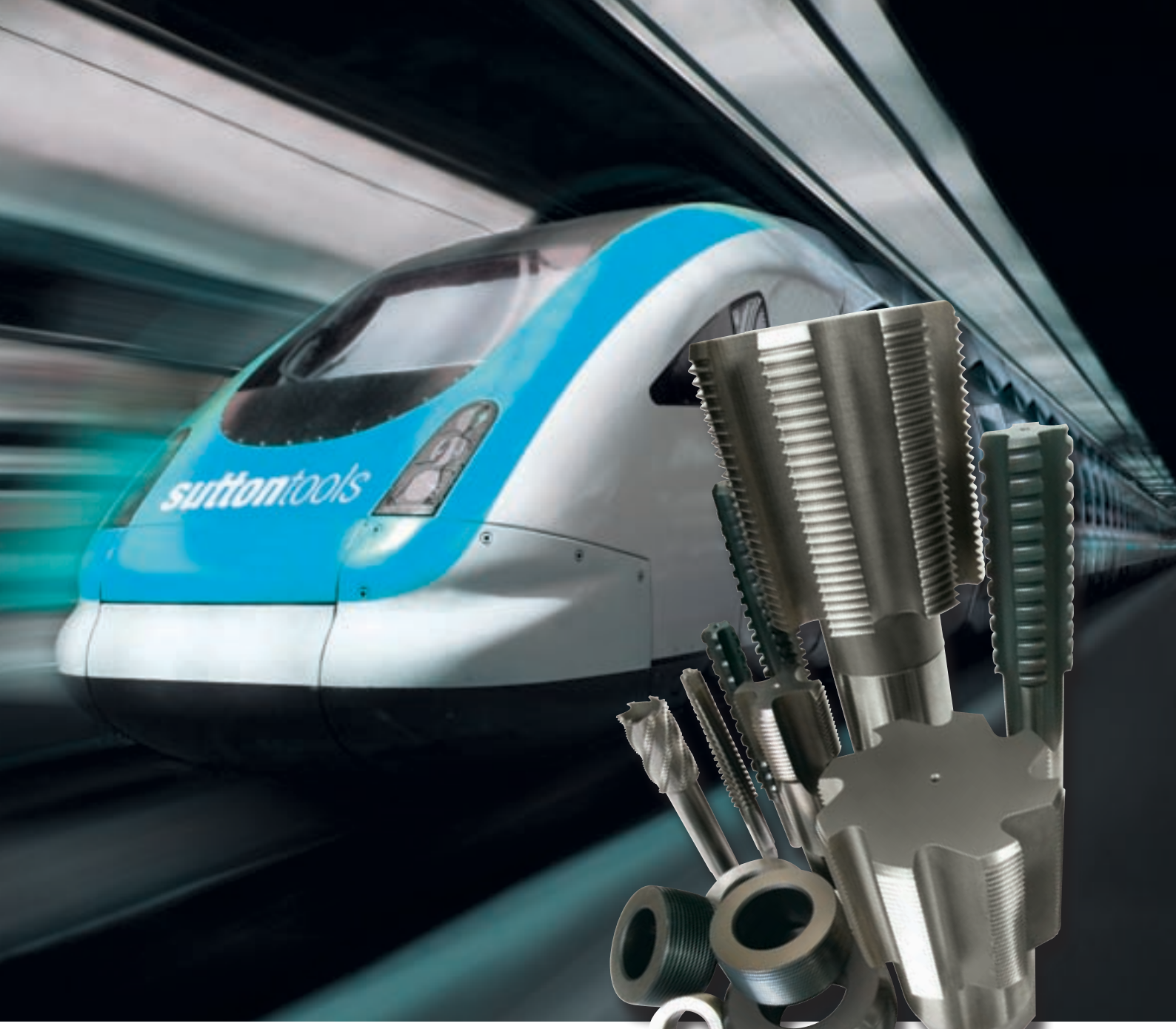
Taps ISO

Reliable, precision threading

- M, MF
- UNC, UNF, UNEF, UN, UNS
- BSW, BSF, BA, BSB
- Rc (BSPT), Rp (BSPPL), Pg Series, G (BSPF)
- NPT, NPTF, NPSF

TAPS ISO



Special Taps Express Delivery Service...

Sutton Tools is a leading international Manufacturer of specialist cutting tools and is renowned for producing high performance, precision cutting tools specifically designed to individual customer requirements.

With comprehensive customer service and warehouse facilities, our Express Delivery Service enables us to meet your requirements more efficiently than ever before.

All Thread Forms
UN, Metric, UNJC, UNJF, MJ, UH, Pg,
Whit, Rope forms & Acme and more!!

With our state of the art CNC grinding equipment almost any profile can be achieved. Feel free to discuss these with our Tech team.

Within 24 hours*
- Straight Flute Taps M3 to M127
- Spiral Taps M3 to M36

Within 48 Hours*
- Gun Taps M3 to M36

Within 5 Working Days*
Surface Finishes and Treatments:
- Steam Oxide
- Gas Nitride
- Titanium Nitride
- Chromium Nitride
- Titanium Carbo-Nitride
- Titanium Aluminum Nitride

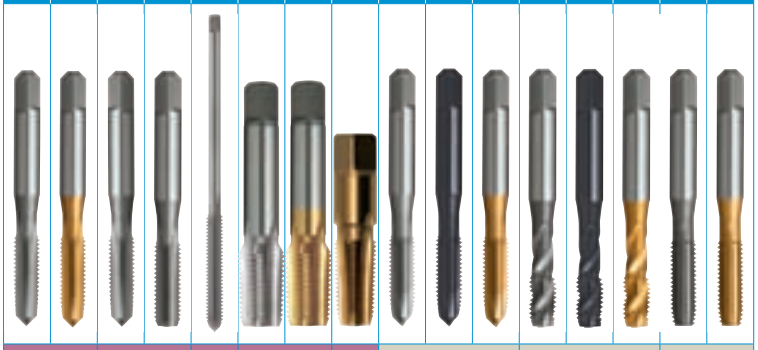
*For orders received prior to 12pm (Australian Eastern Standard Time)

suttontools

Page M	134	135	136	136					137	137	137	138	138	138	139	139
MF	140	141							142	142	142	143		143		
UNC	144	145	146		150				147	147	147	148	148	148	149	149
UNF	151	152	153						155	155	155	156		156	157	
BSW	159	160	161		165				162	162	162	163	163	163	164	164
BSF, BA, BSB (Brass)	166															
G (BSPF)	167	168							167			167				
Rc (BSPT), Rp (BSPPL), Pg, NPT, NPTF, NPSF	169					169	169	170								

ISO	VDI	Material Group	Sutton	
P	A	Steel	N	UNI
M	R	Stainless Steel	VA	
K	F	Cast Iron	GG	
N	N	Non-Ferrous Metals, Aluminiums & Coppers	Al W	
S	S	Titaniums & Super Alloys	Ti	Ni
H	H	Hard Materials (≥ 45 HRC)	H	

^ VDI 3323 material groups can also be determined by referring to the material cross reference listing in the application guide at the back of this catalogue.



Material	HSS		HSS		HSS	HSS			HSSE			HSSE			HSSE	
Surface Finish	Brt	TiN	Brt		Brt	Brt	TiN	Colour Temp	Brt	Blu	TiN	Brt	Blu	TiN	Brt	TiN
Sutton Designation	N		N-LH	0/Size	Nut	N			N			N			N	
Tapping Depth	≤ 1xØ		≤ 1xØ		≤ 2xØ	-			≤ 3xØ			≤ 2.5xØ			≤ 1.5xØ	

ISO	VDI^ 3323	Material		Condition	HB	N/mm²														
P	1	Steel - Non-alloy, cast & free cutting	~ 0.15 %C	A	125	440	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
	2		~ 0.45 %C	A	190	640	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
	3			QT	250	840	●	●	●	●	●	●	●	●	○	●	●	○	●	●	○	○
	4		~ 0.75 %C	A	270	910	●	●	●	●	●	●	●	●	○	●	●	○	●	●	○	○
	5			QT	300	1010		○					○				○			○		
	6	Steel - Low alloy & cast < 5% of alloying elements		A	180	610	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
	7			QT	275	930	○	●	○	○	○	○	●	○	○	○	●		○	●		○
	8			QT	300	1010		○					○				○			○		
	9			QT	350	1180																
	10	Steel - High alloy, cast & tool		A	200	680		○					○				○			○		
	11			HT	325	1100																
	12	Steel - Corrosion resistant & cast	Ferritic / Martensitic	A	200	680		○								○	○		○	○		
	13		Martensitic	QT	240	810											○			○		
M	14.1	Stainless Steel	Austenitic	AH	180	610		○			○		○	○	○	○	○	○	○	○		○
	14.2		Duplex		250	840									○	○	○	○	○	○		
	14.3		Precipitation Hardening		250	840																
K	15	Cast Iron - Grey (GG)	Ferritic / Pearlitic		180	610	○	○	○	○	○	○	○	○								
	16		Pearlitic		260	880																
	17	Cast Iron - Nodular (GGG)	Ferritic		160	570	○	○	○	○	○	○	○	○	○	○	○	○	○	○		
	18		Pearlitic		250	840									○	○	○	○	○	○		
	19	Cast Iron - Malleable	Ferritic		130	460	○	○	○	○	○	○	○	○	○	○	○					
	20		Pearlitic		230	780																
N	21	Aluminum & Magnesium - wrought alloy	Non Heat Treatable		60	210	○	○	○	○	○	○	○	○	○		○	○		○	●	●
	22		Heat Treatable	AH	100	360	○	○	○	○	○	○	○	○	○		○	○		○	●	●
	23	Aluminum & Magnesium - cast alloy ≤12% Si	Non Heat Treatable		75	270	○	○	○	○	○	○	○	○	○		○	○		○	●	○
	24		Heat Treatable	AH	90	320	○	○	○	○	○	○	○	○	○		○	○		○	●	○
	25	Al & Mg - cast alloy >12% Si	Non Heat Treatable		130	460											○			○		
	26	Copper & Cu alloys (Brass/Bronze)	Free cutting, Pb > 1%		110	390	○	○	○	○	○	○	○	○	●		○	●			●	●
	27		Brass (CuZn, CuSnZn)		90	320		○					○	○	○		○	○		○		
	28		Bronze (CuSn)		100	360	○	○	○	○	○	○	○	○				○			○	○
	29	Non-metallic - Thermosetting & fiber-reinforced plastics																				
	30	Non-metallic - Hard rubber, wood etc.																				
S	31	High temp. alloys	Fe based	A	200	680																
	32			AH	280	950																
	33		Ni / Co based	A	250	840																
	34			AH	350	1180																
	35			C	320	1080																
	36	Titanium & Ti alloys	CP Titanium		400 MPa																	
	37.1		Alpha alloys		860 MPa																	
	37.2		Alpha / Beta alloys	A	960 MPa																	
	37.3			AH	1170 MPa																	
	37.4		Beta alloys	A	830 MPa																	
	37.5			AH	1400 MPa																	
H	38.1	Hardened steel		HT	45 HRC																	
	38.2			HT	55 HRC																	
	39.1			HT	58 HRC																	
	39.2			HT	62 HRC																	
	40	Cast Iron	Chilled	C	400	1350									○	○	○	○	○	○		
	41			HT	55 HRC																	

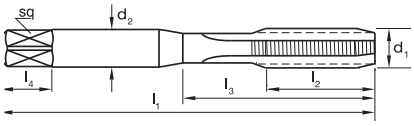
Condition: **A** (Annealed), **AH** (Age Hardened), **C** (Cast), **HT** (Hardened & Tempered), **QT** (Quenched & Tempered)

● Optimal ○ Effective

ISO Taps Metric, Straight Flute, N

suttontools

- General purpose use
- Suitable for materials up to 1000N/mm²
- Through & blind holes
- Suitable for both hand and machine operations
- Depths up to approx. 1 x d_1



	T384	T385	T386	T901
Catalogue Code	T384	T385	T386	T901
Discount Group	D0702	D0702	D0702	D0702
Material	HSS	HSS	HSS	HSS
Surface Finish	*Brt*	*Brt*	*Brt*	*Brt*
Sutton Designation	N	N	N	N
Geometry	-	-	-	-
Chamfer	Taper	Intermediate	Bottoming	Set
Limit & Nut Tolerance	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H

Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #	Item #	Item #
0200	M 2	x 0.4	41	8	-	2.50	2.00	4	3	1.6	T384 0200	T385 0200	T386 0200	T901 0200
0250	M 2.5	x 0.45	45	10	-	2.80	2.24	5	3	2.05	T384 0250	T385 0250	T386 0250	T901 0250
0300	M 3	x 0.5	48	11	15	3.15	2.50	5	3	2.5	T384 0300	T385 0300	T386 0300	T901 0300
0350	M 3.5	x 0.6	50	13	17.5	3.55	2.80	5	3	2.9	T384 0350	T385 0350	T386 0350	T901 0350
0400	M 4	x 0.7	53	13	18	4.00	3.15	6	3	3.3	T384 0400	T385 0400	T386 0400	T901 0400
0450	M 4.5	x 0.75	53	13	19	4.50	3.55	6	3	3.7	T384 0450	T385 0450	T386 0450	T901 0450
0500	M 5	x 0.8	58	16	22	5.00	4.00	7	3	4.2	T384 0500	T385 0500	T386 0500	T901 0500
0600	M 6	x 1	66	19	26	6.30	5.00	8	3	5.0	T384 0600	T385 0600	T386 0600	T901 0600
0700	M 7	x 1	66	19	26	7.10	5.60	8	4	6.0	T384 0700	T385 0700	T386 0700	T901 0700
0800	M 8	x 1.25	72	22	30	8.00	6.30	9	4	6.8	T384 0800	T385 0800	T386 0800	T901 0800
0900	M 9	x 1.25	72	22	31	9.00	7.10	10	4	7.8	T384 0900	T385 0900	T386 0900	T901 0900
1000	M 10	x 1.5	80	24	34	10.00	8.00	11	4	8.5	T384 1000	T385 1000	T386 1000	T901 1000
1100	M 11	x 1.5	85	25	-	8.00	6.30	9	4	9.5	T384 1100	T385 1100	T386 1100	T901 1100
1200	M 12	x 1.75	89	29	-	9.00	7.10	10	4	10.2	T384 1200	T385 1200	T386 1200	T901 1200
1400	M 14	x 2	95	30	-	11.20	9.00	12	4	12.0	T384 1400	T385 1400	T386 1400	T901 1400
1600	M 16	x 2	102	32	-	12.50	10.00	13	4	14.0	T384 1600	T385 1600	T386 1600	T901 1600
1800	M 18	x 2.5	112	37	-	14.00	11.20	14	4	15.5	T384 1800	T385 1800	T386 1800	T901 1800
2000	M 20	x 2.5	112	37	-	14.00	11.20	14	4	17.5	T384 2000	T385 2000	T386 2000	T901 2000
2200	M 22	x 2.5	118	38	-	16.00	12.50	16	4	19.5	T384 2200	T385 2200	T386 2200	T901 2200
2400	M 24	x 3	130	45	-	18.00	14.00	18	4	21.0	T384 2400	T385 2400	T386 2400	T901 2400
2700	M 27	x 3	135	45	-	20.00	16.00	20	4	24.0	T384 2700	T385 2700	T386 2700	•
3000	M 30	x 3.5	138	48	-	20.00	16.00	20	4	26.5	T384 3000	T385 3000	T386 3000	•
3300	M 33	x 3.5	151	51	-	22.40	18.00	22	4	29.5	T384 3300	T385 3300	T386 3300	•
3600	M 36	x 4	162	57	-	25.00	20.00	24	4	32.0	T384 3600	T385 3600	T386 3600	•
3900	M 39	x 4	170	60	-	28.00	22.40	26	4	35.0	T384 3900	T385 3900	T386 3900	•
4200	M 42	x 4.5	170	60	-	28.00	22.40	26	4	37.5	T384 4200	T385 4200	T386 4200	•
4500	M 45	x 4.5	187	67	-	31.50	25.00	28	4	40.5	T384 4500	T385 4500	T386 4500	•
4800	M 48	x 5	187	67	-	31.50	25.00	28	4	43.0	T384 4800	T385 4800	T386 4800	•
5200	M 52	x 5	200	70	-	35.50	28.00	31	4	47.0	T384 5200	T385 5200	T386 5200	•
	Tap & Drill Sets													
0014	**14 piece set (intermediate)** Taps: M3, M4, M5, M6, M8, M10, M12 Drills: 2.5, 3.3, 4.2, 5.0, 6.8, 8.5, 10.2mm											T385 0014		
SDT1	**28 piece set (taper, inter, bott) (Discount Group Z0304)** Taps: M3, M4, M5, M6, M8, M10, M12 Drills: 2.5, 3.3, 4.2, 5.0, 6.8, 8.5, 10.2mm													T901 SDT1

T385 0014

T901 SDT1

ISO	P													M			K						N									S																		H					
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T384	●	●	●	●		●	○										○		○		○		○	○	○	○		○		○																							

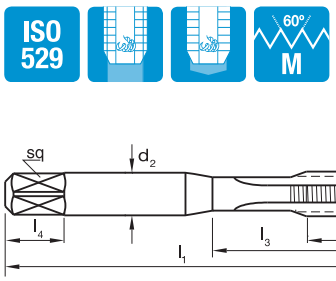
P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials

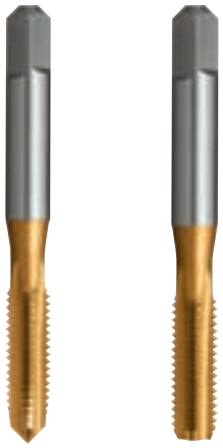
● Optimal ○ Effective

• Available on request as special manufacture. Subject to lead time.

suttontools

- General purpose use
- Suitable for materials up to 1000N/mm²
- Through & blind holes
- Suitable for both hand and machine operations
- Depths up to approx. 1 x d_1





	T387	T388
Catalogue Code	T387	T388
Discount Group	D0706	D0706
Material	HSS	HSS
Surface Finish	*TiN*	*TiN*
Sutton Designation	N	N
Geometry	-	-
Chamfer	Intermediate	Bottoming
Limit & Nut Tolerance	ISO 2 / 6H	ISO 2 / 6H

Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
0200	M 2	x 0.4	41	8	-	2.50	2.00	4	3	1.6	T387 0200	T388 0200
0250	M 2.5	x 0.45	45	10	-	2.80	2.24	5	3	2.05	•	•
0300	M 3	x 0.5	48	11	-	3.15	2.50	5	3	2.5	T387 0300	T388 0300
0350	M 3.5	x 0.6	50	13	-	3.55	2.80	5	3	2.9	T387 0350	T388 0350
0400	M 4	x 0.7	53	13	-	4.00	3.15	6	3	3.3	T387 0400	T388 0400
0450	M 4.5	x 0.75	53	13	19	4.50	3.55	6	3	3.7	•	•
0500	M 5	x 0.8	58	16	22	5.00	4.00	7	3	4.2	T387 0500	T388 0500
0600	M 6	x 1	66	19	26	6.30	5.00	8	3	5.0	T387 0600	T388 0600
0700	M 7	x 1	66	19	26	7.10	5.60	8	4	6.0	•	T388 0700
0800	M 8	x 1.25	72	22	30	8.00	6.30	9	4	6.8	T387 0800	T388 0800
0900	M 9	x 1.25	72	22	31	9.00	7.10	10	4	7.8	•	•
1000	M 10	x 1.5	80	24	34	10.00	8.00	11	4	8.5	T387 1000	T388 1000
1100	M 11	x 1.5	85	25	-	8.00	6.30	9	4	9.5	•	•
1200	M 12	x 1.75	89	29	-	9.00	7.10	10	4	10.2	T387 1200	T388 1200
1400	M 14	x 2	95	30	-	11.20	9.00	12	4	12.0	T387 1400	T388 1400
1600	M 16	x 2	102	32	-	12.50	10.00	13	4	14.0	T387 1600	T388 1600
1800	M 18	x 2.5	112	37	-	14.00	11.20	14	4	15.5	T387 1800	T388 1800
2000	M 20	x 2.5	112	37	-	14.00	11.20	14	4	17.5	T387 2000	T388 2000
2200	M 22	x 2.5	118	38	-	16.00	12.50	16	4	19.5	•	•
2400	M 24	x 3	130	45	-	18.00	14.00	18	4	21.0	•	•
2700	M 27	x 3	135	45	-	20.00	16.00	20	4	24.0	•	•
3000	M 30	x 3.5	138	48	-	20.00	16.00	20	4	26.5	•	•
3300	M 33	x 3.5	151	51	-	22.40	18.00	22	4	29.5	•	•
3600	M 36	x 4	162	57	-	25.00	20.00	24	4	32.0	•	•
3900	M 39	x 4	170	60	-	28.00	22.40	26	4	35.0	•	•
4200	M 42	x 4.5	170	60	-	28.00	22.40	26	4	37.5	•	•
4500	M 45	x 4.5	187	67	-	31.50	25.00	28	4	40.5	•	•
4800	M 48	x 5	187	67	-	31.50	25.00	28	4	43.0	•	•
5200	M 52	x 5	200	70	-	35.50	28.00	31	4	47.0	•	•

ISO	P													M			K					N									S													H					
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T387	●	●	●	●	○	●	●	○		○		○		○			○		○		○		○	○	○	○		○	○	○																		

P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials

● Optimal ○ Effective

• Available on request as special manufacture. Subject to lead time.

ISO Taps Metric, Straight Flute, N, Left Hand

suttontools

- General purpose use
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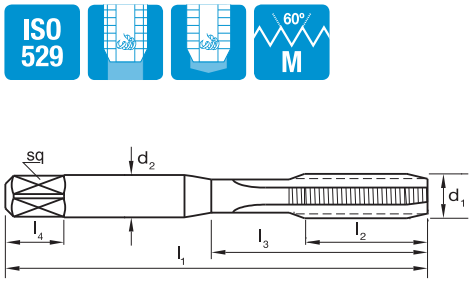
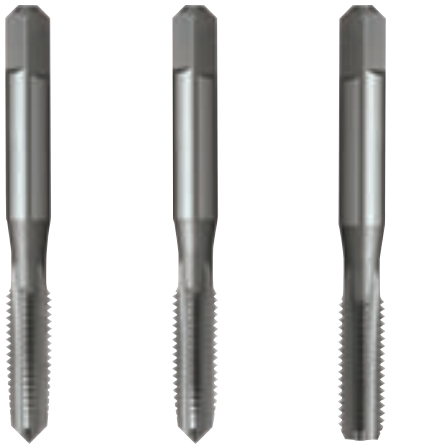


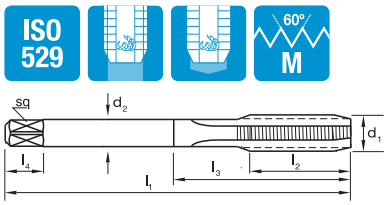


Catalogue Code	T389	T390	T391
Discount Group	D0702	D0702	D0702
Material	HSS	HSS	HSS
Surface Finish	*Brt*	*Brt*	*Brt*
Sutton Designation	N	N	N
Geometry	Left Hand	Left Hand	Left Hand
Chamfer	Taper	Intermediate	Bottoming
Limit & Nut Tolerance	ISO 2 / 6H LH	ISO 2 / 6H LH	ISO 2 / 6H LH

Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #	Item #
0300	M 3	x 0.5	48	11	15	3.15	2.50	5	3	2.5	T389 0300	T390 0300	T391 0300
0400	M 4	x 0.7	53	13	18	4.00	3.15	6	3	3.3	T389 0400	T390 0400	T391 0400
0500	M 5	x 0.8	58	16	22	5.00	4.00	7	3	4.2	T389 0500	T390 0500	T391 0500
0600	M 6	x 1	66	19	26	6.30	5.00	8	3	5.0	T389 0600	T390 0600	T391 0600
0800	M 8	x 1.25	72	22	30	8.00	6.30	9	4	6.8	T389 0800	T390 0800	T391 0800
1000	M 10	x 1.5	80	24	34	10.00	8.00	11	4	8.5	T389 1000	T390 1000	T391 1000
1200	M 12	x 1.75	89	29	-	9.00	7.10	10	4	10.2	T389 1200	T390 1200	T391 1200
1400	M 14	x 2	95	30	-	11.20	9.00	12	4	12.0	T389 1400	T390 1400	T391 1400
1600	M 16	x 2	102	32	-	12.50	10.00	13	4	14.0	T389 1600	T390 1600	T391 1600
1800	M 18	x 2.5	112	37	-	14.00	11.20	14	4	15.5	T389 1800	T390 1800	T391 1800
2000	M 20	x 2.5	112	37	-	14.00	11.20	14	4	17.5	T389 2000	T390 2000	T391 2000

ISO Taps Metric, Straight Flute, Oversize

- Oversize allowance to suit components for galvanize plating
- General purpose use, materials up to 1000N/mm²
- Through & blind holes
- Suitable for both hand and machine operations
- Depths up to approx 1 x d_1
- Taper and inter leads available on request



Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #
											T392
1000	M10 +0.4	x 1.5	85	25	-	8.0	6.3	9.0	4	8.9	T392 1000
1200	M12 +0.4	x 1.75	89	29	-	9.0	7.1	10.0	4	10.6	T392 1200
1600	M16 +0.4	x 2	112	37	-	12.5	10.0	13.0	4	14.4	T392 1600
2000	M20 +0.4	x 2.5	118	38	-	16.0	12.5	16.0	4	17.9	T392 2000
2400	M24 +0.45	x 3	130	45	-	18.0	14.0	18.0	4	21.5	T392 2400

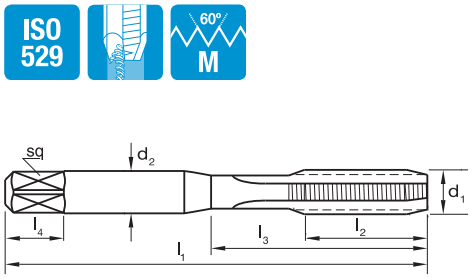
ISO	P												M			K						N										S														H					
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T389	●	●	●	●		●	○										○		○		○		○	○	○	○		○		○																					

P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials

● Optimal ○ Effective

suttontools

- General purpose use
- Suitable for materials up to 1000N/mm²
- Through holes
- Depths up to approx. 3 x d_1



	T393	T394	T395
Catalogue Code	T393	T394	T395
Discount Group	D0702	D0702	D0706
Material	HSSE	HSSE	HSSE
Surface Finish	*Brt*	*Blu*	*TiN*
Sutton Designation	N	N	N
Geometry	-	-	-
Chamfer	Intermediate	Intermediate	Intermediate
Limit & Nut Tolerance	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H

Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #	Item #
0250	M 2.5	x 0.45	45	10	-	2.80	2.24	5	3	2.05	T393 0250	T394 0250	•
0300	M 3	x 0.5	48	11	15	3.15	2.50	5	3	2.5	T393 0300	T394 0300	T395 0300
0350	M 3.5	x 0.6	50	13	17.5	3.55	2.80	5	3	2.9	T393 0350	T394 0350	T395 0350
0400	M 4	x 0.7	53	13	18	4.00	3.15	6	3	3.3	T393 0400	T394 0400	T395 0400
0500	M 5	x 0.8	58	16	22	5.00	4.00	7	3	4.2	T393 0500	T394 0500	T395 0500
0600	M 6	x 1	66	19	26	6.30	5.00	8	3	5.0	T393 0600	T394 0600	T395 0600
0800	M 8	x 1.25	72	22	30	8.00	6.30	9	3	6.8	T393 0800	T394 0800	T395 0800
1000	M 10	x 1.5	80	24	34	10.00	8.00	11	3	8.5	T393 1000	T394 1000	T395 1000
1200	M 12	x 1.75	89	29	-	9.00	7.10	10	3	10.2	T393 1200	T394 1200	T395 1200
1400	M 14	x 2	95	30	-	11.20	9.00	12	3	12.0	T393 1400	T394 1400	•
1600	M 16	x 2	102	32	-	12.50	10.00	13	3	14.0	T393 1600	T394 1600	T395 1600
1800	M 18	x 2.5	112	37	-	14.00	11.20	14	4	15.5	T393 1800	T394 1800	T395 1800
2000	M 20	x 2.5	112	37	-	14.00	11.20	14	4	17.5	T393 2000	T394 2000	T395 2000
2200	M 22*	x 2.5	118	38	-	16.00	12.50	16	4	19.5	•	T394 2200	•
2400	M 24*	x 3	130	45	-	18.00	14.00	18	4	21.0	•	T394 2400	•
3000	M 30*	x 3.5	138	48	-	20.00	16.00	20	4	26.5	•	T394 3000	•

ISO	P													M			K					N										S													H					
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T393	●	●	○	○		●	○							○	○				○	○	○		○	○	○	○		●	○																		○	
T394	●	●	●	●		●	○					○		○	○				○	○	○																										○	
T395	●	●	●	●	○	●	●	○		○		○	○	○	○				○	○	○		○	○	○	○	○	○	○																		○	

P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials

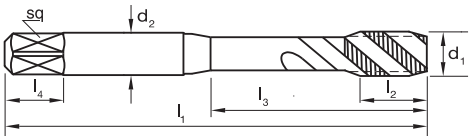
● Optimal ○ Effective

*HSS >20mm • Available on request as special manufacture. Subject to lead time.

suttontools

- General purpose use
- Suitable for materials up to 1000N/mm²
- Blind holes
- Depths up to approx. 2.5 x d_1

ISO 529 | DIN 2197 | 60° M



	T397	T396	T398
Catalogue Code	T397	T396	T398
Discount Group	D0702	D0702	D0706
Material	HSSE	HSSE	HSSE
Surface Finish	*Brt*	*Blu*	*TiN*
Sutton Designation	N	N	N
Geometry	-	-	-
Chamfer	Bottoming	Bottoming	Bottoming
Limit & Nut Tolerance	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H

Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #	Item #
0250	M 2.5	x 0.45	45	5	-	2.80	2.24	5	2	2.05	T397 0250	•	•
0300	M 3	x 0.5	48	6	15	3.15	2.50	5	3	2.5	T397 0300	T396 0300	T398 0300
0350	M 3.5	x 0.6	50	6	17.5	3.55	2.80	5	3	2.9	T397 0350	T396 0350	•
0400	M 4	x 0.7	53	7	18	4.00	3.15	6	3	3.3	T397 0400	T396 0400	T398 0400
0500	M 5	x 0.8	58	8	22	5.00	4.00	7	3	4.2	T397 0500	T396 0500	T398 0500
0600	M 6	x 1	66	10	26	6.30	5.00	8	3	5.0	T397 0600	T396 0600	T398 0600
0800	M 8	x 1.25	72	13	30	8.00	6.30	9	3	6.8	T397 0800	T396 0800	T398 0800
1000	M 10	x 1.5	80	15	34	10.00	8.00	11	3	8.5	T397 1000	T396 1000	T398 1000
1200	M 12	x 1.75	89	18	-	9.00	7.10	10	3	10.2	T397 1200	T396 1200	T398 1200
1400	M 14	x 2	95	20	-	11.20	9.00	12	3	12.0	T397 1400	T396 1400	•
1600	M 16	x 2	102	20	-	12.50	10.00	13	3	14.0	T397 1600	T396 1600	T398 1600
1800	M 18	x 2.5	112	25	-	14.00	11.20	14	4	15.5	T397 1800	T396 1800	T398 1800
2000	M 20	x 2.5	112	25	-	14.00	11.20	14	4	17.5	T397 2000	T396 2000	T398 2000
2200	M 22*	x 2.5	118	38	-	16.00	12.50	16	4	19.5	T397 2200	•	•
2400	M 24*	x 3	130	45	-	18.00	14.00	18	4	21.0	T397 2400	•	•
3000	M 30*	x 3.5	138	48	-	20.00	16.00	20	4	26.5	T397 3000	•	•

ISO	P													M			K						N										S														H					
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T397	●	●	○	○		●								○	○				○	○			○	○	○	○		●	○	○																			○	
T396	●	●	●	●		●	○					○		○	○				○	○			○	○	○	○			○																			○	
T398	●	●	●	●	○	●	●	○		○		○	○	○	○				○	○			○	○	○	○	○		○																			○	

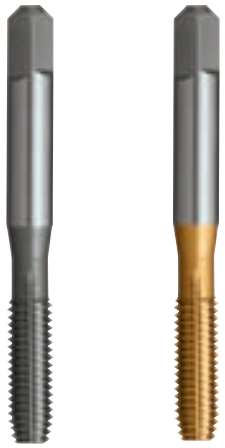
P Steel | M Stainless Steel | K Cast Iron | N Non-Ferrous Metals | S Titanium & Super Alloys | H Hard Materials

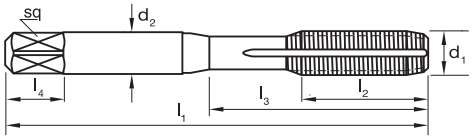
● Optimal ○ Effective

*HSS >20mm • Available on request as special manufacture. Subject to lead time.

suttontools

- For cold forming of threads in materials with good flow characteristics
- Through or blind holes
- Depths up to approx. 1.5 x d_1
- TiN for longer tool life





	T399	T400
Catalogue Code	T399	T400
Discount Group	D0702	D0706
Material	HSSE	HSSE
Surface Finish	*Brt*	*TiN*
Sutton Designation	N	N
Geometry	Single Coolant Groove ≥ M3	Single Coolant Groove ≥ M3
Chamfer	Short	Short
Limit & Nut Tolerance	GH4 / 6H	GH4 / 6H

Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
0250	M 2.5	x 0.45	45	10	-	2.80	2.24	5	-	2.3	T399 0250	•
0300	M 3	x 0.5	48	11	15	3.15	2.50	5	-	2.8	T399 0300	T400 0300
0350	M 3.5	x 0.6	50	13	17.5	3.55	2.80	5	-	3.2	T399 0350	•
0400	M 4	x 0.7	53	13	18	4.00	3.15	6	-	3.7	T399 0400	T400 0400
0500	M 5	x 0.8	58	16	22	5.00	4.00	7	-	4.6	T399 0500	T400 0500
0600	M 6	x 1	66	19	26	6.30	5.00	8	-	5.5	T399 0600	T400 0600
0800	M 8	x 1.25	72	22	30	8.00	6.30	9	-	7.4	T399 0800	•
1000	M 10	x 1.5	80	24	34	10.00	8.00	11	-	9.3	T399 1000	•
1200	M 12	x 1.75	89	29	-	9.00	7.10	10	-	11.2	T399 1200	•
											T637	
1005	MF 10	x 1	80	24	34	10.00	8.00	11	-	9.5	T637 1005	•
1206	MF 12	x 1.25	89	29	-	9.00	7.00	10	-	11.4	T637 1206	•

ISO	P													M			K							N								S														H					
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T399	●	●	○	○		●																	●	●	●	●		●		○																				
T400	●	●	○	○		●	○							○									●	●	○	○		●		○																				

P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials

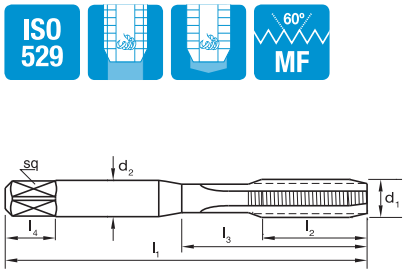
● Optimal ○ Effective

• Available on request as special manufacture. Subject to lead time.

ISO Taps Metric Fine, Straight Flute, N

suttontools

- General purpose use
- Suitable for materials up to 1000N/mm²
- Through & blind holes
- Suitable for both hand and machine operations
- Depths up to approx. 1 x d_1



	T401	T402	T403	T902
Catalogue Code	T401	T402	T403	T902
Discount Group	D0702	D0702	D0702	D0702
Material	HSS	HSS	HSS	HSS
Surface Finish	*Brt*	*Brt*	*Brt*	*Brt*
Sutton Designation	N	N	N	N
Geometry	-	-	-	-
Chamfer	Taper	Intermediate	Bottoming	Set
Limit & Nut Tolerance	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H

Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #	Item #	Item #
0503	MF 5	x 0.5	58	16	22	5.0	4.0	7	4	4.5	•	•	T403 0503	•
0604	MF 6	x 0.75	66	19	26	6.3	5.0	8	4	5.3	•	•	T403 0604	•
0805	MF 8	x 1*	72	22	30	8.0	6.3	9	4	7.0	T401 0805	T402 0805	T403 0805	T902 0805
0804	MF 8	x 0.75	72	22	30	8.0	6.3	9	4	7.3	•	•	T403 0804	•
1004	MF 10	x 0.75	80	24	34	10.0	8.0	11	4	9.3	•	•	T403 1004	•
1005	MF 10	x 1†	80	24	34	10.0	8.0	11	4	9.0	T401 1005	T402 1005	T403 1005	T902 1005
1006	MF 10	x 1.25*	80	24	34	10.0	8.0	11	4	8.8	T401 1006	T402 1006	T403 1006	T902 1006
1205	MF 12	x 1	89	29	-	9.0	7.1	10	4	11.0	T401 1205	T402 1205	T403 1205	•
1206	MF 12	x 1.25	89	29	-	9.0	7.1	10	4	10.8	T401 1206	T402 1206	T403 1206	T902 1206
1207	MF 12	x 1.5*	89	29	-	9.0	7.1	10	4	10.5	T401 1207	T402 1207	T403 1207	T902 1207
1405	MF 14	x 1	95	30	-	11.2	9.0	12	4	13.0	•	•	T403 1405	•
1406	MF14	x 1.25†	95	30	-	11.2	9.0	12	4	12.8	T401 1406	T402 1406	T403 1406	T902 1406
1407	MF 14	x 1.5*	95	30	-	11.2	9.0	12	4	12.5	T401 1407	T402 1407	T403 1407	T902 1407
1605	MF 16	x 1	102	32	-	12.5	10.0	13	4	15.0	•	•	T403 1605	•
1606	MF 16	x 1.25	102	32	-	12.5	10.0	13	4	14.8	•	•	T403 1606	•
1607	MF 16	x 1.5*	102	32	-	12.5	10.0	13	4	14.5	T401 1607	T402 1607	T403 1607	T902 1607
1806	MF 18	x 1.25	112	37	-	14.0	11.2	14	4	16.8	•	•	T403 1806	•
1807	MF 18	x 1.5*	112	37	-	14.0	11.2	14	4	16.5	T401 1807	T402 1807	T403 1807	T902 1807
2006	MF 20	x 1.25	112	37	-	14.0	11.2	14	4	18.8	•	•	T403 2006	•
2007	MF 20	x 1.5**	112	37	-	14.0	11.2	14	4	18.5	T401 2007	T402 2007	T403 2007	T902 2007
2008	MF 20	x 2*	112	37	-	14.0	11.2	14	4	18.0	•	•	T403 2008	•
2207	MF 22	x 1.5	118	38	-	16.0	12.5	16	4	20.5	T401 2207	T402 2207	T403 2207	T902 2207
2208	MF 22	x 2	118	38	-	16.0	12.5	16	4	20.0	•	•	T403 2208	•
2407	MF 24	x 1.5	130	45	-	18.0	14.0	18	4	22.5	•	•	T403 2407	•
2408	MF 24	x 2*	130	45	-	18.0	14.0	18	4	22.0	T401 2408	T402 2408	T403 2408	T902 2408
2507	MF 25	x 1.5**	130	45	-	18.0	14.0	18	4	23.5	T401 2507	T402 2507	T403 2507	•
2708	MF 27	x 2	135	45	-	20.0	16.0	20	4	25.0	•	•	T403 2708	•
3007	MF 30	x 1.5	138	48	-	20.0	16.0	20	4	28.5	T401 3007	T402 3007	T403 3007	•
3008	MF 30	x 2	138	48	-	20.0	16.0	20	4	28.0	T401 3008	T402 3008	T403 3008	•
3207	MF 32	x 1.5**	151	51	-	22.4	18.0	22	4	30.5	T401 3207	T402 3207	T403 3207	•
4007	MF 40	x 1.5**	170	60	-	28.0	22.4	26	4	38.5	T401 4007	T402 4007	T403 4007	•
	Spark Plug													
1005	MF 10	x 1†	80	24	34	10.0	8.0	11	4	9.0	T401 1005	T402 1005	T403 1005	T902 1005
1206	MF 12	x 1.25	89	29	-	9.0	7.1	10	4	10.8	T401 1206	T402 1206	T403 1206	T902 1206
1406	MF 14	x 1.25†	95	30	-	11.2	9.0	12	4	12.8	T401 1406	T402 1406	T403 1406	T902 1406
1807	MF 18	x 1.5	112	37	-	14.0	11.2	14	4	16.5	T401 1807	T402 1807	T403 1807	T902 1807

ISO	P												M			K						N									S												H					
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T401	●	●	●	●		●	○										○		○		○		○	○	○	○		○		○																			

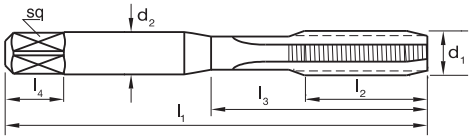
P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials

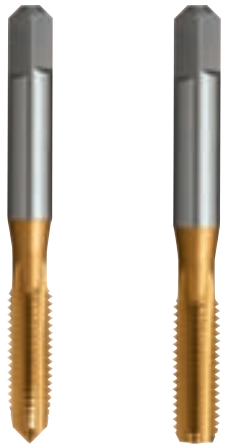
● Optimal ○ Effective

* Alternative Metric Fine ** Conduit Metric • Available on request as special manufacture. Subject to lead time. † Limit & Nut Tolerance: ISO 1 / 4H

suttontools

- General purpose use
- Suitable for materials up to 1000N/mm²
- Through & blind holes
- Suitable for both hand and machine operations
- Depths up to approx. 1 x d_1





	T404	T405
Catalogue Code	T404	T405
Discount Group	D0706	D0706
Material	HSS	HSS
Surface Finish	*TiN*	*TiN*
Sutton Designation	N	N
Geometry	-	-
Chamfer	Intermediate	Bottoming
Limit & Nut Tolerance	ISO 2 / 6H	ISO 2 / 6H

Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
0503	MF 5	x 0.5	58	16	22	5.0	4.0	7	4	4.5	•	•
0604	MF 6	x 0.75	66	19	26	6.3	5.0	8	4	5.3	•	•
0804	MF 8	x 0.75	72	22	30	8.0	6.3	9	4	7.3	•	•
0805	MF 8	x 1*	72	22	30	8.0	6.3	9	4	7.0	T404 0805	T405 0805
1004	MF 10	x 0.75	80	24	34	10.0	8.0	11	4	9.3	•	•
1005	MF 10	x 1†	80	24	34	10.0	8.0	11	4	9.0	T404 1005	T405 1005
1006	MF 10	x 1.25*	80	24	34	10.0	8.0	11	4	8.8	T404 1006	T405 1006
1205	MF 12	x 1	89	29	-	9.0	7.1	10	4	11.0	•	•
1206	MF 12	x 1.25	89	29	-	9.0	7.1	10	4	10.8	T404 1206	T405 1206
1207	MF 12	x 1.5*	89	29	-	9.0	7.1	10	4	10.5	T404 1207	T405 1207
1405	MF 14	x 1	95	30	-	11.2	9.0	12	4	13.0		•
1406	MF 14	x 1.25†	95	30	-	11.2	9.0	12	4	12.8	T404 1406	T405 1406
1407	MF 14	x 1.5*	95	30	-	11.2	9.0	12	4	12.5	T404 1407	T405 1407
1605	MF 16	x 1	102	32	-	12.5	10.0	13	4	15.0		•
1606	MF 16	x 1.25	102	32	-	12.5	10.0	13	4	14.8		•
1607	MF 16	x 1.5*	102	32	-	12.5	10.0	13	4	14.5	•	T405 1607
1806	MF 18	x 1.25	112	37	-	14.0	11.2	14	4	16.8		•
1807	MF 18	x 1.5*	112	37	-	14.0	11.2	14	4	16.5	•	•
2006	MF 20	x 1.25	112	37	-	14.0	11.2	14	4	18.8		•
2007	MF 20	x 1.5**	112	37	-	14.0	11.2	14	4	18.5	•	•
2008	MF 20	x 2*	112	37	-	14.0	11.2	14	4	18.0		•
2207	MF 22	x 1.5	118	38	-	16.0	12.5	16	4	20.5	•	•
2208	MF 22	x 2	118	38	-	16.0	12.5	16	4	20.0		•
2407	MF 24	x 1.5	130	45	-	18.0	14.0	18	4	22.5		•
2408	MF 24	x 2*	130	45	-	18.0	14.0	18	4	22.0	•	•
2507	MF 25	x 1.5**	130	45	-	18.0	14.0	18	4	23.5	•	•
2708	MF 27	x 2	135	45	-	20.0	16.0	20	4	25.0		•
3007	MF 30	x 1.5	138	48	-	20.0	16.0	20	4	28.5	•	
3008	MF 30	x 2	138	48	-	20.0	16.0	20	4	28.0	•	•
3207	MF 32	x 1.5**	151	51	-	22.4	18.0	22	4	30.5	•	•
4007	MF 40	x 1.5**	170	60	-	28.0	22.4	26	4	38.5	•	•
	Spark Plug											
1005	MF 10	x 1†	80	24	34	10.0	8.0	11	4	9.0	T404 1005	T405 1005
1206	MF 12	x 1.25	89	29	-	9.0	7.1	10	4	10.8	T404 1206	T405 1206
1406	MF 14	x 1.25†	95	30	-	11.2	9.0	12	4	12.8	T404 1406	T405 1406
1807	MF 18	x 1.5	112	37	-	14.0	11.2	14	4	16.5		

ISO	P												M			K						N										S													H					
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T404	●	●	●	●	○	●	●	○		○		○		○			○		○		○		○	○	○	○		○	○	○																		

P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials

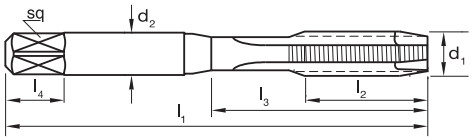
● Optimal ○ Effective

* Alternative Metric Fine ** Conduit Metric • Available on request as special manufacture. Subject to lead time. † Limit & Nut Tolerance: ISO 1 / 4H

suttontools

- General purpose use
- Suitable for materials up to 1000N/mm²
- Through holes
- Depths up to approx. 3 x d_1

ISO 529 | 60° MF



	T406	T407	T408
Catalogue Code	T406	T407	T408
Discount Group	D0702	D0702	D0706
Material	HSSE	HSSE	HSSE
Surface Finish	*Brt*	*Blu*	*TiN*
Sutton Designation	N	N	N
Geometry	-	-	-
Chamfer	Intermediate	Intermediate	Intermediate
Limit & Nut Tolerance	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H

Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #	Item #
0503	MF 5	x 0.5	58	16	22	5.0	4.0	7	3	4.5	•	T407 0503	•
0604	MF 6	x 0.75	66	19	26	6.3	5.0	8	3	5.3	•	T407 0604	•
0805	MF 8	x 1	72	22	30	8.0	6.3	9	3	7.0	T406 0805	T407 0805	T408 0805
1005	MF 10	x 1	80	24	34	10.0	8.0	11	3	9.0	•	T407 1005	•
1006	MF 10	x 1.25	80	24	34	10.0	8.0	11	3	8.8	T406 1006	T407 1006	T408 1006
1206	MF 12	x 1.25	89	29	-	9.0	7.1	10	3	10.8	•	T407 1206	•
1207	MF 12	x 1.5	89	29	-	9.0	7.1	10	3	10.5	T406 1207	T407 1207	T408 1207
1407	MF 14	x 1.5	95	30	-	11.2	9.0	12	3	12.5	•	T407 1407	•
1607	MF 16	x 1.5	102	32	-	12.5	10.0	13	3	14.5	•	T407 1607	•
1807	MF 18	x 1.5	112	37	-	14.0	11.2	14	4	16.5	•	T407 1807	•
2007	MF 20	x 1.5	112	37	-	14.0	11.2	14	4	18.5	•	T407 2007	•
2207	MF 22	x 1.5	118	38	-	16.0	12.5	16	4	20.5	•	T407 2207	•

ISO	P													M			K						N										S															H					
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T406	●	●	○	○		●	○							○	○				○	○	○		○	○	○	○		●	○																			○	
T407	●	●	●	●		●	○					○		○	○				○	○	○																											○	
T408	●	●	●	●	○	●	●	○		○		○	○	○	○				○	○	○		○	○	○	○	○	○	○																			○	

P Steel | M Stainless Steel | K Cast Iron | N Non-Ferrous Metals | S Titanium & Super Alloys | H Hard Materials

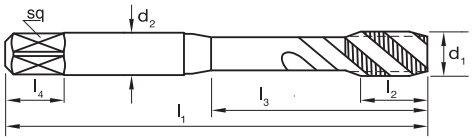
● Optimal ○ Effective

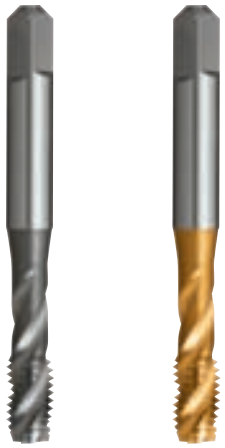
• Available on request as special manufacture. Subject to lead time.

suttontools

- General purpose use
- Suitable for materials up to 1000N/mm²
- Blind holes
- Depths up to approx. 2.5 x d_1

ISO 529 | DIN 2197 | 60° MF





	T409	T411
Catalogue Code	T409	T411
Discount Group	D0702	D0706
Material	HSSE	HSSE
Surface Finish	*Brt*	*TiN*
Sutton Designation	N	N
Geometry	-	-
Chamfer	Bottoming	Bottoming
Limit & Nut Tolerance	ISO 2 / 6H	ISO 2 / 6H

Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
0503	MF 5	x 0.5	58	16	22	5.0	4.0	7	3	4.5	T409 0503	•
0604	MF 6	x 0.75	66	19	26	6.3	5.0	8	3	5.3	T409 0604	•
0805	MF 8	x 1	72	22	30	8.0	6.3	9	3	7.0	T409 0805	T411 0805
1005	MF 10	x 1	80	24	34	10.0	8.0	11	3	9.0	T409 1005	•
1006	MF 10	x 1.25	80	24	34	10.0	8.0	11	3	8.8	T409 1006	T411 1006
1206	MF 12	x 1.25	89	29	-	9.0	7.1	10	3	10.8	T409 1206	•
1207	MF 12	x 1.5	89	29	-	9.0	7.1	10	3	10.5	T409 1207	T411 1207
1406	MF 14	x 1.25	95	30	-	11.2	9.0	12	3	12.8	T409 1406	•
1407	MF 14	x 1.5	95	30	-	11.2	9.0	12	3	12.5	T409 1407	•
1607	MF 16	x 1.5	102	32	-	12.5	10.0	13	3	14.5	T409 1607	•
1807	MF 18	x 1.5	112	37	-	14.0	11.2	14	4	16.5	T409 1807	•
2007	MF 20	x 1.5	112	37	-	14.0	11.2	14	4	18.5	T409 2007	•
2207	MF 22	x 1.5	118	38	-	16.0	12.5	16	4	20.5	T409 2207	•

ISO	P													M			K					N									S													H					
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T409	●	●	○	○		●								○	○				○	○			○	○	○	○		●	○	○																		○	
T411	●	●	●	●	○	●	●	○		○		○	○	○	○				○	○			○	○	○	○	○		○																			○	

P Steel | M Stainless Steel | K Cast Iron | N Non-Ferrous Metals | S Titanium & Super Alloys | H Hard Materials

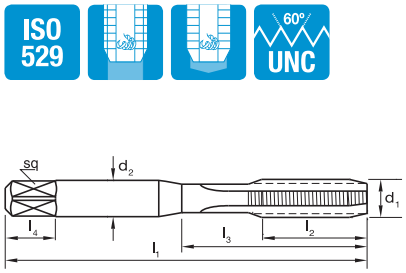
● Optimal ○ Effective

• Available on request as special manufacture. Subject to lead time.

ISO Taps UNC, Straight Flute, N

suttontools

- General purpose use
- Suitable for materials up to 1000N/mm²
- Through & blind holes
- Suitable for both hand and machine operations
- Depths up to approx. 1 x d_1



	T414	T415	T416	T903
Catalogue Code	T414	T415	T416	T903
Discount Group	D0702	D0702	D0702	D0702
Material	HSS	HSS	HSS	HSS
Surface Finish	*Brt*	*Brt*	*Brt*	*Brt*
Sutton Designation	N	N	N	N
Geometry	-	-	-	-
Chamfer	Taper	Intermediate	Bottoming	Set
Limit & Nut Tolerance	2B	2B	2B	2B

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	Limit	Item #	Item #	Item #	Item #
0251	#3	48	45	10	-	2.80	2.24	5	3	GH2	T414 0251	T415 0251	T416 0251	•
0284	#4	40	48	15	14.5	3.15	2.50	5	3	GH2	T414 0284	T415 0284	T416 0284	T903 0284
0318	#5	40	48	15	15	3.15	2.50	5	3	GH2	T414 0318	T415 0318	T416 0318	T903 0318
0351	#6	32	50	17	17.5	3.55	2.80	5	3	GH3	T414 0351	T415 0351	T416 0351	T903 0351
0417	#8	32	53	13	17	4.50	3.55	6	3	GH3	T414 0417	T415 0417	T416 0417	T903 0417
0476	3/16	24 (UNS)	58	16	22	5.00	4.00	7	3	GH4	T414 0476	T415 0476	T416 0476	T903 0476
0483	#10	24	58	16	22	5.00	4.00	7	3	GH4	T414 0483	T415 0483	T416 0483	T903 0483
0549	#12	24	62	17	23	5.60	4.50	7	3	GH4	T414 0549	T415 0549	T416 0549	T903 0549
0635	1/4	20	66	19	25	6.30	5.00	8	3	GH4	T414 0635	T415 0635	T416 0635	T903 0635
0636	1/4*	20	66	19	25	6.30	5.00	8	3	GH3	•	•	T416 0636	•
0794	5/16*	18	72	22	30	8.00	6.30	9	4	GH5	•	•	T416 0794	•
0795	5/16	18	72	22	30	8.00	6.30	9	4	GH3	T414 0794	T415 0794	T416 0795	T903 0794
0953	3/8	16	80	24	33	10.00	8.00	11	4	GH5	T414 0953	T415 0953	T416 0953	T903 0953
1111	7/16	14	85	25	-	8.00	6.30	9	4	GH3	T414 1111	T415 1111	T416 1111	T903 1111
1270	1/2	13	89	29	-	9.00	7.10	10	4	GH6	T414 1270	T415 1270	T416 1270	T903 1270
1429	9/16	12	95	30	-	11.20	9.00	12	4	GH6	T414 1429	T415 1429	T416 1429	T903 1429
1588	5/8	11	102	32	-	12.50	10.00	13	4	GH6	T414 1588	T415 1588	T416 1588	T903 1588
1905	3/4	10	112	37	-	14.00	11.20	14	4	GH7	T414 1905	T415 1905	T416 1905	T903 1905
2223	7/8	9	118	38	-	16.00	12.50	16	4	GH7	T414 2223	T415 2223	T416 2223	T903 2223
2540	1	8	130	45	-	18.00	14.00	18	4	GH7	T414 2540	T415 2540	T416 2540	T903 2540
2858	1-1/8	7	138	48	-	20.00	16.00	20	4	GH8	T414 2858	T415 2858	T416 2858	•
3175	1-1/4	7	151	51	-	22.40	18.00	22	4	GH8	T414 3175	T415 3175	T416 3175	T903 3175
3810	1-1/2	6	170	60	-	28.00	22.40	26	4	GH8	T414 3810	T415 3810	T416 3810	T903 3810

ISO	P													M			K						N									S														H					
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T414	●	●	●	●		●	○										○		○		○		○	○	○	○		○		○																					

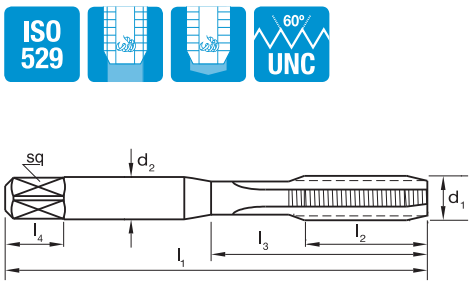
P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials

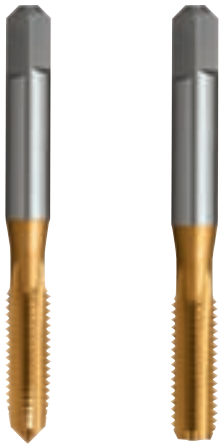
● Optimal ○ Effective

* Alternative Limit • Available on request as special manufacture. Subject to lead time.

suttontools

- General purpose use
- Suitable for materials up to 1000N/mm²
- Through & blind holes
- Suitable for both hand and machine operations
- Depths up to approx. 1 x d_1





	T417	T418
Catalogue Code	T417	T418
Discount Group	D0706	D0706
Material	HSS	HSS
Surface Finish	*TiN*	*TiN*
Sutton Designation	N	N
Geometry	-	-
Chamfer	Intermediate	Bottoming
Limit & Nut Tolerance	2B	2B

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	Limit	drill Ø	Item #	Item #
0251	#3	48	45	10	-	2.80	2.24	5	3	GH2	2.1	•	•
0284	#4	40	48	15	14.5	3.15	2.50	5	3	GH2	2.3	•	•
0318	#5	40	48	15	15	3.15	2.50	5	3	GH2	2.6	•	•
0351	#6	32	50	17	17.5	3.55	2.80	5	3	GH3	2.8	T417 0351	T418 0351
0417	#8	32	53	13	18	4.50	3.55	6	3	GH3	3.4	T417 0417	T418 0417
0476	3/16	24 (UNS)	58	16	22	5.00	4.00	7	3	GH4	3.7	•	•
0483	#10	24	58	16	22	5.00	4.00	7	3	GH4	3.8	T417 0483	T418 0483
0549	#12	24	62	17	23	5.60	4.50	7	3	GH4	4.5	•	•
0635	1/4	20	66	19	25	6.30	5.00	8	3	GH4	5.1	T417 0635	T418 0635
0636	1/4*	20	66	19	25	6.30	5.00	8	3	GH3	5.1		•
0794	5/16*	18	72	22	30	8.00	6.30	9	4	GH3	6.6		•
0795	5/16	18	72	22	30	8.00	6.30	9	4	GH5	6.6	T417 0794	T418 0794
0953	3/8	16	80	24	33	10.00	8.00	11	4	GH5	8.0	T417 0953	T418 0953
1111	7/16	14	85	25	-	8.00	6.30	9	4	GH3	9.4	T417 1111	T418 1111
1270	1/2	13	89	29	-	9.00	7.10	10	4	GH6	10.8	T417 1270	T418 1270
1429	9/16	12	95	30	-	11.20	9.00	12	4	GH6	12.2	•	•
1588	5/8	11	102	32	-	12.50	10.00	13	4	GH6	13.5	T417 1588	T418 1588
1905	3/4	10	112	37	-	14.00	11.20	14	4	GH7	16.5	T417 1905	T418 1905
2223	7/8	9	118	38	-	16.00	12.50	16	4	GH7	19.5	•	•
2540	1	8	130	45	-	18.00	14.00	18	4	GH7	22.2	•	•
2858	1-1/8	7	138	48	-	20.00	16.00	20	4	GH8	25.0	•	•
3175	1-1/4	7	151	51	-	22.40	18.00	22	4	GH8	28.0	•	•
3810	1-1/2	6	170	60	-	28.00	22.40	26	4	GH8	34.0	•	•

ISO	P												M			K						N									S												H					
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T417	●	●	●	●	○	●	●	○		○		○		○			○		○		○		○	○	○	○		○	○	○																		

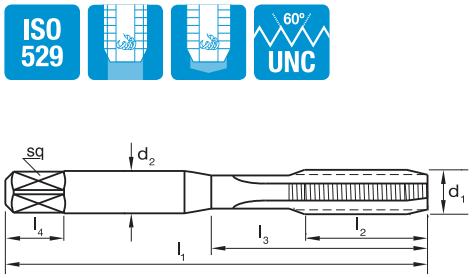
P Steel M Stainless Steel Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials

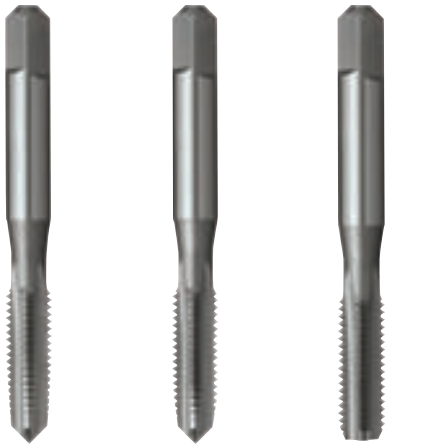
● Optimal ○ Effective

* Alternative Limit • Available on request as special manufacture. Subject to lead time.

suttontools

- General purpose use
- Suitable for materials up to 1000N/mm²
- Through & blind holes
- Suitable for both hand and machine operations
- Depths up to approx. 1 x d_1





	T419	T420	T421
Catalogue Code	T419	T420	T421
Discount Group	D0702	D0702	D0702
Material	HSS	HSS	HSS
Surface Finish	*Brt*	*Brt*	*Brt*
Sutton Designation	N	N	N
Geometry	Left Hand	Left Hand	Left Hand
Chamfer	**Taper**	**Intermediate**	**Bottoming**
Nut Tolerance	2B LH	2B LH	2B LH

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	Limit	drill Ø	Item #	Item #	Item #
0635	1/4	20	66	19	25	6.30	5.00	8	3	GH4	5.1	T419 0635	T420 0635	T421 0635
0794	5/16	18	72	22	30	8.00	6.30	9	4	GH5	6.6	T419 0794	T420 0794	T421 0794
0953	3/8	16	80	24	33	10.00	8.00	11	4	GH5	8.0	T419 0953	T420 0953	T421 0953
1111	7/16	14	85	25	-	8.00	6.30	9	4	GH5	9.4	T419 1111	T420 1111	T421 1111
1270	1/2	13	89	29	-	9.00	7.10	10	4	GH6	10.8	T419 1270	T420 1270	T421 1270
1429	9/16	12	95	30	-	11.20	9.00	12	4	GH6	12.2	T419 1429	T420 1429	T421 1429
1588	5/8	11	102	32	-	12.50	10.00	13	4	GH6	13.5	T419 1588	T420 1588	T421 1588
1905	3/4	10	112	37	-	14.00	11.20	14	4	GH7	16.5	T419 1905	T420 1905	T421 1905
2223	7/8	9	118	38	-	16.00	12.50	16	4	GH7	19.5	•	•	•
2540	1	8	130	45	-	18.00	14.00	18	4	GH7	22.2	•	•	•
2858	1-1/8	7	138	48	-	20.00	16.00	20	4	GH8	25.0	•	•	•
3175	1-1/4	7	151	51	-	22.40	18.00	22	4	GH8	28.0	•	•	•
3810	1-1/2	6	170	60	-	28.00	22.40	26	4	GH8	34.0	•	•	•

ISO	P													M			K						N								S													H					
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T419	●	●	●	●		●	○										○		○		○		○	○	○	○		○		○																			

P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials

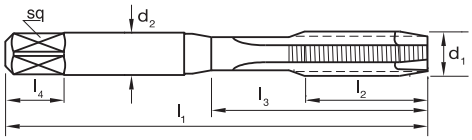
● Optimal ○ Effective

• Available on request as special manufacture. Subject to lead time.

suttontools

- General purpose use
- Suitable for materials up to 1000N/mm²
- Through holes
- Depths up to approx. 3 x d_1

ISO 529 | 60° UNC



	T422	T423	T424
Catalogue Code	T422	T423	T424
Discount Group	D0702	D0702	D0706
Material	HSSE	HSSE	HSSE
Surface Finish	*Brt*	*Blu*	*TiN*
Sutton Designation	N	N	N
Geometry	-	-	-
Chamfer	Intermediate	Intermediate	Intermediate
Nut Tolerance	2B	2B	2B

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	Limit	drill Ø	Item #	Item #	Item #
0284	#4	40	48	15	14.5	3.15	2.50	5	2	GH2	2.3	T422 0284	T423 0284	•
0351	#6	32	50	17	17.5	3.55	2.80	5	3	GH3	2.8	T422 0351	T423 0351	T424 0351
0417	#8	32	53	13	18	4.50	3.55	6	3	GH3	3.4	T422 0417	T423 0417	T424 0417
0483	#10	24	58	16	22	5.00	4.00	7	3	GH4	3.8	T422 0483	T423 0483	T424 0483
0549	#12	24	62	17	23	5.60	4.50	7	3	GH4	4.5	•	T423 0549	•
0635	1/4	20	66	19	25	6.30	5.00	8	3	GH4	5.1	T422 0635	T423 0635	T424 0635
0794	5/16	18	72	22	30	8.00	6.30	9	3	GH5	6.6	T422 0794	T423 0794	T424 0794
0953	3/8	16	80	24	33	10.00	8.00	11	3	GH5	8.0	T422 0953	T423 0953	T424 0953
1111	7/16	14	85	25	-	8.00	6.30	9	3	GH5	9.4	T422 1111	T423 1111	•
1270	1/2	13	89	29	-	9.00	7.10	10	3	GH6	10.8	T422 1270	T423 1270	T424 1270
1588	5/8	11	102	32	-	12.50	10.00	13	3	GH6	13.5	T422 1588	T423 1588	T424 1588
1905	3/4	10	112	37	-	14.00	11.20	14	4	GH7	16.5	T422 1905	T423 1905	T424 1905
2223	7/8	9	118	38	-	16.00	12.50	16	4	GH7	19.5	•	T423 2223	•
2540	1	8	130	45	-	18.00	14.00	18	4	GH7	22.2	•	T423 2540	•

ISO	P													M			K				N									S												H					
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T422	●	●	○	○		●	○							○	○				○	○	○		○	○	○	○		●	○																		○	
T423	●	●	●	●		●	○					○		○	○				○	○	○																										○	
T424	●	●	●	●	○	●	●	○		○		○	○	○	○				○	○	○		○	○	○	○	○	○	○																		○	

P Steel | M Stainless Steel | K Cast Iron | N Non-Ferrous Metals | S Titanium & Super Alloys | H Hard Materials

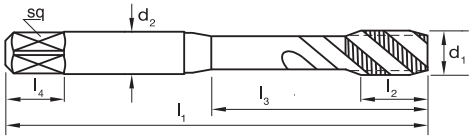
● Optimal ○ Effective

• Available on request as special manufacture. Subject to lead time.

suttontools

- General purpose use
- Suitable for materials up to 1000N/mm²
- Blind holes
- Depths up to approx. 2.5 x d_1

ISO 529 | 60° UNC



Catalogue Code	T425	T426	T427
Discount Group	D0702	D0702	D0706
Material	HSSE	HSSE	HSSE
Surface Finish	*Brt*	*Blu*	*TiN*
Sutton Designation	N	N	N
Geometry	-	-	-
Chamfer	Bottoming	Bottoming	Bottoming
Nut Tolerance	2B	2B	2B

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	Limit	drill Ø	Item #	Item #	Item #
0218	#2	56	41	8	-	2.5	2.0	-	2	GH2	1.85	T425 0218	•	•
0284	#4	40	48	6	-	3.15	2.50	5	3	GH2	2.3	T425 0284	•	•
0351	#6	32	50	6	-	3.55	2.80	5	3	GH3	2.8	T425 0351	•	•
0417	#8	32	53	8	18	4.50	3.55	6	3	GH3	3.4	T425 0417	•	•
0483	#10	24	58	11	22	5.00	4.00	7	3	GH4	3.8	T425 0483	•	T427 0483
0635	1/4	20	66	10	25	6.30	5.00	8	3	GH4	5.1	T425 0635	T426 0635	T427 0635
0794	5/16	18	72	13	30	8.00	6.30	9	3	GH5	6.6	T425 0794	T426 0794	T427 0794
0953	3/8	16	80	16	33	10.00	8.00	11	3	GH5	8.0	T425 0953	T426 0953	T427 0953
1111	7/16	14	85	18	-	8.00	6.30	9	3	GH5	9.4	T425 1111	T426 1111	T427 1111
1270	1/2	13	89	20	-	9.00	7.10	10	3	GH6	10.8	T425 1270	T426 1270	T427 1270
1588	5/8	11	102	20	-	12.50	10.00	13	3	GH6	13.5	T425 1588	T426 1588	T427 1588
1905	3/4	10	112	25	-	14.00	11.20	14	4	GH7	16.5	T425 1905	T426 1905	T427 1905
2223	7/8	9	118	38	-	16.00	12.50	16	4	GH7	19.5	T425 2223	•	•
2540	1	8	130	45	-	18.00	14.00	18	4	GH7	22.2	T425 2540	•	•

ISO	P													M			K						N									S													H					
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T425	●	●	○	○		●								○	○				○	○			○	○	○	○		●	○	○																			○	
T426	●	●	●	●		●	○					○		○	○				○	○																												○	
T427	●	●	●	●	○	●	●	○		○		○	○	○	○				○	○			○	○	○	○	○		○																			○	

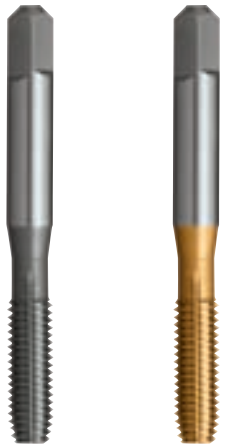
P Steel | M Stainless Steel | K Cast Iron | N Non-Ferrous Metals | S Titanium & Super Alloys | H Hard Materials

● Optimal ○ Effective

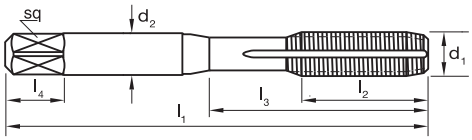
• Available on request as special manufacture. Subject to lead time.

suttontools

- For cold forming of threads in materials with good flow characteristics
- Through or blind holes
- Depths up to approx. 1.5 x d_1
- TiN for longer tool life



ISO 529 | 60° UNC



	T428	T429
Catalogue Code	T428	T429
Discount Group	D0702	D0706
Material	HSSE	HSSE
Surface Finish	*Brt*	*TiN*
Sutton Designation	N	N
Geometry	Single Coolant Groove	Single Coolant Groove
Chamfer	Short	Short
Nut Tolerance	2B	2B

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	Limit	drill Ø	Item #	Item #
0318	#5	40	48	15	15	3.15	2.50	5	-	GH5	2.9	T428 0318	•
0351	#6	32	50	17	17.5	3.55	2.80	5	-	GH6	3.2	T428 0351	T429 0351
0417	#8	32	53	13	18	4.50	3.55	6	-	GH6	3.8	T428 0417	T429 0417
0483	#10	24	58	16	22	5.00	4.00	7	-	GH6	4.4	T428 0483	T429 0483
0635	1/4	20	66	19	25	6.30	5.00	8	-	GH7	5.8	T428 0635	T429 0635
0794	5/16	18	72	22	30	8.00	6.30	9	-	GH7	7.3	T428 0794	•
0953	3/8	16	80	24	33	10.00	8.00	11	-	GH7	8.8	T428 0953	•
1270	1/2	13	89	29	-	9.00	7.10	10	-	GH8	11.7	T428 1270	•

ISO	P													M			K							N								S														H					
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T428	●	●	○	○		●																	●	●	●	●		●		○																				
T429	●	●	○	○		●	○							○									●	●	○	○		●		○																				

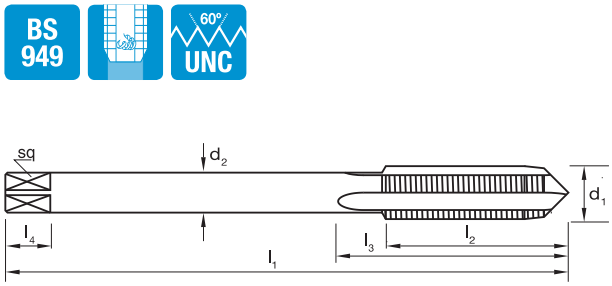
P Steel | M Stainless Steel | K Cast Iron | N Non-Ferrous Metals | S Titanium & Super Alloys | H Hard Materials

● Optimal ○ Effective

• Available on request as special manufacture. Subject to lead time.

suttontools

- Suited to long reach applications
- Suitable for materials up to 1000N/mm²
- Through holes
- Depths up to approx. 2 x d_1



Catalogue Code	T430
Discount Group	D0702
Material	HSS
Surface Finish	*Brt*
Sutton Designation	Nut
Geometry	Extra Length
Chamfer	Bottoming
Nut Tolerance	2B

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	Limit	drill Ø	Item #
0635	1/4	20	110	38	-	4.5	3.55	6	4	GH4	5.1	T430 0635
0794	5/16	18	125	43	-	6	4.5	7	4	GH5	6.6	T430 0794
0953	3/8	16	140	48	-	7	5.6	8	4	GH5	8.0	T430 0953
1270	1/2	13	180	59	-	9.5	7.5	10	4	GH6	10.8	T430 1270

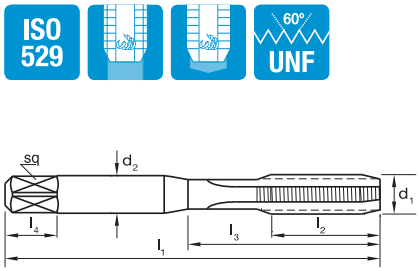
ISO	P													M			K						N									S														H					
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T430	●	●	●	●		●	○							○			○		○		○		○	○	○	○		○		○																					

P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials

● Optimal ○ Effective

suttontools

- General purpose use
- Suitable for materials up to 1000N/mm²
- Through & blind holes
- Suitable for both hand and machine operations
- Depths up to approx. 1 x d_1



	T431	T432	T433	T904
Catalogue Code	T431	T432	T433	T904
Discount Group	D0702	D0702	D0702	D0702
Material	HSS	HSS	HSS	HSS
Surface Finish	*Brt*	*Brt*	*Brt*	*Brt*
Sutton Designation	N	N	N	N
Geometry	-	-	-	-
Chamfer	Taper	Intermediate	Bottoming	Set
Nut Tolerance	2B	2B	2B	2B

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #	Item #	Item #
0251	#3	56	45	10	-	2.80	2.24	5	3	2.1	T431 0251	T432 0251	T433 0251	•
0284	#4	48	48	15	14.5	3.15	2.50	5	3	2.35	T431 0284	T432 0284	T433 0284	T904 0284
0318	#5	44	48	15	15	3.15	2.50	5	3	2.65	T431 0318	T432 0318	T433 0318	T904 0318
0351	#6	40	50	17	17.5	3.55	2.80	5	3	2.9	T431 0351	T432 0351	T433 0351	T904 0351
0417	#8	36	53	13	17	4.50	3.55	6	3	3.5	T431 0417	T432 0417	T433 0417	T904 0417
0476	3/16	32 (UNS)	58	16	22	5.00	4.00	7	3	4.0	T431 0476	T432 0476	T433 0476	T904 0476
0483	#10	32	58	16	22	5.00	4.00	7	3	4.1	T431 0483	T432 0483	T433 0483	T904 0483
0549	#12	28	62	17	23	5.60	4.50	7	3	4.6	T431 0549	T432 0549	T433 0549	T904 0549
0635	1/4	28	66	19	25	6.30	5.00	8	3	5.5	T431 0635	T432 0635	T433 0635	T904 0635
0794	5/16	24	72	22	30	8.00	6.30	9	4	6.9	T431 0794	T432 0794	T433 0794	T904 0794
0953	3/8	24	80	24	33	10.00	8.00	11	4	8.5	T431 0953	T432 0953	T433 0953	T904 0953
1111	7/16	20	85	25	-	8.00	6.30	9	4	9.8	T431 1111	T432 1111	T433 1111	T904 1111
1270	1/2	20	89	29	-	9.00	7.10	10	4	11.5	T431 1270	T432 1270	T433 1270	T904 1270
1429	9/16	18	95	30	-	11.20	9.00	12	4	12.8	T431 1429	T432 1429	T433 1429	T904 1429
1588	5/8	18	102	32	-	12.50	10.00	13	4	14.5	T431 1588	T432 1588	T433 1588	T904 1588
1905	3/4	16	112	37	-	14.00	11.20	14	4	17.5	T431 1905	T432 1905	T433 1905	T904 1905
2223	7/8	14	118	38	-	16.00	12.50	16	4	20.5	T431 2223	T432 2223	T433 2223	T904 2223
2540	1	12	130	45	-	18.00	14.00	18	4	23.5	T431 2540	T432 2540	T433 2540	T904 2540
2541	1	14 (UNS)	130	45	-	18.00	14.00	18	4	24.0	T431 2541	T432 2541	T433 2541	T904 2541
2858	1-1/8	12	138	48	-	20.00	16.00	20	4	26.5	T431 2858	T432 2858	T433 2858	•
3175	1-1/4	12	151	51	-	22.40	18.00	22	4	29.5	T431 3175	T432 3175	T433 3175	•
3810	1-1/2	12	170	60	-	28.00	22.40	26	4	36.0	T431 3810	T432 3810	T433 3810	•

ISO	P													M			K						N									S														H					
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T431	●	●	●	●		●	○										○		○		○		○	○	○	○		○		○																					

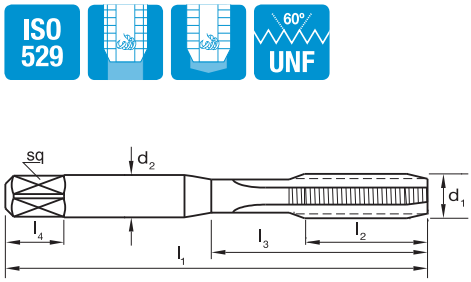
P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials

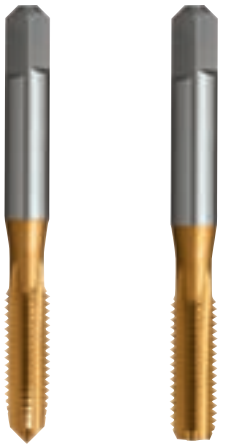
● Optimal ○ Effective

• Available on request as special manufacture. Subject to lead time.

suttontools

- General purpose use
- Suitable for materials up to 1000N/mm²
- Through & blind holes
- Suitable for both hand and machine operations
- Depths up to approx. 1 x d_1





	T434	T435
Catalogue Code	T434	T435
Discount Group	D0706	D0706
Material	HSS	HSS
Surface Finish	TiN	TiN
Sutton Designation	N	N
Geometry	-	-
Chamfer	Intermediate	Bottoming
Nut Tolerance	2B	2B

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	Limit	drill Ø	Item #	Item #
0251	#3	56	45	10	-	2.80	2.24	5	3	GH2	2.1	•	•
0284	#4	48	48	15	14.5	3.15	2.50	5	3	GH2	2.35	•	•
0318	#5	44	48	15	15	3.15	2.50	5	3	GH2	2.65	•	•
0351	#6	40	50	17	17.5	3.55	2.80	5	3	GH2	2.9	•	•
0417	#8	36	53	13	18	4.50	3.55	6	3	GH2	3.5	•	•
0476	3/16	32 (UNS)	58	16	22	5.00	4.00	7	3	GH3	4.0	•	•
0483	#10	32	58	16	22	5.00	4.00	7	3	GH3	4.1	T434 0483	T435 0483
0549	#12	28	62	17	23	5.60	4.50	7	3	GH3	4.6	•	•
0635	1/4	28	66	19	25	6.30	5.00	8	3	GH3	5.5	T434 0635	T435 0635
0794	5/16	24	72	22	30	8.00	6.30	9	4	GH4	6.9	T434 0794	T435 0794
0953	3/8	24	80	24	33	10.00	8.00	11	4	GH4	8.5	T434 0953	T435 0953
1111	7/16	20	85	25	-	8.00	6.30	9	4	GH5	9.8	T434 1111	T435 1111
1270	1/2	20	89	29	-	9.00	7.10	10	4	GH5	11.5	T434 1270	T435 1270
1429	9/16	18	95	30	-	11.20	9.00	12	4	GH5	12.8	•	•
1588	5/8	18	102	32	-	12.50	10.00	13	4	GH5	14.5	T434 1588	T435 1588
1905	3/4	16	112	37	-	14.00	11.20	14	4	GH6	17.5	T434 1905	T435 1905
2223	7/8	14	118	38	-	16.00	12.50	16	4	GH6	20.5	•	•
2540	1	12	130	45	-	18.00	14.00	18	4	GH7	23.5	•	•
2541	1	14 (UNS)	130	45	-	18.00	14.00	18	4	GH5	24.0	•	•
2858	1-1/8	12	138	48	-	20.00	16.00	20	4	GH7	26.5	•	•
3175	1-1/4	12	151	51	-	22.40	18.00	22	4	GH7	29.5	•	•
3810	1-1/2	12	170	60	-	28.00	22.40	26	4	GH7	36.0	•	•

ISO	P													M			K						N									S													H					
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T434	●	●	●	●	○	●	●	○		○		○		○			○		○		○		○	○	○	○		○	○	○																		

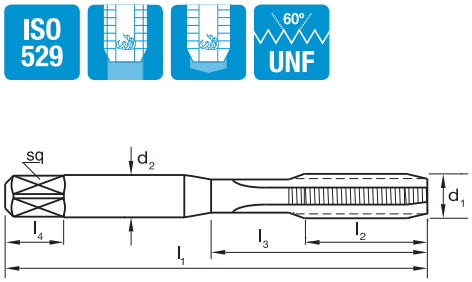
P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials

● Optimal ○ Effective

• Available on request as special manufacture. Subject to lead time.

suttontools

- General purpose use
- Suitable for materials up to 1000N/mm²
- Through & blind holes
- Suitable for both hand and machine operations
- Depths up to approx. 1 x d_1



Catalogue Code	T436	T437	T438
Discount Group	D0702	D0702	D0702
Material	HSS	HSS	HSS
Surface Finish	*Brt*	*Brt*	*Brt*
Sutton Designation	N	N	N
Geometry	Left Hand	Left Hand	Left Hand
Chamfer	Taper	Intermediate	Bottoming
Nut Tolerance	2B LH	2B LH	2B LH

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	Limit	drill Ø	Item #	Item #	Item #
0635	1/4	28	66	19	25	6.30	5.00	8	3	GH3	5.5	T436 0635	T437 0635	T438 0635
0794	5/16	24	72	22	30	8.00	6.30	9	4	GH4	6.9	T436 0794	T437 0794	T438 0794
0953	3/8	24	80	24	33	10.00	8.00	11	4	GH4	8.5	T436 0953	T437 0953	T438 0953
1111	7/16	20	85	25	-	8.00	6.30	9	4	GH5	9.8	T436 1111	T437 1111	T438 1111
1270	1/2	20	89	29	-	9.00	7.10	10	4	GH5	11.5	T436 1270	T437 1270	T438 1270
1429	9/16	18	95	30	-	11.20	9.00	12	4	GH5	12.8	T436 1429	T437 1429	T438 1429
1588	5/8	18	102	32	-	12.50	10.00	13	4	GH5	14.5	T436 1588	T437 1588	T438 1588
1905	3/4	16	112	37	-	14.00	11.20	14	4	GH6	17.5	T436 1905	T437 1905	T438 1905

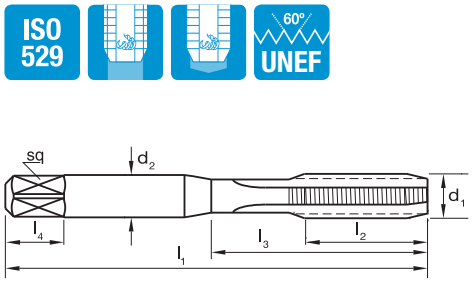
ISO	P													M			K						N									S														H					
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T436	●	●	●	●		●	○										○		○		○		○	○	○	○		○		○																					

P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials

● Optimal ○ Effective

suttontools

- General purpose use
- Suitable for materials up to 1000N/mm²
- Through & blind holes
- Suitable for both hand and machine operations
- Depths up to approx. 1 x d_1



	T445	T446	T447
Catalogue Code	T445	T446	T447
Discount Group	D0702	D0702	D0702
Material	HSS	HSS	HSS
Surface Finish	*Brt*	*Brt*	*Brt*
Sutton Designation	N	N	N
Geometry	Extra Fine	Extra Fine	Extra Fine
Chamfer	Taper	Intermediate	Bottoming
Nut Tolerance	2B	2B	2B

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	Limit	drill Ø	Item #	Item #	Item #
	UNEF Series													
0635	1/4	32	66	19	25	6.30	5.00	8	3	GH3	5.6	T445 0635	T446 0635	T447 0635
0794	5/16	32	72	22	30	8.00	6.30	9	4	GH4	7.2	T445 0794	T446 0794	T447 0794
0953	3/8	32	80	24	33	10.00	8.00	11	4	GH4	8.8	T445 0953	T446 0953	T447 0953
1270	1/2	28	89	29	-	9.00	7.10	10	4	GH5	11.8	T445 1270	T446 1270	T447 1270
1588	5/8	24	102	32	-	12.50	10.00	13	4	GH5	14.75	T445 1588	T446 1588	T447 1588
1905	3/4	20	112	37	-	14.00	11.20	14	4	GH6	18.0	T445 1905	T446 1905	T447 1905
2540	1	20	130	45	-	18.00	14.00	18	4	GH7	24.2	T445 2540	T446 2540	T447 2540
	Tyre Valve Tap (UNS)													**T489**
0533	5V1	36	62	17	23	5.60	4.50	7	3	-	4.6	•	•	T489 0533
	Stitching Tap													**T490**
0655	#1		64	36	-	8.08	6.15	9.5	4	-	5.0	•	•	T490 0655

ISO	P													M			K						N									S													H					
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T445	●	●	●	●		●	○										○		○		○		○	○	○	○		○		○																				

P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials

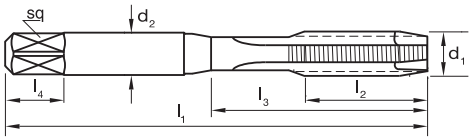
● Optimal ○ Effective

• Available on request as special manufacture. Subject to lead time.

suttontools

- General purpose use
- Suitable for materials up to 1000N/mm²
- Through holes
- Depths up to approx. 3 x d_1

ISO 529 | 60° UNF



	T439	T440	T441
Catalogue Code	T439	T440	T441
Discount Group	D0702	D0702	D0706
Material	HSSE	HSSE	HSSE
Surface Finish	*Brt*	*Blu*	*TiN*
Sutton Designation	N	N	N
Geometry	-	-	-
Chamfer	Intermediate	Intermediate	Intermediate
Nut Tolerance	2B	2B	2B

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	Limit	drill Ø	Item #	Item #	Item #
0483	#10	32	58	16	22	5.00	4.00	7	3	GH3	4.1	T439 0483	T440 0483	T441 0483
0635	1/4	28	66	19	25	6.30	5.00	8	3	GH3	5.5	T439 0635	T440 0635	T441 0635
0794	5/16	24	72	22	30	8.00	6.30	9	3	GH4	6.9	T439 0794	T440 0794	T441 0794
0953	3/8	24	80	24	33	10.00	8.00	11	3	GH4	8.5	T439 0953	T440 0953	T441 0953
1111	7/16	20	85	25	-	8.00	6.30	9	3	GH5	9.8	T439 1111	T440 1111	•
1270	1/2	20	89	29	-	9.00	7.10	10	3	GH5	11.5	T439 1270	T440 1270	T441 1270
1588	5/8	18	102	32	-	12.50	10.00	13	3	GH5	12.8	T439 1588	T440 1588	T441 1588
1905	3/4	16	112	37	-	14.00	11.20	14	4	GH6	17.5	T439 1905	T440 1905	T441 1905
2223	7/8	14	118	38	-	16.00	12.50	16	4	GH6	20.5	•	T440 2223	•
2540	1	12	130	45	-	18.00	14.00	18	4	GH7	23.5	•	T440 2540	•

ISO	P													M			K				N									S														H					
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T439	●	●	○	○		●	○							○	○				○	○	○		○	○	○	○		●	○																			○	
T440	●	●	●	●		●	○					○		○	○				○	○	○																											○	
T441	●	●	●	●	○	●	●	○		○		○	○	○	○				○	○	○		○	○	○	○	○	○	○																			○	

P Steel | M Stainless Steel | K Cast Iron | N Non-Ferrous Metals | S Titanium & Super Alloys | H Hard Materials

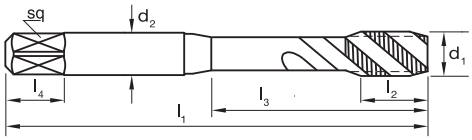
● Optimal ○ Effective

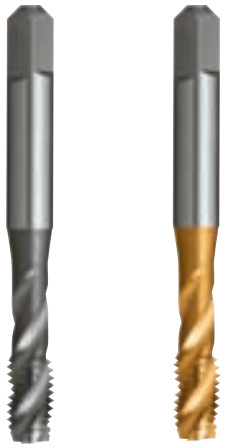
• Available on request as special manufacture. Subject to lead time.

suttontools

- General purpose use
- Suitable for materials up to 1000N/mm²
- Blind holes
- Depths up to approx. 2.5 x d_1

ISO 529 | 60° UNF





	T442	T443
Catalogue Code	T442	T443
Discount Group	D0702	D0706
Material	HSSE	HSSE
Surface Finish	*Brt*	*TiN*
Sutton Designation	N	N
Geometry	-	-
Chamfer	Bottoming	Bottoming
Nut Tolerance	2B	2B

Size Ref	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	Limit	drill Ø	Item #	Item #
0483	#10	32	58	11	22	5.00	4.00	7	3	GH3	4.1	T442 0483	T443 0483
0635	1/4	28	66	10	25	6.30	5.00	8	3	GH3	5.5	T442 0635	T443 0635
0794	5/16	24	72	13	30	8.00	6.30	9	3	GH4	6.9	T442 0794	T443 0794
0953	3/8	24	80	16	33	10.00	8.00	11	3	GH4	8.5	T442 0953	T443 0953
1111	7/16	20	85	18	-	8.00	6.30	9	3	GH5	9.8	T442 1111	•
1270	1/2	20	89	20	-	9.00	7.10	10	3	GH5	11.5	T442 1270	T443 1270
1588	5/8	18	102	20	-	12.50	10.00	13	3	GH5	12.8	T442 1588	T443 1588
1905	3/4	16	112	25	-	14.00	11.20	14	4	GH6	17.5	T442 1905	T443 1905

ISO	P													M			K						N									S														H					
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T442	●	●	○	○		●								○	○				○	○			○	○	○	○		●	○	○																			○	
T443	●	●	●	●	○	●	●	○		○		○	○	○	○				○	○			○	○	○	○	○		○																			○	

P Steel | M Stainless Steel | K Cast Iron | N Non-Ferrous Metals | S Titanium & Super Alloys | H Hard Materials

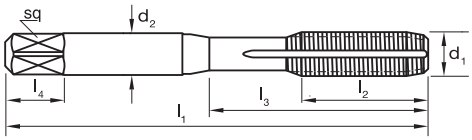
● Optimal ○ Effective

• Available on request as special manufacture. Subject to lead time.

suttontools

- For cold forming of threads in materials with good flow characteristics
- Through or blind holes
- Depths up to approx. 1.5 x d_1

ISO 529 | 60° UNF



Catalogue Code	T444
Discount Group	D0702
Material	HSSE
Surface Finish	*Brt*
Sutton Designation	N
Geometry	Single Coolant Groove
Chamfer	Short
Nut Tolerance	2B

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	Limit	drill Ø	Item #
0635	1/4	28	66	19	25	6.30	5.00	7	-	GH7	6.0	T444 0635
0794	5/16	24	72	22	30	8.00	6.30	8	-	GH7	7.5	T444 0794
0953	3/8	24	80	24	33	10.00	8.00	9	-	GH7	9.0	T444 0953
1270	1/2	20	89	29	-	9.00	7.10	10	-	GH8	12.1	T444 1270

ISO	P												M			K						N									S														H					
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T444	●	●	○	○		●																	●	●	●	●		●		○																				

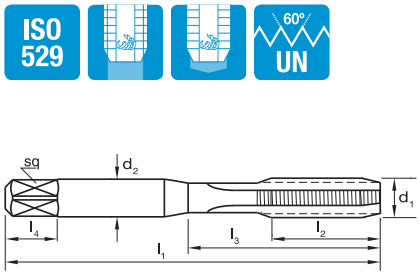
P Steel | M Stainless Steel | K Cast Iron | N Non-Ferrous Metals | S Titanium & Super Alloys | H Hard Materials

● Optimal ○ Effective

ISO Taps 8UN, Straight Flute, N

suttontools

- General purpose use
- Suitable for materials up to 1000N/mm²
- Through & blind holes
- Suitable for both hand and machine operations
- Depths up to approx. 1 x d_1



	T448	T449	T450	T910
Catalogue Code	T448	T449	T450	T910
Discount Group	D0702	D0702	D0702	D0702
Material	HSS	HSS	HSS	HSS
Surface Finish	*Brt*	*Brt*	*Brt*	*Brt*
Sutton Designation	N	N	N	N
Geometry	Extra Fine	Extra Fine	Extra Fine	Extra Fine
Chamfer	**Taper**	**Intermediate**	**Bottoming**	**Set**
Limit & Nut Tolerance	GH8/2B	GH8/2B	GH8/2B	GH8/2B

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #	Item #	Item #
2858	1-1/8	8	138	48	-	20.00	16.00	20	4	25.5	T448 2858	T449 2858	T450 2858	T910 2858
3175	1-1/4	8	151	51	-	22.40	18.00	22	4	28.5	T448 3175	T449 3175	T450 3175	T910 3175
3493	1-3/8	8	162	57	-	25.00	20.00	24	4	31.75	T448 3493	T449 3493	T450 3493	T910 3493
3810	1-1/2	8	170	60	-	28.00	22.40	26	4	35.0	T448 3810	T449 3810	T450 3810	T910 3810
4128	1-5/8	8	170	60	-	28.00	22.40	26	4	38.0	T448 4128	T449 4128	T450 4128	T910 4128
4445	1-3/4	8	187	67	-	31.50	25.00	28	4	41.5	T448 4445	T449 4445	T450 4445	T910 4445
4763	1-7/8	8	187	67	-	31.50	25.00	28	4	44.5	T448 4763	T449 4763	T450 4763	T910 4763
5080	2	8	200	70	-	35.50	28.00	31	4	47.5	T448 5080	T449 5080	T450 5080	T910 5080
6033	2-3/8	8	221	76	-	40.00	31.50	34	6	57.15	•	•	•	•

ISO	P													M			K						N									S														H					
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T448	●	●	●	●		●	○										○		○		○		○	○	○	○		○		○																					

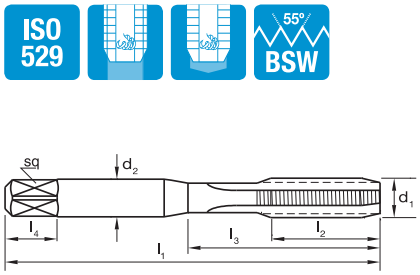
P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials

● Optimal ○ Effective

• Available on request as special manufacture. Subject to lead time.

suttontools

- General purpose use
- Suitable for materials up to 1000N/mm²
- Through & blind holes
- Suitable for both hand and machine operations
- Depths up to approx. 1 x d_1



	T451	T452	T453	T905
Catalogue Code	T451	T452	T453	T905
Discount Group	D0702	D0702	D0702	D0702
Material	HSS	HSS	HSS	HSS
Surface Finish	*Brt*	*Brt*	*Brt*	*Brt*
Sutton Designation	N	N	N	N
Geometry	-	-	-	-
Chamfer	Taper	Intermediate	Bottoming	Set
Limit & Nut Tolerance	Z3 Medium	Z3 Medium	Z3 Medium	Z3 Medium

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #	Item #	Item #
0238	3/32	48(WHIT)	45	10	-	2.80	2.24	5	3	1.85	T451 0238	T452 0238	T453 0238	T905 0238
0318	1/8	40	48	15	15	3.15	2.50	5	3	2.55	T451 0318	T452 0318	T453 0318	T905 0318
0397	5/32	32(WHIT)	53	17	17	4.00	3.15	6	3	3.2	T451 0397	T452 0397	T453 0397	T905 0397
0476	3/16	24	58	16	22	5.00	4.00	7	3	3.7	T451 0476	T452 0476	T453 0476	T905 0476
0556	7/32	24(WHIT)	62	17	23	5.60	4.50	7	3	4.5	T451 0556	T452 0556	T453 0556	T905 0556
0635	1/4	20	66	19	25	6.30	5.00	8	3	5.1	T451 0635	T452 0635	T453 0635	T905 0635
0794	5/16	18	72	22	30	8.00	6.30	9	4	6.5	T451 0794	T452 0794	T453 0794	T905 0794
0953	3/8	16	80	24	33	10.00	8.00	11	4	7.9	T451 0953	T452 0953	T453 0953	T905 0953
1111	7/16	14	85	25	-	8.00	6.30	9	4	9.3	T451 1111	T452 1111	T453 1111	T905 1111
1270	1/2	12	89	29	-	9.00	7.10	10	4	10.5	T451 1270	T452 1270	T453 1270	T905 1270
1429	9/16	12	95	30	-	11.20	9.00	12	4	12.1	T451 1429	T452 1429	T453 1429	T905 1429
1588	5/8	11	102	32	-	12.50	10.00	13	4	13.5	T451 1588	T452 1588	T453 1588	T905 1588
1905	3/4	10	112	37	-	14.00	11.20	14	4	16.25	T451 1905	T452 1905	T453 1905	T905 1905
2223	7/8	9	118	38	-	16.00	12.50	16	4	19.25	T451 2223	T452 2223	T453 2223	T905 2223
2540	1	8	130	45	-	18.00	14.00	18	4	22.0	T451 2540	T452 2540	T453 2540	T905 2540
2858	1-1/8	7	138	48	-	20.00	16.00	20	4	24.75	T451 2858	T452 2858	T453 2858	•
3175	1-1/4	7	151	51	-	22.40	18.00	22	4	28.0	T451 3175	T452 3175	T453 3175	•
3810	1-1/2	6	170	60	-	28.00	22.40	26	4	33.5	T451 3810	T452 3810	T453 3810	•
4445	1-3/4	5	187	67	-	31.50	25.00	28	4	39.0	T451 4445	T452 4445	T453 4445	•
5080	2	4-1/2	200	70	-	35.50	28.00	31	4	44.5	T451 5080	T452 5080	T453 5080	•

ISO	P												M			K					N								S												H				
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T451	●	●	●	●		●	○										○		○		○		○	○	○	○		○		○																	

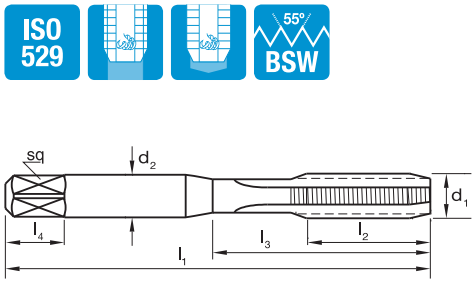
P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials

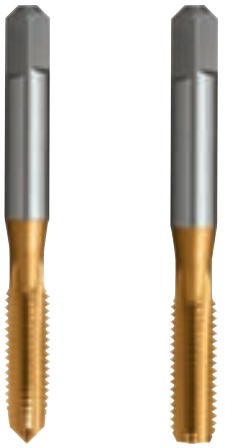
● Optimal ○ Effective

• Available on request as special manufacture. Subject to lead time.

suttontools

- General purpose use
- Suitable for materials up to 1000N/mm²
- Through & blind holes
- Suitable for both hand and machine operations
- Depths up to approx. 1 x d_1





	T454	T455
Catalogue Code	T454	T455
Discount Group	D0706	D0706
Material	HSS	HSS
Surface Finish	TiN	TiN
Sutton Designation	N	N
Geometry	-	-
Chamfer	Intermediate	Bottoming
Limit & Nut Tolerance	Z3 Medium	Z3 Medium

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
0238	3/32	48(WHIT)	45	10	-	2.80	2.24	5	3	1.85	•	•
0318	1/8	40	48	15	15	3.15	2.50	5	3	2.55	T454 0318	T455 0318
0397	5/32	32(WHIT)	53	17	17	4.00	3.15	6	3	3.2	T454 0397	T455 0397
0476	3/16	24	58	16	22	5.00	4.00	7	3	3.7	T454 0476	T455 0476
0556	7/32	24(WHIT)	62	17	23	5.60	4.50	7	3	4.5	•	•
0635	1/4	20	66	19	25	6.30	5.00	8	3	5.1	T454 0635	T455 0635
0794	5/16	18	72	22	30	8.00	6.30	9	4	6.5	T454 0794	T455 0794
0953	3/8	16	80	24	33	10.00	8.00	11	4	7.9	T454 0953	T455 0953
1111	7/16	14	85	25	-	8.00	6.30	9	4	9.3	T454 1111	T455 1111
1270	1/2	12	89	29	-	9.00	7.10	10	4	10.5	T454 1270	T455 1270
1429	9/16	12	95	30	-	11.20	9.00	12	4	12.1	•	•
1588	5/8	11	102	32	-	12.50	10.00	13	4	13.5	T454 1588	T455 1588
1905	3/4	10	112	37	-	14.00	11.20	14	4	16.25	T454 1905	T455 1905
2223	7/8	9	118	38	-	16.00	12.50	16	4	19.25	•	•
2540	1	8	130	45	-	18.00	14.00	18	4	22.0	•	•
2858	1-1/8	7	138	48	-	20.00	16.00	20	4	24.75	•	•
3175	1-1/4	7	151	51	-	22.40	18.00	22	4	28.0	•	•
3810	1-1/2	6	170	60	-	28.00	22.40	26	4	33.5	•	•
4445	1-3/4	5	187	67	-	31.50	25.00	28	4	39.0	•	•
5080	2	4-1/2	200	70	-	35.50	28.00	31	4	44.5	•	•

ISO	P													M			K						N									S														H					
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T454	●	●	●	●	○	●	●	○		○		○		○			○		○		○		○	○	○	○		○	○	○																			

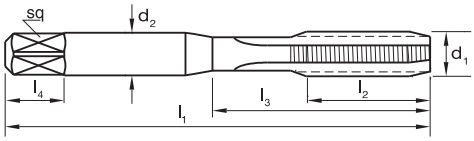
P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials

● Optimal ○ Effective

• Available on request as special manufacture. Subject to lead time.

suttontools

- General purpose use
- Suitable for materials up to 1000N/mm²
- Through & blind holes
- Suitable for both hand and machine operations
- Depths up to approx. 1 x d_1



Catalogue Code	T456
Discount Group	D0702
Material	HSS
Surface Finish	*Brt*
Sutton Designation	N
Geometry	Left Hand
Chamfer	**Bottoming**
Limit & Nut Tolerance	Z3 LH Medium

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #
0635	1/4	20	66	19	25	6.30	5.00	8	3	5.1	T456 0635
0794	5/16	18	72	22	30	8.00	6.30	9	4	6.5	T456 0794
0953	3/8	16	80	24	33	10.00	8.00	11	4	7.9	T456 0953
1111	7/16	14	85	25	-	8.00	6.30	9	4	9.3	T456 1111
1270	1/2	12	89	29	-	9.00	7.10	10	4	10.5	T456 1270
1429	9/16	12	95	30	-	11.20	9.00	12	4	12.1	T456 1429
1588	5/8	11	102	32	-	12.50	10.00	13	4	13.5	T456 1588
1905	3/4	10	112	37	-	14.00	11.20	14	4	16.25	T456 1905

ISO	P												M			K						N								S													H				
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T456	●	●	●	●		●	○										○		○		○		○	○	○	○		○		○																			

P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials

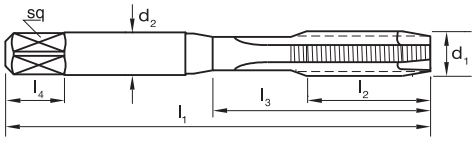
● Optimal ○ Effective

BSW

suttontools

- General purpose use
- Suitable for materials up to 1000N/mm²
- Through holes
- Depths up to approx. 3 x d_1

ISO 529 | 55° BSW



	T457	T458	T459
Catalogue Code	T457	T458	T459
Discount Group	D0702	D0702	D0706
Material	HSSE	HSSE	HSSE
Surface Finish	*Brt*	*Blu*	*TiN*
Sutton Designation	N	N	N
Geometry	-	-	-
Chamfer	Intermediate	Intermediate	Intermediate
Limit & Nut Tolerance	Z3 Medium	Z3 Medium	Z3 Medium

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #	Item #
0318	1/8	40	48	15	15	3.15	2.50	5	3	2.55	T457 0318	T458 0318	T459 0318
0397	5/32	32(WHIT)	53	17	17	4.00	3.15	6	3	3.2	T457 0397	T458 0397	T459 0397
0476	3/16	24	58	16	22	5.00	4.00	7	3	3.7	T457 0476	T458 0476	T459 0476
0635	1/4	20	66	19	25	6.30	5.00	8	3	5.1	T457 0635	T458 0635	T459 0635
0794	5/16	18	72	22	30	8.00	6.30	9	3	6.5	T457 0794	T458 0794	T459 0794
0953	3/8	16	80	24	33	10.00	8.00	11	3	7.9	T457 0953	T458 0953	T459 0953
1111	7/16	14	85	25	-	8.00	6.30	9	3	9.3	T457 1111	T458 1111	•
1270	1/2	12	89	29	-	9.00	7.10	10	3	10.5	T457 1270	T458 1270	T459 1270
1588	5/8	11	102	32	-	12.50	10.00	13	3	13.5	T457 1588	T458 1588	T459 1588
1905	3/4	10	112	37	-	14.00	11.20	14	4	16.25	T457 1905	T458 1905	T459 1905
2223	7/8	9	118	38	-	16.00	12.50	16	4	19.25	•	T458 2223	•
2540	1	8	130	45	-	18.00	14.00	18	4	22.0	•	T458 2540	•

ISO	P													M			K						N										S														H					
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T457	●	●	○	○		●	○							○	○				○	○	○		○	○	○	○		●	○																			○	
T458	●	●	●	●		●	○					○		○	○				○	○	○																											○	
T459	●	●	●	●	○	●	●	○		○		○	○	○	○				○	○	○		○	○	○	○	○	○	○																			○	

P Steel | M Stainless Steel | K Cast Iron | N Non-Ferrous Metals | S Titanium & Super Alloys | H Hard Materials

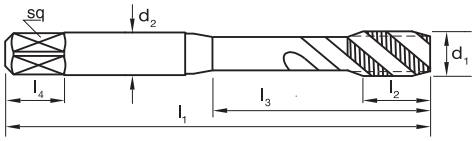
● Optimal ○ Effective

• Available on request as special manufacture. Subject to lead time.

suttontools

- General purpose use
- Suitable for materials up to 1000N/mm²
- Blind holes
- Depths up to approx. 2.5 x d_1

ISO 529 | 55° BSW



	T460	T461	T462
Catalogue Code	T460	T461	T462
Discount Group	D0702	D0702	D0706
Material	HSSE	HSSE	HSSE
Surface Finish	*Brt*	*Blu*	*TiN*
Sutton Designation	N	N	N
Geometry	-	-	-
Chamfer	Bottoming	Bottoming	Bottoming
Limit & Nut Tolerance	Z3 Medium	Z3 Medium	Z3 Medium

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #	Item #
0318	1/8	40	48	6	15	3.15	2.50	5	3	2.55	T460 0318	•	•
0397	5/32	32(WHIT)	53	7	17	4.00	3.15	6	3	3.2	T460 0397	•	•
0476	3/16	24	58	11	22	5.00	4.00	7	3	3.7	T460 0476	•	T462 0476
0635	1/4	20	66	10	25	6.30	5.00	8	3	5.1	T460 0635	T461 0635	T462 0635
0794	5/16	18	72	13	30	8.00	6.30	9	3	6.5	T460 0794	T461 0794	T462 0794
0953	3/8	16	80	16	33	10.00	8.00	11	3	7.9	T460 0953	T461 0953	T462 0953
1111	7/16	14	85	18	-	8.00	6.30	9	3	9.3	T460 1111	T461 1111	•
1270	1/2	12	89	20	-	9.00	7.10	10	3	10.5	T460 1270	T461 1270	T462 1270
1588	5/8	11	102	20	-	12.50	10.00	13	3	13.5	T460 1588	T461 1588	T462 1588
1905	3/4	10	112	25	-	14.00	11.20	14	4	16.25	T460 1905	T461 1905	•
2223	7/8	9	118	28	-	16.00	12.50	16	4	19.25	T460 2223	•	•
2540	1	8	130	35	-	18.00	14.00	18	4	22.0	T460 2540	•	•

ISO	P													M			K					N									S												H					
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T460	●	●	○	○		●								○	○				○	○			○	○	○	○		●	○	○																	○	
T461	●	●	●	●		●	○					○		○	○				○	○																											○	
T462	●	●	●	●	○	●	●	○		○		○	○	○	○				○	○			○	○	○	○	○		○																	○	

P Steel | M Stainless Steel | K Cast Iron | N Non-Ferrous Metals | S Titanium & Super Alloys | H Hard Materials

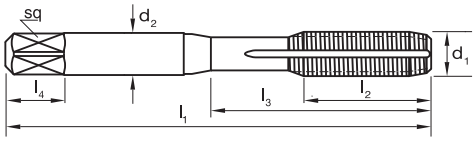
● Optimal ○ Effective

• Available on request as special manufacture. Subject to lead time.

suttontools

- For cold forming of threads in materials with good flow characteristics
- Through or blind holes
- Depths up to approx. 1.5 x d_1
- TiN for longer tool life

ISO 529 | 55° BSW



	T463	T464
Catalogue Code	T463	T464
Discount Group	D0702	D0706
Material	HSSE	HSSE
Surface Finish	*Brt*	*TiN*
Sutton Designation	N	N
Geometry	Single Coolant Groove	Single Coolant Groove
Chamfer	Short	Short
Limit & Nut Tolerance	Z3 Medium	Z3 Medium

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
0318	1/8	40	48	15	15	3.15	2.50	5	-	2.9	T463 0318	•
0397	5/32	32(WHIT)	53	17	17	4.00	3.15	6	-	3.6	T463 0397	T464 0397
0476	3/16	24	58	16	22	5.00	4.00	7	-	4.3	T463 0476	T464 0476
0635	1/4	20	66	19	25	6.30	5.00	8	-	5.8	T463 0635	•
0794	5/16	18	72	22	30	8.00	6.30	9	-	7.3	T463 0794	•
0953	3/8	16	80	24	33	10.00	8.00	11	-	8.8	T463 0953	•

ISO	P													M			K						N									S													H					
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T463	●	●	○	○		●																	●	●	●	●		●		○																			
T464	●	●	○	○		●	○							○									●	●	○	○		●		○																			

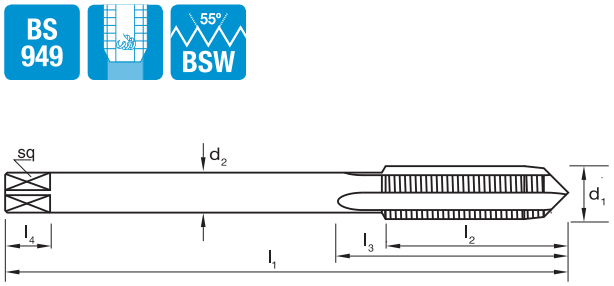
P Steel | M Stainless Steel | K Cast Iron | N Non-Ferrous Metals | S Titanium & Super Alloys | H Hard Materials

● Optimal ○ Effective

• Available on request as special manufacture. Subject to lead time.

suttontools

- Suited to long reach applications
- Suitable for materials up to 1000N/mm²m²
- Through holes
- Depths up to approx. 2 x d_1



Catalogue Code	T465
Discount Group	D0702
Material	HSS
Surface Finish	*Brt*
Sutton Designation	Nut
Geometry	-
Chamfer	Bottoming
Limit & Nut Tolerance	Z3 Medium

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #
0635	1/4	20	110	38	-	4.5	3.55	6	4	5.1	T465 0635
0794	5/16	18	125	43	-	6	4.5	7	4	6.5	T465 0794
0953	3/8	16	140	48	-	7	5.6	8	4	7.9	T465 0953
1270	1/2	12	180	59	-	9.5	7.5	10	4	10.5	T465 1270
1588	5/8	11	200	70	-	12.5	10.0	13	4	13.5	T465 1588
1905	3/4	10	250	76	-	14	11.2	14	4	16.25	T465 1905
2540	1	8	280	95	-	18	14.0	18	4	22.0	T465 2540

ISO	P												M			K					N							S												H				
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T465	●	●	●	●		●	○							○			○		○		○		○	○	○	○		○		○																		

P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials

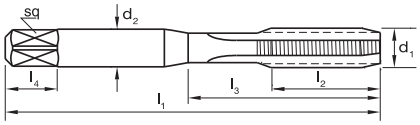
● Optimal ○ Effective

BSW

ISO Taps BSF, BSB & BA, Straight Flute, N

suttontools

- General purpose use
- Suitable for materials up to 1000N/mm²
- Through & blind holes
- Suitable for both hand and machine operations
- Depths up to approx. 1 x d_1



Catalogue Code	-	-	-	-
Discount Group	D0702	D0702	D0702	D0702
Material	HSS	HSS	HSS	HSS
Surface Finish	*Brt*	*Brt*	*Brt*	*Brt*
Sutton Designation	N	N	N	N
Geometry	-	-	-	-
Chamfer	Taper	Intermediate	Bottoming	Set
Limit & Nut Tolerance	Z3 Medium	Z3 Medium	Z3 Medium	Z3 Medium

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #	Item #	Item #
	BSF										**T466**	**T467**	**T468**	**T906**
0476	3/16	32	58	16	22	5.00	4.00	7	3	4.0	T466 0476	T467 0476	T468 0476	T906 0476
0635	1/4	26	66	19	25	6.30	5.00	8	3	5.3	T466 0635	T467 0635	T468 0635	T906 0635
0794	5/16	22	72	22	30	8.00	6.30	9	4	6.8	T466 0794	T467 0794	T468 0794	T906 0794
0953	3/8	20	80	24	33	10.00	8.00	11	4	8.3	T466 0953	T467 0953	T468 0953	T906 0953
1111	7/16	18	85	25	-	8.00	6.30	9	4	9.8	T466 1111	T467 1111	T468 1111	T906 1111
1270	1/2	16	89	29	-	9.00	7.10	10	4	11.0	T466 1270	T467 1270	T468 1270	T906 1270
1429	9/16	16	95	30	-	11.20	9.00	12	4	12.7	T466 1429	T467 1429	T468 1429	•
1588	5/8	14	102	32	-	12.50	10.00	13	4	14.0	T466 1588	T467 1588	T468 1588	•
1905	3/4	12	112	37	-	14.00	11.20	14	4	16.75	T466 1905	T467 1905	T468 1905	•
2223	7/8	11	118	38	-	16.00	12.50	16	4	19.75	T466 2223	T467 2223	T468 2223	•
2540	1	10	130	45	-	18.00	14.00	18	4	22.75	T466 2540	T467 2540	T468 2540	•
	BSB										**T472**	**T473**	**T474**	**T908**
0635	1/4	26(BSF)	66	19	25	6.30	5.00	8	3	5.2	T466 0635	T467 0635	T468 0635	T906 0635
0794	5/16*	26	72	22	30	8.00	6.30	9	4	6.8	T472 0794	T473 0794	T474 0794	T908 0794
0953	3/8*	26	80	24	33	10.00	8.00	11	4	8.4	T472 0953	T473 0953	T474 0953	T908 0953
1111	7/16*	26	85	25	-	8.00	6.30	9	4	10.0	T472 1111	T473 1111	T474 1111	T908 1111
1270	1/2*	26	89	29	-	9.00	7.10	10	4	11.6	T472 1270	T473 1270	T474 1270	T908 1270
1429	9/16*	26	95	30	-	11.20	9.00	12	4	13.2	•	•	T474 1429	•
1588	5/8*	26	102	32	-	12.50	10.00	13	4	14.8	•	•	T474 1588	•
1905	3/4*	26	112	37	-	14.00	11.20	14	4	18.0	•	•	T474 1905	•
2223	7/8*	26	118	38	-	16.00	12.50	16	4	20.8	•	•	T474 2223	•
2540	1*	26	130	45	-	18.00	14.00	18	4	24.3	•	•	T474 2540	•
	BA										**T469**	**T470**	**T471**	**T907**
0600	0	1	66	19	26	6.30	5.00	8	3	5.1	T469 0600	T470 0600	T471 0600	•
0530	1	0.9	62	17	23	5.60	4.50	7	3	4.5	T469 0530	T470 0530	T471 0530	T907 0530
0470	2	0.81	58	16	22	5.00	4.00	7	3	4.0	T469 0470	T470 0470	T471 0470	T907 0470
0410	3	0.73	53	13	18	4.50	3.55	6	3	3.4	T469 0410	T470 0410	T471 0410	T907 0410
0360	4	0.66	50	17	-	3.55	2.80	5	3	3.0	T469 0360	T470 0360	T471 0360	T907 0360
0320	5	0.59	48	15	-	3.15	2.50	5	3	2.65	T469 0320	T470 0320	T471 0320	T907 0320
0280	6	0.53	48	15	-	3.15	2.50	5	3	2.3	T469 0280	T470 0280	T471 0280	T907 0280
0250	7	0.48	45	10	-	2.80	2.24	5	3	2.05	T469 0250	T470 0250	T471 0250	T907 0250
0220	8	0.43	45	10	-	2.80	2.24	5	3	1.8	T469 0220	T470 0220	T471 0220	T907 0220
0190	9	0.39	41	8	-	2.50	2.00	4	3	1.55	T469 0190	T470 0190	T471 0190	T907 0190
0170	10	0.35	41	8	-	2.50	2.00	4	3	1.4	T469 0170	T470 0170	T471 0170	T907 0170

ISO	P												M			K						N									S												H					
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T466	●	●	●	●		●	○										○		○		○		○	○	○	○		○		○																			

P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials

● Optimal ○ Effective

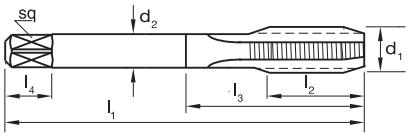
• Available on request as special manufacture. Subject to lead time. * Limit & Nut Tolerance = Z4

ISO Taps Pipe, G (BSPF), Straight Flute

suttontools

- General purpose use
- Suitable for materials up to 1000N/mm²
- Through & blind holes
- Suitable for both hand and machine operations
- Depths up to approx. 1 x d_1

ISO 2284 | 55° G



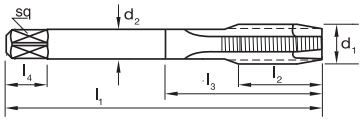
Catalogue Code	T479	T480	T481	T909
Discount Group	D0702	D0702	D0702	D0702
Material	HSS	HSS	HSS	HSS
Surface Finish	*Brt*	*Brt*	*Brt*	*Brt*
Sutton Designation	N	N	N	N
Geometry	-	-	-	-
Chamfer	Taper	Intermediate	Bottoming	Set
Limit	Z3	Z3	Z3	Z3

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #	Item #	Item #
0973	1/8	28	59	15	-	8.0	6.3	9	4	8.8	T479 0973	T480 0973	T481 0973	T909 0973
1316	1/4	19	67	19	-	10.0	8.0	11	4	11.8	T479 1316	T480 1316	T481 1316	T909 1316
1666	3/8	19	75	21	-	12.5	10.0	13	4	15.3	T479 1666	T480 1666	T481 1666	T909 1666
2096	1/2	14	87	26	-	16.0	12.5	16	4	19.0	T479 2096	T480 2096	T481 2096	T909 2096
2291	5/8	14	91	26	-	18.0	14.0	18	4	21.0	T479 2291	T480 2291	T481 2291	T909 2291
2644	3/4	14	96	28	-	20.0	16.0	20	4	24.5	T479 2644	T480 2644	T481 2644	T909 2644
3020	7/8	14	102	29	-	22.4	18.0	22	4	28.5	T479 3020	T480 3020	T481 3020	•
3325	1	11	109	33	-	25.0	20.0	24	4	31.0	T479 3325	T480 3325	T481 3325	T909 3325
4191	1-1/4	11	119	36	-	31.5	25.0	28	4	39.5	T479 4191	T480 4191	T481 4191	•
4780	1-1/2	11	125	37	-	35.5	28.0	31	4	45.5	T479 4780	T480 4780	T481 4780	•
5375	1-3/4	11	132	39	-	35.5	28.0	31	6	51.5	T479 5375	T480 5375	T481 5375	•
5961	2	11	140	41	-	40.0	31.5	34	6	57.5	T479 5961	T480 5961	T481 5961	•

ISO Taps Pipe, G (BSPF), Gun & Spiral Flute

- General purpose use
- Suitable for materials up to 1000N/mm²
- Through & blind holes
- Depths up to approx. 1 x d_1

ISO 529



Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
											T484	T485
0973	1/8	28	80	24	33	10	8	11	3	8.8	T484 0973	T485 0973
1316	1/4	19	95	30	-	11.2	9	12	3	11.8	T484 1316	T485 1316
1666	3/8	19	112	37	-	14	11.2	14	4	15.3	T484 1666	T485 1666
2096	1/2	14	118	38	-	16	12.5	16	4	19.0	T484 2096	T485 2096
2644	3/4	14	135	45	-	20	16	20	4	24.5	T484 2644	T485 2644

ISO	P													M			K							N										S															H					
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T479	●	●	●	●		●	○										○		○		○		○	○	○	○		○		○																					
T484	●	●	○	○		●	○							○	○				○	○	○		○	○	○	○		●	○																					
T485	●	●	○	○		●								○	○				○	○			○	○	○	○		●	○	○																					

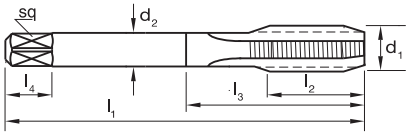
P Steel | M Stainless Steel | K Cast Iron | N Non-Ferrous Metals | S Titanium & Super Alloys | H Hard Materials

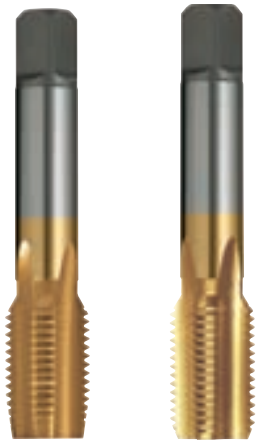
● Optimal ○ Effective

• Available on request as special manufacture. Subject to lead time.

suttontools

- General purpose use
- Suitable for materials up to 1000N/mm²
- Through & blind holes
- Suitable for both hand and machine operations
- Depths up to approx. 1 x d_1





	T482	T483
Catalogue Code	T482	T483
Discount Group	D0706	D0706
Material	HSS	HSS
Surface Finish	TiN	TiN
Sutton Designation	N	N
Geometry	-	-
Chamfer	Intermediate	Bottoming
Limit	Z3	Z3

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
0973	1/8	28	59	15	-	8.0	6.3	9	4	8.8	T482 0973	T483 0973
1316	1/4	19	67	19	-	10.0	8.0	11	4	11.8	T482 1316	T483 1316
1666	3/8	19	75	21	-	12.5	10.0	13	4	15.3	T482 1666	T483 1666
2096	1/2	14	87	26	-	16.0	12.5	16	4	19.0	T482 2096	T483 2096
2291	5/8	14	91	26	-	18.0	14.0	18	4	21.0	•	T483 2291
2644	3/4	14	96	28	-	20.0	16.0	20	4	24.5	•	T483 2644
3020	7/8	14	102	29	-	22.4	18.0	22	4	28.5	•	•
3325	1	11	109	33	-	25.0	20.0	24	4	31.0	•	•
4191	1-1/4	11	119	36	-	31.5	25.0	28	4	39.5	•	•
4780	1-1/2	11	125	37	-	35.5	28.0	31	4	45.5	•	•
5375	1-3/4	11	132	39	-	35.5	28.0	31	6	51.5	•	•
5961	2	11	140	41	-	40.0	31.5	34	6	57.5	•	•

ISO	P													M			K						N								S												H					
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T482	●	●	●	●	○	●	●	○		○		○		○			○		○		○		○	○	○	○		○	○	○																		

P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials

● Optimal ○ Effective

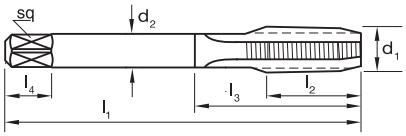
• Available on request as special manufacture. Subject to lead time.

ISO Taps Pipe, Rc (BSPT), Straight Flute

suttontools

- General purpose use
- Suitable for materials up to 1000N/mm²
- Through & blind holes
- Suitable for both hand and machine operations
- Taper pipe reamer recommended prior to tapping Rc (BSPT) thread forms

ISO 2284 | 55° Rc



Catalogue Code	T475	T476
Discount Group	D0702	D0706
Material	HSS	HSS
Surface Finish	*Brt*	*TiN*
Sutton Designation	N	N
Geometry	-	-
Chamfer	Bottoming	Bottoming
Limit & Nut Tolerance	To Suit	To Suit

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
	Rc (BSPT) 1:16 Taper Rate											
0973	1/8	28	59	15	-	8.0	6.3	9	4	8.4	T475 0973	T476 0973
1316	1/4	19	67	19	-	10.0	8.0	11	4	10.8	T475 1316	T476 1316
1666	3/8	19	75	21	-	12.5	10.0	13	4	14.5	T475 1666	T476 1666
2096	1/2	14	87	26	-	16.0	12.5	16	4	18.0	T475 2096	T476 2096
2644	3/4	14	96	28	-	20.0	16.0	20	4	23.0	T475 2644	•
3325	1	11	109	33	-	25.0	20.0	24	5	29.0	T475 3325	•
4191	1-1/4	11	119	36	-	31.5	25.0	28	5	38.0	T475 4191	•
4780	1-1/2	11	125	37	-	35.5	28.0	31	7	44.0	T475 4780	•
5961	2	11	140	41	-	40.0	31.5	34	7	55.0	T475 5961	•

ISO Taps Pipe, Rp & Pg Series, Straight Flute

- General Purpose use for materials up to approx. 1000 N/mm²
- Through & blind holes
- Suitable for both hand and machine operations

Discount Group: D0702

ISO 2284 | ISO 529 | 55° RP | 80° Pg

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Nominal OD	Item #	Item #
	Rp Series (BSPPL) Sealing Pipe Thread Parallel											T477	
0973	1/8	28	59	15	-	8.0	6.3	9	4	8.6	-	T477 0973	
1316	1/4	19	67	19	-	10.0	8.0	11	4	11.5	-	T477 1316	
1666	3/8	19	75	21	-	12.5	10.0	13	4	15.0	-	T477 1666	
2096	1/2	14	87	26	-	16.0	12.5	16	4	18.5	-	T477 2096	
2644	3/4	14	96	28	-	20.0	16.0	20	4	24.0	-	T477 2644	
3325	1	11	109	33	-	25.0	20.0	24	4	30.2	-	T477 3325	
4191	1-1/4	11	119	36	-	31.5	25.0	28	4	39.0	-	T477 4191	
4780	1-1/2	11	125	37	-	35.5	28.0	31	4	45.0	-	T477 4780	
5961	2	11	140	41	-	40.0	31.5	34	4	56.4	-	T477 5961	
	Pg – Steel Conduit (Armour Pipe)											T478	
1250	Pg 7	20	89	29	-	9	7.1	10	4	11.3	12.5	T478 1250	
1520	Pg 9	18	102	32	-	12.5	10	12	4	13.9	15.2	T478 1520	
1860	Pg 11	18	112	37	-	14	11.2	14	4	17.3	18.6	T478 1860	
2040	Pg 13.5	18	118	38	-	16	12.5	16	4	19.1	20.4	T478 2040	
2250	Pg 16	18	118	38	-	16	12.5	16	4	21.2	22.5	T478 2250	
2830	Pg 21	16	138	48	-	20	16	20	4	26.8	28.3	T478 2830	

ISO	P													M			K						N							S														H					
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T475	●	●	●	●		●	○										○		○		○		○	○	○	○		○		○																			
T476	●	●	●	●	○	●	●	○		○				○			○		○		○		○	○	○	○		○	○	○																			
T477	●	●	●	●		●	○										○		○		○		○	○	○	○		○		○																			

P Steel | M Stainless Steel | K Cast Iron | N Non-Ferrous Metals | S Titanium & Super Alloys | H Hard Materials

● Optimal ○ Effective

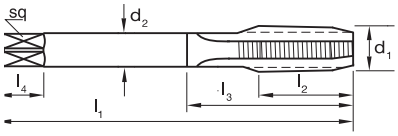
• Available on request as special manufacture. Subject to lead time.

ISO Taps Pipe, National Series

suttontools

- General purpose use, materials up to approx. 1000 N/mm²
- Suitable for both hand and machine operations
- Taper pipe reamer recommended prior to tapping

ANSI B94-9 | 60° NPSF | 60° NPT | 60° NPTF

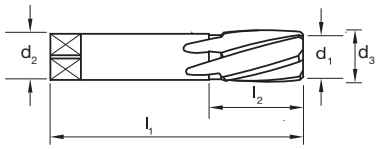


Catalogue Code	-
Discount Group	D0702
Material	HSS
Surface Finish	*Colour Temp*
Sutton Designation	N
Geometry	-
Chamfer	Bottoming
Limit & Nut Tolerance	Refer Limit

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	Limit	drill Ø	Item #
	NPSF (Dryseal Straight)											**T486**
1029	1/8	27	54	19	-	11.11	8.33	9.5	4	GH3	8.6	T486 1029
1372	1/4	18	62	27	-	14.29	10.70	11.1	4	GH4	11.3	T486 1372
1715	3/8	18	65	27	-	17.78	13.49	12.7	4	GH4	14.5	T486 1715
2134	1/2	14	79	35	-	17.46	13.08	15.9	4	GH5	18.0	T486 2134
	NPT (National Pipe Taper) 15° Chamfer (1:16 Taper Rate)											**T487**
1029	1/8	27	54	19	-	11.11	8.33	9.5	4	-	8.2	T487 1029
1372	1/4	18	62	27	-	14.29	10.70	11.1	4	-	10.8	T487 1372
1715	3/8	18	65	27	-	17.78	13.49	12.7	4	-	14.0	T487 1715
2134	1/2	14	79	35	-	17.46	13.08	15.9	4	-	17.5	T487 2134
2667	3/4	14	82	35	-	23.00	17.25	17.5	4	-	23.0	T487 2667
3340	1	11-1/2	95	44.5	-	28.60	21.40	20.6	5	-	28.5	T487 3340
4216	1-1/4	11-1/2	102	44.5	-	33.30	25.00	23.8	5	-	37.0	T487 4216
	NPTF (Dryseal Taper) 15° Chamfer (1:16 Taper Rate)											**T488**
1029	1/8	27	54	19	-	11.11	8.33	9.5	4	-	8.2	T488 1029
1372	1/4	18	62	27	-	14.29	10.70	11.1	4	-	10.8	T488 1372
1715	3/8	18	65	27	-	17.78	13.49	12.7	4	-	14.0	T488 1715
2134	1/2	14	79	35	-	17.46	13.08	15.9	4	-	17.50	T488 2134

Reamers Taper Pipe (1:16)

- Used prior to tapping
- For Rc (BSPT), NPT & NPTF tapered threads
- Prolongs tap life, especially in tough materials



Discount Group: B0302

Size Ref.	Size	d_1	l_1	l_2	d_3	d_2	z	Item #
								R108
0803	1/8	0.316	2-11/32	19/32	0.353	0.315	6	R108 0803
1031	1/4	0.406	2-21/32	25/32	0.453	0.394	6	R108 1031
1372	3/8	0.540	2-31/32	7/8	0.592	0.492	6	R108 1372
1689	1/2	0.665	3-7/16	1-1/32	0.729	0.630	6	R108 1689
2225	3/4	0.876	3-25/32	1-1/8	0.945	0.787	6	R108 2225
2802	1	1.103	4-5/16	1-5/16	1.184	0.984	6	R108 2802
3668	1-1/4	1.444	4-11/16	1-7/16	1.529	1.240	6	R108 3668
4277	1-1/2	1.684	4-15/16	1-15/32	1.775	1.398	8	R108 4277
5484	2	2.159	5-17/32	1-5/8	2.260	1.575	8	R108 5484

ISO	P													M			K						N									S													H					
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T486	●	●	●	●		●	○							○			○		○		○		○	○	○	○		○	○	○																			
R108	●	●	●	●	○	●	○	○		○		○		○	○	○	●	○	○	○	○	○	○	○	○	○		○	○	○																		○	

P Steel | M Stainless Steel | K Cast Iron | N Non-Ferrous Metals | S Titanium & Super Alloys | H Hard Materials

● Optimal ○ Effective

NPT