

HIGH SPEED STEEL / GROUND THREAD  
SPIRAL POINTED GUN TAPS

PLUG STYLE

SERIES 6:



Size	TPI	No. of Flutes	GH Limit	Order No.	Price
0	80	2	H1	1050080	
1	64	2	H1	1050164	
1	72	2	H1	1050172	
2	56	2	H2	1050256	
2	64	2	H2	1050264	
3	48	2	H2	1050348	
3	56	2	H2	1050356	
4	40	2	H2	1050440	
4	48	2	H2	1050448	
5	40	2	H2	1050540	
5	44	2	H2	1050544	
6	32	2	H3	1050632	
6	40	2	H2	1050640	
8	32	2	H3	1050832	
8	36	2	H2	1050836	
10	24	2	H3	1051024	
10	32	2	H3	1051032	
12	24	2	H3	1051224	
12	28	2	H3	1051228	
1/4	20	2	H3	1051620	
1/4	28	2	H3	1051628	
5/16	18	2	H3	1052018	
5/16	24	2	H3	1052024	
3/8	16	3	H3	1052416	
3/8	24	3	H3	1052424	
7/16	14	3	H3	1052814	
7/16	20	3	H3	1052820	
1/2	13	3	H3	1053213	
1/2	20	3	H3	1053220	
9/16	12	3	H3	1053612	
9/16	18	3	H3	1053618	
5/8	11	3	H3	1054011	
5/8	18	3	H3	1054018	
3/4	10	3	H3	1054810	
3/4	16	3	H3	1054816	
7/8	9	3	H4	1055609	
7/8	14	3	H4	1055614	
1	8	3	H4	1056408	
1	12	3	H4	1056412	
1	14	3	H4	1056414	

HIGH SPEED STEEL / GROUND THREAD  
SPIRAL POINTED GUN TAPS

PLUG STYLE

SERIES 549: STAR USA

SERIES 919: VERMONT TAP & DIE



Size	T.P.I	No. of Flutes	Ground Thread Limit*	USA		Vermont Tap & Die	
				Order No.	Price	Order No.	Price
0	80	2	H1	1060080		356002	
1	64	2	H1	1060164		356043	
1	72	2	H1	1060172		356084	
2	56	2	H2	1060256		356142	
2	64	2	H2	1060264		356183	
3	48	2	H2	1060348		356225	
3	56	2	H2	1060356		356266	
4	40	2	H2	1060440		356324	
4	48	2	H2	1060448		356365	
5	40	2	H2	1060540		356407	
5	44	2	H2	1060544		356419	
6	32	2	H3	1060632		356506	
6	40	2	H2	1060640		356548	
8	32	2	H3	1060832		356633	
8	36	2	H2	1060836		356647	
10	24	2	H3	1061024		356704	
10	32	2	H3	1061031		356761	
12	24	2	H3	1061224		356803	
12	28	2	H3	1061228		356845	
1/4	20	2	H3	1061620		357041	
1/4	28	2	H3	1061628		357165	
5/16	18	2	H3	1062018		357280	
5/16	24	2	H3	1062024		357405	
3/8	16	3	H3	1062416		357520	
3/8	24	3	H3	1062424		357603	
7/16	14	3	H3	1062814		357686	
7/16	20	3	H3	1062820		357769	
1/2	13	3	H3	1063213		357827	
1/2	20	3	H3	1063220		357868	
9/16	12	3	H3	1063612		-	
9/16	18	3	H3	1063618		-	
5/8	11	3	H3	1064011		357926	
5/8	18	3	H3	1064018		357942	
3/4	10	3	H3	1064810		357967	
3/4	16	3	H3	1064816		-	

\* Other "Ground Thread Limits" including .002 & .005 oversize available in Vermont Tap & Die; please inquire.

SOLID CARBIDE / GROUND THREAD  
SPIRAL POINTED GUN TAPS

PLUG STYLE

SERIES 819:



Size	T.P.I	No. of Flutes	Ground Threads Limit	Order No.	Price
4	40	2	H2	8190440	
6	32	2	H3	8190632	
8	32	2	H3	8190832	
10	24	2	H3	8191024	
10	32	2	H3	8191032	
1/4	20	2	H3	8191620	
5/16	18	2	H3	8192018	
3/8	16	2	H3	8192416	

HIGH SPEED STEEL / SPECIAL THREAD  
SPIRAL POINTED GUN TAPS

PLUG STYLE

SERIES 820:



Size	T.P.I	No. of Flutes	Ground Thread Limit	Order No.	Price
6	48	2	H3	8200648	
8	40	2	H3	8200840	
10	40	2	H3	8201040	
12	32	2	H3	8201232	
1/4	24	2	H3	8201624	
1/4	32	2	H3	8201632	
1/4	40	2	H3	8201640	
5/16	32	3	H3	8202032	
3/8	32	3	H3	8202432	
1/2	24	3	H3	8203224	
1/2	28	3	H3	8203228	

**HIGH SPEED STEEL / GROUND THREAD  
SPIRAL POINTED GUN TAPS  
PLUG STYLE - GOLD (TIN) COATED  
SERIES 817 :**



Size	T.P.I	No. of Flutes	Ground Threads Limit	Order No.	Price	Size	T.P.I	No. of Flutes	Ground Threads Limit	Order No.	Price
0	80	2	H1	8170080		1/4	20	2	H3	8171620	
1	64	2	H1	8170164		1/4	28	2	H3	8171628	
1	72	2	H1	8170172		5/16	18	2	H3	8172018	
2	56	2	H2	8170256		5/16	24	2	H3	8172024	
2	64	2	H2	8170264		3/8	16	3	H3	8172416	
3	48	2	H2	8170348		3/8	24	3	H3	8172424	
3	56	2	H2	8170356		7/16	14	3	H3	8172814	
4	40	2	H2	8170440		7/16	20	3	H3	8172820	
4	48	2	H2	8170448		1/2	13	3	H3	8173213	
5	40	2	H2	8170540		1/2	20	3	H3	8173220	
5	44	2	H2	8170544		5/8	11	3	H3	8174011	
6	32	2	H3	8170632		5/8	18	3	H3	8174018	
6	40	2	H2	8170640		3/4	10	3	H3	8174810	
8	32	2	H3	8170832		3/4	16	3	H3	8174816	
8	36	2	H2	8170836		7/8	9	3	H4	8175609	
10	24	2	H3	8171024		7/8	14	3	H4	8175614	
10	32	2	H3	8171032		1	8	3	H4	8176408	
12	24	2	H3	8171224		1	12	3	H4	8176412	
12	28	2	H3	8171228		1	14	3	H4	8176414	

**HIGH SPEED / GROUND THREAD  
SPIRAL POINTED GUN TAPS  
BOTTOMING STYLE  
SERIES 919: VERMONT TAP & DIE ‡**



**HIGH SPEED STEEL / GROUND THREAD  
SPIRAL POINTED GUN TAPS  
PLUG STYLE - GOLD (TIN) COATED  
SERIES 919: VERMONT TAP & DIE**



Size	T.P.I.	No. of Flutes	Ground Thread Limit*	Order No.	Price
0	80	2	H1	356019	
2	56	2	H2	356159	
3	48	2	H2	356233	
4	40	2	H2	356332	
5	40	2	H2	356415	
6	32	2	H3	356514	
6	40	2	H2	356555	
8	32	2	H3	356634	
10	24	2	H3	356712	
10	32	2	H3	356779	
1/4	20	2	H3	357058	
1/4	28	2	H3	357173	
5/16	18	2	H3	357298	
5/16	24	2	H3	357413	

Size	T.P.I	No. of Flutes	Ground Thread Limit*	Order No.	Price
0	80	2	H1	356023	
1	72	2	H1	356106	
2	56	2	H2	356148	
2	64	2	H2	356189	
3	48	2	H2	356221	
3	56	2	H2	356262	
4	40	2	H2	356320	
4	48	2	H2	356361	
5	40	2	H2	356403	
5	44	2	H2	356402	
6	32	2	H3	356502	
6	40	2	H2	356544	
8	32	2	H3	356602	
10	24	2	H3	356703	
10	32	2	H3	356767	
12	24	2	H3	356809	
12	28	2	H3	356841	
1/4	20	2	H3	357047	
1/4	28	2	H3	357161	
5/16	18	2	H3	357286	
5/16	24	2	H3	357401	
3/8	16	3	H3	357526	
3/8	24	3	H3	357609	
7/16	14	3	H3	357682	
7/16	20	3	H3	357765	
1/2	13	3	H3	357823	
1/2	20	3	H3	357864	
5/8	11	3	H3	357922	
3/4	10	3	H3	357963	

\* Other "Ground Thread Limits" including .002 & .005 oversize available; please inquire.

‡ Available Gold (TIN) Coated; please inquire.

\* Other "Ground Thread Limits" including .002 & .005 oversize available; please inquire.

**Quality Cutting Tools**



**The Choice Is Yours!!!**

HIGH SPEED STEEL / GROUND THREAD  
METRIC SPIRAL POINTED GUN TAPS  
SERIES 556:



HIGH SPEED STEEL / GROUND THREAD  
METRIC SPIRAL  
POINTED GUN TAPS  
SERIES 824: VERMONT TAP & DIE



Size mm	Pitch mm	Order No.	Price	Size mm	Pitch mm	Order No.	Price
1.6	.35	5561635		10.0	1.00	5561010	
1.8	.35	5561835		10.0	1.25	5561012	
2.0	.40	5562040		10.0	1.50	5561015	
2.2	.45	5562245		12.0	1.00	5561210	
2.5	.45	5562545		12.0	1.25	5561212	
3.0	.50	5563050		12.0	1.50	5561215	
3.5	.60	5563560		12.0	1.75	5561217	
4.0	.70	5564070		14.0	1.00	5561410	
4.5	.75	5564575		14.0	1.25	5561412	
5.0	.50	5565050		14.0	1.50	5561415	
5.0	.80	5565080		14.0	2.00	5561420	
5.0	.90	5565090		16.0	1.00	5561610	
6.0	.50	5566050		16.0	1.50	5561615	
6.0	.75	5566075		16.0	2.00	5561620	
6.0	1.00	5566010		18.0	1.00	5561810	
6.3	1.00	5566310		18.0	1.50	5561815	
7.0	1.00	5567010		18.0	2.00	5561820	
8.0	.75	5568075		18.0	2.50	5561825	
8.0	1.00	5568010		20.0	1.00	5562010	
8.0	1.25	5568012		20.0	1.50	5562015	
9.0	1.0	5569010		20.0	2.50	5562025	

Size mm	Pitch mm	Pitch Dia. Limit	No. of Flutes	Order No.	Price
1.6	.35	D3	2	360755	
2.0	.40	D3	2	360771	
2.5	.45	D3	2	360797	
3.0	.50	D3	2	360805	
3.5	.60	D4	2	360821*	
4.0	.70	D4	2	360839*	
4.5	.75	D4	2	360854	
5.0	.80	D4	2	360862*	
6.0	1.00	D5	2	360888*	
6.3	1.00	D5	2	360896	
7.0	1.00	D5	2	360904	
8.0	1.25	D5	2	360920	
10.0	1.50	D6	3	360946*	
12.0	1.75	D6	3	360961*	
14.0	2.00	D7	3	360995	
16.0	2.00	D7	3	361019	
18.0	2.50	D7	3	361035	
20.0	2.50	D7	3	361050	

\* Available Gold (TIN) Coated; please inquire.

HIGH SPEED STEEL / GROUND THREAD  
+.005" OVERSIZE SPIRAL  
POINTED GUN TAPS  
PLUG STYLE  
SERIES 8:



HIGH SPEED STEEL / GROUND THREAD  
LEFT HAND SPIRAL POINTED GUN TAPS  
SERIES 830:



Size	Threads Per Inch	Order No.	Price
6	32	1150632	
8	32	1150832	
10	24	1151024	
10	32	1151032	
1/4	20	1151620	
1/4	28	1151628	
5/16	18	1152018	
5/16	24	1152024	
3/8	16	1152416	
3/8	24	1152424	
7/16	14	1152814	
7/16	20	1152820	
1/2	13	1153213	
1/2	20	1153220	
5/8	11	1154011	
5/8	18	1154018	
3/4	10	1154810	
3/4	16	1154816	
7/8	9	1155609	
7/8	14	1155614	
1	8	1156408	
1	12	1156412	
1	14	1156414	



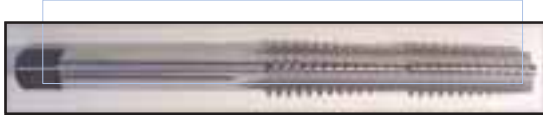
Size	Threads Per Inch	Order No.	Price
4	40	8300440	
5	40	8300540	
6	32	8300632	
8	32	8300832	
10	24	8301024	
10	32	8301032	
1/4	20	8301620	
5/16	18	8302018	
3/8	16	8302416	
1/2	13	8303213	

SEE PAGES 186 - 189  
FOR RELATED ITEMS



- TAP WRENCHES
- TAP GUIDES
- TAP EXTRACTORS

**HIGH SPEED STEEL / GROUND THREAD  
ACME TAPS - TANDEM STYLE  
SERIES 554:**



Size	TPI	Thread Length	Overall Length	Order No.	Price
1/2	10	2-9/16	5	5543210	
5/8	8	3-3/16	6-1/4	5544008	
3/4	6	4-5/16	7-15/16	5544806	
7/8	6	4-3/8	8-5/8	5545606	
1	5	5-1/4	10-1/8	5546405	
1-1/8	5	5-1/4	10-3/4	5547205	
1-1/4	5	5-1/4	11-1/8	5548005	
1-3/8	4	5-7/8	12-1/4	5548804	
1-1/2	4	5-7/8	12-5/8	5549604	

**HIGH SPEED STEEL / GROUND THREAD  
SPIRAL POINTED GUN  
PULLEY TAPS  
SERIES 552:**



**OVERALL LENGTH: 6"  
PLUG STYLE GROUND THREAD LIMIT: GH3**



Size	Threads Per Inch	No. of Flutes	Order No.	Price
10	24	2	5521024	
10	32	2	5521032	
1/4	20	2	5521620	
1/4	28	2	5521628	
5/16	18	2	5522018	
5/16	24	2	5522024	
3/8	16	3	5522416	
3/8	24	3	5522424	
1/2	13	3	5523213	
1/2	20	3	5523220	

**HIGH SPEED STEEL / GROUND THREAD  
EXTENSION SPIRAL  
POINT TAPS  
SERIES 922: VERMONT TAP & DIE  
OAL: 6", GROUND THREAD LIMIT: GH3  
PLUG STYLE**



Size	Threads Per Inch	No. of Flutes	Order No.	Price
6	32	2	918930	
8	32	2	918932	
10	24	2	918934	
10	32	2	918935	
1/4	20	2	918936	
1/4	28	2	918937	
5/16	18	2	918938	
5/16	24	2	918939	
3/8	16	3	918940	
3/8	24	3	918941	

**HIGH SPEED STEEL / GROUND THREAD  
LONG SPIRAL POINTED  
GUN TAPS  
SERIES 553:  
OVERALL LENGTH: 6"  
GROUND THREAD LIMIT: GH3**



Long undercut shanks provide deeper reach and smoother chip flow.

Size	Threads Per Inch	Order No.	Price
4*	40	5530440	
6	32	5530632	
8	32	5530832	
10	24	5531024	
10	32	5531032	
1/4	20	5531620	
1/4	28	5531628	
5/16	18	5532018	
5/16	24	5532024	
3/8	16	5532416	
3/8	24	5532423	
7/16	14	5532814	
7/16	20	5532820	
1/2	13	5533213	
1/2	20	5533220	



\* Overall Length: 4", Ground Thread Limit: GH2

**See Our Entire Selection of:**

**TOOL BITS.....Pages 191 - 194**



**BROACHES.....Pages 197 - 201**



**TAP EXTENSIONS  
SERIES 410:**



For use with a tap wrench to permit tapping in hard to get at places.

Overall Length	Capacity		Order No.	Price
	Hand Taps	Machine Screw Taps		
7	1/16-1/4	0-14	4100012	
10-3/4	1/4-1/2	-	4100023	



SERIES 872:

# VERMONT TAP & DIE

SERIES 872:



GROUND THREAD - CNC TAPS - GROUND THREAD

**CNC H/D SpPt. Plug : HSS/ Ground Thread Heavy Duty Spiral Point Taps**

**CNC H/D SpFl. Plug / Bott : HSS / Ground Thread Spiral Fluted Taps**

**CNC CO. SpPt. Plug : Premium PM Cobalt Hss / Ground Thread Spiral Point Taps**

**CNC CO. SpFl. Bott : Premium PM Cobalt Hss / Ground Thread Spiral Fluted Taps**

## CNC HEAVY DUTY SPIRAL POINT TAPS

Vermont CNC Heavy Duty Spiral Point taps are designed to tap difficult to machine hard materials such as heat-treated steels, tool steels, and some hard exotic materials up to 35 Rc. Spiral Point CNC Heavy Duty Taps, which drive the chips ahead of the tool, are recommended for through holes or blind holes with sufficient chip clearance. For blind holes, CNC Heavy Duty Spiral Fluted Taps are recommended. Vermont CNC taps are manufactured with closely controlled dimensions for fast, repeatable tool changes on CNC equipment.

## CNC SPIRAL FLUTED TAPS

Vermont CNC Heavy Duty Spiral Fluted taps are designed to tap blind holes in heat-treated steels, tool steels, and some hard exotic materials up to 35 Rc. For through holes, CNC Heavy Duty Spiral Point Taps are recommended. Vermont CNC taps are manufactured with closely controlled dimensions for fast, repeatable tool changes on CNC equipment.

## CNC COBALT SPIRAL POINT TAPS / CNC COBALT SPIRAL FLUTED TAPS

Vermont CNC Cobalt Spiral Point taps, manufactured from premium PM cobalt-bearing high speed steel, are designed for the most difficult tapping applications, including heat-treated materials up to 45 Rc as well as softer, high strength materials such as super alloys. With CNC equipment in mind, Vermont closely controls tap dimensions for fast, repeatable tap changes. CNC Spiral Point Taps which drive the chips ahead of the tool are recommended for through holes or blind holes with sufficient clearance (typically 1-1/2 tap diameters minimum). Vermont CNC Cobalt Spiral Fluted taps are recommended for blind holes with limited clearance.

Size	Threads Per Inch	No. of Flutes	Ground Thread Limit	Overall Length	Thread Length
6	32	3	H3	2	3/8
8	32	3	H3	2-1/8	3/8
10	24	3	H3	2-3/8	1/2
10	32	3	H3	2-3/8	1/2
1/4	20	3	H3	2-1/2	5/8
1/4	28	3	H3	2-1/2	5/8
5/16	18	3	H3	2-23/32	11/16
5/16	24	3	H3	2-23/32	11/16
3/8	16	3	H3	2-15/16	3/4
3/8	24	3	H3	2-15/16	3/4
7/16	14	3	H3	3-5/32	7/8
7/16	20	3	H3	3-5/32	7/8
1/2	13	3	H3	3-3/8	15/16
1/2	20	3	H3	3-3/8	15/16
5/8	11	3*	H3‡	3-13/16	1-1/8



SPIRAL POINT



SPIRAL FLUTED

While we show only the most popular items we can of course supply their entire range of products. Please inquire for a complete catalog.

Size	Threads Per Inch	CNC H/D SpPt Plug		CNC Co SpPt Plug		CNC H/D SpFl Plug / Bott			CNC Co SpFl Bott**	
		Order No.	Price	Order No. Plug	Price	Order No. Plug	Order No. Bott	Price	Order No.	Price
6	32	282108		272004		272957	272005		295001	
8	32	282157		272046		272054	272104		295043	
10	24	282207		272087		272062	272120		295084	
10	32	282256		272129		272153	272203		295126	
1/4	20	282306		272160		272252	272302		295167	
1/4	28	282405		272202		272351	272401		295209	
5/16	18	282454		272244		272450	272501		295241	
5/16	24	282504		272285		272568	272526		295282	
3/8	16	282553		272328		272559	272609		295324	
3/8	24	282652		272368		272567	272625		295365	
7/16	14	282702		272402		272658	272708		295407	
7/16	20	282751		272446		-	-		295449	
1/2	13	282801		272483		272557	272807		295480	
1/2	20	282901		272525		272765	272823		295522	
5/8	11	282959		-		272856	272906		-	

\* CNC HD SpFl; 4 Flute

\*\* Semi - Bottoming

‡ Other "Pitch Diameter Limits" available; please inquire.



SERIES 872:

# VERMONT TAP & DIE

SERIES 872:



## GROUND THREAD - CNC TAPS - GOLD (TiN) COATED

Coating: VERTANIUM™ Titanium Nitride (TiN) (bright gold color)

**Recommended Applications:** For ferrous, nonmetallic and some nonferrous materials. VERTANIUM's extreme hardness and low coefficient of friction increase tool life, improve thread finish and often allow higher tapping speeds for increased productivity. Use in steel, cast iron, stainless steel, high-temperature alloys, plastics, rubber, and most non-ferrous castings.

**Precautions:** Avoid in titanium and titanium alloys and most wrought nonferrous materials due to tendency to gall.

CNC H/D SpPt. Plug : HSS/ Ground Thread Heavy Duty Spiral Point Taps

CNC AERO SpPt. Plug : HSS / Ground Thread AERO Spiral Point Taps

CNC H/D SpFl. Plug / Bott : HSS / Ground Thread Spiral Fluted Taps

CNC CO. SpPt. Plug : Premium PM Cobalt Hss / Ground Thread Spiral Point Taps

CNC CO. SpFl. Bott : Premium PM Cobalt Hss / Ground Thread Spiral Fluted Taps

### CNC HEAVY DUTY SPIRAL POINT TAPS

Vermont VERTANIUM CNC Heavy Duty Spiral Point taps are designed to tap difficult to machine hard materials such as heat-treated steels, tool steels, and some hard exotic materials up to 35 Rc. Spiral Point CNC Heavy Duty Taps, which drive the chips ahead of the tool, are recommended for through holes or blind holes with sufficient chip clearance. For blind holes, CNC Heavy Duty Spiral Fluted Taps are recommended. Vermont CNC taps are manufactured with closely controlled dimensions for fast, repeatable tool changes on CNC equipment.

### CNC SPIRAL FLUTED TAPS

Vermont VERTANIUM CNC Heavy Duty Spiral Fluted taps are designed to tap blind holes in heat-treated steels, tool steels, and some hard exotic materials up to 35 Rc. For through holes, CNC Heavy Duty Spiral Point Taps are recommended. Vermont CNC taps are manufactured with closely controlled dimensions for fast, repeatable tool changes on CNC equipment.

### CNC AERO SPIRAL POINT TAPS

Vermont VERTANIUM CNC AERO Spiral Point Taps were developed to tap heat resisting stainless steel alloys, for example 17-4PH, A286 and other soft nickel based exotic materials such as Hastelloy, Inconel, Waspoly, and Incoloy. The unique spiral point geometry is designed to freely tap these difficult to machine Aerospace materials with minimal contact between work material and tool. With CNC equipment in mind, Vermont closely controls tap dimensions for fast, repeatable tap changes. VERTANIUM CNC AERO taps are recommended for exotic materials 275 BHN or less. For harder materials, VERTANIUM CNC Heavy Duty Taps are recommended.

### CNC COBALT SPIRAL POINT TAPS CNC COBALT SPIRAL FLUTED TAPS

Vermont VERTANIUM CNC Cobalt Spiral Point taps, manufactured from premium PM cobalt-bearing high speed steel, are designed for the most difficult tapping applications, including heat-treated materials up to 45 Rc as well as softer, high strength materials such as super alloys. With CNC equipment in mind, Vermont closely controls tap dimensions for fast, repeatable tap changes. CNC Spiral Point Taps which drive the chips ahead of the tool are recommended for through holes or blind holes with sufficient clearance (typically 1-1/2 tap diameters minimum). Vermont VERTANIUM CNC Cobalt Spiral Fluted taps are recommended for blind holes with limited clearance.

Size	Threads Per Inch	No. of Flutes	Ground Thread Limit ‡	Overall Length	Thread Length
6	32	3	H3	2	3/8
8	32	3	H3	2-1/8	3/8
10	24	3	H3	2-3/8	1/2
10	32	3	H3	2-3/8	1/2
1/4	20	3	H3	2-1/2	5/8
1/4	28	3	H3	2-1/2	5/8
5/16	18	3	H3	2-23/32	11/16
5/16	24	3	H3	2-23/32	11/16
3/8	16	3	H3	2-15/16	3/4
3/8	24	3	H3	2-15/16	3/4
7/16	14	3	H3	3-5/32	7/8
7/16	20	3	H3	3-5/32	7/8
1/2	13	3	H3	3-3/8	15/16
1/2	20	3	H3	3-3/8	15/16
5/8	11	3*	H3	3-13/16	1-1/8
3/4	10	3	H5	4-1/4	1-1/4



SPIRAL POINT



SPIRAL FLUTED

Size/ TPI	CNC H/D SpPt Plug		CNC AERO SpPt Plug		CNC H/D SpFl Plug/Bott			CNC CO SpPt Plug		CNC CO SpFl Bott**	
	Order No.	Price	Order No.	Price	Order No. Plug	Order No. Bott	Price	Order No.	Price	Order No.	Price
6-32	280108		285057		281957	282005		292004		295007	
8-32	280157		285107		282054	282104		292046		295049	
10-24	280207		285156		282062	282120		292087		295080	
10-32	280256		285206		282153	282203		292129		295122	
1/4-20	280306		285255		282252	282302		9292160		295163	
1/4-28	280405		285354		282351	282401		292202		295205	
5/16-18	280454		285404		282450	282501		292244		295247	
5/16-24	280504		285453		282468	282526		292285		295288	
3/8-16	280553		285503		282559	282609		292328		295320	
3/8-24	280652		285602		282567	282625		292368		295361	
7/16-14	280702		285651		282658	282708		292401		295403	
7/16-20	280751		285701		-	292442		295445		-	
1/2-13	280801		285750		282757	282807		292483		295486	
1/2-20	280901		285859		282765	282823		292525		295528	
5/8-11	280959		282856		282856	282906		-		-	
3/4-10	281056		-		-	-		-		-	

\* CNC HD SpFl; 4 Flute

\*\* Semi - Bottoming

‡ Other "Pitch Diameter Limits" available; please inquire.



SERIES 872

# VERMONT TAP & DIE

SERIES 872



## HIGH SPEED STEEL - CNC FORMING TAPS - GROUND THREAD

The Vermont CNC Forming Tap is a new design expanding the use of forming taps further into harder and less ductile materials which up to now have been successfully tapped with other existing types of forming taps. The design of the CNC Forming Tap makes it less sensitive to undesirable hole conditions such as size variation, out-of-roundness, and excessive taper that often cause other forming taps to fail or break. However, in the case of holes that are small, or excessively tapered, the CNC Forming Tap may generate some fine chips.

Vermont CNC Forming Taps are designed to form threads by material displacement. This process results in numerous tapping advantages: greater tap strength, especially in smaller tap sizes; potentially greater fastener strength; and elimination of chip disposal. CNC Forming Taps have been designed with straight lobes and oil grooves (#5, M3 and larger). They can be used to advantage in soft, ductile materials (25Rc or less). They are manufactured with closely controlled dimensions for fast, repeatable tool changes and therefore are well suited for use on CNC equipment.



Size	Threads Per Inch	Ground Thread Limit	Overall Length	Thread Length	Order No.		Price
					CNC Plug	CNC Bottoming	
4	40	H3	1-7/8	5/16	289004	289012	
4	40	H5	1-7/8	5/16	289020	289038	
4	48	H3	1-7/8	5/16	289046	289053	
5	40	H3	1-15/16	3/8	289087	289095	
5	40	H5	1-15/16	3/8	-	289111	
6	32	H3	2	3/8	289202	289210	
6	32	H5	2	3/8	289228	289236	
6	32	H10	2	3/8	289244	289251	
6	40	H3	2	3/8	289160	289178	
6	40	H5	2	3/8	289186	289194	
8	32	H3	2-1/8	3/8	289269	289277	
8	32	H5	2-1/8	3/8	289285	289293	
8	32	H10	2-1/8	3/8	289301	289319	
8	36	H3	2-1/8	3/8	-	289335	
8	36	H5	2-1/8	3/8	289343	289350	
10	24	H4	2-3/8	1/2	289368	289376	
10	24	H6	2-3/8	1/2	289384	289392	
10	32	H4	2-3/8	1/2	289426	289434	
10	32	H6	2-3/8	1/2	289442	289459	
10	32	H10	2-3/8	1/2	289467	-	
1/4	20	H4	2-1/2	5/8	289525	289533	
1/4	20	H6	2-1/2	5/8	289541	289558	
1/4	20	H10	2-1/2	5/8	289566	-	
1/4	28	H4	2-1/2	5/8	289582	289590	
1/4	28	H6	2-1/2	5/8	289608	289616	
5/16	18	H5	2-23/32	11/16	289640	289657	
5/16	18	H7	2-23/32	11/16	289665	289673	
5/16	18	H10	2-23/32	11/16	-	289699	
5/16	24	H5	2-23/32	11/16	289707	289715	
5/16	24	H7	2-23/32	11/16	289723	289731	
3/8	16	H5	2-15/16	3/4	289764	289772	
3/8	16	H7	2-15/16	3/4	289780	289798	
3/8	24	H5	2-15/16	3/4	289822	289830	
3/8	24	H7	2-15/16	3/4	-	289855	
7/16	14	H5	3-5/32	7/8	289889	289897	
7/16	14	H8	3-5/32	7/8	-	289913	
7/16	20	H5	3-5/32	7/8	289921	289939	
7/16	20	H8	3-5/32	7/8	-	289954	
1/2	13	H5	3-3/8	15/16	289962	289970	
1/2	13	H8	3-3/8	15/16	289988	289996	
1/2	20	H5	3-3/8	15/16	290002	290010	

(Continued)



SERIES 872:

# VERMONT TAP & DIE

SERIES 872:



## HIGH SPEED STEEL - CNC FORMING TAPS - GROUND THREAD

(Continued)

Size	Threads Per Inch	Ground Thread Limit	Overall Length	Thread Length	Order No.		Price
					CNC Plug	CNC Bottoming	
M3	0.5	D5	1-15/16	3/8	291001	291018	
M4	0.7	D6	2-1/8	3/8	291083	291091	
M5	0.8	D7	2-3/8	1/2	291125	291133	
M6	1.0	D8	2-1/2	5/8	291166	291174	
M8	1.25	D9	2-23/32	11/16	291240	291257	
M10	1.5	D10	2-15/16	3/4	291176	291178	
M12	1.75	D11	3-3/8	15/16	291179	291181	

## CNC FORMING TAPS - GOLD (TIN) COATED

Vermont VERTANIUM CNC Forming Taps are designed to form threads by material displacement. This process results in numerous tapping advantages: greater tap strength, especially in smaller tap sizes; potentially greater fastener strength; and elimination of chip disposal. VERTANIUM CNC Forming Taps have been designed with straight lobes and oil grooves (#8, M4 and larger) to take maximum advantage of TiN coating. They can be used to advantage in soft, ductile materials (25Rc or less). They are manufactured with closely controlled dimensions for fast, repeatable tool changes and therefore are well suited for use on CNC equipment.



Size	Threads Per Inch	Ground Thread Limit	Overall Length	Thread Length	Order No.		Price
					CNC Plug	CNC Bottoming	
6	32	H3	2	3/8	287004	287053	
6	32	H5	2	3/8	287103	287152	
8	32	H3	2-1/8	3/8	287202	287251	
8	32	H5	2-1/8	3/8	287301	287350	
10	24	H4	2-3/8	1/2	287400	287459	
10	24	H6	2-3/8	1/2	287509	287558	
10	32	H6	2-3/8	1/2	287608	287657	
1/4	20	H4	2-1/2	5/8	287665	287634	
1/4	20	H6	2-1/2	5/8	287707	287756	
1/4	28	H6	2-1/2	5/8	287806	287855	
5/16	18	H7	2-23/32	11/16	287905	287954	
5/16	24	H7	2-23/32	11/16	288002	288051	
3/8	16	H7	2-15/16	3/4	288101	288150	
3/8	24	H7	2-15/16	3/4	288200	288259	
7/16	14	H8	3-5/32	7/8	288309	288358	
1/2	13	H8	3-3/8	15/16	288408	288457	



### Metric Sizes

Size	Threads Per Inch	Ground Thread Limit	Overall Length	Thread Length	Order No.		Price
					CNC Plug	CNC Bottom	
M3	0.5	D5	1-15/16	3/8	291006	291014	
M4	0.7	D6	2-1/8	3/8	291089	291097	
M5	0.8	D7	2-3/8	1/2	291123	291139	
M6	1.0	D8	2-1/2	5/8	291162	291170	
M8	1.25	D9	2-23/32	11/16	291246	291253	
M10	1.5	D10	2-15/16	3/4	291287	291295	
M12	1.75	D11	3-3/8	15/16	291180	291182	

**HIGH SPEED STEEL / GROUND THREAD  
48° FAST SPIRAL FLUTED TAPS** 

**HIGH SPEED STEEL / GROUND THREAD  
30° SPIRAL FLUTED TAPS**    
SERIES 920: VERMONT TAP & DIE ‡



Size	TPI	No. of Flutes	Ground Thread Limit	Order No.		Price
				Plug	Bottom	
3	48	2	H2	0703481	0703482	
3	56	2	H2	0703561	0703562	
4	40	2	H2	0704401	0704402	
4	48	2	H2	0704481	0704482	
5	40	2	H2	0705401	0705402	
5	44	2	H2	0705441	0705442	
6	32	2	H3	0706321	0706322	
6	40	2	H3	0706401	0706402	
8	32	3	H3	0708321	0708322	
8	36	3	H3	0708361	0708362	
10	24	3	H3	0710241	0710242	
10	32	3	H3	0710321	0710322	
12	24	3	H3	0712241	0712242	
12	28	3	H3	0712281	0712282	
1/4	20	3	H3	0716201	0716202	
1/4	28	3	H3	0716281	0716282	
5/16	18	3	H3	0720181	0720182	
5/16	24	3	H3	0720241	0720242	
3/8	16	3	H3	0724161	0724162	
3/8	24	3	H3	0724241	0724242	
7/16	14	3	H3	0728141	0728142	
7/16	20	3	H3	0728201	0728202	
1/2	13	3	H3	0732131	0732132	
1/2	20	3	H3	0732201	0732202	
9/16	12	3,4	H3	0736121	0736122	
9/16	18	3,4	H3	0736181	0736182	
5/8	11	4	H3	0740111	0740112	
5/8	18	4	H3	0740181	0740182	
11/16	11	4	H3	0744111	0744112	
11/16	16	4	H3	0744161	0744162	
3/4	10	4	H3	0748101	0748102	
3/4	16	4	H3	0748161	0748162	

Size	TPI	No. of Flutes	Ground Thread Limit	Order No.		Price
				Plug	Bottom	
4	40	2	H2	365676	365678	
6	32	2	H3	365648	365655	
8	32	3	H3	365689	365697	
10	24	3	H3	365721	365739	
10	32	3	H3	365747	365754	
1/4	20	3	H3	366323	366331	
1/4	28	3	H3	366364	366372	
5/16	18	3	H3	366406	366414	
5/16	24	3	H3	366448	366455	
3/8	16	3	H3	366463	366471	
3/8	24	3	H3	366489	366497	
7/16	14	3	H3	366505	366513	
7/16	20	3	H3	366521	366538	
1/2	13	3	H3	366547	366554	
1/2	20	3	H3	366562	366570	

‡ Available Gold (TIN) Coated; please inquire.

**HIGH SPEED STEEL / GROUND THREAD  
49° QUICK SPIRAL FLUTED TAPS**    
SERIES 920 : VERMONT TAP & DIE



Vermont Spiral Fluted Taps (also known as Helical Fluted Taps) are designed to provide efficient chip ejection in a wide variety of soft materials such as aluminum, copper, brass, magnesium, die casting metals, and steel in which stringy chips are generated. These taps are particularly useful in threading deep or blind holes, and in bridging keyways or other interruptions in the surface of holes being tapped.

**HIGH SPEED STEEL / GROUND THREAD  
49° QUICK SPIRAL FLUTED TAPS**

**GOLD (TIN) COATED**  
SERIES 920 : VERMONT TAP & DIE



Size	TPI	No. of Flutes	Ground Thread Limit	Order No.		Price
				Plug	Bottom	
4	40	2	H2	367145	367152	
6	32	2	H3	367228	367236	
8	32	3	H3	367269	367278	
10	24	3	H3	367302	367320	
10	32	3	H3	367327	367335	
1/4	20	3	H3	367905	367913	
1/4	28	3	H3	367921	367939	
5/16	18	3	H3	367947	367954	
5/16	24	3	H3	367962	367970	
3/8	16	3	H3	367988	367996	
3/8	24	3	H3	368038	368039	
7/16	14	3	H3	368043	368036	
1/2	13	3	H3	368069	368077	
5/8	11	4	H3	368145	368091	

Size	TPI	No. of Flutes	Ground Thread Limit	Vermont Tap & Die		Price
				Order No.		
				Plug	Bottom	
3	48	2	H2	367107	367115	
4	40	2	H2	367149	367156	
5	40	2	H2	367180	367198	
6	32	2	H3	367222	367230	
8	32	3	H3	367263	367271	
10	24	3	H3	367305	367313	
10	32	3	H3	367321	367339	
12	24	3	H3	367347	367354	
1/4	20	3	H3	367909	367917	
1/4	28	3	H3	367925	367933	
5/16	18	3	H3	367941	367958	
5/16	24	3	H3	367966	367974	
3/8	16	3	H3	367982	367990	
3/8	24	3	H3	368006	368014	
7/16	14	3	H3	9368022	368030	
7/16	20	3	H3	368048	368055	
1/2	13	3	H3	368063	368071	
1/2	20	3	H3	368089	368097	
5/8	11	4	H3	368147	368154	

**HIGH SPEED STEEL / GROUND THREAD  
49° QUICK SPIRAL FLUTED TAPS - METRIC  
SERIES 920 : VERMONT TAP & DIE**



Size mm	Pitch mm	Pitch Dia. Limit	No. of Flutes	Order No.		Price
				Plug	Bott	
3.0	.50	D3	2	366110	366112	
3.5	.60	D4	3	366120	366122	
4.0	.70	D4	3	366130	366132	
5.0	.80	D4	3	366140	366142	
6.0	1.00	D5	3	366150	366152	
8.0	1.25	D5	3	366160	366162	
10.0	1.50	D6	3	366170	366172	
12.0	1.75	D6	3	366180	366182	

**HIGH SPEED STEEL / GROUND THREAD  
THREAD FORMING  
TAPS - FLUTELESS**



SERIES 557:



Size	TPI	Order No.	Price
2	56	5570256	
4	40	5570440	
5	40	5570540	
6	32	5570632	
8	32	5570832	
10	24	5571024	
10	32	5571032	
1/4	20	5571620	
1/4	28	5571628	
5/16	18	5572018	
5/16	24	5572024	
3/8	16	5572416	
3/8	24	5572424	
7/16	14	5572814	
7/16	20	5572820	
1/2	13	5573213	
1/2	20	5573220	

**HIGH SPEED STEEL / GROUND THREAD  
S.T.I. (SCREW THREAD INSERT) TAPS  
SERIES 935:**



Nominal Thread Size	Straight Flute					
	Plug Style (3B)			Bottoming Style (3B)		
	Model No.	Order No.	Price	Model No.	Order No.	Price
2-56	TP02-CPB	0110256		TP02-CBB	0120256	
3-48	TP03-CPB	0110348		TP03-CBB	0120348	
3-56	TP03-FPB	0110356		TP03-FBB	9120356	
4-40	TP04-CPB	0110440		TP04-CBB	0120440	
4-48	TP04-FPB	0110448		TP04-FBB	9120448	
5-40	TP05-CPB	0110540		TP05-CBB	0120540	
6-32	TP06-CPB	0110632		TP06-CBB	0120632	
6-40	TP06-FPB	0110640		TP06-FBB	0120640	
8-32	TP2-CPB	0110832		TP2-CBB	0120832	
8-36	TP2-FPB	0110836		TP2-FBB	0120836	
10-24	TP3-CPB	9011024		TP3-CBB	0121024	
10-32	TP3-FPB	9011032		TP3-FBB	0121032	
12-24	TP1-CPB	0111224		TP1-CBB	0121224	
12-28	TP1-FPB	9011228		TP1-FBB	0121228	
1/4-20	TP4-CPB	0111620		TP4-CBB	0121620	
1/4-28	TP4-FPB	0111628		TP4-FBB	9121628	
5/16-18	TP5-CPB	0112018		TP5-CBB	0122018	
5/16-24	TP5-FPB	0112024		TP5-FBB	0122024	
3/8-16	TP6-CPB	0112416		TP6-CBB	0122416	
3/8-24	TP6-FPB	0112424		TP6-FBB	0122424	
7/16-14	TP7-CPB	0112814		TP7-CBB	0122814	
7/16-20	TP7-FPB	0112820		TP7-FBB	0122820	
1/2-13	TP8-CPB	0113213		TP8-CBB	0123213	
1/2-20	TP8-FPB	0113220		TP8-FBB	0123220	
9/16-12	TP9-CPB	0113612		TP9-CBB	0123612	
9/16-18	TP9-FPB	0113618		TP9-FBB	0123618	
5/8-11	TP10-CPB	0114011		TP10-CBB	0124011	
5/8-18	TP10-FPB	0114018		TP10-FBB	0124018	
3/4-10	TP12-CPB	0114810		TP12-CBB	0124810	
3/4-16	TP12-FPB	0114816		TP12-FBB	9124816	
7/8-9	TP14-CPB	0115609		TP14-CBB	0125609	
7/8-14	TP14-FPB	0115614		TP14-FBB	0125614	
1-8	TP16-CPB	0116408		TP16-CBB	0126408	
1-12	TP161-FPB	0116412		TP161-FBB	0126412	
1-14	TP16-FPB	0116414		TP16-FBB	0126414	
1-1/8-7	TP18-CPB	0117207		TP18-CBB	0127207	
1-1/8-12	TP18-FPB	0117212		TP18-FBB	0127212	
1-1/4-7	TP20-CPB	0118007		TP20-CBB	0128007	
1-1/4-12	TP20-FPB	9018012		TP20-FBB	0128012	
1-3/8-6	TP22-CPB	0118806		TP22-CBB	0128806	
1-3/8-12	TP22-FPB	0118812		TP22-FBB	0128812	
1-1/2-6	TP24-CPB	9019606		TP24-CBB	0129606	
1-1/2-12	TP24-FPB	0119612		TP24-FBB	0129612	



**Plug Style**

4 Thread Chamfer-For thru holes and in blind holes that allow for ample chip clearance. Easier starting and requires less tapping torque than bottoming taps.



**Bottoming Style**

2 Thread Chamfer - For blind holes drilled to a minimum depth that requires threads close to the bottom of the hole.