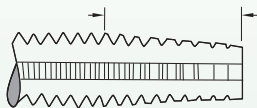
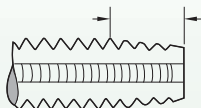


■ Tap Chamfers • ANSI Taps

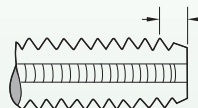
Taper Chamfer
7–10 Pitches



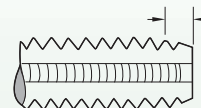
Plug Chamfer
3–5 Pitches



Modified Bottoming Chamfer
2–2.5 Pitches



Full Bottoming Chamfer
1–2 Pitches



Tap Chamfers

Taper (7–10 pitches)

The taper chamfer has the longest standard chamfer ensuring easier starting. It requires less tapping torque because of more working teeth.

Plug (3–5 pitches)

The most common chamfer for use by hand or machine in through or blind holes. This chamfer is more efficient than a bottoming or modified bottoming chamfer.

Semi-Bottom (2–2.5 pitches)

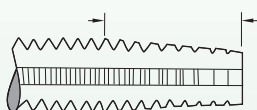
This short chamfer enables threading close to the bottom of blind holes. Due to the slightly longer chamfer and more working teeth, this chamfer is more efficient than a bottoming chamfer.

Bottoming (1–2 pitches)

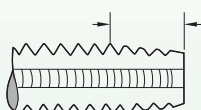
For threading close to the bottom of blind holes, the bottoming chamfer is the least efficient chamfer available.

■ Tap Chamfers • DIN Taps

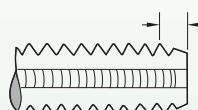
Taper Chamfer
7–10 Pitches



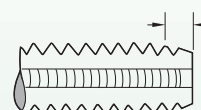
Plug Chamfer
3–5 Pitches



Modified Bottoming Chamfer
2–2.5 Pitches



Full Bottoming Chamfer
1–2 Pitches



Hand Tap Chamfers

Form A (6–8 pitches)

The Form A chamfer has the longest standard chamfer ensuring easier starting. It requires less tapping torque because of more working teeth.

Form B/D (3.5–5 pitches)

The most common chamfers for use by hand or machine in through or blind holes. Form B applies to spiral-point taps and Form D applies to straight-flute and spiral-flute taps. This chamfer is more efficient than Form E or Form C chamfer.

Form C (2–2.5 pitches)

This short chamfer enables threading close to the bottom of blind holes. Due to the slightly longer chamfer and more working teeth, this chamfer is more efficient than a Form E chamfer.

Form E (1.5–2 pitches)

For threading close to the bottom of blind holes, the Form E chamfer is the least efficient chamfer available.