

## SG Lo-Spiral Fluted Tap



Modified Bottoming Style 2 1/2 to 3 Thread Lead  
SG Coating

### List No. 6958 Metric Sizes

\*GT to H-limit conversion chart refer to Page: 235

Nominal Size (mm)	Pitch (mm)	E.D.P. Numbers					No. Of Flutes	Dimensions			Std. Pack.
		GT5	GT6	GT7	GT8	GT9		Overall Length	Length of Thread	Shank Dia.	
<b>METRIC</b>											
M3	0.5	59615					3	1 15/16	0.236	0.141	3
M4	0.7	59617						2 1/8	0.276	0.168	3
M5	0.8		59619					2 3/8	0.354	0.194	1
M6	1		59620					2 1/2	0.433	0.255	1
M8	1		59622					2 23/32	0.472	0.318	3
	1.25		59623			1					
M10	1.25		59624					2 15/16	0.551	0.381	3
	1.5			59625		1					
M12	1.25				59626			3 3/8	0.669	0.367	3
	1.75				59627						1
M14	1.5				59628			3 19/32	0.787	0.429	1
	2				59629						3
M16	1.5				59630			3 13/16	0.787	0.480	1
	2				59631						1
M18	1.5				59632		4 1/32	0.984	0.542	1	
	2.5					59633				1	
M20	1.5				59634		4 15/32	0.984	0.652	1	
	2.5					59635				1	
M22	1.5				59636		4 11/16	0.984	0.697	1	
	2.5					59637				1	
M24	1.5				59638		4 29/32	1.181	0.760	1	
	3					59639				1	

Order by EDP Number

### Tapping Speeds

SG-Low Spiral Taps List No. 6958, 6959  
SFM : Surface Feet per Minutes

Work Materials		Tapping Speed SFM
Low Carbon Steel	1010,1018	25-50
Medium Carbon Steel	1035,1045	20-50
High Carbon Steel	1065,1095	15-30
Alloy Steel	4140,4130	15-30
Die Steels	D2,H13	15-35
Hardened Die Steels (20-40HRC)	D2,H13	8-15
Stainless Steel (Austenitic)	303,304,316	15-45
Stainless Steel (Martensitic)	410,430	12-20
Stainless Steel (PH) up to 35HRC	17-4PH	12-20
Titanium Alloy Up to 32HRC	6AL4V	15-20
Magnesium Alloy		40-80
Ductile Cast Irons	80-55-06	20-50
Cast Irons	Nodular,Grey	30-65

- These are general tapping condition, may be altered by your condition.
- These conditions are for tapping depth 1.5D. In case of deeper thread you may multiply these values by the coefficient of next table.

Thread Depth	Coefficient
Up to 1.5D	1
1.5D~2.5D	0.9
2.5D~3D	0.8
Over 3D	0.7

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**List No. 6959** Machine Screw & Fractional Sizes

\*GT to H-limit conversion chart refer to Page: 235

Nominal Size	Thread/Inch		E.D.P. Numbers							No. of Flutes	Dimensions			Std. Pack.
	NC UNC	NF UNF	GT3	GT4	GT5	GT6	GT7	GT8	GT9		Overall Length	Length of Thread	Shank Dia.	
<b>MACHINE SCREW SIZES</b>														
2	56		94597							3	1 3/4	0.437		1
		64	94598											1
3	48			94599							1 13/16	0.500		1
		56	94600											1
4	40				94601						1 7/8	0.236	0.141	3
		48		94602										1
5	40				94603						1 15/16			1
		44			94604									1
6	32				94605						2	0.276		1
		40			94606									1
8	32				94607						2 1/8		0.168	3
		36			94608									1
10	24					94609					2 3/8	0.354	0.194	3
		32			94610									1
12	24					94611						0.220	1	
		28				94612							1	
<b>FRACTIONAL SIZES</b>														
1/4	20			94633			94613			3	2 1/2	0.433	0.255	1
		28		94634		94614								3
5/16	18			94635			94615				2 23/32	0.472	0.318	1
		24		94636			94616							1
3/8	16			94637				94617			2 15/16	0.551	0.381	1
		24		94638			94618							1
7/16	14						94619				3 5/32	0.709	0.323	1
		20		94639			94620							3
1/2	13			94640			94621				3 3/8	0.787	0.367	1
		20		94641			94622							1
9/16	12						94623				3 19/32	0.827	0.429	1
		18					94624							1
5/8	11							94625			3 13/16	0.905	0.480	1
		18					94626							1
3/4	10							94627		4 1/4	0.984	0.590	1	
		16					94628						1	
7/8	9							94629		4 11/16	1.102	0.697	1	
		14					94630						1	
1	8							94631		5 1/8	1.260	0.800	1	
		12					94632						1	

Order by EDP Number

TAPS