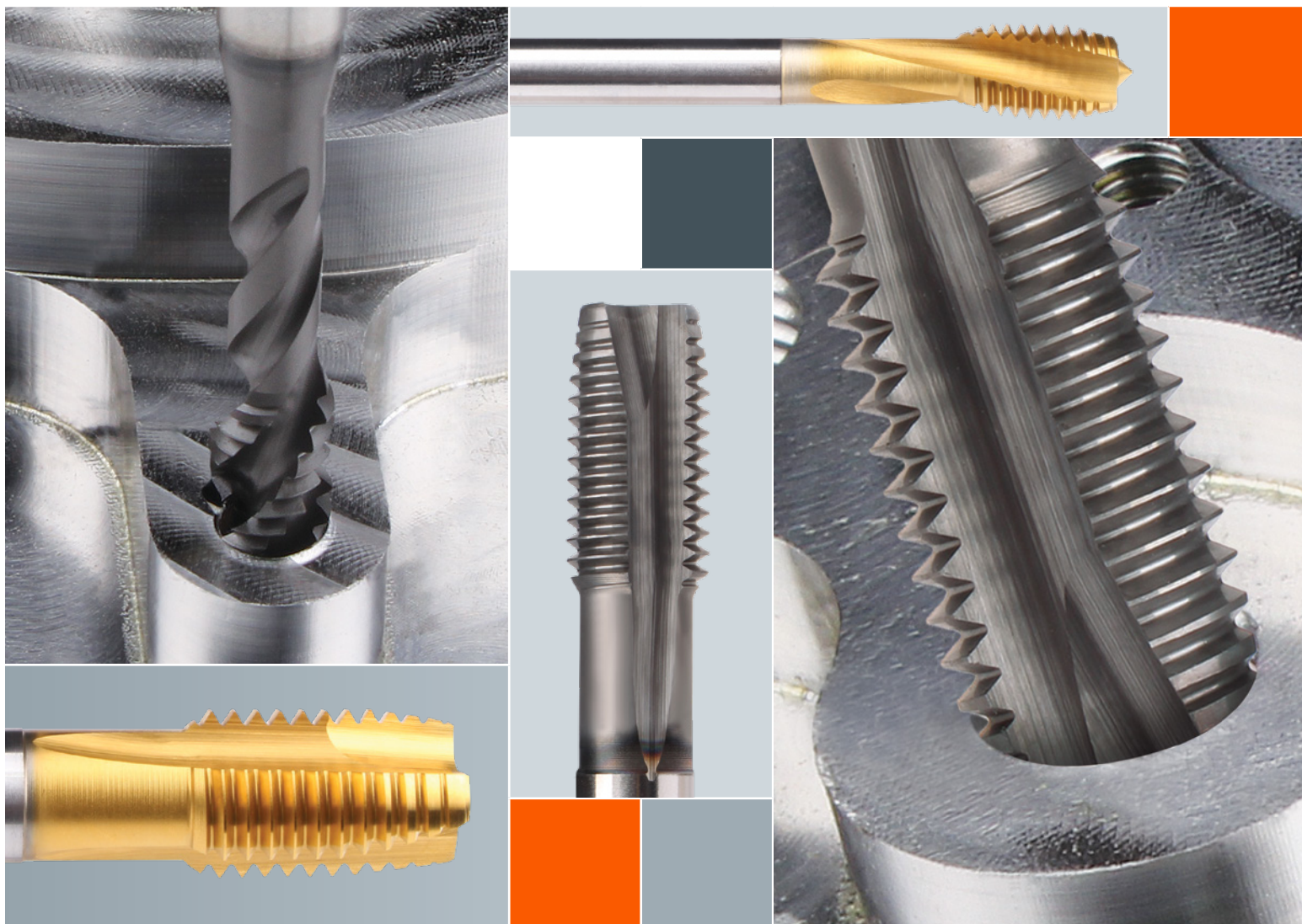


NEW!

EMUGE



TAPPING SOLUTIONS FOR
STEEL & ALLOYED STEEL CHALLENGES

Introducing a New Generation of Taps for Steel and Alloyed Steel Applications

Advanced geometry and new coatings for longer lasting tools

With so many brands and solutions to choose from, finding the optimum performance level for your application can be a challenging process. Emuge takes the guesswork out of the process by offering you the best tools for each material group. Years of Emuge testing and field results have shown that these new Emuge tools provide the longest and most consistent solution for threading steel and alloyed steel materials.

Although both material groups are similar, carbon and structural steel are very different from alloyed steels in their machining characteristics. Each group has their own unique challenges, and require different tool geometries and coatings to be successfully tapped. Although Emuge offers an extensive array of standard tap designs for each material, we have narrowed these down to the most effective solution in 90% of steel and alloyed steel tapping applications. Please visit Emuge.com for more information.

Steel

Including carbon steel, cold extruded steel and structural steel

The **Rekord B-Steel-L tap** is a plug tap that is used in through-hole applications. A new optimized cutting geometry on this series of taps has produced **tool life increases of 30-60%** over previous designs.

The **Rekord D-Steel tap** is a slow spiral semi-bottoming tap for thread depths of up to 2xD in blind-hole applications.

Both the B-Steel and D-Steel taps are TiN coated for long life and heat resistance.

Alloyed Steel

Including heat-treatable steels and tool steels

The **Rekord B-VA tap** is a plug tap used for through-hole applications. The **Enorm VA** is a spiral flute tap for semi-bottoming blind-hole applications. Both taps are now available with Emuge's own **GLT-1 multi-layered, high lubricity coating**, which produces consistent, controllable chip formations that release smoothly for fast and efficient chip removal. GLT-1 is uniquely structured with advanced heat resistance characteristics, along with an outer anti-friction layer. These elements have been synergistically combined to produce exceptional wear resistance and sliding properties that result in **improved tool life, reduced torque, optimized chip evacuation and superior thread finish**.

Taps for Steel Applications

| | |
|---|---|
|  |  |
| Page 4 | Page 5 |
| Rekord B-Steel-L | Rekord D-Steel |
| Spiral Point Plug Tap | Spiral Flute Bottoming Tap |
| TiN Coating | TiN Coating |
| 2B class of fit | 2B class of fit |

Taps for Alloyed Steel Applications

| | |
|--|---|
|  |  |
| Pages 6-7 | Pages 8-9 |
| Rekord B-VA | Enorm VA |
| Spiral Point Plug Tap | Spiral Flute Bottoming Tap |
| GLT-1 Coating | GLT-1 Coating |
| 2B and 3B Class of fit | 2B and 3B Class of fit |



MATERIALS AND SPEED RECOMMENDATIONS

| Applications – Materials | | Hardness Range | | | Material Examples | SFM |
|--------------------------|---|----------------|-------|-------------------|---|----------|
| | | HRC | BHN | N/mm ² | | |
| | Steel materials | | | | | |
| 1.1 | Cold-extrusion steels, Construction steels, Free-cutting steels, etc. | | ≤ 180 | ≤ 600 | 1010 / 1018 / 1020 / 12L14 / 12L15 / A36 / T1 | 48 - 148 |
| 2.1 | Construction steels, Cementation steels, Steel castings, etc. | ≤ 22 | ≤ 235 | ≤ 800 | A36 / T1 / 1030-1095 / 4140 / 4340 / 8620 | 33 - 131 |
| 3.1 | Cementation steels, Heat-treatable steels, Cold work steels, etc. | ≤ 31 | ≤ 295 | ≤ 1000 | 4140 / 4340 / 8620 / P20 / H13 / D2 / A2 / S7 / H1150 | 16 - 82 |
| 4.1 | Heat-treatable steels, Cold work steels, Nitriding steels, etc. | ≤ 38 | ≤ 355 | ≤ 1200 | 4140 / 4340 / 8620 / P20 / H13 / D2 / 300M / 52100 / M1-M42 | 16 - 66 |

- TiN Coating
- B / 4-5 Chamfer Length
- 2B Class of Fit




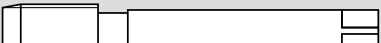
UNC – THROUGH-HOLE

| Size | T.P.I. | # Flutes | Shank Dia. | Square Width | OAL | EDP No. |
|-------|--------|----------|------------|--------------|-------|----------------------|
| #3 | 48 | 2 | 0.141 | 0.110 | 1.969 | BU208400.5002 |
| #4 | 40 | 2 | 0.141 | 0.110 | 2.205 | BU208400.5003 |
| #5 | 40 | 3 | 0.141 | 0.110 | 2.205 | BU208400.5004 |
| #6 | 32 | 3 | 0.141 | 0.110 | 2.205 | BU208400.5005 |
| #8 | 32 | 3 | 0.168 | 0.131 | 2.480 | BU208400.5006 |
| #10 | 24 | 3 | 0.194 | 0.152 | 2.756 | BU208400.5007 |
| #12 | 24 | 3 | 0.220 | 0.165 | 3.150 | BU208400.5008 |
| 1/4 | 20 | 3 | 0.255 | 0.191 | 3.150 | BU208400.5009 |
| 5/16 | 18 | 3 | 0.318 | 0.238 | 3.543 | BU208400.5010 |
| 3/8 | 16 | 3 | 0.381 | 0.286 | 3.937 | BU208400.5011 |
| 7/16 | 14 | 3 | 0.323 | 0.242 | 3.937 | CU208400.5012 |
| 1/2 | 13 | 3 | 0.367 | 0.275 | 3.937 | CU208400.5013 |
| 9/16 | 12 | 3 | 0.429 | 0.322 | 3.937 | CU208400.5014 |
| 5/8 | 11 | 3 | 0.480 | 0.360 | 3.937 | CU208400.5015 |
| 3/4 | 10 | 3 | 0.590 | 0.442 | 4.331 | CU208400.5016 |
| 7/8 | 9 | 3 | 0.697 | 0.523 | 4.921 | CU208400.5017 |
| 1 | 8 | 3 | 0.800 | 0.600 | 5.512 | CU208400.5018 |
| 1 1/8 | 7 | 3 | 0.896 | 0.672 | 5.906 | CU208400.5019 |
| 1 1/4 | 7 | 4 | 1.021 | 0.766 | 5.906 | CU208400.5020 |
| 1 3/8 | 6 | 4 | 1.108 | 0.831 | 6.693 | CU208400.5021 |
| 1 1/2 | 6 | 4 | 1.233 | 0.925 | 6.693 | CU208400.5022 |
| 1 3/4 | 5 | 4 | 1.430 | 1.072 | 8.661 | CU208400.5023 |
| 2 | 4 1/2 | 4 | 1.644 | 1.233 | 9.843 | CU208400.5024 |

UNF – THROUGH-HOLE

| Size | T.P.I. | # Flutes | Shank Dia. | Square Width | OAL | EDP No. |
|-------|--------|----------|------------|--------------|-------|----------------------|
| #2 | 64 | 2 | 0.141 | 0.110 | 1.772 | BU208400.5035 |
| #3 | 56 | 2 | 0.141 | 0.110 | 1.969 | BU208400.5036 |
| #4 | 48 | 2 | 0.141 | 0.110 | 2.205 | BU208400.5037 |
| #5 | 44 | 3 | 0.141 | 0.110 | 2.205 | BU208400.5038 |
| #6 | 40 | 3 | 0.141 | 0.110 | 2.205 | BU208400.5039 |
| #8 | 36 | 3 | 0.168 | 0.131 | 2.480 | BU208400.5040 |
| #10 | 32 | 3 | 0.194 | 0.152 | 2.756 | BU208400.5041 |
| #12 | 28 | 3 | 0.220 | 0.165 | 3.150 | BU208400.5042 |
| 1/4 | 28 | 3 | 0.255 | 0.191 | 3.150 | BU208400.5043 |
| 5/16 | 24 | 3 | 0.318 | 0.238 | 3.543 | BU208400.5044 |
| 3/8 | 24 | 4 | 0.381 | 0.286 | 3.937 | BU208400.5045 |
| 7/16 | 20 | 3 | 0.323 | 0.242 | 3.937 | CU208400.5046 |
| 1/2 | 20 | 3 | 0.367 | 0.275 | 3.937 | CU208400.5047 |
| 9/16 | 18 | 3 | 0.429 | 0.322 | 3.937 | CU208400.5048 |
| 5/8 | 18 | 3 | 0.480 | 0.360 | 3.937 | CU208400.5049 |
| 3/4 | 16 | 3 | 0.590 | 0.442 | 4.331 | CU208400.5050 |
| 7/8 | 14 | 4 | 0.697 | 0.523 | 4.921 | CU208400.5051 |
| 1 | 12 | 4 | 0.800 | 0.600 | 5.512 | CU208400.5052 |
| 1 1/8 | 12 | 4 | 0.896 | 0.672 | 5.906 | CU208400.5053 |
| 1 1/4 | 12 | 4 | 1.021 | 0.766 | 5.906 | CU208400.5054 |
| 1 3/8 | 12 | 5 | 1.108 | 0.831 | 6.693 | CU208400.5055 |
| 1 1/2 | 12 | 5 | 1.233 | 0.925 | 6.693 | CU208400.5056 |

For Materials and Speed Recommendations, see page 3.

| | | |
|----------------------|---|---|
| DIN Shank Type |  | Reinforced Style: on tap sizes: 0 – 3/8 |
| |  | Reduced Style: on tap sizes: 7/16 – 2 |



- TiN Coating
- C / 2-3 Chamfer Length
- 2B Class of Fit

UNC – BLIND-HOLE

| Size | T.P.I. | # Flutes | Shank Dia. | Square Width | OAL | EDP No. |
|-------|--------|----------|------------|--------------|-------|----------------------|
| #1 | 64 | 2 | 0.141 | 0.110 | 1.772 | BU451400.5000 |
| #2 | 56 | 2 | 0.141 | 0.110 | 1.772 | BU451400.5001 |
| #3 | 48 | 2 | 0.141 | 0.110 | 1.969 | BU451400.5002 |
| #4 | 40 | 2 | 0.141 | 0.110 | 2.205 | BU451400.5003 |
| #5 | 40 | 2 | 0.141 | 0.110 | 2.205 | BU451400.5004 |
| #6 | 32 | 3 | 0.141 | 0.110 | 2.205 | BU451400.5005 |
| #8 | 32 | 3 | 0.168 | 0.131 | 2.480 | BU451400.5006 |
| #10 | 24 | 3 | 0.194 | 0.152 | 2.756 | BU451400.5007 |
| #12 | 24 | 3 | 0.220 | 0.165 | 3.150 | BU451400.5008 |
| 1/4 | 20 | 3 | 0.255 | 0.191 | 3.150 | BU451400.5009 |
| 5/16 | 18 | 3 | 0.318 | 0.238 | 3.543 | BU451400.5010 |
| 3/8 | 16 | 3 | 0.381 | 0.286 | 3.937 | BU451400.5011 |
| 7/16 | 14 | 3 | 0.323 | 0.242 | 3.937 | CU451400.5012 |
| 1/2 | 13 | 3 | 0.367 | 0.275 | 4.331 | CU451400.5013 |
| 9/16 | 12 | 3 | 0.429 | 0.322 | 4.331 | CU451400.5014 |
| 5/8 | 11 | 3 | 0.480 | 0.360 | 4.331 | CU451400.5015 |
| 3/4 | 10 | 3 | 0.590 | 0.442 | 4.921 | CU451400.5016 |
| 7/8 | 9 | 3 | 0.697 | 0.523 | 5.512 | CU451400.5017 |
| 1 | 8 | 3 | 0.800 | 0.600 | 6.299 | CU451400.5018 |
| 1 1/8 | 7 | 3 | 0.896 | 0.672 | 7.087 | CU451400.5019 |
| 1 1/4 | 7 | 4 | 1.021 | 0.766 | 7.087 | CU451400.5020 |

UNF – BLIND-HOLE

| Size | T.P.I. | # Flutes | Shank Dia. | Square Width | OAL | EDP No. |
|------|--------|----------|------------|--------------|-------|----------------------|
| #0 | 80 | 2 | 0.141 | 0.110 | 1.626 | BU451400.5033 |
| #1 | 72 | 2 | 0.141 | 0.110 | 1.772 | BU451400.5034 |
| #2 | 64 | 2 | 0.141 | 0.110 | 1.772 | BU451400.5035 |
| #3 | 56 | 2 | 0.141 | 0.110 | 1.969 | BU451400.5036 |
| #4 | 48 | 2 | 0.141 | 0.110 | 2.205 | BU451400.5037 |
| #5 | 44 | 3 | 0.141 | 0.110 | 2.205 | BU451400.5038 |
| #6 | 40 | 3 | 0.141 | 0.110 | 2.205 | BU451400.5039 |
| #8 | 36 | 3 | 0.168 | 0.131 | 2.480 | BU451400.5040 |
| #10 | 32 | 3 | 0.194 | 0.152 | 2.756 | BU451400.5041 |
| #12 | 28 | 3 | 0.220 | 0.165 | 3.150 | BU451400.5042 |
| 1/4 | 28 | 3 | 0.255 | 0.191 | 3.150 | BU451400.5043 |
| 5/16 | 24 | 3 | 0.318 | 0.238 | 3.543 | BU451400.5044 |
| 3/8 | 24 | 4 | 0.381 | 0.286 | 3.937 | BU451400.5045 |
| 7/16 | 20 | 3 | 0.323 | 0.242 | 3.937 | CU451400.5046 |
| 1/2 | 20 | 3 | 0.367 | 0.275 | 3.937 | CU451400.5047 |
| 9/16 | 18 | 3 | 0.429 | 0.322 | 3.937 | CU451400.5048 |
| 5/8 | 18 | 3 | 0.480 | 0.360 | 3.937 | CU451400.5049 |
| 3/4 | 16 | 4 | 0.590 | 0.442 | 4.331 | CU451400.5050 |
| 7/8 | 14 | 4 | 0.697 | 0.523 | 4.921 | CU451400.5051 |
| 1 | 12 | 4 | 0.800 | 0.600 | 5.512 | CU451400.5052 |

For Materials and Speed Recommendations, see page 3.

- GLT-1 Coating
- B / 4-5 Chamfer Length
- 2B and 3B Class of Fit

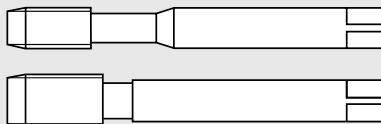


UNC – THROUGH-HOLE

| Size | T.P.I. | # Flutes | Shank Dia. | Square Width | OAL | 2B Class of Fit | 3B Class of Fit |
|-------|--------|----------|------------|--------------|-------|-----------------|-----------------|
| | | | | | | EDP No. | EDP No. |
| #1 | 64 | 2 | 0.141 | 0.110 | 1.772 | BU20C300.5000 | BU20C310.5000 |
| #2 | 56 | 2 | 0.141 | 0.110 | 1.772 | BU20C300.5001 | BU20C310.5001 |
| #3 | 48 | 2 | 0.141 | 0.110 | 1.969 | BU20C300.5002 | BU20C310.5002 |
| #4 | 40 | 2 | 0.141 | 0.110 | 2.205 | BU20C300.5003 | BU20C310.5003 |
| #5 | 40 | 3 | 0.141 | 0.110 | 2.205 | BU20C300.5004 | BU20C310.5004 |
| #6 | 32 | 3 | 0.141 | 0.110 | 2.205 | BU20C300.5005 | BU20C310.5005 |
| #8 | 32 | 3 | 0.168 | 0.131 | 2.480 | BU20C300.5006 | BU20C310.5006 |
| #10 | 24 | 3 | 0.194 | 0.152 | 2.756 | BU20C300.5007 | BU20C310.5007 |
| #12 | 24 | 3 | 0.220 | 0.165 | 3.150 | BU20C300.5008 | BU20C310.5008 |
| 1/4 | 20 | 3 | 0.255 | 0.191 | 3.150 | BU20C300.5009 | BU20C310.5009 |
| 5/16 | 18 | 3 | 0.318 | 0.238 | 3.543 | BU20C300.5010 | BU20C310.5010 |
| 3/8 | 16 | 3 | 0.381 | 0.286 | 3.937 | BU20C300.5011 | BU20C310.5011 |
| 7/16 | 14 | 3 | 0.323 | 0.242 | 3.937 | CU20C300.5012 | CU20C310.5012 |
| 1/2 | 13 | 3 | 0.367 | 0.275 | 4.331 | CU20C300.5013 | CU20C310.5013 |
| 9/16 | 12 | 3 | 0.429 | 0.322 | 4.331 | CU20C300.5014 | CU20C310.5014 |
| 5/8 | 11 | 3 | 0.480 | 0.360 | 4.331 | CU20C300.5015 | CU20C310.5015 |
| 3/4 | 10 | 3 | 0.590 | 0.442 | 4.921 | CU20C300.5016 | CU20C310.5016 |
| 7/8 | 9 | 3 | 0.697 | 0.523 | 5.512 | CU20C300.5017 | CU20C310.5017 |
| 1 | 8 | 3 | 0.800 | 0.600 | 6.299 | CU20C300.5018 | CU20C310.5018 |
| 1 1/8 | 7 | 3 | 0.896 | 0.672 | 7.087 | CU20C300.5019 | CU20C310.5019 |
| 1 1/4 | 7 | 4 | 1.021 | 0.766 | 7.087 | CU20C300.5020 | CU20C310.5020 |
| 1 3/8 | 6 | 4 | 1.108 | 0.831 | 7.874 | CU20C300.5021 | CU20C310.5021 |
| 1 1/2 | 6 | 4 | 1.233 | 0.925 | 7.874 | CU20C300.5022 | CU20C310.5022 |
| 1 3/4 | 5 | 4 | 1.430 | 1.072 | 8.661 | CU20C300.5023 | CU20C310.5023 |
| 2 | 4 1/2 | 4 | 1.644 | 1.233 | 9.843 | CU20C300.5024 | CU20C310.5024 |

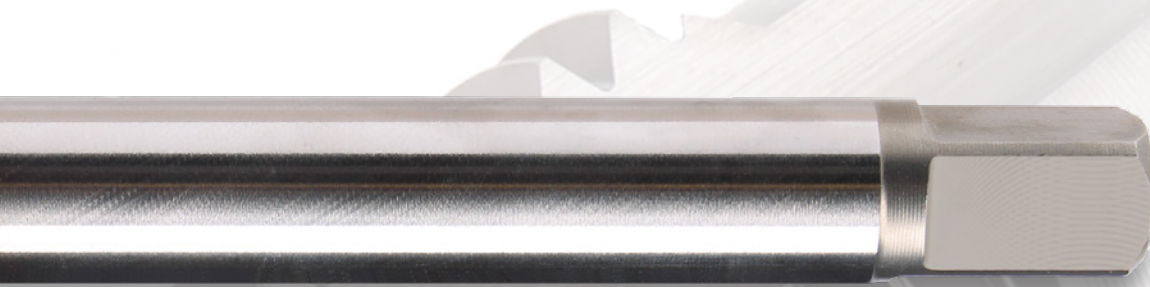
For Materials and Speed Recommendations, see page 3.

DIN
Shank
Type



Reinforced Style:
on tap sizes: 0 – 3/8

Reduced Style:
on tap sizes: 7/16 – 2


UNF – THROUGH-HOLE

| Size | T.P.I. | # Flutes | Shank Dia. | Square Width | OAL | 2B Class of Fit | 3B Class of Fit |
|-------|--------|----------|------------|--------------|-------|----------------------|----------------------|
| | | | | | | EDP No. | EDP No. |
| #0 | 80 | 2 | 0.141 | 0.110 | 1.626 | BU20C300.5033 | BU20C310.5033 |
| #1 | 72 | 2 | 0.141 | 0.110 | 1.772 | BU20C300.5034 | BU20C310.5034 |
| #2 | 64 | 2 | 0.141 | 0.110 | 1.772 | BU20C300.5035 | BU20C310.5035 |
| #3 | 56 | 2 | 0.141 | 0.110 | 1.969 | BU20C300.5036 | BU20C310.5036 |
| #4 | 48 | 2 | 0.141 | 0.110 | 2.205 | BU20C300.5037 | BU20C310.5037 |
| #5 | 44 | 3 | 0.141 | 0.110 | 2.205 | – | BU20C310.5038 |
| #6 | 40 | 3 | 0.141 | 0.110 | 2.205 | BU20C300.5039 | BU20C310.5039 |
| #8 | 36 | 3 | 0.168 | 0.131 | 2.480 | BU20C300.5040 | BU20C310.5040 |
| #10 | 32 | 3 | 0.194 | 0.152 | 2.756 | BU20C300.5041 | BU20C310.5041 |
| #12 | 28 | 3 | 0.220 | 0.165 | 3.150 | – | BU20C310.5042 |
| 1/4 | 28 | 3 | 0.255 | 0.191 | 3.150 | BU20C300.5043 | BU20C310.5043 |
| 5/16 | 24 | 3 | 0.318 | 0.238 | 3.543 | BU20C300.5044 | BU20C310.5044 |
| 3/8 | 24 | 4 | 0.381 | 0.286 | 3.937 | BU20C300.5045 | BU20C310.5045 |
| 7/16 | 20 | 3 | 0.323 | 0.242 | 3.937 | CU20C300.5046 | CU20C310.5046 |
| 1/2 | 20 | 3 | 0.367 | 0.275 | 3.937 | CU20C300.5047 | CU20C310.5047 |
| 9/16 | 18 | 3 | 0.429 | 0.322 | 3.937 | CU20C300.5048 | CU20C310.5048 |
| 5/8 | 18 | 3 | 0.480 | 0.360 | 3.937 | CU20C300.5049 | CU20C310.5049 |
| 3/4 | 16 | 4 | 0.590 | 0.442 | 4.331 | CU20C300.5050 | CU20C310.5050 |
| 7/8 | 14 | 4 | 0.697 | 0.523 | 4.921 | CU20C300.5051 | CU20C310.5051 |
| 1 | 12 | 4 | 0.800 | 0.600 | 5.512 | CU20C300.5052 | CU20C310.5052 |
| 1 1/8 | 12 | 4 | 0.896 | 0.672 | 5.906 | CU20C300.5053 | CU20C310.5053 |
| 1 1/4 | 12 | 4 | 1.021 | 0.766 | 5.906 | CU20C300.5054 | CU20C310.5054 |
| 1 3/8 | 12 | 5 | 1.108 | 0.831 | 6.693 | CU20C300.5055 | CU20C310.5055 |
| 1 1/2 | 12 | 5 | 1.233 | 0.925 | 6.693 | CU20C300.5056 | CU20C310.5056 |

For Materials and Speed Recommendations, see page 3.

- GLT-1 Coating
- C / 2-3 Chamfer Length
- 2B and 3B Class of Fit

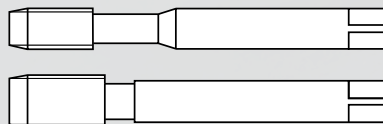


UNC – BLIND-HOLE

| Size | T.P.I. | # Flutes | Shank Dia. | Square Width | OAL | Class of Fit | |
|-------|--------|----------|------------|--------------|-------|----------------------------|----------------------------|
| | | | | | | 2B Class of Fit EDP No. | 3B Class of Fit EDP No. |
| #1 | 64 | 2 | 0.141 | 0.110 | 1.772 | BU50C300.5000 | BU50C310.5000 |
| #2 | 56 | 2 | 0.141 | 0.110 | 1.772 | BU50C300.5001 | BU50C310.5001 |
| #3 | 48 | 2 | 0.141 | 0.110 | 1.969 | - | BU50C310.5002 |
| #4 | 40 | 2 | 0.141 | 0.110 | 2.205 | BU50C300.5003 | BU50C310.5003 |
| #5 | 40 | 3 | 0.141 | 0.110 | 2.205 | BU50C300.5004 | BU50C310.5004 |
| #6 | 32 | 3 | 0.141 | 0.110 | 2.205 | BU50C300.5005 | BU50C310.5005 |
| #8 | 32 | 3 | 0.168 | 0.131 | 2.480 | BU50C300.5006 | BU50C310.5006 |
| #10 | 24 | 3 | 0.194 | 0.152 | 2.756 | BU50C300.5007 | BU50C310.5007 |
| #12 | 24 | 3 | 0.220 | 0.165 | 3.150 | BU50C300.5008 | BU50C310.5008 |
| 1/4 | 20 | 3 | 0.255 | 0.191 | 3.150 | BU50C300.5009 | BU50C310.5009 |
| 5/16 | 18 | 3 | 0.318 | 0.238 | 3.543 | BU50C300.5010 | BU50C310.5010 |
| 3/8 | 16 | 3 | 0.381 | 0.286 | 3.937 | BU50C300.5011 | BU50C310.5011 |
| 7/16 | 14 | 3 | 0.323 | 0.242 | 3.937 | CU50C300.5012 | CU50C310.5012 |
| 1/2 | 13 | 3 | 0.367 | 0.275 | 4.331 | CU50C300.5013 | CU50C310.5013 |
| 9/16 | 12 | 3 | 0.429 | 0.322 | 4.331 | CU50C300.5014 | CU50C310.5014 |
| 5/8 | 11 | 3 | 0.480 | 0.360 | 4.331 | CU50C300.5015 | CU50C310.5015 |
| 3/4 | 10 | 3 | 0.590 | 0.442 | 4.921 | CU50C300.5016 | CU50C310.5016 |
| 7/8 | 9 | 4 | 0.697 | 0.523 | 5.512 | CU50C300.5017 | CU50C310.5017 |
| 1 | 8 | 4 | 0.800 | 0.600 | 6.299 | CU50C300.5018 | CU50C310.5018 |
| 1 1/8 | 7 | 4 | 0.896 | 0.672 | 7.087 | CU50C300.5019 | CU50C310.5019 |
| 1 1/4 | 7 | 4 | 1.021 | 0.766 | 7.087 | CU50C300.5020 | CU50C310.5020 |
| 1 3/8 | 6 | 4 | 1.108 | 0.831 | 7.874 | CU50C300.5021 | CU50C310.5021 |
| 1 1/2 | 6 | 4 | 1.233 | 0.925 | 7.874 | CU50C300.5022 | CU50C310.5022 |
| 1 3/4 | 5 | 5 | 1.430 | 1.072 | 8.661 | CU50C300.5023 | CU50C310.5023 |
| 2 | 4 1/2 | 5 | 1.644 | 1.233 | 9.843 | CU50C300.5024 | - |

For Materials and Speed Recommendations, see page 3.

DIN
Shank
Type



Reinforced Style:
on tap sizes: 0 – 3/8

Reduced Style:
on tap sizes: 7/16 – 2


UNF – BLIND-HOLE

| Size | T.P.I. | # Flutes | Shank Dia. | Square Width | OAL | 2B Class of Fit | 3B Class of Fit |
|-------|--------|----------|------------|--------------|-------|-----------------|-----------------|
| | | | | | | EDP No. | EDP No. |
| #0 | 80 | 2 | 0.141 | 0.110 | 1.626 | BU50C300.5033 | BU50C310.5033 |
| #1 | 72 | 2 | 0.141 | 0.110 | 1.772 | – | BU50C310.5034 |
| #2 | 64 | 2 | 0.141 | 0.110 | 1.772 | BU50C300.5035 | BU50C310.5035 |
| #3 | 56 | 2 | 0.141 | 0.110 | 1.969 | – | BU50C310.5036 |
| #4 | 48 | 2 | 0.141 | 0.110 | 2.205 | BU50C300.5037 | BU50C310.5037 |
| #5 | 44 | 3 | 0.141 | 0.110 | 2.205 | BU50C300.5038 | BU50C310.5038 |
| #6 | 40 | 3 | 0.141 | 0.110 | 2.205 | BU50C300.5039 | BU50C310.5039 |
| #8 | 36 | 3 | 0.168 | 0.131 | 2.480 | BU50C300.5040 | BU50C310.5040 |
| #10 | 32 | 3 | 0.194 | 0.152 | 2.756 | BU50C300.5041 | BU50C310.5041 |
| #12 | 28 | 3 | 0.220 | 0.165 | 3.150 | BU50C300.5042 | BU50C310.5042 |
| 1/4 | 28 | 3 | 0.255 | 0.191 | 3.150 | BU50C300.5043 | BU50C310.5043 |
| 5/16 | 24 | 3 | 0.318 | 0.238 | 3.543 | BU50C300.5044 | BU50C310.5044 |
| 3/8 | 24 | 3 | 0.381 | 0.286 | 3.937 | BU50C300.5045 | BU50C310.5045 |
| 7/16 | 20 | 3 | 0.323 | 0.242 | 3.937 | CU50C300.5046 | CU50C310.5046 |
| 1/2 | 20 | 4 | 0.367 | 0.275 | 3.937 | CU50C300.5047 | CU50C310.5047 |
| 9/16 | 18 | 4 | 0.429 | 0.322 | 3.937 | CU50C300.5048 | CU50C310.5048 |
| 5/8 | 18 | 4 | 0.480 | 0.360 | 3.937 | CU50C300.5049 | CU50C310.5049 |
| 3/4 | 16 | 4 | 0.590 | 0.442 | 4.331 | CU50C300.5050 | CU50C310.5050 |
| 7/8 | 14 | 4 | 0.697 | 0.523 | 4.921 | CU50C300.5051 | CU50C310.5051 |
| 1 | 12 | 4 | 0.800 | 0.600 | 5.512 | CU50C300.5052 | CU50C310.5052 |
| 1 1/8 | 12 | 4 | 0.896 | 0.672 | 5.906 | CU50C300.5053 | CU50C310.5053 |
| 1 1/4 | 12 | 5 | 1.021 | 0.766 | 5.906 | CU50C300.5054 | CU50C310.5054 |
| 1 3/8 | 12 | 5 | 1.108 | 0.831 | 6.693 | CU50C300.5055 | CU50C310.5055 |
| 1 1/2 | 12 | 6 | 1.233 | 0.925 | 6.693 | CU50C300.5056 | CU50C310.5056 |

UN – BLIND-HOLE

| Size | T.P.I. | # Flutes | Shank Dia. | Square Width | OAL | 2B Class of Fit | 3B Class of Fit |
|-------|--------|----------|------------|--------------|-------|-----------------|-----------------|
| | | | | | | EDP No. | EDP No. |
| 1 1/8 | 8 | 4 | 0.896 | 0.672 | 7.087 | – | CU50C310.5247 |
| 1 1/4 | 8 | 4 | 1.021 | 0.766 | 7.087 | – | CU50C310.5249 |
| 1 3/8 | 8 | 5 | 1.108 | 0.831 | 7.874 | – | CU50C310.5251 |
| 1 1/2 | 8 | 5 | 1.233 | 0.925 | 7.874 | – | CU50C310.5253 |
| 1 5/8 | 8 | 5 | 1.305 | 0.979 | 7.874 | – | CU50C310.5255 |
| 1 3/4 | 8 | 6 | 1.430 | 1.072 | 7.874 | – | CU50C310.5257 |
| 1 7/8 | 8 | 6 | 1.519 | 1.139 | 8.858 | – | CU50C310.5259 |
| 2 | 8 | 6 | 1.644 | 1.233 | 8.858 | – | CU50C310.5261 |

For Materials and Speed Recommendations, see page 3.



Spiral Point Plug Taps

Rekord B Steel • B / 4-5 Chamfer Length
TiN Coating • 6H Class of fit

Spiral Flute Bottoming Taps

Rekord D Steel • E / 1.5-2 Chamfer Length
TiN Coating • 6H Class of fit

METRIC – COARSE / THROUGH-HOLE

| Size | T.P.I. | # Flutes | Shank Dia. | Square Width | OAL | EDP No. |
|------|--------|----------|------------|--------------|-----|---------------|
| 2.5 | 0.45 | 2 | 2.8 | 2.1 | 50 | B0208400.0025 |
| 3 | 0.5 | 3 | 3.5 | 2.7 | 56 | B0208400.0030 |
| 4 | 0.7 | 3 | 4.5 | 3.4 | 63 | B0208400.0040 |
| 5 | 0.8 | 3 | 6 | 4.9 | 70 | B0208400.0050 |
| 6 | 1 | 3 | 6 | 4.9 | 80 | B0208400.0060 |
| 8 | 1.25 | 3 | 8 | 6.2 | 90 | B0208400.0080 |
| 10 | 1.5 | 3 | 10 | 8 | 100 | B0208400.0100 |
| 12 | 1.75 | 3 | 9 | 7 | 110 | C0208400.0112 |
| 14 | 2 | 3 | 11 | 9 | 110 | C0208400.0114 |
| 16 | 2 | 3 | 12 | 9 | 110 | C0208400.0116 |
| 18 | 2.5 | 3 | 14 | 11 | 125 | C0208400.0118 |
| 20 | 2.5 | 3 | 16 | 12 | 140 | C0208400.0120 |
| 22 | 2.5 | 3 | 18 | 14.5 | 140 | C0208400.0122 |
| 24 | 3 | 3 | 18 | 14.5 | 160 | C0208400.0124 |

METRIC – COARSE / BLIND-HOLE

| Size | T.P.I. | # Flutes | Shank Dia. | Square Width | OAL | EDP No. |
|------|--------|----------|------------|--------------|-----|---------------|
| 2 | 0.4 | 2 | 2.8 | 2.1 | 45 | B0461400.0020 |
| 2.5 | 0.45 | 2 | 2.8 | 2.1 | 50 | B0461400.0025 |
| 3 | 0.5 | 3 | 3.5 | 2.7 | 56 | B0461400.0030 |
| 4 | 0.7 | 3 | 4.5 | 3.4 | 63 | B0461400.0040 |
| 5 | 0.8 | 3 | 6 | 4.9 | 70 | B0461400.0050 |
| 6 | 1 | 3 | 6 | 4.9 | 80 | B0461400.0060 |
| 8 | 1.25 | 3 | 8 | 6.2 | 90 | B0461400.0080 |
| 10 | 1.5 | 3 | 10 | 8 | 100 | B0461400.0100 |
| 12 | 1.75 | 3 | 9 | 7 | 110 | C0461400.0112 |
| 14 | 2 | 3 | 11 | 9 | 110 | C0461400.0114 |
| 16 | 2 | 3 | 12 | 9 | 110 | C0461400.0116 |
| 18 | 2.5 | 3 | 14 | 11 | 125 | C0461400.0118 |
| 20 | 2.5 | 3 | 16 | 12 | 140 | C0461400.0120 |
| 24 | 3 | 3 | 18 | 14.5 | 160 | C0461400.0124 |

METRIC – FINE / THROUGH-HOLE

| Size | T.P.I. | # Flutes | Shank Dia. | Square Width | OAL | EDP No. |
|-----------|--------|----------|------------|--------------|-----|---------------|
| 4 x 0.5 | 0.5 | 3 | 4.5 | 3.4 | 63 | B0208400.0210 |
| 5 x 0.5 | 0.5 | 3 | 6 | 4.9 | 70 | B0208400.0218 |
| 6 x 0.75 | 0.75 | 3 | 6 | 4.9 | 80 | B0208400.0229 |
| 8 x 0.75 | 0.75 | 3 | 8 | 6.2 | 80 | B0208400.0250 |
| 8 x 1 | 1 | 3 | 8 | 6.2 | 90 | B0208400.0251 |
| 10 x 1 | 1 | 4 | 10 | 8 | 90 | B0208400.0276 |
| 10 x 1.25 | 1.25 | 3 | 10 | 8 | 100 | B0208400.0277 |
| 8 x 0.75 | 0.75 | 3 | 6 | 4.9 | 80 | C0208400.0250 |
| 8 x 1 | 1 | 3 | 6 | 4.9 | 90 | C0208400.0251 |
| 10 x 1 | 1 | 4 | 7 | 5.5 | 90 | C0208400.0276 |
| 10 x 1.25 | 1.25 | 3 | 7 | 5.5 | 100 | C0208400.0277 |
| 12 x 1.5 | 1.5 | 3 | 9 | 7 | 100 | C0208400.0303 |
| 14 x 1.5 | 1.5 | 3 | 11 | 9 | 100 | C0208400.0331 |
| 16 x 1.5 | 1.5 | 3 | 12 | 9 | 100 | C0208400.0359 |
| 18 x 1.5 | 1.5 | 4 | 14 | 11 | 110 | C0208400.0390 |
| 20 x 1.5 | 1.5 | 4 | 16 | 12 | 125 | C0208400.0422 |

METRIC – FINE / BLIND-HOLE

| Size | T.P.I. | # Flutes | Shank Dia. | Square Width | OAL | EDP No. |
|-----------|--------|----------|------------|--------------|-----|---------------|
| 8 x 1 | 1 | 3 | 6 | 4.9 | 90 | C0461400.0251 |
| 10 x 1 | 1 | 3 | 7 | 5.5 | 90 | C0461400.0276 |
| 12 x 1.25 | 1.5 | 3 | 9 | 7 | 100 | C0461400.0303 |
| 14 x 1.5 | 1.5 | 3 | 11 | 9 | 100 | C0461400.0331 |
| 16 x 1.5 | 1.5 | 3 | 12 | 9 | 100 | C0461400.0359 |
| 20 x 1.5 | 1.5 | 4 | 16 | 12 | 125 | C0461400.0422 |
| 22 x 1.5 | 1.5 | 4 | 18 | 14.5 | 125 | C0461400.0438 |

For Materials and Speed Recommendations, see page 3.



Spiral Point Plug Taps

Rekord B VA • B / 4-5 Chamfer Length
GLT-1 Coating • 6H Class of fit

Spiral Flute Semi-Bottoming Taps

Enorm VA • C / 2-3 Chamfer Length
GLT-1 Coating • 6H Class of fit

METRIC – COARSE / THROUGH-HOLE

| Size | T.P.I. | # Flutes | Shank Dia. | Square Width | OAL | EDP No. |
|------|--------|----------|------------|--------------|-----|---------------|
| 2 | 0.4 | 2 | 2.8 | 2.1 | 45 | B020C300.0020 |
| 2.5 | 0.45 | 2 | 2.8 | 2.1 | 50 | B020C300.0025 |
| 3 | 0.5 | 3 | 3.5 | 2.7 | 56 | B020C300.0030 |
| 4 | 0.7 | 3 | 4.5 | 3.4 | 63 | B020C300.0040 |
| 5 | 0.8 | 3 | 6 | 4.9 | 70 | B020C300.0050 |
| 6 | 1 | 3 | 6 | 4.9 | 80 | B020C300.0060 |
| 8 | 1.25 | 3 | 8 | 6.2 | 90 | B020C300.0080 |
| 10 | 1.5 | 3 | 10 | 8 | 100 | B020C300.0100 |
| 12 | 1.75 | 3 | 9 | 7 | 110 | C020C300.0112 |
| 14 | 2 | 3 | 11 | 9 | 110 | C020C300.0114 |
| 16 | 2 | 3 | 12 | 9 | 110 | C020C300.0116 |
| 18 | 2.5 | 3 | 14 | 11 | 125 | C020C300.0118 |
| 20 | 2.5 | 3 | 16 | 12 | 140 | C020C300.0120 |
| 22 | 2.5 | 3 | 18 | 14.5 | 140 | C020C300.0122 |
| 24 | 3 | 3 | 18 | 14.5 | 160 | C020C300.0124 |
| 27 | 3 | 3 | 20 | 16 | 160 | C020C300.0127 |
| 30 | 3.5 | 4 | 22 | 18 | 180 | C020C300.0130 |
| 33 | 3.5 | 4 | 25 | 20 | 180 | C020C300.0133 |
| 36 | 4 | 4 | 28 | 22 | 200 | C020C300.0136 |
| 39 | 4 | 4 | 32 | 24 | 200 | C020C300.0139 |
| 42 | 4.5 | 4 | 32 | 24 | 200 | C020C300.0142 |
| 45 | 4.5 | 4 | 36 | 29 | 220 | C020C300.0145 |
| 48 | 5 | 4 | 36 | 29 | 250 | C020C300.0148 |
| 52 | 5 | 4 | 40 | 32 | 250 | C020C300.0152 |

METRIC – FINE / THROUGH-HOLE

| Size | T.P.I. | # Flutes | Shank Dia. | Square Width | OAL | EDP No. |
|----------|--------|----------|------------|--------------|-----|---------------|
| 8 x 1 | 1 | 3 | 6 | 4.9 | 90 | C020C300.0251 |
| 10 x 1 | 1 | 4 | 7 | 5.5 | 90 | C020C300.0276 |
| 12 x 1.5 | 1.5 | 3 | 9 | 7 | 100 | C020C300.0303 |
| 14 x 1.5 | 1.5 | 3 | 11 | 9 | 100 | C020C300.0331 |
| 16 x 1.5 | 1.5 | 3 | 12 | 9 | 100 | C020C300.0359 |
| 18 x 1.5 | 1.5 | 4 | 14 | 11 | 110 | C020C300.0390 |
| 20 x 1.5 | 1.5 | 4 | 16 | 12 | 125 | C020C300.0422 |

METRIC – COARSE / BLIND-HOLE

| Size | T.P.I. | # Flutes | Shank Dia. | Square Width | OAL | EDP No. |
|------|--------|----------|------------|--------------|-----|---------------|
| 2 | 0.4 | 2 | 2.8 | 2.1 | 45 | B050C300.0020 |
| 2.3 | 0.4 | 2 | 2.8 | 2.1 | 45 | B050C300.0023 |
| 2.5 | 0.45 | 2 | 2.8 | 2.1 | 50 | B050C300.0025 |
| 3 | 0.5 | 3 | 3.5 | 2.7 | 56 | B050C300.0030 |
| 3.5 | 0.6 | 3 | 4 | 3 | 56 | B050C300.0035 |
| 4 | 0.7 | 3 | 4.5 | 3.4 | 63 | B050C300.0040 |
| 5 | 0.8 | 3 | 6 | 4.9 | 70 | B050C300.0050 |
| 6 | 1 | 3 | 6 | 4.9 | 80 | B050C300.0060 |
| 8 | 1.25 | 3 | 8 | 6.2 | 90 | B050C300.0080 |
| 10 | 1.5 | 3 | 10 | 8 | 100 | B050C300.0100 |

METRIC – FINE / BLIND-HOLE

| Size | T.P.I. | # Flutes | Shank Dia. | Square Width | OAL | EDP No. |
|----------|--------|----------|------------|--------------|-----|---------------|
| 4 x 0.5 | 0.5 | 3 | 4.5 | 3.4 | 63 | B050C300.0210 |
| 5 x 0.5 | 0.5 | 3 | 6 | 4.9 | 70 | B050C300.0218 |
| 6 x 0.75 | 0.75 | 3 | 6 | 4.9 | 80 | B050C300.0229 |
| 8 x 1 | 1 | 3 | 6 | 4.9 | 90 | C050C300.0251 |
| 10 x 1 | 1 | 3 | 7 | 5.5 | 90 | C050C300.0276 |
| 12 x 0.5 | 0.5 | 4 | 9 | 7 | 100 | C050C300.0299 |
| 12 x 1 | 1 | 4 | 9 | 7 | 100 | C050C300.0301 |
| 12 x 1.5 | 1.5 | 4 | 9 | 7 | 100 | C050C300.0303 |
| 13 x 1 | 1 | 4 | 11 | 9 | 100 | C050C300.0315 |
| 14 x 1.5 | 1.5 | 4 | 11 | 9 | 100 | C050C300.0331 |
| 16 x 1.5 | 1.5 | 4 | 12 | 9 | 100 | C050C300.0359 |
| 17 x 1 | 1 | 4 | 12 | 9 | 100 | C050C300.0372 |
| 18 x 1.5 | 1.5 | 4 | 14 | 11 | 110 | C050C300.0390 |
| 20 x 1.5 | 1.5 | 4 | 16 | 12 | 125 | C050C300.0422 |

For Materials and Speed Recommendations, see page 3.

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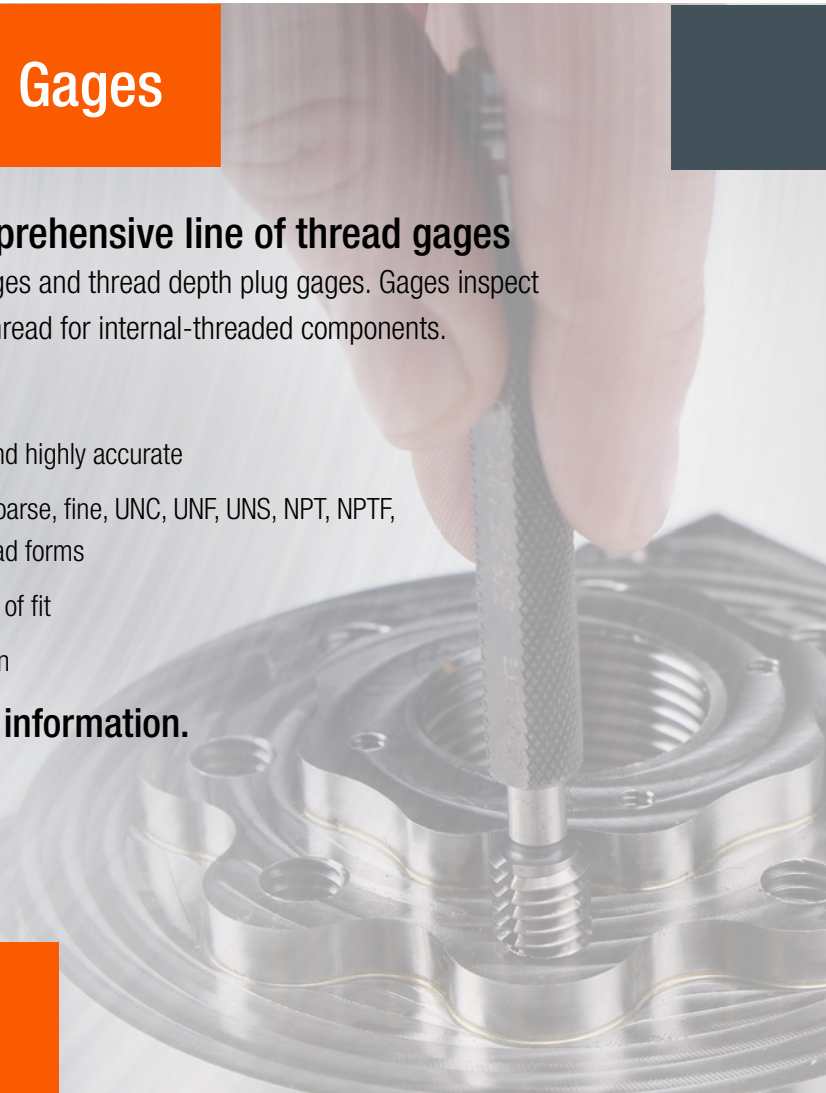
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