

**NEW!**

# EMUGE

# AHB

TOOLING & MACHINERY, INC.

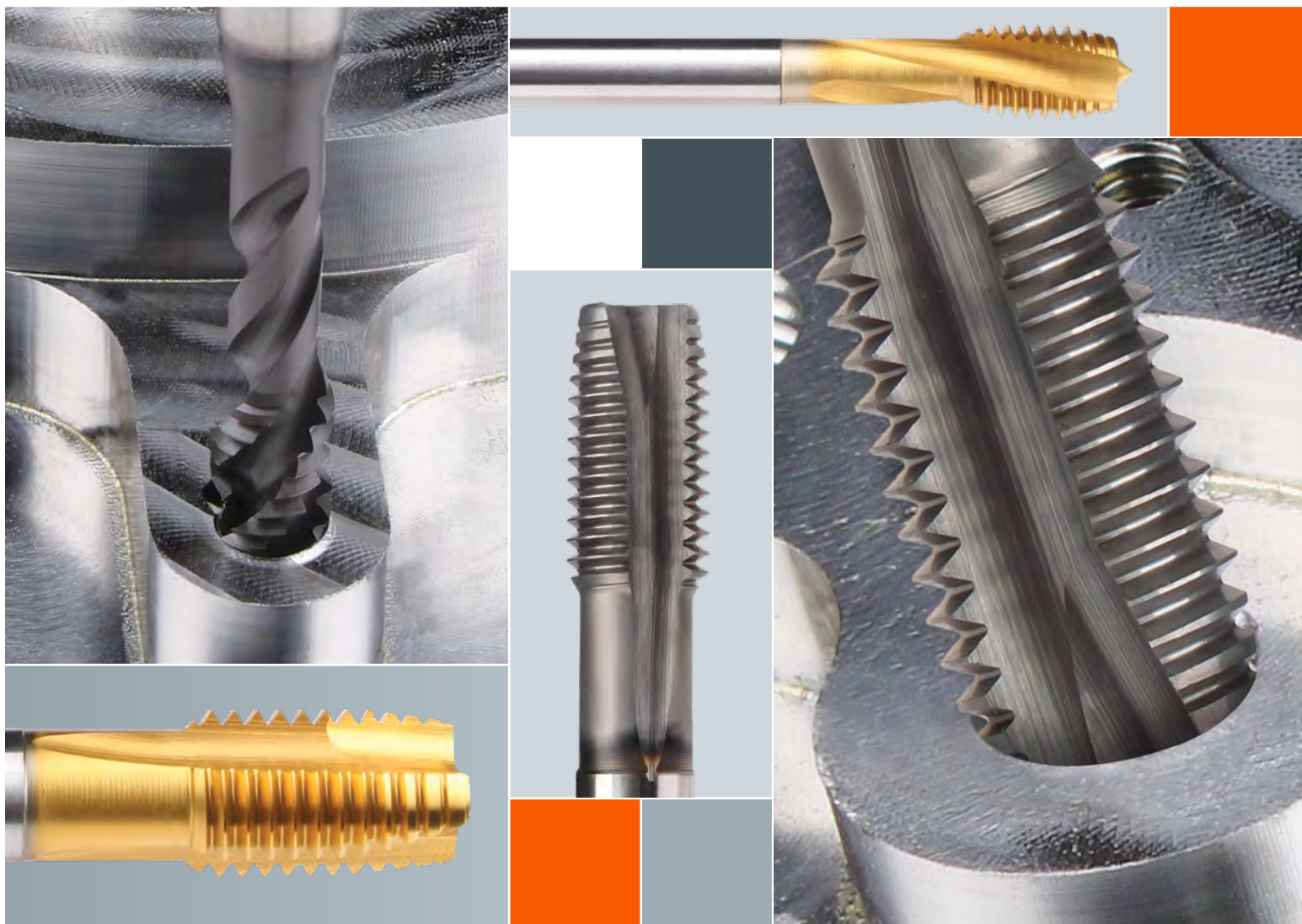
COMPLETE METALWORKING SOLUTIONS

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## 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](http://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 <sup>2</sup>		
<b>Steel materials</b>						
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	<b>BU208400.5002</b>
#4	40	2	0.141	0.110	2.205	<b>BU208400.5003</b>
#5	40	3	0.141	0.110	2.205	<b>BU208400.5004</b>
#6	32	3	0.141	0.110	2.205	<b>BU208400.5005</b>
#8	32	3	0.168	0.131	2.480	<b>BU208400.5006</b>
#10	24	3	0.194	0.152	2.756	<b>BU208400.5007</b>
#12	24	3	0.220	0.165	3.150	<b>BU208400.5008</b>
1/4	20	3	0.255	0.191	3.150	<b>BU208400.5009</b>
5/16	18	3	0.318	0.238	3.543	<b>BU208400.5010</b>
3/8	16	3	0.381	0.286	3.937	<b>BU208400.5011</b>
7/16	14	3	0.323	0.242	3.937	<b>CU208400.5012</b>
1/2	13	3	0.367	0.275	3.937	<b>CU208400.5013</b>
9/16	12	3	0.429	0.322	3.937	<b>CU208400.5014</b>
5/8	11	3	0.480	0.360	3.937	<b>CU208400.5015</b>
3/4	10	3	0.590	0.442	4.331	<b>CU208400.5016</b>
7/8	9	3	0.697	0.523	4.921	<b>CU208400.5017</b>
1	8	3	0.800	0.600	5.512	<b>CU208400.5018</b>
1 1/8	7	3	0.896	0.672	5.906	<b>CU208400.5019</b>
1 1/4	7	4	1.021	0.766	5.906	<b>CU208400.5020</b>
1 3/8	6	4	1.108	0.831	6.693	<b>CU208400.5021</b>
1 1/2	6	4	1.233	0.925	6.693	<b>CU208400.5022</b>
1 3/4	5	4	1.430	1.072	8.661	<b>CU208400.5023</b>
2	4 1/2	4	1.644	1.233	9.843	<b>CU208400.5024</b>

### UNF – THROUGH-HOLE

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

For Materials and Speed Recommendations, see page 3.

DIN Shank Type

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

DIN Shank Type

**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	<b>BU451400.5000</b>
#2	56	2	0.141	0.110	1.772	<b>BU451400.5001</b>
#3	48	2	0.141	0.110	1.969	<b>BU451400.5002</b>
#4	40	2	0.141	0.110	2.205	<b>BU451400.5003</b>
#5	40	2	0.141	0.110	2.205	<b>BU451400.5004</b>
#6	32	3	0.141	0.110	2.205	<b>BU451400.5005</b>
#8	32	3	0.168	0.131	2.480	<b>BU451400.5006</b>
#10	24	3	0.194	0.152	2.756	<b>BU451400.5007</b>
#12	24	3	0.220	0.165	3.150	<b>BU451400.5008</b>
1/4	20	3	0.255	0.191	3.150	<b>BU451400.5009</b>
5/16	18	3	0.318	0.238	3.543	<b>BU451400.5010</b>
3/8	16	3	0.381	0.286	3.937	<b>BU451400.5011</b>
7/16	14	3	0.323	0.242	3.937	<b>CU451400.5012</b>
1/2	13	3	0.367	0.275	4.331	<b>CU451400.5013</b>
9/16	12	3	0.429	0.322	4.331	<b>CU451400.5014</b>
5/8	11	3	0.480	0.360	4.331	<b>CU451400.5015</b>
3/4	10	3	0.590	0.442	4.921	<b>CU451400.5016</b>
7/8	9	3	0.697	0.523	5.512	<b>CU451400.5017</b>
1	8	3	0.800	0.600	6.299	<b>CU451400.5018</b>
1 1/8	7	3	0.896	0.672	7.087	<b>CU451400.5019</b>
1 1/4	7	4	1.021	0.766	7.087	<b>CU451400.5020</b>

**UNF – BLIND-HOLE**

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

For Materials and Speed Recommendations, see page 3.

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

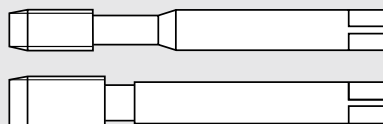


### UNC – THROUGH-HOLE

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

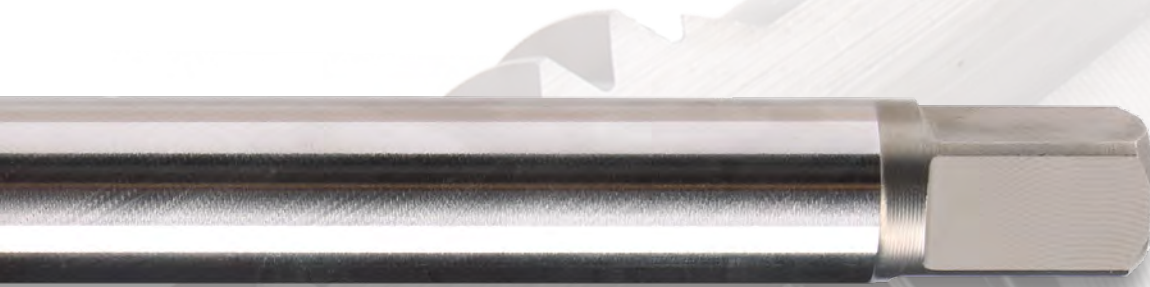
For Materials and Speed Recommendations, see page 3.

DIN  
Shank  
Type



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

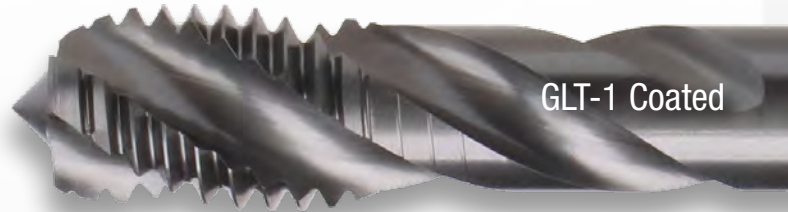
**Reduced Style:**  
on tap sizes: 7/16 – 2


**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	<b>BU20C300.5033</b>	<b>BU20C310.5033</b>
#1	72	2	0.141	0.110	1.772	<b>BU20C300.5034</b>	<b>BU20C310.5034</b>
#2	64	2	0.141	0.110	1.772	<b>BU20C300.5035</b>	<b>BU20C310.5035</b>
#3	56	2	0.141	0.110	1.969	<b>BU20C300.5036</b>	<b>BU20C310.5036</b>
#4	48	2	0.141	0.110	2.205	<b>BU20C300.5037</b>	<b>BU20C310.5037</b>
#5	44	3	0.141	0.110	2.205	–	<b>BU20C310.5038</b>
#6	40	3	0.141	0.110	2.205	<b>BU20C300.5039</b>	<b>BU20C310.5039</b>
#8	36	3	0.168	0.131	2.480	<b>BU20C300.5040</b>	<b>BU20C310.5040</b>
#10	32	3	0.194	0.152	2.756	<b>BU20C300.5041</b>	<b>BU20C310.5041</b>
#12	28	3	0.220	0.165	3.150	–	<b>BU20C310.5042</b>
1/4	28	3	0.255	0.191	3.150	<b>BU20C300.5043</b>	<b>BU20C310.5043</b>
5/16	24	3	0.318	0.238	3.543	<b>BU20C300.5044</b>	<b>BU20C310.5044</b>
3/8	24	4	0.381	0.286	3.937	<b>BU20C300.5045</b>	<b>BU20C310.5045</b>
7/16	20	3	0.323	0.242	3.937	<b>CU20C300.5046</b>	<b>CU20C310.5046</b>
1/2	20	3	0.367	0.275	3.937	<b>CU20C300.5047</b>	<b>CU20C310.5047</b>
9/16	18	3	0.429	0.322	3.937	<b>CU20C300.5048</b>	<b>CU20C310.5048</b>
5/8	18	3	0.480	0.360	3.937	<b>CU20C300.5049</b>	<b>CU20C310.5049</b>
3/4	16	4	0.590	0.442	4.331	<b>CU20C300.5050</b>	<b>CU20C310.5050</b>
7/8	14	4	0.697	0.523	4.921	<b>CU20C300.5051</b>	<b>CU20C310.5051</b>
1	12	4	0.800	0.600	5.512	<b>CU20C300.5052</b>	<b>CU20C310.5052</b>
1 1/8	12	4	0.896	0.672	5.906	<b>CU20C300.5053</b>	<b>CU20C310.5053</b>
1 1/4	12	4	1.021	0.766	5.906	<b>CU20C300.5054</b>	<b>CU20C310.5054</b>
1 3/8	12	5	1.108	0.831	6.693	<b>CU20C300.5055</b>	<b>CU20C310.5055</b>
1 1/2	12	5	1.233	0.925	6.693	<b>CU20C300.5056</b>	<b>CU20C310.5056</b>

For Materials and Speed Recommendations, see page 3.

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

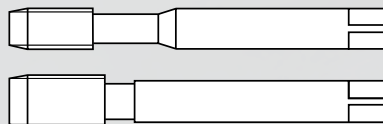


**UNC – BLIND-HOLE**

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.

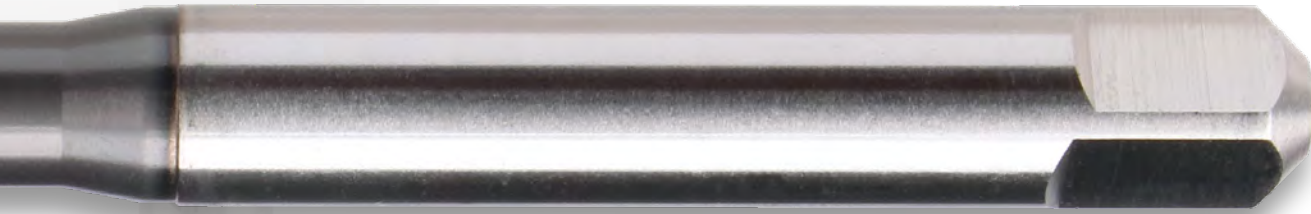
DIN  
Shank  
Type



**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

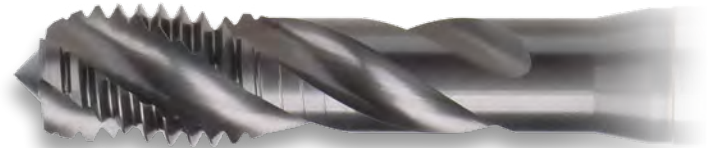
### METRIC – FINE / THROUGH-HOLE

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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