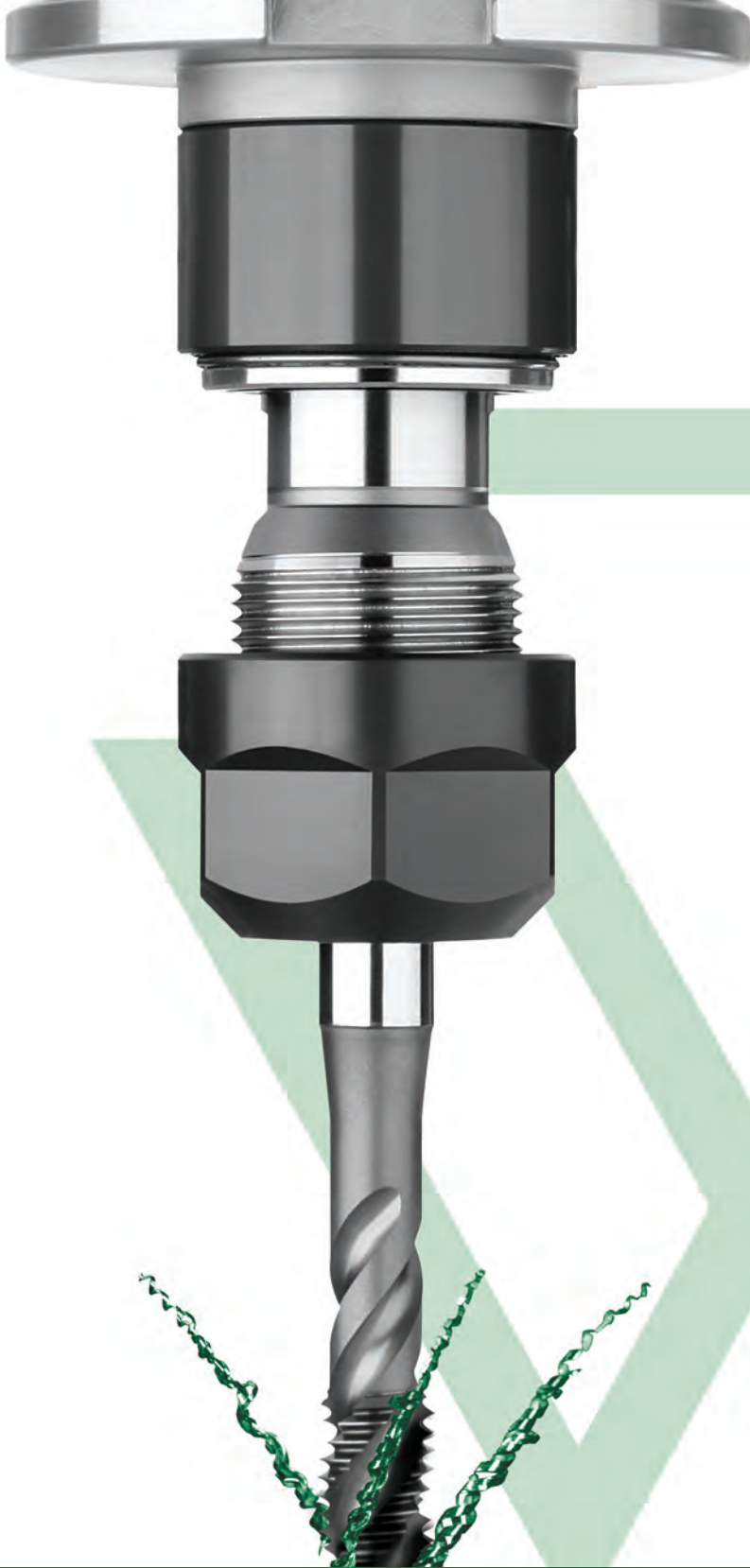


ADVANCES VariTap 2015



ADVANCES

VariTap™

| High-Performance Solution for Multipurpose Tapping

Distributed by:



Industrial Tooling Corporation Ltd.

WIDIA ™

High-Performance Taps

VariTap™ Technical Information

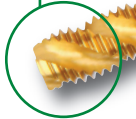


High-Performance Taps

Multipurpose Tap for Steel, Stainless Steel, Cast Aluminium, and Ductile Iron



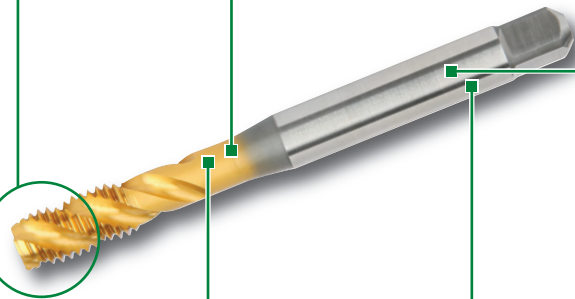
Advanced spiral flute design
Smooth ejection of chips to reduce or eliminate bird-nesting.



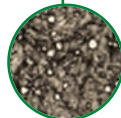
PVD coatings and surface treatments
For use with various workpiece materials:

WP42EG TiCN	WU41EG TiN	WP49EG Oxide	WU40EG Bright
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Multiple tap dimension options
ANSI, DIN, JIS, and DIN/ANSI.



Precision ground shanks
Low runout.



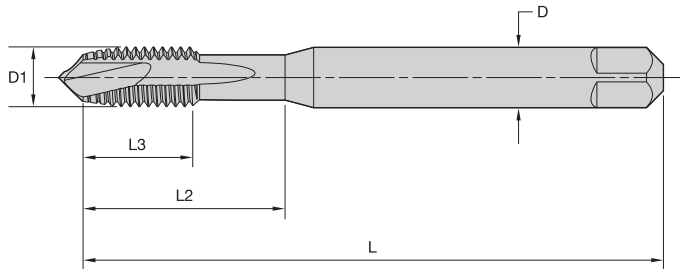
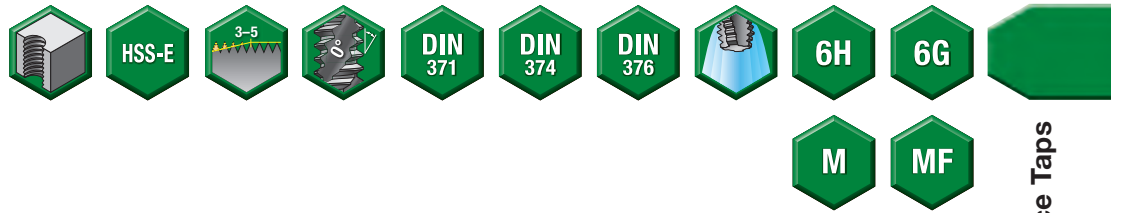
High-vanadium HSS-E
Improved wear resistance and longer life.



High-Performance Taps

VariTap™ Spiral Point HSS-E Taps • Through Holes

- WP42EG TiCN
- WU41EG TiN
- WP49EG oxide
- WU40EG bright



Shank Tolerance	
D mm	tolerance h9
1-3	+0, -0,025
>3-6	+0, -0,030
>6-10	+0, -0,036
>10-18	+0, -0,043
>18-30	+0, -0,052

High-Performance Taps

■ VT-SPO • Form B Chamfer • Metric DIN 371, 374, and 376

WP42EG TiCN		WU41EG TiN		WP49EG Oxide		WU40EG Bright		metric dimensions					class of fit
WP42EG	Price	WU41EG	Price	WP49EG	Price	WU40EG	Price	D1 size	L	L3	L2	D	
—	—	—	—	VTSP06506	£13.45	—	—	M2 X 0,4	45	7	13	2,8	6G
VTSP06505	£17.75	VTSP06505	£16.10	VTSP06505	£12.90	VTSP06505	£12.90	M2 X 0,4	45	7	13	2,8	6H
—	—	—	—	VTSP06507	£12.90	—	—	M2,2 X 0,45	45	7	13	2,8	6H
—	—	—	—	VTSP06509	£14.15	—	—	M2,5 X 0,45	50	7	15	2,8	6G
—	—	VTSP06508	£16.90	VTSP06508	£13.50	VTSP06508	£13.50	M2,5 X 0,45	50	7	15	2,8	6H
—	—	—	—	VTSP06545	£19.10	VTSP06545	£19.10	M3 X 0,35	56	8	—	2,2	6H
—	—	—	—	VTSP06511	£12.80	—	—	M3 X 0,5	56	8	18	3,5	6G
VTSP06510	£16.75	VTSP06510	£15.25	VTSP06510	£12.15	VTSP06510	£12.15	M3 X 0,5	56	8	18	3,5	6H
—	—	VTSP06525	£17.95	VTSP06525	£14.35	VTSP06525	£14.35	M3 X 0,5	56	8	—	2,2	6H
—	—	VTSP06512	£14.75	VTSP06512	£11.80	VTSP06512	£11.80	M3,5 X 0,6	56	9	20	4,0	6H
—	—	—	—	VTSP06546	£19.25	VTSP06546	£19.25	M4 X 0,5	63	10	21	2,8	6H
—	—	—	—	VTSP06514	£12.35	—	—	M4 X 0,7	63	11	21	4,5	6G
VTSP06513	£16.25	VTSP06513	£14.75	VTSP06513	£11.80	VTSP06513	£11.80	M4 X 0,7	63	11	21	4,5	6H
—	—	VTSP06526	£17.45	VTSP06526	£13.90	VTSP06526	£13.90	M4 X 0,7	63	10	21	2,8	6H
—	—	—	—	VTSP06547	£20.00	VTSP06547	£20.00	M5 X 0,5	70	12	25	3,5	6H
—	—	—	—	VTSP06516	£13.05	—	—	M5 X 0,8	70	12	25	6,0	6G
VTSP06515	£17.05	VTSP06515	£15.55	VTSP06515	£12.40	VTSP06515	£12.40	M5 X 0,8	70	12	25	6,0	6H
—	—	VTSP06527	£18.30	VTSP06527	£14.60	VTSP06527	£14.60	M5 X 0,8	70	12	25	3,5	6H
—	—	—	—	VTSP06548	£21.00	VTSP06548	£21.00	M6 X 0,5	80	12	30	4,5	6H
—	—	—	—	VTSP06549	£21.00	VTSP06549	£21.00	M6 X 0,75	80	12	30	4,5	6H
—	—	—	—	VTSP06518	£13.05	—	—	M6 X 1	80	12	30	6,0	6G
VTSP06517	£17.05	VTSP06517	£15.55	VTSP06517	£12.40	VTSP06517	£12.40	M6 X 1	80	12	30	6,0	6H
—	—	VTSP06528	£18.30	VTSP06528	£14.60	VTSP06528	£14.60	M6 X 1	80	12	30	4,5	6H
—	—	—	—	VTSP06550	£21.95	VTSP06550	£21.95	M7 X 0,75	80	12	30	5,5	6H
—	—	—	—	VTSP06520	£14.35	—	—	M7 X 1	80	12	30	7,0	6G
VTSP06519	£18.85	VTSP06519	£17.20	VTSP06519	£13.75	VTSP06519	£13.75	M7 X 1	80	12	30	7,0	6H
—	—	—	—	VTSP06551	£21.95	VTSP06551	£21.95	M8 X 0,75	80	12	30	6,0	6H
—	—	—	—	VTSP06552	£21.95	VTSP06552	£21.95	M8 X 1	90	15	35	6,0	6H
—	—	—	—	VTSP06522	£14.35	—	—	M8 X 1,25	90	15	35	8,0	6G
VTSP06521	£18.85	VTSP06521	£17.20	VTSP06521	£13.75	VTSP06521	£13.75	M8 X 1,25	90	15	35	8,0	6H
—	—	VTSP06529	£20.20	VTSP06529	£16.15	VTSP06529	£16.15	M8 X 1,25	90	15	35	6,0	6H
—	—	—	—	VTSP06553	£22.30	VTSP06553	£22.30	M10 X 0,75	90	15	35	7,0	6H

(continued)



High-Performance Taps

VariTap™ Spiral Point HSS-E Taps • Through Holes



(VT-SPO • Form B Chamfer • Metric DIN 371, 374, and 376 continued)

High-Performance Taps

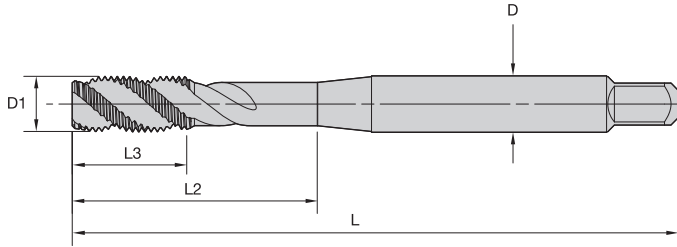
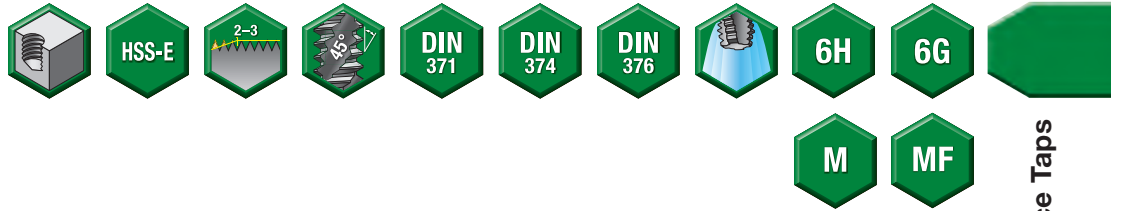
WP42EG TiCN		WU41EG TiN		WP49EG Oxide		WU40EG Bright		metric dimensions					class of fit
WP42EG	Price	WU41EG	Price	WP49EG	Price	WU40EG	Price	D1 size	L	L3	L2	D	
—	—	—	—	VTSP06554	£22.30	VTSP06554	£22.30	M10 X 1	90	15	35	7,0	6H
—	—	—	—	VTSP06555	£22.30	VTSP06555	£22.30	M10 X 1,25	100	18	39	7,0	6H
—	—	—	—	VTSP06524	£17.00	—	—	M10 X 1,5	100	18	39	10,0	6G
VTSP06523	£22.35	VTSP06523	£20.35	VTSP06523	£16.25	VTSP06523	£16.25	M10 X 1,5	100	18	39	10,0	6H
—	—	VTSP06530	£23.90	VTSP06530	£19.10	VTSP06530	£19.10	M10 X 1,5	100	18	39	7,0	6H
—	—	—	—	VTSP06556	£24.30	VTSP06556	£24.30	M11 X 1	90	15	36	8,0	6H
—	—	—	—	VTSP06557	£24.30	VTSP06557	£24.30	M12 X 1	100	21	39	9,0	6H
—	—	—	—	VTSP06558	£24.30	VTSP06558	£24.30	M12 X 1,25	100	21	39	9,0	6H
—	—	—	—	VTSP06559	£24.30	VTSP06559	£24.30	M12 X 1,5	100	21	39	9,0	6H
—	—	—	—	VTSP06532	£23.75	—	—	M12 X 1,75	110	21	44	9,0	6G
VTSP06531	£31.20	VTSP06531	£28.30	VTSP06531	£22.65	VTSP06531	£22.65	M12 X 1,75	110	21	44	9,0	6H
—	—	—	—	VTSP06560	£32.40	VTSP06560	£32.40	M14 X 1	100	21	47	11,0	6H
—	—	—	—	VTSP06561	£32.40	VTSP06561	£32.40	M14 X 1,25	100	21	47	11,0	6H
—	—	—	—	VTSP06562	£32.40	VTSP06562	£32.40	M14 X 1,5	100	21	47	11,0	6H
—	—	—	—	VTSP06534	£31.45	—	—	M14 X 2	110	24	52	11,0	6G
VTSP06533	£41.15	VTSP06533	£37.35	VTSP06533	£29.90	VTSP06533	£29.90	M14 X 2	110	24	52	11,0	6H
—	—	—	—	VTSP06563	£34.90	VTSP06563	£34.90	M16 X 1	100	21	46	12,0	6H
—	—	—	—	VTSP06564	£34.90	VTSP06564	£34.90	M16 X 1,5	100	21	46	12,0	6H
—	—	—	—	VTSP06536	£34.15	—	—	M16 X 2	110	24	51	12,0	6G
VTSP06535	£44.75	VTSP06535	£40.65	VTSP06535	£32.50	VTSP06535	£32.50	M16 X 2	110	24	51	12,0	6H
—	—	—	—	VTSP06565	£48.15	VTSP06565	£48.15	M18 X 1	110	21	50	14,0	6H
—	—	—	—	VTSP06566	£48.15	VTSP06566	£48.15	M18 X 1,5	110	21	50	14,0	6H
—	—	—	—	VTSP06567	£48.15	VTSP06567	£48.15	M18 X 2	125	30	58	14,0	6H
VTSP06537	£64.10	VTSP06537	£58.30	VTSP06537	£46.60	VTSP06537	£46.60	M18 X 2,5	125	30	58	14,0	6H
—	—	—	—	VTSP06568	£53.50	VTSP06568	£53.50	M20 X 1	125	24	56	16,0	6H
—	—	—	—	VTSP06569	£53.50	VTSP06569	£53.50	M20 X 1,5	125	24	56	16,0	6H
—	—	—	—	VTSP06570	£53.50	VTSP06570	£53.50	M20 X 2	140	30	64	16,0	6H
VTSP06538	£68.30	VTSP06538	£62.20	VTSP06538	£49.70	VTSP06538	£49.70	M20 X 2,5	140	30	64	16,0	6H
—	—	—	—	VTSP06571	£72.60	VTSP06571	£72.60	M22 X 1,5	125	24	62	18,0	6H
—	—	—	—	—	—	VTSP06572	£72.60	M22 X 2	140	30	70	18,0	6H
VTSP06539	£88.40	VTSP06539	£80.40	VTSP06539	£64.30	VTSP06539	£64.30	M22 X 2,5	140	30	70	18,0	6H
—	—	—	—	VTSP06573	£73.30	VTSP06573	£73.30	M24 X 1,5	140	28	67	18,0	6H
—	—	—	—	—	—	VTSP06574	£73.30	M24 X 2	140	30	67	18,0	6H
VTSP06540	£90.60	VTSP06540	£82.10	VTSP06540	£65.70	VTSP06540	£65.70	M24 X 3	160	36	77	18,0	6H
—	—	VTSP06541	£117.50	VTSP06541	£94.60	VTSP06541	94.60	M27 X 3	160	36	82	20,0	6H
—	—	—	—	—	—	VTSP06575	£126.00	M30 X 2	150	28	80	22,0	6H
—	—	VTSP06542	£139.50	VTSP06542	£112.00	VTSP06542	£112.00	M30 X 3,5	180	42	91	22,0	6H
—	—	—	—	VTSP06543	£156.50	—	—	M33 X 3,5	180	42	100	25,0	6H
—	—	—	—	VTSP06544	£175.00	—	—	M36 X 4	200	48	110	28,0	6H



High-Performance Taps

VariTap™ Spiral Flute HSS-E Taps • Blind Holes

- WP42EG TiCN
- WU41EG TiN
- WP49EG oxide
- WU40EG bright



Shank Tolerance	
D mm	tolerance h9
1-3	+0, -0,025
>3-6	+0, -0,030
>6-10	+0, -0,036
>10-18	+0, -0,043
>18-30	+0, -0,052

High-Performance Taps

■ VT-SFT • Form C Chamfer • Metric DIN 371, 374, and 376

WP42EG TiCN		WU41EG TiN		WP49EG Oxide		WU40EG Bright		metric dimensions					class of fit
WP42EG	Price	WU41EG	Price	WP49EG	Price	WU40EG	Price	D1 size	L	L3	L2	D	
-	-	-	-	VTSFT6507	£15.95	-	-	M2 X 0,4	45	7	13	2,8	6G
VTSFT6506	£20.90	VTSFT6506	£18.95	VTSFT6506	£15.20	VTSFT6506	£15.20	M2 X 0,4	45	7	13	2,8	6H
-	-	-	-	VTSFT6508	£15.20	-	-	M2,2 X 0,45	45	7	13	2,8	6H
-	-	-	-	VTSFT6510	£16.65	-	-	M2,5 X 0,45	50	7	15	2,8	6G
-	-	VTSFT6509	£19.90	VTSFT6509	£15.90	VTSFT6509	£15.90	M2,5 X 0,45	50	7	15	2,8	6H
-	-	-	-	VTSFT6545	£22.00	-	-	M3 X 0,35	56	8	-	2,2	6H
-	-	-	-	VTSFT6512	£15.10	-	-	M3 X 0,5	56	8	18	3,5	6G
VTSFT6511	£19.75	VTSFT6511	£17.95	VTSFT6511	£14.35	VTSFT6511	£14.35	M3 X 0,5	56	8	18	3,5	6H
-	-	-	-	VTSFT6525	£16.55	VTSFT6525	£16.55	M3 X 0,5	56	8	-	2,2	6H
-	-	VTSFT6513	£17.45	VTSFT6513	£13.90	VTSFT6513	£13.90	M3,5 X 0,6	56	9	20	4,0	6H
-	-	-	-	VTSFT6515	£14.60	-	-	M4 X 0,7	63	11	21	4,5	6G
-	-	-	-	VTSFT6546	£22.25	VTSFT6546	£22.25	M4 X 0,5	63	10	21	2,8	6H
VTSFT6514	£19.15	VTSFT6514	£17.45	VTSFT6514	£13.90	VTSFT6514	£13.90	M4 X 0,7	63	11	21	4,5	6H
-	-	-	-	VTSFT6526	£16.05	VTSFT6526	£16.05	M4 X 0,7	63	10	21	2,8	6H
-	-	-	-	VTSFT6547	£22.95	VTSFT6547	£22.95	M5 X 0,5	70	12	25	3,5	6H
-	-	-	-	VTSFT6517	£15.35	-	-	M5 X 0,8	70	12	25	6,0	6G
VTSFT6516	£20.10	VTSFT6516	£18.30	VTSFT6516	£14.60	VTSFT6516	£14.60	M5 X 0,8	70	12	25	6,0	6H
-	-	-	-	VTSFT6527	£16.80	VTSFT6527	£16.80	M5 X 0,8	70	12	25	3,5	6H
-	-	-	-	VTSFT6548	£24.20	-	-	M6 X 0,5	80	12	30	4,5	6H
-	-	-	-	VTSFT6549	£24.20	VTSFT6549	£24.20	M6 X 0,75	80	12	30	4,5	6H
-	-	-	-	VTSFT6519	£15.35	-	-	M6 X 1	80	12	30	6,0	6G
VTSFT6518	£20.10	VTSFT6518	£18.30	VTSFT6518	£14.60	VTSFT6518	£14.60	M6 X 1	80	12	30	6,0	6H
-	-	-	-	VTSFT6528	£16.80	VTSFT6528	£16.80	M6 X 1	80	12	30	4,5	6H
-	-	-	-	VTSFT6520	£16.15	VTSFT6520	£16.15	M7 X 1	80	12	30	7,0	6H
-	-	-	-	VTSFT6550	£25.25	VTSFT6550	£25.25	M8 X 0,75	80	12	30	6,0	6H
VTSFT6551	£34.65	-	-	VTSFT6551	£25.25	VTSFT6551	£25.25	M8 X 1	90	15	35	6,0	6H
-	-	-	-	VTSFT6522	£16.95	-	-	M8 X 1,25	90	15	35	8,0	6G
VTSFT6521	£22.25	VTSFT6521	£20.50	VTSFT6521	£16.15	VTSFT6521	£16.15	M8 X 1,25	90	15	35	8,0	6H
-	-	-	-	VTSFT6529	£18.60	VTSFT6529	£18.60	M8 X 1,25	90	15	35	6,0	6H
-	-	-	-	-	-	VTSFT6552	£25.60	M10 X 0,75	90	15	35	7,0	6H
-	-	-	-	VTSFT6553	£25.60	VTSFT6553	£25.60	M10 X 1	90	15	35	7,0	6H
VTSFT6554	£35.15	-	-	VTSFT6554	£25.60	VTSFT6554	£25.60	M10 X 1,25	100	18	39	7,0	6H

(continued)



High-Performance Taps

VariTap™ Spiral Flute HSS-E Taps • Blind Holes



(VT-SFT • Form C Chamfer • Metric DIN 371, 374, and 376 continued)

High-Performance Taps

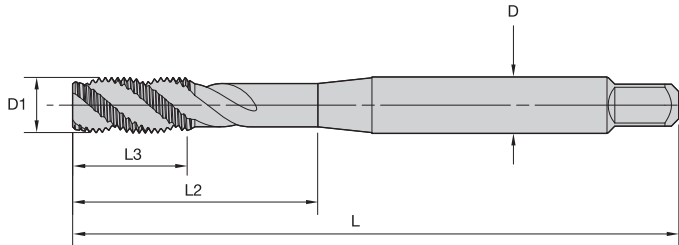
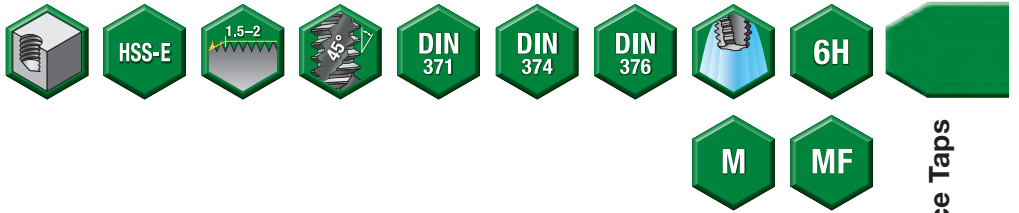
WP42EG TiCN		WU41EG TiN		WP49EG Oxide		WU40EG Bright		metric dimensions					class of fit
WP42EG	Price	WU41EG	Price	WP49EG	Price	WU40EG	Price	D1 size	L	L3	L2	D	
—	—	—	—	VTSFT6524	£20.10	—	—	M10 X 1,5	100	18	39	10,0	6G
VTSFT6523	£26.35	VTSFT6523	£23.90	VTSFT6523	£19.10	VTSFT6523	£19.10	M10 X 1,5	100	18	39	10,0	6H
—	—	—	—	VTSFT6530	£22.00	VTSFT6530	£22.00	M10 X 1,5	100	18	39	7,0	6H
—	—	—	—	VTSFT6555	£27.95	VTSFT6555	£27.95	M12 X 1	100	21	39	9,0	6H
—	—	—	—	VTSFT6556	£27.95	VTSFT6556	£27.95	M12 X 1,25	100	21	39	9,0	6H
VTSFT6557	£38.40	—	—	VTSFT6557	£27.95	VTSFT6557	£27.95	M12 X 1,5	100	21	39	9,0	6H
—	—	—	—	VTSFT6532	£27.20	—	—	M12 X 1,75	110	21	44	9,0	6G
VTSFT6531	£35.80	VTSFT6531	£32.55	VTSFT6531	£26.00	VTSFT6531	£26.00	M12 X 1,75	110	21	44	9,0	6H
—	—	—	—	—	—	VTSFT6558	£37.20	M14 X 1	100	21	47	11,0	6H
—	—	—	—	—	—	VTSFT6559	£37.20	M14 X 1,25	100	21	47	11,0	6H
VTSFT6560	£51.20	—	—	VTSFT6560	£37.20	VTSFT6560	£37.20	M14 X 1,5	100	21	47	11,0	6H
—	—	—	—	VTSFT6534	£35.90	—	—	M14 X 2	110	24	52	11,0	6G
VTSFT6533	£47.25	VTSFT6533	£43.05	VTSFT6533	£34.40	VTSFT6533	£34.40	M14 X 2	110	24	52	11,0	6H
—	—	—	—	—	—	VTSFT6561	£40.20	M16 X 1	100	21	46	12,0	6H
—	—	—	—	VTSFT6562	£40.20	VTSFT6562	£40.20	M16 X 1,5	100	21	46	12,0	6H
—	—	—	—	VTSFT6536	£39.00	—	—	M16 X 2	110	24	51	12,0	6G
—	—	VTSFT6535	£46.70	VTSFT6535	£37.35	VTSFT6535	£37.35	M16 X 2	110	24	51	12,0	6H
—	—	—	—	—	—	VTSFT6563	£55.30	M18 X 1	110	21	50	14,0	6H
—	—	—	—	VTSFT6564	£55.30	VTSFT6564	£55.30	M18 X 1,5	110	21	50	14,0	6H
—	—	—	—	—	—	VTSFT6565	£55.30	M18 X 2	125	30	58	14,0	6H
—	—	VTSFT6537	£67.00	VTSFT6537	£53.60	VTSFT6537	£53.60	M18 X 2,5	125	30	58	14,0	6H
—	—	—	—	—	—	VTSFT6566	£61.40	M20 X 1	125	24	56	16,0	6H
—	—	—	—	VTSFT6567	£61.40	VTSFT6567	£61.40	M20 X 1,5	125	24	56	16,0	6H
—	—	—	—	—	—	VTSFT6568	£61.40	M20 X 2	140	30	64	16,0	6H
—	—	VTSFT6538	£71.40	VTSFT6538	£57.20	VTSFT6538	£57.20	M20 X 2,5	140	30	64	16,0	6H
—	—	—	—	VTSFT6569	£83.50	VTSFT6569	£83.50	M22 X 1,5	125	24	62	18,0	6H
—	—	—	—	—	—	VTSFT6570	£83.50	M22 X 2	140	30	70	18,0	6H
—	—	VTSFT6539	£92.40	VTSFT6539	£73.90	VTSFT6539	£73.90	M22 X 2,5	140	30	70	18,0	6H
—	—	—	—	VTSFT6571	£84.30	VTSFT6571	£84.30	M24 X 1,5	140	28	67	18,0	6H
—	—	—	—	—	—	VTSFT6572	£84.30	M24 X 2	140	28	67	18,0	6H
—	—	VTSFT6540	£94.60	VTSFT6540	£75.60	VTSFT6540	£75.60	M24 X 3	160	36	77	18,0	6H
—	—	VTSFT6541	£135.50	VTSFT6541	£108.50	VTSFT6541	£108.50	M27 X 3	160	36	82	20,0	6H
—	—	—	—	—	—	VTSFT6573	£144.50	M30 X 2	150	28	80	22,0	6H
—	—	VTSFT6542	£161.00	VTSFT6542	£128.50	VTSFT6542	£128.50	M30 X 3,5	180	42	91	22,0	6H
—	—	—	—	VTSFT6543	£179.00	VTSFT6543	£179.00	M33 X 3,5	180	42	100	25,0	6H
—	—	—	—	VTSFT6544	£197.50	VTSFT6544	£197.50	M36 X 4	200	48	110	28,0	6H



High-Performance Taps

VariTap™ Spiral Flute HSS-E Taps • Blind Holes

- WP42EG TiCN
- WP49EG oxide



High-Performance Taps

Shank Tolerance	
D mm	tolerance h9
1-3	+0, -0,025
>3-6	+0, -0,030
>6-10	+0, -0,036
>10-18	+0, -0,043
>18-30	+0, -0,052

■ VT-SFT • Form E Bottoming Chamfer • Metric DIN 371, 374, and 376

WP42EG TiCN		WP49EG Oxide		metric dimensions					class of fit
WP42EG	Price	WP49EG	Price	D1 size	L	L3	L2	D	
VTSFT6574	£19.75	VTSFT6574	£14.35	M3 X 0,5	56	8	18	3,5	6H
VTSFT6575	£19.15	VTSFT6575	£13.90	M4 X 0,7	63	11	21	4,5	6H
VTSFT6576	£20.10	VTSFT6576	£14.60	M5 X 0,8	70	12	25	6,0	6H
VTSFT6577	£20.10	VTSFT6577	£14.60	M6 X 1	80	12	30	6,0	6H
VTSFT6585	£34.65	VTSFT6585	£25.25	M8 X 1	90	15	35	6,0	6H
VTSFT6578	£22.25	VTSFT6578	£16.15	M8 X 1,25	90	15	35	8,0	6H
VTSFT6586	£35.15	VTSFT6586	£25.60	M10 X 1,25	100	18	39	7,0	6H
VTSFT6579	£26.35	VTSFT6579	£19.10	M10 X 1,5	100	18	39	10,0	6H
VTSFT6587	£38.40	VTSFT6587	£27.95	M12 X 1,5	110	21	44	9,0	6H
VTSFT6580	£35.80	VTSFT6580	£26.00	M12 X 1,75	110	21	44	9,0	6H
VTSFT6588	£51.20	VTSFT6588	£37.20	M14 X 1,5	110	24	52	11,0	6H
VTSFT6581	£47.25	VTSFT6581	£34.40	M14 X 2	110	24	52	11,0	6H
—	—	VTSFT6582	£37.35	M16 X 2	110	24	51	12,0	6H
VTSFT6583	£73.70	VTSFT6583	£53.60	M18 X 2,5	125	30	58	14,0	6H
VTSFT6584	£78.50	VTSFT6584	£57.20	M20 X 2,5	140	30	64	16,0	6H



High-Performance Taps

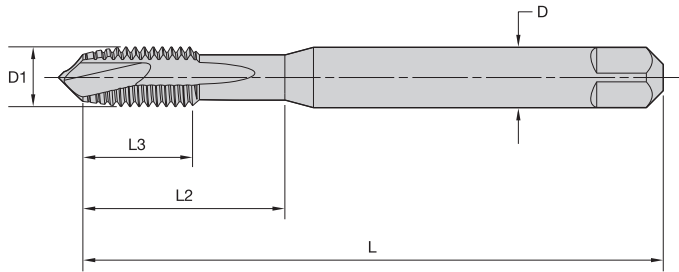
VariTap™ Spiral Point HSS-E Taps • Through Holes



- WU41EG TiN
- WP49EG oxide



High-Performance Taps



Shank Tolerance	
D mm	tolerance h9
1-3	+0, -0,025
>3-6	+0, -0,030
>6-10	+0, -0,036
>10-18	+0, -0,043
>18-30	+0, -0,052

■ VT-SPO • Form B Chamfer • DIN 371 and 376

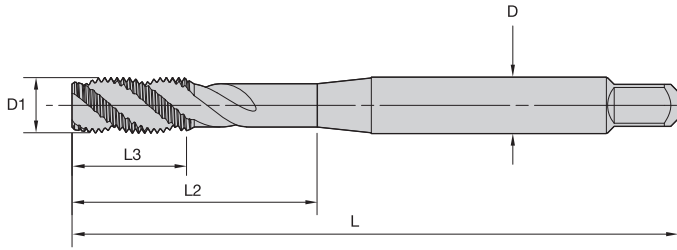
WU41EG TiN		WP49EG Oxide		metric dimensions					class of fit
WU41EG	Price	WP49EG	Price	D1 size	L	L3	L2	D	
VTSP06005	£17.95	VTSP06005	£14.35	4 - 40	56	8	18	3,5	2B
VTSP06007	£17.95	VTSP06007	£14.35	5 - 40	56	9	20	4,0	2B
VTSP06008	£17.45	VTSP06008	£13.90	6 - 32	56	9	20	4,0	2B
VTSP06010	£24.15	VTSP06010	£19.25	6 - 40	56	9	20	4,0	2B
VTSP06011	£17.45	VTSP06011	£13.90	8 - 32	63	11	21	4,5	2B
VTSP06013	£18.30	VTSP06013	£14.60	10 - 24	70	12	25	6,0	2B
VTSP06014	£25.00	VTSP06014	£20.00	10 - 32	70	12	25	6,0	2B
VTSP06016	£18.30	VTSP06016	£14.60	1/4 - 20	80	15	30	7,0	2B
VTSP06017	£26.35	VTSP06017	£21.00	1/4 - 28	80	15	30	7,0	2B
VTSP06019	£20.20	VTSP06019	£16.15	5/16 - 18	90	15	35	8,0	2B
VTSP06020	£27.45	VTSP06020	£21.95	5/16 - 24	90	15	35	8,0	2B
VTSP06022	£23.90	VTSP06022	£19.10	3/8 - 16	100	19	39	10,0	2B
VTSP06023	£27.85	VTSP06023	£22.30	3/8 - 24	100	19	39	10,0	2B
VTSP06025	£28.30	VTSP06025	£22.65	7/16 - 14	100	18	41	8,0	2B
VTSP06026	£30.35	VTSP06026	£24.30	7/16 - 20	100	18	41	8,0	2B
VTSP06028	£28.30	VTSP06028	£22.65	1/2 - 13	110	23	47	9,0	2B
VTSP06029	£30.35	VTSP06029	£24.30	1/2 - 20	110	23	47	9,0	2B
VTSP06031	£37.35	VTSP06031	£29.30	9/16 - 12	110	25	53	11,0	2B
VTSP06032	£40.45	VTSP06032	£32.40	9/16 - 18	110	25	53	11,0	2B
VTSP06033	£40.65	VTSP06033	£32.50	5/8 - 11	110	24	51	12,0	2B
VTSP06034	£43.65	VTSP06034	£34.90	5/8 - 18	110	24	51	12,0	2B
VTSP06035	£62.20	VTSP06035	£49.70	3/4 - 10	140	30	64	16,0	2B
VTSP06036	£66.80	VTSP06036	£53.50	3/4 - 16	140	30	64	16,0	2B
VTSP06037	£80.40	VTSP06037	£64.30	7/8 - 9	140	34	71	18,0	2B
VTSP06038	£91.00	VTSP06038	£72.60	7/8 - 14	140	34	71	18,0	2B
VTSP06039	£97.70	VTSP06039	£78.40	1 - 8	160	38	81	18,0	2B
VTSP06040	£123.00	VTSP06040	£98.60	1 - 12	160	38	81	18,0	2B



High-Performance Taps

VariTap™ Spiral Flute HSS-E Taps • Blind Holes

- WU41EG TiN
- WP49EG oxide



High-Performance Taps

Shank Tolerance	
D mm	tolerance h9
1-3	+0, -0,025
>3-6	+0, -0,030
>6-10	+0, -0,036
>10-18	+0, -0,043
>18-30	+0, -0,052

■ VT-SFT • Form C Chamfer • DIN 371 and 376

WU41EG TiN		WP49EG Oxide		metric dimensions					class of fit
WU41EG	Price	WP49EG	Price	D1 size	L	L3	L2	D	
VTSFT6005	£21.55	VTSFT6005	£17.25	4 - 40	56	8	18	3,5	2B
VTSFT6007	£21.55	VTSFT6007	£17.25	5 - 40	56	9	20	4,0	2B
VTSFT6008	£20.90	VTSFT6008	£16.70	6 - 32	56	9	20	4,0	2B
VTSFT6010	£29.00	VTSFT6010	£23.20	6 - 40	56	9	20	4,0	2B
VTSFT6011	£20.90	VTSFT6011	£16.70	8 - 32	63	11	21	4,5	2B
VTSFT6013	£21.95	VTSFT6013	£17.55	10 - 24	70	12	25	6,0	2B
VTSFT6014	£29.95	VTSFT6014	£23.95	10 - 32	70	12	25	6,0	2B
VTSFT6016	£21.95	VTSFT6016	£17.55	1/4 - 20	80	15	30	7,0	2B
VTSFT6017	£31.60	VTSFT6017	£25.25	1/4 - 28	80	15	30	7,0	2B
VTSFT6019	£24.25	VTSFT6019	£19.35	5/16 - 18	90	15	35	8,0	2B
VTSFT6020	£32.95	VTSFT6020	£26.35	5/16 - 24	90	15	35	8,0	2B
VTSFT6022	£28.75	VTSFT6022	£22.95	3/8 - 16	100	19	39	10,0	2B
VTSFT6023	£33.40	VTSFT6023	£26.75	3/8 - 24	100	19	39	10,0	2B
VTSFT6025	£36.80	VTSFT6025	£29.45	7/16 - 14	100	18	41	8,0	2B
VTSFT6026	£39.45	VTSFT6026	£31.65	7/16 - 20	100	18	41	8,0	2B
VTSFT6028	£36.80	VTSFT6028	£29.45	1/2 - 13	110	23	40	9,0	2B
VTSFT6029	£39.45	VTSFT6029	£31.65	1/2 - 20	110	23	40	9,0	2B
VTSFT6031	£48.70	VTSFT6031	£38.90	9/16 - 12	110	25	32	11,0	2B
VTSFT6032	£52.70	VTSFT6032	£42.05	9/16 - 18	110	25	32	11,0	2B
VTSFT6033	£52.90	VTSFT6033	£42.30	5/8 - 11	110	24	35	12,0	2B
VTSFT6034	£56.80	VTSFT6034	£45.35	5/8 - 18	110	24	35	12,0	2B
VTSFT6035	£80.80	VTSFT6035	£64.60	3/4 - 10	140	30	46	16,0	2B
VTSFT6036	£86.90	VTSFT6036	£69.40	3/4 - 16	140	30	46	16,0	2B
VTSFT6037	£104.50	VTSFT6037	£83.50	7/8 - 9	140	34	35	18,0	2B
VTSFT6038	£117.50	VTSFT6038	£94.60	7/8 - 14	140	34	35	18,0	2B
VTSFT6039	£127.50	VTSFT6039	£102.00	1 - 8	160	38	41	18,0	2B
VTSFT6040	£161.00	VTSFT6040	£128.50	1 - 12	160	38	41	18,0	2B



High-Performance Taps

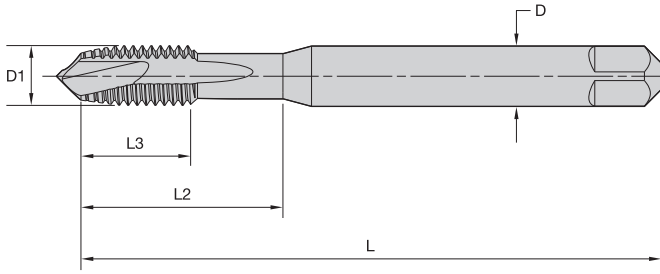
VariTap™ Spiral Point HSS-E Taps • Through Holes • Blind Holes



- WU41EG TiN
- WP49EG oxide

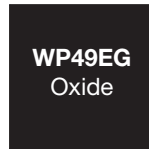


High-Performance Taps



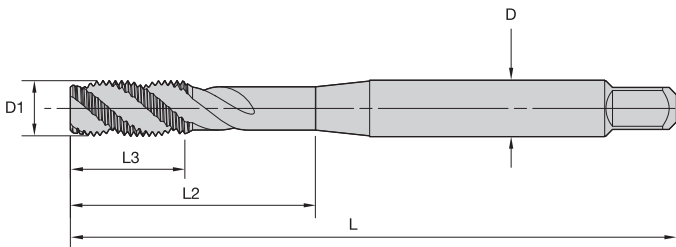
Shank Tolerance	
D mm	tolerance h9
1-3	+0, -0,025
>3-6	+0, -0,030
>6-10	+0, -0,036
>10-18	+0, -0,043
>18-30	+0, -0,052

■ VT-SPO • Form B Plug Chamfer • UNJC/UNJF • Inch DIN 371 and 376



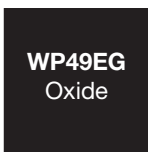
				metric dimensions					class of fit
WU41EG	Price	WP49EG	Price	D1 size	L	L3	L2	D	
VTSP06006	£19.75	VTSP06006	£15.80	4 - 40	56	8	18	3,5	3B
VTSP06009	£19.15	VTSP06009	£15.30	6 - 32	56	9	20	4,0	3B
VTSP06012	£19.15	VTSP06012	£15.30	8 - 32	63	11	21	4,5	3B
VTSP06015	£27.50	VTSP06015	£21.95	10 - 32	70	12	25	6,0	3B
VTSP06018	£29.00	VTSP06018	£23.15	1/4 - 28	80	15	30	7,0	3B
VTSP06021	£30.20	VTSP06021	£24.15	5/16 - 24	90	15	35	8,0	3B
VTSP06024	£30.65	VTSP06024	£24.55	3/8 - 24	100	19	39	10,0	3B
VTSP06027	£33.35	VTSP06027	£26.25	7/16 - 20	100	18	41	8,0	3B
VTSP06030	£33.35	VTSP06030	£26.75	1/2 - 20	110	23	47	9,0	3B

- WP49EG oxide



Shank Tolerance	
D mm	tolerance h9
1-3	+0, -0,025
>3-6	+0, -0,030
>6-10	+0, -0,036
>10-18	+0, -0,043
>18-30	+0, -0,052

■ VT-SFT • Form C Semi-Bottoming Chamfer • UNJC/UNJF • Inch DIN 371 and 376



				metric dimensions					class of fit
WP49EG	Price	D1 size	L	L3	L2	D			
VTSFT6006	£21.55	4 - 40	56	8	18	3,5	3B		
VTSFT6009	£20.90	6 - 32	56	9	20	4,0	3B		
VTSFT6012	£20.90	8 - 32	63	11	21	4,5	3B		
VTSFT6015	£29.95	10 - 32	70	12	25	6,0	3B		
VTSFT6018	£31.60	1/4 - 28	80	15	30	7,0	3B		
VTSFT6021	£32.95	5/16 - 24	90	15	35	8,0	3B		
VTSFT6024	£33.40	3/8 - 24	100	19	39	10,0	3B		
VTSFT6027	£36.45	7/16 - 20	100	18	41	8,0	3B		
VTSFT6030	£36.45	1/2 - 20	110	23	40	9,0	3B		



High-Performance Taps



Application Data • VariTap™

■ VariTap • HSS-E • Metric

P	Steel
M	Stainless Steel
K	Cast Iron
N	Non-Ferrous Materials
S	High-Temp Alloys

NOTE: For further information, please contact the Technical Department at ITC.

High-Performance Taps

VariTap HSS-E											
		 Through Holes					 Blind Holes				
Material Group	VDI 3323	Tap Style	Grade*	Range – m/min			Tap Style	Grade*	Range – m/min		
				min	Starting Value	max			min	Starting Value	max
P	1	VT-SPO	WP42EG, WU41EG	25	34	42	VT-SFT	WP42EG, WU41EG	17	24	35
		VT-SPO	WP49EG, WU40EG	14	18	23	VT-SFT	WP49EG, WU40EG	9	13	18
	2, 3, 4, 5	VT-SPO	WP42EG, WU41EG	18	24	30	VT-SFT	WP42EG, WU41EG	11	15	22
		VT-SPO	WP49EG, WU40EG	10	14	17	VT-SFT	WP49EG, WU40EG	6	9	13
	6, 7, 8, 10	VT-SPO	WP42EG, WU41EG	11	15	19	VT-SFT	WP42EG, WU41EG	9	12	17
		VT-SPO	WP49EG, WU40EG	7	9	11	VT-SFT	WP49EG, WU40EG	5	7	10
9	VT-SPO	WP42EG, WU41EG	11	15	19	VT-SFT	WP42EG, WU41EG	6	9	13	
	VT-SPO	WP49EG, WU40EG	6	8	10	VT-SFT	WP49EG, WU40EG	4	5	8	
M	14.1, 14.3	VT-SPO	WP42EG, WU41EG	16	21	27	VT-SFT	WP42EG, WU41EG	11	15	22
		VT-SPO	WP49EG, WU40EG	9	12	15	VT-SFT	WP49EG, WU40EG	6	9	13
	14.2	VT-SPO	WP42EG, WU41EG	11	15	19	VT-SFT	WP42EG, WU41EG	9	12	17
VT-SPO		WP49EG, WU40EG	7	9	11	VT-SFT	WP49EG, WU40EG	4	6	9	
K	15, 16	—	—	—	—	—	—	—	—	—	
		—	—	—	—	—	—	—	—	—	
	17, 18, 19	VT-SPO	WP42EG, WU41EG	16	21	27	VT-SFT	WP42EG, WU41EG	11	15	22
VT-SPO		WP49EG, WU40EG	9	12	15	VT-SFT	WP49EG, WU40EG	6	9	12	
N	21, 22	VT-SPO	WP42EG, WU41EG	37	49	61	VT-SFT	WP42EG, WU41EG	26	37	52
		VT-SPO	WU40EG	21	27	34	VT-SFT	WU40EG	14	20	28
	23, 24	VT-SPO	WP42EG, WU41EG	30	40	50	VT-SFT	WP42EG, WU41EG	19	27	39
		VT-SPO	WU40EG	16	21	27	VT-SFT	WU40EG	11	15	22
	26, 27, 28	VT-SPO	WP42EG, WU41EG	37	49	61	VT-SFT	WP42EG, WU41EG	23	34	48
		VT-SPO	WU40EG	21	27	34	VT-SFT	WU40EG	13	18	26

* Grades: WP42EG = TiCN
 WU41EG = TiN
 WP49EG = oxide
 WU40EG = bright



ADVANCES

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