



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

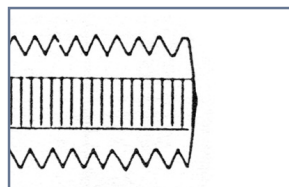
TiN coating - increases wear resistance by producing a higher surface hardness and exceptional lubricity resulting in longer tool life.



Type 25 - Bottoming
Bright Finish

Red Bold = most common used Taps

| 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 |
|--------------------------|-------------------------|------------------------------|---------------------------|--------------------------|-------------------------------|-----------------------|----------------------|---------------------------|----------------|----------------|------------|-----------------|
| 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
Type 33-UB, 33-UBN, 33

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