

Standard Taps--High Speed Steel Spiral Point, Plug Style

Spiral pointed taps are recommended for machine tapping of through or open holes and for blind holes with sufficient chip-room below the full threads required. As a result of the spiral point grind, the chips are forced ahead of the tap with the least amount of resistance to the thrust. This feature makes it possible to build additional strength into the tap and allows a better flow of lubricant to the cutting edges. The use of the spiral pointed tap prevents chips from packing in the flutes or wedging between the flanks and the work, a major cause of breakage particularly in the small size taps. Generally, spiral pointed taps can be run at higher speeds as they require less torque to drive and are recommended for all materials except the abrasive group such as cast-iron and plastics. Bottoming spiral pointed taps are similar to the plug spiral pointed tap except for the style of chamfer. This style of tap tends to form a tightly curled broken chip, thus making chip removal easier. Bottoming spiral pointed taps can be used for blind hole tapping where sufficient space can be provided at the bottom of the hole to accommodate chips.



Tap Description	Part Number	Price
0-80 H1 2FL	116609	22.12
0-80 H2 2FL	116622	22.12
1-64 H1 2FL	116701	18.67
1-64 H2 2FL	116713	18.67
1-72 H1 2FL	116828	18.67
1-72 H2 2FL	116830	18.67
2-56 H1 2FL	117031	17.85
2-56 H2 2FL	117055	15.66
2-56 H5 2FL	117072	17.85
2-64 H1 2FL	117134	17.85
2-64 H2 2FL	117158	17.85
3-48 H1 2FL	117304	12.67
3-48 H2 2FL	117316	12.67
3-56 H1 2FL	117420	15.38
3-56 H2 2FL	117432	14.02
4-36 H2 2FL	117535	11.71
4-40 H1 2FL	117742	11.71
4-40 H2 2FL	117766	10.13
4-40 H3 2FL	117780	10.13
4-40 H5 2FL	117784	11.71
4-48 H1 2FL	117900	11.71
4-48 H2 2FL	117912	11.71
5-40 H1 2FL	118102	11.71
5-40 H2 2FL	118126	10.13
5-40 H3 2FL	118140	10.13
5-44 H2 2FL	118291	11.71

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Tap Description	Part Number	Price
6-32 H1 2FL	118540	9.70
6-32 H2 2FL	118564	8.52
6-32 H3 2FL	118588	8.52
6-32 H5 2FL	118593	9.70
6-32 H7 2FL	118606	9.70
6-40 H1 2FL	118801	9.95
6-40 H2 2FL	118813	9.70
8-32 H1 2FL	119210	9.70
8-32 H2 2FL	119234	8.52
8-32 H3 2FL	119258	8.52
8-32 H5 2FL	119263	9.70
8-32 H7 2FL	119271	9.70
8-36 H1 2FL	119441	10.59
8-36 H2 2FL	119453	9.70
10-24 H1 2FL	119817	10.59
10-24 H2 2FL	119830	9.70
10-24 H3 2FL	119854	8.52
10-24 H5 2FL	119869	10.63
10-24 H7 2FL	119878	10.63
10-32 H1 2FL	120339	9.70
10-32 H2 2FL	120352	8.52
10-32 H3 2FL	120376	8.52
10-32 H5 2FL	120389	10.58
10-32 H7 2FL	120390	10.58
12-24 H1 2FL	120583	10.58
12-24 H3 2FL	120601	9.70
12-28 H3 2FL	120777	9.70



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