

TMX Performance Taps

YELLOW BANDED FOR STEELS & STAINLESS STEELS



Cutting Tools

SPIRAL FLUTE TAPS

MODIFIED BOTTOMING CHAMFER = 2-3 THREAD CHAMFER



SPIRAL POINT / GUN STYLE TAPS

PLUG CHAMFER = 4-5 THREAD CHAMFER



Yellow Band Performance Taps

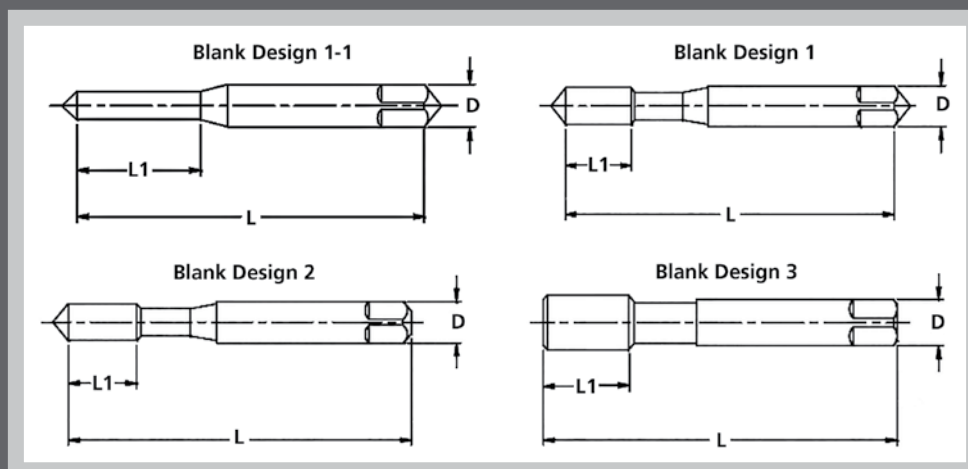
Application Key

○ = VERY GOOD ● = BEST

RECOMMENDED APPLICATION	MATERIAL TO BE TAPPED	HARDNESS UP TO	CUTTING SPEED (SFM*)
○	Medium to High Carbon Steel such as 1040, 1050, 1080 & 1572	Rc 28	20-45
○	Medium Alloyed Steel such as 4140	Rc 30	15-30
●	Cast Steel such as A356	Rc 28	25-40
●	Stainless Steels - 200 and 400 Series	Rc 28	25-40
●	Stainless Steels - 300 Series		20-35
●	Stainless Steels Precipitation Hardened (PH) such as 17-4 PH		15-25

□ = STEEL □ = STAINLESS STEEL *RPM = 3.82 X SFM/DIA

- ▶ HSS-E designed for excellent results in steels and stainless steels
- ▶ Available in spiral point gun style for through holes and spiral flute for blind holes
- ▶ Fractional, machine screw, and metric sizes
- ▶ Black steam oxide to help in coolant retention
- ▶ TMX Yellow Banded Taps contain 2% vanadium plus 5% cobalt offering superior wear resistance with additional benefit of increased heat resistance
- ▶ ANSI dimensions
- ▶ 60° Unified National (UN) thread form



SPIRAL FLUTE TAPS

MODIFIED BOTTOMING CHAMFER = 2-3 THREAD CHAMFER



*Fractional
and
Machine
Screw Sizes*

Diameter	Threads Per Inch (TPI)	Limit	Number of Flutes	OAL (L)	Thread Length (L1)	Shank Diameter (D)	Square Across The Flats	Blank Design	TMX Part Number
#4	40	H2	2	1-7/8"	.236	.141"	.110"	1	5-787-0040
#6	32	H3	3	2"	.276	.141"	.110"	1	5-787-0060
#8	32	H3	3	2-1/8"	.276	.168"	.131"	1	5-787-0080
#10	24	H3	3	2-3/8"	.354	.194"	.152"	1	5-787-0100
#10	32	H3	3	2-3/8"	.276	.194"	.152"	1	5-787-0101
1/4	20	H3	3	2-1/2"	.433	.255"	.191"	2	5-787-0250
1/4	28	H3	3	2-1/2"	.354	.255"	.191"	2	5-787-0251
5/16	18	H3	3	2-23/32"	.472	.318"	.238"	2	5-787-0310
5/16	24	H3	3	2-23/32"	.394	.318"	.238"	2	5-787-0311
3/8	16	H3	3	2-15/16"	.551	.381"	.286"	2	5-787-0370
3/8	24	H3	3	2-15/16"	.394	.381"	.286"	2	5-787-0371
7/16	14	H3	3	3-5/32"	.591	.323"	.242"	3	5-787-0430
7/16	20	H3	3	3-5/32"	.866	.323"	.242"	3	5-784-0431
1/2	13	H3	3	3-3/8"	.630	.367"	.275"	3	5-787-0500
1/2	20	H3	3	3-3/8"	.472	.367"	.275"	3	5-787-0501
5/8	11	H3	4	3-13/16"	.748	.480"	.360"	3	5-787-0620
5/8	18	H3	4	3-13/16"	.512	.480"	.360"	3	5-787-0621
3/4	10	H3	4	4-1/4"	.827	.590"	.442"	3	5-787-0750
3/4	16	H3	4	4-1/4"	.591	.590"	.442"	3	5-787-0751
7/8	9	H4	4	4-11/16"	.827	.697"	.523"	3	5-787-0870
7/8	14	H4	4	4-11/16"	.709	.697"	.523"	3	5-787-0871
1	8	H4	4	5-1/8"	.984	.800"	.600"	3	5-787-1000

**For additional dimensions, visit www.tmxtools.com

*Metric
Sizes*

Diameter	Threads Per Inch (TPI)	Limit	Number of Flutes	OAL (L)	Thread Length (L1)	Shank Diameter (D)	Square Across The Flats	Blank Design	TMX Part Number
M2	0.4	D3	2	1-3/4"	.394	.141"	.110"	1-1	5-785-0020
M2.5	0.45	D3	2	1-13/16"	.457	.141"	.110"	1-1	5-785-0025
M3	0.5	D3	3	1-15/16"	.197	.141"	.110"	1	5-788-0030
M3.5	0.6	D4	3	2"	.413	.141"	.110"	1	5-785-0035
M4	0.7	D4	3	2-1/8"	.276	.168"	.131"	1	5-788-0040
M5	0.8	D4	3	2-3/8"	.354	.194"	.152"	1	5-788-0050
M6	1.0	D5	3	2-1/2"	.433	.255"	.191"	2	5-788-0060
M8	1.25	D5	3	2-23/32"	.472	.318"	.238"	2	5-788-0080
M8	1.0	D5	3	2-23/32"	.433	.318"	.238"	2	5-788-0081
M10	1.5	D6	3	2-15/16"	.512	.381"	.286"	2	5-788-0100
M10	1.25	D5	3	2-15/16"	.472	.381"	.286"	2	5-788-0101
M12	1.75	D6	3	3-3/8"	.591	.367"	.275"	3	5-788-0120
M12	1.25	D5	3	3-3/8"	.551	.367"	.275"	3	5-788-0121
M14	2.0	D7	3	3-19/32"	.709	.429"	.322"	3	5-788-0140
M14	1.5	D6	3	3-19/32"	.551	.429"	.322"	3	5-788-0141
M16	2.0	D7	3	3-13/16"	.709	.480"	.360"	3	5-788-0160
M16	1.5	D6	3	3-13/16"	.551	.480"	.360"	3	5-788-0161
M18	2.5	D7	4	4-1/32"	.787	.542"	.406"	3	5-788-0180
M18	1.5	D6	4	4-1/32"	.551	.542"	.406"	3	5-788-0181
M20	2.5	D7	4	4-15/32"	.787	.652"	.489"	3	5-788-0200
M20	1.5	D5	4	4-15/32"	.551	.652"	.489"	3	5-788-0201

SPIRAL POINT / GUN STYLE TAPS

PLUG CHAMFER = 4-5 THREAD CHAMFER



*Fractional
and
Machine
Screw Sizes*

Diameter	Threads Per Inch (TPI)	Limit	Number of Flutes	OAL (L)	Thread Length (L1)	Shank Diameter (D)	Square Across The Flats	Blank Design	TMX Part Numberw
# 4	40	H2	2	1-7/8"	0.335	.141"	.110"	1	5-784-0040
# 6	32	H3	3	2"	0.413	.141"	.110"	1	5-784-0060
# 8	32	H3	3	2-1/8"	0.453	.168"	.131"	1	5-784-0080
# 10	24	H3	3	2-3/8"	0.531	.194"	.152"	1	5-784-0100
# 10	32	H3	3	2-3/8"	0.531	.194"	.152"	1	5-784-0101
1/4	20	H3	3	2-1/2"	0.591	.255"	.191"	2	5-784-0250
1/4	28	H3	3	2-1/2"	0.591	.255"	.191"	2	5-784-0251
5/16	18	H3	3	2-23/32"	0.669	.318"	.238"	2	5-784-0310
5/16	24	H3	3	2-23/32"	0.669	.318"	.238"	2	5-784-0311
3/8	16	H3	3	2-15/16"	0.748	.381"	.286"	2	5-784-0370
3/8	24	H3	3	2-15/16"	0.748	.381"	.286"	2	5-784-0371
7/16	14	H3	3	3-5/32"	0.866	.323"	.242"	3	5-784-0430
7/16	20	H3	3	3-5/32"	0.866	.323"	.242"	3	5-784-0431
1/2	13	H3	3	3-3/8"	0.984	.367"	.275"	3	5-784-0500
1/2	20	H3	3	3-3/8"	0.984	.367"	.275"	3	5-784-0501
5/8	11	H3	3	3-13/16"	1.083	.480"	.360"	3	5-784-0620
5/8	18	H3	3	3-13/16"	1.083	.480"	.360"	3	5-784-0621
3/4	10	H3	3	4-1/4"	1.201	.590"	.442"	3	5-784-0750
3/4	16	H3	3	4-1/4"	1.201	.590"	.442"	3	5-784-0751
7/8	9	H4	3	4-11/16"	1.339	.697"	.523"	3	5-784-0870
7/8	14	H4	3	4-11/16"	1.339	.697"	.523"	3	5-784-0871
1	8	H4	3	5-1/8"	1.496	.800"	.600"	3	5-784-1000

**For additional dimensions, visit www.tmxtools.com

*Metric
Sizes*

Diameter	Threads Per Inch (TPI)	Limit	Number of Flutes	OAL (L)	Thread Length (L1)	Shank Diameter (D)	Square Across The Flats	Blank Design	TMX Part Number
M2	0.4	D3	2	1-3/4"	0.394	.141"	.110"	1-1	5-785-0020
M2.5	0.45	D3	2	1-13/16"	0.457	.141"	.110"	1-1	5-785-0025
M3	0.5	D3	3	1-15/16"	0.374	.141"	.110"	1	5-785-0030
M3.5	0.6	D4	3	2"	0.413	.141"	.110"	1	5-785-0035
M4	0.7	D4	3	2-1/8"	0.453	.168"	.131"	1	5-785-0040
M5	0.8	D4	3	2-3/8"	0.531	.194"	.152"	1	5-785-0050
M6	1.0	D5	3	2-1/2"	0.591	.255"	.191"	2	5-785-0060
M8	1.25	D5	3	2-23/32"	0.669	.318"	.238"	2	5-785-0080
M8	1.0	D5	3	2-23/32"	0.669	.318"	.238"	2	5-785-0081
M10	1.5	D6	3	2-15/16"	0.748	.381"	.286"	2	5-785-0100
M10	1.25	D5	3	2-15/16"	0.748	.381"	.286"	2	5-785-0101
M12	1.75	D6	3	3-3/8"	0.984	.367"	.275"	3	5-785-0120
M12	1.25	D5	3	3-3/8"	0.984	.367"	.275"	3	5-785-0121
M14	2.0	D7	3	3-19/32"	0.984	.429"	.322"	3	5-785-0140
M14	1.5	D6	3	3-19/32"	0.984	.429"	.322"	3	5-785-0141
M16	2.0	D7	3	3-13/16"	1.083	.480"	.360"	3	5-785-0160
M16	1.5	D6	3	3-13/16"	1.083	.480"	.360"	3	5-785-0161
M18	2.5	D7	3	4-1/32"	1.083	.542"	.406"	3	5-785-0180
M18	1.5	D6	3	4-1/32"	1.083	.542"	.406"	3	5-785-0181
M20	2.5	D7	3	4-15/32"	1.201	.652"	.489"	3	5-785-0200
M20	1.5	D5	3	4-15/32"	1.201	.652"	.489"	3	5-785-0201

ALSO AVAILABLE FROM TMX CUTTING TOOLS:

TMX Integral Shank Tap Holders & Adapters

**INTEGRAL SHANK
TENSION/COMPRESSION
TAP HOLDERS & ADAPTERS**



- ▶ Quick change
- ▶ Available with CAT & BT tapers as well as straight shank
- ▶ Compatible with BILZ system
- ▶ For use with TMX tap adapters
- ▶ Tap holder and adapter sets available

**INTEGRAL SHANK RIGID
TAP HOLDERS & ADAPTERS**



Cutting Tools
www.tmxtools.com

1075 Worcester Street
Natick, MA 01760
844-TMX-TOOL
(844-869-8665)
Int'l +1-508-653-8897
Fax 508-653-5110
support@tmxtools.com

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