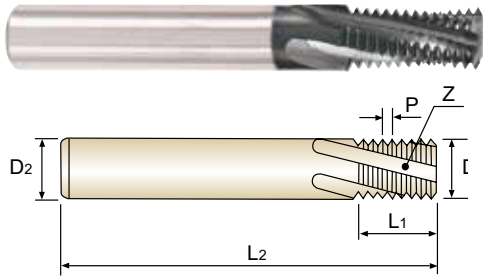


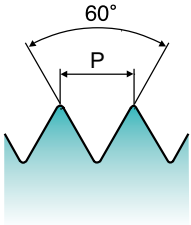
UNF Solid Carbide Thread Mill for UNF Internal Thread - ANSI B 1.1

- VOLLHARTMETALL GEWINDEFÄRÄSER für UNF INNENGEWINDE, ANSI B 1.1
- FRAISES A FILETER CARBURE MONOBLOC POUR FILETAGE INTER UNC - ANSI B 1.1
- Filettature interne, unificato, passo grosso - ANSI B 1.1

- Easy to cut threads even for exotic materials like Nickel, Titanium and their alloys.
- Problemloses Gewindeschneiden sogar in exotischen Werkstoffen, wie Nickel, Titan und ihre Legierungen.



Thread Depth
2×D



Material groups **MU** CARBIDE DIN 6535HA 60° R15 TiAlN p.B52

Recommended ToolHolder	Flat Shank		Plain Shank	
	Page	Page	Page	Page
⊙	END MILL HOLDER D117-137		HYDRAULIC CHUCK SHRINK FIT HOLDER D15-46 D47-72	
⊙	POWER MILLING CHUCK		D161-176	
○	ER COLLET CHUCK SKSLIM CHUCK		D73-115 D183-201	

Unit : mm

EDP No.	Nominal Diameter [D]	T.P.I	Cutter Diameter	Shank Diameter	Thread Length	Overall Length	No. of Flute
			D1	D2	L1	L2	Z
L1214420	1/4	28	5.0	6	13.6	57	3
L1214460	5/16	24	6.0	6	16.9	65	3
L1214500	3/8	24	8.0	8	20.1	72	4
L1214540	7/16	20	8.0	8	24.1	72	4
L1214580	1/2	20	10.0	10	26.7	80	4
L1214620	9/16	18	12.0	12	29.6	83	4
L1214660	5/8	18	12.0	12	33.9	92	4
L1214720	3/4	16	14.0	14	39.7	104	5

* Other coatings are available on your request

⊙ : Excellent ○ : Good

ISO	P										M				K					
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel		Stainless steel		Grey cast iron		Nodular cast iron		Malleable cast iron	
Material Description	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRC	13	25	28	32	38	10	29	32	38	15	35	15	23	10	10	26	3	25	21	21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙	○	○	○	⊙	⊙	⊙	⊙	⊙	⊙

ISO	N					S										H					
	Aluminum-wrought alloy		Aluminum-cast, alloyed		Copper and Copper Alloys (Bronze / Brass)	Non Metallic Materials	Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron					
Material Description	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRC	60	100	75	90	130	110	90	100			15	30	25	38	34	55	60	55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550
Recommended	⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙	○	○	○	○	○	○	○	○	○	○	○

SELECTION GUIDE



THREADING TOOLS

THREAD MILLS

TYPE	Thread Mill without Coolant Hole				Thread Mill with Coolant Hole		
	M	MF	UNC	UNF	M	MF	BSP(G)
THREAD FORM							
HOLE TYPE	Max. 2.0xD Blind /Through Hole	Max. 1.5xD Blind /Through Hole	Max. 2.0xD Blind /Through Hole	Max. 2.0xD Blind /Through Hole	Max. 2.0xD Blind /Through Hole	Max. 1.5xD Blind /Through Hole	-
TOOL MATERIAL	CARBIDE						
FLUTE TYPE	Helix						
HELIX ANGLE	R15						
SERIES NO.	L1211 (p.B34)	L1212 (p.B35)	L1213 (p.B36)	L1214 (p.B37)	L4211 (p.B38)	L4212 (p.B39)	L6215 (p.B40)
SURFACE TREATMENT	TiAIN	TiAIN	TiAIN	TiAIN	TiAIN	TiAIN	TiAIN
MODEL							

Please visit globalyg1.com/mat for material search

◎ : Excellent ○ : Good

ISO	VDI 3323	Material Description	HB	HRC	L1211	L1212	L1213	L1214	L4211	L4212	L6215
P	1	Non-alloy steel	125		◎	◎	◎	◎	◎	◎	◎
	2		190	13	◎	◎	◎	◎	◎	◎	◎
	3		250	25	◎	◎	◎	◎	◎	◎	◎
	4		270	28	◎	◎	◎	◎	◎	◎	◎
	5	300	32	◎	◎	◎	◎	◎	◎	◎	◎
	6	180	10	◎	◎	◎	◎	◎	◎	◎	◎
	7	Low alloy steel	275	29	◎	◎	◎	◎	◎	◎	◎
	8		300	32	◎	◎	◎	◎	◎	◎	◎
	9		350	38	◎	◎	◎	◎	◎	◎	◎
	10	High alloyed steel, and tool steel	200	15	◎	◎	◎	◎	◎	◎	◎
	11		325	35	◎	◎	◎	◎	◎	◎	◎
M	12	Stainless steel	200	15	○	○	○	○	○	○	○
	13		240	23	○	○	○	○	○	○	○
	14		180	10	○	○	○	○	○	○	○
K	15	Grey cast iron	180	10	◎	◎	◎	◎	◎	◎	◎
	16		260	26	◎	◎	◎	◎	◎	◎	◎
	17	Nodular Cast Iron	160	3	◎	◎	◎	◎	◎	◎	◎
	18		250	25	◎	◎	◎	◎	◎	◎	◎
	19	Malleable cast iron	130		◎	◎	◎	◎	◎	◎	◎
	20		230	21	◎	◎	◎	◎	◎	◎	◎
N	21	Aluminum-wrought alloy	60		◎	◎	◎	◎	◎	◎	◎
	22		100		◎	◎	◎	◎	◎	◎	◎
	23	Aluminum-cast, alloyed	75		◎	◎	◎	◎	◎	◎	◎
	24		90		◎	◎	◎	◎	◎	◎	◎
	25		130		◎	◎	◎	◎	◎	◎	◎
	26	Copper and Copper Alloys (Bronze / Brass)	110		◎	◎	◎	◎	◎	◎	◎
	27		90		◎	◎	◎	◎	◎	◎	◎
	28		100		◎	◎	◎	◎	◎	◎	◎
	29	Non Metallic Materials			◎	◎	◎	◎	◎	◎	◎
30				◎	◎	◎	◎	◎	◎	◎	
S	31	Heat Resistant Super Alloys	200	15	○	○	○	○	○	○	○
	32		280	30	○	○	○	○	○	○	○
	33		250	25	○	○	○	○	○	○	○
	34		350	38	○	○	○	○	○	○	○
	35		320	34	○	○	○	○	○	○	○
	36	Titanium Alloys	400 Rm		○	○	○	○	○	○	○
	37		1050 Rm		○	○	○	○	○	○	○
H	38	Hardened steel	550	55							
	39		630	60							
	40	Chilled Cast Iron	400	42							
41	Hardened Cast Iron	550	55								



RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDKONDITIONEN

THREAD MILLS					L1211	L1212	L1213	L1214	L4211	L4212	L6215	L4271	L4272			
ISO	VDI 3323	Material Description	HB	HRc	Vc (m/min)											
SYNCHRO TAPS PRIME TAPS COMBO TAPS YG TAP GENERAL YG TAP STEEL YG TAP HARDENED	P	Non-alloy steel	1	125		80-120	80-120	80-120	80-120	80-120	80-120	80-120	80-120	80-120		
			2	190	13	80-120	80-120	80-120	80-120	80-120	80-120	80-120	80-120	80-120	80-120	
			3	250	25	80-120	80-120	80-120	80-120	80-120	80-120	80-120	80-120	80-120	80-120	
			4	270	28	80-120	80-120	80-120	80-120	80-120	80-120	80-120	80-120	80-120	80-120	
			5	300	32	80-120	80-120	80-120	80-120	80-120	80-120	80-120	80-120	80-120	80-120	
		Low alloy steel	6	180	10	80-120	80-120	80-120	80-120	80-120	80-120	80-120	80-120	80-120	80-120	
			7	275	29	80-120	80-120	80-120	80-120	80-120	80-120	80-120	80-120	80-120	80-120	
			8	300	32	80-120	80-120	80-120	80-120	80-120	80-120	80-120	80-120	80-120	80-120	
			9	350	38	80-120	80-120	80-120	80-120	80-120	80-120	80-120	80-120	80-120	80-120	
			High alloyed steel, and tool steel	10	200	15	80-120	80-120	80-120	80-120	80-120	80-120	80-120	80-120	80-120	80-120
				11	325	35	80-120	80-120	80-120	80-120	80-120	80-120	80-120	80-120	80-120	80-120
YG TAP INOX	M	Stainless steel	12	200	15	40-80	40-80	40-80	40-80	40-80	40-80	40-80	40-80	40-80		
			13	240	23	40-80	40-80	40-80	40-80	40-80	40-80	40-80	40-80	40-80		
			14	180	10	40-80	40-80	40-80	40-80	40-80	40-80	40-80	40-80	40-80		
YG TAP CAST IRON YG TAP ALU	K	Grey cast iron	15	180	10	50-100	50-100	50-100	50-100	50-100	50-100	50-100	50-100	50-100		
			16	260	26	50-100	50-100	50-100	50-100	50-100	50-100	50-100	50-100	50-100		
		Nodular cast iron	17	160	3	50-100	50-100	50-100	50-100	50-100	50-100	50-100	50-100	50-100		
			18	250	25	50-100	50-100	50-100	50-100	50-100	50-100	50-100	50-100	50-100		
		Malleable cast iron	19	130		50-100	50-100	50-100	50-100	50-100	50-100	50-100	50-100	50-100		
20	230	21	50-100	50-100	50-100	50-100	50-100	50-100	50-100	50-100	50-100	50-100				
YG TAP Ti Ni YG TAP FORMING NUT TAPS STI TAPS PIPE TAPS	N	Aluminum-wrought alloy	21	60		100-300	100-300	100-300	100-300	100-300	100-300	100-300	100-300	100-300		
			22	100		100-300	100-300	100-300	100-300	100-300	100-300	100-300	100-300	100-300		
		Aluminum-cast, alloyed	23	75		100-300	100-300	100-300	100-300	100-300	100-300	100-300	100-300	100-300		
			24	90		100-300	100-300	100-300	100-300	100-300	100-300	100-300	100-300	100-300		
			25	130		100-300	100-300	100-300	100-300	100-300	100-300	100-300	100-300	100-300		
		Copper and Copper Alloys (Bronze / Brass)	26	110		100-300	100-300	100-300	100-300	100-300	100-300	100-300	100-300	100-300		
			27	90		100-300	100-300	100-300	100-300	100-300	100-300	100-300	100-300	100-300		
		Non Metallic Materials	28	100		100-300	100-300	100-300	100-300	100-300	100-300	100-300	100-300	100-300	100-300	
			29			100-300	100-300	100-300	100-300	100-300	100-300	100-300	100-300	100-300	100-300	
			30			100-300	100-300	100-300	100-300	100-300	100-300	100-300	100-300	100-300	100-300	
TECHNICAL DATA	S	Heat Resistant Super Alloys	31	200	15	20-60	20-60	20-60	20-60	20-60	20-60	20-60	20-60	20-60		
			32	280	30	20-60	20-60	20-60	20-60	20-60	20-60	20-60	20-60	20-60		
			33	250	25	20-60	20-60	20-60	20-60	20-60	20-60	20-60	20-60	20-60		
			34	350	38	20-60	20-60	20-60	20-60	20-60	20-60	20-60	20-60	20-60		
			35	320	34	20-60	20-60	20-60	20-60	20-60	20-60	20-60	20-60	20-60		
		Titanium Alloys	36	400Rm		20-60	20-60	20-60	20-60	20-60	20-60	20-60	20-60	20-60	20-60	
			37	1050Rm		20-60	20-60	20-60	20-60	20-60	20-60	20-60	20-60	20-60	20-60	
H	H	Hardened steel	38	550	55					25-60	25-60					
			39	630	60					25-50	25-50					
		Chilled Cast Iron	40	400	42					25-70	25-70					
		Hardened Cast Iron	41	550	55					25-60	25-60					

SURFACE TREATMENT AND COATING

The applied High Speed Steels holds a grant of good wear resistance and toughness. Therefore YG-1 normally delivers taps with bright and unfinished surface. For certain materials, various surface treatments provide higher advantage in machining.

STEAM TEMPERED - Vap

Steam Tempered is a Fe₃O₄-oxyd-coating which reduces friction between the tool and workpiece, also preventing cold welding.

NITRIDING - NI

Recommend surface treatment for machining materials that affect wear abrasion, such as grey cast iron, alu-alloys with high Si-percentages (more than 10%).

Below are the various surface treatments for excellent finish surfaces suitable for many applications. The surface treatments are produced and developed within the company.

TiN-COATING

TiN-coating yields a hardness of approx. 2,300 HV and also a heat resistant up to approx. 600°C. The current coating is an excellent all-round coating for normal applications.

Colour : Golden Coefficient of friction against steel : 0.4

TiCN-COATING

TiCN takes place of TiN when the conditions require the coating to have a different hardness and toughness.

The TiCN brings advantages for machining very difficult steels or cutting interrupted bores.

The TiCN-coating has a hardness of approx. 3,000 HV, but is heat resistance only holds up to approx. 400°C, meaning that the TiCN needs an excellent cooling system for a long service life.

Colour : Blue-Grey Coefficient of friction against steel : 0.4

TiAlN-COATING

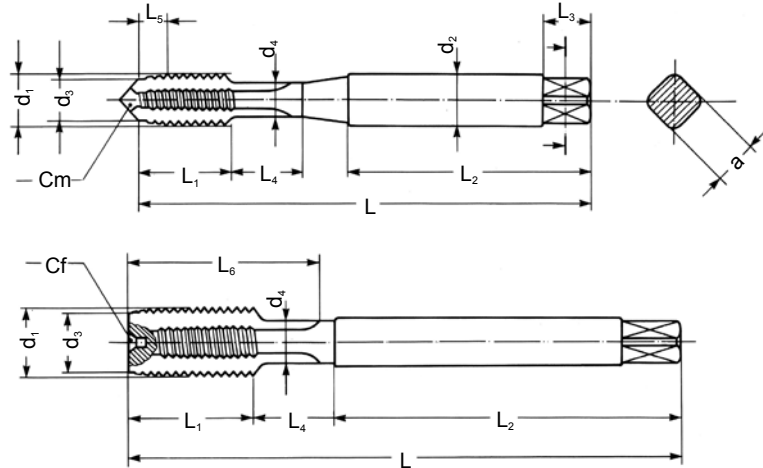
A special coating for machining abrasive materials such as grey cast iron, alu-alloys with silicon, fiber reinforced plastics, etc., or machining at high temperatures with insufficient cooling, or at high speeds $\geq 600\text{m/min}$. TiAlN has a hardness of approx. 3,000 HV and is heat resistant up to approx. 800°C.

Colour : Violet-Grey Coefficient of friction against steel : 0.4

Hardslick-COATING

Hardslick combines the advantages of an extremely hard, thermally stable TiAlN-coating with the sliding and lubricating properties of an outer WC/C(Tungsten carbide/carbon)-coating in a novel way. The Hardslick coating has a hardness of approx. 3,000 HV and is temperature-resistant up to approx. 800°C.

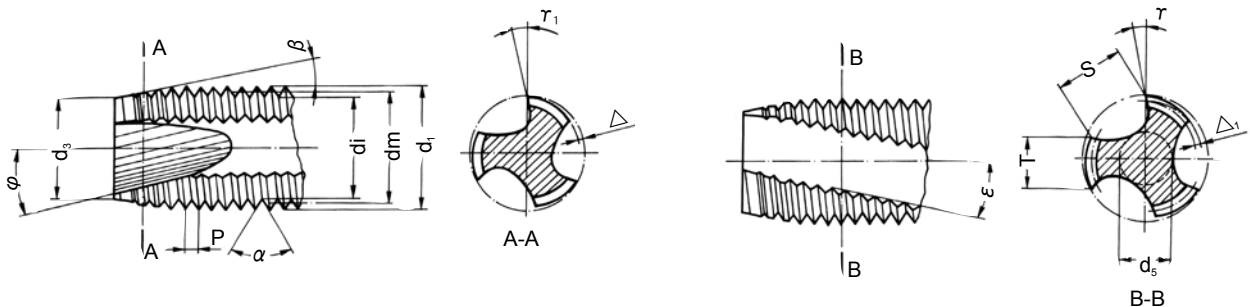
Colour : Violet-Grey Coefficient of friction against steel : 0.2


TAPS TERMINOLOGY
FACHAUSDRÜCKE BEI GEWINDEBOHRERN (Terminologie)


d_1 Major diameter
 d_2 Shank diameter
 d_3 Chamfer diameter
 d_4 Neck diameter
 L Total length
 L_1 Thread length
 L_2 Shank length
 L_3 Square length
 L_4 Neck length
 L_5 Chamfer length
 L_6 Flutes length
 a Square
 Cm Center male
 Cf Center female

d_1 Nenn Aussendurchmesser
 d_2 Schaftdurchmesser
 d_3 Anschnittdurchmesser
 d_4 Bunddurchmesser
 L Gesamtlänge
 L_1 Gewindelänge
 L_2 Schaftlänge
 L_3 Vierkantlänge
 L_4 Bundlänge
 L_5 Anschnittlänge
 L_6 Nutenlänge
 a Vierkantmaß β
 Cm Mittelpunkt des Aussengewindes
 Cf Mittelpunkt des Innengewindes

d_1 Diamètre externe nominal
 d_2 Diamètre de la queue
 d_3 Diamètre de l'entrée
 d_4 Diamètre de la collerette de dégagement
 L Longueur totale
 L_1 Longueur de la partie filetée
 L_2 Longueur de la queue
 L_3 Longueur du carré
 L_4 Longueur de la collerette de dégagement
 L_5 Longueur de l'entrée
 L_6 Longueur des goujures
 a Carré
 Cm Centre mâle
 Cf Centre femelle



d_1 Major diameter
 dm Flank diameter
 d_i Minor diameter
 d_3 Chamfer diameter
 P Pitch
 a Flank angle
 β Chamfer angle
 φ Gun nose angle
 r Gun nose rake angle in front
 Δ Chamfer relief
 Δ_1 Pitch diameter relief on the land
 τ Rake angle
 T Width of land
 S Flute width
 d_5 Web thickness
 ϵ Angle of spiral flute

d_1 Nenn Aussendurchmesser
 dm Flankendurchmesser
 d_i Kerndurchmesser
 d_3 Anschnittdurchmesser
 P Steigung
 a Flankenwinkel
 β Anschnittwinkel
 φ Schälsschnittwinkel
 r Schälsschnitt-Spanwinkel
 r_1 Schälsschnitt-Spanwinkel
 Δ Hinterschliff am Anschnitt
 Δ_1 Flankenhinterschliff auf Zahnbreite
 τ Spanwinkel
 T Zahnstollenbreite
 S Nutenbreite
 d_5 Seelendicke
 ϵ Spiralwinkel

d_1 Diamètre externe nominal
 dm Diamètre moyen
 d_i Diamètre interne
 d_3 Diamètre de l'entrée
 P Pas
 a Angle du filet
 β Demi-angle du cône d'entrée
 φ Angle de l'entrée GUN
 r Angle de coupe sur l'entrée GUN
 Δ Détalonnage sur l'entrée
 Δ_1 Détalonnage sur le filet
 τ Angle de coupe frontale
 T Largeur des dents
 S Largeur des goujures
 d_5 Diamètre de l'âme
 ϵ Angle d'hélice des goujures

**RECOMMENDED TAP DRILL SIZE
EMPFOHLENE KERNLOCHMASSE**

Unit : mm

Metric-ISO threads coarse pitch				Metric-ISO threads fine pitch				Metric-ISO threads fine pitch			
M	Pitch	Maximum core dia.	Drill size	MF	Pitch	Maximum core dia.	Drill size	MF	Pitch	Maximum core dia.	Drill size
1	0.25	0.785	0.75	2.5	0.35	2.221	2.15	25	2.00	23.210	23.00
1.1	0.25	0.885	0.85	3	0.35	2.271	2.65	26	1.50	24.676	24.50
1.2	0.25	0.985	0.95	3.5	0.35	3.221	3.15	27	1.00	26.153	26.00
1.4	0.30	1.160	1.10	4	0.50	3.599	3.50	27	1.50	25.676	25.50
1.6	0.35	1.321	1.25	4.5	0.50	4.099	4.00	27	2.00	25.210	25.00
1.7	0.35	1.346	1.30	5	0.50	4.599	4.50	28	1.00	27.153	27.00
1.8	0.35	1.521	1.45	5.5	0.50	5.099	5.00	28	1.50	26.676	26.50
2	0.40	1.679	1.60	6	0.75	5.378	5.20	28	2.00	26.210	26.00
2.2	0.45	1.838	1.75	7	0.75	6.378	6.20	30	1.00	29.153	29.00
2.3	0.40	1.920	1.90	8	0.75	7.378	7.20	30	1.50	28.676	28.50
2.5	0.45	2.138	2.05	8	1.00	7.153	7.00	30	2.00	28.210	28.00
2.6	0.45	2.176	2.10	9	0.75	8.378	8.20	30	3.00	27.252	27.00
3	0.50	2.599	2.50	9	1.00	8.153	8.00	32	1.50	30.675	30.50
3.5	0.60	3.010	2.90	10	0.75	9.378	9.20	32	2.00	30.210	30.00
4	0.70	3.422	3.30	10	1.00	9.153	9.00	33	1.50	31.676	31.50
4.5	0.75	3.878	3.70	10	1.25	8.912	8.80	33	2.00	31.210	31.00
5	0.80	4.334	4.20	11	0.75	10.378	10.20	33	3.00	30.252	30.00
6	1.00	5.153	5.00	11	1.00	10.153	10.00	35	1.50	33.676	33.50
7	1.00	6.153	6.00	12	1.00	11.153	11.00	36	1.50	34.676	34.50
8	1.25	6.912	6.80	12	1.25	10.912	10.80	36	2.00	34.210	34.00
9	1.25	7.912	7.80	12	1.50	10.676	10.50	36	3.00	33.252	33.00
10	1.50	8.676	8.50	14	1.00	13.153	13.00	38	1.50	36.676	36.50
11	1.50	9.676	9.50	14	1.25	12.912	12.80	39	1.50	37.676	37.50
12	1.75	10.441	10.20	14	1.50	12.676	12.50	39	2.00	37.210	37.00
14	2.00	12.210	12.00	15	1.00	14.153	14.00	39	3.00	36.252	36.00
16	2.00	14.210	14.00	15	1.50	13.676	13.50	40	1.50	38.676	38.50
18	2.50	15.744	15.50	16	1.00	15.153	15.00	40	2.00	38.210	38.00
20	2.50	17.744	17.50	16	1.50	14.676	14.50	40	3.00	37.252	37.00
22	2.50	19.744	19.50	17	1.00	16.153	16.00	42	1.50	40.676	40.50
24	3.00	21.252	21.00	17	1.50	15.676	15.50	42	2.00	40.210	40.00
27	3.00	24.252	24.00	18	1.00	17.153	17.00	42	3.00	39.252	39.00
30	3.50	26.771	26.50	18	1.50	16.676	16.50	45	1.50	43.676	43.50
33	3.50	29.771	29.50	18	2.00	16.210	16.00	45	2.00	43.210	43.00
36	4.00	32.270	32.00	20	1.00	19.153	19.00	45	3.00	42.252	42.00
39	4.00	35.270	35.00	20	1.50	18.676	18.50	48	1.50	46.676	46.50
42	4.50	37.799	37.50	20	2.00	18.210	18.00	48	2.00	46.210	46.00
45	4.50	40.799	40.50	22	1.00	21.153	21.00	48	3.00	45.252	45.00
48	5.00	43.297	43.00	22	1.50	20.676	20.50	50	1.50	48.676	48.50
52	5.00	47.297	47.00	22	2.00	20.210	20.00	50	2.00	48.210	48.00
56	5.50	50.796	50.50	24	1.00	23.153	23.00	50	3.00	47.252	47.00
60	5.50	54.796	54.50	24	1.50	22.676	22.50	52	1.50	50.676	50.50
64	6.00	58.305	58.00	24	2.00	22.210	22.00	52	2.00	50.210	50.00
68	6.00	62.305	62.00	25	1.00	24.153	24.00	52	3.00	49.252	49.00
				25	1.50	23.676	23.50				



Unit : mm

	American Unified coarse threads				American Unified fine threads			
	UNC	T.P.I	Maximum core dia.	Drill size	UNF	T.P.I	Maximum core dia.	Drill size
	#1	64	1.585	1.50	#0	80	1.306	1.30
	#2	56	1.872	1.80	#1	72	1.613	1.60
	#3	48	2.146	2.10	#2	64	1.913	1.90
COMBO TAPS	#4	40	2.385	2.30	#3	56	2.197	2.10
	#5	40	2.697	2.60	#4	48	2.459	2.40
	#6	32	2.896	2.85	#5	44	2.741	2.70
YG TAP GENERAL	#8	32	3.528	3.50	#6	40	3.012	3.00
	#10	24	3.950	3.90	#8	36	3.597	3.50
	#12	24	4.590	4.50	#10	32	4.168	4.10
YG TAP STEEL	1/4"	20	5.250	5.20	#12	28	4.717	4.70
	5/16"	18	6.680	6.60	1/4"	28	5.563	5.50
	3/8"	16	8.082	8.00	5/16"	24	6.995	6.90
YG TAP HARDENED	7/16"	14	9.441	9.40	3/8"	24	8.565	8.50
	1/2"	13	10.881	10.75	7/16"	20	9.947	9.90
YG TAP INOX	9/16"	12	12.301	12.25	1/2"	20	11.524	11.50
	5/8"	11	13.693	13.50	9/16"	18	12.969	12.90
	3/4"	10	16.624	16.50	5/8"	18	14.554	14.50
YG TAP CAST IRON	7/8"	9	19.520	19.50	3/4"	16	17.546	17.50
	1"	8	22.344	22.25	7/8"	14	20.493	20.50
	1*1/8"	7	25.082	25.00	1"	12	23.363	23.25
YG TAP ALU	1*1/4"	7	28.258	28.25	1*1/8"	12	26.538	26.50
	1*3/8"	6	30.851	30.75	1*1/4"	12	29.713	29.50
	1*1/2"	6	34.026	34.00	1*3/8"	12	32.888	32.70
YG TAP Ti Ni	1*3/4"	5	39.560	39.50	1*1/2"	12	36.063	36.00
	2"	4.5	45.367	45.25				

	Whitworth threads B.S.W.				Whitworth pipe thread BSP.PI			
	BSW	T.P.I	Maximum core dia.	Drill size	G(BSP)	T.P.I	Maximum core dia.	Drill size
	3/32"	48	1.910	1.80	1/8"	28	8.848	8.80
	1/8"	40	2.590	2.50	1/4"	19	11.890	11.80
	5/32"	32	3.211	3.10	3/8"	19	15.395	15.25
PIPE TAPS	3/16"	24	3.743	3.60	1/2"	14	19.172	19.00
	7/32"	24	4.538	4.40	5/8"	14	21.128	21.00
	1/4"	20	5.224	5.10	3/4"	14	24.658	24.50
	5/16"	18	6.661	6.50	7/8"	14	28.418	28.25
	3/8"	16	8.052	7.90	1"	11	30.931	30.75
	7/16"	14	9.379	9.30	1*1/8"	11	35.579	35.50
	1/2"	12	10.610	10.50	1*1/4"	11	39.592	39.50
	9/16"	12	12.176	12.00	1*3/8"	11	42.005	42.00
	5/8"	11	13.598	13.50	1*1/2"	11	45.485	45.20
	3/4"	10	16.538	16.50	1*5/8"	11	49.670	49.60
	7/8"	9	19.411	19.25	1*3/4"	11	51.428	51.40
	1"	8	22.185	22.00	2"	11	57.296	57.20
	1*1/8"	7	24.879	24.75	2*1/4"	11	63.392	63.30
	1*1/4"	7	28.054	27.75	2*3/8"	11	67.080	67.00
	1*3/8"	6	30.555	30.50	2*1/2"	11	72.866	72.80
	1*1/2"	6	33.730	33.50	2*3/4"	11	79.216	79.10
	1*5/8"	5	35.921	35.50	3"	11	85.566	85.50
	1*3/4"	5	39.096	39.00	3*1/4"	11	91.662	91.50
	1*7/8"	4.5	41.648	41.50	3*1/2"	11	98.012	98.00
	2"	4.5	44.823	44.50	3*3/4"	11	104.362	104.00
	2*1/4"	4	50.420	50.00	4"	11	110.712	110.50
	2*1/2"	4	56.770	56.50				
	2*3/4"	3.5	62.108	62.00				
	3"	3.5	68.459	68.50				