GUANG ZHOU JHOME CNC TOOLS CO.,LTD

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JHOME

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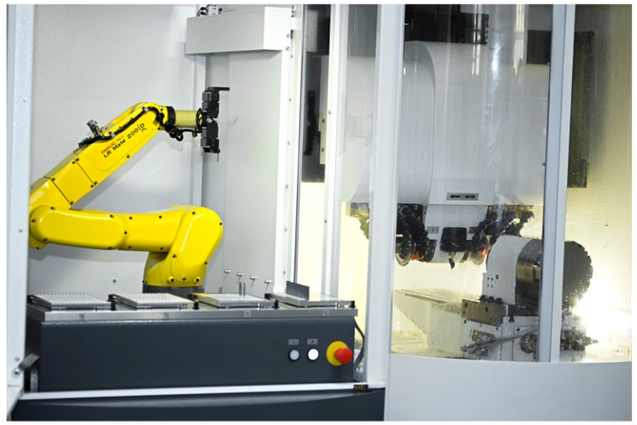
Company SHOW



ABOUT US

JHOME CNC Tools Co.,Ltd is a manufacturer from Guangzhou , China. specialized in the sale and production.

We provide the highest quality tools with the most competitive price and fastest delivery and technology service in all aspects to CNC machine tool user all around the world.

JHOME CNC Tools Co., Ltd is always advocating the management idea and high efficiency of CNC production line to improve our quality and short the production time.

We have introduced the most advanced CNC machine & technology from Germany,using the highest quality material to manufacture the highest quality product . such as tungsten end mills, carbide insert and carbide drills. we have full faith to meet with your requirements.

Welcome to your inquiry !!!

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PRODUCT DESCRPTION

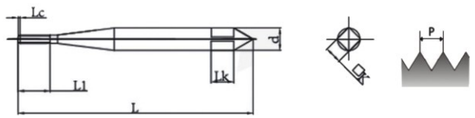
Forming Taps

Material: cps Unit: mm

PRODUCTS APPEARANCE AND DIAMENSION LIST

SPECIFICATION	L	L1	d	K
M1.0*0.25 RH4	32.5	3.5	3	2.5*3
M1.0*0.25 RH4	32.5	4.5	3	2.5*3
M1.2*0.25 RH4	32.5	3.5	3	2.5*3
M1.2*0.25 RH4	32.5	4.5	3	2.5*3
M1.4*0.3 RH4	37	6.5	3	2.5*3
M1.6*0.35 RH5	37	8	3	2.5*3

Timepiece Industry



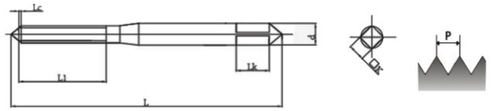
2 chamfers,for blind hole

4 chamfers,for through hole

IT & Electronics

PRODUCT DESCRPTION

Forming Taps



2 chamfers,for blind hole

4 chamfers,for through hole

Material: cps Unit: mm

PRODUCTS APPEARANCE AND DIAMENSION LIST

SPECIFICATION	L	L1	d	K
M1.7*0.35 RH4	37	8	3	2.5*3
M1.8*0.35 RH4	37	8	3	2.5*3
M2*0.4 RH5	45	10	3	2.5*3
M2.3*0.4 RH5.	45	10	3	2.5*3
M2.5*0.45 RH5	45	13	3	2.5*3
M2.6*0.45 RH5	45	13	3	2.5*3
M3*0.5 RH7	50	16	4	3.2*6
M3.5*0.6 RH7	50	16	4	3.2*6
M4*0.7 RH7	57	18	5	4*7
M5*0.8 RH7	66	20	5.5	4.5*7

Material: cps Unit: mm

PRODUCTS APPEARANCE AND DIAMENSION LIST

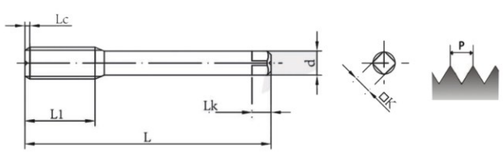
SPECIFICATION	L	L1	d	K
NO.0-80UNF RH4	37	6.5	3	2.5*3
NO.1-64UNC RH4	37	9	3	2.5*3
NO.1-72UNF RH4	37	9	3	2.5*3
NO.2-56UNC RH4	45	12	3	2.5*3
NO.3- 48UNC RH4	45	15	3	2.5*3
NO.4-40UNC RH4	45	15	3	2.5*3
NO.5-40UNC RH5	50	15	4	3.2*6
NO.6-32UNC RH6	50	16	4	3.2*6
NO.8-32UNC RH7	57	18	5	4*7
NO.10-24UNC Rh7	66	20	5.5	4.5*7
NO.10-32UNC Rh7	66	20	5.5	4.5*7
NO.12-24UNC Rh7	66	20	5.5	4.5*7
NO.12-28UNC RH7	66	20	5.5	4.5*7

FEATURES AND APPLICATION

Features: thread size≤M5: normally without oil groove, please note in the order if needed; thread size M6-M8 (including M6):with 2 oil grooves ; thread size M8-M10 (including M8): with 3 oil grooves; thread size≥M10 (including M10):with 6 oil grooves

PRODUCT DESCRPTION

Forming Taps



2 chamfers,for blind hole
4 chamfers,for through hole

Material: cps Unit: mm

PRODUCTS APPEARANCE AND DIAMENSION LIST

SPECIFICATION	L	L1	d	K
M6*1.0 RH7	62	24	6	4.5*7
M7*1.0 RH7	70	13	6.2	5*8
M8*1.0 RH7	70	13	6.2	5*8
M8*1.25 RH7	70	13	6.2	5*8
M10*1.0 RH7	75	13	7	5.5*8
M10*1.25 RH7	75	13	7	5.5*8
M10*1.5 RH7	75	15	7	5.5*8
M12*1.0 RH7	82	13	8.5	6.5*9
M12*1.25 RH8	82	13	8.5	6.5*9
M12*1.5 RH8	82	17	8.5	6.5*9
M12*1.75 RH8	82	17	8.5	6.5*9
M14*1.0 RH7	88	13	10.5	8*11
M14*1.25 RH7	88	13	10.5	8*11
M14*1.5 RH8	88	20	10.5	8*11
M14*2.0 RH8	88	20	12.5	10*13
M16*1.0 RH8	95	13	12.5	10*13
M16*1.25 RH8	95	13	12.5	10*13
M16*1.5 RH8	95	20	12.5	10*13
M16*2.0 RH9	95	20	12.5	10*13

FEATURES AND APPLICATION

Features: thread size≤M5: normally without oil groove, please note in the order if needed; thread size M6-M8(including M6):with 2 oil grooves ; thread sizeM8-M10(including M8): with 3 oil grooves; thread size≥ M10 (including M10):with 6 oil grooves

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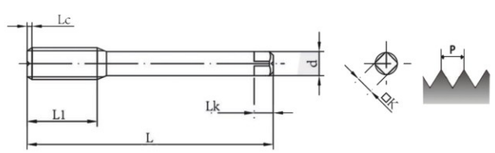
SHAPES AND FEATURES OF FORMING TAPS

PRODUCT DESCRPTION

Forming Taps



2 chamfers,for blind hole
4 chamferS,for through hole

Material: cps Unit: mm

PRODUCTS APPEARANCE AND DIAMENSION LIST

SPECIFICATION	L	L1	d	K
1/4 20UNC RH7	62	24	6	4.5*7
1/4-28UNF RH7	62	24	6	4.5*7
5/16-18UNC RH7	70	15	6.1	5*8
5/16-24UNF RH7	70	11	6.1	5*8
3/8-16UNC RH7	75	16	7	5.5*8
3/8- 24UNF RH7	75	11	7	5.5*8
7/16-20UNF RH7	80	13	8	5*8
1/2-13UNC RH8	85	21	9	7*10
1/2-20UNF RH8	85	13	9	7*10
9/16-18UNF RH7	90	15	10.5	8*11
5/8-11UNC RH9	95	23	12	9*12
W1/8-40 RH6	50	15	4	3.2*6
W5/32-32 RH7	66	18	5	47
W3/16-24 RH7	66	18	5.5	4.5*7
W1/4-20 RH7	62	24	6	4.5*7
W5/16-18 RH7	70	15	6.1	5*8
W3/8-16 RH7	75	16	7	5.5*8
W1/2-12 RH8	85	21	9	7*10
W5/8-11 RH9	95	23	12	9*12

FEATURES AND APPLICATION

Features: thread size≤M5: normally without oil groove, please note in the order if needed; thread size M6-M8(including M6):with 2 oil grooves ; thread size M8-M10(including M8): with 3 oil grooves; thread size≥ M10 (including M10):with 6 oil grooves

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PRODUCT DESCRPTION

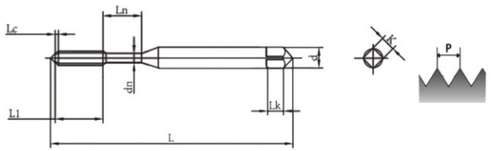
Cutting Taps

Material: HSSE Unit:mm

PRODUCTS APPEARANCE AND DIAMENSION LIST

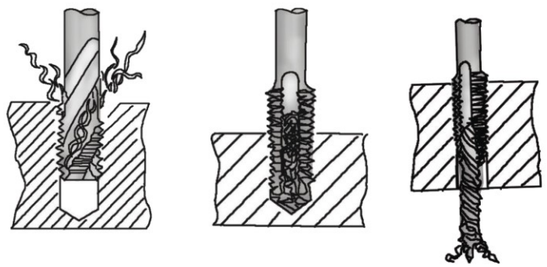
SPECIFICATION	L	L1	d	K	LK	dn	ln
M1*0.25 P1	32	6.5	3	2.5	3		
M1.2*0.25 P1	32	6.5	3	2.5	3		
M1.4*0.3 P1	37	9.5	3	2.5	3		
M1.6*0.35 P1	37	10	3	2.5	3		
M2*0.4 P1	45	9	3	2.5	3	1.4	6
M2.5*0.45 P2	45	9	3	2.5	3	1.9	7
M3*0.5 P2	50	12	4	3.2	6	2.3	7
M3.5*0.6 P2	50	13	4	3.2	6	2.6	7
M4*0.7 P2	57	14	5	4	7	3	7
M5*0.8 P2	66	16	5.5	4.5	7	4	9
NO.4- 40UNC P2	45	10	3	2.5	3	2	6
NO.5-40UNC P2	50	12	4	3.2	6	2.3	7
NO.6-32UNC P2	50	13	4	3.2	6	2.4	7
NO.8-32UNC P2	57	13.5	5	4	7	3	8
NO.10-24UNC P2	66	16.5	5.5	4.5	7	3.4	9.5
NO.12-24UNC P2	66	16.5	5.5	4.5	7	4	9.5

Remark : Please see taps drlling size on page 23-24
If machine feeding speed is not stable ,may cause internal thread expand



Point taps
Downward chip, for through hole

Processing schematic drawing



SHAPES AND CHARACTERIATICS OF CUTTING TAPS

PRODUCT DESCRPTION

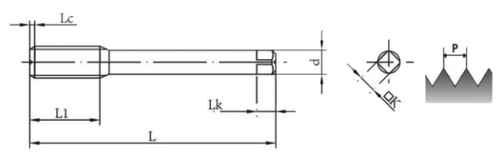
Cutting Taps

Material: HSSE Unit:mm

PRODUCTS APPEARANCE AND DIAMENSION LIST

SPECIFICATION	L	L1	d	K	LK	dn	ln
M6*1 P2	62	19.5	6	4.5	7	4.6	9.5
M8*1.25 P3	70	22	6.2	5	8		
M8*1 P3	70	22	6.2	5	8		
M10*1.5 P3	75	24	7	5.5	8		
M10*1.25 P3	75	24	7	5.5	8		
M10*1 P3	75	24	7	5.5	8		
M12*1.75 P3	82	29	8.5	6.5	9		
M12*1.5 P3	82	29	8.5	6.5	9		
M12*1.25 P3	82	29	8.5	6.5	9		
M12*1 P3	82	29	8.5	6.5	9		
M14*2 P4	88	20	10.5	8	11		
M14*1.5 P4	88	20	10.5	8	11		
M14*1.25 P4	88	20	10.5	8	11		
M14*1 P4	88	20	10.5	8	11		
M16*2 P4	95	20	12.5	10	13		
M16*1.5 P4	95	20	12.5	10	13		
M16*1.25 P4	95	20	12.5	10	13		
M16*1 P4	95	20	12.5	10	13		
1/4-20UNC P2	62	19.5	6	4.5	7	4.6	9.5
5/16-18UNC P3	70	23	6.1	5	8		
3/8-16UNC P3	75	24	7	5.5	8		
7/16-14UNC P3	80	29	8	6	9		
1/2-13UNC P3	85	30	9	7	10		
9/16-12UNC P4	90	30	10.5	8	11		
5/8-11UNC P4	95	23	12	9	12		

Remark : Please see taps drling size on page 23-24.
If machine feeding speed is not stable ,may cause internal thread expand

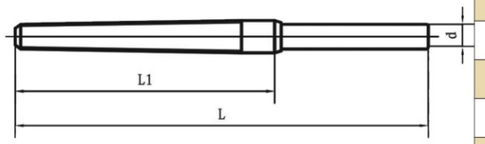


Spiral flute taps
Upward chip, for blind hole

PRODUCT DESCRPTION

Nut Taps

General usage



Above M8 taps specifications

Material: HSSE Unit: mm

PRODUCTS APPEARANCE AND DIAMENSION LIST

SPECIFICATION	Overall Length	Cutting Length	Number Of Teeth	Shank dia	Number Of Flutes
M3*0.5	55	12	24	2.3	3
M4*0.7	67	17	24	3	3
M5*0.8	67	19	24	3.8	3
M6*1.0	70	24	24	4.6	3
M7*1.0	82	24	24	5.6	3
M8*1.25	85	32	24	6	5
M10*1.5	95	38	24	8	5
M12*1.75	102	46	24	9.5	5
M14*2.0	114	52	24	11.2	5
M16*2.0	127	52	24	13.1	5
M18*2.5	133	64	24	14	5
NO.6-32UNC	62	19	24	2.4	3
NO.8-32UNC	65	19	24	3.1	3
NO.10-24UNC	65	25	24	3.4	3
NO.12-24UNC	70	25	24	4	3
1/4-20UNC	75	30	24	4.6	3
5/16-18UNC	80	35	24	6	5
3/8-16UNC	89	40	24	7.3	5
7/16-14UNC	102	47	24	8.6	5
1/2-13UNC	102	50	24	10	5
9/16-12UNC	114	54	24	11	5
5/8-11UNC	127	59	24	12.8	5
3/4-10UNC	133	64	24	15	5
7/8-9UNC	145	72	24	17	5
1"- 8UNC	170	80	24	20	5

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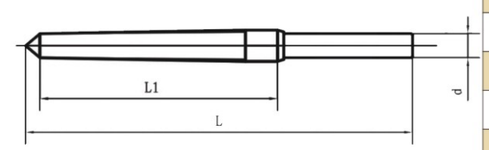
SPECIFICATIONS AND FEATURES OF NUT TAPS

PRODUCT DESCRPTION

Nut Taps

Special for stainless steel



From M3 to M7 taps specifications

Suitable for taps automated processing , long life, high fficiency and good wear resistance. If taps demage ,can be reused after grinding, keep same precision, dramatically reducing the cost of production.

Material: HSSE Unit: mm

PRODUCTS APPEARANCE AND DIAMENSION LIST

SPECIFICATION	Overall Length	Cutting Length	Number Of Teeth	Shank dia	Number Of Flutes
M3*0.5	55	5	80	2.3	3
M4*0.7	57	21	80	3	3
M5*0.8	67	24	80	3.8	3
M6*1.0	70	28	28	4.6	3
M7*1.0	82	30	30	5.6	3
M8*1.25	85	39	B0	6	5
M10*1.5	)5	47	80	8	5
M12*1.75	102	56	30	9.5	5
M14*2.0	114	64	30	11.2	5
M16*2,0	127	64	30	13.1	5
M18*2.5	133	79	30	14	5
NO.6-32UNC	62	24	30	2.4	3
NO.8-32UNC	65	24	30	3.1	3
NO.10-24UNC	65	32	30	3.4	3
NO.12-24UNC	70	32	80	4	3
1/4- 20UNC	75	36	28	4.6	3
5/16-18UNC	80	41	28	6	5
3/8- 16UNC	89	49	30	7.3	5
7/16-14UNC	102	58	30	8.6	5
1/2-13UNC	102	52	30	10	5
9/16-12UNC	114	7	30	11	5
5/8-11UNC	127	73	30	12.8	5
3/4- 10UNC	133	80	80	15	5
7/8-9UNC	145	39	80	17	5
1"-8UNC	170	118	36	20	5

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PRODUCT DESCRPTION

DIN371 Cutting Taps

Material: HSSE Unit: mm

PRODUCTS APPEARANCE AND DIAMENSION LIST

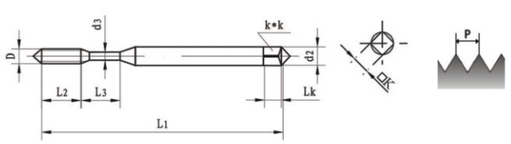
SPECIFICATION	L1	d2	L2	k	Lk	L3
M1*0.25	40	2.5	4.5	2.1	5	-
M1.1*0.25	40	2.5	4.5	2.1	5	-
M1.2*0.25	40	2.5	5.5	2.1	5	-
M1.4*0.3	40	2.5	7	2.1	5	-
M1.6*0.35	40	2.5	8	2.1	5	-
M1.7*0.35	40	2.5	8	2.1	5	-
M1.8*0.35	40	2.5	8	2.1	5	-
M2*0.4.	45	2.8	10	2.1	5	-
M2.5*0.45	50	2.8	13	2.1	5	-

Remark;below M7 is outside-point, above M8 is inside-point

Material: HSSE Unit: mm

PRODUCTS APPEARANCE AND DIAMENSION LIST

SPECIFICATION	L1	d2	L2	L3	d2	k	Lk
M3*0.5	56	3.5	10	8	2.4	2.7	6
M3.5*0.6	56	4	11	9	2.8	3	6
M4*0.7	63	4.5	12	9	3.15	3.4	6
M4.5*0.75	70	6	12	13	3.6	4.9	8
M5*0.8	70	6	14	11	4.05	4.9	8
M6*1	80	6	15	15	4.8	4.9	8
M7*1	80	7	15	15	5.8	5.5	8
M8*1.25	90	8	18	17	6.5	6.2	9
M10*1.5	100	10	22	17	8.25	8	11



Remark:below M7 is outside-point, above M8 is inside-point

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SHAPES AND FEATURES OF DIN CUTTNG TAPS

PRODUCT DESCRPTION

DIN371 Cutting Taps

Material: HSSE Unit: mm

PRODUCTS APPEARANCE AND DIAMENSION LIST

SPECIFICATION	L1	d2	L2	L3	d3	k	Lk
NO.1-64UNC	45	2.8	9	-	-	2.1	5
N0.2-56UNC	45	2.8	12	-	-	2.1	5
NO.3-48UNC	50	2.8	15	-	-	2.1	5
NO.4-40UNC	50	3.5	10	8	2.1	2.7	6
NO.5-40UNC	56	3.5	10	8	2.4	2.7	6
N0.6-32UNC	56	4	12	8	2.55	3	6
NO.8-32UNC	63	4.5	12	9	3.2	3.4	6
NO.10-24UNC	70	6	16	9	3.4	4.9	8
NO.12-24UNC	80	6	16	9	4.2	4.9	8
1/4-20UNC	80	7	19	11	4.8	5.5	8
5/16-18UNC	90	8	20	15	6.3	6.2	9
3/8-16UNC	100	10	22	17	7.7	8	11

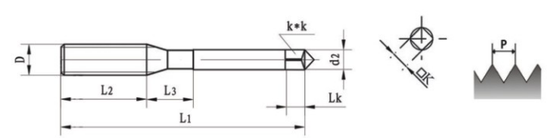
Remark:below 1/4 is outside- point, above 3/8 is inside-point

DIN376 Cutting Taps

Material: HSSE Unit: mm

PRODUCTS APPEARANCE AND DIAMENSION LIST

SPECIFICATION	L1	d2	L2	k	Lk	L3
M12*1.75	110	9	26	7	10	23
M14*2	110	11	30	9	12	23
M16*2	110	12	30	9	12	24
M18*2.5.	125	14	36	11	14	26
M20*2.5	140	16	36	12	14	26
5/16-18UNC	90	6	20	4.9	8	15
3/8-16UNC	100	7	22	5.5	8	17
7/16-14UNC	100	8	27	6.2	9	15
1/2-13UNC	110	9	28	7	10	21
9/16-12UNC	110	11	30	9	12	23
5/8-11UNC	110	12	32	9	12	21



Remark:below M7 is outside-point, above M8 is inside-point, below 1/4 is outside-point, above 3/8 is inside-point.

Tel: 0086-13539027780
Head Add: 12# xinghe industry park changan Town Dongguan, China.

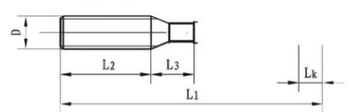
PRODUCT DESCRPTION

DIN374 Cutting Taps

Material: HSSE Unit: mm

PRODUCTS APPEARANCE AND DIAMENSION LIST

SPECIFICATION	L1	d2	L2	k	Lk	L3
M8*0.5	80	6	15	4.9	8	15
M8*0.75	90	6	15	4.9	8	15
M8*1	90	6	15	4.9	8	20
M10*0.5	90	7	15	5.5	8	20
M10*0.75	90	7	15	5.5	8	20
M10*1	90	7	15	5.5	8	20
M10*1.25	100	7	17	5.5	8	22
M12*1	100	9	20	7	10	20
M12*1.25	100	9	20	7	10	20
M12*1.5	100	9	20	7	10	20
M14*1	100	11	20	9	12	20
M14*1.25	100	11	20	9	12	20
M14*1.5	100	11	20	9	12	20
M16*1	100	12	22	9	12	22
M16*1.25	100	12	22	9	12	22
M16*1.5	100	12	22	9	12	22



Remark : below M7 is outside-point, above M8 is inside -point

Remark : Please see taps drlling size on page 23-24
If machine feeding speed is not stable ,may cause internal thread expand

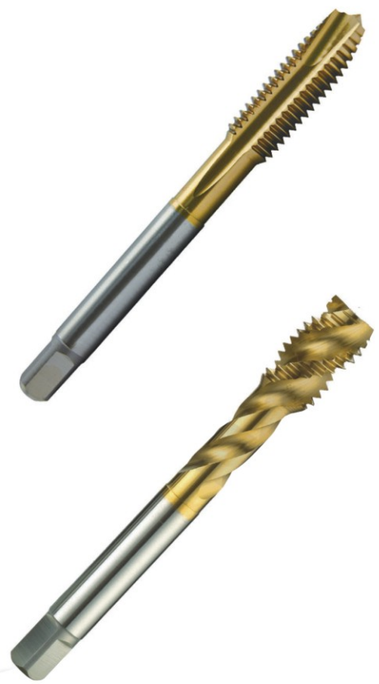
Tel: 0086-13539027780
Head Add: 12# xinghe industry park changan Town Dongguan, China.

SHAPES AND FEATURES OF DIN CUTTNG TAPS

PRODUCT DESCRPTION

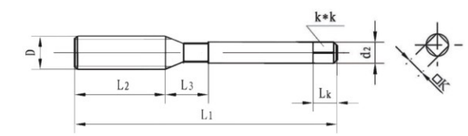
DIN374 Cutting Taps

Material: HSSE Unit: mm



PRODUCTS APPEARANCE AND DIAMENSION LIST

SPECIFICATION	L1	d2	L2	k	Lk	L3
5/16-24UNF	90	6	16	4.9	8	19
3/8- 24UNF	90	7	16	5.5	8	19
7/16-20UNF	100	8	20	6.2	9	24
1/2-20UNF	100	9	20	7	10	24
9/16-18UNF	100	11	24	9	12	20
5/8-1 8UNF	100	12	24	9	12	20



Remark : below 1/4 is outside- point above 5/16 is inside -point

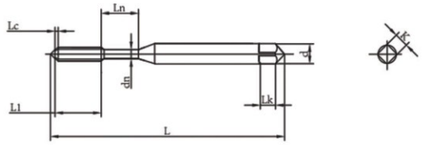
Remark : Please see taps drling size on page 23-24
If machine feeding speed is not stable ,may cause internal thread expand

Tel: 0086-13539027780
Head Add: 12# xinghe industry park changan Town Dongguan, China.

PRODUCT DESCRPTION

Standard Forming Taps With Regular Neck

2 chamfers,for blind hole
4 chamfers,for through hole



Material: cps Unit: mm

PRODUCTS APPEARANCE AND DIAMENSION LIST

SPECIFICATION	Dimensions						
	L	L1	d	k	Lk	dn	ln
M2*0.4 RH4	45	7	3	2.5	3	1.8	6
M25*0.45 RH5	45	8	3	2.5	3	2.2	7
M3*05 RH7	50	10	4	3.2	6	2.3	8
M3.5*0.6 RH7	50	10	4	3.2	6	2.6	8
M4*0.7 RH7	57	11	5	4	7	3	9
M5*0.8 RH7	66	12	5.5	4.5	7	4	10
M6*1.0 RH7	62	12	6	4.5	7	4.6	12
M7*1.0 RH7	70	13	6.2	5	8	5.6	10
N0.4-40UNC RH5	45	9	3	2.5	3	2	7
NO.540UNC RH5	50	10	4	3.2	6	2.3	8
N0.6-32UNC RH6	50	10	4	3.2	6	2.4	8
N0.832UNC RH7	57	11	5	4	7	3	9
NO.10-24UNCRH7	66	12	5.5	4.5	7	3.4	10
N0.12-24UNCRH7	66.	12	5.5	4.5	7	4	12
1/4-20UNC RH7	62	12	6	4.5	7	4.6	12
W1/4-20 RH7	62	12	6	4.5	7	4.6	12

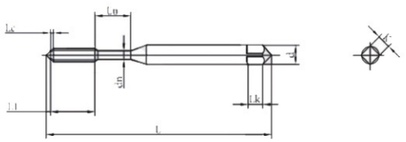
Remark:taps below M5 are external tip without oil groove, M6 and 1/4 are inside tip with oil groove

Tel: 0086-13539027780
Head Add: 12# xinghe industry park changan Town Dongguan, China.

PRODUCT DESCRPTION

Long Shank Forming Taps With Regular Neck

2 chamfers,for blind hole
4 chamfers,for through hole



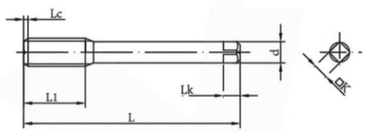
Material: cps Unit:mm

PRODUCTS APPEARANCE AND DIAMENSION LIST

SPECIFICATION	Dimensions						
	L	L1	d	k	Lk	dn	ln
M2*0.4 RH4	50-80	7	3	2.5	5	1.8	6
M2.5*0.45 RH5	50-80	8	3	2.5	5	2.2	7
M3*0.5 RH7	60-100	10	4	3.2	6	2.3	8
M3.5*0.6 RH7	60-100	10	4	3.2	6	2.6	8
M4*0.7 RH7	65-100	11	5	4	7	3	9
M5*0.8 RH7	80-100	12	5.5	4.5	7	4	10
M6*1.0 RH7	70-100	12	6	4.5	7	4.6	12
M7*1.0 RH7	80-120	13	6.2	5	8	5.6	10
NO.4-40UNC RH5	50-80	9	3	2.5	3	2	7
NO.5-40UNC RH6	60-80	10	4	3.2	6	2.3	8
NO.6-32UNC RH7	60-100	10	4	3.2	6	2.4	8
NO.8-32UNC RH7	65-100	11	5	4	7	3	9
NO.10-24UNC RH7	80-100	12	5.5	4.5	7	3.4	10
NO.12-24UNC RH7	80-100	12	5.5	4.5	7	4	12
1/4-20UNC RH7	70-120	12	6	4.5	7	4.6	12

Left Hand Forming Taps

2 chamfers,for blind hole
4 chamfers,for through hole



Remark: left hand taps specifications is same with standard taps,pls see PO2-P04.

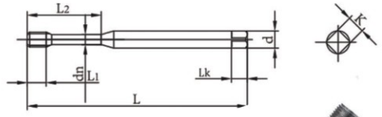
Tel: 0086-13539027780
Head Add: 12# xinghe industry park changan Town Dongguan, China.

SPECIFICATIONS AND FEATURES OF NON-STANDARD TAPS

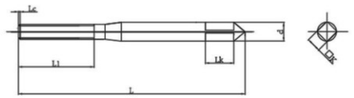
PRODUCT DESCRPTION

Deep Hole High Speed Forming Taps

4 chamfers,for through hole



2 chamfers,for blind hole
4 chamfers,for through hole



Material: cps Unit:mm

PRODUCTS APPEARANCE AND DIAMENSION LIST

SPECIFICATION	Dimensions						
	L	L1	d	k	Lk	dn	ln
M3*0.5 RH7	70	4	6	4.5	7	2.3	18
M4*0.7 RH7	70	5.6	6	4.5	7	3	21
M5*0.8 RH7	70	6.4	6	4.5	7	3.9	25
M6*1.0 RH7	80	8	6	4.5	7	4.6	30
M8*1.25 RH7	90	10	7	5.5	8	6.4	35
M10*1.5 RH7	90	12	8.5	6.5	9	8	39
M12*1.75 RH8	100	12	10.5	8	11	12	42
M14*2.0 RH9	100	12	12.5	10	13	12	49
M16*2.0 RH9	100	12	14	11	14	13.5	50

Fine Thread Forming Taps

Material: cps Unit:mm

PRODUCTS APPEARANCE AND DIAMENSION LIST

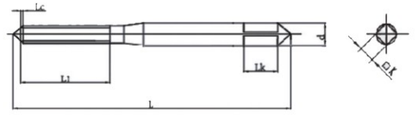
SPECIFICATION	Dimensions						
	L	L1	d	k	Lk	dn	ln
M1*0.2 RH4	32	3	3	2.5	3		
M1.2*0.2 RH4	32	3	3	2.5	3		
M1.4*0.2 RH4	37	3	3	2.5	3		
M1.6*0.2 RH4	37	3	3	2.5	3		
M2*0.25 RH4	45	4	3	2.5	3	1.6	5
M3*0.35 RH6	50	6	4	3.2	6	2.4	8
M4*0.5 RH6	57	8	5	4	7	3.2	8
M5*0.5 RH6	66	8	5.5	4.5	7	4.2	8
M6*0.5 RH6	62	8	5.5	4.5	7	5.2	10
M6*0.75 RH7	62	12	6	4.5	7	4.9	12
M8*0.75 RH7	70	13	6.2	5	8		
M10*0.75 RH7	75	13	7	5.5	8		

Tel: 0086-13539027780
Head Add: 12# xinghe industry park changan Town Dongguan, China.

PRODUCT DESCRPTION

STI Forming Taps

2 chamfers,for blind hole
4 chamfers,for through hole



Materia: cps Unit: mm

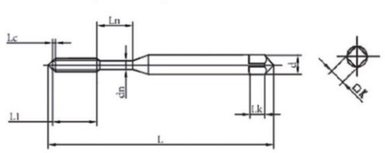
PRODUCTS APPEARANCE AND DIAMENSION LIST

SPECIFICATION	Dimensions				
	L	L1	d	k	Lk
M3X0.5	50	16	4	3.2	6
M4X0.7	66	18	5.5	4.5	7
M5X0.8	62	24	6	4.5	7
M6X1	70	13	6.2	5	8
M8X1.25	75	13	7	5.5	8
M10X1.5	82	17	8.5	6.5	9
M12X1.75	88	20	10.5	8	11

Note: M3 /M4 is external tip

STI Spiral Flute Taps

Upward chip, for blind hole



PRODUCTS APPEARANCE AND DIAMENSION LIST

SPECIFICATION	Dimensions						
	L	L1	d	k	Lk	dn	ln
M3X0.5	50	11	4	3.2	6	3	9
M4X0.7	66	12	5.5	4.5	7	4	10
M5X0.8	62	12	6	4.5	7	4.6	12
M6X1	70	13	6.2	5	8		
M8X1.25	75	15	7	5.5	8		
M10X1.5	82	17	8.5	6.5	9		
M12X1.75	88	20	10.5	8	11		

Note: M3/M4 is external tip, the others are internal tip
please see page19 taps drilling size

PRODUCT DESCRPTION

Automotive Valve Forming Taps

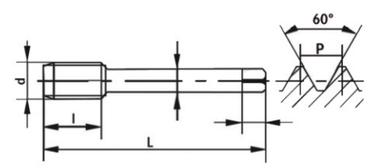
Materia: cps Unit: mm

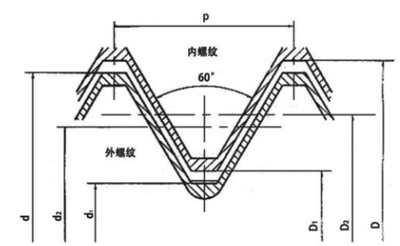
PRODUCTS APPEARANCE AND DIAMENSION LIST

SPECIFICATION	Dimensions				
	L	L1	d	k	Lk
5V1	66	18	5.5	4.5	7
5V2	66	18	5.5	4.5	7
6V1	62	24	6	4.5	7
8V1	70	13	6.2	5	8
8V2	70	13	6.2	5	8
9V1	75	13	7	5.5	8
12V1	85	13	9	7	10
13V1	85	13	9	7	10
13V2	85	13	9	7	10

P- pitch; d -thread major diameter; d1 - external thread min diamter; d2-external thread pitch diameter; D - intern thread major diameter; D1 - internal thread min diameter; D2 - internal thread pitch diameter

Processing automobiles, motorcycles,
bicycles and other kinds of tires
valve thread





PRODUCT DESCRPTION

Thread Plug Gauge

Material: HSS Unit: mm

PRODUCTS APPEARANCE AND DIAMENSION LIST

SPECIFIC ATION	Precision	Thread Size	Precision
M1*0.25	5H	M7*1	6H
M1.2*0.25	5H	M8*1.25	6H
M1.4*0.3	6H	M8*1	6H
M1.6*0.35	6H	M10*1.5	6H
M1.7*0.35	6H	M10*1.25	6H
M1.8*0.35	6H	M10*1	6H
M2*0.4	6H	M12*1.75	6H
M2.5*0.45	6H	M12*1.5	6H
M2.6*0.45	6H	M12*1.25	6H
M3*0.5	6H	M12*1	6H
M3.5*0.6	6H	M14*2	6H
M4*0.7	6H	M14*1.5	6H
M5*0.8	6H	M16*2	6H
M6*1	6H	M16*1.5	6H

Plug gauge use hss material, the size <3mm' hardness is HRC53-60°⩾3mm the hardness is HRC58-60°, go and no go plgu gauge precision can be 5H, 6H, also can be 6G, 7H. Size⩽M1.4 can be 5H, go end gauge use GP to mark T=GO=GR, not go end use IP to mark Z= NO=NR.

Tel: 0086-13539027780
Head Add: 12# xinghe industry park changan Town Dongguan, China.

SPECIFICATIONS AND FEATURES OF THREAD PLUG GAUGE

PRODUCT DESCRPTION

Thread Plug Gauge

Material: HSS Unit: mm

PRODUCTS APPEARANCE AND DIAMENSION LIST

SPECIFIC ATION	Precision	Thread Size	Precision
N0.4 40 UNC	2B	1/2-13 UNC	2B
NO.5-40UNC	2B	1/2-20 UNF	2B
N0.6-32 UNC	2B	9/16-12 UNC	2B
N0.8-32 UNC	2B	5/8-11 UNC	2B
NO.10-24 UNC	2B	5/8-18 UNF	2B
N0.10-32 UNF	2B	5/8-24 UNEF	2B
N0.12-24 UNC	2B	W1/8-40	2B
N0.12-28 UNF	2B	W5/32-32	2B
1/4-20 UNC	2B	W3/16-24	2B
1/4 28 UNF	2B	W1/4-20	2B
5716-18 UNC	2B	W5716-18	2B
5/16-24 UNF	2B	W3/8-16	2B
3/8- 16 UNC	2B	W1/2-12	2B
3/8-24 UNF	2B	W5/8-11	2B
7/16-14 UNC	2B		
7/16-20 UNF	2B		

Plug gauge use hss material, the size <3mm' hardness is HRC53-60°,⩾3mm the hardness is HRC58-60°, go and no go plgu gauge precision can be 5H, 6H, also can be 6G, 7H. Size⩽M1.4 can be 5H, go end gauge use; GP to mark T=GO=GR, not go end use IP to mark Z= NOF NR.

Tel: 0086-13539027780
Head Add: 12# xinghe industry park changan Town Dongguan, China.

PRODUCT DESCRPTION

SPECIFICATION	For JIS class 1 drill hole dia		For JIS class 2 drill hole dia	
	RH	MIN~MAX	RH	MIN~MAX
	Precision	Thread Grip Ratio:%	Precision	Thread Grip Ratio:%
M1 X0.25	2	0.87 ~0.89 (100~85)	4	0.90 ~0.92 (100~80)
1.2 X0.25	2	1.07 ~1.09 (100~85)	4	1.10 ~1.12 (100~80)
1.4X0.3	2	1.244 ~1.263 (100~85)	4	1.270 ~1.294 (100~80)
1.6 X0.35	2	1.40 ~1.44 (100~80)	4	1.44 ~1.48 (100~75)
1.7 X0.35	2	1.51 ~1.54 (100~80)	4	1.54 ~1.58 (100~75)
2 X0.4	2	1.78 ~1.82 (100~80)	4	1.81 ~1.85 (100~75)
2.3 X0.4	2	2.08 ~2.12 (100~80)	4	2.11 ~2.15 (100~75)
2.5 X0.45	2	2.25 ~2.29 (100~80)	4	2.28 ~2.33 (100~75)
2.6 X0.45	2	2.35 ~2.39 (100~80)	4	2.38 ~2.43 (100~75)
3 X0.5	3	2.74 ~2.78 (100~80)	5	2.76 ~2.81 (100~75)
3.5 X0.6	3	3.18 ~3.21 (100~85)	5	3.20 ~3.26 (100~75)
4 X0.7	4	3.63 ~3.67 (100~85)	6	3.65 ~3.70 (100~85)
5 X0.8	4	4.57 ~4.62 (100~85)	6	4.59 ~4.66 (100~80)
6 X1.0	4	5.45 ~5.51 (100~85)	7	5.48 ~5.57 (100~80)
7 X1.0	4	6.45 ~6.51 (100~85)	7	6.48 ~6.57 (100~80)
8 X1.25	5	7.31 ~7.38 (100~85)	7	7.34 ~7.41 (100~85)
10 X1.5	5	9.16 ~9.22 (100~90)	7	9.18 ~9.28 (100~85)
12 X1.75	5	11.01 ~11.08 (100~90)	8	11.05 ~11.15 (100~85)
14 X2.0	6	12.83 ~12.95 (100~90)	10	12.92 ~13.04 (100~85)
16 X2.0	6	14.87 ~14.95 (100~90)	10	14.92 ~15.04 (100~85)

NRT hole diameter calculating mode

1.dN=D-P*0.45 2.dN=D-0.2P-0.00403. P. f1+0.0127・n

dN=Hole diameter D=Diameter

P=Pitch

f1=Thread overlap ratio

n=RH

Eg: M3*0.5 RH6 JIS class 2 drill hole

Thread overlap ratio 90%

dN=3-0.2*0.5-0.00403・0.5・90+0.0127・6=2.79

Tel: 0086-13539027780
Head Add: 12# xinghe industry park changan Town Dongguan, China.

DRILLING SIZE OF FORMING TAPS

PRODUCT DESCRPTION

Unit: mm

SPECIFICATION	For JIS class 2B drill hole dia		For JIS class 3B drill hole dia	
	RH	MIN~MAX	RH	MIN~MAX
	Precision	Thread Grip Ratio:%	Precision	Thread Grip Ratio:%
N0.2~56UNC	4	1.96 ~2.02 (100~65)	3	1.95 ~2.01 (100~65)
2~64	3	1.98 ~2.04 (100~65)	2	1.97 ~2.03 (100~65)
3~48	4	2.25 ~2.32 (100~65)	3	2.23 ~2.31 (100~65)
4~40	5	2.52 ~2.60 (100~70]	3	2.50 ~2.58 (100~70)
4~48	4	2.57 ~2.64 (100~70)	3	2.56 ~2.63 (100~70)
6~32	5	3.09 ~3.17 (100~75)	3	3.06 ~3.14 (100~75)
6~40	5	3.19 ~3.26 (100~70)	3	3.16 ~3.22 (100~75)
8~32	6	3.75 ~3.83 (100~75)	4	3.74 ~3.82 (100~75)
10~24	6	4.26 ~4.35 (100~80)	4	4.24 ~4.32 (100~80)
10~32	5	4.41 ~4.48 (100~80)	4	4.40 ~4.46 (100~80)
12~28	5	5.00 ~5.08 (100~80)	4	4.99 ~5.06 (100~80)
1/4~20	6	5.66 ~5.76 (100~80)	4	5.64 ~5.74 (100~80)
1/4~28	5	5.86 ~5.93 (100~80)	4	5.85 ~5.92 (100~80)
5/16~18	7	7.18 ~7.29 (100~80) .	5	7.15 ~7.24 (100~85)
5/16~24	6	7.38 ~7.46 (100~80)	5	7.36 ~7.43 (100~85)
3/8~16	7	8.66 ~8.78 (100~80]	5	8.63 ~8.73 (100~85)
3/8~24	7	8.96 ~9.05 (100~80]	5	8.95 ~9.02 (100~85)
7/16~20	8	10.44 ~10.54 (100~80)	5	10.41 ~10.49 (100~85)
1/2~13	6	11.62~11.78 (100~80)	6	11.60~11.68 (100~90)
1/2~20	7	12.02 ~12.12 (100~80)	5	12.00 ~12.05 (100~90)
5/8~11	11	14.62 ~14.76 (100~85)	8	14.58 ~14.67 (100~90)
5/8~18	9	15.14 ~15.25 (100~80)	7	15.11 ~15.17 (100~90)

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PRODUCT DESCRPTION

Unit:mm

Specification(M)		Standard Hole Dia	For JIS Class2 Drill Hole Dia	
			Max	Min
M1.0	0.25	0.75	0.785	0.729
M1.1	0.25	0.85	0.885	0.829
M1.2	0.25	0.95	0.985	0.929
M1.4	0.3	1.10	1.142	1.075
M1.6	0.35	1.25	1.321	1.221
M1.7	0.35	1.35	1.421	1.321
M1.8	0.35	1.45	1.521	1.421
M2.0	0.4	1.60	1.679	1.567
M2.2	0.45.	1.75	1.838	1.713
M2.3	0.4	1.90	1.979	1.867
M2.5	0.45	2.10	2.138	2.013
M2.6	0.45	2.20	2.238	2.113
M3.0	0.5	2.50	2.599	2.459
M3.5	0.6	2.90	3.010	2.850
M4.0	0.7	3.30	3.422	3.242
M4.5	0.75	3.80	3.878	3.688
M5.0	0.8	4.20	4.334	4.134
M6.0	1.0	5.00	5.153	4.917
M7.0	1.0	6.00	6.153	5.917
M8.0	1.25	6.80	6.912	6.647
M8.0	1.0	7.00	7.153	6.917
M9.0	1.25	7.80	7.912	7.647
M10	1.5	8.50	8.676	8.376
M10	1.25	8.80	8.912	8.647
M10	1.0	9.00	9.153	8.917
M11	1.5	9.50	9.676	9.376
M12	1.75	10.30	10.441	10.106
M12	1.5	10.50	10.676	10.376
M12	1.25	10.80	10.912	10.647
M12	1.0	11.00	11.153	10.917
M14	2.0	12.00	12.210	11.835
M14	1.5	12.50	12.676	12.376
M14	1.0	13.00	13.153	12.917
M16	2.0	14.00	14.210	13.835
M16	1.5	14.50	14.676	14.376
M16	1.0	15.00	15.153	14.917

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DRILLING HOLE SIZE OF CUTTING TAPS

PRODUCT DESCRPTION

Unit:mm

Specification (UNC)		Standard Hole Dia	For JIS Class2 Drill Hole Dia	
			Max	Min
NO.1	-64	1.55	1.582	1.425
NO.2	-56	1.80	1.871	1.695
NO.3	-48	2.10	2.146	1.941
NO.4	-40	2.30	2.385	2.157
NO.5	-40	2.60	2.697	2.487
NO.6	-32	2.80	2.895	2.642
NO.8	-32	3.40	3.530	3.302
NO.10	-24	3.90	3.962	3.683
NO.12	-24	4.50	4.597	4.344
1/4	-20	5.10	5.257	4.979
5/16	18	6.60	6.731	6.401
3/8	-1	8.00	8.153	7.798
7/16	-14	9.40.	9.550	9.144
1/2	-13	10.90	11.023	10.592
9/16	-12	12.20	12.466	11.989
5/8	-11	13.60	13.868	13.386

Unit:mm

Specification (UNF)		Standard Hole Dia	For JIS Class2 Drill Hole Dia	
			Max	Min
NO.0	-80	1.25	1.305	1.182
NO.1	-72	1.55	1.612	1.474
NO.2	-64	1.85	1.912	1.756
NO.3	-56	2.10	2.197	2.025
N0.4	-48	2.40	2.458	2.271
NO.5	-44	2.70	2.740	2.551
NO.6	-40	2.90	3.022	2.820
NO.8	-36	3.50	3.606	3.404
N0.10	-32	4.10	4.165	3.963
N0.12	-28	4.60	4.724	4.496
1/4	-28	5.50	5.588	5.360
5/16	-24	6.90	7.035	6.782
3/8	-24	8.50	8.636	8.382
7/16	-20	9.90	10.033	9.729
1/2	-20	11.50	11.607	11.329
9/16	-18	12.90	13.081	12.751
5/8	-18	14.50	14.681	14.351

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PRODUCT DESCRPTION

Metric Coarse Thread

Unit:mm

SPECIFIC ATION	drilling size		Suitable drill dia
	MIN	MAX	
M 2.5*0.45	2.6	2.65	2.6
M 2.6*0.45	2.7	2.75	2.7
M3*0.5	3.12	3.2	3.15
M 4*0.7	4.17	4.3	4.2
M 5*0.8	5.16	5.33	5.2
M6*1	6.25	6.42	6.3
M 8*1.25	8.31	8.52	8.4
M 10*1.5	10.37	10.62	10.5
M 12*1.75	12.43	12.73	12.5
M 14*2	14.49	14.83	14.5
M16*2	16.49	16.83	16.5
M 18*2.5	18.58	19.04	19
M 20*2.5	20.58	21.04	21
M 22*2.5	22.58	23.04	23
M.24*3	24.7	25.25	25
M 27*3	27.65	28.05	27.8
M30*3.5	30.76	31.2	31

Metric Fine Thread

Unit:mm

SPECIFIC ATION	drilling size		Suitable drill dia
	MIN	MAX	
M 10*1	10.25	10.42	10.3
M 10*1.25	10.31	10.52	10.4
M 12*1.25	12.31	12.52	12.5
M12*1.5	12.37	12.62	12.5
M 14*1.5	14.37	14.62	14.5
M16*1.5	16.37	16.62	16.5
M 18*1.5	18.37	18.62	18.5
M 20*1.5	20.37	20.62	20.4
M 20*2	20.47	20.83	20.5
M 22*1.5	22.37	22.62	22.5
M 24*1.5	24.37	24.62	24.5
M 24*2	24.47	24.83	24.5
M 27*1.5	27.33	27.56	27.4
M 30*1.5	30.37	30.62	30.5

US-Made Coarse Thread

Unit:mm

SPECIFIC ATION	drilling size		Suitable drill dia
	MIN	MAX	
No.2- 56UNC	2.29	2.39	2.3
No.3- 48	2.64	2.74	2.7
No.4- 40	2.95	3.07	3
No.5- 40	3.25	3.38	3.3
No.6- 32	3.66	3.81	3.7
No.8- 32	4.32	4.47	4.4
-No.10-24-	5.05	5.21	5.1
No.12- 24	5.61	5.77	5.7
1/4 -20	6.63	6.78	6.7
5/16- 18	8.33	8.48	8.4
3/8 -16	9.91	1.11	10
7/16- 14	11.51	11.75	11.5
1/2 - 13	13.08	13.34	13.1
9/16- 12	14.68	14.94	14.7

US-Made Fine Thread

Unit:mm

SPECIFIC ATION	drilling size		Suitable drill dia
	MIN	MAX	
No.4- 48UNF	2.97	3.05	3
No.6-40	3.66	3.78	3.7
No.8-36	4.32	4.44	4.4
No.10-32	4.98	5.13	5
1/4 - 28	6.53	6.71	6.6
5/16- 24	8.2	8.38	8.2
3/8 -24	9.78	9.96	9.8
7/16- 20	11.43	11.63	11.5
1/2 - 20	13.03	13.26	13.1
9/16- 18	14.66	14.88	14.7
5/8-18	16.26	16.48	16.3
3/4- 19	19.43	19.68	19.5
7/8-14	22.61	22.86	22.7
1-12	25.76	26.04	26

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PRODUCT DESCRPTION

Drilling Size Of JIS Parallel Pipe Taps (G :PF)

Unit:mm

SPECIFICATION	outer diameter	Percentage of thread engagement hole diameter							Minor dia of internal thread
		100%	95%	90%	85%	80%	75%	70%	
1/16	7.723	6.56	6.62	6.68	6.74	6.79	6.85	6.91	6.561~6.843
1/8	9.728	8.57	8.62	8.68	8.74	8.8	8.86	8.91	8.566~8.848
1/4	13.157	11.45	11.53	11.62	. 11.7	11.79	11.87	11.96	11.445~11 .890
3/8	16.662	14.95	15.04	15.12	15.21	15.29	15.38	15.46	14.950~15.395
1/2	20.955	18.6	18.8	18.9	19.0	19.1	19.2	19.3	.18.631~19.172
5/8	22.911	20.6	20.7	20.8	20.9	21.1	21.2	21.3	20.589~21.130
3/4	26.441	24.1	24.2	24.4	24.5	24.6	24.7	24.8	24.117~24.658
7/8	30.201	27.9	28.0	28.1	28.2	28.3	28.5	28.6	27.877~28.418
1	33.249	30.3	30.4	30.6	30.7	30.9	31.0	31.2	30.291~30.931
11/8	37.897	34.9	35.1	35.2	35.4	35.5	35.7	35.8	34.939~35.579
11/4	41.91	39	39.1	39.3	39.4	39.5	39.7	39.8	38.952~39.592
13/8	44.323	41.4	41.5	41.7	41.8	42.0	42.1	42.3	41.365~42.005
11/2	47.803	44.9	45.0	45.1	45.3	45.4	45.6	45.7	44.845~45.485
13/4	53.746	50.8	50.9	51.1	51.2	51.4	51.5	51.7	50.788~51.428
2	59.614	56.7	56.8	57.0	57.1	57.3	57.4	57.5	56.656~57.296

Dilling Size Of JIS Tapper Pipe Taps RC (NPT)* RP(PS)

SPECIFICATION	outer diameter	Taper threads Rc (PT)		Parallel threads Rp(PS)
		Hole Dia (Straight hole)	Hole Dia (Taper hole)	Hole Dia
1/16	7.723	6.17	6.49	6.49
1/8	9.728	8.18	8.5	8.5
1/4	13.157	10.86	11.34	11.34
3/8	16.662	14.34	14.85	14.85
1/2	20.955	17.84	18.49	18.49
3/4	26.441	23.24	23.98	23.98
1	33.249	29.28	30.11	30.11
11/4	41.91	37.8	38.77	38.77
11/2	47.803	43.69	44.66	44.66
2	59.614	55.23	56.48	56.48

Dilling Size OfPipe Taps NPT*NPS

Unit:mm

SPECIFICATION	Taper threads NPT		paralell threads NPS
	when reamer is applied	when no reamer is applied	Drill dia
1/16	0.234(5.94)	0.242(6.15)	0.250(6.35)
1/8	0.328(8.33)	0.332(8.43)	0.344(8.74)
1/4	0.422(10.72)	0.438(11.13)	0.438(11.13)
3/8	0.562(14.27)	0.562(14.27)	0.578(14.68)
.1/2	0.688(17.48)	0.703(17.86)	0.719(18.26)
3/4	0.891(22.63)	0.906(23.01)	0.922(23.42)
1	1.125(28.58)	1.141 (28.98)	1.1 56(29.36)
11/4	1. 469(37.31)	1.484(37.96)	1.500(38.10)
11/2	1.703(43.26)	1.719(43.66)	1.750(44.45)
2	2.172(55.17)	2.188(55.58)	2.219(56.36)

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PRODUCT DESCRPTION

Hill Number And Pitch Conversion Table

Threads per inch	(mm)Pitch of Thread
100	0.2540
80	0.3175
72	0.3528
64	0.3969
60	0.4233
56	0.4536
48	0.5292
44	0.5773
40	0.6350
36	0.7056
32	0.7938
28	0.9071
24	1.0583
20	1.2700
18	1.4111
16	1 5875
14	1.8143
13	1.9538
12	2.1167

UNC External Diameter Conversion Table

Specification	Inch	(mm)Metric
NO.0	0.0600	1.524
1	0.0730	1.854
2	0.0860	2.184.
3	0.0990	2.515
4	0.1120	2.845
5	0.1250	3.175
6	0.1380	3.505
8	0.1640	4.166
10	0.1900	4.826
12	0.2160	5.486

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PRODUCT DESCRPTION

Tapping Speed AndTapping Oil

Work Material		Forming Tap	Pointed Tap	Fluted Tap	Straight Fluted Tap
Low Carbon Steel	C~0.2%	8~~13	15~ 25	8~13	8~13
Medium Carbon Steel	C 0.25%~0.40%	7~~10	10~15	7~12	7~12
High Carbon Steel	C 0.459%~	5~~8	8~13	6~9	6~9.
Alloy Steel	SCM	5~~8	10~15	7~12	7~12
Stainless Steel	SUS	5~~10	8~13	5~8	4~7
Copper	CU	7~~12	7~12	6~11	6~9
Brass.Brass Casting	Bs. BsC	7~~12	15~25	10~20	10~15
Bronze . Bronze Casting	PB.PBC	7~~12	10~15	7~12	7~12
i Wrought Aluminum Alloy	AL	10~~20	15~25	10~20	10~20
Aluminum Alloy Casting	AC.ADC	10~~15	15~ -20	10~15	10~15
Zinc Casting	ZDC	7~~12	10~15	7~12	7~12

Cutting Speed Formula

1.Eemale screw(-)

2. Male screw(+)

3. Tapping speed of TIN coated tap can increase by 30%

4. Tapping speed should reduce by 20-30% when tapping depth>=2D.

D: rocessing.diamete(mm)

d: Tap diameter(mm)

Z: Feed times

f: Amount of feed(mm)

V: Tapping speed(m/min)

N: Revolution(rpm)

π:3.1415

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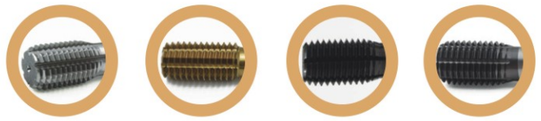

B TIN ALSIN-A TICN

Tapping in a narrow hole ,makes lubricating oil hard to cool and lubricate taps ,the heat of cutting and friction will lead to taps' abrasion and melt. To solve the problems,need to do kinds of surface treatment.

Types	Color	Function	Hardness	APPLICATION
B	Bright		HV 900	Suitable for machining pure aluminum, pure zinc,aluminum aly,etc
TIN	Gold	Improved wear resistance and galling-proofness	HV 2300	Suitable for machining low and medium carbon steel,sus etc
TICN	Blue gray	Improved wear resistance and galling-proofness	HV 3000	Suitable for machining sus,aluninum alloy(low aluminum),magneium alloy,zinc alloy etc
ALSIN-A	Black	Improved heat resistance and galling-proofness	HV 2000	Suitable for machining sus,titanium aly,low and medium carbon steel,etc
THJ	Black	Improved wear resistance andgalling-proofness	HV 3000~5000	Titanium aloy special coating

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THE DIFFERENCE BETWEEN FORMING TAPS AND CUTTING TAPS

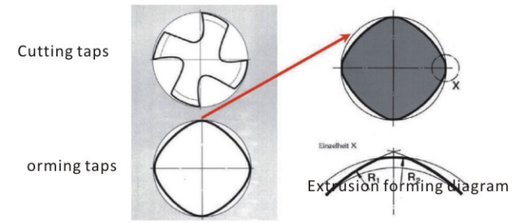
forming taps

forming taps make treads through cold e xtrusion

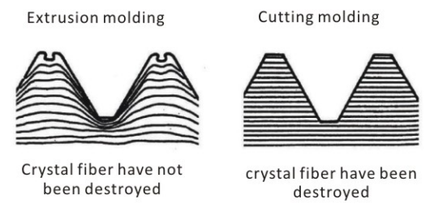
no cutting chips ,so no chips removal problem
improved thread surface quality
increased about twice cutting speed
increased taps life

Forming taps limited on workpiece material
Brittle materials(l.e. Grey cast iron)are not suitable
workpiece' s elongation at least up to 10%
Remark:the bottom hole bigger than normal thread bottom hole

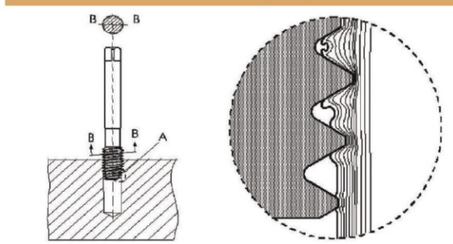
Feature comparison



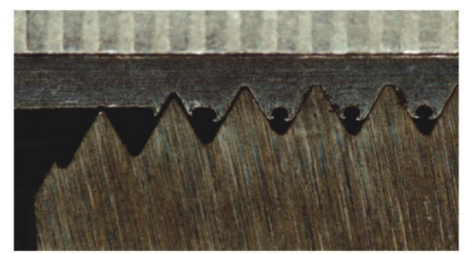
thread comparison



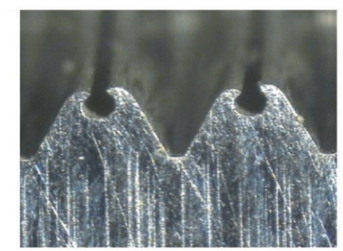
Extrusion forming diagram



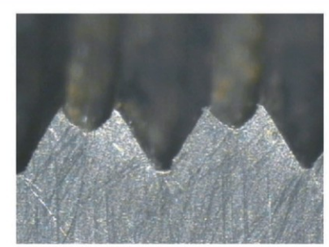
extrusion molding example



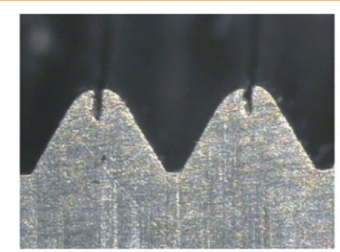
normal extrusion thread when bottom hole is reasonable



unfinished thread when bottom hole is too big



bad thread when bottom hole is too small



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PRODUCT DESCRPTION

The main problem ,reason and slove way while tapping

No	PROBLEM	REASON	SOLUTION
1	Taps broken	1. The bottom hole is too small 2. Taps quality is not good 3. Dilling depth is not enough when tapping in blind hole 4. Tapping speed is too fast 5. The taps and bottom hole' s shaft is diferent 6. The workpiece material is not stable ,some parts have airhole and the hardness is different	1. Increase bottom hole diameter 2. Choose better taps 3. Increase dilling depth 4. Reduce tapping speed 5. Calibration fixture, choose float tapping chuck 6. Choose better material
2	Taps gear demaged	1. Taps quality is not good 2. Cutting speed is not suitable	1. Choose better taps 2. Choose suitable cutting speed
3	Taps' abrasion is fast	1. Tapping speed is too high 2. Taps quality is not good 3. Cutting fluid is not suitalbe 4. Workpiece' s hardness is too high	1. Reduce tapping speed 2. Choose better taps 3. Choose good lubricity cutting fluid 4. Proper heat treatment of workpiece
4	Thread diameter is too big	1. Taps accuracy is not suitable 2. Cutting fluid is not suitable 3. Tapping speed is too high 4. The taps and bottom hole' s shaft is different 5. Taps stik crumbs 6. Burr in tap grinding 7. The machine spindle swinging too big	1. Choose proper accuracy 2. Choose proper cutting fluid 3. Reduce cutting speed 4. Calibration fixture, choose float tapping chuck 5. Choose suitable taps and coating 6. Clean the burrs
5	Pitch diameter is too small	1. Taps' accuracy is not suitable 2. Cutting fuid is not suitable	1. Choose proper accuracy 2. Choose good lubricit' s cutting fluid
6	Thread surface is not smooth , wavy	1. Taps quilfyts' notgooa 2. The workpiece is too soft 3. Cutting fluid is not suitable 4. Tapping speed is too high	1. Choose better taps 2. Do heat treatment to improve workpiece hardness 3. Choose good lubricity' s cutting fluid 4. Reduce Cutting speed

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PROBLEMS AND COUNTERMEASURES OF TAPS PROCESSING

PRODUCT DESCRPTION

Machine tap tapping common problems, reasons and solutions

PROBLEMS	REASONS	SOLUTIONS	IF NEED TO VERIFYTAPS OR NOT
The inner thread pitch diamieter is too big (gaugeno-go- end all go	Unsuitable taps	1. Choose suitable accuary taps	1. No need to verify taps, checkif taps match with crafts
	Tap and plug do not match	1. oose suitable taps and plug gauge (eg: taps RH7 should match plug gauge 6H)	1. Noneed to verify taps, chedk taps and plug' s label
	Cutting jam	1. Choose spiral flute taps、 point taps 2 Choose Lless chip flutes、 bigger capacity taps 3. Increase bottom hole diameter 4. Increase bottom hole diameter when tapping blind hole 5, Change cutting fluid types and watering way	1. According to current crafts ,no need to consider verification, Only new crafts happem similar case
	Unsuitable procssing condition	1. Motify cutting speed 2. Avoidtaps and bottom hole in different shaft 3. . Taps or cutting material adopt floating fixed mode 4. Adopt proper Cutting speed to avoid excessive cutting 5. Using forced feeding method 6. Choose suitable processing machine 7. To prevent the tap vibration	1. The present condition is sultable and thesefactors can be verified one by one , no need to verify taps
	bond	1. Choose oxidation treated or other kind of treated taps 2. Choose good anti adhesion' S cutting fluid 3. Reduce Cutting speed	1. No need to verify taps, require operator to check taps regularly,
Other factors are romal but gauge no-go-end all got hrough	The upper,lower, and both sides of taps thread been over much cut	1. The match gap between non screw feeding machine' sand the splined shaft need to be checked regularly, to reduce the resitance or spindle feed rate. 2. Screw feding machine need to be motfed priodically and check the gap between screw and screw nut	1. Through hand tapping to chedk iftaps can process qualified thread 2. Change processing station and part to check if taps can process qualfied thread
The inner thread is too smal (gauge go-end can't gothrough).	Unsuitable taps	1. Choose bigger size taps 2. Choose suitable taps structure	
	Intemal thread scratch	1. Choose suitable reversal recede speed	
	Remain chips in internat thread	1. Improve taps sharpness ,avoid appearing whisker chips 2: Atererfiver alt chipsout;then theckbyptag gauge	
Other factors are normal but gauge-go-end Can't go through	Because the tapschuck's total weight and machine shaft have a force efect on taps,lead tp teeth type extrusion deformation or mash, so gauge go-end can't go through	Tapping the thread hole again by hand	

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Tapping Grease

Tapping Oil

FEATURES

Containing eficient additives, good wear resistance and extreme pressure ,extend cutting tools' life, excellent coling performance.

INSTRUTION

※ For nomally machining ,using 5-10times tpping oil to dlute spindle olfr heavy duty machining using2-5 timnes tpping oil to dilute spindle oil

※ Oiler way: dripping ,dircylating or brushing

FUNCTION

※ For metal cutting(oily)

※ Suitable for sainles seel steel ,copper diling reaming tapping and milling expecially suitable for thread processing.

※ Tapping grease is yllow in normal temperature, flash point aboce 190°C.

※ Tapping oil is brown liquid in normal temperature fash point aboce 200°C

※ Water insolubility

PRECAUTIONS

※ Use brush to brushing grease on taps, when the viscosity is high, please use a ltte of engine oil or insolubility cutting oil and fully mixing,dilution, dilution, using in Suitable coneentraionusing in Suitable coneentraion

※ When dean it, please use lye or kerosen(do not use acid)

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JHOME taps provide professional processing solutions for fllowing fielids:

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