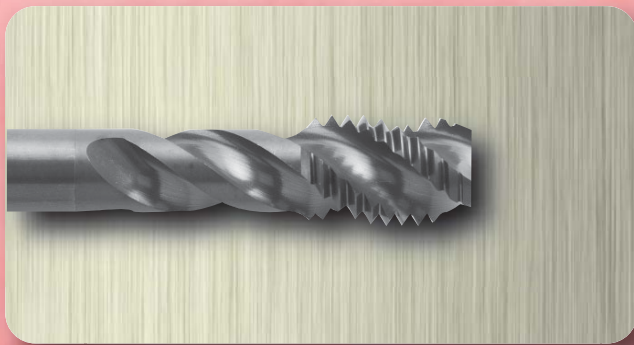


VTP SERIES PREMIUM VANADIUM HSS GENERAL PURPOSE TAPS



Spiral Fluted Taps
Machine Screw #2 - #10
Fractional 1/4" - 1"
Metric M3 - M18

VTP Series Taps:

- Made from HSSE-V for longer tapping action
- Steam oxide maximizes the cooling effect to make rigorous tapping easy
- Recommended for a wide variety of materials



Spiral Pointed Taps
Machine Screw #2 - #10
Fractional 1/4" - 1"
Metric M3 - M18

VTP SPIRAL FLUTED

List No. 983 Machine Screw Sizes



List No. 981 Fractional Sizes



VANADIUM HIGH SPEED STEEL HSSE-V

Modified Bottoming Style 2-1/2 To 3 Thread Lead
Surface Treated



Nominal Size	Thread/Inch		No. of Flutes	E.D.P. Numbers						Dimensions			List Price
	NC UNC	NF UNF		H2	H3	H4	H5	H6	H7	Overall Length	Length of Thread	Shank Dia.	
2	56		2	88239	—	—	—	—	—	1 3/4	0.433	0.141	63.40
3	48		2	88240	—	—	—	—	—	1 13/16	0.500	0.141	47.06
4	40		2	88241	88242	88243	—	—	—	1 7/8	0.236	0.141	36.21
5	40		3	88253	—	—	—	—	—	1 15/16	0.236	0.141	36.21
6	32		3	—	88263	88264	88265	88266	88267	2	0.276	0.141	29.30
8	32		3	—	88277	88278	88279	88280	88281	2 1/8	0.276	0.168	29.30
10	24		3	—	88291	—	88292	88293	88294	2 3/8	0.354	0.194	29.30
		32	3	—	88299	88300	88301	—	88303	2 3/8	0.354	0.194	29.30

Nominal Size	Thread/Inch		No. of Flutes	E.D.P. Numbers						Dimensions			List Price
	NC UNC	NF UNF		H2	H3	H4	H5	H6	H7	Overall Length	Length of Thread	Shank Dia.	
1/4	20		3	—	88057	—	88060	—	88062	2 1/2	0.433	0.255	31.70
5/16	18	28	3	—	88071	88072	88073	88074	88075	2 1/2	0.433	0.255	31.70
		24	3	—	88081	—	88083	—	88085	2 23/32	0.472	0.318	37.48
3/8	16	24	3	—	88095	88096	88097	—	88098	2 23/32	0.472	0.318	37.48
		24	3	—	88103	—	88105	—	88107	2 15/16	0.551	0.381	43.94
7/16	14	24	3	—	88111	88112	88113	—	88115	2 15/16	0.551	0.381	43.94
		20	3	—	88117	—	88119	—	—	3 5/32	0.591	0.323	64.65
1/2	13	20	3	—	88123	—	88125	—	—	3 5/32	0.591	0.323	64.65
		20	3	—	88131	—	88133	—	88135	3 3/8	0.630	0.367	78.70
9/16	12	20	3	—	88139	—	88141	—	—	3 3/8	0.630	0.367	78.70
		18	3	—	88145	—	—	—	—	3 19/32	0.709	0.429	112.13
5/8	11	18	3	—	88146	—	—	—	—	3 19/32	0.709	0.429	112.13
		18	3	—	88149	—	88151	—	88153	3 13/16	0.748	0.480	134.32
3/4	10	18	3	—	88157	—	88159	—	—	3 13/16	0.748	0.480	134.32
		16	3	—	88167	—	—	—	88171	4 1/4	0.827	0.590	170.12
7/8	9	16	3	—	88175	—	88177	—	—	4 1/4	0.827	0.590	170.12
		14	4	—	88180	—	—	—	—	4 11/16	0.906	0.697	226.34
1	8	14	4	—	88185	—	—	—	—	4 11/16	0.906	0.697	226.34
		14	4	—	88190	—	—	—	—	5 1/8	0.984	0.800	313.61

SFM: Surface Feet per Minutes

VTP Series Cutting Conditions

Work Materials		Tapping Speed SFM
Low Carbon Steel	1010,1018	25-50
Medium Carbon Steel	1035,1045	20-50
High Carbon Steel	1065,1095	15-30
Alloy Steel	4140,4130	15-30
Die Steels	D2,H13	15-35
Hardened Die Steels(20-40HRC)	D2,H13	8-15
Stainless steel (Austenitic)	303,304,316	15-45
Stainless steel (Martensitic)	410,430	12-20
Stainless steel (PH) up to 35HRC	17-4PH	12-20
Titanium Alloy Up to 32HRC	6AL4V	15-20
Magnesium Alloy		40-80
Ductile cast Irons	80-55-06	20-50
Cast Irons	Nodular,Grey	30-65
Copper		30-60
Brass, Brass casting		60-100
Bronze, Brass casting		40-60

1. These are general tapping conditions, may be altered by your condition.
2. These conditions are for tapping depth 15D. In case of deeper thread you may multiply these values by the coefficient of next table

Thread depth	Coefficient
Up to 1.5D	1
1.5D ~ 2.5D	0.9
2.5D ~ 3D	0.8
Over 3D	0.7

TAPS

VTP SPIRAL POINTED

List No. 973 Machine Screw Sizes



Plug Style 4 to 5 Threads
Surface Treated

List No. 971 Fractional Sizes



Plug Style 4 to 5 Threads
Surface Treated

VANADIUM HIGH SPEED STEEL HSSE-V



Nominal Size	Thread/Inch		No. of Flutes	E.D.P. Numbers						Dimensions			List Price
	NC UNC	NF UNF		H2	H3	H4	H5	H6	H7	Overall Length	Length of Thread	Shank Dia.	
2	56		2	87216	87218	—	—	—	—	13/4	0.437	0.141	35.78
3	48		2	87220	—	—	—	—	—	1 13/16	0.500	0.141	35.78
4	40		2	87240	87242	87243	87244	—	—	1 7/8	0.354	0.141	23.95
5	40		2	87252	—	—	—	—	—	1 15/16	0.394	0.141	23.95
6	32		2	87258	87260	87261	87264	87265	87266	2	0.433	0.141	20.43
8	32		3	87272	87274	87275	87278	87279	87280	2 1/8	0.472	0.168	20.43
10	24		3	—	87288	—	87290	—	—	2 3/8	0.551	0.194	20.43
		32	3	87294	87296	87297	87300	87301	87302	2 3/8	0.551	0.194	20.43

Nominal Size	Thread/Inch		No. of Flutes	E.D.P. Numbers						Dimensions			List Price
	NC UNC	NF UNF		H2	H3	H4	H5	H6	H7	Overall Length	Length of Thread	Shank Dia.	
1/4	20		3	87052	87056	—	87060	—	87062	2 1/2	0.591	0.255	21.41
		28	3	87066	87068	87070	87071	87072	87073	2 1/2	0.591	0.255	21.41
5/16	18		3	—	87080	—	87084	—	87086	2 23/32	0.669	0.318	25.92
		24	3	—	87094	87096	87097	87098	87099	2 23/32	0.669	0.318	25.92
3/8	16		3	—	87102	—	87104	—	87106	2 15/16	0.748	0.381	29.59
		24	3	—	87110	87112	87113	87114	87115	2 15/16	0.748	0.381	29.59
7/16	14		3	—	87116	—	87120	—	—	3 5/32	0.866	0.323	40.53
		20	3	—	87122	—	87126	87127	87129	3 5/32	0.866	0.323	40.53
1/2	13		3	—	87130	—	87134	—	87136	3 3/8	0.984	0.367	46.60
		20	3	—	87138	—	87140	87141	87142	3 3/8	0.984	0.367	46.60
9/16	12		3	—	87143	—	—	—	—	3 19/32	0.984	0.429	74.11
		18	3	—	87144	—	—	—	—	3 19/32	0.984	0.429	74.11
5/8	11		3	—	87148	—	87152	—	87154	3 13/16	1.102	0.480	85.21
		18	3	—	87158	—	87159	—	—	3 13/16	1.102	0.480	85.21
3/4	10		3	—	87164	—	—	—	87167	4 1/4	1.181	0.590	125.89
		16	3	—	87168	—	87169	—	—	4 1/4	1.181	0.590	125.89
7/8	9		3	—	87170	—	—	—	—	4 11/16	1.299	0.697	168.64
		14	3	—	87171	—	—	—	—	4 11/16	1.299	0.697	168.64
1	8		3	—	87172	—	—	—	—	5 1/8	1.378	0.800	238.17

SFM: Surface Feet per Minutes

VTP Series Cutting Conditions

Work Materials		Tapping Speed SFM
Low Carbon Steel	1010,1018	25-50
Medium Carbon Steel	1035,1045	20-50
High Carbon Steel	1065,1095	15-30
Alloy Steel	4140,4130	15-30
Die Steels	D2,H13	15-35
Hardened Die Steels(20-40HRC)	D2,H13	8-15
Stainless steel (Austenitic)	303,304,316	15-45
Stainless steel (Martensitic)	410,430	12-20
Stainless steel (PH) up to 35HRC	17-4PH	12-20
Titanium Alloy Up to 32HRC	6AL4V	15-20
Magnesium Alloy		40-80
Ductile cast Irons	80-55-06	20-50
Cast Irons	Nodular,Grey	30-65
Copper		30-60
Brass, Brass casting		60-100
Bronze, Brass casting		40-60

1. These are general tapping conditions, may be altered by your condition.
2. These conditions are for tapping depth 15D. In case of deeper thread you may multiply these values by the coefficient of next table

Thread depth	Coefficient
Up to 1.5D	1
1.5D ~ 2.5D	0.9
2.5D ~ 3D	0.8
Over 3D	0.7

TAPS

VTP METRIC TAPS SPIRAL FLUTED VTP METRIC TAPS SPIRAL POINTED

List No. 980

Modified Bottoming Style 2-1/2 To 3 Thread Lead

VANADIUM HIGH SPEED STEEL HSSE-V



Surface Treated - Spiral Fluted



Nominal Size (mm)	Pitch (mm)	No. Of Flutes	E.D.P. Number					Dimensions			List Price
			D3	D4	D5	D6	D7	Overall Length	Length of Thread	Shank Dia.	
3	0.5	3	54615	—	—	—	—	1 15/16	0.236	0.141	37.70
3.5	0.6	3	—	54616	—	—	—	2	0.276	0.141	34.75
4	0.7	3	—	54617	—	—	—	2 1/8	0.276	0.168	34.75
5	0.8	3	—	54619	—	—	—	2 3/8	0.354	0.194	34.75
6	1	3	—	—	54620	—	—	2 1/2	0.433	0.255	35.02
7	1	3	—	—	54621	—	—	2 23/32	0.472	0.318	39.05
8	1	3	—	—	54622	—	—	2 23/32	0.472	0.318	39.05
8	1.25	3	—	—	54623	—	—	2 23/32	0.472	0.318	39.05
10	1.25	3	—	—	54624	—	—	2 15/16	0.551	0.381	61.69
10	1.5	3	—	—	—	54625	—	2 15/16	0.551	0.381	61.69
12	1.25	3	—	—	54626	—	—	3 3/8	0.630	0.367	69.46
12	1.75	3	—	—	—	54627	—	3 3/8	0.630	0.367	69.46
14	1.5	3	—	—	—	54628	—	3 19/32	0.551	0.429	113.55
14	2	3	—	—	—	—	54629	3 19/32	0.709	0.429	113.55
16	1.5	3	—	—	—	54630	—	3 13/16	0.551	0.480	133.56
16	2	3	—	—	—	—	54631	3 13/16	0.709	0.480	133.56
18	1.5	3	—	—	—	54632	—	4 1/32	0.551	0.542	193.02
18	2.5	3	—	—	—	—	54633	4 1/32	0.874	0.542	193.02

List No. 982

Plug Style, 4 To 5 Thread Lead

VANADIUM HIGH SPEED STEEL HSSE-V



Surface Treated - Spiral Pointed



Nominal Size (mm)	Pitch (mm)	No. Of Flutes	E.D.P. Number					Dimensions			List Price
			D3	D4	D5	D6	D7	Overall Length	Length of Thread	Shank Dia.	
3	0.5	3	52615	—	—	—	—	1 15/16	0.394	0.141	26.30
3.5	0.6	3	—	52616	—	—	—	2	0.433	0.141	23.21
4	0.7	3	—	52617	—	—	—	2 1/8	0.472	0.168	23.21
5	0.8	3	—	52619	—	—	—	2 3/8	0.551	0.194	23.21
6	1	3	—	—	52620	—	—	2 1/2	0.591	0.255	24.55
7	1	3	—	—	52621	—	—	2 23/32	0.669	0.318	26.97
8	1	3	—	—	52622	—	—	2 23/32	0.669	0.318	26.97
8	1.25	3	—	—	52623	—	—	2 23/32	0.669	0.318	26.97
10	1.25	3	—	—	52624	—	—	2 15/16	0.748	0.381	41.00
10	1.5	3	—	—	—	52625	—	2 15/16	0.748	0.381	41.00
12	1.25	3	—	—	52626	—	—	3 3/8	0.984	0.367	47.20
12	1.75	3	—	—	—	52627	—	3 3/8	0.984	0.367	47.20
14	1.5	3	—	—	—	52628	—	3 19/32	0.984	0.429	76.08
14	2	3	—	—	—	—	52629	3 19/32	0.984	0.429	76.08
16	1.5	3	—	—	—	52630	—	3 13/16	1.102	0.480	92.42
16	2	3	—	—	—	—	52631	3 13/16	1.102	0.480	92.42
18	1.5	3	—	—	—	52632	—	4 1/32	1.102	0.542	129.48
18	2.5	3	—	—	—	—	52633	4 1/32	1.102	0.542	129.48



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