

**High-Performance Form Taps for
Steel and Stainless Steel
ADVANCES 2015
Inch**

WIDIA ™

High-Performance HSS-E-PM Victory™ Taps • **WIDIA-GTD™**

Our powdered metal taps deliver highly reliable threads and superior performance in blind and through hole applications. The HP HSS-E-PM is the optimum choice for customers looking for high productivity and long tool life in material-specific applications.

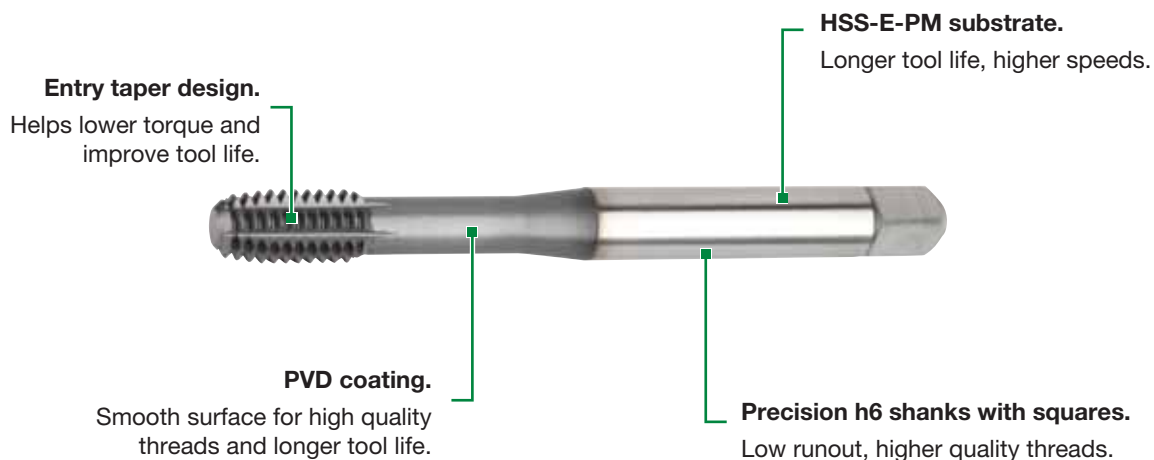


Line Expansion

WIDIA-GTD

- Enhanced design for reliable thread in different materials.
- More resistant to edge chipping than carbide.
- Better performance at high speeds.

High-Performance HSS-E-PM Form Taps for Steel and Stainless Steel



Powdered Metal Taps

- Manufactured from powdered metal high-speed steel coated for thread cutting and thread forming in various applications.
- Offer performance advantages over other regular high-speed steel taps.
- Unmatched by competitive products.

Tap Functions

- High wear resistance and hot hardness without sacrificing edge strength.
- PVD coatings offer outstanding thermal stability, hot hardness, oxidation resistance, and low coefficient of friction.
- Left-hand spiral fluted taps push chips ahead in through holes.
- Optimized spiral flute designs enable deep blind holes to be threaded.
- Straight flute taps store chips in hole or are flushed out with internal coolant.
- Taps can be used in collet and hydraulic holders.
- Low runout of thread and chamfer.

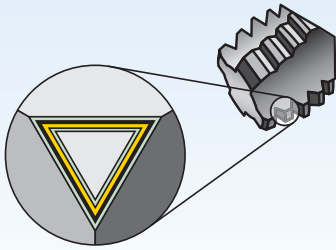
Benefits

- Long tap life at up to 50% higher tapping speed.
- Excellent chip control.
- Reliable performance.
- Exceptional thread quality.



★ Good ★★ Better ★★★ Best	hole		thread		coolant		size range min-max	grade/ coating	material				chamfer		helix angle	dimension
	through	blind	cutting	forming	flood	through			carbide	HSS-E-PM	HSS-E	HSS	type	form		
GT Series High-Performance Taps																
	X	X		X	X		#6-3/4"	WU32MG		X			semi-bottom	C	-	DIN/ANSI
	X	X		X	X		M3-M16	WU32MG		X			semi-bottom	C	-	DIN/ANSI
	X	X		X		X	1/4-3/4"	WU32MG		X			semi-bottom	C	-	DIN/ANSI
	X	X		X		X	M3-M16	WU32MG		X			semi-bottom	C	-	DIN/ANSI
		X		X	X		#0-3/4"	WU32MG		X			bottom	E	-	DIN/ANSI
		X		X	X		M3-M16	WU32MG		X			bottom	E	-	DIN/ANSI
		X		X		X	1/4-3/4"	WU32MG		X			bottom	E	-	DIN/ANSI
		X		X		X	M3-M16	WU32MG		X			bottom	E	-	DIN/ANSI

	P				M	K		N			S				H		page(s)	recommended cutting parameters
	1, 2, 3, 4, 6, 7	5, 9, 10, 11	12, 13.1	13.2	14.1, 14.2, 14.3, 14.4	15, 16	17, 18, 19, 20	21	22, 23, 24, 25	26, 27, 28	31, 32	33, 34, 35	36	37	38.1, 38.2, 40.1, 40.2, 41.1	39.1, 41.2		
	Steel <35 HRC	Steel >36-48 HRC	PH and Ferritic Stainless Steel <35 HRC	PH and Ferritic Stainless Steel >35 HRC	Stainless Steel	Gray Cast Iron	Ductile Cast Iron	Wrought Aluminum	Cast Aluminum	Copper, Copper Alloys	Iron Based	Cobalt Based	Nickel Based	Titanium Alloys	Hardened Steels 49-55 HRC	Hardened Steels 56-68 HRC		
GT Series High-Performance Taps (continued)																		
***				**												7-8	19	
***				**												9	19	
***				**												10-11	19	
***				**												12	19	
***				**												13-14	19	
***				**												15	19	
***				**												16-17	19	
***				**												18	19	



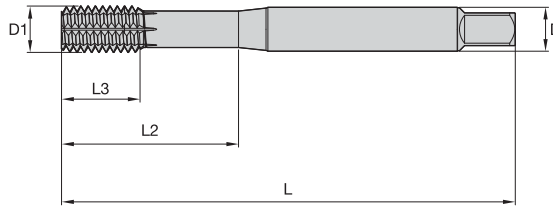
Coatings are designed for optimized tapping performance in specific materials.

P	Steel
M	Stainless Steel
K	Cast Iron
N	Non-Ferrous
S	High-Temp Alloys
H	Hardened Materials

NEW!

Grade	Coating	Grade Description	wear resistance ← → toughness													
			05	10	15	20	25	30	35	40	45					
WU32MG		Coated HSS-E-PM, PVD heat- and wear-resistant high-vanadium cobalt powder metal HSS substrate coated with wear-resistant TiCN base layer.	P													

- WU32MG TiCN for steel and stainless steel.



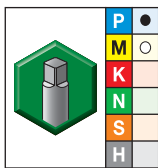
- first choice
- alternate choice

Shank Tolerance

D inch	tolerance h6
.118-.236	+0, -.0003
.236-.394	+0, -.0004
.394-.709	+0, -.0004
.709-1.181	+0, -.0005
1.181-1.969	+0, -.0006



■ GT24 • Form C Semi-Bottoming Entry Taper • Machine Screw and Fractional • DIN Length ANSI Shank



grade WU32MG
TiCN

order #	catalog #	D1 TPI	L	L3	L2	D	number of lube grooves	pitch diameter limit
5944876	GT245001	6 - 32	2.22	.41	.81	.141	2	H3
5944877	GT245002	6 - 32	2.22	.41	.81	.141	2	H5
5944878	GT245003	8 - 32	2.48	.39	.83	.168	4	H3
5944879	GT245004	8 - 32	2.48	.39	.83	.168	4	H5
5944880	GT245005	10 - 24	2.78	.39	1.01	.194	4	H4
5944971	GT245006	10 - 24	2.78	.39	1.01	.194	4	H6
5944972	GT245007	10 - 32	2.77	.39	1.00	.194	4	H4
5944973	GT245008	10 - 32	2.77	.39	1.00	.194	4	H6
5944974	GT245009	1/4 - 20	3.18	.51	1.22	.255	4	H4
5944975	GT245010	1/4 - 20	3.18	.51	1.21	.255	4	H6
5944976	GT245011	1/4 - 28	3.16	.51	1.20	.255	4	H4
5944977	GT245012	1/4 - 28	3.16	.51	1.20	.255	4	H6
5944978	GT245013	5/16 - 18	3.58	.55	1.42	.318	4	H5
5944979	GT245014	5/16 - 18	3.58	.55	1.42	.318	4	H7
5944980	GT245015	5/16 - 24	3.56	.55	1.40	.318	4	H5
5944981	GT245016	5/16 - 24	3.56	.55	1.38	.318	4	H7
5944982	GT245017	3/8 - 16	3.98	.63	1.54	.381	6	H5
5944983	GT245018	3/8 - 16	3.98	.63	1.54	.381	6	H7
5944984	GT245019	3/8 - 24	3.95	.63	1.54	.381	6	H5
5944985	GT245020	3/8 - 24	3.94	.63	1.54	.381	6	H7

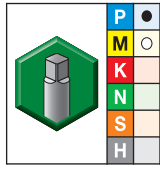
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High-Performance Taps

Victory™ Forming Taps HSS-E-PM • Blind and Through Holes



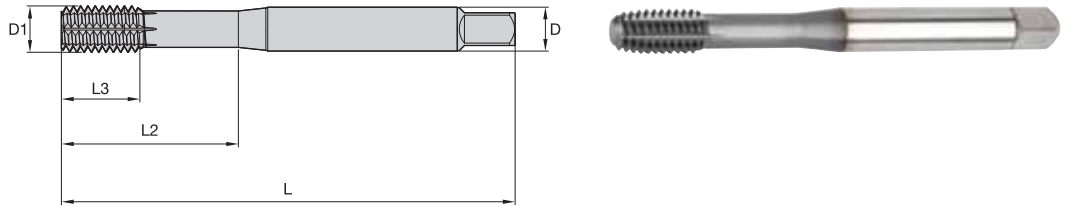
(GT24 • Form C Semi-Bottoming Entry Taper • Machine Screw and Fractional • DIN Length ANSI Shank — continued)



grade WU32MG
TiCN

order #	catalog #	D1 TPI	L	L3	L2	D	number of lube grooves	pitch diameter limit
5944986	GT245021	7/16 - 14	3.94	.71	1.61	.323	6	H5
5944987	GT245022	7/16 - 14	3.94	.71	1.61	.323	6	H7
5944988	GT245023	7/16 - 20	3.94	.71	1.61	.323	6	H5
5944989	GT245024	7/16 - 20	3.94	.71	1.61	.323	6	H7
5944990	GT245025	1/2 - 13	4.33	.79	1.85	.367	6	H5
5945001	GT245026	1/2 - 13	4.33	.79	1.85	.367	6	H7
5945002	GT245027	1/2 - 20	4.33	.79	1.85	.367	6	H5
5945003	GT245028	1/2 - 20	4.33	.79	1.85	.367	6	H7
5945004	GT245029	5/8 - 11	4.33	.91	2.01	.480	6	H7
5945005	GT245030	5/8 - 11	4.33	.91	2.01	.480	6	H10
5945006	GT245031	5/8 - 18	4.33	.91	2.01	.480	6	H7
5945007	GT245032	5/8 - 18	4.33	.91	2.01	.480	6	H10
5945008	GT245033	3/4 - 10	4.92	.98	2.52	.590	6	H7
5945009	GT245034	3/4 - 10	4.92	.98	2.52	.590	6	H10
5945010	GT245035	3/4 - 16	4.92	.98	2.52	.590	6	H7
5945011	GT245036	3/4 - 16	4.92	.98	2.52	.590	6	H10

- WU32MG TiCN for steel and stainless steel.



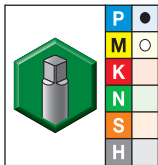
- first choice
- alternate choice

Shank Tolerance

D inch	tolerance h6
.118-.236	+0, -.0003
>.236-.394	+0, -.0004
>.394-.709	+0, -.0004
>.709-1.181	+0, -.0005
>1.181-1.969	+0, -.0006



■ GT24 • Form C Semi-Bottoming Entry Taper • Metric • DIN Length ANSI Shank



grade WU32MG
TiCN

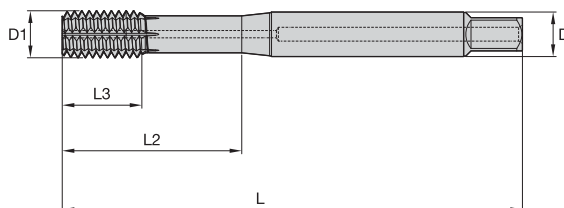
order #	catalog #	D1 TPI	L	L3	L2	D	number of lube grooves	pitch diameter limit
5945012	GT245037	M3 X 0,5	2.22	.39	.80	.141	2	D5
5945013	GT245038	M3,5 X 0,6	2.22	.39	.80	.141	2	D6
5945014	GT245039	M4 X 0,7	2.50	.39	.85	.168	4	D6
5945015	GT245040	M5 X 0,8	2.77	.39	1.00	.194	4	D7
5945016	GT245041	M6 X 1	3.18	.51	1.21	.255	4	D8
5945017	GT245042	M7 X 1	3.18	.51	1.21	.318	4	D9
5945018	GT245043	M8 X 1	3.56	.55	1.39	.318	6	D9
5945019	GT245044	M8 X 1,25	3.57	.55	1.41	.318	6	D9
5945020	GT245045	M10 X 1,25	3.96	.63	1.56	.381	6	D9
5945021	GT245046	M10 X 1,5	3.98	.63	1.57	.381	6	D10
5945022	GT245047	M12 X 1,25	4.33	.71	1.73	.367	6	D9
5945023	GT245048	M12 X 1,5	4.33	.71	1.73	.367	6	D9
5945024	GT245049	M12 X 1,75	4.33	.71	1.73	.367	6	D11
5945025	GT245050	M14 X 1,5	4.33	.79	2.05	.429	6	D11
5945026	GT245051	M14 X 2	4.33	.79	2.05	.429	6	D12
5945027	GT245052	M16 X 1,5	4.33	.79	2.01	.480	6	D11
5945028	GT245053	M16 X 2	4.33	.79	2.01	.480	6	D12

High-Performance Taps

Victory™ Forming Taps HSS-E-PM • Blind and Through Holes



- WU32MG TiCN for steel and stainless steel.



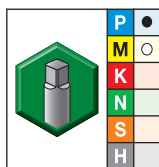
- first choice
- alternate choice

Shank Tolerance

D inch	tolerance h6
.118-.236	+0, -.0003
.236-.394	+0, -.0004
.394-.709	+0, -.0004
.709-1.181	+0, -.0005
1.181-1.969	+0, -.0006



- GT25 • Form C Semi-Bottoming Entry Taper • Through Coolant • Machine Screw and Fractional • DIN Length ANSI Shank



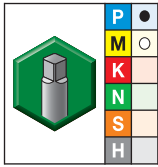
grade WU32MG
TiCN

order #	catalog #	D1 TPI	L	L3	L2	D	number of lube grooves	pitch diameter limit
5945029	GT255001	1/4 - 20	3.15	.51	1.18	.255	4	H4
5945030	GT255002	1/4 - 20	3.15	.51	1.18	.255	4	H6
5945031	GT255003	1/4 - 28	3.15	.51	1.18	.255	4	H4
5945032	GT255004	1/4 - 28	3.15	.51	1.18	.255	4	H6
5945033	GT255005	5/16 - 18	3.54	.55	1.38	.318	6	H5
5945034	GT255006	5/16 - 18	3.54	.55	1.38	.318	6	H7
5945035	GT255007	5/16 - 24	3.54	.55	1.38	.318	6	H5
5945036	GT255008	5/16 - 24	3.54	.55	1.38	.318	6	H7
5945037	GT255009	3/8 - 16	3.94	.63	1.54	.381	6	H5
5945038	GT255010	3/8 - 16	3.94	.63	1.54	.381	6	H7
5945039	GT255011	3/8 - 24	3.94	.63	1.54	.381	6	H5
5945040	GT255012	3/8 - 24	3.94	.63	1.54	.381	6	H7
5945041	GT255013	7/16 - 14	3.94	.71	1.61	.323	6	H5
5945042	GT255014	7/16 - 14	3.94	.71	1.61	.323	6	H7
5945043	GT255015	7/16 - 20	3.94	.71	1.61	.323	6	H5
5945044	GT255016	7/16 - 20	3.94	.71	1.61	.323	6	H7
5945045	GT255017	1/2 - 13	4.33	.79	1.85	.367	6	H5
5945046	GT255018	1/2 - 13	4.33	.79	1.85	.367	6	H7
5945047	GT255019	1/2 - 20	4.33	.79	1.85	.367	6	H5
5945048	GT255020	1/2 - 20	4.33	.79	1.85	.367	6	H7

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(GT25 • Form C Semi-Bottoming Entry Taper • Through Coolant • Machine Screw and Fractional • DIN Length ANSI Shank — continued)



grade WU32MG
TiCN

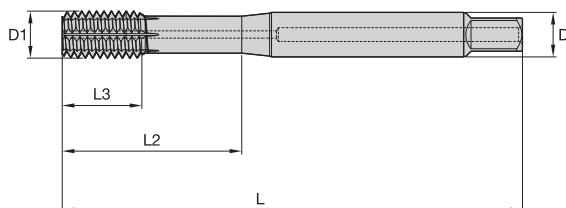
order #	catalog #	D1 TPI	L	L3	L2	D	number of lube grooves	pitch diameter limit
5945049	GT255021	5/8 - 11	4.33	.79	2.01	.480	6	H7
5945050	GT255022	5/8 - 11	4.33	.79	2.01	.480	6	H10
5945051	GT255023	5/8 - 18	4.33	.79	2.01	.480	6	H7
5945052	GT255024	5/8 - 18	4.33	.79	2.01	.480	6	H10
5945053	GT255025	3/4 - 10	4.92	.98	2.52	.590	6	H7
5945054	GT255026	3/4 - 10	4.92	.98	2.52	.590	6	H10
5945055	GT255027	3/4 - 16	4.92	.98	2.52	.590	6	H7
5945056	GT255028	3/4 - 16	4.92	.98	2.52	.590	6	H10

High-Performance Taps

Victory™ Forming Taps HSS-E-PM • Blind and Through Holes



- WU32MG TiCN for steel and stainless steel.



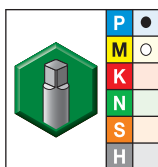
- first choice
- alternate choice

Shank Tolerance

D inch	tolerance h6
.118-.236	+0, -.0003
>.236-.394	+0, -.0004
>.394-.709	+0, -.0004
>.709-1.181	+0, -.0005
>1.181-1.969	+0, -.0006



■ GT25 • Form C Semi-Bottoming Entry Taper • Through Coolant • Metric • DIN Length ANSI Shank

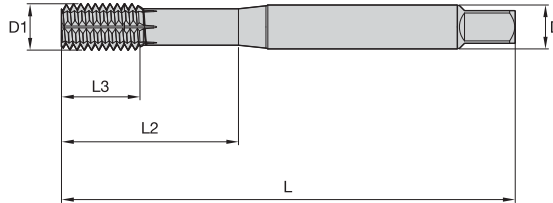


grade WU32MG TiCN

order #	catalog #	D1 TPI	L	L3	L2	D	number of lube grooves	pitch diameter limit
5945057	GT255029	M6 X 1	3.15	.51	1.18	.255	4	D8
5945058	GT255030	M7 X 1	3.15	.51	1.18	.318	4	D9
5945059	GT255031	M8 X 1	3.54	.55	1.38	.318	6	D9
5945060	GT255032	M8 X 1,25	3.54	.55	1.38	.318	6	D9
5945071	GT255033	M10 X 1,25	3.94	.63	1.54	.381	4	D9
5945072	GT255034	M10 X 1,5	3.94	.63	1.54	.381	4	D10
5945073	GT255035	M12 X 1,25	4.33	.71	1.73	.367	6	D9
5945074	GT255036	M12 X 1,5	4.33	.71	1.73	.367	6	D9
5945075	GT255037	M12 X 1,75	4.33	.71	1.73	.367	6	D11
5945076	GT255038	M14 X 1,5	4.33	.79	2.05	.429	6	D11
5945077	GT255039	M14 X 2	4.33	.79	2.05	.429	6	D12
5945078	GT255040	M16 X 1,5	4.33	.79	2.01	.480	6	D11
5945079	GT255041	M16 X 2	4.33	.79	2.01	.480	6	D12



- WU32MG TiCN for steel and stainless steel.



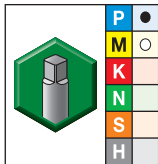
- first choice
- alternate choice

Shank Tolerance

D inch	tolerance h6
.118-.236	+0, -.0003
.236-.394	+0, -.0004
.394-.709	+0, -.0004
.709-1.181	+0, -.0005
1.181-1.969	+0, -.0006



■ GT26 • Form E Bottoming Entry Taper • Machine Screw and Fractional • DIN Length ANSI Shank



grade WU32MG
TiCN

order #	catalog #	D1 TPI	L	L3	L2	D	number of lube grooves	pitch diameter limit
5945080	GT265001	0 - 80	1.69	.31	.38	.141	0	H2
5945091	GT265002	2 - 56	1.81	.44	.51	.141	0	H3
5945092	GT265003	3 - 48	1.98	.39	.72	.141	0	H3
5945093	GT265004	3 - 56	1.98	.39	.72	.141	0	H3
5945094	GT265005	4 - 40	2.22	.39	.72	.141	0	H3
5945095	GT265006	4 - 40	2.22	.39	.72	.141	0	H5
5945096	GT265007	4 - 48	2.22	.39	.72	.141	0	H3
5945097	GT265008	4 - 48	2.21	.39	.72	.141	0	H5
5945098	GT265009	5 - 40	2.22	.39	.81	.141	2	H5
5945099	GT265010	6 - 32	2.23	.39	.81	.141	2	H3
5945100	GT265011	6 - 32	2.22	.39	.81	.141	2	H5
5945101	GT265012	8 - 32	2.50	.39	.85	.168	4	H3
5945102	GT265013	8 - 32	2.50	.39	.85	.168	4	H5
5945103	GT265014	10 - 24	2.78	.39	1.01	.194	4	H4
5945104	GT265015	10 - 24	2.78	.39	1.01	.194	4	H6
5945105	GT265016	10 - 32	2.77	.39	1.00	.194	4	H4
5945106	GT265017	10 - 32	2.77	.39	1.00	.194	4	H6
5945107	GT265018	1/4 - 20	3.18	.51	1.22	.255	4	H4
5945108	GT265019	1/4 - 20	3.18	.51	1.21	.255	4	H6
5945109	GT265020	1/4 - 28	3.16	.51	1.20	.255	4	H4

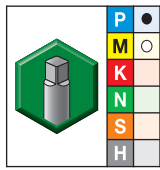
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High-Performance Taps

Victory™ Forming Taps HSS-E-PM • Blind and Through Holes



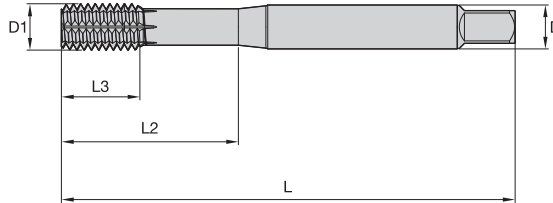
(GT26 • Form E Bottoming Entry Taper • Machine Screw and Fractional • DIN Length ANSI Shank — continued)



grade WU32MG TiCN								
order #	catalog #	D1 TPI	L	L3	L2	D	number of lube grooves	pitch diameter limit
5945110	GT265021	1/4 - 28	3.16	.51	1.20	.255	4	H6
5945111	GT265022	5/16 - 18	3.58	.55	1.42	.318	6	H5
5945112	GT265023	5/16 - 18	3.58	.55	1.42	.318	6	H7
5945113	GT265024	5/16 - 24	3.56	.55	1.40	.318	6	H5
5945114	GT265025	5/16 - 24	3.56	.55	1.40	.318	6	H7
5945115	GT265026	3/8 - 16	3.98	.63	1.58	.381	6	H5
5945116	GT265027	3/8 - 16	3.98	.63	1.58	.381	6	H7
5945117	GT265028	3/8 - 24	3.95	.63	1.55	.381	6	H5
5945118	GT265029	3/8 - 24	3.95	.63	1.55	.381	6	H7
5945119	GT265030	7/16 - 14	3.94	.71	1.61	.323	6	H5
5945120	GT265031	7/16 - 14	3.94	.71	1.61	.323	6	H7
5945121	GT265032	7/16 - 20	3.94	.71	1.61	.323	6	H5
5945122	GT265033	7/16 - 20	3.94	.71	1.61	.323	6	H7
5945123	GT265034	1/2 - 13	4.33	.79	1.85	.367	6	H5
5945124	GT265035	1/2 - 13	4.33	.79	1.85	.367	6	H7
5945125	GT265036	1/2 - 20	4.33	.79	1.85	.367	6	H5
5945126	GT265037	1/2 - 20	4.33	.79	1.85	.367	6	H7
5945127	GT265038	5/8 - 11	4.33	.79	2.01	.480	6	H7
5945128	GT265039	5/8 - 11	4.33	.79	2.01	.480	6	H10
5945129	GT265040	5/8 - 18	4.33	.79	2.01	.480	6	H7
5945130	GT265041	5/8 - 18	4.33	.79	2.01	.480	6	H10
5945131	GT265042	3/4 - 10	4.92	.98	2.52	.590	6	H7
5945132	GT265043	3/4 - 10	4.92	.98	2.52	.590	6	H10
5945133	GT265044	3/4 - 16	4.92	.98	2.52	.590	6	H7
5945134	GT265045	3/4 - 16	4.92	.98	2.52	.590	6	H10



- WU32MG TiCN for steel and stainless steel.



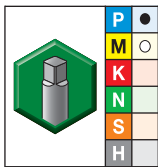
- first choice
- alternate choice

Shank Tolerance

D inch	tolerance h6
.118-.236	+0, -.0003
>.236-.394	+0, -.0004
>.394-.709	+0, -.0004
>.709-1.181	+0, -.0005
>1.181-1.969	+0, -.0006



■ GT26 • Form E Bottoming Entry Taper • Metric • DIN Length ANSI Shank



grade WU32MG
TiCN

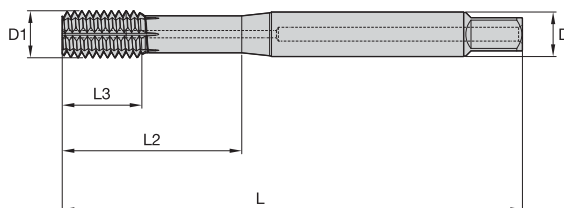
order #	catalog #	D1 TPI	L	L3	L2	D	number of lube grooves	pitch diameter limit
5945135	GT265046	M3 X 0,5	2.22	.39	.80	.141	2	D5
5945136	GT265047	M3,5 X 0,6	2.22	.39	.80	.141	2	D6
5945137	GT265048	M4 X 0,7	2.50	.39	.85	.168	4	D6
5945138	GT265049	M5 X 0,8	2.77	.39	1.00	.194	4	D7
5945139	GT265050	M6 X 1	3.18	.51	1.21	.255	4	D8
5945140	GT265051	M7 X 1	3.18	.51	1.21	.318	4	D9
5945141	GT265052	M8 X 1	3.56	.55	1.39	.318	6	D9
5945142	GT265053	M8 X 1,25	3.57	.55	1.41	.318	6	D9
5945143	GT265054	M10 X 1,25	3.96	.63	1.56	.381	6	D9
5945144	GT265055	M10 X 1,5	3.98	.63	1.57	.381	6	D10
5945145	GT265056	M12 X 1,25	4.33	.71	1.73	.367	6	D9
5945146	GT265057	M12 X 1,5	4.33	.71	1.73	.367	6	D9
5945147	GT265058	M12 X 1,75	4.33	.71	1.73	.367	6	D11
5945148	GT265059	M14 X 1,5	4.33	.79	2.05	.429	6	D11
5945149	GT265060	M14 X 2	4.33	.79	2.05	.429	6	D12
5945150	GT265061	M16 X 1,5	4.33	.79	2.01	.480	6	D11
5945151	GT265062	M16 X 2	4.33	.79	2.01	.480	6	D12

High-Performance Taps

Victory™ Forming Taps HSS-E-PM • Blind and Through Holes



- WU32MG TiCN for steel and stainless steel.



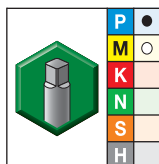
- first choice
- alternate choice

Shank Tolerance

D inch	tolerance h6
.118-.236	+0, -.0003
.236-.394	+0, -.0004
.394-.709	+0, -.0004
.709-1.181	+0, -.0005
1.181-1.969	+0, -.0006



- GT27 • Form E Bottoming Entry Taper • Through Coolant • Machine Screw and Fractional • DIN Length ANSI Shank



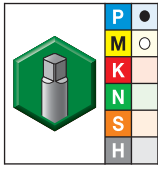
grade WU32MG
TiCN

order #	catalog #	D1 TPI	L	L3	L2	D	number of lube grooves	pitch diameter limit
5944922	GT275001	1/4 - 20	3.15	.51	1.18	.255	4	H4
5944923	GT275002	1/4 - 20	3.15	.51	1.18	.255	4	H6
5944924	GT275003	1/4 - 28	3.15	.51	1.18	.255	4	H4
5944925	GT275004	1/4 - 28	3.15	.51	1.18	.255	4	H6
5944926	GT275005	5/16 - 18	3.54	.55	1.38	.318	6	H5
5944927	GT275006	5/16 - 18	3.54	.55	1.38	.318	6	H7
5944928	GT275007	5/16 - 24	3.54	.55	1.38	.318	6	H5
5944929	GT275008	5/16 - 24	3.54	.55	1.38	.318	6	H7
5944930	GT275009	3/8 - 16	3.94	.63	1.54	.381	6	H5
5945171	GT275010	3/8 - 16	3.94	.63	1.54	.381	6	H7
5945172	GT275011	3/8 - 24	3.94	.63	1.54	.381	6	H5
5945173	GT275012	3/8 - 24	3.94	.63	1.54	.381	6	H7
5945174	GT275013	7/16 - 14	3.94	.71	1.61	.323	6	H5
5945175	GT275014	7/16 - 14	3.94	.71	1.61	.323	6	H7
5945176	GT275015	7/16 - 20	3.94	.71	1.61	.323	6	H5
5945177	GT275016	7/16 - 20	3.94	.71	1.61	.323	6	H7
5945178	GT275017	1/2 - 13	4.33	.79	1.85	.367	6	H5
5945179	GT275018	1/2 - 13	4.33	.79	1.85	.367	6	H7
5945180	GT275019	1/2 - 20	4.33	.79	1.85	.367	6	H5
5945181	GT275020	1/2 - 20	4.33	.79	1.85	.367	6	H7

(continued)



(GT27 • Form E Bottoming Entry Taper • Through Coolant • Machine Screw and Fractional • DIN Length ANSI Shank — continued)



grade WU32MG
TiCN

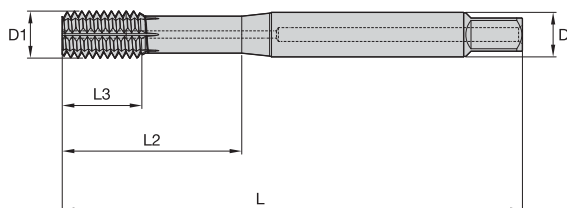
order #	catalog #	D1 TPI	L	L3	L2	D	number of lube grooves	pitch diameter limit
5945182	GT275021	5/8 - 11	4.33	.79	2.01	.480	6	H7
5945183	GT275022	5/8 - 11	4.33	.79	2.01	.480	6	H10
5945184	GT275023	5/8 - 18	4.33	.79	2.01	.480	6	H7
5945185	GT275024	5/8 - 18	4.33	.79	2.01	.480	6	H10
5945186	GT275025	3/4 - 10	4.92	.98	2.52	.590	6	H7
5945187	GT275026	3/4 - 10	4.92	.98	2.52	.590	6	H10
5945188	GT275027	3/4 - 16	4.92	.98	2.52	.590	6	H7
5945189	GT275028	3/4 - 16	4.92	.98	2.52	.590	6	H10

High-Performance Taps

Victory™ Forming Taps HSS-E-PM • Blind and Through Holes



- WU32MG TiCN for steel and stainless steel.



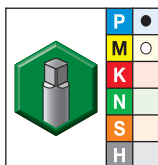
- first choice
- alternate choice

Shank Tolerance

D inch	tolerance h6
.118-.236	+0, -.0003
>.236-.394	+0, -.0004
>.394-.709	+0, -.0004
>.709-1.181	+0, -.0005
>1.181-1.969	+0, -.0006



■ GT27 • Form E Bottoming Entry Taper • Through Coolant • Metric • DIN Length ANSI Shank



grade WU32MG
TiCN

order #	catalog #	D1 TPI	L	L3	L2	D	number of lube grooves	pitch diameter limit
5945190	GT275029	M6 X 1	3.15	.51	1.18	.255	4	D8
5945191	GT275030	M7 X 1	3.15	.51	1.18	.318	4	D9
5945192	GT275031	M8 X 1	3.54	.55	1.38	.318	6	D9
5945193	GT275032	M8 X 1,25	3.54	.55	1.38	.318	6	D9
5945194	GT275033	M10 X 1,25	3.94	.63	1.54	.381	6	D9
5945195	GT275034	M10 X 1,5	3.94	.63	1.54	.381	6	D10
5945196	GT275035	M12 X 1,25	4.33	.71	1.73	.367	6	D9
5945197	GT275036	M12 X 1,5	4.33	.71	1.73	.367	6	D9
5945198	GT275037	M12 X 1,75	4.33	.71	1.73	.367	6	D11
5945199	GT275038	M14 X 1,5	4.33	.79	2.05	.429	6	D11
5945200	GT275039	M14 X 2	4.33	.79	2.05	.429	6	D12
5945211	GT275040	M16 X 1,5	4.33	.79	2.01	.480	6	D11
5945212	GT275041	M16 X 2	4.33	.79	2.01	.480	6	D12



■ HSS-E-PM Taps • Metric

		 Through Holes					 Blind Holes				
		Range – m/min					Range – m/min				
Material Group	VDI 3323	Tap Style	Grade	min	Starting Value	max	Tap Style	Grade	min	Starting Value	max
P	1	GT24	WU32MG	20	30	45	GT24, GT26	WU32MG	14	21	32
	2, 3, 4, 5	GT24	WU32MG	17	25	38	GT24, GT26	WU32MG	12	18	26
M	14.1, 14.3	GT24	WU32MG	5	8	12	GT24, GT26	WU32MG	4	6	8

■ HSS-E-PM Taps • Inch

		 Through Holes					 Blind Holes				
		Range – SFM					Range – SFM				
Material Group	VDI 3323	Tap Style	Grade	min	Starting Value	max	Tap Style	Grade	min	Starting Value	max
P	1	GT24	WU32MG	70	100	150	GT24, GT26	WU32MG	50	70	100
	2, 3, 4, 5	GT24	WU32MG	50	80	120	GT24, GT26	WU32MG	40	60	90
M	14.1, 14.3	GT24	WU32MG	20	30	40	GT24, GT26	WU32MG	10	20	30

High-Performance Form Taps for Steel and Stainless Steel

ADVANCES 2015

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