

M42 COBALT TAPS & TiN COATED

Type 24-RNC Gold Oxide Type 24-RNCN TiN Coated Fractional - Taps for Hardened Steel and Iron

- M42 plug taps for tapping through holes in mold steel and hardened steel with Rockwell C hardness between C30 – C45.
 - Titanium coated M42 plug taps last twice as long as uncoated taps, titanium coatings lubricity produces smooth threads.
- For use in cast iron, brass, bronze, armor plate with a Rockwell C hardness between C30 – C45 and hard plastics

Part #	TIN Part #	Thread Size	Thread Length	Overall Length	Shank Diameter	Drill Bit Size	# of Flutes	Pitch Limit Diameter	Qty Per Pack
10052	13802	4-40	5/16"	1-7/8"	0.1405	#43	3	H2	3
10072	13822	5-40	5/16"	1-15/16"	0.1405	#38	3	H2	3
10092	13842	6-32	3/8"	2"	0.1405	#36	3	H3	3
10112	13862	8-32	3/8"	2-1/8"	0.1675	#29	3	H3	3
10132	13882	10-24	1/2"	2-3/8"	0.1935	#25	3	H3	3
10142	13892	10-32	1/2"	2-3/8"	0.1935	#21	3	H3	3
10172	13922	1/4-20	5/8"	2-1/2"	0.2545	#7	3	H3	3
10182	13932	1/4-28	5/8"	2-1/2"	0.2545	#3	3	H3	3
10192	13942	5/16-18	11/16"	2-23/32"	0.3175	F	4	H3	3
10202	13952	5/16-24	11/16"	2-23/32"	0.3175	I	4	H3	3
10212	13962	3/8-16	3/4"	2-15/16"	0.3805	5/16"	4	H3	3
10222	13972	3/8-24	3/4"	2-15/16"	0.3805	Q	4	H3	3
10232	13982	7/16-14	7/8"	3-5/32"	0.3225	U	4	H3	3
10242	13992	7/16-20	7/8"	3-5/32"	0.3225	25/64"	4	H3	3
10272	14002	1/2-13	15/16"	3-3/8"	0.3665	27/64"	4	H3	3
10282	14012	1/2-20	15/16"	3-3/8"	0.3665	29/64"	4	H3	3
10292	14042	5/8-11	1-3/32"	3-13/16"	0.4795	17/32"	4	H3	1
10302	14052	5/8-18	1-3/32"	3-13/16"	0.4795	37/64"	4	H3	1
10312	14062	3/4-10	1-7/32"	4-1/4"	0.5895	21/32"	4	H3	1
10322	14072	3/4-16	1-7/32"	4-1/4"	0.5895	11/16"	4	H3	1

HSS STRAIGHT FLUTE HAND TAPS

Machine Screw / Fractional - Ground Thread

Types 23-UB, Type 24-UB & Type 25-UB Gold Oxide Types 23-UBN, Type 24-UBN & Type 25-UBN TiN Coated

Types 23, Type 24 & Type 25 Bright Finish

- The most common style of tap
- Can be used by hand or for tapping under power
- Versatile taps for use in general machine tapping or CNC tapping applications
- Use for through hole or blind hole tapping.



Type 23-UB - Taper

Gold Oxide - low temperature stress relief that enhances lubricity, reduces friction and increases tap toughness.



Type 24-UBN - Plug

TiN coating - increases wear resistance by producing a higher surface hardness and exceptional lubricity resulting in longer tool life.



Type 25 - Bottoming
Bright Finish

23-UB Taper Part#	24-UB Plug Part #	25-UB Bottoming Part #	23-UBN Taper Part #	24-UBN Plug Part #	25-UBN Bottoming Part #	23 Taper Part #	24 Plug Part #	25 Bottoming Part #	Size	# of Flutes	H Limit	QTY per/pack
72701	72702	72703	45981	45982	45983	71661	71662	71663	0-80	2	H1	3
72711	72712	72713	45991	45992	45993	71671	71672	71673	0-80	2	H2	3
72721	72722	72723	44101	44102	44103	71681	71682	71683	1-64	2	H1	3
72731	72732	72733	44111	44112	44113	71691	71692	71693	1-64	2	H2	3
72741	72742	72743	44121	44122	44123	71701	71702	71703	1-72	2	H1	3
72751	72752	72753	44131	44132	44133	71711	71712	71713	1-72	2	H2	3
72761	72762	72763	44141	44142	44143	71721	71722	71723	2-56	3	H1	3
60660	60661	60662	46001	46002	46003	71231	71232	71233	2-56	3	H2	3
72771	72772	72773	44151	44152	44153	71731	71732	71733	2-64	3	H2	3
72781	72782	72783	44161	44162	44163	71741	71742	71743	3-48	3	H1	3
60680	60681	60682	46011	46012	46013	71251	71252	71253	3-48	3	H2	3
60710	60711	60712	45931	45932	45933	71751	71752	71753	3-56	3	H2	3
60700	60701	60702	46021	46022	46023	61001	61002	61003	4-40	3	H2	3
60720	60721	60722	45951	45952	45953	61011	61012	61013	4-48	3	H2	3
72791	72792	72793	44191	44192	44193	71761	71762	71763	5-40	3	H1	3
60730	60731	60732	46031	46032	46033	61021	61022	61023	5-40	3	H2	3
60740	60741	60742	45971	45972	45973	61031	61032	61033	5-44	3	H2	3
72801	72802	72803	44211	44212	44213	71771	71772	71773	6-32	3	H1	3
72811	72812	72813	44221	44222	44223	71781	71782	71783	6-32	3	H2	3
60750	60751	60752	46041	46042	46043	61041	61042	61043	6-32	3	H3	3
72821	72822	72823	44231	44232	44233	71791	71792	71793	6-40	3	H1	3
60760	60761	60762	46051	46052	46053	61051	61052	61053	6-40	3	H2	3
72831	72832	72833	44241	44242	44243	71801	71802	71803	8-32	4	H1	3
72841	72842	72843	44251	44252	44253	71811	71812	71813	8-32	4	H2	3
60770	60771	60772	46061	46062	46063	61061	61062	61063	8-32	4	H3	3
60780	60781	60782	46071	46072	46073	61071	61072	61073	8-36	4	H2	3
72851	72852	72853	44261	44262	44263	71821	71822	71823	10-24	4	H1	3

Red Bold = most common used Taps

HSS STRAIGHT FLUTE HAND TAPS

Machine Screw / Fractional - Ground Thread - Ultra Bor Super Premium

Types 23-UB, Type 24-UB & Type 25-UB **Gold Oxide**

Types 23-UBN, Type 24-UBN & Type 25-UBN **TiN Coated**

Types 23, Type 24 & Type 25 **Bright Finish**

- The most common style of tap
- Can be used by hand or for tapping under power
- Versatile taps for use in general machine tapping or CNC tapping applications
- Use for through hole or blind hole tapping



Type 23-UB - Taper

Gold Oxide - low temperature stress relief that enhances lubricity, reduces friction and increases tap toughness.



Type 24-UBN - Plug

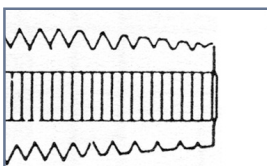
TiN coating - increases wear resistance by producing a higher surface hardness and exceptional lubricity resulting in longer tool life.



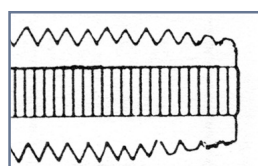
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23-UB Taper Part#	24-UB Plug Part #	25-UB Bottoming Part #	23-UBN Taper Part #	24-UBN Plug Part #	25-UBN Bottoming Part #	23 Taper Part #	24 Plug Part #	25 Bottoming Part #	Size	# of Flutes	H Limit	QTY per/pack
72861	72862	72863	44271	44272	44273	71831	71832	71833	10-24	4	H2	3
60790	60791	60792	46081	46082	46083	61081	61082	61083	10-24	4	H3	3
72871	72872	72873	44281	44282	44283	71841	71842	71843	10-32	4	H1	3
72881	72882	72883	44291	44292	44293	71851	71852	71853	10-32	4	H2	3
60800	60801	60802	46091	46092	46093	61091	61092	61093	10-32	4	H3	3
60810	60811	60812	46101	46102	46103	61101	61102	61103	12-24	4	H3	3
60820	60821	60822	46111	46112	46113	61111	61112	61113	12-28	4	H3	3
72891	72892	72893	44301	44302	44303	71861	71862	71863	1/4-20	4	H1	3
72901	72902	72903	44311	44312	44313	71871	71872	71873	1/4-20	4	H2	3
60830	60831	60832	46121	46122	46123	61121	61122	61123	1/4-20	4	H3	3
72911	72912	72913	44321	44322	44323	71881	71882	71883	1/4-20	4	H5	3
72921	72922	72923	44331	44332	44333	71891	71892	71893	1/4-28	4	H1	3
72931	72932	72933	44341	44342	44343	71901	71902	71903	1/4-28	4	H2	3
60840	60841	60842	46131	46132	46133	61131	61132	61133	1/4-28	4	H3	3
72941	72942	72943	44351	44352	44353	71911	71912	71913	1/4-28	4	H4	3
72951	72952	72953	44361	44362	44363	71921	71922	71923	5/16-18	4	H2	3
60850	60851	60852	46141	46142	46143	61141	61142	61143	5/16-18	4	H3	3
72961	72962	72963	44371	44372	44373	71931	71932	71933	5/16-18	4	H5	3
72971	72972	72973	44381	44382	44383	71941	71942	71943	5/16-24	4	H2	3
60860	60861	60862	46151	46152	46153	61151	61152	61153	5/16-24	4	H3	3
72981	72982	72983	44391	44392	44393	71951	71952	71953	5/16-24	4	H4	3
72991	72992	72993	44401	44402	44403	71961	71962	71963	3/8-16	4	H1	3
73001	73002	73003	44411	44412	44413	71971	71972	71973	3/8-16	4	H2	3
60870	60871	60872	46161	46162	46163	61161	61162	61163	3/8-16	4	H3	3
73011	73012	73013	44421	44422	44423	71981	71982	71983	3/8-16	4	H5	3
73021	73022	73023	44431	44432	44433	71991	71992	71993	3/8-24	4	H1	3
73031	73032	73033	44441	44442	44443	72001	72002	72003	3/8-24	4	H2	3
60880	60881	60882	46171	46172	46173	61171	61172	61173	3/8-24	4	H3	3
73041	73042	73043	44451	44452	44453	72011	72012	72013	3/8-24	4	H4	3
60890	60891	60892	46181	46182	46183	61181	61182	61183	7/16-14	4	H3	3
73051	73052	73053	44461	44462	44463	72021	72022	72023	7/16-14	4	H5	3
60900	60901	60902	46191	46192	46193	61191	61192	61193	7/16-20	4	H3	3
73061	73062	73063	44471	44472	44473	72031	72032	72033	7/16-20	4	H5	3
73071	73072	73073	44481	44482	44483	72041	72042	72043	1/2-13	4	H1	3
60910	60911	60912	46201	46202	46203	61201	61202	61203	1/2-13	4	H3	3
73081	73082	73083	44491	44492	44493	72051	72052	72053	1/2-13	4	H5	3
73091	73092	73093	44501	44502	44503	72061	72062	72063	1/2-20	4	H1	3
60920	60921	60922	46211	46212	46213	61211	61212	61213	1/2-20	4	H3	3
73101	73102	73103	44511	44512	44513	72071	72072	72073	1/2-20	4	H5	3
60950	60951	60952	46221	46222	46223	55011	55012	55013	9/16-12	4	H3	1



TAPER
Type 23-UB, 23-UBN, 23
Type 31-UB, 31-UBN, 31
Eight to ten threads chamfered for easy
thread starting in tough materials.



PLUG
Type 24-UB, 24-UBN, 24
Type 32-UB, 32-UBN, 32

Three to five threads
chamfered. For general use when tapping into
the bottom of the hole is not critical. (This is the
most widely used style.)

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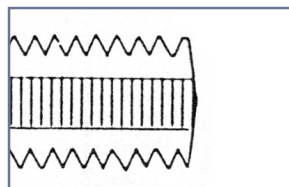
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73111	73112	73113	44521	44522	44523	72081	72082	72083	9/16-12	4	H5	1
73121	73122	73123	44531	44532	44533	72091	72092	72093	9/16-18	4	H2	1
60960	60961	60962	46231	46232	46233	55021	55022	55023	9/16-18	4	H3	1
73131	73132	73133	44541	44542	44543	72101	72102	72103	9/16-18	4	H5	1
73141	73142	73143	44551	44552	44553	72111	72112	72113	5/8-11	4	H2	1
60970	60971	60972	46241	46242	46243	55031	55032	55033	5/8-11	4	H3	1
73151	73152	73153	44561	44562	44563	72121	72122	72123	5/8-11	4	H5	1
73161	73162	73163	44571	44572	44573	72131	72132	72133	5/8-18	4	H2	1
60980	60981	60982	46251	46252	46253	55041	55042	55043	5/8-18	4	H3	1
73171	73172	73173	44581	44582	44583	72141	72142	72143	5/8-18	4	H5	1
73181	73182	73183	44591	44592	44593	72151	72152	72153	11/16-11	4	H3	1
73191	73192	73193	44601	44602	44603	72161	72162	72163	11/16-16	4	H3	1
60990	60991	60992	46261	46262	46263	55051	55052	55053	3/4-10	4	H3	1
73201	73202	73203	44611	44612	44613	72171	72172	72173	3/4-10	4	H5	1
73211	73212	73213	44621	44622	44623	72181	72182	72183	3/4-16	4	H1	1
73221	73222	73223	44631	44632	44633	72191	72192	72193	3/4-16	4	H2	1
61400	61401	61402	46271	46272	46273	55061	55062	55063	3/4-16	4	H3	1
73231	73232	73233	44641	44642	44643	72201	72202	72203	3/4-16	4	H5	1
61410	61411	61412	46281	46282	46283	55071	55072	55073	7/8-9	4	H4	1
73241	73242	73243	44651	44652	44653	72211	72212	72213	7/8-9	4	H6	1
73251	73252	73253	44661	44662	44663	72221	72222	72223	7/8-14	4	H2	1
61420	61421	61422	46291	46292	46293	55081	55082	55083	7/8-14	4	H4	1
73261	73262	73263	44671	44672	44673	72231	72232	72233	7/8-14	4	H6	1
61430	61431	61432	46301	46302	46303	55091	55092	55093	1"-8	4	H4	1
73271	73272	73273	44681	44682	44683	72241	72242	72243	1"-8	4	H6	1
61440	61441	61442	46311	46312	46313	55101	55102	55103	1"-12	4	H4	1
27570	27571	27572	46321	46322	46323	55111	55112	55113	1"-14	4	H4	1
61450	61451	61452	46331	46332	46333	55121	55122	55123	1" 1/8-7	4	H4	1
61460	61461	61462	46341	46342	46343	55131	55132	55133	1" 1/8-12	4	H4	1
61470	61471	61472	46351	46352	46353	55141	55142	55143	1" 1/4-7	4	H4	1
61480	61481	61482	46361	46362	46363	55151	55152	55153	1" 1/4-12	6	H4	1
61490	61491	61492	46371	46372	46373	55161	55162	55163	1" 3/8-6	4	H4	1
61500	61501	61502	46381	46382	46383	55171	55172	55173	1" 3/8-12	6	H4	1
61510	61511	61512	46391	46392	46393	55181	55182	55183	1" 1/2-6	4	H4	1
61520	61521	61522	46401	46402	46403	55191	55192	55193	1" 1/2-12	6	H4	1



BOTTOMING

Type 25-UB, 25-UBN, 25-UBN
Type 33-UB, 33-UBN, 33-UBN

One-and - two threads chamfered. To use after threads have been started for tapping to the bottom of a hole.