

Sur—Form Thread Forming Taps

MACHINE & FRACTIONAL

HIGH SPEED M-7 STEEL

GROUND THREAD



Packaging: 0 thru 1/4", 12 per box. 5/16" thru 1/2", 6 per box. 5/8", 3 per box. 3/4" individually packaged.

MADE IN USA

SERIES 2090

PLUG & BOTT CHAMFER

TAP SIZE	NC	NF	UNC UNF	CLASS of FIT	EDP NO PLUG	EDP NO BOTTOM	LIST PRICE
0	--	80	UNF	2B-3G	209A000FP	209A000FB	\$29.62
1	64	--	UNC	2B-3G	209A001CP	209A001CB	29.62
1	--	72	UNF	2B-3G	209A001FP	209A001FB	29.62
2	56	--	UNC	2B-3G	209A002CP	209A002CB	29.43
2	--	64	UNF	2B-3G	209A002FP	209A002FB	29.43
3	48	--	UNC	2B-3G	209A003CP	209A003CB	29.43
3	--	56	UNF	2B-3G	209A003FP	209A003FB	29.43
4	40	--	UNC	2B-3G	209A004CP	209A004CB	26.95
4	--	48	UNF	2B-3G	209A004FP	209A004FB	26.95
5	40	--	UNC	2B-3G	209A005CP	209A005CB	26.95
5	--	44	UNF	2B-3G	209A005FP	209A005FB	26.95
6	32	--	UNC	2B-3G	209A006CP	209A006CB	21.99
6	32	--	UNC	Pre-Plate	209A006CPP	209A006CPB	21.99
6	--	40	UNF	2B-3G	209A006FP	209A006FB	21.99
8	32	--	UNC	2B-3G	209A008CP	209A008CB	21.99
8	32	--	UNC	Pre-Plate	209A008CPP	209A008CPB	21.99
8	--	36	UNF	2B-3G	209A008FP	209A008FB	21.99
10	24	--	UNC	2B-3G	209A010CP	209A010CB	21.99
10	24	--	UNC	Pre-Plate	209A010CPP	209A010CPB	21.99
10	--	32	UNF	2B-3G	209A010FP	209A010FB	21.99
10	--	32	UNF	Pre-Plate	209A010FPP	209A010FPB	21.99
12	24	--	UNC	2B-3G	209A012CP	209A012CB	23.29
12	--	28	UNF	2B-3B	209A012FP	209A012FB	23.29
1/4	20	--	UNC	2B-3G	209A116CP	209A116CB	22.45
1/4	20	--	UNC	Pre-Plate	209A116CPP	209A116CPB	22.45
1/4	--	28	UNF	2B-3G	209A116FP	209A116FB	22.45
1/4	--	28	UNF	Pre-Plate	209A116FPP	209A116FPB	22.45
5/16	18	--	UNC	2B-3G	209A120CP	209A120CB	25.97
5/16	18	--	UNC	Pre-Plate	209A120CPP	209A120CPB	25.97
5/16	--	24	UNF	2B-3G	209A120FP	209A120FB	25.97
5/16	--	24	UNF	Pre-Plate	209A120FPP	209A120FPB	25.97
3/8	16	--	UNC	2B-3G	209A124CP	209A124CB	29.43
3/8	16	--	UNC	Pre-Plate	209A124CPP	209A124CPB	29.43
3/8	--	24	UNF	2B-3G	209A124FP	209A124FB	29.43
3/8	--	24	UNF	Pre-Plate	209A124FPP	209A124FPB	29.43
7/16	14	--	UNC	2B-3G	209A128CP	209A128CB	43.46
7/16	--	20	UNF	2B-3G	209A128FP	209A128FB	43.46
1/2	13	--	UNC	2B-3G	209A132CP	209A132CB	50.70
1/2	--	20	UNF	2B-3G	209A132FP	209A132FB	50.70
5/8	11	--	UNC	2B-3G	209A140CP	209A140CB	72.49
5/8	11	--	UNF	Pre-Plate	209A140CPP	209A140CPB	72.49
5/8	--	18	UNF	2B-3G	209A140FP	209A140FB	72.49
5/8	--	18	UNF	Pre-Plate	209A140FPP	209A140FPB	72.49
3/4	10	--	UNC	2B-3G	209A148CP	209A148CB	101.72
3/4	10	--	UNC	Pre-Plate	209A148CPP	209A148CPB	101.72
3/4	--	16	UNF	2B-3G	209A148FP	209A148FB	101.72
3/4	--	16	UNF	Pre-Plate	209A148FPP	209A148FPB	101.72

Formula for Special
Sur-Form Tap Drill Size

Basic Major Diameter	Minus X	= Drill Size
X = $\frac{.510}{\text{TPI}}$		for 75% Thread
X = $\frac{.476}{\text{TPI}}$		for 70% Thread
X = $\frac{.446}{\text{TPI}}$		for 65% Thread
X = $\frac{.408}{\text{TPI}}$		for 60% Thread
X = $\frac{.374}{\text{TPI}}$		for 55% Thread

Example:
(Using 75% formula for 10-32)

$$\frac{.510}{32 \text{ (pitch)}} = \frac{X}{.0159}$$

(#10 = .190)
so
.190 - .0159 = .174 (drill size)