32	-	12.50	10.00	13	4	14.8	T474 1588	•
1905	3/4*	26	112	37	-	14.00	11.20	14	4	18.0	T474 1905	•
2223	7/8*	26	118	38	-	16.00	12.50	16	4	20.8	T474 2223	•
2540	1*	26	130	45	-	18.00	14.00	18	4	24.3	T474 2540	•
	BA										T471	T907
0600	0	1	66	19	26	6.30	5.00	8	3	5.1	T471 0600	•
0530	1	0.9	62	17	23	5.60	4.50	7	3	4.5	T471 0530	T907 0530
0470	2	0.81	58	16	22	5.00	4.00	7	3	4.0	T471 0470	T907 0470
0410	3	0.73	53	13	18	4.50	3.55	6	3	3.4	T471 0410	T907 0410
0360	4	0.66	50	17	-	3.55	2.80	5	3	3.0	T471 0360	T907 0360
0320	5	0.59	48	15	-	3.15	2.50	5	3	2.65	T471 0320	T907 0320
0280	6	0.53	48	15	-	3.15	2.50	5	3	2.3	T471 0280	T907 0280
0250	7	0.48	45	10	-	2.80	2.24	5	3	2.05	T471 0250	T907 0250
0220	8	0.43	45	10	-	2.80	2.24	5	3	1.8	T471 0220	T907 0220
0190	9	0.39	41	8	-	2.50	2.00	4	3	1.55	T471 0190	T907 0190
0170	10	0.35	41	8	-	2.50	2.00	4	3	1.4	T471 0170	T907 0170

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
T468 / T906	●	●	●	●		●	○										○		○		○		○	○	○	○		○		○																			
T474 / T908	●	●	●	●		●	○										○		○		○		○	○	○	○		○		○																			
T471 / T907	●	●	●	●		●	○										○		○		○		○	○	○	○		○		○																			

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

BSF Finder

ISO Taps Pipe, G (BSPF), Straight Flute

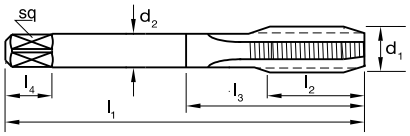
suttontools

- 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 d_1





ISO 2284 | 55° G



Catalogue Code	T479	T480
Discount Group	D0702	D0702
Material	HSS	HSS
Surface Finish	*Brt*	*Brt*
Sutton Designation	N	N
Geometry	-	-
Chamfer	Taper	Intermediate
Limit	Z3	Z3

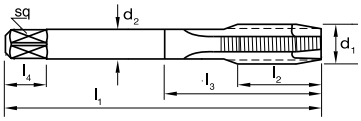
Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
0973	1/8	28	59	15	-	8.0	6.3	9	4	8.8	T479 0973	T480 0973
1316	1/4	19	67	19	-	10.0	8.0	11	4	11.8	T479 1316	T480 1316
1666	3/8	19	75	21	-	12.5	10.0	13	4	15.3	T479 1666	T480 1666
2096	1/2	14	87	26	-	16.0	12.5	16	4	19.0	T479 2096	T480 2096
2291	5/8	14	91	26	-	18.0	14.0	18	4	21.0	T479 2291	T480 2291
2644	3/4	14	96	28	-	20.0	16.0	20	4	24.5	T479 2644	T480 2644
3020	7/8	14	102	29	-	22.4	18.0	22	4	28.5	T479 3020	T480 3020
3325	1	11	109	33	-	25.0	20.0	24	4	31.0	T479 3325	T480 3325
4191	1-1/4	11	119	36	-	31.5	25.0	28	4	39.5	T479 4191	T480 4191
4780	1-1/2	11	125	37	-	35.5	28.0	31	4	45.5	T479 4780	T480 4780
5375	1-3/4	11	132	39	-	35.5	28.0	31	6	51.5	T479 5375	T480 5375
5961	2	11	140	41	-	40.0	31.5	34	6	57.5	T479 5961	T480 5961

ISO Taps Pipe, G (BSPF), Spiral Point Gun

- General purpose use
- Suitable for materials up to 1000N/mm²
- Through & blind holes
- Depths up to approx. 1 x d_1



ISO 529 | 55° G



Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #
											T484
0973	1/8	28	80	24	33	10	8	11	3	8.8	T484 0973
1316	1/4	19	95	30	-	11.2	9	12	3	11.8	T484 1316
1666	3/8	19	112	37	-	14	11.2	14	4	15.3	T484 1666
2096	1/2	14	118	38	-	16	12.5	16	4	19.0	T484 2096
2644	3/4	14	135	45	-	20	16	20	4	24.5	T484 2644

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	●	●	●	●		●	○										○		○		○		○	○	○	○		○		○																				
T480	●	●	●	●		●	○										○		○		○		○	○	○	○		○		○																				
T484	●	●	○	○		●	○							○	○				○	○	○		○	○	○	○		●	○																				

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

● Optimal ○ Effective

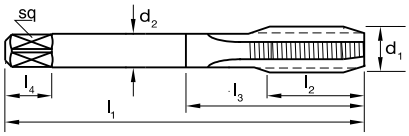
G (BSPF) Finder

ISO Taps Pipe, G (BSPF), Straight Flute

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 d_1

ISO 2284 | 55° G







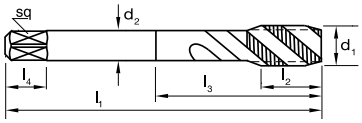
Catalogue Code	T481	T909
Discount Group	D0702	D0702
Material	HSS	HSS
Surface Finish	*Brt*	*Brt*
Sutton Designation	N	N
Geometry	-	-
Chamfer	Bottoming	Set
Limit	Z3	Z3

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
0973	1/8	28	59	15	-	8.0	6.3	9	4	8.8	T481 0973	T909 0973
1316	1/4	19	67	19	-	10.0	8.0	11	4	11.8	T481 1316	T909 1316
1666	3/8	19	75	21	-	12.5	10.0	13	4	15.3	T481 1666	T909 1666
2096	1/2	14	87	26	-	16.0	12.5	16	4	19.0	T481 2096	T909 2096
2291	5/8	14	91	26	-	18.0	14.0	18	4	21.0	T481 2291	T909 2291
2644	3/4	14	96	28	-	20.0	16.0	20	4	24.5	T481 2644	T909 2644
3020	7/8	14	102	29	-	22.4	18.0	22	4	28.5	T481 3020	•
3325	1	11	109	33	-	25.0	20.0	24	4	31.0	T481 3325	T909 3325
4191	1-1/4	11	119	36	-	31.5	25.0	28	4	39.5	T481 4191	•
4780	1-1/2	11	125	37	-	35.5	28.0	31	4	45.5	T481 4780	•
5375	1-3/4	11	132	39	-	35.5	28.0	31	6	51.5	T481 5375	•
5961	2	11	140	41	-	40.0	31.5	34	6	57.5	T481 5961	•

ISO Taps Pipe, G (BSPF), Spiral Flute

- General purpose use
- Suitable for materials up to 1000N/mm²
- Through & blind holes
- Depths up to approx. 1 x d_1

ISO 529 | 55° G





Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #
											T485
0973	1/8	28	80	24	33	10	8	11	3	8.8	T485 0973
1316	1/4	19	95	30	-	11.2	9	12	3	11.8	T485 1316
1666	3/8	19	112	37	-	14	11.2	14	4	15.3	T485 1666
2096	1/2	14	118	38	-	16	12.5	16	4	19.0	T485 2096
2644	3/4	14	135	45	-	20	16	20	4	24.5	T485 2644

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
T481	●	●	●	●		●	○										○		○		○		○	○	○	○		○		○																				
T485	●	●	○	○		●								○	○				○	○			○	○	○	○		●	○	○																			○	
T909	●	●	●	●		●	○										○		○		○		○	○	○	○		○		○																				

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.

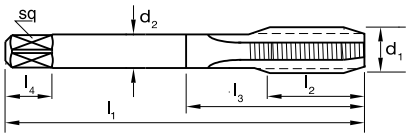
ISO Taps Pipe, G (BSPF), Straight Flute

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 d_1







Catalogue Code	T482	T483
Discount Group	D0706	D0706
Material	HSS	HSS
Surface Finish	*TiN*	*TiN*
Sutton Designation	N	N
Geometry	-	-
Chamfer	Intermediate	Bottoming
Limit	Z3	Z3

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
0973	1/8	28	59	15	-	8.0	6.3	9	4	8.8	T482 0973	T483 0973
1316	1/4	19	67	19	-	10.0	8.0	11	4	11.8	T482 1316	T483 1316
1666	3/8	19	75	21	-	12.5	10.0	13	4	15.3	T482 1666	T483 1666
2096	1/2	14	87	26	-	16.0	12.5	16	4	19.0	T482 2096	T483 2096
2291	5/8	14	91	26	-	18.0	14.0	18	4	21.0	•	T483 2291
2644	3/4	14	96	28	-	20.0	16.0	20	4	24.5	•	T483 2644
3020	7/8	14	102	29	-	22.4	18.0	22	4	28.5	•	•
3325	1	11	109	33	-	25.0	20.0	24	4	31.0	•	•
4191	1-1/4	11	119	36	-	31.5	25.0	28	4	39.5	•	•
4780	1-1/2	11	125	37	-	35.5	28.0	31	4	45.5	•	•
5375	1-3/4	11	132	39	-	35.5	28.0	31	6	51.5	•	•
5961	2	11	140	41	-	40.0	31.5	34	6	57.5	•	•

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
T482	●	●	●	●	○	●	●	○		○		○		○			○		○		○		○	○	○	○		○	○	○																		
T483	●	●	●	●	○	●	●	○		○		○		○			○		○		○		○	○	○	○		○	○	○																		

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.

ISO Taps Pipe, Rc (BSPT), Straight Flute

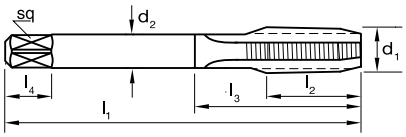
suttontools

- 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





ISO 2284 | 55° Rc



	T475	T476
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

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
	Rc (BSPT) 1:16 Taper Rate											
0973	1/8	28	59	15	-	8.0	6.3	9	4	8.4	T475 0973	T476 0973
1316	1/4	19	67	19	-	10.0	8.0	11	4	10.8	T475 1316	T476 1316
1666	3/8	19	75	21	-	12.5	10.0	13	4	14.5	T475 1666	T476 1666
2096	1/2	14	87	26	-	16.0	12.5	16	4	18.0	T475 2096	T476 2096
2644	3/4	14	96	28	-	20.0	16.0	20	4	23.0	T475 2644	•
3325	1	11	109	33	-	25.0	20.0	24	5	29.0	T475 3325	•
4191	1-1/4	11	119	36	-	31.5	25.0	28	5	38.0	T475 4191	•
4780	1-1/2	11	125	37	-	35.5	28.0	31	7	44.0	T475 4780	•
5961	2	11	140	41	-	40.0	31.5	34	7	55.0	T475 5961	•

ISO 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

Discount Group: D0702

ISO 2284 | ISO 529 | 55° Rp | 80° Pg



Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Nom* 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 / T478	●	●	●	●		●	○										○		○		○		○	○	○	○		○		○																			

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. *Nominal OD

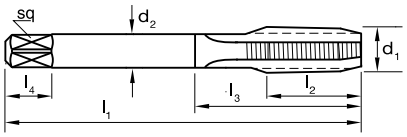
ISO Taps Pipe, National Series

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



ANSI B94-9 | 60° NPSF | 60° NPT | 60° NPTF



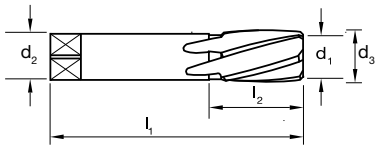
Catalogue Code	T486
Discount Group	D0702
Material	HSS
Surface Finish	*Colour Temp*
Sutton Designation	N
Geometry	-
Chamfer	Bottoming
Limit & Nut Tolerance	Refer Limit

NPT Finder

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	Limit drill Ø	Item #
	NPSF (Dryseal Straight)										
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

Reamers Taper Pipe (1:16)

- 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	0.316	2-11/32	19/32	0.353	0.315	6	R108 0803
1031	1/4	0.406	2-21/32	25/32	0.453	0.394	6	R108 1031
1372	3/8	0.540	2-31/32	7/8	0.592	0.492	6	R108 1372
1689	1/2	0.665	3-7/16	1-1/32	0.729	0.630	6	R108 1689
2225	3/4	0.876	3-25/32	1-1/8	0.945	0.787	6	R108 2225
2802	1	1.103	4-5/16	1-5/16	1.184	0.984	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	1-15/32	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	●	●	●	●		●	○							○			○		○		○		○	○	○	○		○	○	○																					
T487	●	●	●	●		●	○							○			○		○		○		○	○	○	○		○	○	○																					
T488	●	●	●	●		●	○							○			○		○		○		○	○	○	○		○	○	○																					
R108	●	●	●	●	○	●	○	○		○		○		○	○	○	●	○	○	○	○	○	○	○	○	○		○	○	○																				○	

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

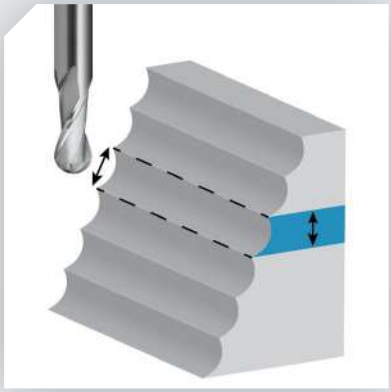
● Optimal ○ Effective

HARMONY 5-Axis

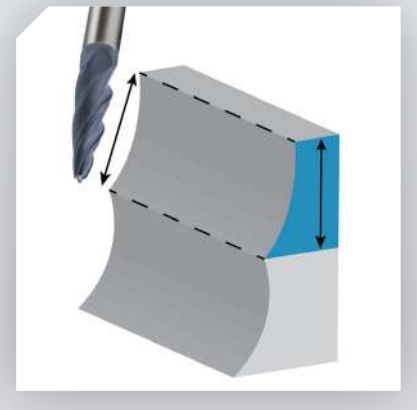
AUSTRALIAN MADE



Ball Nose Endmill



5 Axis - Oval Endmill



Optimise your 5-Axis Machining

- Up to 90% cycle time savings over Ball Nose Endmills
- Ideal for finishing of 3D surfaces and Hybrid CNC-3D printing application
- Less than 10µm profile deviation for high workpiece accuracy
- Customised solutions available

