Taps DIN

High Performance Tap Range

- M, MF, MJ
- UNC, UNF, UN
- G (BSPF)
- NPT

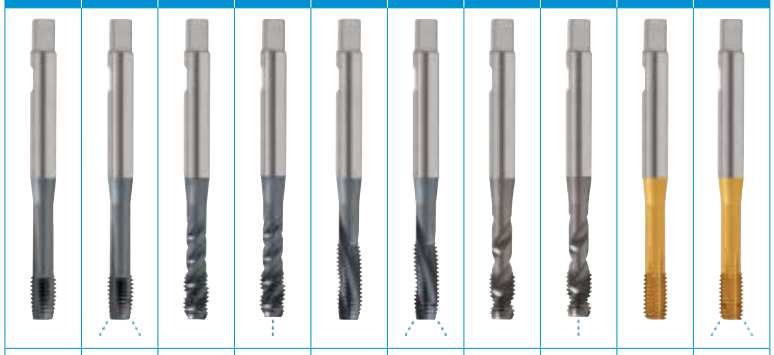
TAPS DIN

suttontools

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.

For Synchro Tapping



Page	183	183	184	184	185	185	186	186	187	187
Catalogue Code M	T377	T379	T373	T375	T365	T367	T369	T371	T381	T383
MF	T766	T768	T762	T764	T754	T756	T758	T760	T770	T772
Material	PM-HSSE V3		PM-HSSE V3		PM-HSSE V3		PM-HSSE V3		PM-HSSE V3	
Surface Finish	TiCN		TiCN		TiCN		CrN		TiN	
Sutton Designation	UNI		UNI		UNI		Al		UNI	
Tapping Depth	2xØ		2xØ		2xØ		2xØ		2xØ	
Limit & Nut Tolerance	6HX		6HX		6HX		6HX		6HX	

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

DIN Tap Finder

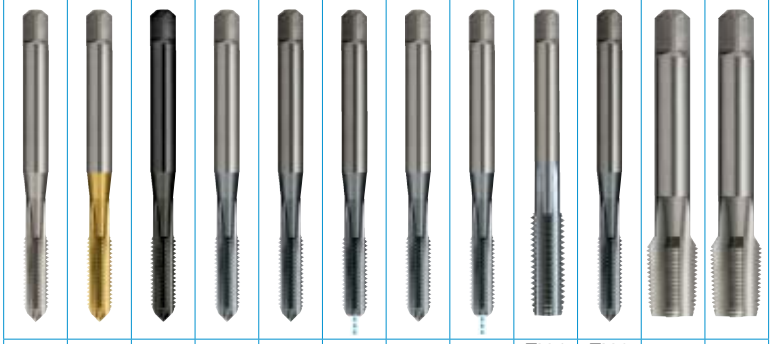
suttontools

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.

For Tapping Through & Blind Holes

Page M	188	188	189	189	190	190	191	191	192	193		
MF	228	228	229	229	229	229	230	230	231	232		
UNC			250	250								
UNF												
G (BSPF)	277	277	278	278								
BSPT / NPT											289	289



Catalogue Code M	T286 / T287	T288 / T289	T290 / T291	T292 / T293	T670 / T671	T741 / T742	T335 / T336	T357 / T358	T294	T296		
MF	T298	T299	T300	T301	T743	T744	T668	T669	T343	T345		
UNC			T302	T303								
UNF												
G (BSPF)	T304	T305	T306	T307								
NPT											T808	T308
Material	HSSE		HSSE		VHM		PM-HSS Co		SPM	VHM	HSSE	
Surface Finish	Brt	TiN	Ni+Blu	TiCN	TiCN		TiCN		TiCN	TiCN	Brt	
Sutton Designation	N		GG		GGG		DC		XH	VH	N	UNI
Tapping Depth	≤ 1.5xØ		≤ 3xØ		≤ 3xØ		≤ 1.5xØ		≤ 1.5xØ	≤ 1.5xØ	-	-
Limit & Nut Tolerance	ISO 2 / 6H		6HX		6H		6HX		6HX	6HX	ANSI B1.20.1	

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

DIN Tap Finder

suttontools

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	

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For Tapping Through Holes

Page M	194	194	194	196	196	197	198	199	199	199
MF	233	233	233	233			235			
UNC	251	251	251	251			252			
UNF	268	268	268	268			269			
G(BSPF)	279	279	279				280			

Catalogue Code M	T100 / T101	T102 / T103	T104 / T105	T106 / T107	T648 / T649	T337 / T338	T687 / T688	T122 / T123	T124 / T125	T126 / T127
MF	T154	T156	T157	T155			T689			
UNC	T164	T166	T167	T165			T693			
UNF	T173	T702	T175	T174			T694			
G(BSPF)	T178	T179	T180				T700			
Material	HSSE			HSSE	HSSE	HSSE	PM-HSSE V3	HSSE		HSSE
Surface Finish	Brt	Blu	TiN	Brt	Brt	Brt	Hardlube	Ni	Blu	CrN
Sutton Designation	N			N	N - LH	N - Long	UNI	W		Cu
Tapping Depth	≤ 3xØ			≤ 3xØ	≤ 3xØ	≤ 3xØ	≤ 3xØ	≤ 3xØ		≤ 3xØ
Limit & Nut Tolerance	ISO 2 / 6H			ISO 3 / 6G	ISO 2 / 6H	ISO 2 / 6H	6HX	ISO 2 / 6H		ISO 2 / 6H

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

200	200	201	201	201	202	202	202	202	203	203	204	204	204	205	205	205	220	221
		236	236		237	237					238	238			239		220	221
		253	253			254					255	255		256	256		266	267
		270	270			271											266	267
		281	281		282	282												

T128 / T129	T130 / T131	T110 / T111	T112 / T113	T359 / T360	T114 / T115	T116 / T117	T118 / T119	T680 / T681	T650 / T651	T120 / T121	T134 / T135	T140 / T141	T142 / T143	T144 / T145	T146 / T147	T148 / T149	T152 / T153	T217 / T218
		T158	T161		T159	T160					T654	T163			T710		T784 / T785	T792 / T793
		T170	T171			T697					T168	T169		T172	T666		T786	T794
		T176	T177			T698											T787	T795
		T181	T182		T349	T350												
HSSE		HSSE			PM-HSSE V3				PM-HSSE V3		PM-HSSE V3			PM-HSS Co			PM-HSS Co	
Brt	TiN	Blu	TiCN	Blu	Blu	TiCN			Blu	TiCN	Blu	TiAlN		Blu	TiCN		TiCN	
Sticky Material		VA			VA PM				VA DH		NH			H			Ti	Ni
≤ 3xØ		≤ 3xØ			≤ 3xØ				≤ 3.5xØ		≤ 3xØ			≤ 3xØ			≤ 1.5xØ	
ISO 2 / 6H		ISO 2 / 6H		ISO 3 / 6G	6HX			6GX	6HX		ISO 2 / 6H			6HX			6HX / 3BX	

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

DIN Tap Finder

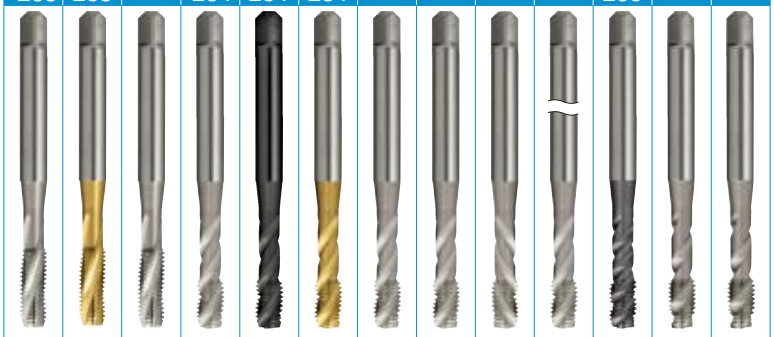
suttontools

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.

For Tapping Blind Holes

Page M	206	206		207	207		209	209	209	210	211	212	212
MF	240	240		241	241	241	241				242		243
UNC	257	257	257	258	258	258	258				259		
UNF	272			273	273						274		
G(BSPF)	283	283		284	284	284					285		



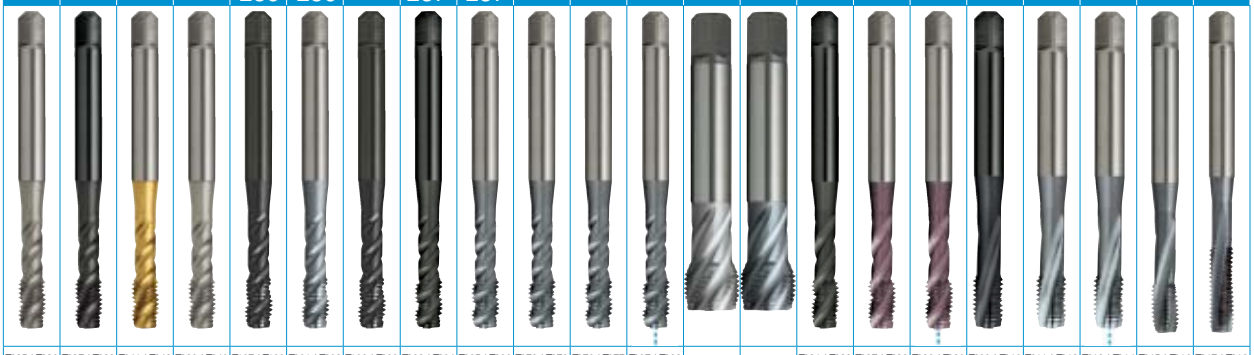
Catalogue Code M	T183 / T184	T185 / T186		T187 / T188	T189 / T190		T191 / T192	T193 / T194	T195 / T196	T339 / T340	T684 / T685	T231 / T232	T233 / T234
MF	T243	T244		T245	T247	T248	T246				T686		T703
UNC	T255	T256	T257	T258	T260	T273	T259				T691		
UNF	T274			T275	T701						T692		
G(BSPF)	T278	T279		T281	T282	T283					T699		
Material	HSSE			HSSE			HSSE				PM-HSSE V3	HSSE	
Surface Finish	Brt	TiN	Brt	Brt	Blu	TiN	Brt				Hardlube	Brt	CrN
Sutton Designation	N			N			N		N - LH	N - Long	UNI	Al	
Tapping Depth	≤ 1.5xØ			≤ 3xØ			≤ 3xØ				≤ 3xØ	≤ 3xØ	
Limit & Nut Tolerance	ISO 2 / 6H		3B	ISO 2 / 6H			ISO 3 / 6G	ISO 1 / 4H	ISO 2 / 6H		6HX	ISO 2 / 6H	

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

213	213	213	213	214	214	214	215	215	215	215	216			217	217	217	218	218	218	219	221
				244	244		245	245						246	246			247		219	221
				260	260			261				262	262	263	263		264	264		265	267
				275	275			276												265	267
				286	286		287	287													



T235 / T236	T237 / T238	T241 / T242	T239 / T240	T197 / T199	T201 / T202	T198 / T200	T203 / T204	T205 / T206	T678 / T679	T676 / T677	T207 / T208			T221 / T222	T227 / T228	T229 / T230	T209 / T210	T211 / T212	T213 / T214	T215 / T216	T217 / T218
				T249	T251		T250	T252						T655	T254			T707		T788 / T789	T792 / T793
				T261	T262			T695				T263	T264	T266	T267		T265	T667		T790	T794
				T276	T277			T696												T791	T795
				T284	T285		T351	T352													
HSSE			HSSE	HSSE			PM-HSSE V3					HSSE		PM-HSSE V3			PM-HSS Co				
Ni	Blu	TiN	CrN	Blu	TiCN	Blu	Blu	TiCN				Brt	TiCN	Blu	TiAlN		Blu	TiCN		TiCN	
W			Cu	VA DH			VA PM					VA		NH			H			Ti	Ni
≤ 3xØ			≤ 3xØ	≤ 3xØ			≤ 3xØ					≤ 2.5xØ		≤ 2.5xØ			≤ 1.5xØ			≤ 1.5xØ	
ISO 2 / 6H			ISO 2 / 6H	ISO 2 / 6H		ISO 3 / 6G	6HX		6GX	6HX		2B		ISO 2 / 6H			ISO 2 / 6HX			6HX / 3BX	

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

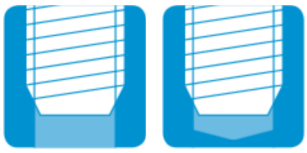
DIN Tap Finder

suttontools

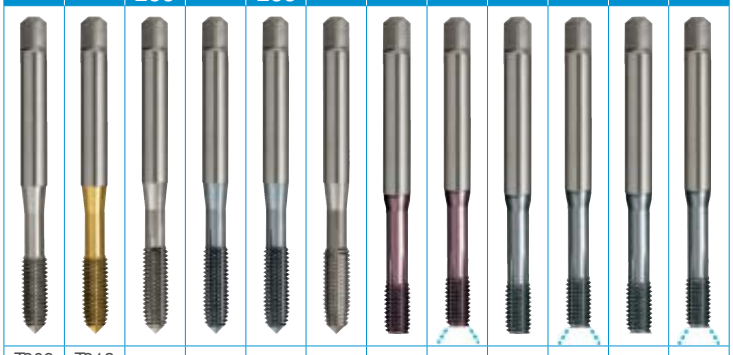
ISO	VDI	Material Group	Sutton	
P	A	Steel	N	UNI
M	R	Stainless Steel	VA	
K	F	Cast Iron	GG	
N	N	Non-Ferrous Metals, Aluminiums & Coppers	Al W	
S	S	Titaniums & Super Alloys	Ti	Ni
H	H	Hard Materials (≥ 45 HRC)	H	

^ 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.

For Thread Forming



Page M	223	223		224	224	224	225	225	226	226	227	227
MF					248							
UNC												
UNF												
G(BSPF)			288		288							



Catalogue Code M	T309	T313		T323 / T324	T319 / T320	T329 / T330	T325 / T326	T327 / T328	T331 / T332	T745 / T746	T682 / T683	T747 / T748
MF												
UNC												
UNF												
G(BSPF)			T360		T363							
Material	HSSE		HSSE			HSSE	SPM		SPM		VHM	
Surface Finish	Brt	TiN	Brt	TiCN		CrN	TiAlN		TiCN		TiCN	
Sutton Designation	N		N			Cu	UNI		NH		N	
Tapping Depth	≤ 1.5xØ		≤ 3xØ			≤ 3xØ	≤ 2xØ		≤ 2xØ		≤ 2xØ	
Limit & Nut Tolerance	6HX		6GX		6HX	6HX	6HX		6HX		6HX	

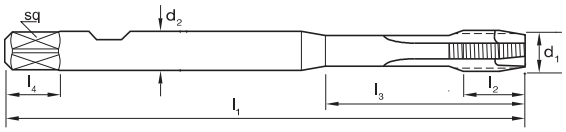
ISO	VDI^ 3323	Material		Condition	HB	N/mm²											
P	1	Steel - Non-alloy, cast & free cutting	~ 0.15 %C	A	125	440	○	●	●	●	●		●	●	○	○	●	●
	2		~ 0.45 %C	A	190	640	○	●	●	●	●		●	●	○	○	●	●
	3			QT	250	840		○	○	●	●		●	●	●	●	●	●
	4		~ 0.75 %C	A	270	910		●	●	●	●		●	●	●	●	●	●
	5			QT	300	1010									○	○	○	○
	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

suttontools

- For high speed and precision tapping
- For rigid tapping in CNC machines with synchronised feed
- Suitable for materials up to 850N/mm²
- Through holes up to 2 x d_1
- h6 endmill shank



Catalogue Code	T377	T379
Discount Group	D0412	D0412
Material	PM-HSSE V3	PM-HSSE V3
Surface Finish	TiCN	TiCN
Geometry		IK
Chamfer	Form B / 4.5 x P	Form B / 4.5 x P
Shank Form (~DIN 1835)	B	B
Limit & Nut Tolerance	6HX	6HX

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	70	4	13	6.0	4.9	8.0	3	1.6	T377 0200	
0250	M 2.5	x 0.45	70	4.5	14	6.0	4.9	8.0	3	2.1	T377 0250	
0300	M 3	x 0.5	70	5	18	6.0	4.9	8.0	3	2.5	T377 0300	
0400	M 4	x 0.7	70	7	21	6.0	4.9	8.0	3	3.3	T377 0400	
0500	M 5	x 0.8	70	8	25	6.0	4.9	8.0	3	4.2	T377 0500	T379 0500
0600	M 6	x 1	80	10	30	6.0	4.9	8.0	3	5.0	T377 0600	T379 0600
0800	M 8	x 1.25	90	13	35	8.0	6.2	9.0	3	6.8	T377 0800	T379 0800
1000	M 10	x 1.5	100	15	39	10.0	8.0	11.0	3	8.5	T377 1000	T379 1000
1200	M 12	x 1.75	110	18	42	12.0	9.0	12.0	3	10.3	T377 1200	T379 1200
1400	M 14	x 2	110	20	49	14.0	11.0	14.0	3	12.0	T377 1400	T379 1400
1600	M 16	x 2	110	20	55	16.0	12.0	15.0	4	14.0	T377 1600	T379 1600
1800	M 18	x 2.5	125	25	-	16.0	12.0	15.0	4	15.5	T377 1800	T379 1800
2000	M 20	x 2.5	140	25	-	16.0	12.0	15.0	4	17.5	T377 2000	T379 2000
											T766	T768
0805	MF 8	x 1	90	13	30	8.0	6.2	9.0	3	7.0	•	•
1005	MF 10	x 1	100	15	39	10.0	8.0	11.0	3	9.0	•	•
1006	MF 10	x 1.25	100	15	39	10.0	8.0	11.0	3	8.8	•	•
1205	MF 12	x 1	110	18	42	12.0	9.0	12.0	3	11.0	•	•
1206	MF 12	x 1.25	110	18	42	12.0	9.0	12.0	3	10.8	•	•
1207	MF 12	x 1.5	110	18	42	12.0	9.0	12.0	3	10.5	•	•

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
T377	●	●	●	●	○	●	●	○		●		●	○	●	●	○	●	○	●	○	●	○	●	●	●	●	○	●	○	●			●		●														
T379	●	●	●	●	○	●	●	○		●		●	○	●	●	○	●	○	●	○	●	○	●	●	●	●	○	●	○	●			●		●														

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

● Optimal ○ Effective

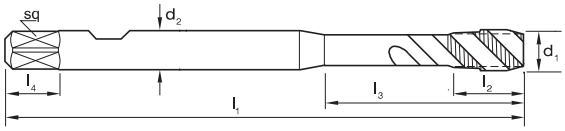
• Available on request as special manufacture. Subject to lead time.

DIN Taps Metric, Synchro, Spiral Flute, R50

suttontools

- For high speed and precision tapping
- For rigid tapping in CNC machines with synchronised feed
- Suitable for materials up to 850N/mm²
- Blind holes up to 2 x d_1
- h6 endmill shank

watch the video



Catalogue Code	T373	T375
Discount Group	D0412	D0412
Material	PM-HSSE V3	PM-HSSE V3
Surface Finish	TiCN	TiCN
Geometry	R50	R50 IK
Chamfer	Form C/ 2.5 x P	Form C/ 2.5 x P
Shank Form (~DIN 1835)	B	B
Limit & Nut Tolerance	6HX	6HX

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	70	4	13	6.0	4.9	8.0	3	1.6	T373 0200	
0250	M 2.5	x 0.45	70	4.5	14	6.0	4.9	8.0	3	2.1	T373 0250	
0300	M 3	x 0.5	70	5	18	6.0	4.9	8.0	3	2.5	T373 0300	
0400	M 4	x 0.7	70	7	21	6.0	4.9	8.0	3	3.3	T373 0400	
0500	M 5	x 0.8	70	8	25	6.0	4.9	8.0	3	4.2	T373 0500	T375 0500
0600	M 6	x 1	80	10	30	6.0	4.9	8.0	3	5.0	T373 0600	T375 0600
0800	M 8	x 1.25	90	13	35	8.0	6.2	9.0	3	6.8	T373 0800	T375 0800
1000	M 10	x 1.5	100	15	39	10.0	8.0	11.0	3	8.5	T373 1000	T375 1000
1200	M 12	x 1.75	110	18	42	12.0	9.0	12.0	4	10.3	T373 1200	T375 1200
1400	M 14	x 2	110	20	49	14.0	11.0	14.0	4	12.0	T373 1400	T375 1400
1600	M 16	x 2	110	20	55	16.0	12.0	15.0	4	14.0	T373 1600	T375 1600
1800	M 18	x 2.5	125	25	-	16.0	12.0	15.0	4	15.5	T373 1800	T375 1800
2000	M 20	x 2.5	140	25	-	16.0	12.0	15.0	4	17.5	T373 2000	T375 2000
											T762	T764
0805	MF 8	x 1	90	13	30	8.0	6.2	9.0	3	7.0	•	•
1005	MF 10	x 1	100	15	39	10.0	8.0	11.0	3	9.0	•	•
1006	MF 10	x 1.25	100	15	39	10.0	8.0	11.0	3	8.8	•	•
1205	MF 12	x 1	110	18	42	12.0	9.0	12.0	3	11.0	•	•
1206	MF 12	x 1.25	110	18	42	12.0	9.0	12.0	3	10.8	•	•
1207	MF 12	x 1.5	110	18	42	12.0	9.0	12.0	3	10.5	•	•

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
T373	●	●	●	●	○	●	●	○		●		●	○	●	●	○	●	○	●	○	●	○	●	●	○	○	●	○	○	○			●		●														
T375	●	●	●	●	○	●	●	○		●		●	○	●	●	○	●	○	●	○	●	○	●	●	○	○	●	○	○	○			●		●														

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

● Optimal ● Effective

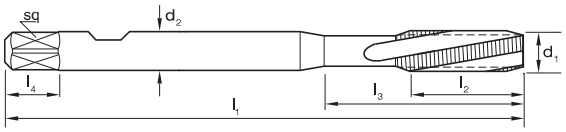
• Available on request as special manufacture. Subject to lead time.

M

DIN Taps Metric, Synchro, Spiral Flute, L20

suttontools

- Right hand cutting / Left hand helix
- For high speed and precision tapping
- For rigid tapping in CNC machines with synchronised feed
- Suitable for materials up to 850N/mm²
- Ideal for through holes with angular exit or interrupted hole



Catalogue Code	T365	T367
Discount Group	D0412	D0412
Material	PM-HSSE V3	PM-HSSE V3
Surface Finish	TiCN	TiCN
Geometry	L20	L20 IK
Chamfer	Form D / 4 x P	Form D / 4 x P
Shank Form (~DIN 1835)	B	B
Limit & Nut Tolerance	6HX	6HX

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	70	8	13	6.0	4.9	8.0	3	1.6	T365 0200	
0250	M 2.5	x 0.45	70	9	14	6.0	4.9	8.0	3	2.1	T365 0250	
0300	M 3	x 0.5	70	11	18	6.0	4.9	8.0	3	2.5	T365 0300	
0400	M 4	x 0.7	70	13	21	6.0	4.9	8.0	3	3.3	T365 0400	
0500	M 5	x 0.8	70	16	25	6.0	4.9	8.0	3	4.2	T365 0500	T367 0500
0600	M 6	x 1	80	19	30	6.0	4.9	8.0	3	5.0	T365 0600	T367 0600
0800	M 8	x 1.25	90	22	35	8.0	6.2	9.0	3	6.8	T365 0800	T367 0800
1000	M 10	x 1.5	100	24	39	10.0	8.0	11.0	3	8.5	T365 1000	T367 1000
1200	M 12	x 1.75	110	29	42	12.0	9.0	12.0	3	10.3	T365 1200	T367 1200
1400	M 14	x 2	110	30	49	14.0	11.0	14.0	4	12.0	T365 1400	T367 1400
1600	M 16	x 2	110	32	55	16.0	12.0	15.0	4	14.0	T365 1600	T367 1600
1800	M 18	x 2.5	125	34	-	16.0	12.0	15.0	4	15.5	T365 1800	T367 1800
2000	M 20	x 2.5	140	34	-	16.0	12.0	15.0	4	17.5	T365 2000	T367 2000
											T754	T756
0805	MF 8	x 1	90	13	30	8.0	6.2	9.0	3	7.0	•	•
1005	MF 10	x 1	100	15	39	10.0	8.0	11.0	3	9.0	•	•
1006	MF 10	x 1.25	100	15	39	10.0	8.0	11.0	3	8.8	•	•
1205	MF 12	x 1	110	18	42	12.0	9.0	12.0	3	11.0	•	•
1206	MF 12	x 1.25	110	18	42	12.0	9.0	12.0	3	10.8	•	•
1207	MF 12	x 1.5	110	18	42	12.0	9.0	12.0	3	10.5	•	•

	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
T365	●	●	●	●	○	●	●	○		●		●	○	●	●	○	●	○	●	○	●	○	●	●	●	●	○	●	○	●									●	●		●						
T367	●	●	●	●	○	●	●	○		●		●	○	●	●	○	●	○	●	○	●	○	●	●	●	●	○	●	○	●									●	●		●						

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

● Optimal ○ Effective

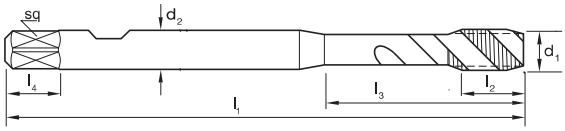
• Available on request as special manufacture. Subject to lead time.

M

DIN Taps Metric, Synchro, Spiral Flute, R45 Al

suttontools

- For high speed and precision tapping
- For rigid tapping in CNC machines with synchronised feed
- For aluminium & aluminium alloys
- Blind holes up to 2 x d_1
- h6 endmill shank



	T369	T371
Catalogue Code	T369	T371
Discount Group	D0412	D0412
Material	PM-HSSE V3	PM-HSSE V3
Surface Finish	CrN	CrN
Geometry	R45	R45 IK
Chamfer	Form C/ 2.5 x P	Form C/ 2.5 x P
Shank Form (~DIN 1835)	B	B
Limit & Nut Tolerance	6HX	6HX

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	70	4	13	6.0	4.9	8.0	2	1.6	T369 0200	
0250	M 2.5	x 0.45	70	4.5	14	6.0	4.9	8.0	2	2.1	T369 0250	
0300	M 3	x 0.5	70	5	18	6.0	4.9	8.0	2	2.5	T369 0300	
0400	M 4	x 0.7	70	7	21	6.0	4.9	8.0	2	3.3	T369 0400	
0500	M 5	x 0.8	70	8	25	6.0	4.9	8.0	2	4.2	T369 0500	T371 0500
0600	M 6	x 1	80	10	30	6.0	4.9	8.0	2	5.0	T369 0600	T371 0600
0800	M 8	x 1.25	90	13	35	8.0	6.2	9.0	2	6.8	T369 0800	T371 0800
1000	M 10	x 1.5	100	15	39	10.0	8.0	11.0	2	8.5	T369 1000	T371 1000
1200	M 12	x 1.75	110	18	42	12.0	9.0	12.0	2	10.3	T369 1200	T371 1200
1400	M 14	x 2	110	20	49	14.0	11.0	14.0	2	12.0	T369 1400	T371 1400
1600	M 16	x 2	110	20	55	16.0	12.0	15.0	2	14.0	T369 1600	T371 1600
1800	M 18	x 2.5	125	25	-	16.0	12.0	15.0	2	15.5	T369 1800	T371 1800
2000	M 20	x 2.5	140	25	-	16.0	12.0	15.0	2	17.5	T369 2000	T371 2000
											T758	T760
0805	MF 8	x 1	90	13	30	8.0	6.2	9.0	2	7.0	•	•
1005	MF 10	x 1	100	15	39	10.0	8.0	11.0	2	9.0	•	•
1006	MF 10	x 1.25	100	15	39	10.0	8.0	11.0	2	8.8	•	•
1205	MF 12	x 1	110	18	42	12.0	9.0	12.0	2	11.0	•	•
1206	MF 12	x 1.25	110	18	42	12.0	9.0	12.0	2	10.8	•	•
1207	MF 12	x 1.5	110	18	42	12.0	9.0	12.0	2	10.5	•	•

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
T369																							◐	◐	◐	◐		◐	◐	◐																				
T371																							◐	◐	◐	◐		◐	◐	◐																				

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

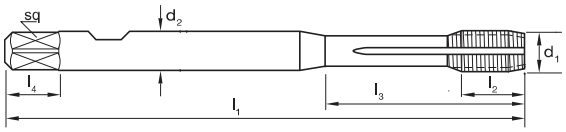
◐ Optimal ◐ Effective

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

M

suttontools

- For high speed and precision tapping
- For rigid tapping in CNC machines with synchronised feed
- For aluminium and aluminium alloys
- Process of plastic deformation to imprint thread on material
- Blind and through holes up to 2 x d_1
- h6 endmill shank



Catalogue Code	T381	T383
Discount Group	D0412	D0412
Material	PM-HSSE V3	PM-HSSE V3
Surface Finish	TiN	TiN
Geometry	Multi-Coolant Groove	Multi-Coolant Groove IK
Chamfer	Form C/ 2.5 x P	Form C/ 2.5 x P
Shank Form (~DIN 1835)	B	B
Limit & Nut Tolerance	6HX	6HX

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	70	4	13	6.0	4.9	8.0		1.8	T381 0200	
0250	M 2.5	x 0.45	70	4.5	14	6.0	4.9	8.0		2.3	T381 0250	
0300	M 3	x 0.5	70	5	18	6.0	4.9	8.0		2.8	T381 0300	
0400	M 4	x 0.7	70	7	21	6.0	4.9	8.0		3.7	T381 0400	
0500	M 5	x 0.8	70	8	25	6.0	4.9	8.0		4.6	T381 0500	T383 0500
0600	M 6	x 1	80	10	30	6.0	4.9	8.0		5.5	T381 0600	T383 0600
0800	M 8	x 1.25	90	13	35	8.0	6.2	9.0		7.4	T381 0800	T383 0800
1000	M 10	x 1.5	100	15	39	10.0	8.0	11.0		9.3	T381 1000	T383 1000
1200	M 12	x 1.75	110	18	42	12.0	9.0	12.0		11.2	T381 1200	T383 1200
1400	M 14	x 2	110	20	49	14.0	11.0	14.0		13.1	T381 1400	T383 1400
1600	M 16	x 2	110	20	55	16.0	12.0	15.0		15.1	T381 1600	T383 1600
1800	M 18	x 2.5	125	25	-	16.0	12.0	15.0		16.9	T381 1800	T383 1800
2000	M 20	x 2.5	140	25	-	16.0	12.0	15.0		18.9	T381 2000	T383 2000
											T770	T772
0800	MF 8	x 1	90	13	30	8.0	6.2	9.0		7.5	•	•
1005	MF 10	x 1	100	15	39	10.0	8.0	11.0		9.5	•	•
1006	MF 10	x 1.25	100	15	39	10.0	8.0	11.0		9.4	•	•
1205	MF 12	x 1	110	18	42	12.0	9.0	12.0		11.5	•	•
1206	MF 12	x 1.25	110	18	42	12.0	9.0	12.0		11.4	•	•
1207	MF 12	x 1.5	110	18	42	12.0	9.0	12.0		11.3	•	•

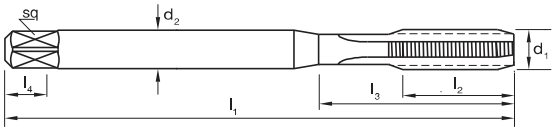
ISO	P													M			K						N										S												H					
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T381	●	●	○	●		○	○			○				●	○								●	●	●	○				●																			
T383	●	●	○	●		○	○			○				●	○								●	●	●	○				●																			

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

● Optimal ○ Effective

suttontools

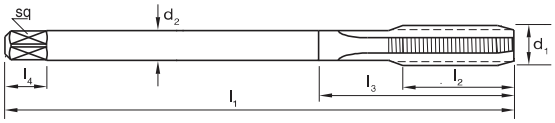
- General purpose use
- Suitable for materials up to 1000N/mm²
- Through & blind holes
- Depths up to 1.5 x d_1



Catalogue Code	T286	T288
Discount Group	D0402	D0406
Material	HSSE	HSSE
Surface Finish	Brt	TiN
Sutton Designation	N	N
Geometry		
Chamfer	Form C/ 2.5 x P	Form C/ 2.5 x P
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	45	8	-	2.8	2.1	5	3	1.6	T286 0200	T288 0200
0220	M 2.2	x 0.45	45	9	-	2.8	2.1	5	3	1.75	T286 0220	T288 0220
0230	M 2.3	x 0.4	45	9	-	2.8	2.1	5	3	1.9	T286 0230	T288 0230
0250	M 2.5	x 0.45	50	9	-	2.8	2.1	5	3	2.05	T286 0250	T288 0250
0260	M 2.6	x 0.45	50	9	-	2.8	2.1	5	3	2.15	T286 0260	T288 0260
0300	M 3	x 0.5	56	11	18	3.5	2.7	6	3	2.5	T286 0300	T288 0300
0350	M 3.5	x 0.6	56	13	20	4.0	3.0	6	3	2.9	T286 0350	T288 0350
0400	M 4	x 0.7	63	13	21	4.5	3.4	6	3	3.3	T286 0400	T288 0400
0500	M 5	x 0.8	70	16	25	6.0	4.9	8	3	4.2	T286 0500	T288 0500
0600	M 6	x 1	80	19	30	6.0	4.9	8	3	5.0	T286 0600	T288 0600
0700	M 7	x 1	80	19	30	7.0	5.5	8	3	6.0	•	•
0800	M 8	x 1.25	90	22	35	8.0	6.2	9	3	6.8	T286 0800	T288 0800
1000	M 10	x 1.5	100	24	39	10.0	8.0	11	3	8.5	T286 1000	T288 1000

M



Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
											T287	T289
0600	M 6	x 1	80	19	-	4.5	3.4	6	3	5.0	T287 0600	T289 0600
0800	M 8	x 1.25	90	22	-	6.0	4.9	8	3	6.8	T287 0800	T289 0800
1000	M 10	x 1.5	100	24	-	7.0	5.5	8	3	8.5	T287 1000	T289 1000
1200	M 12	x 1.75	110	28	-	9.0	7.0	10	3	10.2	T287 1200	T289 1200
1400	M 14	x 2	110	30	-	11.0	9.0	12	3	12.0	T287 1400	T289 1400
1600	M 16	x 2	110	32	-	12.0	9.0	12	4	14.0	T287 1600	T289 1600
1800	M 18	x 2.5	125	34	-	14.0	11.0	14	4	15.5	T287 1800	T289 1800
2000	M 20	x 2.5	140	34	-	16.0	12.0	15	4	17.5	T287 2000	T289 2000
2200	M 22	x 2.5	140	34	-	18.0	14.5	17	4	19.5	T287 2200	T289 2200
2400	M 24	x 3	160	38	-	18.0	14.5	17	4	21.0	T287 2400	T289 2400
2700	M 27	x 3	160	38	-	20.0	16.0	19	4	24.0	T287 2700	T289 2700
3000	M 30	x 3.5	180	45	-	22.0	18.0	21	4	26.5	T287 3000	T289 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
T286	●	●	●	●	○	●	○	○		○													○	○	○	○		○	○	○																		
T288	●	●	●	●	○	●	○	○		○													○	○	○	○		○	○	○																		

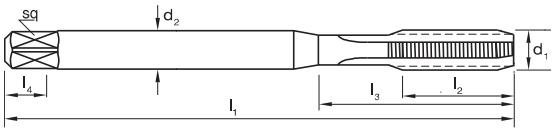
P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials

● Optimal ○ Effective

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

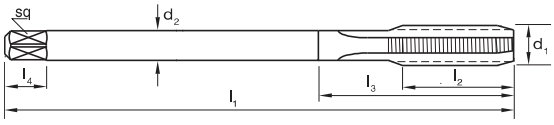
suttontools

- For use in grey cast iron (GG)
- Through & blind holes
- Depths up to 3 x d_1



Catalogue Code	T290	T292
Discount Group	D0402	D0408
Material	HSSE	HSSE
Surface Finish	Ni + Blu	TiCN
Sutton Designation	GG	GG
Geometry	Low Relief	Low Relief
Chamfer	Form C/ 2.5 x P	Form C/ 2.5 x P
Limit & Nut Tolerance	6HX	6HX

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 0.40	45	8	-	2.8	2.1	5	4	1.6	•	•
0220	M 2.2	x 0.45	45	9	-	2.8	2.1	5	4	1.75	•	•
0230	M 2.3	x 0.4	45	9	-	2.8	2.1	5	4	1.9	•	•
0250	M 2.5	x 0.45	50	9	-	2.8	2.1	5	4	2.05	•	•
0260	M 2.6	x 0.45	50	9	-	2.8	2.1	5	4	2.15	•	•
0300	M 3	x 0.5	56	11	18	3.5	2.7	6	4	2.5	T290 0300	T292 0300
0350	M 3.5	x 0.6	56	13	20	4.0	3.0	6	4	2.9	•	•
0400	M 4	x 0.7	63	13	21	4.5	3.4	6	4	3.3	T290 0400	T292 0400
0500	M 5	x 0.8	70	16	25	6.0	4.9	8	4	4.2	T290 0500	T292 0500
0600	M 6	x 1	80	19	30	6.0	4.9	8	4	5.0	T290 0600	T292 0600
0800	M 8	x 1.25	90	22	35	8.0	6.2	9	4	6.8	T290 0800	T292 0800
1000	M 10	x 1.5	100	24	39	10.0	8.0	11	4	8.5	T290 1000	T292 1000



Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
											T291	T293
0600	M 6	x 1	80	19	-	4.5	3.4	6	4	5.0	T291 0600	T293 0600
0800	M 8	x 1.25	90	22	-	6.0	4.9	8	4	6.8	T291 0800	T293 0800
1000	M 10	x 1.5	100	24	-	7.0	5.5	8	4	8.5	T291 1000	T293 1000
1200	M 12	x 1.75	110	28	-	9.0	7.0	10	4	10.2	T291 1200	T293 1200
1400	M 14	x 2	110	30	-	11.0	9.0	12	4	12.0	T291 1400	T293 1400
1600	M 16	x 2	110	32	-	12.0	9.0	12	4	14.0	T291 1600	T293 1600
1800	M 18	x 2.5	125	34	-	14.0	11.0	14	4	15.5	•	•
2000	M 20	x 2.5	140	34	-	16.0	12.0	15	4	17.5	T291 2000	T293 2000

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
T290																	◐	◐	◐	◐	●	●																												
T292																	◐	◐	◐	◐	●	●					●																							

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

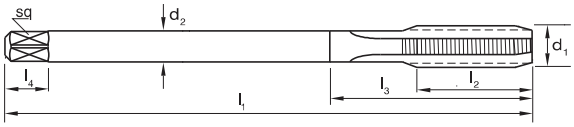
● Optimal ◐ Effective

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

M

suttontools

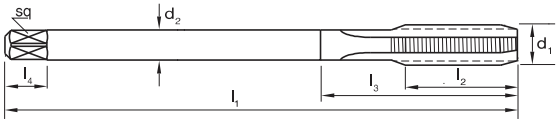
- VHM, for use in Al >10%Si & cast iron (GGG)
- Through & blind holes
- Depths up to 3 x d_1



Catalogue Code	T670	T741
Discount Group	D0414	D0414
Material	VHM	VHM
Surface Finish	TiCN	TiCN
Sutton Designation	GGG	GGG
Geometry	Low Relief	IK
Chamfer	Form C/ 2.5 x P	Form C/ 2.5 x P
Limit & Nut Tolerance	6H	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 0.40	45	8	-	2.8	2.1	5	4	1.6	•	•
0220	M 2.2	x 0.45	45	9	-	2.8	2.1	5	4	1.75	•	•
0230	M 2.3	x 0.4	45	9	-	2.8	2.1	5	4	1.9	•	•
0250	M 2.5	x 0.45	50	9	-	2.8	2.1	5	4	2.05	•	•
0260	M 2.6	x 0.45	50	9	-	2.8	2.1	5	4	2.15	•	•
0300	M 3	x 0.5	56	11	18	3.5	2.7	6	4	2.5	•	•
0350	M 3.5	x 0.6	56	13	20	4.0	3.0	6	4	2.9	•	•
0400	M 4	x 0.7	63	13	21	4.5	3.4	6	4	3.3	•	•
0500	M 5	x 0.8	70	16	25	6.0	4.9	8	4	4.2	•	•
0600	M 6	x 1	80	19	30	6.0	4.9	8	4	5.1	T670 0600	•
0800	M 8	x 1.25	90	22	35	8.0	6.2	9	4	6.9	T670 0800	•
1000	M 10	x 1.5	100	24	39	10.0	8.0	11	4	8.6	T670 1000	•

M



Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
											T671	T742
0600	M 6	x 1	80	19	-	4.5	3.4	6	4	5.1	•	•
0800	M 8	x 1.25	90	22	-	6.0	4.9	8	4	6.9	•	•
1000	M 10	x 1.5	100	24	-	7.0	5.5	8	4	8.6	•	•
1200	M 12	x 1.75	110	28	-	9.0	7.0	10	4	10.3	T671 1200	•
1400	M 14	x 2	110	30	-	11.0	9.0	12	4	12.1	•	•
1600	M 16	x 2	110	32	-	12.0	9.0	12	4	14.1	T671 1600	•
1800	M 18	x 2.5	125	34	-	14.0	11.0	14	4	15.7	•	•
2000	M 20	x 2.5	140	34	-	16.0	12.0	15	4	17.7	•	•

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
T670																	◐	◐	◐	◐	○	○					◐		◐																			◐	
T741																	◐	◐	◐	◐	○	○					◐		◐																			◐	

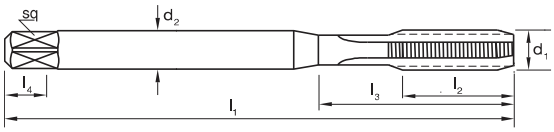
P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials

○ Optimal ◐ Effective

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

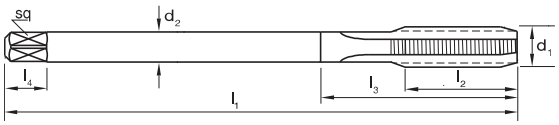
suttontools

- For production tapping in die cast materials
- PM-HSS Co for superior tool life
- Form E for maximum thread depth in blind holes
- Depths up to 1.5 x d_1



Catalogue Code	T335	T357
Discount Group	D0408	D0408
Material	PM-HSS Co	PM-HSS Co
Surface Finish	TiCN	TiCN
Sutton Designation	Die Cast	Die Cast
Geometry		IK
Chamfer	Form E/ 1.5 x P	Form E/ 1.5 x P
Limit & Nut Tolerance	6HX	6HX

Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
0600	M 6	x 1	80	19	30	6.0	4.9	8	4	5.0	T335 0600	T357 0600
0800	M 8	x 1.25	90	22	35	8.0	6.2	9	4	6.8	T335 0800	T357 0800
1000	M 10	x 1.5	100	24	39	10.0	8.0	11	4	8.5	T335 1000	T357 1000



Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
											T336	T358
1200	M 12	x 1.75	110	28	-	9.0	7.0	10	4	10.2	T336 1200	T358 1200
1400	M 14	x 2	110	30	-	11.0	9.0	12	4	12.0	T336 1400	T358 1400
1600	M 16	x 2	110	32	-	12.0	9.0	12	4	14.0	T336 1600	T358 1600
2000	M 20	x 2.5	140	34	-	16.0	12.0	15	4	17.5	T336 2000	T358 2000

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
T335																	●	●	●	●	●	●			◐	◐	◐		●																				◐	
T357																	●	●	●	●	●	●			◐	◐	◐		●																				◐	

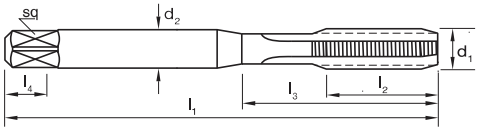
P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials

● Optimal ◐ Effective

M

suttontools

- Use in hardened steels 42-52 HRC
- Through & blind holes
- Depths up to 1.5 x d_1



Catalogue Code	T294	T295
Discount Group	DO408	DO408
Material	SPM	SPM
Surface Finish	TiCN	TiCN
Sutton Designation	XH	XH
Geometry	Special Relief	Special Relief
Chamfer	Form C/ 3 x P	Form D/ 5 x P
Limit & Nut Tolerance	6HX	6HX

Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
0300	M 3	x 0.5	46	11	18	3.5	2.7	6	4	2.55	T294 0300	T295 0300
0400	M 4	x 0.7	52	13	21	4.5	3.4	6	4	3.4	T294 0400	T295 0400
0500	M 5	x 0.8	60	16	25	6.0	4.9	8	4	4.3	T294 0500	T295 0500
0600	M 6	x 1	62	19	30	6.0	4.9	8	4	5.1	T294 0600	T295 0600
0800	M 8	x 1.25	70	22	-	6.0	4.9	9	5	6.9	T294 0800	T295 0800
1000	M 10	x 1.5	75	24	-	7.0	5.5	11	5	8.6	T294 1000	T295 1000
1200	M 12	x 1.75	82	29	-	9.0	7.0	10	5	10.3	T294 1200	T295 1200
1600	M 16	x 2	95	32	-	12.0	9.0	12	5	14.1	T294 1600	T295 1600
2000	M 20	x 2.5	105	37	-	16.0	12.0	15	5	17.7	T294 2000	T295 2000

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
T294					◐			◐	●		●		●					●		●									◐															●				●	
T295					◐			◐	●		●		●					●		●									◐															●				●	

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

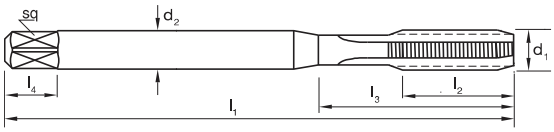
◐ Optimal ● Effective

DIN Taps Metric, Straight Flute, VH

suttontools

- Use in hardened steels 50-60 HRC
- Through & blind holes
- Depths up to 1.5 x d_1

DIN 371 | DIN 376 | 60° M



Catalogue Code	T296	T297
Discount Group	D0414	D0414
Material	VHM	VHM
Surface Finish	TiCN	TiCN
Sutton Designation	VH	VH
Geometry	Special Relief	Special Relief
Chamfer	Form C/ 3 x P	Form D/ 5 x P
Limit & Nut Tolerance	6HX	6HX

Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
	DIN371											
0300	M 3	x 0.5	56	11	18	3.5	2.7	6	4	2.55	T296 0300	T297 0300
0400	M 4	x 0.7	63	13	21	4.5	3.4	6	4	3.4	T296 0400	T297 0400
0500	M 5	x 0.8	70	16	25	6.0	4.9	8	4	4.3	T296 0500	T297 0500
0600	M 6	x 1	80	19	30	6.0	4.9	8	5	5.1	T296 0600	T297 0600
0800	M 8	x 1.25	90	22	35	8.0	6.2	9	5	6.9	T296 0800	T297 0800
1000	M 10	x 1.5	100	24	39	10.0	8.0	11	5	8.6	T296 1000	T297 1000
	DIN376											
1200	M 12	x 1.75	110	28	-	9.0	7.0	10	5	10.3	T296 1200	T297 1200
1600	M 16	x 2	110	32	-	12.0	9.0	12	6	14.1	T296 1600	T297 1600
2000	M 20	x 2.5	140	34	-	16.0	12.0	15	6	17.7	T296 2000	T297 2000

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
T296									●		●		●																●															◐	◐	◐	◐	◐	◐
T297									●		●		●																●															◐	◐	◐	◐	◐	◐

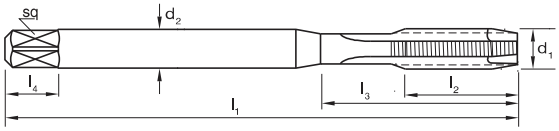
P Steel | M Stainless Steel | K Cast Iron | N Non-Ferrous Metals | S Titanium & Super Alloys | H Hard Materials

● Optimal ◐ Effective

M

suttontools

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



Catalogue Code	T100	T102	T104
Discount Group	D0402	D0402	D0406
Material	HSSE	HSSE	HSSE
Surface Finish	Brt	Blu	TiN
Sutton Designation	N	N	N
Geometry			
Chamfer	Form B / 4.5 x P	Form B / 4.5 x P	Form B / 4.5 x P
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 #
0100	M 1	x 0.25	40	6	-	2.5	2.1	5	2	0.75	T100 0100	•	•
0110	M 1.1	x 0.25	40	6	-	2.5	2.1	5	2	0.85	•	•	•
0120	M 1.2	x 0.25	40	6	-	2.5	2.1	5	2	0.95	T100 0120	•	•
0140	M 1.4	x 0.3	40	7	-	2.5	2.1	5	2	1.1	T100 0140	•	•
0160	M 1.6	x 0.35	40	8	-	2.5	2.1	5	2	1.25	T100 0160	•	•
0170	M 1.7	x 0.35	40	8	-	2.5	2.1	5	2	1.35	•	•	•
0180	M 1.8	x 0.35	40	8	-	2.5	2.1	5	2	1.45	T100 0180	•	•
0200	M 2	x 0.4	45	8	-	2.8	2.1	5	2	1.6	T100 0200	T102 0200	•
0220	M 2.2	x 0.45	45	9	-	2.8	2.1	5	2	1.75	T100 0220	T102 0220	•
0230	M 2.3	x 0.4	45	9	-	2.8	2.1	5	2	1.9	T100 0230	T102 0230	•
0250	M 2.5	x 0.45	50	9	-	2.8	2.1	5	2	2.05	T100 0250	T102 0250	•
0260	M 2.6	x 0.45	50	9	-	2.8	2.1	5	2	2.15	T100 0260	T102 0260	•
0300	M 3	x 0.5	56	11	18	3.5	2.7	6	3	2.5	T100 0300	T102 0300	T104 0300
0350	M 3.5	x 0.6	56	13	20	4.0	3.0	6	3	2.9	T100 0350	T102 0350	T104 0350
0400	M 4	x 0.7	63	13	21	4.5	3.4	6	3	3.3	T100 0400	T102 0400	T104 0400
0500	M 5	x 0.8	70	16	25	6.0	4.9	8	3	4.2	T100 0500	T102 0500	T104 0500
0600	M 6	x 1	80	19	30	6.0	4.9	8	3	5.0	T100 0600	T102 0600	T104 0600
0700	M 7	x 1	80	19	30	7.0	5.5	8	3	6.0	T100 0700	T102 0700	•
0800	M 8	x 1.25	90	22	35	8.0	6.2	9	3	6.8	T100 0800	T102 0800	T104 0800
1000	M 10	x 1.5	100	24	39	10.0	8.0	11	3	8.5	T100 1000	T102 1000	T104 1000

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
T100	◉	◉	○	○		◉	○			○							○		○		○	○	◉	◉	○	○		○	○																				
T102	◉	◉	◉	◉		◉	◉			◉		○		○	○	○	○		○		○	○																										
T104	◉	◉	◉	◉	○	◉	◉	○		◉		○		○	○	○	○	○	○	○	○	○	◉	◉	○	○		◉	○																				

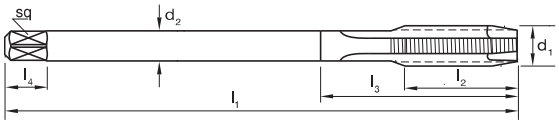
P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials

◉ 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 3 x d_1



Catalogue Code	T101	T103	T105
Discount Group	D0402	D0402	D0406
Material	HSSE	HSSE	HSSE
Surface Finish	Brt	Blu	TiN
Sutton Designation	N	N	N
Geometry			
Chamfer	Form B / 4.5 x P	Form B / 4.5 x P	Form B / 4.5 x P
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 #
0300	M3	x0.5	56	11	-	2.2	-	-	3	2.5	T101 0300	•	•
0400	M4	x0.7	63	13	-	2.8	2.1	5	3	3.3	T101 0400	•	•
0500	M5	x0.8	70	16	-	3.5	2.7	6	3	4.2	T101 0500	•	•
0600	M6	x1	80	19	-	4.5	3.4	6	3	5.0	T101 0600	T103 0600	T105 0600
0800	M8	x1.25	90	22	-	6.0	4.9	8	3	6.8	T101 0800	T103 0800	T105 0800
1000	M10	x1.5	100	24	-	7.0	5.5	8	3	8.5	T101 1000	T103 1000	T105 1000
1200	M12	x1.75	110	28	-	9.0	7.0	10	3	10.2	T101 1200	T103 1200	T105 1200
1400	M14	x2	110	30	-	11.0	9.0	12	3	12.0	T101 1400	T103 1400	T105 1400
1600	M16	x2	110	32	-	12.0	9.0	12	3	14.0	T101 1600	T103 1600	T105 1600
1800	M18	x2.5	125	34	-	14.0	11.0	14	4	15.5	T101 1800	T103 1800	T105 1800
2000	M20	x2.5	140	34	-	16.0	12.0	15	4	17.5	T101 2000	T103 2000	T105 2000
2200	M22	x2.5	140	34	-	18.0	14.5	17	4	19.5	T101 2200	T103 2200	T105 2200
2400	M24	x3	160	38	-	18.0	14.5	17	4	21.0	T101 2400	T103 2400	T105 2400
2700	M27	x3	160	38	-	20.0	16.0	19	4	24.0	T101 2700	•	T105 2700
3000	M30	x3.5	180	45	-	22.0	18.0	21	4	26.5	T101 3000	T103 3000	T105 3000
3300	M33	x3.5	180	50	-	25.0	20.0	23	4	29.5	T101 3300	•	•
3600	M36	x4	200	56	-	28.0	22.0	25	4	32.0	T101 3600	T103 3600	•
3900	M39	x4	200	60	-	32.0	24.0	27	4	35.0	T101 3900	•	•
4200	M42	x4.5	200	60	-	32.0	24.0	27	4	37.5	T101 4200	T103 4200	•
4500	M45	x4.5	220	65	-	36.0	29.0	32	4	40.5	T101 4500	•	•
4800	M48	x5	250	70	-	36.0	29.0	32	4	43.0	T101 4800	T103 4800	•
5200	M52	x5	250	70	-	40.0	32.0	35	4	47.0	T101 5200	T103 5200	•

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
T101	●	●	○	○		●	○			○							○		○		○	○	●	●	○	○		○	○																				
T103	●	●	●	●		●	●			●		○		○	○	○	○		○		○	○																										
T105	●	●	●	●	○	●	●	○		●		○		○	○	○	○	○	○	○	○	○	●	●	○	○		●	○																				

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

● Optimal ○ Effective

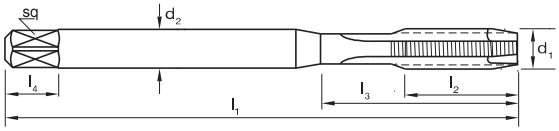
• Available on request as special manufacture. Subject to lead time.

M

DIN Taps Metric, Gun, N - 6G, 4H, LH

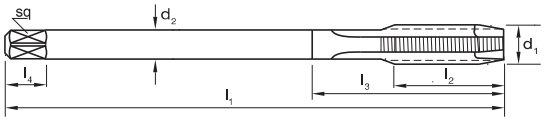
suttontools

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



Catalogue Code	T106	T108*	T648
Discount Group	D0402	D0402	D0402
Material	HSSE	HSSE	HSSE
Surface Finish	Brt	Brt	Brt
Sutton Designation	N	N	N
Geometry	6G	4H	Left Hand
Chamfer	Form B / 4.5 x P	Form B / 4.5 x P	Form B / 4.5 x P
Limit & Nut Tolerance	ISO 3 / 6G	ISO 1 / 4H	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 #
0200	M 2	x 0.4	45	8	-	2.8	2.1	5	2	1.6	•		•
0220	M 2.2	x 0.45	45	9	-	2.8	2.1	5	2	1.75	•		•
0230	M 2.3	x 0.4	45	9	-	2.8	2.1	5	2	1.9	•		•
0250	M 2.5	x 0.45	50	9	-	2.8	2.1	5	2	2.05	•		•
0260	M 2.6	x 0.45	50	9	-	2.8	2.1	5	2	2.15	•		•
0300	M 3	x 0.5	56	11	18	3.5	2.7	6	3	2.5	T106 0300	T108 0300	T648 0300
0350	M 3.5	x 0.6	56	13	20	4.0	3.0	6	3	2.9	T106 0350	T108 0350	•
0400	M 4	x 0.7	63	13	21	4.5	3.4	6	3	3.3	T106 0400		T648 0400
0500	M 5	x 0.8	70	16	25	6.0	4.9	8	3	4.2	T106 0500	T108 0500	T648 0500
0600	M 6	x 1	80	19	30	6.0	4.9	8	3	5.0	T106 0600	T108 0600	T648 0600
0800	M 8	x 1.25	90	22	35	8.0	6.2	9	3	6.8	T106 0800	T108 0800	T648 0800
1000	M 10	x 1.5	100	24	39	10.0	8.0	11	3	8.5	T106 1000	T108 1000	T648 1000



Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #	Item #
											T107	T109*	T649
0600	M 6	x 1	80	19	-	4.5	3.4	6	3	5.0	•		•
0800	M 8	x 1.25	90	22	-	6.0	4.9	8	3	6.8	•		•
1000	M 10	x 1.5	100	24	-	7.0	5.5	8	3	8.5	•		•
1200	M 12	x 1.75	110	28	-	9.0	7.0	10	3	10.2	T107 1200	T109 1200	T649 1200
1400	M 14	x 2	110	30	-	11.0	9.0	12	3	12.0	T107 1400	T109 1400	T649 1400
1600	M 16	x 2	110	32	-	12.0	9.0	12	3	14.0	T107 1600	T109 1600	T649 1600
1800	M 18	x 2.5	125	34	-	14.0	11.0	14	4	15.5	T107 1800	T109 1800	T649 1800
2000	M 20	x 2.5	140	34	-	16.0	12.0	15	4	17.5	T107 2000		T649 2000

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
T106	●	●	○	○		●	○			○							○		○		○	○	●	●	○	○		○	○																				
T108	●	●	○	○		●	○			○							○		○		○	○	●	●	○	○		○	○																				
T648	●	●	○	○		●	○			○							○		○		○	○	●	●	○	○		○	○																				

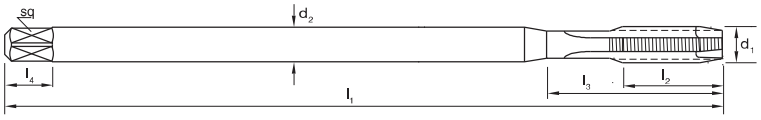
P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials

● Optimal ○ Effective

• Available on request as special manufacture. Subject to lead time. *Not available once current stock is depleted

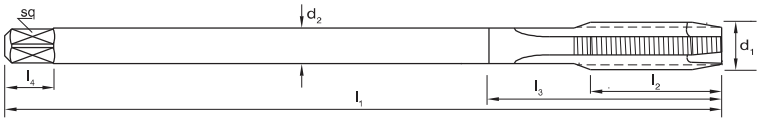
suttontools

- For long reach applications
- Suitable for materials up to 1000N/mm²
- Depths up to 3 x d_1
- d_2 and sq in accordance to DIN371



Catalogue Code	T337
Discount Group	D0402
Material	HSSE
Surface Finish	Brt
Sutton Designation	N
Geometry	Extra Length
Chamfer	Form B / 4.5 x P
Limit & Nut Tolerance	ISO 2 / 6H

Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #
0300	M 3	x 0.5	112	11		3.5	2.7	6	3	2.5	T337 0300
0400	M 4	x 0.7	126	13		4.5	3.4	6	3	3.3	T337 0400
0500	M 5	x 0.8	140	15		6.0	4.9	8	3	4.2	T337 0500
0600	M 6	x 1	160	17		6.0	4.9	8	3	5.0	T337 0600
0800	M 8	x 1.25	180	20		8.0	6.2	10	3	6.8	T337 0800



Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #
											T338
1000	M 10	x 1.5	200	24	100	7.0	5.5	8	3	8.5	T338 1000
1200	M 12	x 1.75	220	28	110	9.0	7.0	10	3	10.2	T338 1200
1400	M 14	x 2	220	30	110	11.0	9.0	12	3	12.0	T338 1400
1600	M 16	x 2	220	32	110	12.0	9.0	12	3	14.0	T338 1600
2000	M 20	x 2.5	280	34	110	16.0	12.0	15	4	17.5	T338 2000
2400	M 24	x 3	320	38	120	18.0	14.5	17	4	21.0	T338 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
T337	◐	◐	●	●		◐	●			●							●		●		●	●	◐	◐	●	●		●	●																				
T338	◐	◐	●	●		◐	●			●							●		●		●	●	◐	◐	●	●		●	●																				

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

● Optimal ◐ Effective

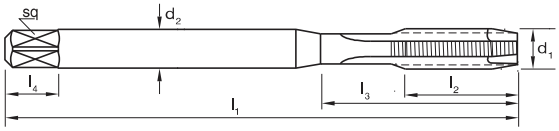
M

suttontools BLACKMAGIC

watch the video

- Universal high performance tapping
- PM-HSSE V3 offers superior tool life
- Use in stainless steels and high strength steels up to 850N/mm²
- Through holes up to 3 x d_1
- Suitable for synchronous tapping in machine operations

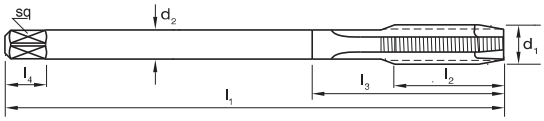
DIN 371 | 60° M | Z



Catalogue Code	T687
Discount Group	D0410
Material	PM-HSSE V3
Surface Finish	HARDLUBE
Sutton Designation	UNI
Geometry	Special Relief
Chamfer	Form B / 4.5 x P
Limit & Nut Tolerance	6HX

Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #
0200	M 2	x 0.4	45	8	-	2.8	2.1	5	3	1.6	•
0220	M 2.2	x 0.45	45	9	-	2.8	2.1	5	3	1.75	•
0230	M 2.3	x 0.4	45	9	-	2.8	2.1	5	3	1.9	•
0250	M 2.5	x 0.45	50	9	-	2.8	2.1	5	3	2.05	•
0260	M 2.6	x 0.45	50	9	-	2.8	2.1	5	3	2.15	•
0300	M 3	x 0.5	56	11	18	3.5	2.7	6	3	2.5	T687 0300
0350	M 3.5	x 0.6	56	13	20	4.0	3.0	6	3	2.9	•
0400	M 4	x 0.7	63	13	21	4.5	3.4	6	3	3.3	T687 0400
0500	M 5	x 0.8	70	16	25	6.0	4.9	8	3	4.2	T687 0500
0600	M 6	x 1	80	19	30	6.0	4.9	8	3	5.0	T687 0600
0800	M 8	x 1.25	90	22	35	8.0	6.2	9	3	6.8	T687 0800
1000	M 10	x 1.5	100	24	39	10.0	8.0	11	3	8.5	T687 1000

DIN 376 | 60° M | Z



Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #
											T688
1200	M 12	x 1.75	110	17.5	-	9.0	7.0	10	3	10.2	T688 1200
1400	M 14	x 2	110	20	-	11.0	9.0	12	3	12.0	T688 1400
1600	M 16	x 2	110	20	-	12.0	9.0	12	4	14.0	T688 1600
1800	M 18	x 2.5	125	25	-	14.0	11.0	14	4	15.5	T688 1800
2000	M 20	x 2.5	140	25	-	16.0	12.0	15	4	17.5	T688 2000
2200	M 22	x 2.5	140	25	-	18.0	14.5	17	4	19.5	•
2400	M 24	x 3	160	30	-	18.0	14.5	17	4	21.0	•
2700	M 27	x 3	160	30	-	20.0	16.0	19	4	24.0	•
3000	M 30	x 3.5	180	35	-	22.0	18.0	21	4	26.5	•

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
T687	●	●	●	○		●	○			●		●	○	●	●		○	○	○	○	○	○	●	●	●	○	○	○	○	○																		

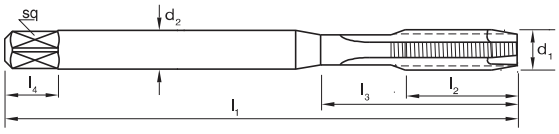
P Steel | M Stainless Steel | K Cast Iron | N Non-Ferrous Metals | S Titanium & Super Alloys | H Hard Materials

● Optimal ○ Effective

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

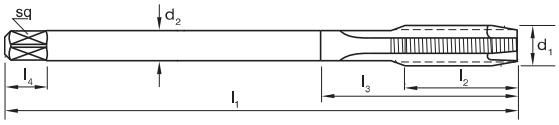
suttontools

- Suitable for use in soft materials
- CrN for copper and non-ferrous materials
- Through holes
- Depths up to 3 x d_1



Catalogue Code	T122	T124	T126
Discount Group	D0402	D0402	D0404
Material	HSSE	HSSE	HSSE
Surface Finish	Ni	Blu	CrN
Sutton Designation	W	W	Qu
Geometry			
Chamfer	Form B / 4.5 x P	Form B / 4.5 x P	Form B / 4.5 x P
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 #
0200	M 2	x 0.4	45	8	-	2.8	2.1	5	2	1.6	T122 0200	•	•
0220	M 2.2	x 0.45	45	9	-	2.8	2.1	5	2	1.75	•	•	•
0230	M 2.3	x 0.4	45	9	-	2.8	2.1	5	2	1.9	•	•	•
0250	M 2.5	x 0.45	50	9	-	2.8	2.1	5	2	2.05	T122 0250	•	•
0260	M 2.6	x 0.45	50	9	-	2.8	2.1	5	2	2.15	•	•	•
0300	M 3	x 0.5	56	11	18	3.5	2.7	6	3	2.5	T122 0300	T124 0300	T126 0300
0350	M 3.5	x 0.6	56	13	20	4.0	3.0	6	3	2.9	T122 0350	•	•
0400	M 4	x 0.7	63	13	21	4.5	3.4	6	3	3.3	T122 0400	T124 0400	T126 0400
0500	M 5	x 0.8	70	16	25	6.0	4.9	8	3	4.2	T122 0500	T124 0500	T126 0500
0600	M 6	x 1	80	19	30	6.0	4.9	8	3	5.0	T122 0600	T124 0600	T126 0600
0800	M 8	x 1.25	90	22	35	8.0	6.2	9	3	6.8	T122 0800	T124 0800	T126 0800
1000	M 10	x 1.5	100	24	39	10.0	8.0	11	3	8.5	T122 1000	T124 1000	T126 1000



Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #	Item #
											T123	T125	T127
0600	M 6	x 1	80	19	-	4.5	3.4	6	3	5.0	•	•	•
0800	M 8	x 1.25	90	22	-	6.0	4.9	8	3	6.8	•	•	•
1000	M 10	x 1.5	100	24	-	7.0	5.5	8	3	8.5	•	•	•
1200	M 12	x 1.75	110	28	-	9.0	7.0	10	3	10.2	T123 1200	T125 1200	T127 1200
1400	M 14	x 2	110	30	-	11.0	9.0	12	3	12.0	T123 1400	•	•
1600	M 16	x 2	110	32	-	12.0	9.0	12	4	14.0	T123 1600	T125 1600	T127 1600
1800	M 18	x 2.5	125	34	-	14.0	11.0	14	4	15.5	T123 1800	•	•
2000	M 20	x 2.5	140	34	-	16.0	12.0	15	4	17.5	T123 2000	T125 2000	T127 2000

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
T122	●	●	○	○		●	○																●	●	○	○		○	○	○																			
T124	●	●	○	○		●	○																●	●	○	○	○																						
T126																							●	●	●	○	●	○	●	○																				

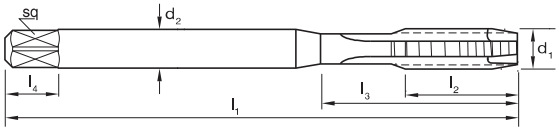
P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials

● Optimal ○ Effective

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

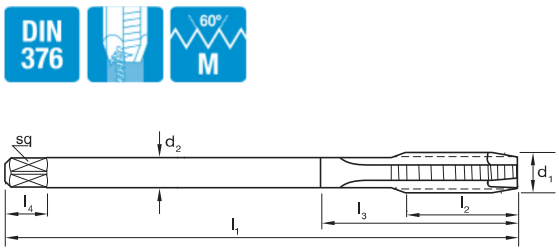
suttontools

- Use in soft elastic materials
- Through holes
- Depths up to 3 x d_1



Catalogue Code	T128	T130
Discount Group	D0402	D0406
Material	HSSE	HSSE
Surface Finish	Brt	TiN
Sutton Designation	Sticky Material	Sticky Material
Geometry	Interrupted Threads	Interrupted Threads
Chamfer	Form B / 4.5 x P	Form B / 4.5 x P
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	45	8	-	2.8	2.1	5	3	1.6	•	•
0220	M 2.2	x 0.45	45	9	-	2.8	2.1	5	3	1.75	•	•
0230	M 2.3	x 0.4	45	9	-	2.8	2.1	5	3	1.9	•	•
0250	M 2.5	x 0.45	50	9	-	2.8	2.1	5	3	2.05	•	•
0260	M 2.6	x 0.45	50	9	-	2.8	2.1	5	3	2.15	•	•
0300	M 3	x 0.5	56	11	18	3.5	2.7	6	3	2.5	T128 0300	T130 0300
0350	M 3.5	x 0.6	56	13	20	4.0	3.0	6	3	2.9	•	•
0400	M 4	x 0.7	63	13	21	4.5	3.4	6	3	3.3	T128 0400	T130 0400
0500	M 5	x 0.8	70	16	25	6.0	4.9	8	3	4.2	T128 0500	T130 0500
0600	M 6	x 1	80	19	30	6.0	4.9	8	3	5.0	T128 0600	T130 0600
0800	M 8	x 1.25	90	22	35	8.0	6.2	9	3	6.8	T128 0800	T130 0800
1000	M 10	x 1.5	100	24	39	10.0	8.0	11	3	8.5	T128 1000	T130 1000



Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
											T129	T131
0600	M 6	x 1	80	19	-	4.5	3.4	6	3	5.0	•	•
0800	M 8	x 1.25	90	22	-	6.0	4.9	8	3	6.8	•	•
1000	M 10	x 1.5	100	24	-	7.0	5.5	8	3	8.5	•	•
1200	M 12	x 1.75	110	28	-	9.0	7.0	10	3	10.2	T129 1200	T131 1200
1400	M 14	x 2	110	30	-	11.0	9.0	12	3	12.0	T129 1400	T131 1400
1600	M 16	x 2	110	32	-	12.0	9.0	12	3	14.0	T129 1600	T131 1600

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
T128	●	●	●	●		●	●					●		●	●								◐	●				◐	◐	◐																			
T130	◐	●	●	●		●	●			●		●		●	●								●	●				◐	◐	◐																			

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

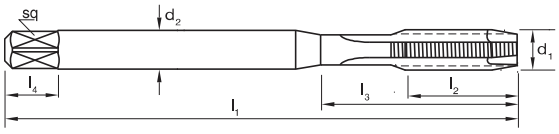
● Optimal ◐ Effective

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

suttontools

- Use in stainless steels and high strength steels
- Suitable for materials up to 850N/mm²
- Through holes
- Depths up to 3 x d_1

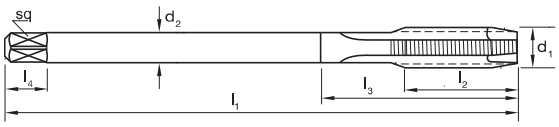
DIN 371 | 60° M



Catalogue Code	T110	T359	T112
Discount Group	D0402	D0402	D0408
Material	HSSE	HSSE	HSSE
Surface Finish	Blu	Blu	TiCN
Sutton Designation	VA	VA	VA
Geometry	Special Relief	Special Relief	Special Relief
Chamfer	Form B / 4.5 x P	Form B / 4.5 x P	Form B / 4.5 x P
Limit & Nut Tolerance	ISO 2 / 6H	ISO 3 / 6G	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 #
0200	M 2	x 0.4	45	8	-	2.8	2.1	5	3	1.6	•	•	•
0220	M 2.2	x 0.45	45	9	-	2.8	2.1	5	3	1.75	•	•	•
0230	M 2.3	x 0.4	45	9	-	2.8	2.1	5	3	1.9	•	•	•
0250	M 2.5	x 0.45	50	9	-	2.8	2.1	5	3	2.05	•	•	•
0260	M 2.6	x 0.45	50	9	-	2.8	2.1	5	3	2.15	•	•	•
0300	M 3	x 0.5	56	11	18	3.5	2.7	6	3	2.5	T110 0300	•	T112 0300
0350	M 3.5	x 0.6	56	13	20	4.0	3.0	6	3	2.9	T110 0350	•	T112 0350
0400	M 4	x 0.7	63	13	21	4.5	3.4	6	3	3.3	T110 0400	•	T112 0400
0500	M 5	x 0.8	70	16	25	6.0	4.9	8	3	4.2	T110 0500	•	T112 0500
0600	M 6	x 1	80	19	30	6.0	4.9	8	3	5.0	T110 0600	•	T112 0600
0800	M 8	x 1.25	90	22	35	8.0	6.2	9	3	6.8	T110 0800	•	T112 0800
1000	M 10	x 1.5	100	24	39	10.0	8.0	11	3	8.5	T110 1000	•	T112 1000

DIN 376 | 60° M



Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #	Item #
											T111	T360	T113
0600	M 6	x 1	80	19	-	4.5	3.4	6	3	5.0	T111 0600	•	T113 0600
0800	M 8	x 1.25	90	22	-	6.0	4.9	8	3	6.8	T111 0800	•	T113 0800
1000	M 10	x 1.5	100	24	-	7.0	5.5	8	3	8.5	T111 1000	•	T113 1000
1200	M 12	x 1.75	110	28	-	9.0	7.0	10	3	10.2	T111 1200	•	T113 1200
1400	M 14	x 2	110	30	-	11.0	9.0	12	3	12.0	T111 1400	•	T113 1400
1600	M 16	x 2	110	32	-	12.0	9.0	12	4	14.0	T111 1600	•	T113 1600
1800	M 18	x 2.5	125	34	-	14.0	11.0	14	4	15.5	T111 1800	•	T113 1800
2000	M 20	x 2.5	140	34	-	16.0	12.0	15	4	17.5	T111 2000	•	T113 2000
2200	M 22	x 2.5	140	34	-	18.0	14.5	17	4	19.5	T111 2200	•	T113 2200
2400	M 24	x 3	160	38	-	18.0	14.5	17	4	21.0	T111 2400	•	T113 2400
2700	M 27	x 3	160	38	-	20.0	16.0	19	4	24.0	T111 2700	•	T113 2700
3000	M 30	x 3.5	180	45	-	22.0	18.0	21	4	26.5	T111 3000	•	T113 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
T110	●	●	○	○		●	○					○		●	●	○																																		
T359	●	●	○	○		●	○					○		●	●	○																																		
T112	●	●	○	○		●	○			○		●	○	●	●	●							○	○	○	○	○	○		○			●	○	○															

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

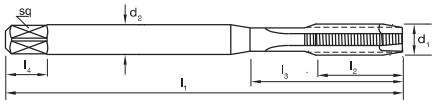
● Optimal ○ Effective

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

M

suttontools

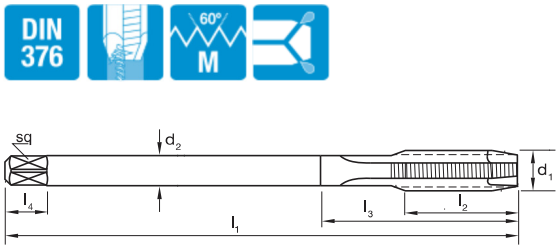
- PM-HSSE V3 offers superior performance
- Use in stainless steels and high strength steels
- Suitable for materials up to 850N/mm²
- Through holes
- Depths up to 3 x d_1



Catalogue Code	T114	T116	T680	T118
Discount Group	D0402	D0408	D0408	D0408
Material	PM-HSSE V3	PM-HSSE V3	PM-HSSE V3	PM-HSSE V3
Surface Finish	Blu	TiCN	TiCN	TiCN
Sutton Designation	VA PM	VA PM	VA PM	VA PM
Geometry	Special Relief	Special Relief	Special Relief	Internal Coolant
Chamfer	Form B / 4.5 x P	Form B / 4.5 x P	Form B / 4.5 x P	Form B / 4.5 x P
Limit & Nut Tolerance	6HX	6HX	6GX	6HX

Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #	Item #	Item #
0160	M 1.6	x 0.35	40	8	-	2.5	2.1	5	3	1.25	•	T116 0160	•	•
0200	M 2	x 0.4	45	8	-	2.8	2.1	5	3	1.6	T114 0200	T116 0200	T680 0200	•
0220	M 2.2	x 0.45	45	9	-	2.8	2.1	5	3	1.75	•	•	•	•
0230	M 2.3	x 0.4	45	9	-	2.8	2.1	5	3	1.9	•	•	•	•
0250	M 2.5	x 0.45	50	9	-	2.8	2.1	5	3	2.05	T114 0250	T116 0250	T680 0250	•
0300	M 3	x 0.5	56	11	18	3.5	2.7	6	3	2.5	T114 0300	T116 0300	T680 0300	•
0350	M 3.5	x 0.6	56	13	20	4.0	3.0	6	3	2.9	•	T116 0350	T680 0350	•
0400	M 4	x 0.7	63	13	21	4.5	3.4	6	3	3.3	T114 0400	T116 0400	T680 0400	•
0500	M 5	x 0.8	70	16	25	6.0	4.9	8	3	4.2	T114 0500	T116 0500	T680 0500	T118 0500
0600	M 6	x 1	80	19	30	6.0	4.9	8	3	5.0	T114 0600	T116 0600	T680 0600	T118 0600
0800	M 8	x 1.25	90	22	35	8.0	6.2	9	3	6.8	T114 0800	T116 0800	T680 0800	T118 0800
1000	M 10	x 1.5	100	24	39	10.0	8.0	11	3	8.5	T114 1000	T116 1000	T680 1000	T118 1000

M



Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #	Item #	Item #
											T115	T117	T681	T119
1200	M 12	x 1.75	110	28	-	9.0	7.0	10	3	10.2	T115 1200	T117 1200	T681 1200	T119 1200
1400	M 14	x 2	110	30	-	11.0	9.0	12	3	12.0	T115 1400	T117 1400	T681 1400	T119 1400
1600	M 16	x 2	110	32	-	12.0	9.0	12	4	14.0	T115 1600	T117 1600	T681 1600	T119 1600
1800	M 18	x 2.5	125	34	-	14.0	11.0	14	4	15.5	T115 1800	T117 1800	T681 1800	T119 1800
2000	M 20	x 2.5	140	34	-	16.0	12.0	15	4	17.5	T115 2000	T117 2000	T681 2000	T119 2000
2200	M 22*	x 2.5	140	34	-	18.0	14.5	17	4	19.5	•	•	T681 2200	•
2400	M 24*	x 3	160	38	-	18.0	14.5	17	4	21.0	•	•	T681 2400	•
2700	M 27*	x 3	160	38	-	20.0	16.0	19	4	24.0	•	•	•	•
3000	M 30*	x 3.5	180	45	-	22.0	18.0	21	4	26.5	•	•	•	•

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
T114	●	●	○	○		●	○			○		○		●	●	○																																		
T116	●	●	○	○		●	○			○		●	○	●	●	●							○	○	○	○	○	○		○			●	●	●														
T680	●	●	○	○		●	○			○		●	○	●	●	●							○	○	○	○	○	○		○			●	●	●														
T118	●	●	○	○		●	○			○		●	○	●	●	●							○	○	○	○	○	○		○			●	●	●														

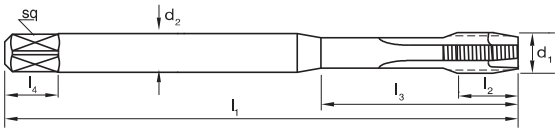
P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials

● Optimal ○ Effective

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

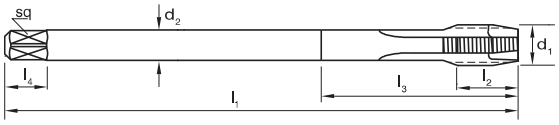
suttontools

- Suitable for synchronous tapping in deep holes
- PM-HSSE V3 offers superior performance
- Use in stainless steels and high strength steels up to 850N/mm²
- Through holes
- Depths up to 3,5 x d_1



Catalogue Code	T650	T120
Discount Group	D0402	D0408
Material	PM-HSSE V3	PM-HSSE V3
Surface Finish	Blu	TiCN
Sutton Designation	VA DH	VA DH
Geometry	Short Pod	Short Pod
Chamfer	Form B / 4.5 x P	Form B / 4.5 x P
Limit & Nut Tolerance	6HX	6HX

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	45	8	-	2.8	2.1	5	2	1.6	•	•
0220	M 2.2	x 0.45	45	9	-	2.8	2.1	5	2	1.75	•	•
0230	M 2.3	x 0.4	45	9	-	2.8	2.1	5	2	1.9	•	•
0250	M 2.5	x 0.45	50	9	-	2.8	2.1	5	2	2.05	•	•
0260	M 2.6	x 0.45	50	9	-	2.8	2.1	5	2	2.15	•	•
0300	M 3	x 0.5	56	5	18	3.5	2.7	6	3	2.5	T650 0300	T120 0300
0350	M 3.5	x 0.6	56	6	20	4.0	3.0	6	3	2.9	•	•
0400	M 4	x 0.7	63	7	21	4.5	3.4	6	3	3.3	T650 0400	T120 0400
0500	M 5	x 0.8	70	8	25	6.0	4.9	8	3	4.2	T650 0500	T120 0500
0600	M 6	x 1	80	10	30	6.0	4.9	8	3	5.0	T650 0600	T120 0600
0800	M 8	x 1.25	90	12.5	35	8.0	6.2	9	3	6.8	T650 0800	T120 0800
1000	M 10	x 1.5	100	15	39	10.0	8.0	11	3	8.5	T650 1000	T120 1000



Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
											T651	T121
0600	M 6	x 1	80	10	-	4.5	3.4	6	3	5.0	•	•
0800	M 8	x 1.25	90	12.5	-	6.0	4.9	8	3	6.8	•	•
1000	M 10	x 1.5	100	15	-	7.0	5.5	8	3	8.5		•
1200	M 12	x 1.75	110	17.5	-	9.0	7.0	10	3	10.2	T651 1200	T121 1200
1400	M 14	x 2	110	20	-	11.0	9.0	12	3	12.0	T651 1400	T121 1400
1600	M 16	x 2	110	20	-	12.0	9.0	12	4	14.0	T651 1600	T121 1600
1800	M 18	x 2.5	125	25	-	14.0	11.0	14	4	15.5	•	T121 1800
2000	M 20	x 2.5	140	25	-	16.0	12.0	15	4	17.5	T651 2000	T121 2000

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
T650	◐	◐	○	○		◐	○			○		○		◐	◐	○							○	○	○	○	○	○		○																				
T120	◐	◐	○	○		◐	○			○		◐	○	◐	◐	◐							○	○	○	○	○	○		○																				

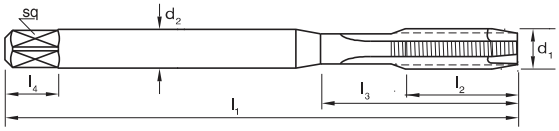
P Steel | M Stainless Steel | K Cast Iron | N Non-Ferrous Metals | S Titanium & Super Alloys | H Hard Materials

● Optimal ◐ Effective

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

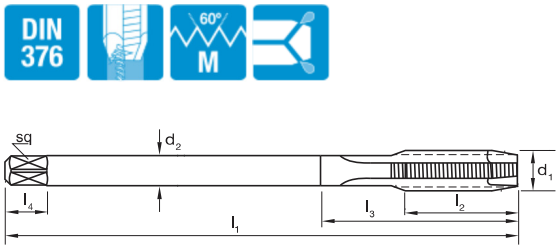
suttontools

- Suitable for harder materials up to 42 HRC
- Through holes
- Depths up to 3 x d_1



Catalogue Code	T134	T140	T142
Discount Group	D0402	D0410	D0410
Material	PM-HSSE V3	PM-HSSE V3	PM-HSSE V3
Surface Finish	Blu	TiAlN	TiAlN
Sutton Designation	NH	NH	NH
Geometry			IK
Chamfer	Form B / 4.5 x P	Form B / 4.5 x P	Form B / 4.5 x P
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 #
0200	M 2	x 0.4	45	8	-	2.8	2.1	5	3	1.6	•	•	•
0220	M 2.2	x 0.45	45	9	-	2.8	2.1	5	3	1.75	•	•	•
0230	M 2.3	x 0.4	45	9	-	2.8	2.1	5	3	1.9	•	•	•
0250	M 2.5	x 0.45	50	9	-	2.8	2.1	5	3	2.05	•	•	•
0260	M 2.6	x 0.45	50	9	-	2.8	2.1	5	3	2.15	•	•	•
0300	M 3	x 0.5	56	11	18	3.5	2.7	6	3	2.5	T134 0300	T140 0300	•
0350	M 3.5	x 0.6	56	13	20	4.0	3.0	6	3	2.9	•	•	•
0400	M 4	x 0.7	63	13	21	4.5	3.4	6	3	3.3	T134 0400	T140 0400	•
0500	M 5	x 0.8	70	16	25	6.0	4.9	8	3	4.2	T134 0500	T140 0500	•
0600	M 6	x 1	80	19	30	6.0	4.9	8	3	5.0	T134 0600	T140 0600	T142 0600
0800	M 8	x 1.25	90	22	35	8.0	6.2	9	3	6.8	T134 0800	T140 0800	T142 0800
1000	M 10	x 1.5	100	24	39	10.0	8.0	11	3	8.5	T134 1000	T140 1000	T142 1000



Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #	Item #
											T135	T141	T143
1200	M 12	x 1.75	110	28	-	9.0	7.0	10	3	10.2	T135 1200	T141 1200	T143 1200
1400	M 14	x 2	110	30	-	11.0	9.0	12	3	12.0	T135 1400	T141 1400	T143 1400
1600	M 16	x 2	110	32	-	12.0	9.0	12	4	14.0	T135 1600	T141 1600	T143 1600
1800	M 18	x 2.5	125	34	-	14.0	11.0	14	4	15.5	T135 1800	T141 1800	T143 1800
2000	M 20	x 2.5	140	34	-	16.0	12.0	15	4	17.5	T135 2000	T141 2000	T143 2000
2200	M 22	x 2.5	140	34	-	18.0	14.5	17	4	19.5	•	•	•
2400	M 24	x 3	160	38	-	18.0	14.5	17	4	21.0	•	•	•
2700	M 27	x 3	160	38	-	20.0	16.0	19	4	24.0	•	•	•
3000	M 30	x 3.5	180	45	-	22.0	18.0	21	4	26.5	•	•	•

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
T134			◐	◐	○		◐	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○																										○	
T140			◐	◐	◐		◐	◐	○	◐	○	○	○	○	○	◐	○	○	○	○	◐	○			○	○	○	◐	○	○															○				○	
T142			◐	◐	◐		◐	◐	○	◐	○	○	○	○	○	◐	○	○	○	○	◐	○			○	○	○	◐	○	○															○				○	

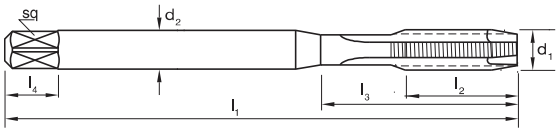
P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials

○ Optimal ◐ Effective

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

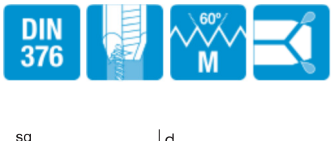
suttontools

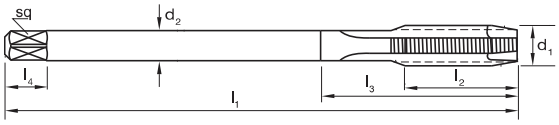
- Suitable for harder materials up to 45 HRC
- Through holes
- Depths up to 3 x d_1



Catalogue Code	T144	T146	T148
Discount Group	D0402	D0408	D0408
Material	PM-HSS Co	PM-HSS Co	PM-HSS Co
Surface Finish	Blu	TiCN	TiCN
Sutton Designation	H	H	H
Geometry	Low Relief	Low Relief	Low Relief - IK
Chamfer	Form B / 4.5 x P	Form B / 4.5 x P	Form B / 4.5 x P
Limit & Nut Tolerance	6HX	6HX	6HX

Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #	Item #
0200	M 2	x 0.4	45	8	-	2.8	2.1	5	3	1.6	•	•	•
0220	M 2.2	x 0.45	45	9	-	2.8	2.1	5	3	1.75	•	•	•
0230	M 2.3	x 0.4	45	9	-	2.8	2.1	5	3	1.9	•	•	•
0250	M 2.5	x 0.45	50	9	-	2.8	2.1	5	3	2.05	•	•	•
0260	M 2.6	x 0.45	50	9	-	2.8	2.1	5	3	2.15	•	•	•
0300	M 3	x 0.5	56	11	18	3.5	2.7	6	3	2.5	T144 0300	T146 0300	•
0350	M 3.5	x 0.6	56	13	20	4.0	3.0	6	3	2.9	•	•	•
0400	M 4	x 0.7	63	13	21	4.5	3.4	6	3	3.3	T144 0400	T146 0400	•
0500	M 5	x 0.8	70	16	25	6.0	4.9	8	3	4.2	T144 0500	T146 0500	•
0600	M 6	x 1	80	19	30	6.0	4.9	8	3	5.0	T144 0600	T146 0600	T148 0600
0800	M 8	x 1.25	90	22	35	8.0	6.2	9	3	6.8	T144 0800	T146 0800	T148 0800
1000	M 10	x 1.5	100	24	39	10.0	8.0	11	3	8.5	T144 1000	T146 1000	T148 1000





Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #	Item #
											T145	T147	T149
1200	M 12	x 1.75	110	28	-	9.0	7.0	10	3	10.2	T145 1200	T147 1200	T149 1200
1400	M 14	x 2	110	30	-	11.0	9.0	12	3	12.0	T145 1400	T147 1400	T149 1400
1600	M 16	x 2	110	32	-	12.0	9.0	12	4	14.0	T145 1600	T147 1600	T149 1600
1800	M 18	x 2.5	125	34	-	14.0	11.0	14	4	15.5	T145 1800	T147 1800	T149 1800
2000	M 20	x 2.5	140	34	-	16.0	12.0	15	4	17.5	T145 2000	T147 2000	T149 2000
2200	M 22	x 2.5	140	34	-	18.0	14.5	17	4	19.5	•	•	•
2400	M 24	x 3	160	38	-	18.0	14.5	17	4	21.0	•	•	•
2700	M 27	x 3	160	38	-	20.0	16.0	19	4	24.0	•	•	•
3000	M 30	x 3.5	180	45	-	22.0	18.0	21	4	26.5	•	•	•

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
T144					◐			◐	◐		◐	◐	◐			○	○	○	○	○	○	○							◐									○	○	○	○	○	○	○					○	
T146					◐			◐	◐		◐	◐	◐			○	◐	◐	◐	◐	◐	◐					○		◐									○	◐	◐	◐	◐	◐	◐					◐	
T148					◐			◐	◐		◐	◐	◐			○	◐	◐	◐	◐	◐	◐					○		◐									○	◐	◐	◐	◐	◐	◐					◐	

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.

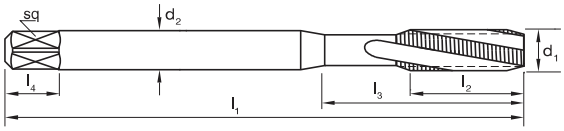
M

DIN Taps Metric, Spiral Flute, R15 N

suttontools

- General purpose use
- Suitable for materials up to 1000N/mm²
- Blind holes
- Depths up to 1.5 x d_1

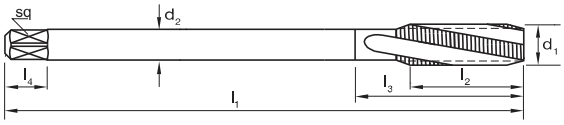
DIN 371 | 60° M



Catalogue Code	T183	T185
Discount Group	D0402	D0406
Material	HSSE	HSSE
Surface Finish	Brt	TiN
Sutton Designation	N	N
Geometry	R15	R15
Chamfer	Form C/ 2.5 x P	Form C/ 2.5 x P
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	45	8	-	2.8	2.1	5	3	1.6	T183 0200	•
0220	M 2.2	x 0.45	45	9	-	2.8	2.1	5	3	1.75	•	•
0230	M 2.3	x 0.4	45	9	-	2.8	2.1	5	3	1.9	•	•
0250	M 2.5	x 0.45	50	9	-	2.8	2.1	5	3	2.05	T183 0250	•
0260	M 2.6	x 0.45	50	9	-	2.8	2.1	5	3	2.15	•	•
0300	M 3	x 0.5	56	11	18	3.5	2.7	6	3	2.5	T183 0300	•
0350	M 3.5	x 0.6	56	13	20	4.0	3.0	6	3	2.9	T183 0350	•
0400	M 4	x 0.7	63	13	21	4.5	3.4	6	3	3.3	T183 0400	•
0500	M 5	x 0.8	70	16	25	6.0	4.9	8	3	4.2	T183 0500	•
0600	M 6	x 1	80	19	30	6.0	4.9	8	3	5.0	T183 0600	•
0800	M 8	x 1.25	90	22	35	8.0	6.2	9	3	6.8	T183 0800	•
1000	M 10	x 1.5	100	24	39	10.0	8.0	11	3	8.5	T183 1000	•

DIN 376 | 60° M



Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
											T184	T186
1200	M 12	x 1.75	110	28	-	9.0	7.0	10	3	10.2	T184 1200	•
1400	M 14	x 2	110	30	-	11.0	9.0	12	3	12.0	T184 1400	•
1600	M 16	x 2	110	32	-	12.0	9.0	12	4	14.0	T184 1600	•
1800	M 18	x 2.5	125	34	-	14.0	11.0	14	4	15.5	T184 1800	•
2000	M 20	x 2.5	140	34	-	16.0	12.0	15	4	17.5	T184 2000	•
2200	M 22	x 2.5	140	34	-	18.0	14.5	17	4	19.5	•	•
2400	M 24	x 3	160	38	-	18.0	14.5	17	4	21.0	•	•
2700	M 27	x 3	160	38	-	20.0	16.0	19	4	24.0	•	•
3000	M 30	x 3.5	180	45	-	22.0	18.0	21	4	26.5	•	•

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
T183	●	●	○	○		●	○			○							○		○		○	○	●	●	○	○		○	○																				
T185	●	●	●	●	○	●	●	○		●		○		○	○	○	○	○	○	○	○	○	●	●	○	○		○	○																				

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

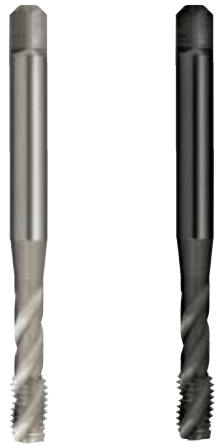
● Optimal ○ Effective

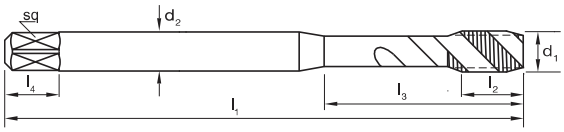
• Available on request as special manufacture. Subject to lead time.

DIN Taps Metric, Spiral Flute, R40 N

suttontools

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





Catalogue Code	T187	T189
Discount Group	D0402	D0402
Material	HSSE	HSSE
Surface Finish	Brt	Blu
Sutton Designation	N	N
Geometry	R40	R40
Chamfer	Form C/ 2.5 x P	Form C/ 2.5 x P
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 #
0100	M 1	x 0.25	40	5.5	-	2.5	2.1	5	2	0.75	T187 0100	•
0110	M 1.1	x 0.25	40	5.5	-	2.5	2.1	5	2	0.85	•	•
0120	M 1.2	x 0.25	40	5.5	-	2.5	2.1	5	2	0.95	T187 0120	•
0140	M 1.4	x 0.3	40	7	-	2.5	2.1	5	2	1.1	T187 0140	•
0160	M 1.6	x 0.35	40	8	-	2.5	2.1	5	2	1.25	T187 0160	•
0170	M 1.7	x 0.35	40	8	-	2.5	2.1	5	2	1.35	•	•
0180	M 1.8	x 0.35	40	8	-	2.5	2.1	5	2	1.45	T187 0180	•
0200	M 2	x 0.4	45	8	-	2.8	2.1	5	2	1.6	T187 0200	T189 0200
0220	M 2.2	x 0.45	45	9	-	2.8	2.1	5	2	1.75	•	•
0230	M 2.3	x 0.4	45	9	-	2.8	2.1	5	2	1.9	•	•
0250	M 2.5	x 0.45	50	9	-	2.8	2.1	5	2	2.05	T187 0250	T189 0250
0260	M 2.6	x 0.45	50	9	-	2.8	2.1	5	2	2.15	•	•
0300	M 3	x 0.5	56	5	18	3.5	2.7	6	3	2.5	T187 0300	T189 0300
0350	M 3.5	x 0.6	56	6	20	4.0	3.0	6	3	2.9	T187 0350	•
0400	M 4	x 0.7	63	7	21	4.5	3.4	6	3	3.3	T187 0400	T189 0400
0500	M 5	x 0.8	70	8	25	6.0	4.9	8	3	4.2	T187 0500	T189 0500
0600	M 6	x 1	80	10	30	6.0	4.9	8	3	5.0	T187 0600	T189 0600
0700	M 7	x 1	80	10	30	7.0	5.5	8	3	6.0	•	•
0800	M 8	x 1.25	90	12.5	35	8.0	6.2	9	3	6.8	T187 0800	T189 0800
1000	M 10	x 1.5	100	15	39	10.0	8.0	11	3	8.5	T187 1000	T189 1000

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
T187	●	●	○	○		●	○			○							○		○		○	○	●	●	○	○		○	○																				
T189	●	●	●	●		●	●			●		○		○	○	○	○		○		○	○																										

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

● Optimal ○ Effective

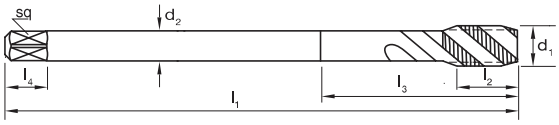
• Available on request as special manufacture. Subject to lead time.

M

DIN Taps Metric, Spiral Flute, R40 N

suttontools

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



Catalogue Code	T188	T190
Discount Group	D0402	D0402
Material	HSSE	HSSE
Surface Finish	Brt	Blu
Sutton Designation	N	N
Geometry	R40	R40
Chamfer	Form C/ 2.5 x P	Form C/ 2.5 x P
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 #
0300	M 3	x 0.5	56	5	-	2.2	-	-	3	2.5	•	•
0350	M 3.5	x 0.6	56	6	-	2.5	2.1	5	3	2.9	T188 0350	T190 0350
0400	M 4	x 0.7	63	7	-	2.8	2.1	5	3	3.3	T188 0400	T190 0400
0500	M 5	x 0.8	70	8	-	3.5	2.7	6	3	4.2	T188 0500	T190 0500
0600	M 6	x 1	80	10	-	4.5	3.4	6	3	5.0	T188 0600	T190 0600
0800	M 8	x 1.25	90	13	-	6.0	4.9	8	3	6.8	T188 0800	T190 0800
0900	M 9	x 1.25	90	13	-	9.0	7.0	10	3	7.8	•	•
1000	M 10	x 1.5	100	15	-	7.0	5.5	8	3	8.5	T188 1000	T190 1000
1200	M 12	x 1.75	110	18	-	9.0	7.0	10	3	10.2	T188 1200	T190 1200
1400	M 14	x 2	110	20	-	11.0	9.0	12	3	12.0	T188 1400	T190 1400
1600	M 16	x 2	110	20	-	12.0	9.0	12	3	14.0	T188 1600	T190 1600
1800	M 18	x 2.5	125	25	-	14.0	11.0	14	4	15.5	T188 1800	T190 1800
2000	M 20	x 2.5	140	25	-	16.0	12.0	15	4	17.5	T188 2000	T190 2000
2200	M 22	x 2.5	140	25	-	18.0	14.5	17	4	19.5	T188 2200	T190 2200
2400	M 24	x 3	160	30	-	18.0	14.5	17	4	21.0	T188 2400	T190 2400
2700	M 27	x 3	160	30	-	20.0	16.0	19	4	24.0	T188 2700	T190 2700
3000	M 30	x 3.5	180	45	-	22.0	18.0	21	4	26.5	T188 3000	T190 3000
3300	M 33	x 3.5	180	35	-	25.0	20.0	23	4	29.5	T188 3300	T190 3300
3600	M 36	x 4	200	40	-	28.0	22.0	25	4	32.0	T188 3600	T190 3600
3900	M 39	x 4	200	40	-	32.0	24.0	27	4	35.0	T188 3900	T190 3900
4200	M 42	x 4.5	200	45	-	32.0	24.0	27	4	37.5	T188 4200	T190 4200
4500	M 45	x 4.5	220	45	-	36.0	29.0	32	4	40.5	T188 4500	T190 4500
4800	M 48	x 5	250	50	-	36.0	29.0	32	4	43.0	T188 4800	T190 4800
5200	M 52	x 5	250	50	-	40.0	32.0	35	4	47.0	T188 5200	T190 5200

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
T188	●	●	○	○		●	○			○							○		○		○	○	●	●	○	○		○	○																				
T190	●	●	●	●		●	●			●		○		○	○	○	○		○		○	○																										

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

● Optimal ○ Effective

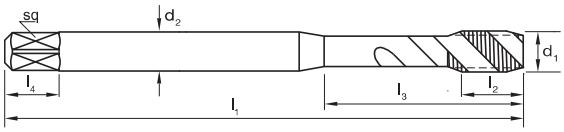
• Available on request as special manufacture. Subject to lead time.

DIN Taps Metric, Spiral Flute, R40 N - 6G, 4H, LH

suttontools

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

DIN 371 | 60° M

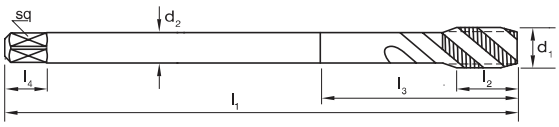


Catalogue Code	T191	T193	T195
Discount Group	D0402	D0402	D0402
Material	HSSE	HSSE	HSSE
Surface Finish	Brt	Brt	Brt
Sutton Designation	N	N	N
Geometry	R40 - 6G	R40 - 4H	L40
Chamfer	Form C/ 2.5 x P	Form C/ 2.5 x P	Form C/ 2.5 x P
Limit & Nut Tolerance	ISO 3 / 6G	ISO 1 / 4H	ISO 2 / 6H

Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #	Item #
0200	M 2	x 0.4	45	8	-	2.8	2.1	5	2	1.6	T191 0200	T193 0200	•
0220	M 2.2	x 0.45	45	9	-	2.8	2.1	5	2	1.75	•	•	•
0230	M 2.3	x 0.4	45	9	-	2.8	2.1	5	2	1.9	•	•	•
0250	M 2.5	x 0.45	50	9	-	2.8	2.1	5	2	2.05	T191 0250	T193 0250	•
0260	M 2.6	x 0.45	50	9	-	2.8	2.1	5	2	2.15	•	•	•
0300	M 3	x 0.5	56	5	18	3.5	2.7	6	3	2.5	T191 0300	T193 0300	T195 0300
0350	M 3.5	x 0.6	56	6	20	4.0	3.0	6	3	2.9	•	•	•
0400	M 4	x 0.7	63	7	21	4.5	3.4	6	3	3.3	T191 0400	T193 0400	T195 0400
0500	M 5	x 0.8	70	8	25	6.0	4.9	8	3	4.2	T191 0500	T193 0500	T195 0500
0600	M 6	x 1	80	10	30	6.0	4.9	8	3	5.0	T191 0600	T193 0600	T195 0600
0800	M 8	x 1.25	90	13	35	8.0	6.2	9	3	6.8	T191 0800	T193 0800	T195 0800
1000	M 10	x 1.5	100	15	39	10.0	8.0	11	3	8.5	T191 1000	T193 1000	T195 1000

M

DIN 376 | 60° M



Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #	Item #
											T192	T194	T196
0600	M 6	x 1	80	10	-	4.5	3.4	6	3	5.0	•	•	•
0800	M 8	x 1.25	90	13	-	6.0	4.9	8	3	6.8	•	•	•
1000	M 10	x 1.5	100	15	-	7.0	5.5	8	3	8.5	•	•	•
1200	M 12	x 1.75	110	18	-	9.0	7.0	10	3	10.2	T192 1200	•	T196 1200
1400	M 14	x 2	110	20	-	11.0	9.0	12	3	12.0	T192 1400	•	T196 1400
1600	M 16	x 2	110	20	-	12.0	9.0	12	3	14.0	T192 1600	•	T196 1600
1800	M 18	x 2.5	125	25	-	14.0	11.0	14	4	15.5	T192 1800	•	T196 1800
2000	M 20	x 2.5	140	25	-	16.0	12.0	15	4	17.5	T192 2000	•	T196 2000

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
T191	●	●	○	○		●	○			○							○		○		○	○	●	●	○	○		○	○																				
T193	●	●	○	○		●	○			○							○		○		○	○	●	●	○	○		○	○																				
T195	●	●	○	○		●	○			○							○		○		○	○	●	●	○	○		○	○																				

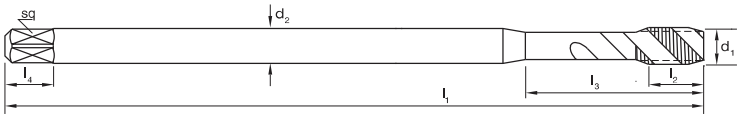
P Steel | M Stainless Steel | K Cast Iron | N Non-Ferrous Metals | S Titanium & Super Alloys | H Hard Materials

● Optimal ○ Effective

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

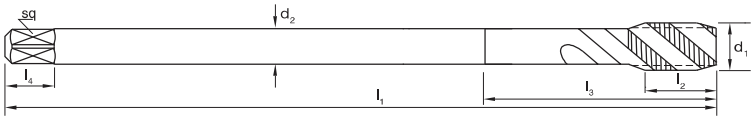
suttontools

- For long reach applications
- Suitable for materials up to 1000N/mm²
- Depths up to 2.5 x d_1
- d_2 and sq in accordance to DIN376



Catalogue Code	T339
Discount Group	D0402
Material	HSSE
Surface Finish	Brt
Sutton Designation	N
Geometry	R40 - Extra Length
Chamfer	Form C/ 2.5 x P
Limit & Nut Tolerance	ISO 2 / 6H

Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #
0300	M 3	x 0.5	112	5		3.5	2.7	6	3	2.5	T339 0300
0400	M 4	x 0.7	126	7		4.5	3.4	6	3	3.3	T339 0400
0500	M 5	x 0.8	140	8		6.0	4.9	8	3	4.2	T339 0500
0600	M 6	x 1	160	10		6.0	4.9	8	3	5.0	T339 0600
0800	M 8	x 1.25	180	13		8.0	6.2	10	3	6.8	T339 0800



Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #
											T340
1000	M 10	x 1.5	200	15	100	7.0	5.5	8	3	8.5	T340 1000
1200	M 12	x 1.75	220	18	110	9.0	7.0	10	3	10.2	T340 1200
1400	M 14	x 2	220	20	110	11.0	9.0	12	3	12.0	T340 1400
1600	M 16	x 2	220	20	110	12.0	9.0	12	3	14.0	T340 1600
2000	M 20	x 2.5	280	34	110	16.0	12.0	15	4	17.5	T340 2000
2400	M 24	x 3	320	38	120	18.0	14.5	17	4	21.0	•

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
T339	●	●	○	○		●	○			○							○		○		○	○	●	●	○	○		○	○																				

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.

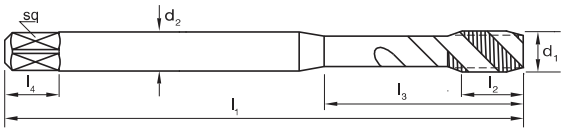
DIN Taps Metric, Spiral Flute, R50 Black Magic

suttontools BLACKMAGIC

watch the video

- Universal high performance tapping
- PM-HSSE V3 offers superior tool life
- Use in stainless steels and high strength steels up to 850N/mm²
- Blind holes up to 3 x d_1
- Suitable for synchronous tapping in machine operations

DIN 371 | 60° M | Z | HSC

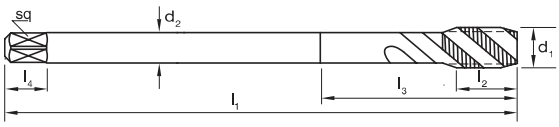


Catalogue Code	T684
Discount Group	D0410
Material	PM-HSSE V3
Surface Finish	HARDLUBE
Sutton Designation	UNI
Geometry	R50
Chamfer	Form C/ 2.5 x P
Limit & Nut Tolerance	6HX

Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #
0200	M 2	x 0.4	45	8	-	2.8	2.1	5	3	1.6	•
0220	M 2.2	x 0.45	45	9	-	2.8	2.1	5	3	1.75	•
0230	M 2.3	x 0.4	45	9	-	2.8	2.1	5	3	1.9	•
0250	M 2.5	x 0.45	50	9	-	2.8	2.1	5	3	2.05	•
0260	M 2.6	x 0.45	50	9	-	2.8	2.1	5	3	2.15	•
0300	M 3	x 0.5	56	5	18	3.5	2.7	6	3	2.5	T684 0300
0350	M 3.5	x 0.6	56	6	20	4.0	3.0	6	3	2.9	•
0400	M 4	x 0.7	63	7	21	4.5	3.4	6	3	3.3	T684 0400
0500	M 5	x 0.8	70	8	25	6.0	4.9	8	3	4.2	T684 0500
0600	M 6	x 1	80	10	30	6.0	4.9	8	3	5.0	T684 0600
0800	M 8	x 1.25	90	12.5	35	8.0	6.2	9	3	6.8	T684 0800
1000	M 10	x 1.5	100	15	39	10.0	8.0	11	3	8.5	T684 1000

M

DIN 376 | 60° M | Z | HSC



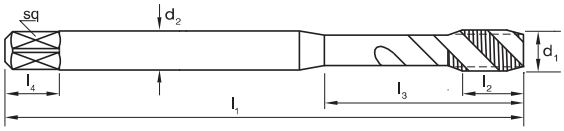
Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #
											T685
1200	M 12	x 1.75	110	17.5	-	9.0	7.0	10	3	10.2	T685 1200
1400	M 14	x 2	110	20	-	11.0	9.0	12	3	12.0	T685 1400
1600	M 16	x 2	110	20	-	12.0	9.0	12	4	14.0	T685 1600
1800	M 18	x 2.5	125	25	-	14.0	11.0	14	4	15.5	T685 1800
2000	M 20	x 2.5	140	25	-	16.0	12.0	15	4	17.5	T685 2000
2200	M 22	x 2.5	140	25	-	18.0	14.5	17	4	19.5	•
2400	M 24	x 3	160	30	-	18.0	14.5	17	4	21.0	•
2700	M 27	x 3	160	30	-	20.0	16.0	19	4	24.0	•
3000	M 30	x 3.5	180	35	-	22.0	18.0	21	4	26.5	•

| ISO | P | | | | | | | | | | | | | M | | | K | | | | | | N | | | | | | | | | | | | |

suttontools

- Suitable for use in wrought aluminium and low silicon aluminium
- Blind holes
- Depths up to 3 x d_1
- CrN for longer tool life

DIN 371 | 60° M | HSC

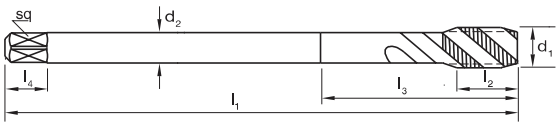


Catalogue Code	T231	T233
Discount Group	D0402	D0404
Material	HSSE	HSSE
Surface Finish	Brt	CrN
Sutton Designation	Al	Al
Geometry	R45 2 Flute	R45 2 Flute
Chamfer	Form C/ 2.5 x P	Form C/ 2.5 x P
Limit & Nut Tolerance	ISO 2 / 6H	ISO 2 / 6H

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	45	8	-	2.8	2.1	5	2	1.6	T231 0200	•
0200	M 2.2	x 0.45	45	9	-	2.8	2.1	5	2	1.75	•	•
0230	M 2.3	x 0.4	45	9	-	2.8	2.1	5	2	1.9	•	•
0250	M 2.5	x 0.45	50	9	-	2.8	2.1	5	2	2.05	T231 0250	•
0260	M 2.6	x 0.45	50	9	-	2.8	2.1	5	2	2.15	•	•
0300	M 3	x 0.5	56	5	18	3.5	2.7	6	2	2.5	T231 0300	T233 0300
0350	M 3.5	x 0.6	56	6	20	4.0	3.0	6	2	2.9	T231 0350	•
0400	M 4	x 0.7	63	7	21	4.5	3.4	6	2	3.3	T231 0400	T233 0400
0500	M 5	x 0.8	70	8	25	6.0	4.9	8	2	4.2	T231 0500	T233 0500
0600	M 6	x 1	80	10	30	6.0	4.9	8	2	5.0	T231 0600	T233 0600
0800	M 8	x 1.25	90	12.5	35	8.0	6.2	9	2	6.8	T231 0800	T233 0800
1000	M 10	x 1.5	100	15	39	10.0	8.0	11	2	8.5	T231 1000	T233 1000

M

DIN 376 | 60° M | HSC



Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
											T232	T234
0600	M 6	x 1	80	10	-	4.5	3.4	6	2	5.0	•	•
0800	M 8	x 1.25	90	12.5	-	6.0	4.9	8	2	6.8	•	•
1000	M 10	x 1.5	100	15	-	7.0	5.5	8	2	8.5	•	•
1200	M 12	x 1.75	110	17.5	-	9.0	7.0	10	2	10.2	T232 1200	T234 1200
1400	M 14	x 2	110	20	-	11.0	9.0	12	2	12.0	T232 1400	T234 1400
1600	M 16	x 2	110	20	-	12.0	9.0	12	2	14.0	T232 1600	T234 1600
1800	M 18	x 2.5	125	25	-	14.0	11.0	14	2	15.5	T232 1800	T234 1800
2000	M 20	x 2.5	140	25	-	16.0	12.0	15	2	17.5	T232 2000	T234 2000

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
T231																							◐	◐	◐	◐		◐		◐																				
T233																							◐	◐	◐	◐		◐		◐																				

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

● Optimal ◐ Effective

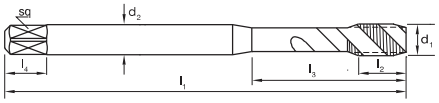
• Available on request as special manufacture. Subject to lead time.

DIN Taps Metric, Spiral Flute, R45 W & Cu

suttontools

- Suitable for use in soft materials
- CrN for copper and non-ferrous materials
- Blind holes
- Depths up to 3 x d_1

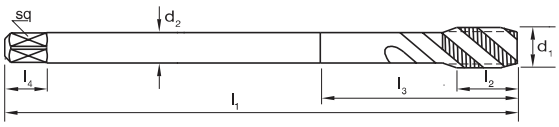
DIN 371 | 60° M



Catalogue Code	T235	T237	T241	T239
Discount Group	D0402	D0402	D0406	D0404
Material	HSSE	HSSE	HSSE	HSSE
Surface Finish	Ni	Blu	TiN	CrN
Sutton Designation	W	W	W	Cu
Geometry	R45	R45	R45	R45
Chamfer	Form C/ 2.5 x P	Form C/ 2.5 x P	Form C/ 2.5 x P	Form C/ 2.5 x P
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	45	8	-	2.8	2.1	5	2	1.6	T235 0200	•	•	•
0220	M 2.2	x 0.45	45	9	-	2.8	2.1	5	2	1.75	•	•	•	•
0230	M 2.3	x 0.4	45	9	-	2.8	2.1	5	2	1.9	•	•	•	•
0250	M 2.5	x 0.45	50	9	-	2.8	2.1	5	2	2.05	T235 0250	•	•	•
0260	M 2.6	x 0.45	50	9	-	2.8	2.1	5	2	2.15	•	•	•	•
0300	M 3	x 0.5	56	5	18	3.5	2.7	6	3	2.5	T235 0300	T237 0300	T241 0300	T239 0300
0350	M 3.5	x 0.6	56	6	20	4.0	3.0	6	3	2.9	T235 0350	•	T241 0350	•
0400	M 4	x 0.7	63	7	21	4.5	3.4	6	3	3.3	T235 0400	T237 0400	T241 0400	T239 0400
0500	M 5	x 0.8	70	8	25	6.0	4.9	8	3	4.2	T235 0500	T237 0500	T241 0500	T239 0500
0600	M 6	x 1	80	10	30	6.0	4.9	8	3	5.0	T235 0600	T237 0600	T241 0600	T239 0600
0800	M 8	x 1.25	90	12.5	35	8.0	6.2	9	3	6.8	T235 0800	T237 0800	T241 0800	T239 0800
1000	M 10	x 1.5	100	15	39	10.0	8.0	11	3	8.5	T235 1000	T237 1000	T241 1000	T239 1000

DIN 376 | 60° M



Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #	Item #	Item #
											T236	T238	T242	T240
0600	M 6	x 1	80	10	-	4.5	3.4	6	3	5.0	T236 0600	•	T242 0600	T240 0600
0800	M 8	x 1.25	90	12.5	-	6.0	4.9	8	3	6.8	T236 0800	•	T242 0800	•
1000	M 10	x 1.5	100	15	-	7.0	5.5	8	3	8.5	T236 1000	•	T242 1000	•
1200	M 12	x 1.75	110	17.5	-	9.0	7.0	10	3	10.2	T236 1200	T238 1200	T242 1200	T240 1200
1400	M 14	x 2	110	20	-	11.0	9.0	12	3	12.0	T236 1400	T238 1400	T242 1400	T240 1400
1600	M 16	x 2	110	20	-	12.0	9.0	12	4	14.0	T236 1600	T238 1600	T242 1600	T240 1600
1800	M 18	x 2.5	125	25	-	14.0	11.0	14	4	15.5	T236 1800	T238 1800	T242 1800	T240 1800
2000	M 20	x 2.5	140	25	-	16.0	12.0	15	4	17.5	T236 2000	T238 2000	T242 2000	T240 2000

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
T235	●	●	○	○		●	○																●	○				○		○																			
T237	●	●	○	○		●	○																○	○																									
T241	●	●	○	●		●	○																○	○				○		●																			
T239																							○	○				●		●																			

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.

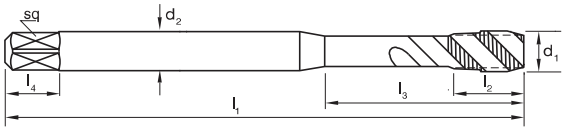
M

DIN Taps Metric, Spiral Flute, R45 VA DH

suttontools

- Suitable for controlled tapping in deep holes
- Use in stainless steels and high strength steels up to 850N/mm²
- Blind holes
- Depths up to 3 x d_1

DIN 371 | 60° M | Z | DH

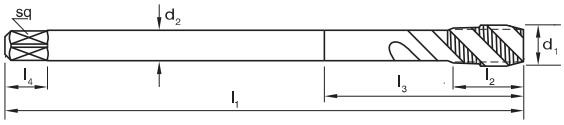


Catalogue Code	T197	T198	T201
Discount Group	D0402	D0402	D0408
Material	HSSE	HSSE	HSSE
Surface Finish	Blu	Blu	TiCN
Sutton Designation	VA DH	VA DH	VA DH
Geometry	R45 Back Chamf.	R45 Back Chamf.	R45 Back Chamf.
Chamfer	Form C/ 2.5 x P	Form C/ 2.5 x P	Form C/ 2.5 x P
Limit & Nut Tolerance	ISO 2 / 6H	ISO 3 / 6G	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 #
0200	M 2	x 0.4	45	8	-	2.8	2.1	5	3	1.6	•	•	•
0220	M 2.2	x 0.45	45	9	-	2.8	2.1	5	3	1.75	•	•	•
0230	M 2.3	x 0.4	45	9	-	2.8	2.1	5	3	1.9	•	•	•
0250	M 2.5	x 0.45	50	9	-	2.8	2.1	5	3	2.05	•	•	•
0260	M 2.6	x 0.45	50	9	-	2.8	2.1	5	3	2.15	•	•	•
0300	M 3	x 0.5	56	5	18	3.5	2.7	6	3	2.5	T197 0300	•	T201 0300
0350	M 3.5	x 0.6	56	6	20	4.0	3.0	6	3	2.9	•	•	•
0400	M 4	x 0.7	63	7	21	4.5	3.4	6	3	3.3	T197 0400	•	T201 0400
0500	M 5	x 0.8	70	8	25	6.0	4.9	8	3	4.2	T197 0500	•	T201 0500
0600	M 6	x 1	80	10	30	6.0	4.9	8	3	5.0	T197 0600	•	T201 0600
0800	M 8	x 1.25	90	12.5	35	8.0	6.2	9	3	6.8	T197 0800	•	T201 0800
1000	M 10	x 1.5	100	15	39	10.0	8.0	11	3	8.5	T197 1000	•	T201 1000

M

DIN 376 | 60° M | Z | DH



Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #	Item #
											T199	T200	T202
0600	M 6	x 1	80	10	-	4.5	3.4	6	3	5.0	T199 0600	•	T202 0600
0800	M 8	x 1.25	90	12.5	-	6.0	4.9	8	3	6.8	T199 0800	•	T202 0800
1000	M 10	x 1.5	100	15	-	7.0	5.5	8	3	8.5	T199 1000	•	T202 1000
1200	M 12	x 1.75	110	17.5	-	9.0	7.0	10	3	10.2	T199 1200	•	T202 1200
1400	M 14	x 2	110	20	-	11.0	9.0	12	3	12.0	T199 1400	•	T202 1400
1600	M 16	x 2	110	20	-	12.0	9.0	12	4	14.0	T199 1600	•	T202 1600
1800	M 18	x 2.5	125	25	-	14.0	11.0	14	4	15.5	T199 1800	•	T202 1800
2000	M 20	x 2.5	140	25	-	16.0	12.0	15	4	17.5	T199 2000	•	T202 2000
2200	M 22	x 2.5	140	25	-	18.0	14.5	17	4	19.5	T199 2200	•	T202 2200
2400	M 24	x 3	160	30	-	18.0	14.5	17	4	21.0	T199 2400	•	T202 2400
2700	M 27	x 3	160	30	-	20.0	16.0	19	4	24.0	T199 2700	•	T202 2700
3000	M 30	x 3.5	180	35	-	22.0	18.0	21	4	26.5	T199 3000	•	T202 3000
3600	M 36	x 4	200	40	-	28.0	22.0	25	4	32.0	T199 3600	•	T202 3600
4200	M 42	x 4.5	200	45	-	32.0	24.0	27	4	37.5	T199 4200	•	•

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
T197	●	●	○			○	○					○		●	●	○																																
T198	●	●	○			○	○					○		●	●	○																																
T201	●	●	○	○		○	○	○		○		●		●	●	●							○	○	○	○		○		○			○		○													

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

● Optimal ○ Effective

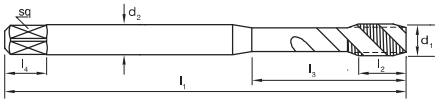
• Available on request as special manufacture. Subject to lead time.

DIN Taps Metric, Spiral Flute, R50 VA PM

suttontools

- Universal high performance tapping
- PM-HSSE V3 offers superior tool life
- Use in stainless steels and high strength steels up to 850N/mm²
- Deep blind holes
- Depths up to 3 x d_1

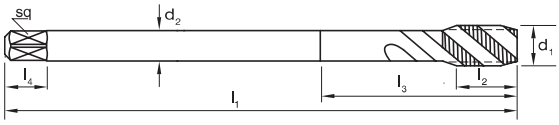
DIN 371 | 60° M | Z | HSC



Catalogue Code	T203	T205	T678	T676
Discount Group	D0402	D0408	D0408	D0408
Material	PM-HSSE V3	PM-HSSE V3	PM-HSSE V3	PM-HSSE V3
Surface Finish	Blu	TiCN	TiCN	TiCN
Sutton Designation	VA PM	VA PM	VA PM	VA PM
Geometry	R50	R50	R50	R50
Chamfer	Form C/ 2.5 x P	Form C/ 2.5 x P	Form C/ 2.5 x P	Form E/ 1.5 x P
Limit & Nut Tolerance	6HX	6HX	6GX	6HX

Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #	Item #	Item #
0160	M 1.6	x 0.35	40	8	-	2.5	2.1	5	3	1.25	•	T205 0160	•	•
0200	M 2	x 0.4	45	8	-	2.8	2.1	5	3	1.6	•	T205 0200	T678 0200	•
0220	M 2.2	x 0.45	45	9	-	2.8	2.1	5	3	1.75	•	•	•	•
0230	M 2.3	x 0.4	45	9	-	2.8	2.1	5	3	1.9	•	•	•	•
0250	M 2.5	x 0.45	50	9	-	2.8	2.1	5	3	2.05	•	T205 0250	T678 0250	•
0300	M 3	x 0.5	56	5	18	3.5	2.7	6	3	2.5	T203 0300	T205 0300	T678 0300	T676 0300
0350	M 3.5	x 0.6	56	6	20	4.0	3.0	6	3	2.9	•	T205 0350	T678 0350	T676 0350
0400	M 4	x 0.7	63	7	21	4.5	3.4	6	3	3.3	T203 0400	T205 0400	T678 0400	T676 0400
0500	M 5	x 0.8	70	8	25	6.0	4.9	8	3	4.2	T203 0500	T205 0500	T678 0500	T676 0500
0600	M 6	x 1	80	10	30	6.0	4.9	8	3	5.0	T203 0600	T205 0600	T678 0600	T676 0600
0800	M 8	x 1.25	90	12.5	35	8.0	6.2	9	3	6.8	T203 0800	T205 0800	T678 0800	T676 0800
1000	M 10	x 1.5	100	15	39	10.0	8.0	11	3	8.5	T203 1000	T205 1000	T678 1000	T676 1000

DIN 376 | 60° M | Z | HSC



Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #	Item #	Item #
											T204	T206	T679	T677
1200	M 12	x 1.75	110	17.5	-	9.0	7.0	10	3	10.2	T204 1200	T206 1200	T679 1200	T677 1200
1400	M 14	x 2	110	20	-	11.0	9.0	12	3	12.0	T204 1400	T206 1400	T679 1400	T677 1400
1600	M 16	x 2	110	20	-	12.0	9.0	12	4	14.0	T204 1600	T206 1600	T679 1600	T677 1600
1800	M 18	x 2.5	125	25	-	14.0	11.0	14	4	15.5	T204 1800	T206 1800	T679 1800	T677 1800
2000	M 20	x 2.5	140	25	-	16.0	12.0	15	4	17.5	T204 2000	T206 2000	T679 2000	T677 2000
2200	M 22*	x 2.5	140	25	-	18.0	14.5	17	4	19.5	T204 2200	T206 2200	T679 2200	T677 2200
2400	M 24*	x 3	160	30	-	18.0	14.5	17	4	21.0	T204 2400	T206 2400	T679 2400	T677 2400
2700	M 27*	x 3	160	30	-	20.0	16.0	19	4	24.0	T204 2700	T206 2700	•	•
3000	M 30*	x 3.5	180	35	-	22.0	18.0	21	4	26.5	T204 3000	T206 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
T203	●	●	●			●	●					○		●	●	○																																	
T205	●	●	○	○		○	○	○		○		●		●	●	●							○	○	○	○		○		○			●		○														
T678	●	●	○	○		○	○	○		○		●		●	●	●							○	○	○	○		○		○			●		○														
T676	●	●	○	○		○	○	○		○		●		●	●	●							○	○	○	○		○		○			●		○														

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

● Optimal ○ Effective

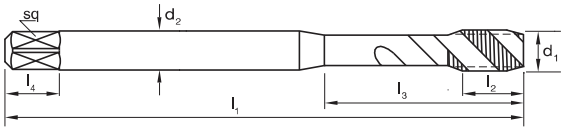
* HSSE >20mm • Available on request as special manufacture. Subject to lead time.

M

DIN Taps Metric, Spiral Flute, R50 VA PM, IK

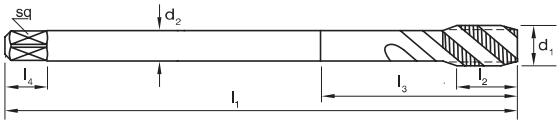
suttontools

- Universal high performance tapping
- PM-HSSE V3 offers superior tool life
- Use in stainless steels and high strength steels up to 850N/mm²
- Deep blind holes
- Depths up to 3 x d_1



Catalogue Code	T207
Discount Group	D0408
Material	PM-HSSE V3
Surface Finish	TiCN
Sutton Designation	VA PM
Geometry	R50 IK
Chamfer	Form C/ 2.5 x P
Limit & Nut Tolerance	6HX

Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #
0160	M 1.6	x 0.35	40	8	-	2.5	2.1	5	4	1.25	•
0200	M 2	x 0.4	45	8	-	2.8	2.1	5	4	1.6	•
0220	M 2.2	x 0.45	45	9	-	2.8	2.1	5	4	1.75	•
0230	M 2.3	x 0.4	45	9	-	2.8	2.1	5	4	1.9	•
0250	M 2.5	x 0.45	50	9	-	2.8	2.1	5	4	2.05	•
0300	M 3	x 0.5	56	5	18	3.5	2.7	6	4	2.5	•
0350	M 3.5	x 0.6	56	6	20	4.0	3.0	6	4	2.9	•
0400	M 4	x 0.7	63	7	21	4.5	3.4	6	4	3.3	•
0500	M 5	x 0.8	70	8	25	6.0	4.9	8	4	4.2	T207 0500
0600	M 6	x 1	80	10	30	6.0	4.9	8	4	5.0	T207 0600
0800	M 8	x 1.25	90	12.5	35	8.0	6.2	9	4	6.8	T207 0800
1000	M 10	x 1.5	100	15	39	10.0	8.0	11	4	8.5	T207 1000



Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #
											T208
1200	M 12	x 1.75	110	17.5	-	9.0	7.0	10	4	10.2	T208 1200
1400	M 14	x 2	110	20	-	11.0	9.0	12	4	12.0	T208 1400
1600	M 16	x 2	110	20	-	12.0	9.0	12	4	14.0	T208 1600
1800	M 18	x 2.5	125	25	-	14.0	11.0	14	4	15.5	T208 1800
2000	M 20	x 2.5	140	25	-	16.0	12.0	15	4	17.5	T208 2000
2200	M 22*	x 2.5	140	25	-	18.0	14.5	17	4	19.5	•
2400	M 24*	x 3	160	30	-	18.0	14.5	17	4	21.0	•
2700	M 27*	x 3	160	30	-	20.0	16.0	19	4	24.0	•
3000	M 30*	x 3.5	180	35	-	22.0	18.0	21	4	26.5	•

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
T207	●	●	●	○		●	○	○		○		●		●	●	●							○	○	○	○		○		○			●		○													

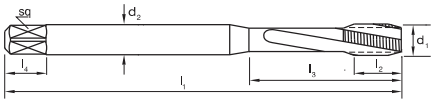
P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials

● Optimal ○ Effective

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

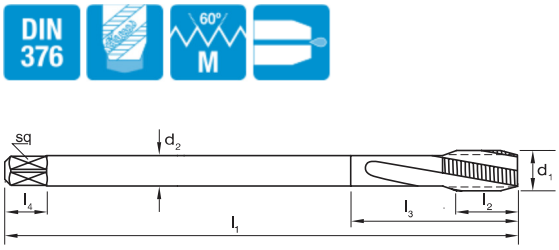
suttontools

- Suitable for harder short chipping materials up to 42 HRC
- Blind holes
- Depths up to 2.5 x d_1



Catalogue Code	T221	T227	T229
Discount Group	D0402	D0410	D0410
Material	PM-HSSE V3	PM-HSSE V3	PM-HSSE V3
Surface Finish	Blu	TiAlN	TiAlN
Sutton Designation	NH	NH	NH
Geometry	R40	R40	R40 IK
Chamfer	Form C/ 2.5 x P	Form C/ 2.5 x P	Form C/ 2.5 x P
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 #
0200	M 2	x 0.4	45	8	-	2.8	2.1	5	3	1.6	•	•	•
0220	M 2.2	x 0.45	45	9	-	2.8	2.1	5	3	1.75	•	•	•
0230	M 2.3	x 0.4	45	9	-	2.8	2.1	5	3	1.9	•	•	•
0250	M 2.5	x 0.45	50	9	-	2.8	2.1	5	3	2.05	•	•	•
0260	M 2.6	x 0.45	50	9	-	2.8	2.1	5	3	2.15	•	•	•
0300	M 3	x 0.5	56	5	18	3.5	2.7	6	3	2.5	T221 0300	T227 0300	•
0350	M 3.5	x 0.6	56	6	20	4.0	3.0	6	3	2.9	•	•	•
0400	M 4	x 0.7	63	7	21	4.5	3.4	6	3	3.3	T221 0400	T227 0400	•
0500	M 5	x 0.8	70	8	25	6.0	4.9	8	3	4.2	T221 0500	T227 0500	T229 0500
0600	M 6	x 1	80	10	30	6.0	4.9	8	3	5.0	T221 0600	T227 0600	T229 0600
0800	M 8	x 1.25	90	12.5	35	8.0	6.2	9	3	6.8	T221 0800	T227 0800	T229 0800
1000	M 10	x 1.5	100	15	39	10.0	8.0	11	3	8.5	T221 1000	T227 1000	T229 1000



Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #	Item #
											T222	T228	T230
1200	M 12	x 1.75	110	17.5	-	9.0	7.0	10	3	10.2	T222 1200	T228 1200	T230 1200
1400	M 14	x 2	110	20	-	11.0	9.0	12	3	12.0	T222 1400	T228 1400	T230 1400
1600	M 16	x 2	110	20	-	12.0	9.0	12	3	14.0	T222 1600	T228 1600	T230 1600
1800	M 18	x 2.5	125	25	-	14.0	11.0	14	4	15.5	T222 1800	T228 1800	T230 1800
2000	M 20	x 2.5	140	25	-	16.0	12.0	15	4	17.5	T222 2000	T228 2000	T230 2000
2200	M 22	x 2.5	140	25	-	18.0	14.5	17	4	19.5	•	•	•
2400	M 24	x 3	160	30	-	18.0	14.5	17	4	21.0	•	•	•
2700	M 27	x 3	160	30	-	20.0	16.0	19	4	24.0	•	•	•
3000	M 30	x 3.5	180	35	-	22.0	18.0	21	4	26.5	•	•	•

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
T221			◐	◐	○		◐	○		○		○		○	○	○	○	○	○	○	○	○																											○	
T227			◐	◐	◐		◐	◐	○	◐	○	○	○	○	○	◐	○	○	○	○	○	○	○	○	○	○	◐	○	○	○																		○	
T229			◐	◐	◐		◐	◐	○	◐	○	○	○	○	○	◐	○	○	○	○	○	○	○	○	○	○	◐	○	○	○																		○	

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

● Optimal ◐ Effective

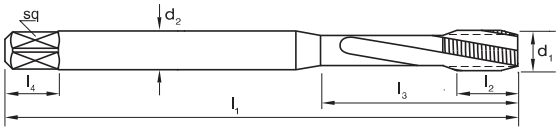
• Available on request as special manufacture. Subject to lead time.

M

DIN Taps Metric, Spiral Flute, R15 H

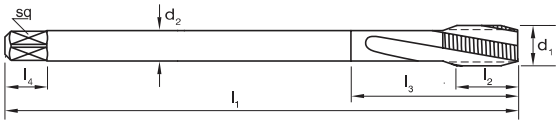
suttontools

- Suitable for harder materials up to 45 HRC
- Blind holes
- Depths up to 1.5 x d_1



Catalogue Code	T209	T211	T213
Discount Group	D0402	D0408	D0408
Material	PM-HSS Co	PM-HSS Co	PM-HSS Co
Surface Finish	Blu	TiCN	TiCN
Sutton Designation	H	H	H
Geometry	R15	R15	R15 IK
Chamfer	Form C/ 3 x P	Form C/ 3 x P	Form C/ 3 x P
Limit & Nut Tolerance	ISO 2 / 6HX	ISO 2 / 6HX	ISO 2 / 6HX

Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #	Item #
0200	M 2	x 0.4	45	4	-	2.8	2.1	5	3	1.6	•	•	•
0220	M 2.2	x 0.45	45	4.5	-	2.8	2.1	5	3	1.75	•	•	•
0230	M 2.3	x 0.4	45	4	-	2.8	2.1	5	3	1.9	•	•	•
0250	M 2.5	x 0.45	50	4	-	2.8	2.1	5	3	2.05	•	•	•
0260	M 2.6	x 0.45	50	4	-	2.8	2.1	5	3	2.15	•	•	•
0300	M 3	x 0.5	56	6	18	3.5	2.7	6	3	2.5	T209 0300	T211 0300	•
0350	M 3.5	x 0.6	56	6	20	4.0	3.0	6	3	2.9	•	•	•
0400	M 4	x 0.7	63	7	21	4.5	3.4	6	3	3.3	T209 0400	T211 0400	•
0500	M 5	x 0.8	70	8	25	6.0	4.9	8	3	4.2	T209 0500	T211 0500	T213 0500
0600	M 6	x 1	80	10	30	6.0	4.9	8	3	5.0	T209 0600	T211 0600	T213 0600
0800	M 8	x 1.25	90	12.5	35	8.0	6.2	9	3	6.8	T209 0800	T211 0800	T213 0800
1000	M 10	x 1.5	100	15	39	10.0	8.0	11	3	8.5	T209 1000	T211 1000	T213 1000



Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #	Item #
											T210	T212	T214
1200	M 12	x 1.75	110	17.5	-	9.0	7.0	10	4	10.2	T210 1200	T212 1200	T214 1200
1400	M 14	x 2	110	20	-	11.0	9.0	12	4	12.0	T210 1400	T212 1400	T214 1400
1600	M 16	x 2	110	20	-	12.0	9.0	12	4	14.0	T210 1600	T212 1600	T214 1600
1800	M 18	x 2.5	125	25	-	14.0	11.0	14	4	15.5	T210 1800	T212 1800	T214 1800
2000	M 20	x 2.5	140	25	-	16.0	12.0	15	4	17.5	T210 2000	T212 2000	T214 2000
2200	M 22	x 2.5	140	25	-	18.0	14.5	17	4	19.5	•	•	•
2400	M 24	x 3	160	30	-	18.0	14.5	17	4	21.0	•	•	•
2700	M 27	x 3	160	30	-	20.0	16.0	19	4	24.0	•	•	•
3000	M 30	x 3.5	180	35	-	22.0	18.0	21	4	26.5	•	•	•

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
T209					◐			◐	◐		◐	○				○	○	○	○	○	○	○							○									○	○	○	○	○	○					○	
T211					◐			◐	◐		◐	○	◐			○	◐	◐	◐	◐	◐	◐					○		○									○	◐	◐	◐	◐	◐					◐	
T213					◐			◐	◐		◐	○	◐			○	◐	◐	◐	◐	◐	◐					○		○									○	◐	◐	◐	◐	◐					◐	

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

● Optimal ◐ Effective

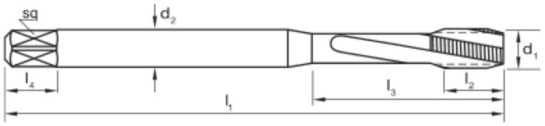
• Available on request as special manufacture. Subject to lead time.

M

suttontools

- For Titanium based alloys
- Unique cutting geometry for highly efficient swarf ejection
- Optimised microfinish for optimal process reliability and excellent thread quality
- Blind holes up to approx. 1.5 x d_1

DIN 371 | DIN 376 | 60° M | μ MICRO



Catalogue Code	T215	T788
Discount Group	D0408	D0408
Material	PM-HSS Co	PM-HSS Co
Surface Finish	*TICN*	*TICN*
Sutton Designation	TI	TI
Geometry	R15	R15
Chamfer	Form C / 3 x P	Form C / 3 x P
Limit & Nut Tolerance	6HX	MJ–4HX

Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
	DIN 371											
0300	M 3	x 0.5	56	6	18	3.5	2.7	6	3	2.5	T215 0300	•
0400	M 4	x 0.7	63	7	21	4.5	3.4	6	3	3.3	T215 0400	•
0500	M 5	x 0.8	70	8	25	6.0	4.9	8	3	4.2	T215 0500	•
0600	M 6	x 1	80	10	30	6.0	4.9	8	3	5.0	T215 0600	•
0800	M 8	x 1.25	90	12.5	35	8.0	6.2	9	3	6.8	T215 0800	•
1000	M 10	x 1.5	100	15	39	10.0	8.0	11	3	8.5	T215 1000	•
	DIN 376										T216	T789
1200	M 12	x 1.75	110	17.5	-	9.0	7.0	10	3	10.2	T216 1200	•
1400	M 14	x 2	110	20	-	11.0	9.0	12	3	12.0	T216 1400	•
1600	M 16	x 2	110	20	-	12.0	9.0	12	3	14.0	T216 1600	•
1800	M 18	x 2.5	125	25	-	14.0	11.0	14	4	15.5	T216 1800	•
2000	M 20	x 2.5	140	25	-	16.0	12.0	15	4	17.5	T216 2000	•

*Other sizes available to order on request

Special Taps Service

Sutton Tools understands the difficulty of manufacturing super alloys.

Our Special Tool Service enables us to meet your requirements and deliver superior performance in Titanium & high temperature alloys.

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

All Thread Forms
M, MJ, UNJC, UNJF, Screw Thread Insert (STI)

Sizes
M2-M30, #2-1"

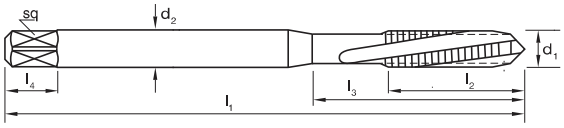
| ISO | P | | | | | | | | | | | | M | | | K | | | | | | N | | | | | | | | | S | | | | | | | | | | | |

DIN Taps Metric, Spiral Flute, L12 Ti

suttontools

- For Titanium based alloys
- Unique cutting geometry for highly efficient swarf ejection
- Optimised microfinish for optimal process reliability and excellent thread quality
- Blind holes up to approx. 1.5 x d_1

DIN 371 | DIN 376 | 60° M | µ MICRO



Catalogue Code	T152	T784
Discount Group	D0408	D0408
Material	PM-HSS Co	PM-HSS Co
Surface Finish	TiCN	TiCN
Sutton Designation	Ti	Ti
Geometry	L12	L12
Chamfer	Form B / 4.5 x P	Form B / 4.5 x P
Limit & Nut Tolerance	6HX	MJ-4HX

Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
	DIN 371											
0300	M 3	x 0.5	56	11	18	3.5	2.7	6	3	2.5	T152 0300	•
0400	M 4	x 0.7	63	13	21	4.5	3.4	6	3	3.3	T152 0400	•
0500	M 5	x 0.8	70	16	25	6.0	4.9	8	3	4.2	T152 0500	•
0600	M 6	x 1	80	19	30	6.0	4.9	8	3	5.0	T152 0600	•
0800	M 8	x 1.25	90	22	35	8.0	6.2	9	3	6.8	T152 0800	•
1000	M 10	x 1.5	100	24	39	10.0	8.0	11	3	8.5	T152 1000	•
	DIN 376										T153	T785
1200	M 12	x 1.75	110	29	-	9.0	7.0	10	3	10.2	T153 1200	•
1400	M 14	x 2	110	30	-	11.0	9.0	12	3	12.0	T153 1400	•
1600	M 16	x 2	110	32	-	12.0	9.0	12	3	14.0	T153 1600	•
1800	M 18	x 2.5	125	34	-	14.0	11.0	14	4	15.5	T153 1800	•
2000	M 20	x 2.5	140	34	-	16.0	12.0	15	4	17.5	T153 2000	•

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
T152													●			○																							●	●	●	●	●						

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

● Optimal ○ Effective

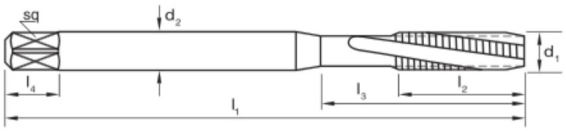
• Available on request as special manufacture. Subject to lead time & MOQ.

DIN Taps Metric, Spiral Flute, R10 Ni

suttontools

- For Nickel alloys / age-hardened super alloys >1150M/mm²
- Reinforced cutting geometry
- Blind or through holes
- Depths up to approx. 1.5 x d_1

DIN 371 | DIN 376 | 60° M | μ MICRO



Catalogue Code	T217	T792
Discount Group	D0408	D0408
Material	PM-HSS Co	PM-HSS Co
Surface Finish	*TICN*	*TICN*
Sutton Designation	NI	NI
Geometry	R10	R10
Chamfer	Form C / 3 x P	Form C / 3 x P
Limit & Nut Tolerance	6HX	MJ–4HX

Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø†	Item #	Item #
	DIN 371											
0300	M 3	x 0.5	56	11	18	3.5	2.7	6	3		T217 0300	•
0400	M 4	x 0.7	63	13	21	4.5	3.4	6	3		T217 0400	•
0500	M 5	x 0.8	70	16	25	6.0	4.9	8	3		T217 0500	•
0600	M 6	x 1	80	19	30	6.0	4.9	8	3		T217 0600	•
0800	M 8	x 1.25	90	22	35	8.0	6.2	9	3		T217 0800	•
1000	M 10	x 1.5	100	24	39	10.0	8.0	11	3		T217 1000	•
	DIN 376										T218	T793
1200	M 12	x 1.75	110	29	-	9.0	7.0	10	3		T218 1200	•
1400	M 14	x 2	110	30	-	11.0	9.0	12	3		T218 1400	•
1600	M 16	x 2	110	32	-	12.0	9.0	12	3		T218 1600	•
2000	M 20	x 2.5	140	34	-	16.0	12.0	15	4		T218 2000	•

Special Taps Service

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

All Thread Forms
M, MJ, UNJC, UNJF, Screw Thread Insert (STI)

Sizes
M2-M30, #2-1"

† Sutton Tools recommends that in difficult to machine materials the tapping drill holes should be drilled as large as practical whilst maintaining sufficient strength in the produced thread. This will need to be determined for each individual application. By decreasing the % thread engagement the tapping torque required is reduced and the tool life can be increased.

	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
T217																																	●	●	●	●	○												

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 & MOQ.

Technical Information Fluteless Taps

Fluteless taps do not cut threads in the same manner as conventional taps – but actually FORM and FLOW the threads with an absence of chips. Used under suitable conditions these taps produce threads with a high degree of finish not possible with ordinary taps. Ductile materials are most appropriate for forming of threads and must have a minimum elongation.

Suitable for wide range materials

- Low carbon steels
- Leaded steels
- Austenitic stainless steels
- Alloy steels; typically up to 1200 N/mm², (36 Rc) with a minimum 10% elongation
- Aluminium die castings alloys (low silicon, 10% max;)
- Wrought aluminium alloys (Ductile)
- Zinc die casting alloys
- Copper and copper alloys

Benefits of thread forming

Figure 1. No chips produced
Figure 2. Higher tensile strength threads produced due to grain structure following the thread form
Figure 3. For use in through and blind holes applications
Higher speeds and tool life
Reduced possibility of breakage due to no cutting edges and robust tool construction

What's New?

Figure 4. New polygon profile
Figure 5. New radiused blend on polygon profile
Figure 6. Thread profile with radius crest
Figure 7. Polished tool surface finish

Figure 1.

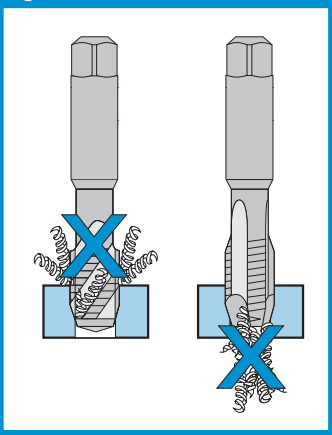


Figure 2.

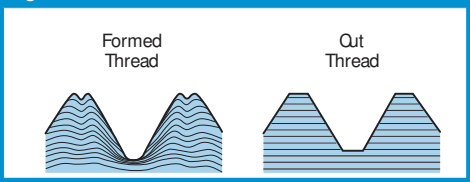


Figure 3.

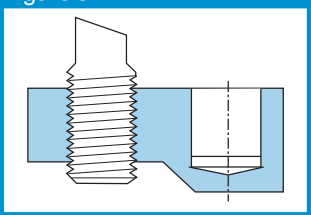


Figure 4.

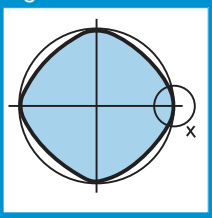


Figure 5.

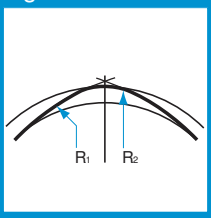


Figure 6.

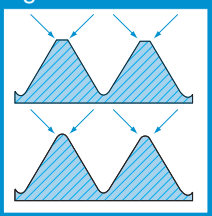


Figure 7.

Percentage of thread required

Because the thread produced by a fluteless tap is substantially stronger than a conventional thread, greater tool life and efficiency may be obtained when forming up to 65% thread.
Threads may be formed up to 80% of depth, but tool life will be reduced and work clamping pressure necessarily increased. Greater tapping speeds allow the metal to flow far more readily, so 60 feet per minute minimum may be used as a guide, but this could increase with the type of material being tapped. A depth of 65% is recommended for the ductile materials mentioned, but this percentage will be reduced for less ductile materials to maintain all round efficiency.

Tapping drill formula for fluteless taps

Refer Tapping Drill Size Chart for recommended sizes suitable for Unified, Whitworth and Metric sizes only. The formula to calculate the theoretical hole size for a required percentage of thread is:

Formula	Example
Drill size = nominal thread dia. (in mm) – [illegible]% of thread pitch	Drill size for 65% of thread in a M6 [illegible] threaded hole would be: Drill size = 6 – [illegible] × 65 × [illegible] pitch [illegible] = 3.5 mm. Use 5,5 mm drill. Stocktable drill [illegible]%

It is to be noted that the drill size for fluteless tapping is always larger than the [illegible] of the thread. A drill size equal to the [illegible] of the thread would produce [illegible]% of thread, but this is [illegible] recommended.

As the additional driving torque is only up to 50% increase, any conventional driving equipment using the square as a drive is suitable for fluteless tapping.

Lubrication

In general it is best to use a good cutting oil or lubricant rather than a coolant for fluteless tapping. Sulphur base and mineral oils, along with most friction reducing lubricants recommended for use in cold extrusion or metal drawing, have proven best for this work. Make sure lubricant is clean, free from chips swarf and filings in suspension, which produce a poor finish and galling, sometimes breakage – extra filtration may be required.

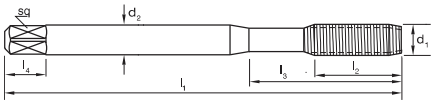
Countersinking

Because the fluteless tap displaces metal, some metal will be displaced above the mouth of the hole during tapping, countersinking or chamfer the hole prior to tapping will reduce the extrusion within the countersink and not interfere with the mating part.

DIN Taps Metric, Forming, No Groove

suttontools

- Suitable for materials with >10%elongation
- Through or blind holes
- Depths up to 3 x d_1



Catalogue Code	T309	T313	T311	T315
Discount Group	D0402	D0406	D0402	D0406
Material	HSSE	HSSE	HSSE	HSSE
Surface Finish	Brt	TiN	Brt	TiN
Sutton Designation	N	N	N	N
Geometry	No Groove	No Groove	No Groove	No Groove
Chamfer	Form C/ 2.5 x P	Form C/ 2.5 x P	Form D/ 4 x P	Form D/ 4 x P
Limit & Nut Tolerance	6HX	6HX	6HX	6HX

Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #	Item #	Item #
0100	M 1	x 0.25	40	6	-	2.5	2.1	3		0.9	T309 0100	T313 0100	T311 0100	T315 0100
0120	M 1.2	x 0.25	40	6	-	2.5	2.1	3		1.1	T309 0120	T313 0120	T311 0120	T315 0120
0140	M 1.4	x 0.3	40	6	-	2.5	2.1	3		1.28	T309 0140	T313 0140	T311 0140	T315 0140
0160	M 1.6	x 0.35	40	7	-	2.5	2.1	3		1.45	T309 0160	T313 0160	T311 0160	T315 0160
0170	M 1.7	x 0.35	40	8	-	2.5	2.1	3		1.55	T309 0170	T313 0170	T311 0170	T315 0170
0180	M 1.8	x 0.35	40	8	-	2.5	2.1	3		1.65	T309 0180	T313 0180	T311 0180	T315 0180
0200	M 2	x 0.4	45	8	-	2.8	2.1	5		1.8	T309 0200	T313 0200	T311 0200	T315 0200
0220	M 2.2	x 0.45	45	8	-	2.8	2.1	5		2.0	T309 0220	T313 0220	T311 0220	T315 0220
0230	M 2.3	x 0.4	45	9	-	2.8	2.1	5		2.1	T309 0230	T313 0230	T311 0230	T315 0230
0250	M 2.5	x 0.45	50	9	-	2.8	2.1	5		2.3	T309 0250	T313 0250	T311 0250	T315 0250
0260	M 2.6	x 0.45	50	9	-	2.8	2.1	5		2.4	T309 0260	T313 0260	T311 0260	T315 0260
0300	M 3	x 0.5	56	11	18	3.5	2.7	6		2.8	T309 0300	T313 0300	T311 0300	T315 0300
0350	M 3.5	x 0.6	56	13	20	4.0	3.0	6		3.2	T309 0350	T313 0350	T311 0350	T315 0350
0400	M 4	x 0.7	63	13	21	4.5	3.4	6		3.7	T309 0400	T313 0400	T311 0400	T315 0400
0500	M 5	x 0.8	70	16	25	6.0	4.9	8		4.6	T309 0500	T313 0500	T311 0500	T315 0500
0600	M 6	x 1	80	19	30	6.0	4.9	8		5.5	T309 0600	T313 0600	T311 0600	T315 0600
0800	M 8	x 1.25	90	22	35	8.0	6.2	9		7.4	T309 0800	T313 0800	T311 0800	T315 0800
1000	M 10	x 1.5	100	24	39	10.0	8.0	11		9.3	T309 1000	T313 1000	T311 1000	T315 1000

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
T309	●	●																					◐	◐	●	●		◐		●																				
T313	◐	◐	●	◐		●								◐									◐	◐	●	●		◐		●																				
T311	●	●																					◐	◐	●	●		◐		●																				
T315	◐	◐	●	◐		●								◐									◐	◐	●	●		◐		●																				

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

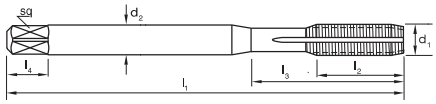
● Optimal ◐ Effective

M

DIN Taps Metric, Forming, Multi Coolant Groove

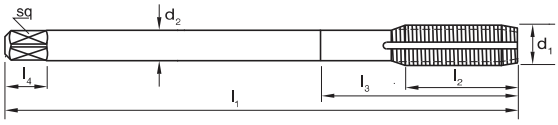
suttontools

- Suitable for materials with >10% elongation
- Through or blind holes
- Depths up to 3 x d_1



Catalogue Code	T319	T321	T323	T329
Discount Group	D0408	D0408	D0408	D0404
Material	HSSE	HSSE	HSSE	HSSE
Surface Finish	TiCN	TiCN	TiCN	CrN
Sutton Designation	N	N	N	Cu
Geometry	Multi Coolant Groove	Multi Coolant Groove	Multi Coolant Groove	Single-Coolant Groove
Chamfer	Form C/ 2.5 x P	Form D/ 4 x P	Form C/ 2.5 x P	Form C/ 2.5 x P
Limit & Nut Tolerance	6HX	6HX	6GX	6HX

Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #	Item #	Item #
0100*	M 1	x 0.25	40	6	-	2.5	2.1	3		0.9	T319 0100	•	•	•
0140	M 1.4	x 0.3	40	6	-	2.5	2.1	3		1.28	T319 0140	•	•	•
0160*	M 1.6	x 0.35	40	7	-	2.5	2.1	3		1.45	T319 0160	•	•	•
0200	M 2	x 0.4	45	8	-	2.8	2.1	5		1.8	T319 0200	•	•	•
0250	M 2.5	x 0.45	50	9	-	2.8	2.1	5		2.3	T319 0250	•	•	•
0300	M 3	x 0.5	56	11	18	3.5	2.7	6		2.8	T319 0300	T321 0300	T323 0300	T329 0300
0350	M 3.5	x 0.6	56	13	20	4.0	3.0	6		3.2	T319 0350	T321 0350	T323 0350	T329 0350
0400	M 4	x 0.7	63	13	21	4.5	3.4	6		3.7	T319 0400	T321 0400	T323 0400	T329 0400
0500	M 5	x 0.8	70	16	25	6.0	4.9	8		4.6	T319 0500	T321 0500	T323 0500	T329 0500
0600	M 6	x 1	80	19	30	6.0	4.9	8		5.5	T319 0600	T321 0600	T323 0600	T329 0600
0800	M 8	x 1.25	90	22	35	8.0	6.2	9		7.4	T319 0800	T321 0800	T323 0800	T329 0800
1000	M 10	x 1.5	100	24	39	10.0	8.0	11		9.3	T319 1000	T321 1000	T323 1000	T329 1000



Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #	Item #	Item #
											T320	T322	T324	T330
0600	M 6†	x 1	80	19	-	4.5	3.4	6		5.5	T320 0600	•	•	•
0800	M 8†	x 1.25	90	22	-	6.0	4.9	8		7.4	T320 0800	•	•	•
1000	M 10†	x 1.5	100	24	-	7.0	5.5	8		9.3	T320 1000	•	•	•
1200	M 12	x 1.75	110	29	-	9.0	7.0	10		11.2	T320 1200	T322 1200	T324 1200	T330 1200
1400	M 14	x 2	110	30	-	11.0	9.0	12		13.1	T320 1400	T322 1400	T324 1400	•
1600	M 16	x 2	110	32	-	12.0	9.0	12		15.1	T320 1600	T322 1600	T324 1600	•
1800	M 18	x 2.5	125	34	-	14.0	11.0	14		16.9	•	•	T324 1800	•
2000	M 20	x 2.5	140	34	-	16.0	12.0	15		18.9	T320 2000	•	T324 2000	•

	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
T319	●	●	●	●		●								●									●	●	○	○		●		○																		
T321	●	●	●	●		●								●									●	●	○	○		●		○																		
T323	●	●	●	●		●								●									●	●	○	○		●		○																		
T329																							●	●	●	●		●		●																			

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

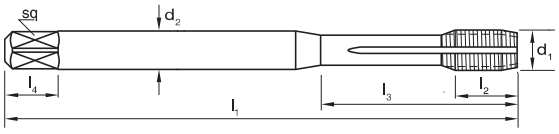
● Optimal ○ Effective

• Available on request as special manufacture. Subject to lead time. † Made to ~DIN 376 standard.

M

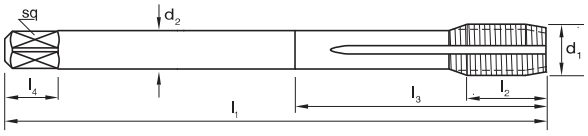
suttontools

- SPM for superior performance
- Application specific geometry
- Suitable for materials with >10% elongation
- Through or blind holes
- Depths up to 3 x d_1



Catalogue Code	T325	T751	T327
Discount Group	D0410	D0410	D0410
Material	SPM	SPM	SPM
Surface Finish	TiAlN	TiAlN	TiAlN
Sutton Designation	UNI	UNI	UNI
Geometry	Multi-Coolant Groove	Multi-Coolant Groove	IK
Chamfer	Form C/ 2.5 x P	Form E/ 1.5 x P	Form C/ 2.5 x P
Limit & Nut Tolerance	6HX	6HX	6HX

Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #	Item #
0200	M 2	x 0.4	45	6	-	2.8	2.1	5		1.8	T325 0200		
0220	M 2.2	x 0.45	45	7	-	2.8	2.1	5		2.0	•		
0230	M 2.3	x 0.4	45	7	-	2.8	2.1	5		2.1	•		
0250	M 2.5	x 0.45	50	8	-	2.8	2.1	5		2.3	T325 0250		
0260	M 2.6	x 0.45	50	8	-	2.8	2.1	5		2.4	•		
0300	M 3	x 0.5	56	9	18	3.5	2.7	6		2.8	T325 0300	•	
0350	M 3.5	x 0.6	56	11	20	4.0	3.0	6		3.2	•		
0400	M 4	x 0.7	63	12	21	4.5	3.4	6		3.7	T325 0400	•	
0500	M 5	x 0.8	70	13	25	6.0	4.9	8		4.6	T325 0500	•	T327 0500
0600	M 6	x 1	80	15	30	6.0	4.9	8		5.5	T325 0600	•	T327 0600
0800	M 8	x 1.25	90	18	35	8.0	6.2	9		7.4	T325 0800	•	T327 0800
1000	M 10	x 1.5	100	20	39	10.0	8.0	11		9.3	T325 1000	•	T327 1000



Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #	Item #
											T326	T752	T328
1200	M 12	x 1.75	110	23	-	9.0	7.0	10		11.2	T326 1200	•	T328 1200
1400	M 14	x 2	110	25	-	11.0	9.0	12		13.1	T326 1400	•	T328 1400
1600	M 16	x 2	110	25	-	12.0	9.0	12		15.1	T326 1600	•	T328 1600
1800	M 18	x 2.5	125	30	-	14.0	11.0	14		16.9	•	•	•
2000	M 20	x 2.5	140	30	-	16.0	12.0	15		18.9	•	•	•

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
T325	◐	◐	◐	◐		◐	●			◐				●	●								◐	◐	◐	◐		◐		●																			
T327	◐	◐	◐	◐		◐	●			◐				◐	◐								◐	◐	◐	◐		◐		●																			

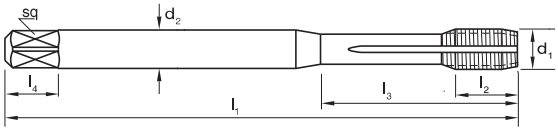
P Steel | M Stainless Steel | K Cast Iron | N Non-Ferrous Metals | S Titanium & Super Alloys | H Hard Materials

● Optimal ◐ Effective

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

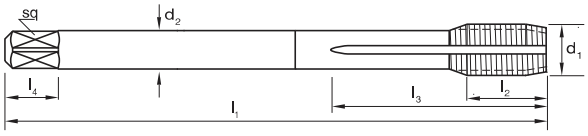
suttontools

- SPM for superior performance
- Suitable for materials with restricted ductility
- Application specific geometry for harder materials (GGV)
- Through or Blind holes
- Depths up to 2 x d1



Catalogue Code	T331	T745
Discount Group	D0408	D0408
Material	SPM	SPM
Surface Finish	TiCN	TiCN
Sutton Designation	NH	NH
Geometry	Multi-Coolant Groove	Multi-Coolant Groove IK
Chamfer	Form C/ 2.5 x P	Form C/ 2.5 x P
Limit & Nut Tolerance	6HX	6HX

Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
0220	M 2.2	x 0.45	45	7	-	2.8	2.1	5		2.0	•	
0230	M 2.3	x 0.4	45	7	-	2.8	2.1	5		2.1	•	
0250	M 2.5	x 0.45	50	8	-	2.8	2.1	5		2..3	T331 0250	
0260	M 2.6	x 0.45	50	8	-	2.8	2.1	5		2.4	•	
0300	M 3	x 0.5	56	9	18	3.5	2.7	6		2.8	T331 0300	
0350	M 3.5	x 0.6	56	11	20	4.0	3.0	6		3.2	T331 0350	
0400	M 4	x 0.7	63	12	21	4.5	3.4	6		3.7	T331 0400	
0500	M 5	x 0.8	70	13	25	6.0	4.9	8		4.6	T331 0500	
0600	M 6	x 1	80	15	30	6.0	4.9	8		5.5	T331 0600	•
0800	M 8	x 1.25	90	18	35	8.0	6.2	9		7.4	T331 0800	•
1000	M 10	x 1.5	100	20	39	10.0	8.0	11		9.3	T331 1000	•



Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
											T332	T746
1200	M 12	x 1.75	110	23	-	9.0	7.0	10		11.2	T332 1200	•
1400	M 14	x 2	110	25	-	11.0	9.0	12		13.1	T332 1400	•
1600	M 16	x 2	110	25	-	12.0	9.0	12		15.1	T332 1600	•
1800	M 18	x 2.5	125	30	-	14.0	11.0	14		16.9	•	
2000	M 20	x 2.5	140	30	-	16.0	12.0	15		18.9	•	

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
T331	●	●	◐	◐	●	◐	◐	●		◐				●	●								●	●	●	●		●	●	●																			
T745	●	●	◐	◐	●	◐	◐	●		◐				●	●								●	●	●	●		●	●	●																			

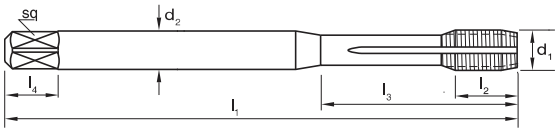
P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials

● Optimal ◐ Effective

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

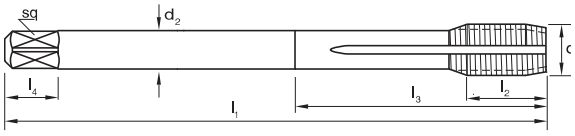
suttontools

- VHM for high volume production
- Suitable for materials with restricted ductility & high Silicon cast Aluminium
- Through or Blind holes
- Depths up to 2 x d_1



Catalogue Code	T682	T747
Discount Group	D0414	D0414
Material	VHM	VHM
Surface Finish	TiCN	TiCN
Sutton Designation	N	N
Geometry	Multi-Coolant Groove	Multi-Coolant Groove IK
Chamfer	Form C/ 2.5 x P	Form C/ 2.5 x P
Limit & Nut Tolerance	6HX	6HX

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	45	6	-	2.8	2.1	5		1.8		
0220	M 2.2	x 0.45	45	7	-	2.8	2.1	5		2.0		
0230	M 2.3	x 0.4	45	7	-	2.8	2.1	5		2.1		
0250	M 2.5	x 0.45	50	8	-	2.8	2.1	5		2..3		
0260	M 2.6	x 0.45	50	8	-	2.8	2.1	5		2.4		
0300	M 3	x 0.5	56	9	18	3.5	2.7	6		2.8	•	
0350	M 3.5	x 0.6	56	11	20	4.0	3.0	6		3.2		
0400	M 4	x 0.7	63	12	21	4.5	3.4	6		3.7	•	
0500	M 5	x 0.8	70	13	25	6.0	4.9	8		4.6	•	
0600	M 6	x 1	80	15	30	6.0	4.9	8		5.5	•	•
0800	M 8	x 1.25	90	18	35	8.0	6.2	9		7.4	•	•
1000	M 10	x 1.5	100	20	39	10.0	8.0	11		9.3	•	•



Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
											T683	T748
1200	M 12	x 1.75	110	23	-	9.0	7.0	10		11.2	•	•
1400	M 14	x 2	110	25	-	11.0	9.0	12		13.1	•	•
1600	M 16	x 2	110	25	-	12.0	9.0	12		15.1	•	•

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
T682	●	●	●	●	◐	●	●	◐		●				●	●								●	●	●	●		◐	◐	●																			
T747	●	●	●	●	◐	●	●	◐		●				●	●								●	●	●	●		◐	◐	●																			

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

● Optimal ◐ Effective

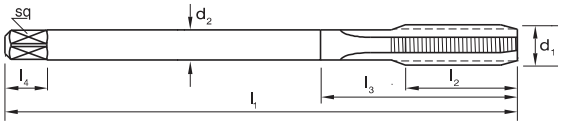
• Available on request as special manufacture. Subject to lead time.

M

DIN Taps Metric Fine, Straight Flute, N

suttontools

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



Catalogue Code	T298	T299
Discount Group	D0402	D0406
Material	HSSE	HSSE
Surface Finish	Brt	TIN
Sutton Designation	N	N
Geometry		
Chamfer	Form C/ 2.5 x P	Form C/ 2.5 x P
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 #
0302	MF 3	x 0.35	56	8	-	2.2	-	-	3	2.65	T298 0302	•
0403	MF 4	x 0.5	63	10	-	2.8	2.1	5	3	3.5	T298 0403	•
0503	MF 5	x 0.5	70	12	-	3.5	2.7	6	3	4.5	T298 0503	•
0603	MF 6	x 0.5	80	14	-	4.5	3.4	6	3	5.5	T298 0603	T299 0603
0604	MF 6	x 0.75	80	14	-	4.5	3.4	6	3	5.3	T298 0604	•
0803	MF 8	x 0.5	80	18	-	6.0	4.9	8	3	7.5	T298 0803	•
0804	MF 8	x 0.75	80	18	-	6.0	4.9	8	3	7.3	T298 0804	•
0805	MF 8	x 1	90	22	-	6.0	4.9	8	3	7.0	T298 0805	T299 0805
1004	MF 10	x 0.75	90	20	-	7.0	5.5	8	3	9.3	T298 1004	•
1005	MF 10	x 1	90	20	-	7.0	5.5	8	3	9.0	T298 1005	T299 1005
1006	MF 10	x 1.25	100	24	-	7.0	5.5	8	3	8.8	T298 1006	T299 1006
1205	MF 12	x 1	100	22	-	9.0	7.0	10	3	11.0	T298 1205	T299 1205
1206	MF 12	x 1.25	100	22	-	9.0	7.0	10	3	10.8	T298 1206	T299 1206
1207	MF 12	x 1.5	100	22	-	9.0	7.0	10	3	10.5	T298 1207	T299 1207
1405	MF 14	x 1	100	22	-	11.0	9.0	12	3	13.0	T298 1405	T299 1405
1406	MF 14	x 1.25	100	22	-	11.0	9.0	12	3	12.8	T298 1406	T299 1406
1407	MF 14	x 1.5	100	22	-	11.0	9.0	12	3	12.5	T298 1407	T299 1407
1605	MF 16	x 1	100	22	-	12.0	9.0	12	3	15.0	T298 1605	T299 1605
1607	MF 16	x 1.5	100	22	-	12.0	9.0	12	3	14.5	T298 1607	T299 1607
1805	MF 18	x 1	110	25	-	14.0	11.0	14	4	17.0	T298 1805	•
1807	MF 18	x 1.5	110	25	-	14.0	11.0	14	4	16.5	T298 1807	T299 1807
1808	MF 18	x 2	125	34	-	14.0	11.0	14	4	16.0	T298 1808	•
2005	MF 20	x 1	125	25	-	16.0	12.0	15	4	19.0	T298 2005	T299 2005
2007	MF 20	x 1.5	125	25	-	16.0	12.0	15	4	18.5	T298 2007	T299 2007
2008	MF 20	x 2	140	34	-	16.0	12.0	15	4	18.0	T298 2008	•

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
T298	●	●	●	●	○	●	○	○		○													○	○	○	○		○	○	○																			
T299	●	●	●	●	○	●	○	○		○													○	○	○	○		○	○	○																			

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.

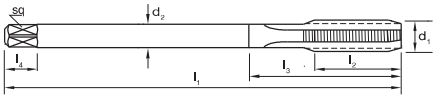
MF

DIN Taps Metric Fine, Straight Flute, GG

suttontools

- HSSE, for use in grey cast iron (GG)
- VHM, for use in Al >10%Si & cast iron (GGG)
- Through & blind holes
- Depths up to 3 x d_1

DIN 374 | DIN 371 | DIN 376 | 60° MF



Catalogue Code	T300	T301	T743	T744
Discount Group	D0402	D0408	D0414	D0414
Material	HSSE	HSSE	VHM	VHM
Surface Finish	Ni + Blu	TiCN	TiCN	TiCN
Sutton Designation	GG	GG	GG	GG
Geometry	Low Relief	Low Relief	Low Relief	IK
Chamfer	Form C/ 2.5 x P	Form C/ 2.5 x P	Form C/ 2.5 x P	Form C/ 2.5 x P
Limit & Nut Tolerance	6HX	6HX	6HX	6HX

Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #	Item #	Item #
	DIN374													
0302	MF3	x 0.35	56	8	-	2.2	-	-	4	2.65	•	•		
0403	MF4	x 0.5	63	10	-	2.8	2.1	5	4	3.5	T300 0403	T301 0403		
0503	MF5	x 0.5	70	12	-	3.5	2.7	6	4	4.5	T300 0503	T301 0503		
0604	MF6	x 0.75	80	14	-	4.5	3.4	6	4	5.3	T300 0604	T301 0604		
0803	MF8	x 0.5	80	18	-	6.0	4.9	8	4	7.5	•	•		
0804	MF8	x 0.75	80	18	-	6.0	4.9	8	4	7.3	•	•		
0805	MF8	x 1	90	22	-	6.0	4.9	8	4	7.0	T300 0805	T301 0805		
1004	MF10	x 0.75	90	20	-	7.0	5.5	8	4	9.3	•	•		
1005	MF10	x 1	90	20	-	7.0	5.5	8	4	9.0	T300 1005	T301 1005		
1006	MF10	x 1.25	100	24	-	7.0	5.5	8	4	8.8	T300 1006	T301 1006		
1205	MF12	x 1	100	22	-	9.0	7.0	10	4	11.0	•	•		
1206	MF12	x 1.25	100	22	-	9.0	7.0	10	4	10.8	T300 1206	T301 1206		
1207	MF12	x 1.5	100	22	-	9.0	7.0	10	4	10.5	T300 1207	T301 1207		
1405	MF14	x 1	100	22	-	11.0	9.0	12	4	13.0	•	•		
1406	MF14	x 1.25	100	22	-	11.0	9.0	12	4	12.8	T300 1406	T301 1406		
1407	MF14	x 1.5	100	22	-	11.0	9.0	12	4	12.5	T300 1407	T301 1407		
1605	MF16	x 1	100	22	-	12.0	9.0	12	4	15.0	•	•		
1607	MF16	x 1.5	100	22	-	12.0	9.0	12	4	14.5	T300 1607	T301 1607		
1805	MF18	x 1	110	25	-	14.0	11.0	14	4	17.0	•	•		
1807	MF18	x 1.5	110	25	-	14.0	11.0	14	4	16.5	T300 1807	T301 1807		
1808	MF18	x 2	125	34	-	14.0	11.0	14	4	16.0	•	•		
2005	MF20	x 1	125	25	-	16.0	12.0	15	4	19.0	•	•		
2007	MF20	x 1.5	125	25	-	16.0	12.0	15	4	18.5	T300 2007	T301 2007		
2008	MF20	x 2	140	34	-	16.0	12.0	15	4	18.0	•	•		
	DIN371													
0805	MF8	x 1	90	22	35	8.0	6.2	9	4	7.0			•	•
1005	MF10	x 1	100	24	39	10.0	8.0	11	4	9.0			•	•
	DIN376													
1207	MF12	x 1.5	110	28	-	9.0	7.0	10	4	10.5			•	•
1407	MF14	x 1.5	110	30	-	11.0	9.0	12	4	12.5			•	•

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
T300																	●	●	●	●	○	○																												
T301																	●	●	●	●	○	○					○																							
T743																	●	●	●	●	○	○					●		●																				●	
T744																	●	●	●	●	○	○					●		●																				●	

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

● Optimal ○ Effective

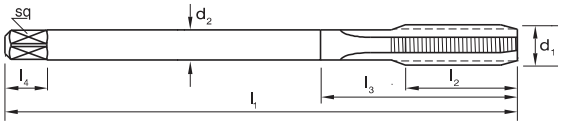
• Available on request as special manufacture. Subject to lead time.

MF

DIN Taps Metric Fine, Straight Flute, DC

suttontools

- Premium design for cast aluminium and cast iron (Short Chipping)
- Through & blind holes
- Depths up to approx. 1.5 x d_1
- Axial coolant duct available



Catalogue Code	T668	T669
Discount Group	D0408	D0408
Material	PM-HSS Co	PM-HSS Co
Surface Finish	TiCN	TiCN
Sutton Designation	Die Cast	Die Cast
Geometry		IK
Chamfer	Form E / 1.5 x P	Form E / 1.5 x P
Limit & Nut Tolerance	6HX	6HX

Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
1006	MF 10	x 1.25	100	24	-	7.0	5.5	8	4	8.8	T668 1006	T669 1006
1207	MF 12	x 1.5	100	22	-	9.0	7.0	10	4	10.5	T668 1207	T669 1207
1407	MF 14	x 1.5	100	22	-	11.0	9.0	12	4	12.5	T668 1407	T669 1407
1607	MF 16	x 1.5	100	22	-	12.0	9.0	12	4	14.5	T668 1607	T669 1607

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
T668																	◐	◐	◐	◐	◐	◐			●	●	●		◐																			◐	
T669																	◐	◐	◐	◐	◐	◐			●	●	●		◐																			◐	

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

● Optimal ◐ Effective

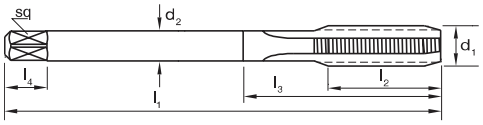
• Available on request as special manufacture. Subject to lead time.

MF

DIN Taps Metric Fine, Straight Flute, XH

suttontools

- Use in hardened steels 42-52 HRC
- Through & blind holes
- Suitable for machine operations
- Depths up to approx. 1.5 x d_1



Catalogue Code	T343	T344
Discount Group	DO408	DO408
Material	SPM	SPM
Surface Finish	TiCN	TiCN
Sutton Designation	XH	XH
Geometry	Special Relief	Special Relief
Chamfer	Form C/ 3 x P	Form D/ 5 x P
Limit & Nut Tolerance	6HX	6HX

Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
0805	MF8	x 1	70	22	-	6.0	4.9	8	5	7.1	•	•
1005	MF10	x 1	75	24	-	7.0	5.5	8	5	9.1	•	•
1006	MF10	x 1.25	75	24	-	7.0	5.5	8	5	8.9	•	•
1205	MF12	x 1	82	29	-	9.0	7.0	10	5	11.1	•	•
1206	MF12	x 1.25	82	29	-	9.0	7.0	10	5	10.9	•	•
1207	MF12	x 1.5	82	29	-	9.0	7.0	10	5	10.6	•	•

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
T343					◐			◐	◒		◒		◒					◒		◒								◐																◒				◒	

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

◐ Optimal ◒ Effective

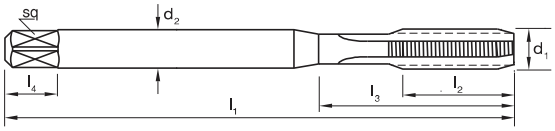
• Available on request as special manufacture. Subject to lead time.

MF

DIN Taps Metric Fine, Straight Flute, VH

suttontools

- Use in hardened steels 50-60 HRC
- Through & blind holes
- Suitable for machine operations
- Depths up to approx. 1.5 x d_1



Catalogue Code	T345	T346
Discount Group	D0414	D0414
Material	VHM	VHM
Surface Finish	TiCN	TiCN
Sutton Designation	VH	VH
Geometry	Special Relief	Special Relief
Chamfer	Form C/ 3 x P	Form D/ 5 x P
Limit & Nut Tolerance	6HX	6HX

Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
	DIN371											
0805	MF 8	x 1	90	22	35	8.0	6.2	9	5	7.0	T345 0805	T346 0805
1005	MF 10	x 1	100	24	39	10.0	8.0	11	5	9.0	T345 1005	T346 1005
1006	MF 10	x 1.25	100	24	39	10.0	8.0	11	5	9.0	T345 1006	T346 1006
	DIN376											
1206	MF 12	x 1.25	110	28	-	9.0	7.0	10	5	10.5	T345 1206	T346 1206
1207	MF 12	x 1.5	110	28	-	9.0	7.0	10	5	10.5	T345 1207	T346 1207
1407	MF 14	x 1.5	110	30	-	11.0	9.0	12	5	12.5	•	•
1607	MF 16	x 1.5	110	32	-	12.0	9.0	12	6	14.1	•	•
2007	MF 20	x 1.5	140	34	-	16.0	12.0	15	6	17.7	•	•

MF

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
T345									○		○		○																○																●	●	●	●	○	●

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

● Optimal ○ Effective

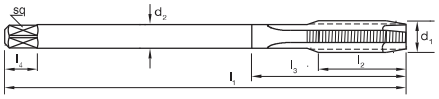
• Available on request as special manufacture. Subject to lead time.

DIN Taps Metric Fine, Gun, N

suttontools

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

DIN 374 | 60° MF



Catalogue Code	T154	T155	T156	T157
Discount Group	D0402	D0402	D0402	D0406
Material	HSSE	HSSE	HSSE	HSSE
Surface Finish	Brt	Brt	Blu	TiN
Sutton Designation	N	N	N	N
Geometry		6G		
Chamfer	Form B / 4.5 x P	Form B / 4.5 x P	Form B / 4.5 x P	Form B / 4.5 x P
Limit & Nut Tolerance	ISO 2 / 6H	ISO 3 / 6G	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 #
0302	MF 3	x 0.35	56	8	-	2.2	-	-	3	2.65	T154 0302	•	•	•
0403	MF 4	x 0.5	63	10	-	2.8	2.1	5	3	3.5	T154 0403	•	T156 0403	•
0503	MF 5	x 0.5	70	12	-	3.5	2.7	6	3	4.5	T154 0503	•	T156 0503	•
0604	MF 6	x 0.75	80	14	-	4.5	3.4	6	3	5.3	T154 0604	T155 0604	T156 0604	T157 0604
0803	MF 8	x 0.5	80	18	-	6.0	4.9	8	3	7.5	T154 0803	T155 0803	•	T157 0803
0804	MF 8	x 0.75	80	18	-	6.0	4.9	8	3	7.3	T154 0804	T155 0804	T156 0804	T157 0804
0805	MF 8	x 1	90	22	-	6.0	4.9	8	3	7.0	T154 0805	T155 0805	T156 0805	T157 0805
1004	MF 10	x 0.75	90	20	-	7.0	5.5	8	3	9.3	T154 1004	•	T156 1004	•
1005	MF 10	x 1	90	20	-	7.0	5.5	8	3	9.0	T154 1005	T155 1005	T156 1005	T157 1005
1006	MF 10	x 1.25	100	24	-	7.0	5.5	8	3	8.8	T154 1006	T155 1006	T156 1006	T157 1006
1205	MF 12	x 1	100	22	-	9.0	7.0	10	3	11.0	T154 1205	T155 1205	T156 1205	T157 1205
1206	MF 12	x 1.25	100	22	-	9.0	7.0	10	3	10.8	T154 1206	T155 1206	T156 1206	T157 1206
1207	MF 12	x 1.5	100	22	-	9.0	7.0	10	3	10.5	T154 1207	T155 1207	T156 1207	T157 1207
1405	MF 14	x 1	100	22	-	11.0	9.0	12	3	13.0	T154 1405	•	•	•
1406	MF 14	x 1.25	100	22	-	11.0	9.0	12	3	12.8	T154 1406	T155 1406	T156 1406	T157 1406
1407	MF 14	x 1.5	100	22	-	11.0	9.0	12	3	12.5	T154 1407	T155 1407	T156 1407	T157 1407
1605	MF 16	x 1	100	22	-	12.0	9.0	12	3	14.5	T154 1605	•	•	•
1607	MF 16	x 1.5	100	22	-	12.0	9.0	12	3	14.5	T154 1607	•	T156 1607	T157 1607
1805	MF 18	x 1	110	25	-	14.0	11.0	14	4	17.0	T154 1805	•	•	•
1807	MF 18	x 1.5	110	25	-	14.0	11.0	14	4	16.5	T154 1807	•	T156 1807	T157 1807
1808	MF 18	x 2	125	34	-	14.0	11.0	14	4	16.0	T154 1808	•	•	•
2005	MF 20	x 1	125	25	-	16.0	12.0	15	4	19.0	T154 2005	•	•	•
2007	MF 20	x 1.5	125	25	-	16.0	12.0	15	4	18.5	T154 2007	•	T156 2007	T157 2007
2008	MF 20	x 2	140	34	-	16.0	12.0	15	4	18.0	T154 2008	•	•	•
2205	MF 22	x 1	125	25	-	18.0	14.5	17	4	18.5	T154 2205	•	•	•
2207	MF 22	x 1.5	125	25	-	18.0	14.5	17	4	20.5	T154 2207	•	•	•
2208	MF 22	x 2	140	28	-	18.0	14.5	17	4	20.0	T154 2208	•	•	•
2405	MF 24	x 1	140	28	-	18.0	14.5	17	4	23.0	T154 2405	•	•	•
2407	MF 24	x 1.5	140	28	-	18.0	14.5	17	4	22.5	T154 2407	•	•	•
2408	MF 24	x 2	140	28	-	18.0	14.5	17	4	22.0	T154 2408	•	•	•
2505	MF 25	x 1	140	28	-	18.0	14.5	17	4	24.0	•	•	•	•
2507	MF 25	x 1.5	140	28	-	18.0	14.5	17	4	23.5	T154 2507	•	•	•
2508	MF 25	x 2	140	28	-	18.0	14.5	17	4	23.0	•	•	•	•
2605	MF 26	x 1	140	28	-	18.0	14.5	17	4	25.0	•	•	•	•
2607	MF 26	x 1.5	140	28	-	18.0	14.5	17	4	24.5	T154 2607	•	•	•
2608	MF 26	x 2	140	28	-	18.0	14.5	17	4	24.0	•	•	•	•
2707	MF 27	x 1.5	140	28	-	20.0	16.0	19	4	25.5	T154 2707	•	•	•
2708	MF 27	x 2	140	28	-	20.0	16.0	19	4	25.0	T154 2708	•	•	•
2807	MF 28	x 1.5	140	28	-	20.0	16.0	19	4	26.5	T154 2807	•	•	•
2808	MF 28	x 2	140	28	-	20.0	16.0	19	4	26.0	•	•	•	•

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
T154	●	●	○	○		●	○			○							○		○		○	○	●	●	○	○		○	○																							
T155	●	●	○	○		●	○			○							○		○		○	○	●	●	○	○		○	○																							
T156	●	●	●	●		●	●			●		○		○	○	○	○		○		○	○																														
T157	●	●	●	●	○	●	●	○		●		○		○	○	○	○	○	○	○	○	○	●	●	○	○		●	○																							

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.

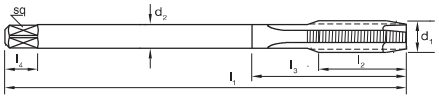
MF

DIN Taps Metric Fine, Gun, N

suttontools

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

DIN 374 | 60° MF



Catalogue Code	T154	T155	T156	T157
Discount Group	D0402	D0402	D0402	D0406
Material	HSSE	HSSE	HSSE	HSSE
Surface Finish	Brt	Brt	Blu	TiN
Sutton Designation	N	N	N	N
Geometry		6G		
Chamfer	Form B / 4.5 x P	Form B / 4.5 x P	Form B / 4.5 x P	Form B / 4.5 x P
Limit & Nut Tolerance	ISO 2 / 6H	ISO 3 / 6G	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 #
3005	MF 30	x 1	150	28	-	22.0	18.0	21	4	29.0	T154 3005	•	•	•
3007	MF 30	x 1.5	150	28	-	22.0	18.0	21	4	28.5	T154 3007	•	•	•
3008	MF 30	x 2	150	28	-	22.0	18.0	21	4	28.0	T154 3008	•	•	•
3207	MF 32	x 1.5	150	28	-	22	18	21	4	30.5	T154 3207	•	•	•
3307	MF 33	x 1.5	160	30	-	25	20	23	4	31.5	T154 3307	•	•	•
3308	MF 33	x 2	160	30	-	25	20	23	4	31	T154 3308	•	•	•
3407	MF 34	x 1.5	170	30	-	28	22	25	4	32.5	T154 3407	•	•	•
3507	MF 35	x 1.5	170	30	-	28	22	25	4	33.5	T154 3507	•	•	•
3607	MF 36	x 1.5	170	30	-	28	22	25	4	34.5	T154 3607	•	•	•
3608	MF 36	x 2	170	30	-	28	22	25	4	34	T154 3608	•	•	•
3609	MF 36	x 3	200	56	-	28	22	25	4	33	T154 3609	•	•	•
3807	MF 38	x 1.5	170	30	-	28	22	25	4	36.5	T154 3807	•	•	•
4007	MF 40	x 1.5	170	30	-	32	24	27	4	38.5	T154 4007	•	•	•
4207	MF 42	x 1.5	170	30	-	32	24	27	4	40.5	T154 4207	•	•	•
4208	MF 42	x 2	170	30	-	32	24	27	4	40	T154 4208	•	•	•
4209	MF 42	x 3	200	30	-	32	24	27	4	39	T154 4209	•	•	•
4507	MF 45	x 1.5	180	32	-	36	29	32	4	43.5	T154 4507	•	•	•
4508	MF 45	x 2	180	32	-	36	29	32	4	43	T154 4508	•	•	•
4807	MF 48	x 1.5	190	32	-	36	29	32	4	46.5	T154 4807	•	•	•
5007	MF 50	x 1.5	190	32	-	36	29	32	4	48.5	T154 5007	•	•	•
5207	MF 52	x 1.5	190	32	-	40	32	35	4	50.5	T154 5207	•	•	•

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
T154	●	●	○	○		●	○			○							○		○		○	○	●	●	○	○		○	○																					
T155	●	●	○	○		●	○			○							○		○		○	○	●	●	○	○		○	○																					
T156	●	●	●	●		●	●			●		○		○	○	○	○		○		○	○																												
T157	●	●	●	●	○	●	●	○		●		○		○	○	○	○	○	○	○	○	○	●	●	○	○		●	○																					

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.

MF

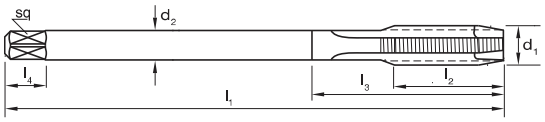
DIN Taps Metric Fine, Gun, Black Magic

suttontools BLACKMAGIC

watch the video

- Universal high performance tapping
- PM-HSSE V3 offers superior tool life
- Use in stainless steels and high strength steels up to 850N/mm²
- Through holes up to 3 x d_1
- Suitable for synchronous tapping in machine operations

DIN 374 | 60° MF | Z



Product Name	T689
Discount Group	D0410
Material	PM-HSSE V3
Surface Finish	HARDLUBE
Sutton Designation	UNI
Geometry	Special Relief
Chamfer	Form B / 4.5 x P
Limit & Nut Tolerance	6HX

Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #
0302	MF3	x 0.35	56	8	-	2.2	-	-	3	2.65	•
0403	MF4	x 0.5	63	10	-	2.8	2.1	5	3	3.5	•
0503	MF5	x 0.5	70	12	-	3.5	2.7	6	3	4.5	•
0604	MF6	x 0.75	80	14	-	4.5	3.4	6	3	5.3	T689 0604
0803	MF8	x 0.5	80	18	-	6.0	4.9	8	3	7.5	T689 0803
0804	MF8	x 0.75	80	18	-	6.0	4.9	8	3	7.3	•
0805	MF8	x 1	90	22	-	6.0	4.9	8	3	7.0	T689 0805
1004	MF10	x 0.75	90	20	-	7.0	5.5	8	3	9.3	•
1005	MF10	x 1	90	20	-	7.0	5.5	8	3	9.0	T689 1005
1006	MF10	x 1.25	100	24	-	7.0	5.5	8	3	8.8	T689 1006
1205	MF12	x 1	100	22	-	9.0	7.0	10	3	11.0	T689 1205
1206	MF12	x 1.25	100	22	-	9.0	7.0	10	3	10.8	T689 1206
1207	MF12	x 1.5	100	22	-	9.0	7.0	10	3	10.5	T689 1207
1405	MF14	x 1	100	22	-	11.0	9.0	12	3	13.0	T689 1405
1406	MF14	x 1.25	100	22	-	11.0	9.0	12	3	12.8	T689 1406
1407	MF14	x 1.5	100	22	-	11.0	9.0	12	3	12.5	T689 1407
1605	MF16	x 1	100	22	-	12.0	9.0	12	3	15.0	T689 1605
1607	MF16	x 1.5	100	22	-	12.0	9.0	12	3	14.5	T689 1607
1805	MF18	x 1	110	25	-	14.0	11.0	14	4	17.0	T689 1805
1807	MF18	x 1.5	110	25	-	14.0	11.0	14	4	16.5	T689 1807
1808	MF18	x 2	125	34	-	14.0	11.0	14	4	16.0	•
2005	MF20	x 1	125	25	-	16.0	12.0	15	4	19.0	T689 2005
2007	MF20	x 1.5	125	25	-	16.0	12.0	15	4	18.5	T689 2007
2008	MF20	x 2	140	34	-	16.0	12.0	15	4	18.0	•

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
T689	●	●	●	○		●	○			●		●	○	●	●		○	○	○	○	○	○	●	●	●	○	○	○	○	○																			

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

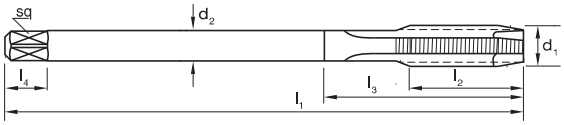
● Optimal ○ Effective

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

MF

suttontools

- Use in stainless steels and high strength steels up to 1000N/mm²
- PM-HSSE V3 offers higher edge hardness than standard VA series
- Through holes
- Suitable for machine operations
- Depths up to approx. 3 x d_1



Catalogue Code	T158	T161
Discount Group	D0402	D0408
Material	HSSE	HSSE
Surface Finish	Blu	TiCN
Sutton Designation	VA	VA
Geometry	Special Relief	Special Relief
Chamfer	Form B / 4.5 x P	Form B / 4.5 x P
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 #
0302	MF 3	x 0.35	56	8	-	2.2	-	-	3	2.65	•	•
0403	MF 4	x 0.5	63	10	-	2.8	2.1	5	3	3.5	•	•
0503	MF 5	x 0.5	70	12	-	3.5	2.7	6	3	4.5	•	•
0604	MF 6	x 0.75	80	14	-	4.5	3.4	6	3	5.3	T158 0604	T161 0604
0803	MF 8	x 0.5	80	18	-	6.0	4.9	8	3	7.5	T158 0803	T161 0803
0804	MF 8	x 0.75	80	18	-	6.0	4.9	8	3	7.3	T158 0804	T161 0804
0805	MF 8	x 1	90	22	-	6.0	4.9	8	3	7.0	T158 0805	T161 0805
1004	MF 10	x 0.75	90	20	-	7.0	5.5	8	3	9.3	T158 1004	•
1005	MF 10	x 1	90	20	-	7.0	5.5	8	3	9.0	T158 1005	T161 1005
1006	MF 10	x 1.25	100	24	-	7.0	5.5	8	3	8.8	T158 1006	T161 1006
1205	MF 12	x 1	100	22	-	9.0	7.0	10	3	11.0	T158 1205	T161 1205
1206	MF 12	x 1.25	100	22	-	9.0	7.0	10	3	10.8	T158 1206	T161 1206
1207	MF 12	x 1.5	100	22	-	9.0	7.0	10	3	10.5	T158 1207	T161 1207
1405	MF 14	x 1	100	22	-	11.0	9.0	12	3	13.0	T158 1405	•
1406	MF 14	x 1.25	100	22	-	11.0	9.0	12	3	12.8	T158 1406	T161 1406
1407	MF 14	x 1.5	100	22	-	11.0	9.0	12	3	12.5	T158 1407	T161 1407
1605	MF 16	x 1	100	22	-	12.0	9.0	12	3	15.0	T158 1605	•
1607	MF 16	x 1.5	100	22	-	12.0	9.0	12	3	14.5	•	•
1805	MF 18	x 1	110	25	-	14.0	11.0	14	4	17.0	T158 1805	•
1807	MF 18	x 1.5	110	25	-	14.0	11.0	14	4	16.5	T158 1807	•
1808	MF 18	x 2	125	34	-	14.0	11.0	14	4	16.0	•	•
2005	MF 20	x 1	125	25	-	16.0	12.0	15	4	19.0	T158 2005	•
2007	MF 20	x 1.5	125	25	-	16.0	12.0	15	4	18.5	T158 2007	•
2008	MF 20	x 2	140	34	-	16.0	12.0	15	4	18.0	•	•

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
T158	●	●	○	○		●	○					○		●	●	○																																		
T161	●	●	○	○		●	○			○		●	○	●	●	●							○	○	○	○	○	○		○			●	○	○														

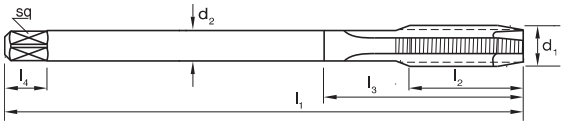
P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials

● Optimal ○ Effective

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

suttontools

- Use in stainless steels and high strength steels up to 1000N/mm²
- PM-HSSE V3 offers higher edge hardness than standard VA series
- Through holes
- Suitable for synchronous tapping in machine operations
- Depths up to approx. 3 x d_1



Catalogue Code	T159	T160
Discount Group	D0402	D0408
Material	PM-HSSE V3	PM-HSSE V3
Surface Finish	Blu	TiCN
Sutton Designation	VA PM	VA PM
Geometry	Special Relief	Special Relief
Chamfer	Form B / 4.5 x P	Form B / 4.5 x P
Limit & Nut Tolerance	6HX	6HX

Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
0302	MF3	x 0.35	56	8	-	2.2	-	-	3	2.65	•	•
0403	MF4	x 0.5	63	10	-	2.8	2.1	5	3	3.5	•	•
0503	MF5	x 0.5	70	12	-	3.5	2.7	6	3	4.5	•	•
0604	MF6	x 0.75	80	14	-	4.5	3.4	6	3	5.3	•	T160 0604
0803	MF8	x 0.5	80	18	-	6.0	4.9	8	3	7.5	•	T160 0803
0804	MF8	x 0.75	80	18	-	6.0	4.9	8	3	7.3	•	•
0805	MF8	x 1	90	22	-	6.0	4.9	8	3	7.0	•	•
1004	MF10	x 0.75	90	20	-	7.0	5.5	8	3	9.3	•	T160 1004
1005	MF10	x 1	90	20	-	7.0	5.5	8	3	9.0	•	T160 1005
1006	MF10	x 1.25	100	24	-	7.0	5.5	8	3	8.8	•	•
1205	MF12	x 1	100	22	-	9.0	7.0	10	3	11.0	•	T160 1205
1206	MF12	x 1.25	100	22	-	9.0	7.0	10	3	10.8	•	T160 1206
1207	MF12	x 1.5	100	22	-	9.0	7.0	10	3	10.5	•	T160 1207
1405	MF14	x 1	100	22	-	11.0	9.0	12	3	13.0	•	T160 1405
1406	MF14	x 1.25	100	22	-	11.0	9.0	12	3	12.8	•	T160 1406
1407	MF14	x 1.5	100	22	-	11.0	9.0	12	3	12.5	•	•
1605	MF16	x 1	100	22	-	12.0	9.0	12	3	15.0	•	T160 1605
1607	MF16	x 1.5	100	22	-	12.0	9.0	12	3	14.5	•	•
1805	MF18	x 1	110	25	-	14.0	11.0	14	4	17.0	•	•
1807	MF18	x 1.5	110	25	-	14.0	11.0	14	4	16.5	•	T160 1807
1808	MF18	x 2	125	34	-	14.0	11.0	14	4	16.0	•	•
2005	MF20	x 1	125	25	-	16.0	12.0	15	4	19.0	•	T160 2005
2007	MF20	x 1.5	125	25	-	16.0	12.0	15	4	18.5	•	•
2008	MF20	x 2	140	34	-	16.0	12.0	15	4	18.0	•	•

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
T159	◐	◐	○	○		◐	○			○		○		◐	◐	○																																		
T160	◐	◐	○	○		◐	○			○		◐	○	◐	◐	◐							○	○	○	○	○	○		○			◐	◐	◐														

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

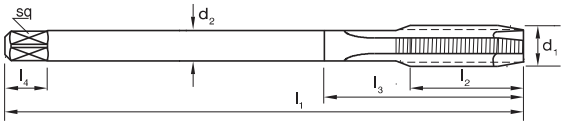
○ Optimal ◐ Effective

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

MF

suttontools

- Suitable for harder materials up to 42 HRC
- Through holes
- Suitable for machine operations
- Depths up to approx. 3 x d_1



Catalogue Code	T654	T163
Discount Group	D0402	D0410
Material	PM-HSSE V3	PM-HSSE V3
Surface Finish	Blu	TiAlN
Sutton Designation	NH	NH
Geometry		
Chamfer	Form B / 4.5 x P	Form B / 4.5 x P
Limit & Nut Tolerance	ISO2 / 6H	ISO2 / 6H

Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
0302	MF 3	x 0.35	56	8	-	2.2	-	-	3	2.65	•	T163 0302
0403	MF 4	x 0.5	63	10	-	2.8	2.1	5	3	3.5	•	T163 0403
0503	MF 5	x 0.5	70	12	-	3.5	2.7	6	3	4.5	•	T163 0503
0604	MF 6	x 0.75	80	14	-	4.5	3.4	6	3	5.3	•	T163 0604
0803	MF 8	x 0.5	80	18	-	6.0	4.9	8	3	7.5	•	T163 0803
0804	MF 8	x 0.75	80	18	-	6.0	4.9	8	3	7.3	•	T163 0804
0805	MF 8	x 1	90	22	-	6.0	4.9	8	3	7.0	T654 0805	T163 0805
1004	MF 10	x 0.75	90	20	-	7.0	5.5	8	3	9.3	•	T163 1004
1005	MF 10	x 1	90	20	-	7.0	5.5	8	3	9.0	T654 1005	T163 1005
1006	MF 10	x 1.25	100	24	-	7.0	5.5	8	3	8.8	•	T163 1006
1205	MF 12	x 1	100	22	-	9.0	7.0	10	3	11.0	•	T163 1205
1206	MF 12	x 1.25	100	22	-	9.0	7.0	10	3	10.8	T654 1206	T163 1206
1207	MF 12	x 1.5	100	22	-	9.0	7.0	10	3	10.5	•	T163 1207
1405	MF 14	x 1	100	22	-	11.0	9.0	12	3	13.0	•	T163 1405
1406	MF 14	x 1.25	100	22	-	11.0	9.0	12	3	12.8	•	T163 1406
1407	MF 14	x 1.5	100	22	-	11.0	9.0	12	3	12.5	•	T163 1407
1605	MF 16	x 1	100	22	-	12.0	9.0	12	3	15.0	•	T163 1605
1607	MF 16	x 1.5	100	22	-	12.0	9.0	12	3	14.5	•	T163 1607
1805	MF 18	x 1	110	25	-	14.0	11.0	14	4	17.0	•	T163 1805
1807	MF 18	x 1.5	110	25	-	14.0	11.0	14	4	16.5	•	T163 1807
1808	MF 18	x 2	125	34	-	14.0	11.0	14	4	16.0	•	T163 1808
2005	MF 20	x 1	125	25	-	16.0	12.0	15	4	19.0	•	T163 2005
2007	MF 20	x 1.5	125	25	-	16.0	12.0	15	4	18.5	•	T163 2007
2008	MF 20	x 2	140	34	-	16.0	12.0	15	4	18.0	•	T163 2008

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
T654			◐	◐	○		◐	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○																										○	
T163			◐	◐	◐		◐	◐	○	◐	○	○	○	○	○	◐	○	○	○	○	◐	○			○	○	○	◐	○	○															○				○	

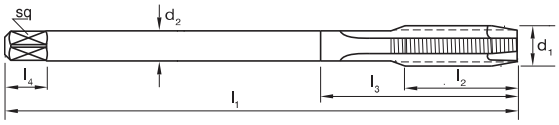
P Steel | M Stainless Steel | K Cast Iron | N Non-Ferrous Metals | S Titanium & Super Alloys | H Hard Materials

○ Optimal ◐ Effective

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

suttontools

- Suitable for harder materials up to 45 HRC
- Through holes
- Depths up to 1.5 x d_1



Catalogue Code	T710
Discount Group	D0408
Material	PM-HSS Co
Surface Finish	TiCN
Sutton Designation	H
Geometry	Low Relief
Chamfer	Form B / 4.5 x P
Limit & Nut Tolerance	6HX

Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #
0604	MF6	x0.75	80	14	-	4.5	3.4	6	3	5.3	•
0805	MF8	x1	90	22	-	6.0	4.9	8	3	7.0	•
1005	MF10	x1	90	20	-	7.0	5.5	8	3	9.0	•
1006	MF10	x1.25	100	24	-	7.0	5.5	8	3	8.8	•
1206	MF12	x1.25	100	22	-	9.0	7.0	10	3	10.8	•
1207	MF12	x1.5	100	22	-	9.0	7.0	10	3	10.5	•
1407	MF14	x1.5	100	22	-	11.0	9.0	12	3	12.5	•
1607	MF16	x1.5	100	22	-	12.0	9.0	12	3	14.5	•
1807	MF18	x1.5	110	25	-	14.0	11.0	14	4	16.5	•
2007	MF20	x1.5	125	25	-	16.0	12.0	15	4	18.5	•

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
T710					●			●	●		●	◐	●			◐	●	●	●	●	●	●					◐		●									◐	●	●	●	●	●	●				●		

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

● Optimal ◐ Effective

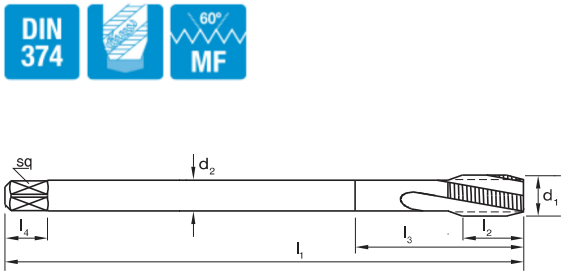
• Available on request as special manufacture. Subject to lead time.

MF

DIN Taps Metric Fine, Spiral Flute, R15 N

suttontools

- General purpose use, materials up to approx. 1000 N/mm²
- Blind holes
- Suitable for machine operations
- Depths up to approx. 1.5 x d_1



Catalogue Code	T243	T244
Discount Group	D0402	D0406
Material	HSSE	HSSE
Surface Finish	Brt	TiN
Sutton Designation	N	N
Geometry	R15	R15
Chamfer	Form C/ 2.5 x P	Form C/ 2.5 x P
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 #
0302	MF 3	x 0.35	56	8	-	2.2	-	-	3	2.65	T243 0302	•
0403	MF 4	x 0.5	63	10	-	2.8	2.1	5	3	3.5	T243 0403	T244 0403
0503	MF 5	x 0.5	70	12	-	3.5	2.7	6	3	4.5	T243 0503	T244 0503
0604	MF 6	x 0.75	80	14	-	4.5	3.4	6	3	5.3	T243 0604	T244 0604
0803	MF 8	x 0.5	80	18	-	6.0	4.9	8	3	7.5	T243 0803	T244 0803
0804	MF 8	x 0.75	80	18	-	7.0	4.9	8	3	7.3	T243 0804	T244 0804
0805	MF 8	x 1	90	22	-	6.0	4.9	8	3	7.0	T243 0805	T244 0805
1004	MF 10	x 0.75	90	20	-	7.0	5.5	8	3	9.3	T243 1004	T244 1004
1005	MF 10	x 1	90	20	-	7.0	5.5	8	3	9.0	T243 1005	T244 1005
1006	MF 10	x 1.25	100	24	-	7.0	5.5	8	3	8.8	T243 1006	T244 1006
1205	MF 12	x 1	100	22	-	9.0	7.0	10	3	11.0	T243 1205	T244 1205
1206	MF 12	x 1.25	100	22	-	9.0	7.0	10	3	10.8	T243 1206	T244 1206
1207	MF 12	x 1.5	100	22	-	9.0	7.0	10	3	10.5	T243 1207	T244 1207
1405	MF 14	x 1	100	22	-	11.0	9.0	12	3	13.0	T243 1405	T244 1405
1406	MF 14	x 1.25	100	22	-	11.0	9.0	12	3	12.8	T243 1406	T244 1406
1407	MF 14	x 1.5	100	22	-	11.0	9.0	12	3	12.5	T243 1407	T244 1407
1605	MF 16	x 1	100	22	-	12.0	9.0	12	3	15.0	T243 1605	T244 1605
1607	MF 16	x 1.5	100	22	-	12.0	9.0	12	3	14.5	T243 1607	T244 1607
1805	MF 18	x 1	110	25	-	14.0	11.0	14	4	17.0	T243 1805	T244 1805
1807	MF 18	x 1.5	110	25	-	14.0	11.0	14	4	16.5	T243 1807	T244 1807
1808	MF 18	x 2	125	34	-	14.0	11.0	14	4	16.0	T243 1808	T244 1808
2005	MF 20	x 1	125	25	-	16.0	12.0	15	4	19.0	T243 2005	T244 2005
2007	MF 20	x 1.5	125	25	-	16.0	12.0	15	4	18.5	T243 2007	T244 2007
2008	MF 20	x 2	140	34	-	16.0	12.0	15	4	18.0	T243 2008	•

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
T243	●	●	○	○		●	○			○							○		○		○	○	●	●	○	○		○	○																				
T244	●	●	●	●	○	●	●	○		●		○		○	○	○	○	○	○	○	○	○	●	●	○	○		○	○																				

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.

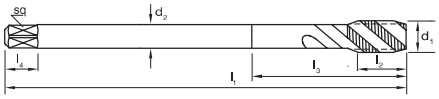
MF

DIN Taps Metric Fine, Spiral Flute, R40 N

suttontools

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

DIN 374 | 60° MF



Catalogue Code	T245	T246	T247	T248
Discount Group	D0402	D0402	D0402	D0406
Material	HSSE	HSSE	HSSE	HSSE
Surface Finish	Brt	Brt	Blu	TiN
Sutton Designation	N	N	N	N
Geometry	R40	R40	R40	R40
Chamfer	Form C/ 2.5 x P	Form C/ 2.5 x P	Form C/ 2.5 x P	Form C/ 2.5 x P
Limit & Nut Tolerance	ISO 2 / 6H	ISO 3 / 6G	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 #
0302	MF 3	x 0.35	56	4	-	2.2	-	-	3	2.65	•	•	•	•
0403	MF 4	x 0.5	63	6	-	2.8	2.1	5	3	3.5	•	•	•	•
0503	MF 5	x 0.5	70	7	-	3.5	2.7	6	3	4.5	•	•	•	•
0604	MF 6	x 0.75	80	8	-	4.5	3.4	6	3	5.3	T245 0604	T246 0604	T247 0604	T248 0604
0803	MF 8	x 0.5	80	10	-	6.0	4.9	8	3	7.5	•	•	•	•
0804	MF 8	x 0.75	80	10	-	6.0	4.9	8	3	7.3	•	•	•	•
0805	MF 8	x 1	90	8	-	6.0	4.9	8	3	7.0	T245 0805	T246 0805	T247 0805	T248 0805
1004	MF 10	x 0.75	90	10	-	7.0	5.5	8	3	9.3	•	•	•	•
1005	MF 10	x 1	90	10	-	7.0	5.5	8	3	9.0	T245 1005	T246 1005	T247 1005	T248 1005
1006	MF 10	x 1.25	100	13	-	7.0	5.5	8	3	8.8	T245 1006	T246 1006	T247 1006	T248 1006
1205	MF 12	x 1	100	14	-	9.0	7.0	10	3	11.0	•	T246 1205	•	•
1206	MF 12	x 1.25	100	14	-	9.0	7.0	10	3	10.8	T245 1206	T246 1206	T247 1206	T248 1206
1207	MF 12	x 1.5	100	14	-	9.0	7.0	10	3	10.5	T245 1207	•	T247 1207	T248 1207
1405	MF 14	x 1	100	16	-	11.0	9.0	12	3	13.0	•	•	•	•
1406	MF 14	x 1.25	100	16	-	11.0	9.0	12	3	12.8	•	•	•	•
1407	MF 14	x 1.5	100	16	-	11.0	9.0	12	3	12.5	T245 1407	T246 1407	T247 1407	T248 1407
1605	MF 16	x 1	100	16	-	12.0	9.0	12	3	14.5	•	•	•	•
1607	MF 16	x 1.5	100	16	-	12.0	9.0	12	3	14.5	T245 1607	•	T247 1607	T248 1607
1805	MF 18	x 1	110	20	-	14.0	11.0	14	4	17.0	•	•	•	•
1807	MF 18	x 1.5	110	20	-	14.0	11.0	14	4	16.5	T245 1807	•	T247 1807	T248 1807
1808	MF 18	x 2	125	20	-	14.0	11.0	14	4	16.0	•	•	•	•
2005	MF 20	x 1	125	20	-	16.0	12.0	15	4	19.0	•	•	•	•
2007	MF 20	x 1.5	125	20	-	16.0	12.0	15	4	18.5	T245 2007	•	T247 2007	T248 2007
2008	MF 20	x 2	140	20	-	16.0	12.0	15	4	18.0	•	•	•	•
2205	MF 22	x 1	125	15	-	18.0	14.5	17	4	18.5	T245 2205	•	•	•
2207	MF 22	x 1.5	125	15	-	18.0	14.5	17	4	20.5	T245 2207	•	•	•
2208	MF 22	x 2	140	20	-	18.0	14.5	17	4	20.0	T245 2208	•	•	•
2405	MF 24	x 1	140	20	-	18.0	14.5	17	4	23.0	T245 2405	•	•	•
2407	MF 24	x 1.5	140	20	-	18.0	14.5	17	4	22.5	T245 2407	•	•	•
2408	MF 24	x 2	140	20	-	18.0	14.5	17	4	22.0	T245 2408	•	•	•
2505	MF 25	x 1	140	15	-	18.0	14.5	17	4	24.0	•	•	•	•
2507	MF 25	x 1.5	140	15	-	18.0	14.5	17	4	23.5	T245 2507	•	•	•
2508	MF 25	x 2	140	15	-	18.0	14.5	17	4	23.0	•	•	•	•
2605	MF 26	x 1	140	15	-	18.0	14.5	17	4	25.0	•	•	•	•
2607	MF 26	x 1.5	140	15	-	18.0	14.5	17	4	24.5	T245 2607	•	•	•
2608	MF 26	x 2	140	15	-	18.0	14.5	17	4	24.0	•	•	•	•
2707	MF 27	x 1.5	140	20	-	20.0	16.0	19	4	25.5	T245 2707	•	•	•
2708	MF 27	x 2	140	20	-	20.0	16.0	19	4	25.0	T245 2708	•	•	•
2807	MF 28	x 1.5	140	15	-	20.0	16.0	19	4	26.5	T245 2807	•	•	•
2808	MF 28	x 2	140	15	-	20.0	16.0	19	4	26.0	•	•	•	•
3005	MF 30	x 1	150	20	-	22.0	18.0	21	4	29.0	T245 3005	•	•	•
3007	MF 30	x 1.5	150	20	-	22.0	18.0	21	4	28.5	T245 3007	•	•	•
3008	MF 30	x 2	150	20	-	22.0	18.0	21	4	28.0	T245 3008	•	•	•

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
T245	●	●	○	○		●	○			○							○		○		○	○	●	●	○	○		○	○																							
T246	●	●	○	○		●	○			○							○		○		○	○	●	●	○	○		○	○																							
T247	●	●	●	●		●	●			●		○		○	○	○	○		○		○	○																													
T248	●	●	●	●	○	●	●	○		●		○		○	○	○	○	○	○	○	○	○	●	●	○	○		●	○																							

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.

MF

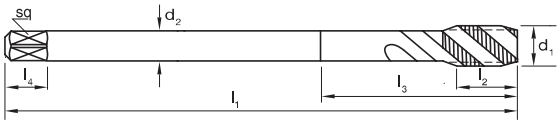
DIN Taps Metric Fine, Spiral Flute, R50 Black Magic

suttontools BLACKMAGIC

watch the video

- Universal high performance tapping
- PM-HSSE V3 offers superior tool life
- Use in stainless steels and high strength steels up to 850N/mm²
- Blind holes up to 3 x d_1
- Suitable for synchronous tapping in machine operations

DIN 374 | 60° MF | Z | HSC



Product Name	T686
Discount Group	D0410
Material	PM-HSSE V3
Surface Finish	HARDLUBE
Sutton Designation	UNI
Geometry	R50
Chamfer	Form C/ 2.5 x P
Limit & Nut Tolerance	6HX

Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #
0302	MF 3	x 0.35	56	4	-	2.2	-	-	3	2.65	•
0403	MF 4	x 0.5	63	6	-	2.8	2.1	5	3	3.5	•
0503	MF 5	x 0.5	70	7	-	3.5	2.7	6	3	4.5	•
0604	MF 6	x 0.75	80	8	-	4.5	3.4	6	3	5.3	T686 0604
0803	MF 8	x 0.5	80	10	-	6.0	4.9	8	3	7.5	T686 0803
0804	MF 8	x 0.75	80	10	-	7.0	4.9	8	3	7.3	•
0805	MF 8	x 1	90	8	-	6.0	4.9	8	3	7.0	T686 0805
1004	MF 10	x 0.75	90	10	-	7.0	5.5	8	3	9.3	T686 1004
1005	MF 10	x 1	90	10	-	7.0	5.5	8	3	9.0	T686 1005
1006	MF 10	x 1.25	100	13	-	7.0	5.5	8	3	8.8	T686 1006
1205	MF 12	x 1	100	14	-	9.0	7.0	10	3	11.0	T686 1205
1206	MF 12	x 1.25	100	14	-	9.0	7.0	10	3	10.8	T686 1206
1207	MF 12	x 1.5	100	14	-	9.0	7.0	10	3	10.5	T686 1207
1405	MF 14	x 1	100	16	-	11.0	9.0	12	3	13.0	T686 1405
1406	MF 14	x 1.25	100	16	-	11.0	9.0	12	3	12.8	T686 1406
1407	MF 14	x 1.5	100	16	-	11.0	9.0	12	3	12.5	T686 1407
1605	MF 16	x 1	100	16	-	12.0	9.0	12	3	15.0	T686 1605
1607	MF 16	x 1.5	100	16	-	12.0	9.0	12	3	14.5	T686 1607
1805	MF 18	x 1	110	20	-	14.0	11.0	14	4	17.0	T686 1805
1807	MF 18	x 1.5	110	20	-	14.0	11.0	14	4	16.5	•
1808	MF 18	x 2	125	20	-	14.0	11.0	14	4	16.0	•
2005	MF 20	x 1	125	20	-	16.0	12.0	15	4	19.0	T686 2005
2007	MF 20	x 1.5	125	20	-	16.0	12.0	15	4	18.5	T686 2007
2008	MF 20	x 2	140	20	-	16.0	12.0	15	4	18.0	•

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
T686	●	●	●	○		●	○			●		●	○	●	●		○	○	○	○	○	○	●	●	●	○	○	○	○																				

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

● Optimal ○ Effective

MF

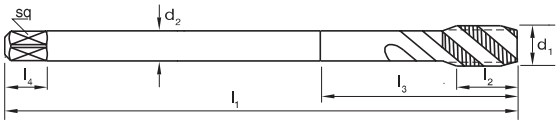
• Available on request as special manufacture. Subject to lead time.

DIN Taps Metric Fine, Spiral Flute, R45 Al

suttontools

- Suitable for use in wrought aluminium and low silicon aluminium
- Blind holes
- Depths up to approx. 3 x d_1
- CrN for longer tool life

DIN 374 | 60° MF



Catalogue Code	T703
Discount Group	D0404
Material	HSSE
Surface Finish	CrN
Sutton Designation	Al
Geometry	R45 2 Flute
Chamfer	Form C/ 2.5 x P
Limit & Nut Tolerance	ISO 2 / 6H

Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #
0805	MF 8	x 1	90	8	-	6.0	4.9	8	2	7.0	•
1005	MF 10	x 1	90	10	-	7.0	5.5	8	2	9.0	•
1006	MF 10	x 1.25	100	13	-	7.0	5.5	8	2	8.8	•
1205	MF 12	x 1	100	14	-	9.0	7.0	10	2	11.0	•
1206	MF 12	x 1.25	100	14	-	9.0	7.0	10	2	10.8	•
1207	MF 12	x 1.5	100	14	-	9.0	7.0	10	2	10.5	•

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
T703																							●	●	●	●		●		●																					

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

● Optimal ◐ Effective

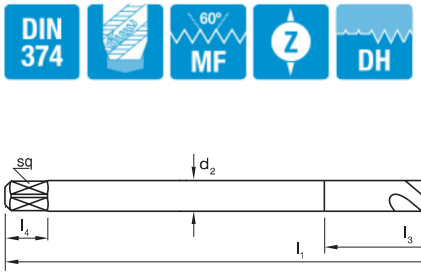
• Available on request as special manufacture. Subject to lead time.

MF

DIN Taps Metric Fine, Spiral Flute, R45 VA DH

suttontools

- Use in stainless steels and high strength steels up to 1000N/mm²
- Blind holes
- Suitable for synchronous tapping in machine operations
- Depths up to approx. 3 x d_1



Catalogue Code	T249	T251
Discount Group	D0402	D0408
Material	HSSE	HSSE
Surface Finish	Blu	TiCN
Sutton Designation	VA DH	VA DH
Geometry	R45	R45
Chamfer	Form C/ 2.5 x P	Form C/ 2.5 x P
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 #
0302	MF 3	x 0.35	56	4	-	2.2	-	-	3	2.65	•	•
0403	MF 4	x 0.5	63	6	-	2.8	2.1	5	3	3.5	•	•
0503	MF 5	x 0.5	70	7	-	3.5	2.7	6	3	4.5	•	•
0604	MF 6	x 0.75	80	8	-	4.5	3.4	6	3	5.3	T249 0604	T251 0604
0803	MF 8	x 0.5	80	10	-	6.0	4.9	8	3	7.5	•	•
0804	MF 8	x 0.75	80	10	-	7.0	4.9	8	3	7.3	•	•
0805	MF 8	x 1	90	8	-	6.0	4.9	8	3	7.0	T249 0805	T251 0805
1004	MF 10	x 0.75	90	10	-	7.0	5.5	8	3	9.3	•	•
1005	MF 10	x 1	90	10	-	7.0	5.5	8	3	9.0	T249 1005	T251 1005
1006	MF 10	x 1.25	100	13	-	7.0	5.5	8	3	8.8	T249 1006	T251 1006
1205	MF 12	x 1	100	14	-	9.0	7.0	10	3	11.0	T249 1205	T251 1205
1206	MF 12	x 1.25	100	14	-	9.0	7.0	10	3	10.8	T249 1206	T251 1206
1207	MF 12	x 1.5	100	14	-	9.0	7.0	10	3	10.5	•	•
1405	MF 14	x 1	100	16	-	11.0	9.0	12	3	13.0	•	•
1406	MF 14	x 1.25	100	16	-	11.0	9.0	12	3	12.8	•	•
1407	MF 14	x 1.5	100	16	-	11.0	9.0	12	3	12.5	T249 1407	T251 1407
1605	MF 16	x 1	100	16	-	12.0	9.0	12	3	15.0	•	•
1607	MF 16	x 1.5	100	16	-	12.0	9.0	12	3	14.5	•	•
1805	MF 18	x 1	110	20	-	14.0	11.0	14	4	17.0	•	•
1807	MF 18	x 1.5	110	20	-	14.0	11.0	14	4	16.5	•	•
1808	MF 18	x 2	125	20	-	14.0	11.0	14	4	16.0	•	•
2005	MF 20	x 1	125	20	-	16.0	12.0	15	4	19.0	•	•
2007	MF 20	x 1.5	125	20	-	16.0	12.0	15	4	18.5	•	•
2008	MF 20	x 2	140	20	-	16.0	12.0	15	4	18.0	•	•

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
T249	◐	◐	○			○	○					○		◐	◐	○																																	
T251	◐	◐	○	○		○	○	○		○		◐		◐	◐	◐							○	○	○	○		○		○			◐		○														

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.

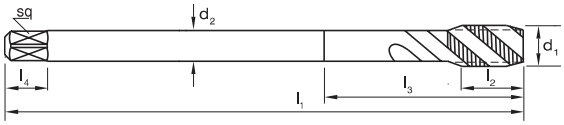
MF

DIN Taps Metric Fine, Spiral Flute, R50 VA PM

suttontools

- Use in stainless steels and high strength steels up to 1000N/mm²
- PM-HSSE V3 offers higher edge hardness than standard VA series
- Blind holes
- Suitable for synchronous tapping in machine operations
- Depths up to approx. 3 x d_1

DIN 374 | 60° MF | Z | HSC



Catalogue Code	T250	T252
Discount Group	D0402	D0408
Material	PM-HSSE V3	PM-HSSE V3
Surface Finish	Blu	TiCN
Sutton Designation	VA PM	VA PM
Geometry	R50	R50
Chamfer	Form C/ 2.5 x P	Form C/ 2.5 x P
Limit & Nut Tolerance	6HX	6HX

Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
0302	MF3	x 0.35	56	4	-	2.2	-	-	3	2.65	T250 0302	•
0403	MF4	x 0.5	63	6	-	2.8	2.1	5	3	3.5	T250 0403	•
0503	MF5	x 0.5	70	7	-	3.5	2.7	6	3	4.5	T250 0503	•
0604	MF6	x 0.75	80	8	-	4.5	3.4	6	3	5.3	T250 0604	T252 0604
0803	MF8	x 0.5	80	10	-	6.0	4.9	8	3	7.5	T250 0803	T252 0803
0804	MF8	x 0.75	80	10	-	7.0	4.9	8	3	7.3	•	•
0805	MF8	x 1	90	8	-	6.0	4.9	8	3	7.0	T250 0805	T252 0805
1004	MF10	x 0.75	90	10	-	7.0	5.5	8	3	9.3	T250 1004	T252 1004
1005	MF10	x 1	90	10	-	7.0	5.5	8	3	9.0	T250 1005	T252 1005
1006	MF10	x 1.25	100	13	-	7.0	5.5	8	3	8.8	T250 1006	T252 1006
1205	MF12	x 1	100	14	-	9.0	7.0	10	3	11.0	T250 1205	T252 1205
1206	MF12	x 1.25	100	14	-	9.0	7.0	10	3	10.8	T250 1206	T252 1206
1207	MF12	x 1.5	100	14	-	9.0	7.0	10	3	10.5	T250 1207	T252 1207
1405	MF14	x 1	100	16	-	11.0	9.0	12	3	13.0	T250 1405	T252 1405
1406	MF14	x 1.25	100	16	-	11.0	9.0	12	3	12.8	T250 1406	T252 1406
1407	MF14	x 1.5	100	16	-	11.0	9.0	12	3	12.5	T250 1407	T252 1407
1605	MF16	x 1	100	16	-	12.0	9.0	12	3	15.0	T250 1605	T252 1605
1607	MF16	x 1.5	100	16	-	12.0	9.0	12	3	14.5	T250 1607	T252 1607
1805	MF18	x 1	110	20	-	14.0	11.0	14	4	17.0	•	T252 1805
1807	MF18	x 1.5	110	20	-	14.0	11.0	14	4	16.5	T250 1807	T252 1807
1808	MF18	x 2	125	20	-	14.0	11.0	14	4	16.0		
2005	MF20	x 1	125	20	-	16.0	12.0	15	4	19.0	•	T252 2005
2007	MF20	x 1.5	125	20	-	16.0	12.0	15	4	18.5	T250 2007	T252 2007
2008	MF20	x 2	140	20	-	16.0	12.0	15	4	18.0	•	•

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
T250	◐	◐	◐			◐	◑					◑		◐	◐	◑																																		
T252	◐	◐	◐	◑		◐	◑	◑		◑		◐		◐	◐	◐							◑	◑	◑	◑	◑	◑		◑			◐		◐														

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

◑ Optimal ◐ Effective

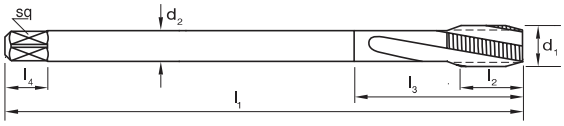
• Available on request as special manufacture. Subject to lead time.

MF

DIN Taps Metric Fine, Spiral Flute, R40 NH

suttontools

- Suitable for harder materials up to 42 HRC
- Blind holes
- Suitable for machine operations
- Depths up to approx. 2.5 x d_1



Catalogue Code	T655	T254
Discount Group	D0402	D0410
Material	PM-HSSE V3	PM-HSSE V3
Surface Finish	Blu	TiAlN
Sutton Designation	NH	NH
Geometry	R40	R40
Chamfer	Form C/ 2.5 x P	Form C/ 2.5 x P
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 #
0302	MF 3	x 0.35	56	4	-	2.2	-	-	3	2.65	•	T254 0302
0403	MF 4	x 0.5	63	6	-	2.8	2.1	5	3	3.5	•	T254 0403
0503	MF 5	x 0.5	70	7	-	3.5	2.7	6	3	4.5	•	T254 0503
0604	MF 6	x 0.75	80	8	-	4.5	3.4	6	3	5.3	T655 0604	T254 0604
0803	MF 8	x 0.5	80	10	-	6.0	4.9	8	3	7.5	•	T254 0803
0804	MF 8	x 0.75	80	10	-	7.0	4.9	8	3	7.3	•	T254 0804
0805	MF 8	x 1	90	8	-	6.0	4.9	8	3	7.0	•	T254 0805
1004	MF 10	x 0.75	90	10	-	7.0	5.5	8	3	9.3	T655 1004	T254 1004
1005	MF 10	x 1	90	10	-	7.0	5.5	8	3	9.0	•	T254 1005
1006	MF 10	x 1.25	100	13	-	7.0	5.5	8	3	8.8	•	T254 1006
1205	MF 12	x 1	100	14	-	9.0	7.0	10	3	11.0	•	T254 1205
1206	MF 12	x 1.25	100	14	-	9.0	7.0	10	3	10.8	•	T254 1206
1207	MF 12	x 1.5	100	14	-	9.0	7.0	10	3	10.5	•	T254 1207
1405	MF 14	x 1	100	16	-	11.0	9.0	12	3	13.0	•	T254 1405
1406	MF 14	x 1.25	100	16	-	11.0	9.0	12	3	12.8	•	T254 1406
1407	MF 14	x 1.5	100	16	-	11.0	9.0	12	3	12.5	•	T254 1407
1605	MF 16	x 1	100	16	-	12.0	9.0	12	3	15.0	•	T254 1605
1607	MF 16	x 1.5	100	16	-	12.0	9.0	12	3	14.5	•	T254 1607
1805	MF 18	x 1	110	20	-	14.0	11.0	14	4	17.0	•	T254 1805
1807	MF 18	x 1.5	110	20	-	14.0	11.0	14	4	16.5	•	T254 1807
1808	MF 18	x 2	125	20	-	14.0	11.0	14	4	16.0	•	T254 1808
2005	MF 20	x 1	125	20	-	16.0	12.0	15	4	19.0	•	T254 2005
2007	MF 20	x 1.5	125	20	-	16.0	12.0	15	4	18.5	•	T254 2007
2008	MF 20	x 2	140	20	-	16.0	12.0	15	4	18.0	•	T254 2008

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
T655			◐	◐	○		◐	○		○		○		○	○	○	○	○	○	○	○	○																										○	
T254			◐	◐	◐		◐	◐	○	◐	○	○	○	○	○	◐	○	○	○	○	○	○	○	○	○	○	◐	○	○	○																		○	

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

○ Optimal ◐ Effective

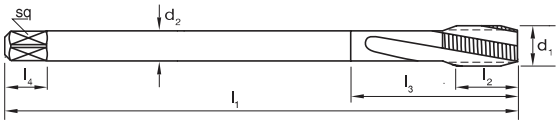
• Available on request as special manufacture. Subject to lead time.

MF

DIN Taps Metric Fine, Spiral Flute, R15 H

suttontools

- Suitable for harder materials up to 45 HRC
- Blind holes
- Depths up to 1.5 x d_1



Catalogue Code	T707
Discount Group	D0408
Material	PM-HSS Co
Surface Finish	TiCN
Sutton Designation	H
Geometry	R15
Chamfer	Form C/ 3 x P
Limit & Nut Tolerance	ISO 2 / 6HX

Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #
0604	MF6	x 0.75	80	8	-	4.5	3.4	6	3	5.3	•
0805	MF8	x 1	90	8	-	6.0	4.9	8	3	7.0	•
1005	MF10	x 1	90	10	-	7.0	5.5	8	3	9.0	•
1006	MF10	x 1.25	100	13	-	7.0	5.5	8	3	8.8	•
1205	MF12	x 1	100	14	-	9.0	7.0	10	3	11.0	•
1206	MF12	x 1.25	100	14	-	9.0	7.0	10	3	10.8	•
1207	MF12	x 1.5	100	14	-	9.0	7.0	10	3	10.5	•
1407	MF14	x 1.5	100	16	-	11.0	9.0	12	3	12.5	•
1607	MF16	x 1.5	100	16	-	12.0	9.0	12	3	14.5	•
1807	MF18	x 1.5	110	20	-	14.0	11.0	14	4	16.5	•
2007	MF20	x 1.5	125	20	-	16.0	12.0	15	4	18.5	•

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
T707					●			●	●		●	◐	●			◐	●	●	●	●	●	●					◐		●									◐	●	●	●	●	●					●	

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

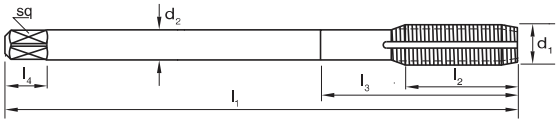
● Optimal ◐ Effective

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

MJ

suttontools

- Suitable for materials with >10%elongation
- Through or blind holes
- Depths up to 3 x d_1



Catalogue Code	T773
Discount Group	D0408
Material	HSSE
Surface Finish	TiCN
Sutton Designation	N
Geometry	Multi Coolant Groove
Chamfer	Form C/ 2.5 x P
Limit & Nut Tolerance	6HX

Size Ref.	d_1	Pitch	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #
0503	MF 5	x 0.5	70	12	-	3.5	2.7	6		4.75	T773 0503
0604	MF 6	x 0.75	80	14	-	4.5	3.4	6		5.65	T773 0604
0804	MF 8	x 0.75	80	18	-	6.0	4.9	8		7.65	T773 0804
0805	MF 8	x 1	90	22	-	6.0	4.9	8		7.55	T773 0805
1005	MF 10	x 1	90	20	-	7.0	5.5	8		9.55	T773 1005
1006	MF 10	x 1.25	100	24	-	7.0	5.5	8		9.40	T773 1006
1205	MF 12	x 1	100	22	-	9.0	7.0	10		11.55	T773 1205
1206	MF 12	x 1.25	100	22	-	9.0	7.0	10		11.40	T773 1206
1207	MF 12	x 1.5	100	22	-	9.0	7.0	10		11.30	T773 1207
1405	MF 14	x 1	100	22	-	11.0	9.0	12		13.55	T773 1405
1406	MF 14	x 1.25	100	22	-	11.0	9.0	12		13.40	T773 1406
1407	MF 14	x 1.5	100	22	-	11.0	9.0	12		13.30	T773 1407
1605	MF 16	x 1	100	22	-	12.0	9.0	12		15.55	T773 1605
1607	MF 16	x 1.5	100	22	-	12.0	9.0	12		15.30	T773 1607
1807	MF 18	x 1.5	110	25	-	14.0	11.0	14		17.30	T773 1807
2007	MF 20	x 1.5	125	25	-	16.0	12.0	15		19.30	T773 2007

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
T773	●	●	●	●		●								●									●	●	●	●		●		●																			

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.

MF

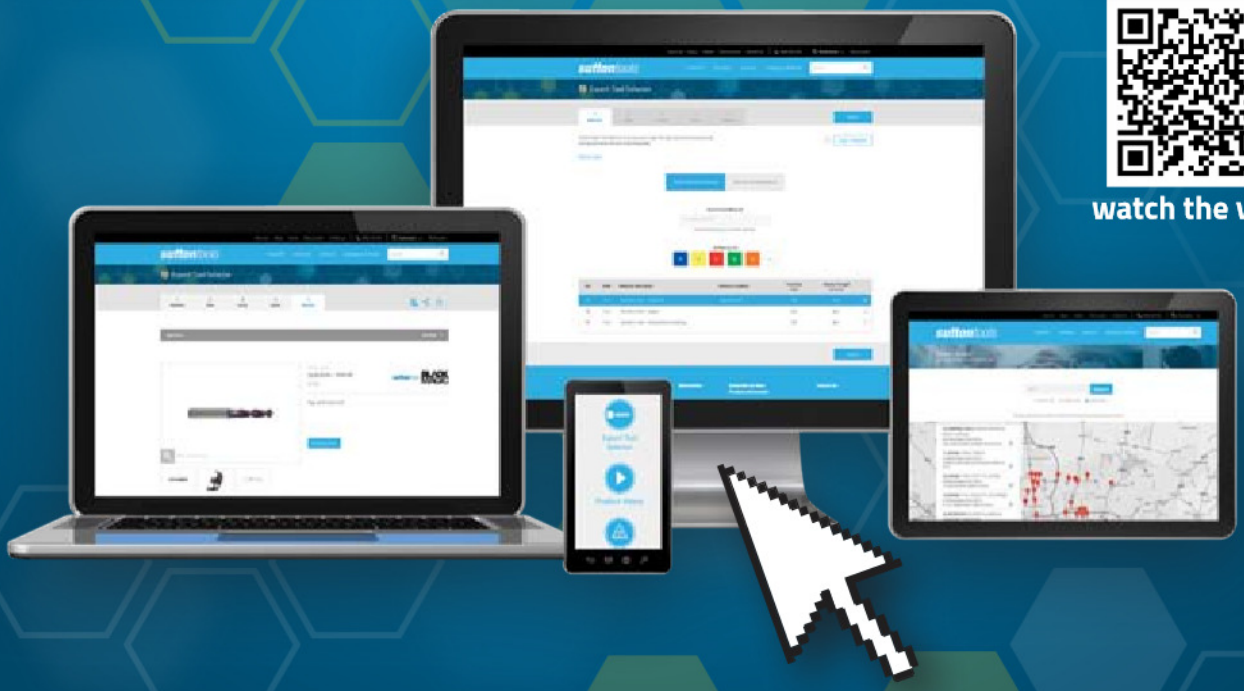
suttontools
world class cutting tools

Expert Tool Selector

Sutton Tools Expert Tool Selector enables easy tool selection for your machining task. The Expert Tool Selector will recommend the right tool for your application, with advice on suitable cutting parameters. Simply select your work piece material, and enter your machining operation and setup to get the best advice in 5 easy steps:

1	2	3	4	5
Material	Task	Setup	Select	Results

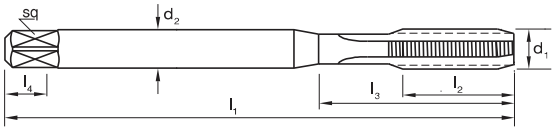
watch the video



suttontools.com/expert-tool-selector

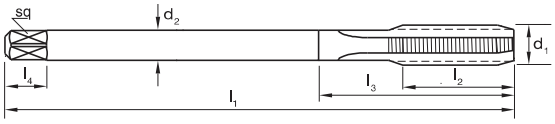
suttontools

- Use in grey cast iron (GG), brittle plastics, hard bronzes to a hardness of 850 N/mm²
- Through & blind holes
- Suitable for machine operations
- Depths up to approx. 3 x d_1



Catalogue Code	T302	T303
Discount Group	D0402	D0408
Material	HSSE	HSSE
Surface Finish	Ni + Blu	TiCN
Sutton Designation	GG	GG
Geometry	Low Relief	Low Relief
Chamfer	Form C/ 2.5 x P	Form C/ 2.5 x P
Limit & Nut Tolerance	2BX	2BX

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
0218	#2	56	45	9	10	2.8	2.1	5	4	1.85	•	•
0251	#3	48	50	9	10	2.8	2.1	5	4	2.1	•	•
0284	# 4	40	56	11	18	3.5	2.7	6	4	2.3	•	•
0318	# 5	40	56	11	18	3.5	2.7	6	4	2.6	•	•
0351	# 6	32	56	13	19	4.0	3.0	6	4	2.8	•	•
0417	# 8	32	63	13	19	4.5	3.4	6	4	3.4	•	•
0483	# 10	24	70	16	20	6.0	4.9	8	4	3.8	•	•
0549	# 12	24	80	19	29	6.0	4.9	8	4	4.5	•	•
0635	1/4	20	80	19	30	7.0	5.5	8	4	5.1	T302 0635	•
0794	5/16	18	90	22	34	8.0	6.2	9	4	6.6	T302 0794	•
0953	3/8	16	100	22	35	10.0	7.0	10	4	8.0	T302 0953	•



Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
1111	7/16	14	100	24	-	8.0	6.2	8	4	9.4	•	•
1270	1/2	13	110	28	-	9.0	7.0	10	4	10.8	T302 1270	•
1429	9/16	12	110	30	-	11.0	9.0	12	4	12.2	•	•
1588	5/8	11	110	32	-	12.0	9.0	12	4	13.5	T302 1588	•
1905	3/4	10	125	34	-	14.0	11.0	14	4	16.5	T302 1905	•
2223	7/8	9	140	34	-	18.0	14.5	17	4	19.5	•	•
2540	1	8	160	38	-	18.0	14.5	17	4	22.2	T302 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
T302																	◐	◐	◐	◐	○	○																										
T303																	◐	◐	◐	◐	○	○					○																					

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

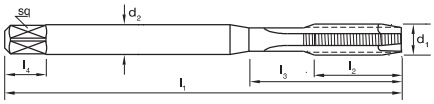
● Optimal ◐ Effective

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

suttontools

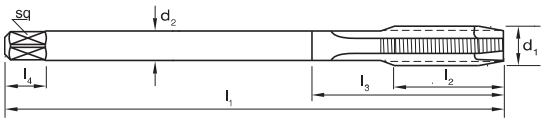
- General purpose use, materials up to approx. 1000 N/mm²
- Through holes
- Suitable for machine operations
- Depths up to approx. 3 x d_1

DIN 2184-1 | 60° UNC



Catalogue Code	T164	T165	T166	T167
Discount Group	D0402	D0402	D0402	D0406
Material	HSSE	HSSE	HSSE	HSSE
Surface Finish	Brt	Brt	Blu	TiN
Sutton Designation	N	N	N	N
Geometry				
Chamfer	Form B / 4.5 x P	Form B / 4.5 x P	Form B / 4.5 x P	Form B / 4.5 x P
Limit & Nut Tolerance	2B	3B	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 #
0218	# 2	56	45	9	10	2.8	2.1	5	2	1.85	T164 0218	•	T166 0218	T167 0218
0251	# 3	48	50	9	10	2.8	2.1	5	2	2.1	T164 0251	•	T166 0251	T167 0251
0284	# 4	40	56	11	18	3.5	2.7	6	2	2.3	T164 0284	•	T166 0284	T167 0284
0318	# 5	40	56	11	18	3.5	2.7	6	3	2.6	T164 0318	•	T166 0318	T167 0318
0351	# 6	32	56	13	19	4.0	3.0	6	3	2.8	T164 0351	•	T166 0351	T167 0351
0417	# 8	32	63	13	19	4.5	3.4	6	3	3.4	T164 0417	•	T166 0417	T167 0417
0483	# 10	24	70	16	20	6.0	4.9	8	3	3.8	T164 0483	•	T166 0483	T167 0483
0549	# 12	24	80	19	29	6.0	4.9	8	3	4.5	T164 0549	•	T166 0549	T167 0549
0635	1/4	20	80	19	30	7.0	5.5	8	3	5.1	T164 0635	•	T166 0635	T167 0635
0794	5/16	18	90	22	34	8.0	6.2	9	3	6.6	T164 0794	•	T166 0794	T167 0794
0953	3/8	16	100	22	35	10.0	7.0	10	3	8.0	T164 0953	•	T166 0953	T167 0953



Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #	Item #	Item #
1111	7/16	14	100	24	-	8.0	6.2	8	3	9.4	T164 1111	•	T166 1111	T167 1111
1270	1/2	13	110	28	-	9.0	7.0	10	3	10.8	T164 1270	•	T166 1270	T167 1270
1429	9/16	12	110	30	-	11.0	9.0	12	3	12.2	T164 1429	•	T166 1429	T167 1429
1588	5/8	11	110	32	-	12.0	9.0	12	3	13.5	T164 1588	•	T166 1588	T167 1588
1905	3/4	10	125	34	-	14.0	11.0	14	4	16.5	T164 1905	•	T166 1905	T167 1905
2223	7/8	9	140	34	-	18.0	14.5	17	4	19.5	T164 2223	•	T166 2223	T167 2223
2540	1	8	160	38	-	18.0	14.5	17	4	22.2	T164 2540	•	T166 2540	T167 2540

ISO	P													M			K																																					
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
T164	●	●	○	○		●	○			○							○		○		○	○	●	●	○	○		○	○																					
T165	●	●	○	○		●	○			○							○		○		○	○	●	●	○	○		○	○																					
T166	●	●	●	●		●	●			●		○		○	○	○	○		○		○	○																													
T167	●	●	●	●	○	●	●	○		●		○		○	○	○	○	○	○	○	○	○	●	●	○	○		●	○																					

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

● Optimal ◐ Effective

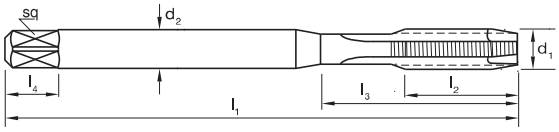
• Available on request as special manufacture. Subject to lead time.

suttontools BLACKMAGIC

watch the video

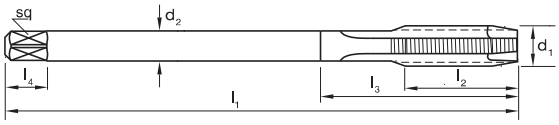
- Universal high performance tapping
- PM-HSSE V3 offers superior tool life
- Use in stainless steels and high strength steels up to 850N/mm²
- Through holes up to 3 x d_1
- Suitable for synchronous tapping in machine operations

DIN 2184-1 | 60° UNC | Z



Catalogue Code	T693
Discount Group	D0410
Material	PM-HSSE V3
Surface Finish	HARDLUBE
Sutton Designation	UNI
Geometry	Special Relief
Chamfer	Form B / 4.5 x P
Limit & Nut Tolerance	2BX

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #
0218	# 2	56	45	9	12	2.8	2.1	5	3	1.85	T693 0218
0284	# 4	40	56	11	18	3.5	2.1	5	3	2.35	T693 0284
0351	# 6	32	56	12	20	4	2.7	6	3	2.85	T693 0351
0417	# 8	32	63	13	21	4.5	2.7	6	3	3.50	T693 0417
0483	# 10	24	70	16	25	6	3.0	6	3	3.90	T693 0483
0635	1/4	20	80	19	30	7	5.5	8	3	5.10	T693 0635



Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #
0794	5/16	18	90	22	35	6	4.9	8	3	6.60	T693 0794
0953	3/8	16	100	24	39	7	5.5	8	3	8.00	T693 0953
1270	1/2	13	110	28	-	9	7	10	4	10.80	T693 1270
1588	5/8	11	110	32	-	12	9	12	4	13.50	T693 1588

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
T693	●	●	●	○		●	○			●		●	○	●	●		○	○	○	○	○	○	●	●	●	○	○	○	○	○																		

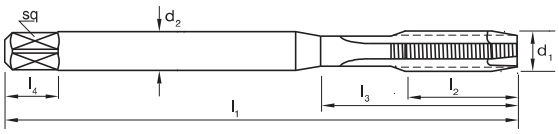
P Steel | M Stainless Steel | K Cast Iron | N Non-Ferrous Metals | S Titanium & Super Alloys | H Hard Materials

● Optimal ○ Effective

suttontools

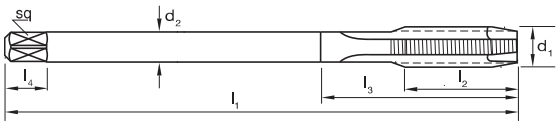
- Use in stainless steels and high strength steels up to 1000N/mm²
- Through holes
- Suitable for machine operations
- Depths up to approx. 3 x d_1

DIN 2184-1 | 60° UNC



Catalogue Code	T170	T171
Discount Group	D0402	D0408
Material	HSSE	HSSE
Surface Finish	Blu	TiCN
Sutton Designation	VA	VA
Geometry	Special Relief	Special Relief
Chamfer	Form B / 4.5 x P	Form B / 4.5 x P
Limit & Nut Tolerance	2B	2B

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
0218	# 2	56	45	9	10	2.8	2.1	5	2	1.85	•	•
0251	# 3	48	50	9	10	2.8	2.1	5	2	2.1	•	•
0284	# 4	40	56	11	18	3.5	2.7	6	2	2.3	•	•
0318	# 5	40	56	11	18	3.5	2.7	6	3	2.6	•	•
0351	# 6	32	56	13	19	4.0	3.0	6	3	2.8	T170 0351	T171 0351
0417	# 8	32	63	13	19	4.5	3.4	6	3	3.4	T170 0417	T171 0417
0483	# 10	24	70	16	20	6.0	4.9	8	3	3.8	T170 0483	T171 0483
0549	# 12	24	80	19	29	6.0	4.9	8	3	4.5	•	•
0635	1/4	20	80	19	30	7.0	5.5	8	3	5.1	T170 0635	T171 0635
0794	5/16	18	90	22	34	8.0	6.2	9	3	6.6	T170 0794	T171 0794
0953	3/8	16	100	22	35	10.0	7.0	10	3	8.0	T170 0953	T171 0953



Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
1111	7/16	14	100	24	-	8.0	6.2	8	3	9.4	T170 1111	T171 1111
1270	1/2	13	110	28	-	9.0	7.0	10	3	10.8	T170 1270	T171 1270
1429	9/16	12	110	30	-	11.0	9.0	12	3	12.2	T170 1429	T171 1429
1588	5/8	11	110	32	-	12.0	9.0	12	3	13.5	T170 1588	T171 1588
1905	3/4	10	125	34	-	14.0.	11.0	14	4	16.5	T170 1905	T171 1905
2223	7/8	9	140	34	-	18.0	14.5	17	4	19.5	T170 2223	T171 2223
2540	1	8	160	38	-	18.0	14.5	17	4	22.2	T170 2540	T171 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
T170	◐	◐	●	●		◐	●					●		◐	◐	●																																		
T171	◐	◐	●	●		◐	●			●		◐	◐	◐	◐	◐							●	●	●	●	●	●		●			◐	●	◐														

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

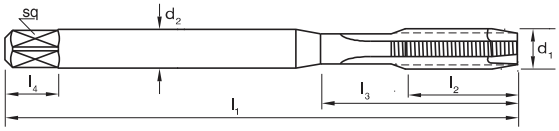
● Optimal ◐ Effective

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

UNC

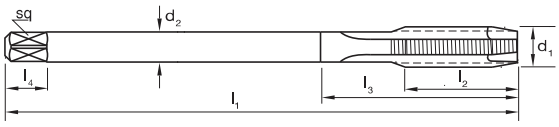
suttontools

- PM-HSSE V3 offers superior tool life
- Use in stainless steels and high strength steels up to 850N/mm²
- Through holes up to 3 x d_1



Catalogue Code	T697
Discount Group	D0408
Material	PM-HSSE V3
Surface Finish	TiCN
Sutton Designation	VA PM
Geometry	Special Relief
Chamfer	Form B / 4.5 x P
Limit & Nut Tolerance	2BX

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #
0218	# 2	56	45	9	12	2.8	2.1	5	3	1.85	T697 0218
0284	# 4	40	56	11	18	3.5	2.7	6	3	2.35	T697 0284
0351	# 6	32	56	12	20	4	3.0	6	3	2.85	T697 0351
0417	# 8	32	63	13	21	4.5	3.4	6	3	3.50	T697 0417
0483	# 10	24	70	16	25	6	4.9	8	3	3.90	T697 0483
0635	1/4	20	80	19	30	7	5.5	8	3	5.10	T697 0635



Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #
0794	5/16	18	90	22	-	6	4.9	8	3	6.60	T697 0794
0953	3/8	16	100	24	-	7	5.5	8	3	8.00	T697 0953
1270	1/2	13	110	28	-	9	7	10	4	10.80	T697 1270
1588	5/8	11	110	32	-	12	9	12	4	13.50	T697 1588

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
T697	●	●	○	○		●	○			○		●	○	●	●	●							○	○	○	○	○	○		○			●	●	●													

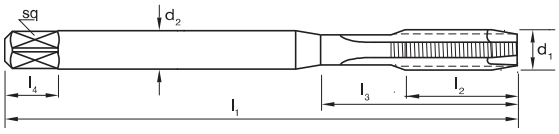
P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials

● Optimal ○ Effective

suttontools

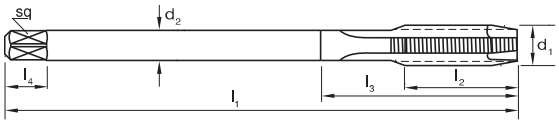
- Use in harder short chipping materials up to 42 HRC
- Through holes
- Suitable for machine operations
- Depths up to approx. 3 x d_1

DIN 2184-1 | 60° UNC



Catalogue Code	T168	T169
Discount Group	D0402	D0410
Material	PM-HSSE V3	PM-HSSE V3
Surface Finish	Blu	TiAlN
Sutton Designation	NH	NH
Geometry		
Chamfer	Form B / 4.5 x P	Form B / 4.5 x P
Limit & Nut Tolerance	2B	2B

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
0218	# 2	56	45	9	10	2.8	2.1	5	2	1.85	•	•
0251	# 3	48	50	9	10	2.8	2.1	5	2	2.1	•	•
0284	# 4	40	56	11	18	3.5	2.7	6	2	2.3	•	•
0318	# 5	40	56	11	18	3.5	2.7	6	3	2.6	•	•
0351	# 6	32	56	13	19	4.0	3.0	6	3	2.8	•	•
0417	# 8	32	63	13	19	4.5	3.4	6	3	3.4	•	•
0483	# 10	24	70	16	20	6.0	4.9	8	3	3.8	•	•
0549	# 12	24	80	19	29	6.0	4.9	8	3	4.5	•	•
0635	1/4	20	80	19	30	7.0	5.5	8	3	5.1	T168 0635	T169 0635
0794	5/16	18	90	22	34	8.0	6.2	9	3	6.6	T168 0794	T169 0794
0953	3/8	16	100	22	35	10.0	7.0	10	3	8.0	T168 0953	T169 0953



Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
1111	7/16	14	100	24	-	8.0	6.2	8	3	9.4	•	•
1270	1/2	13	110	28	-	9.0	7.0	10	3	10.8	T168 1270	T169 1270
1429	9/16	12	110	30	-	11.0	9.0	12	3	12.2	•	•
1588	5/8	11	110	32	-	12.0	9.0	12	3	13.5	T168 1588	T169 1588
1905	3/4	10	125	34	-	14.0	11.0	14	4	16.5	T168 1905	T169 1905
2223	7/8*	9	140	34	-	18.0	14.5	17	4	19.5	•	•
2540	1*	8	160	38	-	18.0	14.5	17	4	22.2	T168 2540	T169 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
T168			◐	◐	○		◐	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○																										○	
T169			◐	◐	◐		◐	◐	○	◐	○	○	○	○	○	◐	○	○	○	○	◐	○			○	○	○	◐	○	○															○				○	

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

○ Optimal ◐ Effective

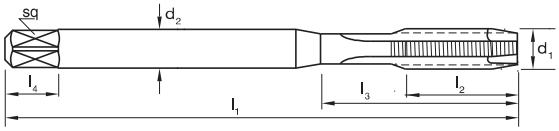
• Available on request as special manufacture. Subject to lead time. * HSSE > 3/4

UNC

suttontools

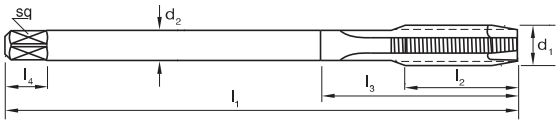
- Use in harder materials up to 45 HRC
- Through holes
- Suitable for machine operations
- Depths up to approx. 3 x d_1

DIN 2184-1 | 60° UNC



Catalogue Code	T172	T666
Discount Group	D0402	D0408
Material	PM-HSS Co	PM-HSS Co
Surface Finish	Blu	TiCN
Sutton Designation	H	H
Geometry	Low Relief	Low Relief
Chamfer	Form C/ 3 x P	Form C/ 3 x P
Limit & Nut Tolerance	2BX	2BX

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
0218	# 2	56	45	9	10	2.8	2.1	5	2	1.85	•	•
0251	# 3	48	50	9	10	2.8	2.1	5	2	2.1	•	•
0284	# 4	40	56	11	18	3.5	2.7	6	2	2.3	•	•
0318	# 5	40	56	11	18	3.5	2.7	6	3	2.6	•	•
0351	# 6	32	56	13	19	4.0	3.0	6	3	2.8	•	•
0417	# 8	32	63	13	19	4.5	3.4	6	3	3.4	•	•
0483	# 10	24	70	16	20	6.0	4.9	8	3	3.8	•	•
0549	# 12	24	80	19	29	6.0	4.9	8	3	4.5	•	•
0635	1/4	20	80	19	30	7.0	5.5	8	3	5.1	T172 0635	T666 0635
0794	5/16	18	90	22	34	8.0	6.2	9	3	6.6	T172 0794	T666 0794
0953	3/8	16	100	22	35	10.0	7.0	10	3	8.0	T172 0953	T666 0953



Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
1111	7/16	14	100	24	-	8.0	6.2	8	3	9.4	T172 1111	T666 1111
1270	1/2	13	110	28	-	9.0	7.0	10	3	10.8	T172 1270	T666 1270
1429	9/16	12	110	30	-	11.0	9.0	12	3	12.2	T172 1429	T666 1429
1588	5/8	11	110	32	-	12.0	9.0	12	3	13.5	T172 1588	T666 1588
1905	3/4	10	125	34	-	14.0	11.0	14	4	16.5	T172 1905	T666 1905
2223	7/8*	9	140	34	-	18.0	14.5	17	4	19.5	T172 2223	T666 2223
2540	1*	8	160	38	-	18.0	14.5	17	4	22.2	T172 2540	T666 2540
2858	1.1/8*	7	180	45	-	22.0	18.0	21	4	25.0	T172 2858	T666 2858

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
T172					◐			◐	◐		◐	◐	◐			○	○	○	○	○	○	○							○									○	○	○	○	○	○	○				○		
T666					◐			◐	◐		◐	◐	◐			○	◐	◐	◐	◐	◐	◐					○		◐									○	◐	◐	◐	◐	◐	◐				◐		

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

○ Optimal ◐ Effective

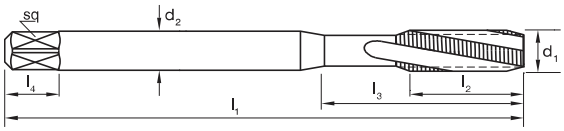
• Available on request as special manufacture. Subject to lead time. * HSSE > 3/4

DIN Taps UNC, Spiral Flute, R15 N

suttontools

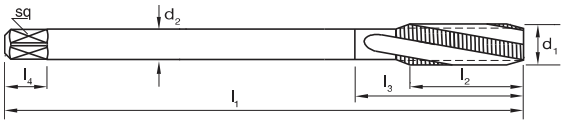
- General purpose use, materials up to approx. 1000 N/mm²
- Blind holes
- Suitable for machine operations
- Depths up to approx. 1.5 x d_1

DIN 2184-1 | 60° UNC



Catalogue Code	T255	T256	T257
Discount Group	D0402	D0406	D0402
Material	HSSE	HSSE	HSSE
Surface Finish	Brt	TiN	Brt
Sutton Designation	N	N	N
Geometry	R15	R15	R15
Chamfer	Form C/ 2.5 x P	Form C/ 2.5 x P	Form C/ 2.5 x P
Limit & Nut Tolerance	2B	2B	3B

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #	Item #
0218	# 2	56	45	9	10	2.8	2.1	5	2	1.85	•	•	•
0251	# 3	48	50	9	10	2.8	2.1	5	2	2.1	•	•	•
0284	# 4	40	56	5	18	3.5	2.7	6	2	2.3	•	•	•
0318	# 5	40	56	6	18	3.5	2.7	6	3	2.6	•	•	•
0351	# 6	32	56	6	19	4.0	3.0	6	3	2.8	•	•	•
0417	# 8	32	63	7	19	4.5	3.4	6	3	3.4	•	•	•
0483	# 10	24	70	8	20	6.0	4.9	8	3	3.8	•	•	•
0549	# 12	24	80	10	29	6.0	4.9	8	3	4.5	•	•	•
0635	1/4	20	80	10	30	7.0	5.5	8	3	5.1	•	•	•
0794	5/16	18	90	13	34	8.0	6.2	9	3	6.6	•	•	•
0953	3/8	16	100	15	35	10.0	7.0	10	3	8.0	•	•	•



Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #	Item #
1111	7/16	14	100	15	-	8.0	6.2	8	3	9.4	•	•	•
1270	1/2	13	110	18	-	9.0	7.0	10	3	10.8	•	•	•
1429	9/16	12	110	20	-	11.0	9.0	12	3	12.2	•	•	•
1588	5/8	11	110	20	-	12.0	9.0	12	3	13.5	•	•	•
1905	3/4	10	125	25	-	14.0	11.0	14	4	16.5	•	•	•
2223	7/8	9	140	28	-	18.0	14.5	17	4	19.5	•	•	•
2540	1	8	160	32	-	18.0	14.5	17	4	22.2	•	•	•

	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
T255	◐	◐	○	○		◐	○			○							○		○		○	○	◐	◐	○	○		○	○																				
T256	◐	◐	◐	◐	○	◐	◐	○		◐		○		○	○	○	○	○	○	○	○	○	◐	◐	○	○		○	○																				
T257	◐	◐	○	○		◐	○			○							○		○		○	○	◐	◐	○	○		○	○																				

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.

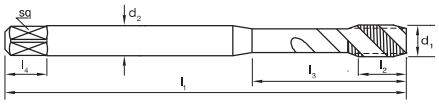
UNC

DIN Taps UNC, Spiral Flute, R40 N

suttontools

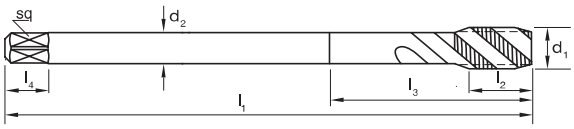
- General purpose use, materials up to approx. 1000 N/mm²
- Blind holes
- Suitable for machine operations
- Depths up to approx. 2.5 x d_1

DIN 2184-1 | 60° UNC



Catalogue Code	T258	T259	T260	T273
Discount Group	D0402	D0402	D0402	D0406
Material	HSSE	HSSE	HSSE	HSSE
Surface Finish	Brt	Brt	Blu	TiN
Sutton Designation	N	N	N	N
Geometry	R40	R40	R40	R40
Chamfer	Form C/ 2.5 x P	Form C/ 2.5 x P	Form C/ 2.5 x P	Form C/ 2.5 x P
Limit & Nut Tolerance	2B	3B	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 #
0218	# 2	56	45	9	10	2.8	2.1	5	2	1.85	T258 0218	•	T260 0218	T273 0218
0251	# 3	48	50	9	10	2.8	2.1	5	2	2.1	•	•	T260 0251	T273 0251
0284	# 4	40	56	5	18	3.5	2.7	6	2	2.3	T258 0284	•	T260 0284	T273 0284
0318	# 5	40	56	6	18	3.5	2.7	6	3	2.6	T258 0318	•	T260 0318	T273 0318
0351	# 6	32	56	6	19	4.0	3.0	6	3	2.8	T258 0351	•	T260 0351	T273 0351
0417	# 8	32	63	7	19	4.5	3.4	6	3	3.4	T258 0417	•	T260 0417	T273 0417
0483	# 10	24	70	8	20	6.0	4.9	8	3	3.8	T258 0483	•	T260 0483	T273 0483
0549	# 12	24	80	10	29	6.0	4.9	8	3	4.5	T258 0549	•	T260 0549	T273 0549
0635	1/4	20	80	10	30	7.0	5.5	8	3	5.1	T258 0635	•	T260 0635	T273 0635
0794	5/16	18	90	13	34	8.0	6.2	9	3	6.6	T258 0794	•	T260 0794	T273 0794
0953	3/8	16	100	15	35	10.0	7.0	10	3	8.0	T258 0953	•	T260 0953	T273 0953



Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #	Item #	Item #
1111	7/16	14	100	15	-	8.0	6.2	8	3	9.4	T258 1111	•	T260 1111	T273 1111
1270	1/2	13	110	18	-	9.0	7.0	10	3	10.8	T258 1270	•	T260 1270	T273 1270
1429	9/16	12	110	20	-	11.0	9.0	12	3	12.2	T258 1429	•	T260 1429	T273 1429
1588	5/8	11	110	20	-	12.0	9.0	12	3	13.5	T258 1588	•	T260 1588	T273 1588
1905	3/4	10	125	25	-	14.0	11.0	14	4	16.5	T258 1905	•	T260 1905	T273 1905
2223	7/8	9	140	28	-	18.0	14.5	17	4	19.5	T258 2223	•	T260 2223	T273 2223
2540	1	8	160	32	-	18.0	14.5	17	4	22.2	T258 2540	•	T260 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
T258	●	●	○	○		●	○			○							○		○		○	○	●	●	○	○		○	○																					
T259	●	●	○	○		●	○			○							○		○		○	○	●	●	○	○		○	○																					
T260	●	●	●	●		●	●			●		○		○	○	○	○		○		○	○																												
T273	●	●	●	●	○	●	●	○		●		○		○	○	○	○	○	○	○	○	○	●	●	○	○		●	○																					

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.

UNC

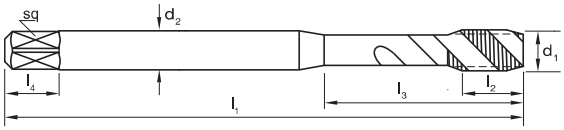
DIN Taps UNC, Spiral Flute, R50 Black Magic

suttontools BLACKMAGIC

watch the video

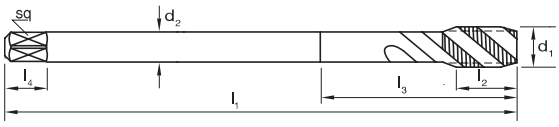
- Universal high performance tapping
- PM-HSSE V3 offers superior tool life
- Use in stainless steels and high strength steels up to 850N/mm²
- Blind holes up to 3 x d_1
- Suitable for synchronous tapping in machine operations

DIN 2184-1 | 60° UNC | Z | HSC



Catalogue Code	T691
Discount Group	D0410
Material	PM-HSSE V3
Surface Finish	HARDLUBE
Sutton Designation	UNI
Geometry	R50
Chamfer	Form C/ 2.5 x P
Limit & Nut Tolerance	2BX

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #
0218	# 2	56	45	9	12	2.8	2.1	5	3	1.85	T691 0218
0284	# 4	40	56	5	18	3.5	2.7	6	3	2.35	T691 0284
0351	# 6	32	56	6	20	4	3	6	3	2.85	T691 0351
0417	# 8	32	63	7	21	4.5	3.4	6	3	3.50	T691 0417
0483	# 10	24	70	9	25	6	4.9	8	3	3.90	T691 0483
0635	1/4	20	80	10	30	7	5.5	8	3	5.10	T691 0635



Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #
0794	5/16	18	90	13	35	6	4.9	8	3	6.60	T691 0794
0953	3/8	16	100	15	39	7	5.5	8	3	8.00	T691 0953
1270	1/2	13	110	18	-	9	7	10	4	10.80	T691 1270
1588	5/8	11	110	20	-	12	9	12	4	13.50	T691 1588

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
T691	◐	◐	◐	●		◐	●			◐		◐	●	◐	◐		●	●	●	●	●	●	◐	◐	◐	●	●	●	●																				

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

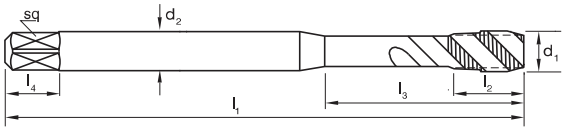
● Optimal ◐ Effective

UNC

DIN Taps UNC, Spiral Flute, R45 VA DH

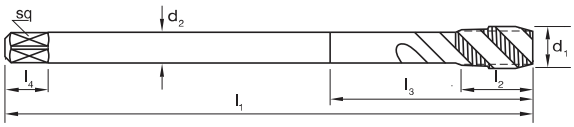
suttontools

- Use in stainless steels and high strength steels up to 1000N/mm²
- Blind holes
- Suitable for synchronous tapping in machine operations
- Depths up to approx. 3 x d_1



Catalogue Code	T261	T262
Discount Group	D0402	D0408
Material	HSSE	HSSE
Surface Finish	Blu	TiCN
Sutton Designation	VA DH	VA DH
Geometry	R45	R45
Chamfer	Form C/ 2.5 x P	Form C/ 2.5 x P
Limit & Nut Tolerance	2B	2B

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
0218	# 2	56	45	9	10	2.8	2.1	5	2	1.85	•	T262 0218
0251	# 3	48	50	9	10	2.8	2.1	5	2	2.1	•	•
0284	# 4	40	56	5	18	3.5	2.7	6	2	2.3	T261 0284	T262 0284
0318	# 5	40	56	6	18	3.5	2.7	6	3	2.6	•	•
0351	# 6	32	56	6	19	4.0	3.0	6	3	2.8	T261 0351	T262 0351
0417	# 8	32	63	7	19	4.5	3.4	6	3	3.4	T261 0417	T262 0417
0483	# 10	24	70	8	20	6.0	4.9	8	3	3.8	T261 0483	T262 0483
0549	# 12	24	80	10	29	6.0	4.9	8	3	4.5	•	•
0635	1/4	20	80	10	30	7.0	5.5	8	3	5.1	T261 0635	T262 0635
0794	5/16	18	90	13	34	8.0	6.2	9	3	6.6	T261 0794	T262 0794
0953	3/8	16	100	15	35	10.0	7.0	10	3	8.0	T261 0953	T262 0953



Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
1111	7/16	14	100	15	-	8.0	6.2	8	3	9.4	T261 1111	T262 1111
1270	1/2	13	110	18	-	9.0	7.0	10	3	10.8	T261 1270	T262 1270
1429	9/16	12	110	20	-	11.0	9.0	12	3	12.2	•	•
1588	5/8	11	110	20	-	12.0	9.0	12	3	13.5	T261 1588	T262 1588
1905	3/4	10	125	25	-	14.0	11.0	14	4	16.5	T261 1905	T262 1905
2223	7/8	9	140	28	-	18.0	14.5	17	4	19.5	T261 2223	T262 2223
2540	1	8	160	32	-	18.0	14.5	17	4	22.2	T261 2540	T262 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
T261	●	●	○			○	○					○		●	●	○																																
T262	●	●	○	○		○	○	○		○		●		●	●	●							○	○	○	○		○		○			●		○													

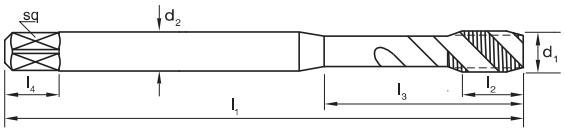
P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials

○ Optimal ● Effective

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

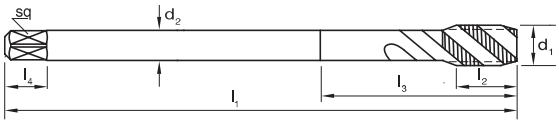
suttontools

- PM-HSSE V3 offers superior tool life
- Use in stainless steels and high strength steels up to 850N/mm²
- Blind holes up to 3 x d_1
- Suitable for synchronous tapping in machine operations



Catalogue Code	T695
Discount Group	D0408
Material	PM-HSSE V3
Surface Finish	TiCN
Sutton Designation	VA PM
Geometry	R50
Chamfer	Form C/ 2.5 x P
Limit & Nut Tolerance	2BX

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #
0218	# 2	56	45	9	12	2.8	2.1	5	3	1.85	T695 0218
0284	# 4	40	56	5	18	3.5	2.7	6	3	2.35	T695 0284
0351	# 6	32	56	6	20	4	3.0	6	3	2.85	T695 0351
0417	# 8	32	63	7	21	4.5	4.3	6	3	3.50	T695 0417
0483	# 10	24	70	9	25	6	4.9	8	3	3.90	T695 0483
0635	1/4	20	80	10	30	7	5.5	8	3	5.10	T695 0635



Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #
0794	5/16	18	90	13	-	6	4.9	8	3	6.60	T695 0794
0953	3/8	16	100	15	-	7	5.5	8	3	8.00	T695 0953
1270	1/2	13	110	18	-	9	7	10	4	10.80	T695 1270
1588	5/8	11	110	20	-	12	9	12	4	13.50	T695 1588

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
T695	●	●	●	○		●	○	○		○		●		●	●	●							○	○	○	○	○	○		○			●		●													

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

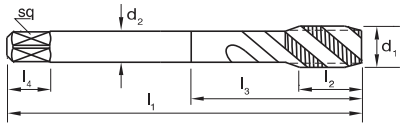
● Optimal ○ Effective

UNC

DIN Taps 8UN, Spiral Flute, R40 VA

suttontools

- Use in stainless steels and high strength steels up to 1000N/mm²
- Blind holes
- Suitable for synchronous tapping in machine operations
- Depths up to approx. 2.5 x d_1



Catalogue Code	T263	T264
Discount Group	D0402	D0408
Material	HSSE	HSSE
Surface Finish	Brt	TiCN
Sutton Designation	VA	VA
Geometry	R40	R40
Chamfer	Form C/ 2.5 x P	Form C/ 2.5 x P
Limit & Nut Tolerance	2B	2B

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
2858	1-1/8	8	180	30	-	22.0	18.0	21	4	25.5	T263 2858	T264 2858
3175	1-1/4	8	180	30	-	22.0	18.0	21	4	28.5	T263 3175	T264 3175
3493	1-3/8	8	200	30	-	28.0	22.0	25	4	31.75	T263 3493	T264 3493
3810	1-1/2	8	200	30	-	28.0	22.0	25	6	35.0	T263 3810	T264 3810
4128	1-5/8	8	200	30	-	32.0	24.0	27	6	38.0	T263 4128	T264 4128
4445	1-3/4	8	220	30	-	36.0	29.0	3	6	41.5	T263 4445	T264 4445
4763	1-7/8	8	250	30	-	40.0	32.0	35	6	44.5	T263 4763	T264 4763
5080	2	8	250	33	-	40.0	32.0	35	6	47.5	T263 5080	T264 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
T263	●	●	●	○		●	○	○		○		●		●	●	●							○	○	○	○		○		○																			
T264	●	●	●	○		●	○	○		○		●		●	●	●							○	○	○	○		○		○																			

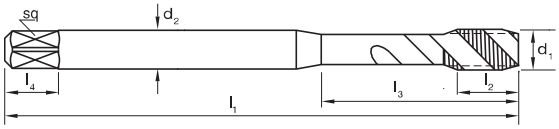
P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials

● Optimal ○ Effective

UN

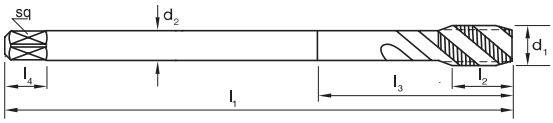
suttontools

- Use in harder materials up to 42 HRC
- Blind holes
- Suitable for machine operations
- Depths up to approx. 2.5 x d_1



Catalogue Code	T266	T267
Discount Group	D0402	D0410
Material	PM-HSSE V3	PM-HSSE V3
Surface Finish	Blu	TiAlN
Sutton Designation	NH	NH
Geometry	R40	R40
Chamfer	Form C/ 2.5 x P	Form C/ 2.5 x P
Limit & Nut Tolerance	2B	2B

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
0218	# 2	56	45	9	10	2.8	2.1	5	2	1.85	•	•
0251	# 3	48	50	9	10	2.8	2.1	5	2	2.1	•	•
0284	# 4	40	56	5	18	3.5	2.7	6	2	2.3	•	•
0318	# 5	40	56	6	18	3.5	2.7	6	3	2.6	•	•
0351	# 6	32	56	6	19	4.0	3.0	6	3	2.8	•	•
0417	# 8	32	63	7	19	4.5	3.4	6	3	3.4	•	•
0483	# 10	24	70	8	20	6.0	4.9	8	3	3.8	•	•
0549	# 12	24	80	10	29	6.0	4.9	8	3	4.5	•	•
0635	1/4	20	80	10	30	7.0	5.5	8	3	5.1	T266 0635	T267 0635
0794	5/16	18	90	13	34	8.0	6.2	9	3	6.6	T266 0794	T267 0794
0953	3/8	16	100	15	35	10.0	7.0	10	3	8.0	T266 0953	T267 0953



Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
1111	7/16	14	100	15	-	8.0	6.2	8	3	9.4	•	•
1270	1/2	13	110	18	-	9.0	7.0	10	3	10.8	T266 1270	T267 1270
1429	9/16	12	110	20	-	11.0	9.0	12	3	12.2	•	T267 1429
1588	5/8	11	110	20	-	12.0	9.0	12	3	13.5	T266 1588	T267 1588
1905	3/4	10	125	25	-	14.0	11.0	14	4	16.5	T266 1905	T267 1905
2223	7/8*	9	140	28	-	18.0	14.5	17	4	19.5	•	•
2540	1*	8	160	32	-	18.0	14.5	17	4	22.2	T266 2540	T267 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
T266			◐	◐	○		◐	○		○		○		○	○	○	○	○	○	○	○	○																										○	
T267			◐	◐	◐		◐	◐	○	◐	○	○	○	○	○	◐	○	○	○	○	○	○	○	○	○	○	◐	○	○	○																		○	

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

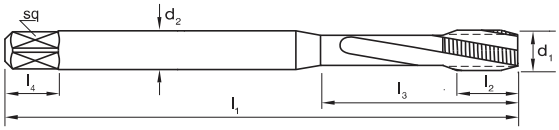
● Optimal ◐ Effective

• Available on request as special manufacture. Subject to lead time. * HSSE > 3/4

suttontools

- Use in harder materials up to 45 HRC
- Blind holes
- Suitable for machine operations
- Depths up to approx. 1.5 x d_1

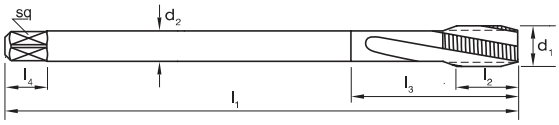
DIN 2184-1 | 60° UNC



Catalogue Code	T265	T667
Discount Group	D0402	D0408
Material	PM-HSS Co	PM-HSS Co
Surface Finish	Blu	TiCN
Sutton Designation	H	H
Geometry	R15	R15
Chamfer	Form C/ 3 x P	Form C/ 3 x P
Limit & Nut Tolerance	2BX	2BX

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
0218	#2	56	45	9	10	2.8	2.1	5	2	1.85	•	•
0251	#3	48	50	9	10	2.8	2.1	5	2	2.1	•	•
0284	#4	40	56	5	18	3.5	2.7	6	2	2.3	•	•
0318	#5	40	56	6	18	3.5	2.7	6	3	2.6	•	•
0351	#6	32	56	6	19	4.0	3.0	6	3	2.8	•	•
0417	#8	32	63	7	19	4.5	3.4	6	3	3.4	•	•
0483	#10	24	70	8	20	6.0	4.9	8	3	3.8	•	•
0549	#12	24	80	10	29	6.0	4.9	8	3	4.5	•	•
0635	1/4	20	80	10	30	7.0	5.5	8	3	5.1	T265 0635	T667 0635
0794	5/16	18	90	13	34	8.0	6.2	9	3	6.6	T265 0794	T667 0794
0953	3/8	16	100	15	35	10.0	7.0	10	3	8.0	T265 0953	T667 0953

UNC



Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
1111	7/16	14	100	15	-	8.0	6.2	8	3	9.4	T265 1111	T667 1111
1270	1/2	13	110	18	-	9.0	7.0	10	4	10.8	T265 1270	T667 1270
1429	9/16	12	110	20	-	11.0	9.0	12	4	12.2	T265 1429	T667 1429
1588	5/8	11	110	20	-	12.0	9.0	12	4	13.5	T265 1588	T667 1588
1905	3/4	10	125	25	-	14.0	11.0	14	4	16.5	T265 1905	T667 1905
2223	7/8*	9	140	28	-	18.0	14.5	17	4	19.5	T265 2223	T667 2223
2540	1*	8	160	32	-	18.0	14.5	17	4	22.2	T265 2540	T667 2540
2858	1.1/8*	7	180	45	-	22.0	18.0	21	4	25.0	T265 2858	T667 2858

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
T265					◐			◐	◐		◐	○				○	○	○	○	○	○	○							○									○	○	○	○	○	○					○	
T667					◐			◐	◐		◐	○	◐			○	◐	◐	◐	◐	◐	◐					○		◐									○	◐	◐	◐	◐	◐					◐	

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

○ Optimal ◐ Effective

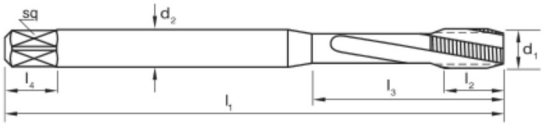
• Available on request as special manufacture. Subject to lead time. * HSSE > 3/4

DIN Taps UNJ, Spiral Flute, R15 Ti

suttontools

- For Titanium based alloys
- Unique cutting geometry for highly efficient swarf ejection
- Optimised microfinish for optimal process reliability and excellent thread quality
- Blind holes up to approx. 1.5 x d_1

DIN 2184-1 | 60° UNJC | 60° UNJF | μ MICRO



Catalogue Code	T790
Discount Group	D0408
Material	PM-HSS Co
Surface Finish	*TICN*
Sutton Designation	TI
Geometry	R15
Chamfer	Form C / 3 x P
Limit & Nut Tolerance	3BX

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	Item #
	UNJC									
0635	1/4	20	80	10	30	7.0	5.5	8	3	T790 0635
0794	5/16	18	90	13	34	8.0	6.2	9	3	T790 0794
0953	3/8	16	100	15	35	10.0	7.0	10	3	T790 0953
	UNJF									**T791**
0635	1/4	28	80	10	30	7.0	5.5	8	3	T791 0635
0794	5/16	24	90	13	34	8.0	6.2	9	3	T791 0794
0953	3/8	24	100	15	35	10.0	7.0	10	3	T791 0953

UNJ

Special Taps Service

Sutton Tools understands the difficulty of manufacturing super alloys.

Our Special Tool Service enables us to meet your requirements and deliver superior performance in Titanium & high temperature alloys.

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

All Thread Forms
M, MJ, UNJC, UNJF, Screw Thread Insert (STI)

Sizes
M2-M30, #2-1"

† Sutton Tools recommends that in difficult to machine materials the tapping drill holes should be drilled as large as practical whilst maintaining sufficient strength in the produced thread. This will need to be determined for each individual application. By decreasing the % thread engagement the tapping torque required is reduced and the tool life can be increased.

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
T790													○			○																							●	●	○	●	○						

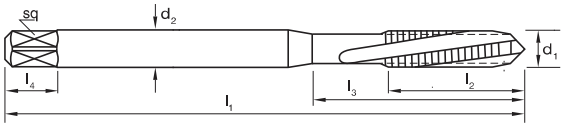
P Steel | M Stainless Steel | K Cast Iron | N Non-Ferrous Metals | S Titanium & Super Alloys | H Hard Materials

● Optimal ○ Effective

*Available on request as special manufacture. Subject to lead time & MOQ.

suttontools

- For Titanium based alloys
- Unique cutting geometry for highly efficient swarf ejection
- Optimised microfinish for optimal process reliability and excellent thread quality
- Blind holes up to approx. 1.5 x d_1



Catalogue Code	T786
Discount Group	D0408
Material	PM-HSSCo
Surface Finish	TiCN
Sutton Designation	Ti
Geometry	L12
Chamfer	Form B / 4.5 x P
Limit & Nut Tolerance	3BX

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #
	UNJC										
0635	1/4	20	80	19	30	7.0	5.5	8	3		T786 0635
0794	5/16	18	90	22	34	8.0	6.2	9	3		T786 0794
0953	3/8	16	100	24	35	10.0	7.0	10	3		T786 0953
	UNJF										T787
0635	1/4	28	80	19	30	7.0	5.5	8	3		T787 0635
0794	5/16	24	90	22	34	8.0	6.2	9	3		T787 0794
0953	3/8	24	100	24	35	10.0	7.0	10	3		T787 0953

UNJ

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
T786													●			○																							●	●	●	●	●						

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

● Optimal ○ Effective

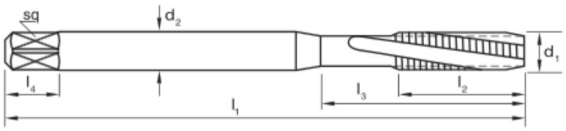
*Available on request as special manufacture. Subject to lead time & MOQ.

DIN Taps UNJ, Spiral Flute, R10 Ni

suttontools

- For Nickel alloys / age-hardened super alloys >1150M/mm²
- Reinforced cutting geometry
- Blind or through holes
- Depths up to approx. 1.5 x d_1

DIN 2184-1 | 60° UNJC | 60° UNJF | μ MICRO



Catalogue Code	T794
Discount Group	D0408
Material	PM-HSS Co
Surface Finish	TICN
Sutton Designation	NI
Geometry	R10
Chamfer	Form C / 3 x P
Limit & Nut Tolerance	3BX

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø†	Item #
	UNJC										
0635	1/4	20	80	19	30	7.0	5.5	8	3		T794 0635
0794	5/16	18	90	22	34	8.0	6.2	9	3		T794 0794
0953	3/8	16	100	22	35	10.0	7.0	10	3		T794 0953
1270	1/2	13	110	28	-	9.0	7.0	10	3		T794 1270
	UNJF										**T795**
0635	1/4	28	80	19	30	7.0	5.5	8	3		T795 0635
0794	5/16	24	90	22	34	8.0	6.2	9	3		T795 0794
0953	3/8	24	100	22	35	10.0	7.0	10	3		T795 0953

UNJ

Special Taps Service

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All Thread Forms
M, MJ, UNJC, UNJF, Screw Thread Insert (STI)

Sizes
M2-M30, #2-1"

† Sutton Tools recommends that in difficult to machine materials the tapping drill holes should be drilled as large as practical whilst maintaining sufficient strength in the produced thread. This will need to be determined for each individual application. By decreasing the % thread engagement the tapping torque required is reduced and the tool life can be increased.

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
T794																																	●	●	●	●	○											

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

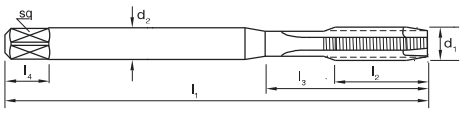
● Optimal ○ Effective

*Available on request as special manufacture. Subject to lead time & MOQ.

suttontools

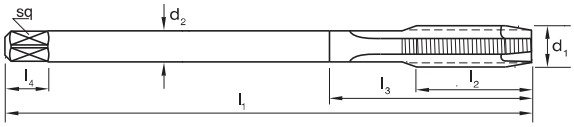
- General purpose use, materials up to approx. 1000 N/mm²
- Through holes
- Suitable for machine operations
- Depths up to approx. 3 x d_1

DIN 2184-1 | 60° UNF



Catalogue Code	T173	T174	T702	T175
Discount Group	D0402	D0402	D0402	D0406
Material	HSSE	HSSE	HSSE	HSSE
Surface Finish	Brt	Brt	Blue	TiN
Application	N	N	N	N
Geometry				
Chamfer	Form B / 4.5 x P	Form C/ 2.5 x P	Form B / 4.5 x P	Form B / 4.5 x P
Limit & Nut Tolerance	2B	3B	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 #
0218	#2	64	45	9	-	2.8	2.1	5	2	1.9	T173 0218	•	T702 0218	T175 0218
0251	#3	56	50	9	-	2.8	2.1	5	2	2.1	•	•	•	•
0284	#4	48	56	11	18	3.5	2.7	6	2	2.35	T173 0284	•	T702 0284	T175 0284
0318	#5	44	56	11	18	3.5	2.7	6	3	2.65	•	•	•	T175 0318
0351	#6	40	56	13	20	4.0	3.0	6	3	2.9	T173 0351	•	T702 0351	T175 0351
0417	#8	36	63	13	21	4.5	3.4	6	3	3.5	T173 0417	•	T702 0417	T175 0417
0483	#10	32	70	16	25	6.0	4.9	8	3	4.1	T173 0483	•	T702 0483	T175 0483
0549	#12	28	80	19	30	6.0	4.9	8	3	4.6	•	•	•	•
0635	1/4	28	80	19	30	7.0	5.5	8	3	5.5	T173 0635	T174 0635	T702 0635	T175 0635
0794	5/16	24	90	22	35	8.0	6.2	9	3	6.9	T173 0794	•	T702 0794	T175 0794
0953	3/8	24	100	20	35	10.0	8.0	11	3	8.5	T173 0953	•	T702 0953	T175 0953



Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #	Item #	Item #
1111	7/16	20	100	24	-	8.0	6.2	8	3	9.8	T173 1111	•	•	T175 1111
1270	1/2	20	110	28	-	9.0	7.0	10	3	11.5	T173 1270	•	•	T175 1270
1429	9/16	18	110	32	-	11.0	9.0	12	3	12.8	T173 1429	•	•	T175 1429
1588	5/8	18	110	32	-	12.0	9.0	12	3	14.5	T173 1588	•	•	T175 1588
1905	3/4	16	125	34	-	14.0	11.0	14	4	17.5	T173 1905	•	•	T175 1905
2223	7/8	14	140	34	-	18.0	14.5	17	4	20.5	T173 2223	•	•	T175 2223
2540	1	12	160	38	-	18.0	14.5	17	4	23.5	T173 2540	•	•	T175 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
T173	●	●	○	○		●	○			○							○		○		○	○	●	●	○	○		○	○																					
T174	●	●	○	○		●	○			○							○		○		○	○	●	●	○	○		○	○																					
T702	●	●	●	●		●	●			●		○		○	○	○	○		○		○	○																												
T175	●	●	●	●	○	●	●	○		●		○		○	○	○	○	○	○	○	○	○	●	●	○	○		●	○																					

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.

UNF

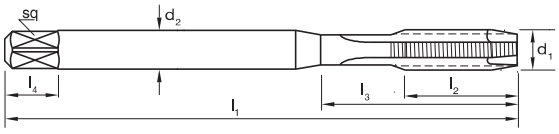
DIN Taps UNF, Gun, Black Magic

suttontools BLACKMAGIC

watch the video

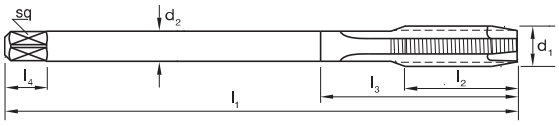
- Universal high performance tapping
- PM-HSSE V3 offers superior tool life
- Use in stainless steels and high strength steels up to 850N/mm²
- Through holes up to 3 x d_1
- Suitable for synchronous tapping in machine operations

DIN 2184-1 | 60° UNF | Z



Catalogue Code	T694
Discount Group	D0410
Material	PM-HSSE V3
Surface Finish	HARDLUBE
Sutton Designation	UNI
Geometry	Special Relief
Chamfer	Form B / 4.5 x P
Limit & Nut Tolerance	2BX

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #
0284	# 4	48	56	11	18	3.5	2.7	6	2	2.35	T694 0284
0318	# 5	44	56	11	18	3.5	2.7	6	3	2.65	•
0351	# 6	40	56	13	20	4.0	3.0	6	3	2.9	T694 0351
0417	# 8	36	63	13	21	4.5	3.4	6	3	3.5	T694 0417
0483	# 10	32	70	16	25	6.0	4.9	8	3	4.1	T694 0483
0635	1/4	28	80	19	30	7.0	5.5	8	3	5.5	T694 0635



Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #
0794	5/16	24	90	22	35	6	4.9	8	3	6.90	T694 0794
0953	3/8	24	90	20	39	7	5.5	8	3	8.50	T694 0953
1270	1/2	20	100	22	-	9	7	10	4	11.50	T694 1270
1588	5/8	18	100	22	-	12	9	12	4	14.50	T694 1588

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
T694	●	●	●	○		●	○			●		●	○	●	●		○	○	○	○	○	○	●	●	●	○	○	○	○	○																			

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

● Optimal ○ Effective

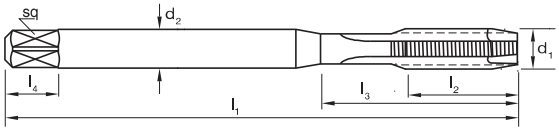
• Available on request as special manufacture. Subject to lead time.

UNF

suttontools

- Use in stainless steels and high strength steels up to 1000N/mm²
- Through holes
- Suitable for machine operations
- Depths up to approx. 3 x d_1

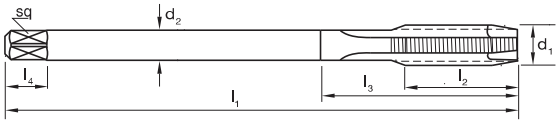
DIN 2184-1 | 60° UNF



Catalogue Code	T176	T177
Discount Group	D0402	D0408
Material	HSSE	HSSE
Surface Finish	Blu	TiCN
Sutton Designation	VA	VA
Geometry	Special Relief	Special Relief
Chamfer	Form B / 4.5 x P	Form B / 4.5 x P
Limit & Nut Tolerance	2B	2B

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
0218	# 2	64	45	9	-	2.8	2.1	5	2	1.9	•	•
0251	# 3	56	50	9	-	2.8	2.1	5	2	2.1	•	•
0284	# 4	48	56	11	18	3.5	2.7	6	2	2.35	T176 0284	•
0318	# 5	44	56	11	18	3.5	2.7	6	3	2.65	•	•
0351	# 6	40	56	13	20	4.0	3.0	6	3	2.9	T176 0351	•
0417	# 8	36	63	13	21	4.5	3.4	6	3	3.5	T176 0417	•
0483	# 10	32	70	16	25	6.0	4.9	8	3	4.1	T176 0483	T177 0483
0549	# 12	28	80	19	30	6.0	4.9	8	3	4.6	•	•
0635	1/4	28	80	19	30	7.0	5.5	8	3	5.5	T176 0635	T177 0635
0794	5/16	24	90	22	35	8.0	6.2	9	3	6.9	T176 0794	T177 0794
0953	3/8	24	100	20	35	10.0	8.0	11	3	8.5	T176 0953	T177 0953

UNF



Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
1111	7/16	20	100	24	-	8.0	6.2	8	3	9.8	T176 1111	T177 1111
1270	1/2	20	110	28	-	9.0	7.0	10	3	11.5	T176 1270	T177 1270
1429	9/16	18	110	32	-	11.0	9.0	12	3	12.8	T176 1429	T177 1429
1588	5/8	18	110	32	-	12.0	9.0	12	3	14.5	T176 1588	T177 1588
1905	3/4	16	125	34	-	14.0	11.0	14	4	17.5	T176 1905	T177 1905
2223	7/8	14	140	34	-	18.0	14.5	17	4	20.5	T176 2223	T177 2223
2540	1	12	160	38	-	18.0	14.5	17	4	23.5	T176 2540	T177 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
T176	●	●	○	○		●	○					○		●	●	○																																			
T177	●	●	○	○		●	○			○		●	○	●	●	●							○	○	○	○	○	○		○			●	○	○															

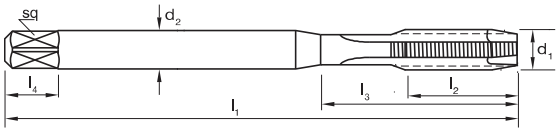
P Steel | M Stainless Steel | K Cast Iron | N Non-Ferrous Metals | S Titanium & Super Alloys | H Hard Materials

● Optimal ○ Effective

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

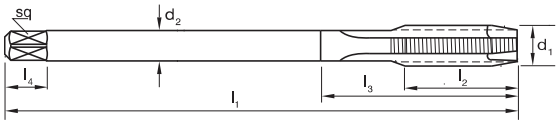
suttontools

- PM-HSSE V3 offers superior tool life
- Use in stainless steels and high strength steels up to 850N/mm²
- Through holes up to 3 x d_1



Catalogue Code	T698
Discount Group	D0408
Material	PM-HSSE V3
Surface Finish	TiCN
Sutton Designation	VA PM
Geometry	Special Relief
Chamfer	Form B / 4.5 x P
Limit & Nut Tolerance	2BX

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #
0284	# 4	48	56	11	18	3.5	2.7	6	2	2.35	T698 0284
0351	# 6	40	56	12	20	4.0	3.0	6	3	2.9	T698 0351
0417	# 8	36	63	13	21	4.5	3.4	6	3	3.5	T698 0417
0483	# 10	32	70	16	25	6.0	4.9	8	3	4.1	T698 0483
0635	1/4	28	80	19	30	7.0	5.5	8	3	5.5	T698 0635



Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #
0794	5/16	24	90	22	-	6	4.9	8	3	6.90	T698 0794
0953	3/8	24	90	20	-	7	5.5	8	3	8.50	T698 0953
1270	1/2	20	100	22	-	9	7	10	4	11.50	T698 1270
1588	5/8	18	100	22	-	12	9	12	4	14.50	T698 1588

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
T698	●	●	○	○		●	○			○		●	○	●	●	●							○	○	○	○	○	○		○			●	●	●													

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

● Optimal ○ Effective

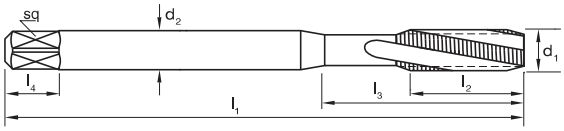
UNF

DIN Taps UNF, Spiral Flute, R15 N

suttontools

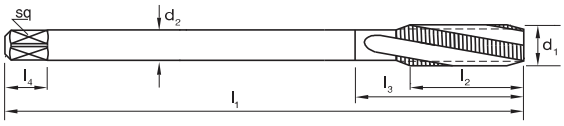
- General purpose use, materials up to approx. 1000 N/mm²
- Blind holes
- Suitable for machine operations
- Depths up to approx. 1.5 x d_1

DIN 2184-1 | 60° UNF



Catalogue Code	T274
Discount Group	D0402
Material	HSSE
Surface Finish	Brt
Sutton Designation	N
Geometry	R15
Chamfer	Form C/ 2.5 x P
Limit & Nut Tolerance	2B

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #
0218	# 2	64	45	9	-	2.8	2.1	5	2	1.9	•
0251	# 3	56	50	9	-	2.8	2.1	5	2	2.1	•
0284	# 4	48	56	5	18	3.5	2.7	6	2	2.35	•
0318	# 5	44	56	6	18	3.5	2.7	6	3	2.65	•
0351	# 6	40	56	6	20	4.0	3.0	6	3	2.9	•
0417	# 8	36	63	7	21	4.5	3.4	6	3	3.5	•
0483	# 10	32	70	8	25	6.0	4.9	8	3	4.1	•
0549	# 12	28	80	10	30	6.0	4.9	8	3	4.6	•
0635	1/4	28	80	10	30	7.0	5.5	8	3	5.5	•
0794	5/16	24	90	13	35	8.0	6.2	9	3	6.9	•
0953	3/8	24	100	15	35	10.0	8.0	11	3	8.5	•



Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #
1111	7/16	20	100	15	-	8.0	6.2	8	3	9.8	•
1270	1/2	20	110	18	-	9.0	7.0	10	3	11.5	•
1429	9/16	18	110	20	-	11.0	9.0	12	3	12.8	•
1588	5/8	18	110	20	-	12.0	9.0	12	3	14.5	•
1905	3/4	16	125	25	-	14.0	11.0	14	4	17.5	•
2223	7/8	14	140	28	-	18.0	14.5	17	4	20.5	•
2540	1	12	160	32	-	18.0	14.5	17	4	23.5	•

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
T274	●	●	○	○		●	○			○							○		○		○	○	●	●	○	○		○	○																				

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.

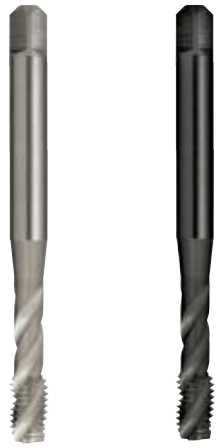
UNF

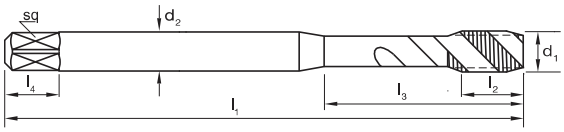
DIN Taps UNF, Spiral Flute, R40 N

suttontools

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

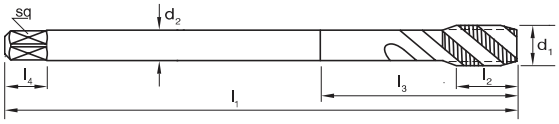
DIN 2184-1 | 60° UNF





	T275	T701
Catalogue Code	T275	T701
Discount Group	D0402	D0402
Material	HSSE	HSSE
Surface Finish	Brt	Blu
Sutton Designation	N	N
Geometry	R40	R40
Chamfer	Form C/ 2.5 x P	Form C/ 2.5 x P
Limit & Nut Tolerance	2B	2B

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
0218	# 2	64	45	9	-	2.8	2.1	5	2	1.9	•	•
0251	# 3	56	50	9	-	2.8	2.1	5	2	2.1	•	•
0284	# 4	48	56	5	18	3.5	2.7	6	2	2.35	T275 0284	•
0318	# 5	44	56	6	18	3.5	2.7	6	3	2.65	T275 0318	•
0351	# 6	40	56	6	20	4.0	3.0	6	3	2.9	T275 0351	T701 0351
0417	# 8	36	63	7	21	4.5	3.4	6	3	3.5	T275 0417	T701 0417
0483	# 10	32	70	8	25	6.0	4.9	8	3	4.1	T275 0483	T701 0483
0549	# 12	28	80	10	30	6.0	4.9	8	3	4.6	T275 0549	•
0635	1/4	28	80	10	30	7.0	5.5	8	3	5.5	T275 0635	T701 0635
0794	5/16	24	90	13	35	8.0	6.2	9	3	6.9	T275 0794	T701 0794
0953	3/8	24	100	15	35	10.0	8.0	11	3	8.5	T275 0953	T701 0953



Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
1111	7/16	20	100	15	-	8.0	6.2	8	3	9.8	T275 1111	T701 1111
1270	1/2	20	110	18	-	9.0	7.0	10	3	11.5	T275 1270	•
1429	9/16	18	110	20	-	11.0	9.0	12	3	12.8	T275 1429	•
1588	5/8	18	110	20	-	12.0	9.0	12	3	14.5	T275 1588	•
1905	3/4	16	125	25	-	14.0	11.0	14	4	17.5	T275 1905	•
2223	7/8	14	140	28	-	18.0	14.5	17	4	20.5	T275 2223	•
2540	1	12	160	32	-	18.0	14.5	17	4	23.5	T275 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
T275	◐	◐	○	○		◐	○			○							○		○		○	○	◐	◐	○	○		○	○																				
T701	◐	◐	◐	◐		◐	◐			◐		○		○	○	○	○		○		○	○																										

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.

UNF

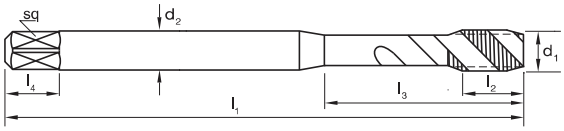
DIN Taps UNF, Spiral Flute, R50 Black Magic

suttontools BLACKMAGIC

watch the video

- Universal high performance tapping
- PM-HSSE V3 offers superior tool life
- Use in stainless steels and high strength steels up to 850N/mm²
- Blind holes up to 3 x d_1
- Suitable for synchronous tapping in machine operations

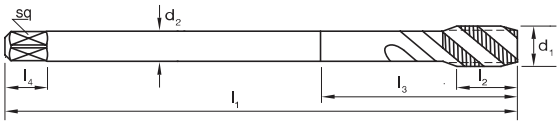
DIN 2184-1 | 60° UNF | Z | HSC



Catalogue Code	T692
Discount Group	D0410
Material	PM-HSSE V3
Surface Finish	HARDLUBE
Sutton Designation	UNI
Geometry	R50
Chamfer	Form B / 4.5 x P
Limit & Nut Tolerance	2BX

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #
0284	# 4	48	56	5	18	3.5	2.7	6	3	2.40	T692 0284
0351	# 6	40	56	6	20	4	3	6	3	2.95	T692 0351
0417	# 8	36	63	7	21	4.5	3.4	6	3	3.50	T692 0417
0483	# 10	32	70	8	25	6	4.9	8	3	4.10	T692 0483
0635	1/4	28	80	10	30	7	5.5	8	3	5.50	T692 0635

UNF



Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #
0794	5/16	24	90	13	35	6	4.9	8	3	6.90	T692 0794
0953	3/8	24	90	15	39	7	5.5	8	3	8.50	T692 0953
1270	1/2	20	100	18	-	9	7	10	4	11.50	T692 1270
1588	5/8	18	100	20	-	12	9	12	4	14.50	T692 1588

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
T692	●	●	●	○		●	○			●		●	○	●	●		○	○	○	○	○	○	●	●	●	○	○	○	○																			

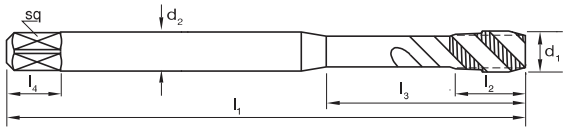
P Steel | M Stainless Steel | K Cast Iron | N Non-Ferrous Metals | S Titanium & Super Alloys | H Hard Materials

● Optimal ○ Effective

DIN Taps UNF, Spiral Flute, R45 VA DH

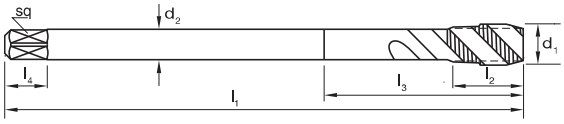
suttontools

- Use in stainless steels and high strength steels up to 1000N/mm²
- Blind holes
- Suitable for synchronous tapping in machine operations
- Depths up to approx. 3 x d_1



Catalogue Code	T276	T277
Discount Group	D0402	D0408
Material	HSSE	HSSE
Surface Finish	Blu	TiCN
Sutton Designation	VA DH	VA DH
Geometry	R45	R45
Chamfer	Form C/ 2.5 x P	Form C/ 2.5 x P
Limit & Nut Tolerance	2B	2B

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
0218	# 2	64	45	9	-	2.8	2.1	5	2	1.9	•	•
0251	# 3	56	50	9	-	2.8	2.1	5	2	2.1	•	•
0284	# 4	48	56	5	18	3.5	2.7	6	2	2.35	•	•
0318	# 5	44	56	6	18	3.5	2.7	6	3	2.65	•	•
0351	# 6	40	56	6	20	4.0	3.0	6	3	2.9	T276 0351	•
0417	# 8	36	63	7	21	4.5	3.4	6	3	3.5	T276 0417	•
0483	# 10	32	70	8	25	6.0	4.9	8	3	4.1	T276 0483	•
0549	# 12	28	80	10	30	6.0	4.9	8	3	4.6	•	•
0635	1/4	28	80	10	30	7.0	5.5	8	3	5.5	T276 0635	T277 0635
0794	5/16	24	90	13	35	8.0	6.2	9	3	6.9	T276 0794	T277 0794
0953	3/8	24	100	15	35	10.0	8.0	11	3	8.5	T276 0953	T277 0953



Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
1429	7/16	20	100	15	-	8.0	6.2	8	3	9.8	T276 1111	T277 1111
1270	1/2	20	110	18	-	9.0	7.0	10	3	11.5	T276 1270	T277 1270
1429	9/16	18	110	20	-	11.0	9.0	12	3	12.8	•	•
1588	5/8	18	110	20	-	12.0	9.0	12	3	14.5	T276 1588	T277 1588
1905	3/4	16	125	25	-	14.0	11.0	14	4	17.5	T276 1905	T277 1905
2223	7/8	14	140	28	-	18.0	14.5	17	4	20.5	T276 2223	T277 2223
2540	1	12	160	32	-	18.0	14.5	17	4	23.5	T276 2540	T277 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
T276	●	●	○			○	○					○		●	●	○																																		
T277	●	●	○	○		○	○	○		○		●		●	●	●							○	○	○	○		○		○			●		○														

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

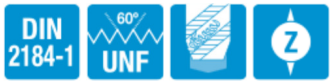
● Optimal ○ Effective

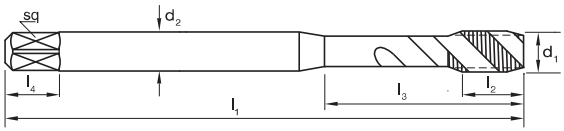
• Available on request as special manufacture. Subject to lead time.

UNF

suttontools

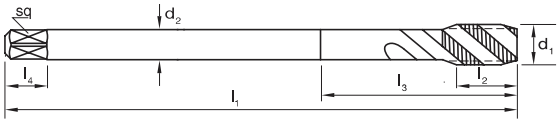
- PM-HSSE V3 offers superior tool life
- Use in stainless steels and high strength steels up to 850N/mm²
- Blind holes up to 3 x d_1
- Suitable for synchronous tapping in machine operations





Catalogue Code	T696
Discount Group	D0408
Material	PM-HSSE V3
Surface Finish	TiCN
Sutton Designation	VA PM
Geometry	R50
Chamfer	Form C/ 2.5 x P
Limit & Nut Tolerance	2BX

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #
0284	# 4	48	56	5	18	3.5	2.7	6	2	2.35	T696 0284
0351	# 6	40	56	6	20	4.0	3.0	6	3	2.9	T696 0351
0417	# 8	36	63	7	21	4.5	3.4	6	3	3.5	T696 0417
0483	# 10	32	70	8	25	6.0	4.9	8	3	4.1	T696 0483
0635	1/4	28	80	10	30	7.0	5.5	8	3	5.5	T696 0635



Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #
0794	5/16	24	90	13	-	6	4.9	8	3	6.90	T696 0794
0953	3/8	24	90	15	-	7	5.5	8	3	8.50	T696 0953
1270	1/2	20	100	18	-	9	7	10	4	11.50	T696 1270
1588	5/8	18	100	20	-	12	9	12	4	14.50	T696 1588

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
T696	●	●	●	○		●	○	○		○		●		●	●	●							○	○	○	○	○	○		●			●		●													

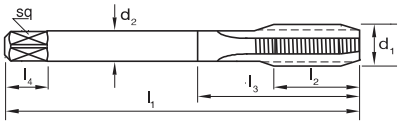
P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials

● Optimal ○ Effective

DIN Taps G (BSPF), Straight Flute, N

suttontools

- General Purpose use in materials up to approx. 1000 N/mm²
- Through & blind holes
- Suitable machine operations
- Depths up to approx. 1 x d_1



Catalogue Code	T304	T305
Discount Group	D0402	D0406
Material	HSSE	HSSE
Surface Finish	Brt	TiN
Sutton Designation	N	N
Geometry		
Chamfer	Form C/ 2.5 x P	Form C/ 2.5 x P
Limit & Nut Tolerance	ISO 228	ISO 228

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
0973	G1/8	28	90	20	-	7.0	5.5	8	4	8.8	T304 0973	T305 0973
1316	G1/4	19	100	22	-	11.0	9.0	12	4	11.8	T304 1316	T305 1316
1666	G3/8	19	100	22	-	12.0	9.0	12	4	15.3	T304 1666	T305 1666
2096	G1/2	14	125	25	-	16.0	12.0	15	4	19.0	T304 2096	T305 2096
2291	G5/8	14	125	25	-	18.0	14.5	17	4	21.0	T304 2291	T305 2291
2644	G3/4	14	140	28	-	20.0	16.0	19	4	24.5	T304 2644	T305 2644
3020	G7/8	14	150	28	-	22.0	18.0	21	4	28.5	T304 3020	T305 3020
3325	G1	11	160	30	-	25.0	20.0	23	4	31.0	T304 3325	T305 3325
3790	G1-1/8	11	170	30	-	28.0	22.0	25	4	35.5	T304 3790	•
4191	G1-1/4	11	170	30	-	32.0	24.0	27	6	39.5	T304 4191	•
4432	G1-3/8	11	180	32	-	36.0	29.0	32	6	42.0	•	•
4780	G1-1/2	11	190	32	-	36.0	29.0	32	6	45.5	T304 4780	•
5375	G1-3/4	11	190	32	-	40.0	32.0	35	6	51.0	•	•
5961	G2	11	220	40	-	45.0	35.0	38	6	57.0	•	•

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
T304	●	●	●	●	○	●	○	○		○													○	○	○	○		○	○	○																			
T305	●	●	●	●	○	●	○	○		○													○	○	○	○		○	○	○																			

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

● Optimal ○ Effective

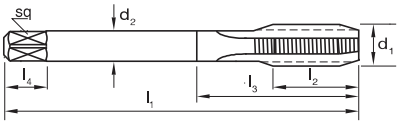
• Available on request as special manufacture. Subject to lead time.

G

DIN Taps G (BSPF), Straight Flute, GG

suttontools

- Use in grey cast iron (GG), brittle plastics, hard bronzes to a hardness of 850 N/mm²
- Through & blind holes
- Suitable machine operations
- Depths up to approx. 3 x d_1



Catalogue Code	T306	T307
Discount Group	D0402	D0408
Material	HSSE	HSSE
Surface Finish	Ni + Blu	TiCN
Sutton Designation	GG	GG
Geometry	Low Relief	Low Relief
Chamfer	Form C/ 2.5 x P	Form C/ 2.5 x P
Limit & Nut Tolerance	ISO 228	ISO 228

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
0973	G1/8	28	90	20	-	7.0	5.5	8	4	8.8	T306 0973	T307 0973
1316	G1/4	19	100	22	-	11.0	9.0	12	4	11.8	T306 1316	T307 1316
1666	G3/8	19	100	22	-	12.0	9.0	12	5	15.3	T306 1666	T307 1666
2096	G1/2	14	125	25	-	16.0	12.0	15	5	19.0	T306 2096	T307 2096
2291	G5/8	14	125	25	-	18.0	14.5	17	5	21.0	T306 2291	T307 2291
2644	G3/4	14	140	28	-	20.0	16.0	19	6	24.5	T306 2644	T307 2644
3020	G7/8	14	150	28	-	22.0	18.0	21	6	28.5	T306 3020	T307 3020
3325	G1	11	160	30	-	25.0	20.0	23	6	31.0	T306 3325	T307 3325

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
T306																	●	●	●	●	○	○																										
T307																	●	●	●	●	○	○					○																					

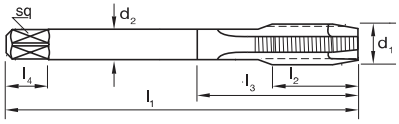
P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials

● Optimal ○ Effective

G

suttontools

- General Purpose use in materials up to approx. 1000 N/mm²
- Through holes
- Suitable machine operations
- Depths up to approx. 3 x d_1



Catalogue Code	T178	T179	T180
Discount Group	D0402	D0402	D0406
Material	HSSE	HSSE	HSSE
Surface Finish	Brt	Blu	TiN
Sutton Designation	N	N	N
Geometry			
Chamfer	Form B / 4.5 x P	Form B / 4.5 x P	Form B / 4.5 x P
Limit & Nut Tolerance	ISO 228	ISO 228	ISO 228

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #	Item #
0973	G1/8	28	90	20	-	7.0	5.5	8	3	8.8	T178 0973	T179 0973	T180 0973
1316	G1/4	19	100	22	-	11.0	9.0	12	3	11.8	T178 1316	T179 1316	T180 1316
1666	G3/8	19	100	22	-	12.0	9.0	12	3	15.3	T178 1666	T179 1666	T180 1666
2096	G1/2	14	125	25	-	16.0	12.0	15	3	19.0	T178 2096	T179 2096	T180 2096
2291	G5/8	14	125	25	-	18.0	14.5	17	4	21.0	T178 2291	T179 2291	T180 2291
2644	G3/4	14	140	28	-	20.0	16.0	19	4	24.5	T178 2644	T179 2644	T180 2644
3020	G7/8	14	150	28	-	22.0	18.0	21	4	28.5	T178 3020	T179 3020	T180 3020
3325	G1	11	160	30	-	25.0	20.0	23	4	31.0	T178 3325	T179 3325	T180 3325

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
T178	◐	◐	●	●		◐	●			●							●		●		●	●	◐	◐	●	●		●	●																				
T179	◐	◐	◐	◐		◐	◐			◐		●		●	●	●	●		●		●	●																											
T180	◐	◐	◐	◐	●	◐	◐	●		◐		●		●	●	●	●	●	●	●	●	●	◐	◐	●	●		◐	●																				

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

● Optimal ◐ Effective

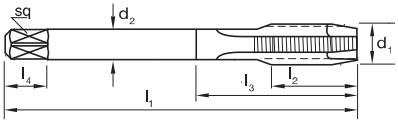
DIN Taps G (BSPF), Gun, Black Magic

suttontools BLACKMAGIC

watch the video

- Universal high performance tapping
- PM-HSSE V3 offers superior tool life
- Use in stainless steels and high strength steels up to 850N/mm²
- Through holes up to 3 x d_1
- Suitable for synchronous tapping in machine operations

DIN 5156 | 55° G | Z



Catalogue Code	T700
Discount Group	D0410
Material	PM-HSSE V3
Surface Finish	HARDLUBE
Sutton Designation	UNI
Geometry	Special Relief
Chamfer	Form B / 4.5 x P
Limit & Nut Tolerance	ISO 228

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #
0973	G1/8	28	90	20	-	7.0	5.5	8	3	8.8	T700 0973
1316	G1/4	19	100	22	-	11.0	9.0	12	3	11.8	T700 1316
1666	G3/8	19	100	22	-	12.0	9.0	12	3	15.3	T700 1666
2096	G1/2	14	125	25	-	16.0	12.0	15	3	19.0	T700 2096
2291	G5/8	14	125	25	-	18.0	14.5	17	4	21.0	T700 2291
2644	G3/4	14	140	28	-	20.0	16.0	19	5	24.5	T700 2644
3020	G7/8	14	150	28	-	22.0	18.0	21	5	28.5	T700 3020
3325	G1	11	160	30	-	25.0	20.0	23	5	31.0	T700 3325

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
T700	●	●	●	○		●	○			●		●	○	●	●		○	○	○	○	○	○	●	●	●	○	○	○	○	○																		

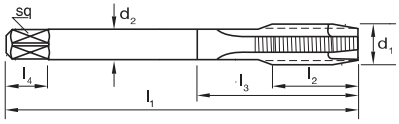
P Steel | M Stainless Steel | K Cast Iron | N Non-Ferrous Metals | S Titanium & Super Alloys | H Hard Materials

● Optimal ○ Effective

G

suttontools

- Use in stainless steels and high strength steels up to 1000N/mm²
- Through holes
- Suitable machine operations
- Depths up to approx. 3 x d_1



Catalogue Code	T181	T182
Discount Group	D0402	D0408
Material	HSSE	HSSE
Surface Finish	Blu	TiCN
Sutton Designation	VA	VA
Geometry	Special Relief	Special Relief
Chamfer	Form B / 4.5 x P	Form B / 4.5 x P
Limit & Nut Tolerance	ISO 228	ISO 228

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
0973	G1/8	28	90	20	-	7.0	5.5	8	3	8.8	T181 0973	T182 0973
1316	G1/4	19	100	22	-	11.0	9.0	12	3	11.8	T181 1316	T182 1316
1666	G3/8	19	100	22	-	12.0	9.0	12	3	15.3	T181 1666	T182 1666
2096	G1/2	14	125	25	-	16.0	12.0	15	3	19.0	T181 2096	T182 2096
2291	G5/8	14	125	25	-	18.0	14.5	17	4	21.0	T181 2291	T182 2291
2644	G3/4	14	140	28	-	20.0	16.0	19	4	24.5	T181 2644	T182 2644
3020	G7/8	14	150	28	-	22.0	18.0	21	4	28.5	T181 3020	T182 3020
3325	G1	11	160	30	-	25.0	20.0	23	4	31.0	T181 3325	T182 3325

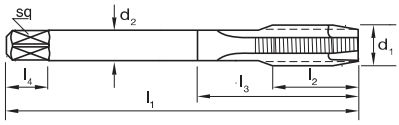
ISO	P													M			K						N										S												H					
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T181	◐	◐	○	○		◐	○					○		◐	◐	○																																		
T182	◐	◐	○	○		◐	○			○		◐	○	◐	◐	◐							○	○	○	○	○	○		○			◐	○	○														

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

◐ Optimal ○ Effective

suttontools

- Use in stainless steels and high strength steels up to 1000N/mm²
- PM-HSSE V3 offers higher edge hardness than standard VA series
- Through holes
- Suitable for synchronous tapping in machine operations
- Depths up to approx. 3 x d_1



Catalogue Code	T349	T350
Discount Group	D0402	D0408
Material	PM-HSSE V3	PM-HSSE V3
Surface Finish	Blu	TiCN
Sutton Designation	VA PM	VA PM
Geometry	Special Relief	Special Relief
Chamfer	Form B / 4.5 x P	Form B / 4.5 x P
Limit & Nut Tolerance	ISO 228	ISO 228

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
0973	G1/8	28	90	20	-	7.0	5.5	8	3	8.8	T349 0973	T350 0973
1316	G1/4	19	100	22	-	11.0	9.0	12	3	11.8	T349 1316	T350 1316
1666	G3/8	19	100	22	-	12.0	9.0	12	3	15.3	T349 1666	T350 1666
2096	G1/2	14	125	25	-	16.0	12.0	15	3	19.0	T349 2096	T350 2096
2291	G5/8	14	125	25	-	18.0	14.5	17	4	21.0	T349 2291	T350 2291
2644	G3/4	14	140	28	-	20.0	16.0	19	5	24.5	T349 2644	T350 2644
3020	G7/8	14	150	28	-	22.0	18.0	21	5	28.5	T349 3020	T350 3020
3325	G1	11	160	30	-	25.0	20.0	23	5	31.0	T349 3325	T350 3325

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
T349	●	●	○	○		●	○			○		○		●	●	●																																
T350	●	●	○	○		●	○			○		●	○	●	●	●							○	○	○	○	○	○		○			●	●	●													

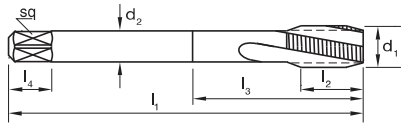
P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials

○ Optimal ● Effective

DIN Taps G (BSPF), Spiral Flute, R15N

suttontools

- General purpose use, materials up to approx. 1000 N/mm²
- Blind holes
- Suitable for machine operations
- Depths up to approx. 1.5 x d_1



Catalogue Code	T278	T279
Discount Group	D0402	D0406
Material	HSSE	HSSE
Surface Finish	Brt	TiN
Sutton Designation	N	N
Geometry	R15	R15
Chamfer	Form C/ 2.5 x P	Form C/ 2.5 x P
Limit & Nut Tolerance	ISO 228	ISO 228

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
0973	G1/8	28	90	20	-	7.0	5.5	8	3	8.8	T278 0973	T279 0973
1316	G1/4	19	100	22	-	11.0	9.0	12	3	11.8	T278 1316	T279 1316
1666	G3/8	19	100	22	-	12.0	9.0	12	3	15.3	T278 1666	T279 1666
2096	G1/2	14	125	25	-	16.0	12.0	15	4	19.0	T278 2096	T279 2096
2291	G5/8	14	125	25	-	18.0	14.5	17	4	21.0	T278 2291	T279 2291
2644	G3/4	14	140	28	-	20.0	16.0	19	5	24.5	T278 2644	T279 2644
3020	G7/8	14	150	28	-	22.0	18.0	21	5	28.5	T278 3020	T279 3020
3325	G1	11	160	30	-	25.0	20.0	23	5	31.0	T278 3325	T279 3325

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
T278	●	●	○	○		●	○			○							○		○		○	○	●	●	○	○		○	○																				
T279	●	●	●	●	○	●	●	○		●		○		○	○	○	○	○	○	○	○	○	●	●	○	○		○	○																				

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

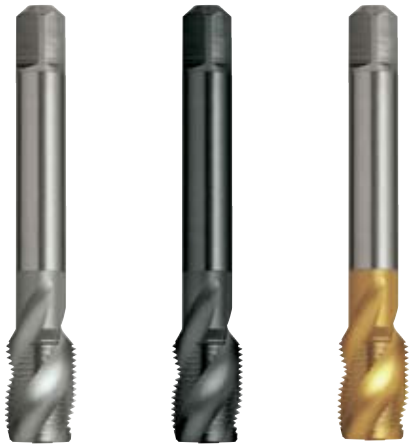
● Optimal ○ Effective

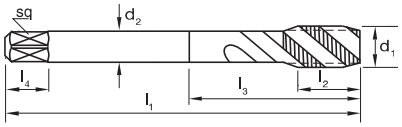
G

DIN Taps G (BSPF), Spiral Flute, R40 N

suttontools

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





Catalogue Code	T281	T282	T283
Discount Group	D0402	D0402	D0406
Material	HSSE	HSSE	HSSE
Surface Finish	Brt	Blu	TiN
Sutton Designation	N	N	N
Geometry	R40	R40	R40
Chamfer	Form C/ 2.5 x P	Form C/ 2.5 x P	Form C/ 2.5 x P
Limit & Nut Tolerance	ISO 228	ISO 228	ISO 228

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #	Item #
0973	G1/8	28	90	20	-	7.0	5.5	8	3	8.8	T281 0973	T282 0973	T283 0973
1316	G1/4	19	100	22	-	11.0	9.0	12	3	11.8	T281 1316	T282 1316	T283 1316
1666	G3/8	19	100	22	-	12.0	9.0	12	3	15.3	T281 1666	T282 1666	T283 1666
2096	G1/2	14	125	25	-	16.0	12.0	15	4	19.0	T281 2096	T282 2096	T283 2096
2291	G5/8	14	125	25	-	18.0	14.5	17	4	21.0	T281 2291	T282 2291	T283 2291
2644	G3/4	14	140	28	-	20.0	16.0	19	4	24.5	T281 2644	T282 2644	T283 2644
3020	G7/8	14	150	28	-	22.0	18.0	21	4	28.5	T281 3020	T282 3020	T283 3020
3325	G1	11	160	30	-	25.0	20.0	23	4	31.0	T281 3325	T282 3325	T283 3325
3790	G1-1/8	11	170	30	-	28.0	22.0	25	4	35.5	•	•	•
4191	G1-1/4	11	170	30	-	32.0	24.0	27	6	39.5	•	•	•
4432	G1-3/8	11	180	32	-	36.0	29.0	32	6	42.0	•	•	•
4780	G1-1/2	11	190	32	-	36.0	29.0	32	6	45.5	•	•	•

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
T281	●	●	○	○		●	○			○							○		○		○	○	●	●	○	○		○	○																				
T282	●	●	●	●		●	●			●		○		○	○	○	○		○		○	○																										
T283	●	●	●	●	○	●	●	○		●		○		○	○	○	○	○	○	○	○	○	●	●	○	○		●	○																				

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.

G

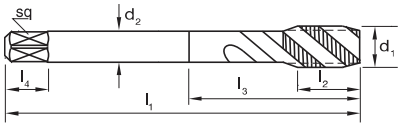
DIN Taps G(BSPF), Spiral Flute, R50 Black Magic

suttontools BLACKMAGIC

watch the video

- Universal high performance tapping
- PM-HSSE V3 offers superior tool life
- Use in stainless steels and high strength steels up to 850N/mm²
- Blind holes up to 3 x d_1
- Suitable for synchronous tapping in machine operations

DIN 5156 | 55° G | Z | HSC



Catalogue Code	T699
Discount Group	D0410
Material	PM-HSSE V3
Surface Finish	HARDLUBE
Sutton Designation	UNI
Geometry	R50
Chamfer	Form C/ 2.5 x P
Limit & Nut Tolerance	ISO 228

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #
0973	G1/8	28	90	20	-	7.0	5.5	8	4	8.8	T699 0973
1316	G1/4	19	100	22	-	11.0	9.0	12	4	11.8	T699 1316
1666	G3/8	19	100	22	-	12.0	9.0	12	5	15.3	T699 1666
2096	G1/2	14	125	25	-	16.0	12.0	15	5	19.0	T699 2096
2291	G5/8	14	125	25	-	18.0	14.5	17	5	21.0	T699 2291
2644	G3/4	14	140	28	-	20.0	16.0	19	5	24.5	T699 2644
3020	G7/8	14	150	28	-	22.0	18.0	21	5	28.5	T699 3020
3325	G1	11	160	30	-	25.0	20.0	23	5	31.0	T699 3325

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
T699	●	●	●	○		●	○			●		●	○	●	●		○	○	○	○	○	○	●	●	●	○	○	○	○																				

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

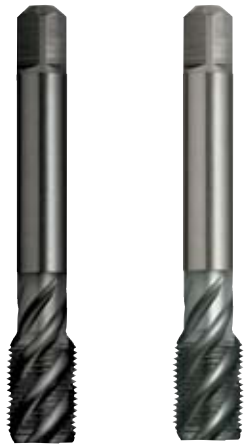
● Optimal ○ Effective

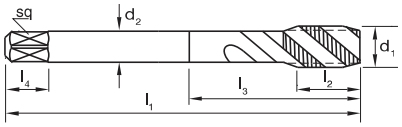
G

DIN Taps G (BSPF), Spiral Flute, R45 VA

suttontools

- Use in stainless steels and high strength steels up to 1000N/mm²
- Blind holes
- Suitable for synchronous tapping in machine operations
- Depths up to approx. 3 x d_1





Catalogue Code	T284	T285
Discount Group	D0402	D0408
Material	HSSE	HSSE
Surface Finish	Blu	TiCN
Sutton Designation	VA	VA
Geometry	R45	R45
Chamfer	Form C/ 2.5 x P	Form C/ 2.5 x P
Limit & Nut Tolerance	ISO 228	ISO 228

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
0973	G1/8	28	90	20	-	7.0	5.5	8	4	8.8	T284 0973	T285 0973
1316	G1/4	19	100	22	-	11.0	9.0	12	4	11.8	T284 1316	T285 1316
1666	G3/8	19	100	22	-	12.0	9.0	12	5	15.3	T284 1666	T285 1666
2096	G1/2	14	125	25	-	16.0	12.0	15	5	19.0	T284 2096	T285 2096
2291	G5/8	14	125	25	-	18.0	14.5	17	5	21.0	T284 2291	T285 2291
2644	G3/4	14	140	28	-	20.0	16.0	19	5	24.5	T284 2644	T285 2644
3020	G7/8	14	150	28	-	22.0	18.0	21	5	28.5	T284 3020	T285 3020
3325	G1	11	160	30	-	25.0	20.0	23	5	31.0	T284 3325	T285 3325

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
T284	●	●	○			○	○					○		●	●	○																																	
T285	●	●	○	○		○	○	○		○		●		●	●	●							○	○	○	○		○		○			●		○														

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

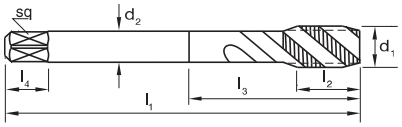
● Optimal ○ Effective

G

DIN Taps G (BSPF), Spiral Flute, R50 VA PM

suttontools

- Use in stainless steels and high strength steels up to 1000N/mm²
- PM-HSSE V3 offers higher edge hardness than standard VA series
- Blind holes
- Suitable for machine operations
- Depths up to approx. 3 x d_1



Catalogue Code	T351	T352
Discount Group	D0402	D0408
Material	PM-HSSE V3	PM-HSSE V3
Surface Finish	Blu	TiCN
Sutton Designation	VA PM	VA PM
Geometry	R50	R50
Chamfer	Form C/ 2.5 x P	Form C/ 2.5 x P
Limit & Nut Tolerance	ISO 228	ISO 228

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
0973	G1/8	28	90	20	-	7.0	5.5	8	4	8.8	T351 0973	T352 0973
1316	G1/4	19	100	22	-	11.0	9.0	12	4	11.8	T351 1316	T352 1316
1666	G3/8	19	100	22	-	12.0	9.0	12	5	15.3	T351 1666	T352 1666
2096	G1/2	14	125	25	-	16.0	12.0	15	5	19.0	T351 2096	T352 2096
2291	G5/8	14	125	25	-	18.0	14.5	17	5	21.0	T351 2291	T352 2291
2644	G3/4	14	140	28	-	20.0	16.0	19	5	24.5	T351 2644	T352 2644
3020	G7/8	14	150	28	-	22.0	18.0	21	5	28.5	T351 3020	T352 3020
3325	G1	11	160	30	-	25.0	20.0	23	5	31.0	T351 3325	T352 3325

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
T351	◐	◐	◐			◐	○					○		◐	◐	○																																		
T352	◐	◐	◐	○		◐	○	○		○		◐		◐	◐	◐							○	○	○	○	○	○		○			◐		◐														

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

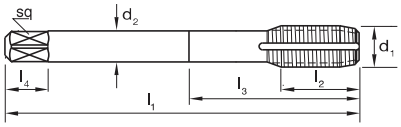
○ Optimal ◐ Effective

G

DIN Taps G(BSPF), Forming, Multi Coolant Groove

suttontools

- For cold forming of threads in materials with good flow characteristics
  Brt - For non-ferrous materials
  TiCN - Suitable for abrasive and difficult materials
- Through or blind holes
- Suitable for machine operations
- Depths up to approx. 3 x d_1



Catalogue Code	T361	T363
Discount Group	D0402	D0408
Material	HSSE	HSSE
Surface Finish	Brt	TiCN
Sutton Designation	N	N
Geometry	Multi Groove	Multi Groove
Chamfer	Form C/ 2.5 x P	Form C/ 2.5 x P
Limit & Nut Tolerance	ISO 228 X	ISO 228 X

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #	Item #
0973	G1/8	28	90	20	-	7.0	5.5	8		9.25	T361 0973	T363 0973
1316	G1/4	19	100	22	-	11.0	9.0	12		12.5	T361 1316	T363 1316
1666	G3/8	19	100	22	-	12.0	9.0	12		16.0	T361 1666	T363 1666
2096	G1/2	14	125	25	-	16.0	12.0	15		20.0	T361 2096	T363 2096
2291	G5/8	14	125	25	-	18.0	14.5	17		22.0	T361 2291	T363 2291
2644	G3/4	14	140	28	-	20.0	16.0	19		25.5	T361 2644	T363 2644
3020	G7/8	14	150	28	-	22.0	18.0	21		29.25	•	•
3325	G1	11	160	30	-	25.0	20.0	23		32.0	•	•

G

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
T361	◐	◐	●	◐		●								◐									◐	◐	●	●		●		●																			
T363	◐	◐	◐	◐		◐								◐									◐	◐	●	●		◐		●																			

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

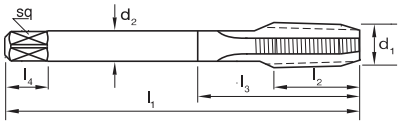
● Optimal ◐ Effective

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

DIN Taps NPT, Straight Flute, UNI

suttontools

- Universal use.
- Suitable for materials up to 1000N/mm²
- Through & blind holes



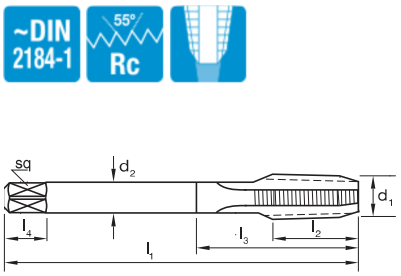
Catalogue Code	T308
Discount Group	D0402
Material	HSSE
Surface Finish	Brt
Sutton Designation	UNI
Geometry	1:16 Taper
Chamfer	Form C/ 2.5 x P
Limit & Nut Tolerance	ANSI B1.20.1

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #
1029	1/8	27	90	20	-	7.0	5.5	8	4	8.2	T308 1029
1372	1/4	18	100	22	-	11.0	9.0	12	4	10.8	T308 1372
1716	3/8	18	100	22	-	12.0	9.0	12	4	14.0	T308 1716
2134	1/2	14	125	25	-	16.0	12.0	15	4	17.5	T308 2134
2667	3/4	14	140	28	-	20.0	16.0	19	4	23.0	T308 2667
3340	1	11.5	160	30	-	25.0	20.0	23	5	28.5	T308 3340
4216	1-1/4	11.5	170	30	-	32.0	24.0	27	5	37.0	•

DIN Taps RC (BSPT), Straight Flute, UNI

suttontools

- Universal use.
- Suitable for materials up to 1000N/mm²
- Through & blind holes



Catalogue Code	T808
Discount Group	D0402
Material	HSSE
Surface Finish	Brt
Sutton Designation	UNI
Geometry	1:16 Taper
Chamfer	Form C/ 2.5 x P
Limit & Nut Tolerance	ANSI B1.20.1

Size Ref.	d_1	TPI	l_1	l_2	l_3	d_2	sq	l_4	z	drill Ø	Item #
0973	1/8	28	90	15	-	7.0	5.5	8	4	8.4	T808 0973
1316	1/4	19	100	22	-	11.0	9.0	12	4	10.8	T808 1316
1666	3/8	19	100	22	-	12.0	9.0	12	4	14.5	T808 1666
2096	1/2	14	125	28	-	16.0	12.0	15	4	18.0	T808 2096
2644	3/4	14	140	28	-	20.0	16.0	19	4	23.0	T808 2644
3325	1	11	160	32	-	25.0	20.0	23	5	29.0	T808 3325

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
T308	◐	◐	◐	◐	○	◐	◐	○		○		○	○	○	○	○	○		○		○	○	◐	◐	○	○		◐	○	○																			
T808	◐	◐	◐	◐	○	◐	◐	○		○		○	○	○	○	○	○		○		○	○	◐	◐	○	○		◐	○	○																			

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.