

TAP & DRILL COMBO & SETS

Ultra Bor Super Premium

Includes corresponding drill with tap in a durable metal case.



TAP & DRILL SETS

SP-18TD (SPIRAL POINT, NC)

Part#	Description of Sizes
57580	
240-UB Drill Sizes	#36, 29, 25, 21, 7, F, 5/16, U & 27/64
20-UB Tap Sizes	6-32, 8-32, 10-24, 10-32, 1/4-20 7/16-18, 3/8-16, 7/16-14 & 1/2-13

SP-18TDM (SPIRAL POINT, METRIC)

Part#	Description of Sizes
57990	
643-UB Drill Sizes (mm)	2.05, 2.50, 2.90, 3.30, 4.20, 5.00, 6.70, 8.50 & 10.20
21-UB Tap Sizes (mm)	2.5-.45, 3.0-.50, 3.5-.60, 4.0-.70, 5.0-.80, 6.0-1.00, 8.0-1.25, 10.0-1.50 & 12.0-1.75

SP-18TDF (SPIRAL POINT, NF)

Part#	Description of Sizes
58010	
240-UB Drill Sizes	#33, 29, 25, 21, 3, 1, Q, 25/64 & 29/64
20-UB Tap Sizes	6-40, 8-36, 10-24, 10-32, 1/4-28, 5/16-24, 3/8-24, 7/16-20 & 1/2-20

SP-12TD (SPIRAL POINT, NC)

Part#	Description of Sizes
58501	
240-UB Drill Sizes	#36, 29, 25, 21, 7, F
20-UB Tap Sizes	6-32, 8-32, 10-24, 10-32, 1/4-20 & 5/16-18

SF-18TDC (STRAIGHT FLUTE, NC)

Part#	Description of Sizes
60930	
240-UB Drill Sizes	#36, 29, 25, 21, 7, F, 5/16, U & 27/64
24-UB Tap Sizes	6-32, 8-32, 10-24, 10-32, 1/4-20, 5/16-18, 3/8-16, 7/16-14 & 1/2-13

SF-18TDF (STRAIGHT FLUTE, NF)

Part#	Description of Sizes
60940	
240-UB Drill Sizes	#33, 29, 25, 21, 3, 1, Q, 25/64 & 29/64
24-UB Tap Sizes	6-40, 8-36, 10-24, 10-32, 1/4-28, 5/16-24, 3/8-24, 7/16-20 & 1/2-20

SF-10TD (STRAIGHT FLUTE, NC)

Part#	Description of Sizes
58500	
240-UB Drill Sizes	31/64
280-UB Drill Sizes	17/32, 21/32, 49/64 & 7/8
24-UB Tap Sizes	9/16-12, 5/8-11, 3/4-10, 7/8-9 & 1-8

DRILL & TAP COMBO

Type 34-UB

- Includes the correct drill with corresponding size tap on a hanging card.
- Both tools are gold surface treated for maximum lubricity, and precision ground for the ultimate in accuracy and performance.
- Hi-Molybdenum super premium twist drill combined with the corresponding Hi-Tungsten Magnum spiral point tap.

Part #	Thread Size	Drill Size	Part #	Thread Size	Drill Size
51800	6-32	36	51890	1/4-28	3
51810	6-40	33	51900	5/16-18	F
51820	8-32	29	51910	5/16-24	I
51830	8-36	29	51920	3/8-16	5/16
51840	10-24	25	51930	3/8-24	Q
51850	10-32	21	51940	7/16-14	U
51860	12-24	16	51950	7/16-20	25/64
51870	12-28	14	51960	1/2-13	27/64
51880	1/4-20	7	51970	1/2-20	29/64

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COMBINATION DRILL & TAP

Type 40-UB

- Hi-Molybdenum tool steel ensures longer tool life.
- Combination drill and taps are ideally suited for on-site tapping in construction, maintenance and repair, assembly, production environments.
- The self-centering split point provides excellent drilling precision and accuracy.



Pitch Diameter and Thread tolerances are designed to produce a Class 2B fit.

Part #	Size	Max Material Thickness	Thread Length
73770	4-40	0.368	0.564
73780	4-48	0.369	0.564
73790	5-40	0.403	0.624
73800	5-44	0.404	0.624
73810	6-32	0.468	0.376
73820	6-40	0.470	0.376
73830	8-32	0.539	0.376
73840	8-36	0.540	0.376
73850	10-24	0.606	0.496
73860	10-32	0.608	0.496
73870	12-24	0.677	0.496
73880	12-28	0.678	0.496
73890	1/4-20	0.746	0.626
73900	1/4-28	0.750	0.626
73910	5/16-18	0.889	0.683
73920	5/16-24	0.893	0.683
73930	3/8-16	1.031	0.746
73940	3/8-24	1.036	0.746
73950	7/16-14	1.172	0.882
73960	7/16-20	1.178	0.880
73970	1/2-13	1.378	0.940
73980	1/2-20	1.384	0.940
75540	9/16-12	1.395	0.940
75550	9/16-18	1.403	0.940
75560	5/8-11	1.412	0.940
75570	5/8-18	1.421	0.940

Pitch Diameter and Thread tolerances are designed to produce a Class 6H fit.

Part #	MM Size	Max Material Thickness	Thread Length
85921	3.0 x 0.5	0.403	0.624
85931	4.0 x 0.7	0.538	0.376
85941	5.0 x 0.8	0.610	0.496
85951	6.0 x 1.00	0.746	0.626
85961	7.0 x 1.00	0.882	0.686
85971	8.0 x 1.25	0.892	0.686
85991	10.0 x 1.50	1.037	0.746
86001	12.0 x 1.75	1.373	0.942

Part#	SETS	Description of Sizes
21330	40-UB - DT-6	6pc. set 6-32, 8-32, 10-24, 10-32, 12-24, 1/4-20
73991	40-UB - DT-7F	7pc. set 8-36, 10-32, 1/4-28, 5/16-24, 3/8-24, 7/16-20, 1/2-20
73990	40-UB - DT-7C	7pc. set 8-32, 10-24, 1/4-20, 5/16-18, 3/8-16, 7/16-14, 1/2-13

1/4" QUICK RELEASE DRILL & TAP COMBO

Type 40-QR



- Hi-Molybdenum tool steel ensures longer tool life.
- Combination drill and taps are ideally suited for on-site tapping in construction, maintenance and repair, assembly, production environments.

Pitch Diameter and Thread tolerances are designed to produce a Class 2B fit.

Part #	Size	Max Material Thickness	Thread Length
73814	6-32	0.170	0.283
73834	8-32	0.200	0.283
73854	10-24	0.200	0.363
73864	10-32	0.200	0.363
73874	12-24	0.200	0.369
73894	1/4-20	0.230	0.326
73904	1/4-28	0.230	0.326
73914	5/16-18	0.480	0.614
73934	3/8-16	0.480	0.585

Pitch Diameter and Thread tolerances are designed to produce a Class 6H fit.

Part #	MM Size	Max Material Thickness	Thread Length
85924	3.0 x 0.50	0.170	0.334
85934	4.0 x 0.70	0.170	0.269
85944	5.0 x 0.80	0.200	0.404
85954	6.0 x 1.00	0.230	0.376
85974	8.0 x 1.25	0.480	0.638
85994	10.0 x 1.50	0.480	0.595

Part#	SETS	Description of Sizes
21324	40-QR DT-5	5pc. set 6-32, 8-32, 10-24, 10-32, 1/4-20

