

	P				M	K		N			S				H		page(s)	recommended cutting parameters
	1, 2, 3, 4, 6, 7	5, 9, 10, 11	12, 13.1	13.2	14.1, 14.2, 14.3, 14.4	15, 16	17, 18, 19, 20	21	22, 23, 24, 25	26, 27, 28	31, 32	33, 34, 35	36	37	38.1, 38.2, 40.1, 40.2, 41.1	39.1, 41.2		
	Steel <35 HRC	Steel >36-48 HRC	PH and Ferritic Stainless Steel <35 HRC	PH and Ferritic Stainless Steel >35 HRC	Stainless Steel	Grey Cast Iron	Ductile Cast Iron	Wrought Aluminium	Cast Aluminium	Copper, Copper Alloys	Iron Based	Cobalt Based	Nickel Based	Titanium Alloys	Hardened Steels 49-55 HRC	Hardened Steels 56-68 HRC		
Spiral-Point and Left-Hand Spiral-Flute Taps (continued)																		
	★★★		★★★		★★★		★★	★	★		★★						Y4	Y85
	★★★		★★★		★★★		★★	★	★		★★						Y5	Y85
	★★★		★★★		★★★		★★	★	★		★★						Y6	Y85
												★★★	★★★				Y7	Y85
														★★★			Y8	Y85
								★★★	★	★							Y9	Y85
		★★★		★★★	★	★	★					★					Y10	Y85
	★★	★	★		★★	★	★★	★	★★	★★	★						Y11	Y86
	★★	★	★		★★	★	★★	★	★★	★★	★						Y14	Y86
	★★	★	★		★★	★	★★	★	★★	★★	★						Y17	Y86
Spiral-Flute Taps (continued)																		
	★★★		★★★		★★★		★★	★	★			★★					Y21	Y85
	★★★		★★★		★★★		★★	★	★			★★					Y20	Y85
	★★★		★★★		★★★		★★	★	★			★★					Y22	Y85
	★★★		★★★		★★★		★★	★	★			★★					Y23	Y85
	★★★		★★★		★★★		★★	★	★			★★					Y24	Y85
	★★★		★★★		★★★		★★	★	★			★★					Y25	Y85
	★★★		★★★				★★										Y26	Y85
	★★★		★★★				★★										Y28	Y85
												★★★	★★★				Y30	Y85
														★★★			Y31	Y85
								★★★									Y32	Y85