

DIN TAPS



Taps - DIN

High Performance Tap Range

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

ISO VDI Material Group

Sutton

P	A	Steel	N	
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



Catalogue Code
Material
Surface Finish
Sutton Designation
Tapping Depth

Page

173	173	174	174	175	175	176	176	177	177
									
T377	T379	T373	T375	T365	T367	T369	T371	T381	T383
PM-HSSE V3									
TiCN						CrN		TiN	
High Speed Cutting									
2 x Ø									

ISO	VDI [^] 3323	Material	Condition	HB	N/mm²	Tapping Depth											
P	1	Steel - Non-alloy, cast & free cutting	~ 0.15 %C	A	125	440	●	●	●	●	●	●			●	●	
	2			A	190	640	●	●	●	●	●	●			●	●	
	3		~ 0.45 %C	QT	250	840	●	●	●	●	●	●			○	○	
	4			A	270	910	●	●	●	●	●	●			●	●	
	5			QT	300	1010	○	○	○	○	○	○					
	6	Steel - Low alloy & cast < 5% of alloying elements	~ 0.75 %C	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	●	●	●	●	●	●	●	●	●	●	
	Heat Treatable		AH	100	360	●	●	●	●	●	●	●	●	●	●		
	23	Aluminum & Magnesium - cast alloy ≤12% Si	Non Heat Treatable		75	270	●	●	○	○	●	●	●	●	●	●	
	Heat Treatable		AH	90	320	●	●	○	○	●	●	●	●	○	○		
	24	Al & Mg - cast alloy >12% Si	Non Heat Treatable		130	460	○	○	●	●	○	○					
	26	Copper & Cu alloys (Brass/Bronze)	Free cutting, Pb > 1%		110	390	●	●	○	○	●	●	●	●			
	Brass (CuZn, CuSnZn)			90	320	○	○	○	○	○	○	●	●				
	27		Brass (CuSn)		100	360	●	●	○	○	●	●	●	●	●	●	
	28																
	29	Non-metallic - Thermosetting & fiber-reinforced plastics															
30	Non-metallic - Hard rubber, wood etc.																
S	31	High temp. alloys	Fe based	A	200	680	●	●	●	●							
	AH			280	950												
	33		Ni / Co based	A	250	840	●	●	●	●							
	AH			350	1180												
	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					●	●						
	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			55 HRC													
	39.1			58 HRC													
	39.2			62 HRC													
	40	Cast Iron	Chilled	C	400	1350											
	41			HT	55 HRC												

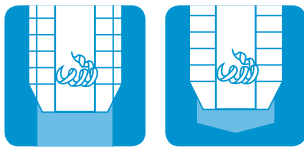
Condition: A (Annealed), AH (Age Hardened), C (Cast), HT (Hardened & Tempered), QT (Quenched & Tempered)

● Optimal ○ Effective

ISO	VDI	Material Group	Sutton
P	A	Steel	N
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



Catalogue Code

Material	Surface Finish	Sutton Designation	Tapping Depth
HSSE V3	BrT	N	≤ 1.5xØ
VHM	TiN	GG	≤ 3xØ
PM-HSS Co	Ni+Blu	GGG	≤ 1.5xØ
SPM	TiCN	DC	≤ 1.5xØ
VHM	BrT	XH	≤ 1.5xØ
HSSE V3	BrT	VH	≤ 1.5xØ
HSSE V3	BrT	UNI	≤ 1.5xØ

ISO	VDI [^] 3323	Material	Condition	HB	N/mm ²															
P	1	Steel - Non-alloy, cast & free cutting	~ 0.15 %C	A	125	440	●	●												●
	2			A	190	640	●	●												●
	3			QT	250	840	●	●												●
	4			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			A	200	680														○
	13	Steel - Corrosion resistant & cast	Ferritic / Martensitic	A	200	680														○
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			○	○	○	○	○	○	○					○
N	20		Pearlitic		230	780			○	○	○	○	○	○	○					○
	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			A	250	840														
	34		Ni / Co based	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															
	38.1	Hardened steel		HT	45 HRC															
	38.2			HT	55 HRC															
	39.1			HT	58 HRC															
	39.2			HT	62 HRC															
H	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)

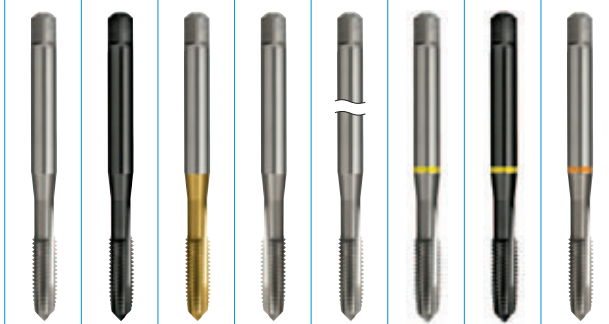
ISO	VDI	Material Group	Sutton
P	A	Steel	N
M	R	Stainless Steel	VA
K	F	Cast Iron	GG
N	N	Non-Ferrous Metals, Aluminiums & Coppers	Al W
S	S	Titaniums & Super Alloys	Ti Ni
H	H	Hard Materials (≥ 45 HRC)	H

^ 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 Holes



Page M	184	184	184	186	187	188	188	188
MF	221	221	221					
UNC	236	236	236					
UNF	251	251	251					
G (BSPF)	260	260	260					



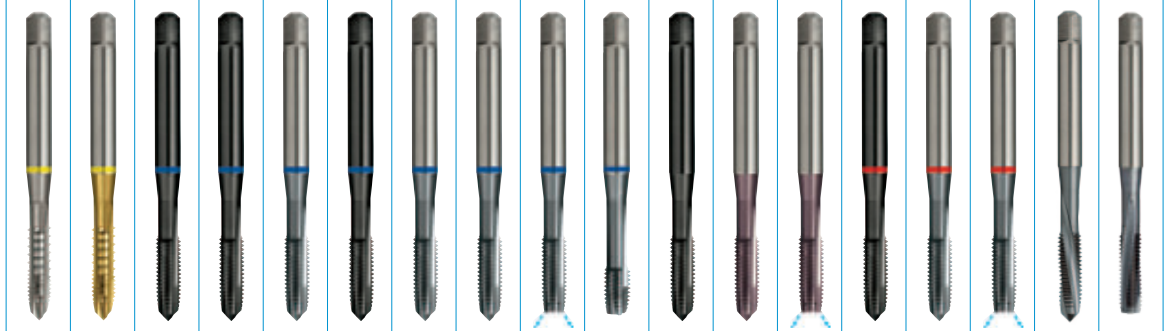
Catalogue Code	M	T100	T101	T102	T103	T104	T105	T648	T649	T337	T338	T122	T123	T124	T125	T126	T127
	MF	T154		T156		T157											
	UNC	T164		T166		T167											
	UNF	T173		T702		T175											
	G (BSPF)	T178		T179		T180											
	Material	HSSE V3															
	Surface Finish	Brt		Blu		TiN						Ni		Blu		CrN	
	Sutton Designation	N						N - LH		N - Long		W				Cu	
	Tapping Depth	≤ 3xØ															

ISO	VDI [^] 3323	Material	Condition	HB	N/mm²											
P	1	Steel - Non-alloy, cast & free cutting	~ 0.15 %C	A	125	440	●	●	●	●	●	●	●	●	●	●
	2			A	190	640	●	●	●	●	●	●	●	●	●	●
	3		~ 0.45 %C	QT	250	840	○	●	●	○	○	○	○	○	○	○
	4			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			A	200	680		○	○							
M	13	Steel - Corrosion resistant & cast	Martensitic	QT	240	810										
	14.1	Stainless Steel	Austenitic	AH	180	610		○	○							
	14.2		Duplex		250	840		○	○							
K	14.3		Precipitation Hardening		250	840		○	○							
	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	○	○	○	○	○					
N	20		Pearlitic		230	780	○	○	○	○	○					
	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		Beta alloys	AH	1170 MPa											
	37.4			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

189	189	190	190	190	191	191	191	191	192	193	193	193	194	194	194	208	209
		223		223	224	224					225			226		211	212
		237		237		238				239	239		240	240		249	250
		252		252		253										249	250
		261		261	262	262											



T128	T129	T130	T131	T110	T111	T359	T360	T112	T113	T114	T115	T116	T117	T680	T681	T118	T119	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		T792	
				T170				T171				T697								T168		T169				T172		T666				T786		T794	
				T176				T177				T698																				T787		T795	
				T181				T182		T349		T350																							

HSSE V3				PM-HSSE V3						PM-HSS Co			
Brt	TiN	Blu	TiCN	Blu	TiCN		Blu	TiAlN	Blu	TiCN			
Sticky Material	VA			VA PM		VA DH	NH		H		Ti	Ni	
≤ 3xØ											≤ 1.5xØ		

																	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	S
				●		●	●	●									31	
				○		●	●	●								○	32	
				○		●	●	●									33	
																○	34	
																○	35	
													○	○	○		36	
													○	○	○	○	37.1	H
													○	○	○	○	37.2	
													○	○	○	○	37.3	
													○	○	○	○	37.4	
													○	○	○	○	37.5	
													○	○	○	○	38.1	
																	38.2	H
																	39.1	
																	39.2	
										○	○	○	○	○	○		40	
																	41	

202	202	203	203	204			205	205	205	206	206	206	207	209
230	230	231	231					232			233		210	212
243	243		244		245	245	246	246		247	247		248	250
256	256		257										248	250
265	265	266	266											



T197	T199	T201	T202	T203	T204	T205	T206	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																								

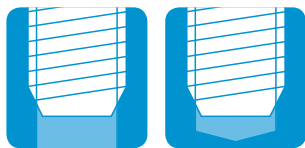
HSSE V3		PM-HSSE V3		HSSE V3		PM-HSSE V3		PM-HSS Co				
Blu	TiCN	Blu	TiCN	Br	TiCN	Blu	TiAlN	Blu	TiCN			
VA DH		VAPM		VA		NH		H		Ti	Ni	
≤ 3x0				≤ 2.5x0		≤ 2.5x0		≤ 1.5x0				

														VDI^	ISO
														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

ISO	VDI	Material Group	Sutton
P	A	Steel	N
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
MF
UNC
UNF
G (BSPF)

213	213		214	214	214	215	215
			234				
		267	267				
							
T309	T313		T319 T320	T323 T324	T329 T330	T325 T326	T327 T328
			T773				
		T360	T363				
HSSE V3						SPM	
Brt	TiN	Brt	TiCN		CrN	TiAlN	
N						Cu	UNI
≤ 1.5xØ		≤ 3xØ					
6HX		6GX	6HX	6GX	6HX		

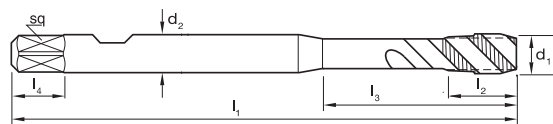
ISO	VDI ³³²³	Material	Condition	HB	N/mm²								
P	1	Steel - Non-alloy, cast & free cutting	~ 0.15 %C	A	125	440	○	●	●	●	●	●	●
	2			A	190	640	○	●	●	●	●	●	●
	3		~ 0.45 %C	QT	250	840		○	○	●	●	●	●
	4			A	270	910		●	●	●	●	●	●
	5			QT	300	1010							
	6	Steel - Low alloy & cast < 5% of alloying elements	A	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		A	200	680								
M	13	Steel - Corrosion resistant & cast	Ferritic / Martensitic	QT	240	810							
	14.1	Stainless Steel	Austenitic	AH	180	610		●	●	●	●	○	●
	14.2		Duplex		250	840						○	●
K	14.3		Precipitation Hardening		250	840							
	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							
N	20		Pearlitic		230	780							
	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

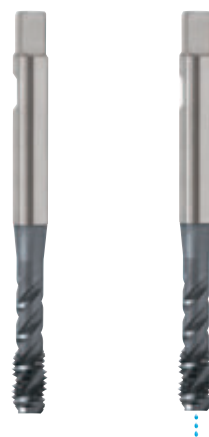
suttontools

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



Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø
0200	M 2	x 0.4	70	4	13	6.0	4.9	8.0	3	1.6
0250	M 2.5	x 0.45	70	4.5	14	6.0	4.9	8.0	3	2.1
0300	M 3	x 0.5	70	5	18	6.0	4.9	8.0	3	2.5
0400	M 4	x 0.7	70	7	21	6.0	4.9	8.0	3	3.3
0500	M 5	x 0.8	70	8	25	6.0	4.9	8.0	3	4.2
0600	M 6	x 1	80	10	30	6.0	4.9	8.0	3	5.0
0800	M 8	x 1.25	90	13	35	8.0	6.2	9.0	3	6.8
1000	M 10	x 1.5	100	15	39	10.0	8.0	11.0	3	8.5
1200	M 12	x 1.75	110	18	42	12.0	9.0	12.0	4	10.3
1400	M 14	x 2	110	20	49	14.0	11.0	14.0	4	12.0
1600	M 16	x 2	110	20	55	16.0	12.0	15.0	4	14.0
1800	M 18	x 2.5	125	25	-	16.0	12.0	15.0	4	15.5
2000	M 20	x 2.5	140	25	-	16.0	12.0	15.0	4	17.5

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



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

[illegible][illegible]

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

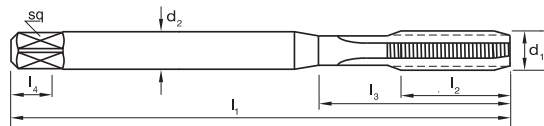
● Optimal ○ Effective

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

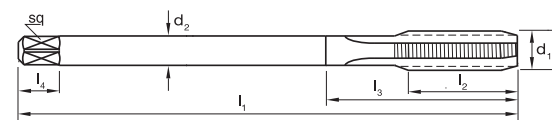
DIN Taps Metric, Straight Flute, N

suttontools

- General purpose use
- Suitable for materials up to 1000N/mm²
- Through & blind holes
- Depths up to 1.5 x d₁



Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø
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
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
0500	M 5	x 0.8	70	16	25	6.0	4.9	8	3	4.2
0600	M 6	x 1	80	19	30	6.0	4.9	8	3	5.0
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
1000	M 10	x 1.5	100	24	39	10.0	8.0	11	3	8.5



Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø
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
1400	M 14	x 2	110	30	-	11.0	9.0	12	3	12.0
1600	M 16	x 2	110	32	-	12.0	9.0	12	4	14.0
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
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
T286	●	●	●	●	○	●	○		○														○	○	○	○		○	○	○																			
T288	●	●	●	●	○	●	○		○														○	○	○	○		○	○	○																			

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

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



Catalogue Code	T286	T288
Discount Group	D0402	D0406
Material	HSSE V3	HSSE V3
Surface Finish	<i>Brt</i>	<i>TiN</i>
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
	Item #	Item #
	T286 0200	T288 0200
	T286 0220	T288 0220
	T286 0230	T288 0230
	T286 0250	T288 0250
	T286 0260	T288 0260
	T286 0300	T288 0300
	T286 0350	T288 0350
	T286 0400	T288 0400
	T286 0500	T288 0500
	T286 0600	T288 0600
	•	•
	T286 0800	T288 0800
	T286 1000	T288 1000

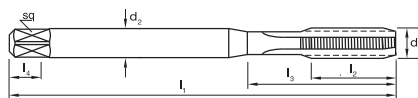


Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #	Item #
0600	M 6	x 1	80	19	-	4.5	3.4	6	3	5.0	T287 0600	T289 0600
0800	M 8	x 1.25	90	22	-	6.0	4.9	8	3	6.8	T287 0800	T289 0800
1000	M 10	x 1.5	100	24	-	7.0	5.5	8	3	8.5	T287 1000	T289 1000
1200	M 12	x 1.75	110	28	-	9.0	7.0	10	3	10.2	T287 1200	T289 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

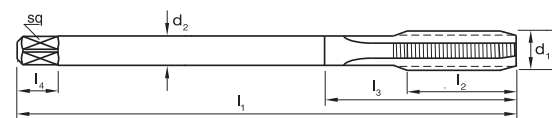
DIN Taps Metric, Straight Flute, GG

suttontools

- For use in grey cast iron (GG)
- Through & blind holes
- Depths up to 3 x d₁



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 #
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																	●	●	●	●	○	○						○																						

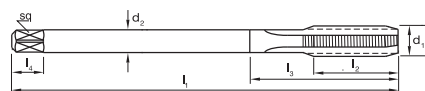
P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials

• Optimal ○ Effective

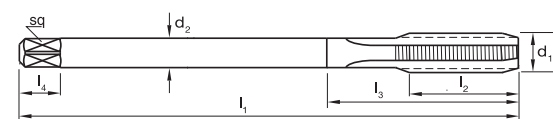
• Available on request as special manufacture. Subject to lead time.

suttontools

- VHM, for use in Al >10% Si & cast iron (GGG)
- Through & blind holes
- Depths up to 3 x d₁



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	•



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	-	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

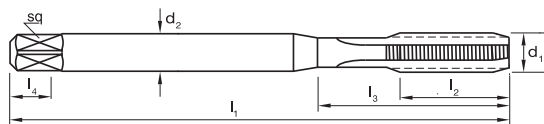
• Available on request as special manufacture. Subject to lead time.



DIN Taps Metric, Straight Flute, DC

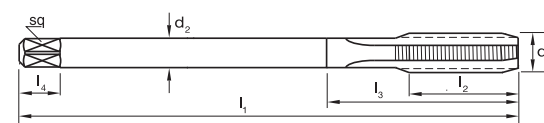
suttontools

- 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 d₁



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

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	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 #
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

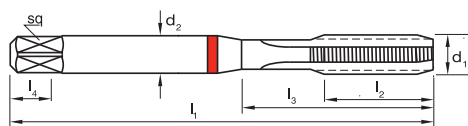
ISO	P													M	K					N										S										H									
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T335																	○	○	○	○	○	○			●	●	●		○																		○		
T357																	○	○	○	○	○	○				●	●	●		○																		○	

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

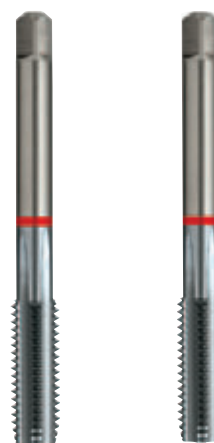
• Available on request as special manufacture. Subject to lead time.

suttontools

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



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



Catalogue Code	T294	T295
Discount Group	D0408	D0408
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

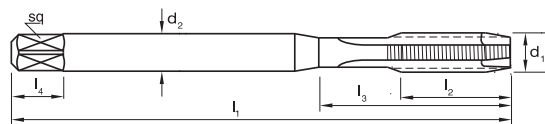
Item #	Item #
T294 0300	T295 0300
T294 0400	T295 0400
T294 0500	T295 0500
T294 0600	T295 0600
T294 0800	T295 0800
T294 1000	T295 1000
T294 1200	T295 1200
T294 1600	T295 1600
T294 2000	T295 2000

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					○			○	●		●		●					●		●									○														●				●		

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

suttontools

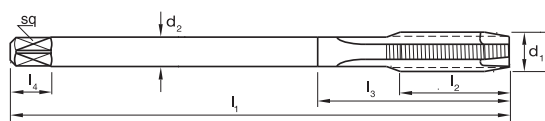
- General purpose use
- Suitable for materials up to 1000N/mm²
- Through holes
- Depths up to 3 x d₁



Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø
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
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
0500	M 5	x 0.8	70	16	25	6.0	4.9	8	3	4.2
0600	M 6	x 1	80	19	30	6.0	4.9	8	3	5.0
0800	M 8	x 1.25	90	22	35	8.0	6.2	9	3	6.8
1000	M 10	x 1.5	100	24	39	10.0	8.0	11	3	8.5

Catalogue Code
Discount Group
Material
Surface Finish
Sutton Designation
Geometry
Chamfer
Limit & Nut Tolerance

T106	T108	T648
D0402	D0402	D0402
HSSE V3	HSSE V3	HSSE V3
Brt	Brt	Brt
N	N	N
6G	4H	Left Hand
Form B / 4.5 x P	Form B / 4.5 x P	Form B / 4.5 x P
ISO 3 / 6G	ISO 1 / 4H	ISO 2 / 6H LH
Item #	Item #	Item #
•	•	•
•	•	•
•	•	•
•	•	•
•	•	•
T106 0300	T108 0300	T648 0300
T106 0350	T108 0350	•
T106 0400	T108 0400	T648 0400
T106 0500	T108 0500	T648 0500
T106 0600	T108 0600	T648 0600
T106 0800	T108 0800	T648 0800
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
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
1400	M 14	x 2	110	30	-	11.0	9.0	12	3	12.0
1600	M 16	x 2	110	32	-	12.0	9.0	12	3	14.0
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

Item #	Item #	Item #
T107	T109	T649
•	•	•
•	•	•
•	•	•
T107 1200	T109 1200	T649 1200
T107 1400	T109 1400	T649 1400
T107 1600	T109 1600	T649 1600
T107 1800	T109 1800	T649 1800
T107 2000	T109 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	●	●	○	○		●	○			○							○		○		○	○	●	●	○	○		○	○																				

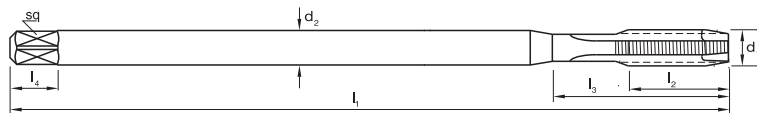
P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials

• Optimal ○ Effective

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

suttontools

- For long reach applications
- Suitable for materials up to 1000N/mm²
- Depths up to 3 x d₁
- d₂ and sq in accordance to DIN371



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



Catalogue Code

T337

Discount Group

D0402

Material

HSSE V3

Surface Finish

Brt

Sutton Designation

N

Geometry

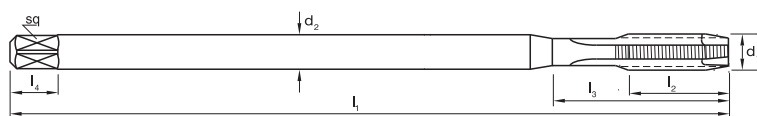
Extra Length

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 #
											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

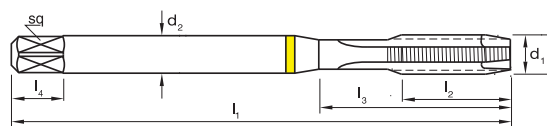
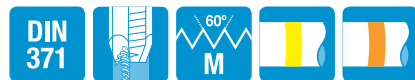


ISO	P													M			K					N										S										H							
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T337	●	●	○	○		●	○			○							○	○		○	○	○	●	●	○	○		○	○																				
T338	●	●	○	○		●	○			○							○	○		○	○	○	●	●	○	○		○	○																				

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

● Optimal ○ Effective

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

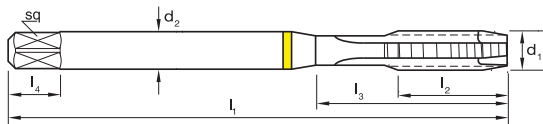
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● Optimal ○ Effective

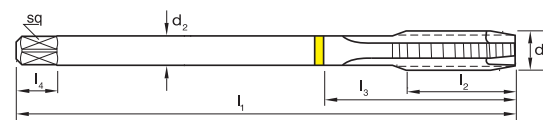
- Available on request as special manufacture. Subject to lead time.



- Interrupted threads allow greater lubricant flow and reduce friction
- Use in soft elastic materials
- For long-chipping materials
- Through holes up to 3 x d₁



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 #
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

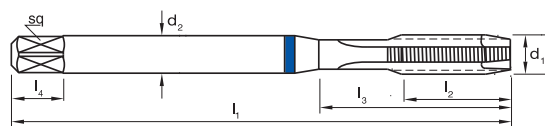
● Optimal ○ Effective

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



suttontools

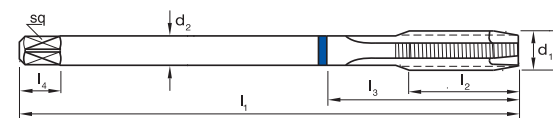
- Use in stainless steels and high strength steels
- Suitable for materials up to 850N/mm²
- Through holes
- Depths up to 3 x d₁



Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø
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
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
0500	M 5	x 0.8	70	16	25	6.0	4.9	8	3	4.2
0600	M 6	x 1	80	19	30	6.0	4.9	8	3	5.0
0800	M 8	x 1.25	90	22	35	8.0	6.2	9	3	6.8
1000	M 10	x 1.5	100	24	39	10.0	8.0	11	3	8.5



Catalogue Code	T110	T359	T112
Discount Group	D0402	D0402	D0408
Material	HSSE V3	HSSE V3	HSSE V3
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
Ø	Item #	Item #	Item #
6	•	•	•
5	•	•	•
9	•	•	•
5	•	•	•
5	•	•	•
5	T110 0300	•	T112 0300
9	T110 0350	•	T112 0350
8	T110 0400	•	T112 0400
2	T110 0500	•	T112 0500
0	T110 0600	•	T112 0600
8	T110 0800	•	T112 0800
5	T110 1000	•	T112 1000



Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #	Item #	Item #
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

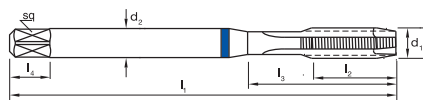
ISO	P													M			K							N										S										H								
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41			
T101	●	●	○	○		●	○						○	13	●	●	○																																			
T359	●	●	○	○		●	○							13	●	●	○																																			
T112	●	●	○	○		●	○			○		●	○	13	●	●	○							○	○	○	○	○	○	○		○			●	○	○															
P Steel	M Stainless Steel	K Cast Iron	N Non-Ferrous Metals	S Titanium & Super Alloys	H Hard Materials																																										● Optimal	○ Effective				

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.

- 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 d₁

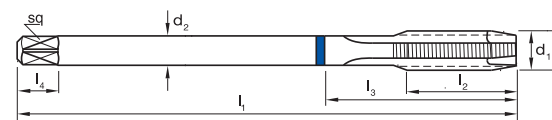


Catalogue Code
Discount Group
Material
Surface Finish
Sutton Designation
Geometry
Chamfer
Limit & Nut Tolerance

Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø
0160	M 1.6	x 0.35	40	8	-	2.5	2.1	5	3	1.25
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
0300	M 3	x 0.5	56	11	18	3.5	2.7	6	3	2.5
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
0500	M 5	x 0.8	70	16	25	6.0	4.9	8	3	4.2
0600	M 6	x 1	80	19	30	6.0	4.9	8	3	5.0
0800	M 8	x 1.25	90	22	35	8.0	6.2	9	3	6.8
1000	M 10	x 1.5	100	24	39	10.0	8.0	11	3	8.5



T114	T116	T680	T118
D0402	D0408	D0408	D0408
PM-HSSE V3	PM-HSSE V3	PM-HSSE V3	PM-HSSE V3
Blu	TiCN	TiCN	TiCN
VA PM	VA PM	VA PM	VA PM
Special Relief	Special Relief	Special Relief	Internal Coolant
Form B / 4.5 x P	Form B / 4.5 x P	Form B / 4.5 x P	Form B / 4.5 x P
6HX	6HX	6GX	6HX
Item #	Item #	Item #	Item #
•	T116 0160	•	•
•	T116 0200	T680 0200	•
•	•	•	•
•	•	•	•
•	T116 0250	T680 0250	•
T114 0300	T116 0300	T680 0300	•
•	T116 0350	T680 0350	•
T114 0400	T116 0400	T680 0400	•
T114 0500	T116 0500	T680 0500	T118 0500
T114 0600	T116 0600	T680 0600	T118 0600
T114 0800	T116 0800	T680 0800	T118 0800
T114 1000	T116 1000	T680 1000	T118 1000



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	●	●	○	○		●	○			○		●	○	●	●	●								○	○	○	○	○	○		○			●	●	●														

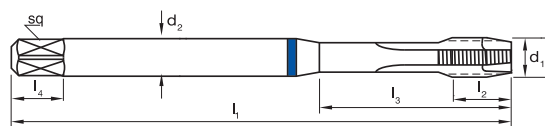
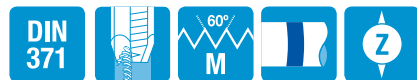
P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials

• Optimal ○ Effective

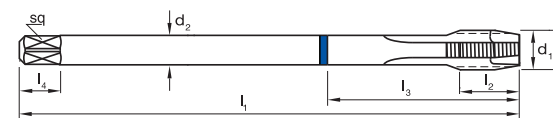
* HSSE V3 >20mm • Available on request as special manufacture. Subject to lead time.

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 d₁



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	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	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	T120 0400
0500	M 5	x 0.8	70	8	25	6.0	4.9	8	3	4.2	T120 0500
0600	M 6	x 1	80	10	30	6.0	4.9	8	3	5.0	T120 0600
0800	M 8	x 1.25	90	12.5	35	8.0	6.2	9	3	6.8	T120 0800
1000	M 10	x 1.5	100	15	39	10.0	8.0	11	3	8.5	T120 1000



Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #
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	T121 1200
1400	M 14	x 2	110	20	-	11.0	9.0	12	3	12.0	T121 1400
1600	M 16	x 2	110	20	-	12.0	9.0	12	4	14.0	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	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					
T120	●	●	●	●		●	●			●	●	●	●	●	●	●								●	●	●	●	●	●	●																								
P	Steel		M	Stainless Steel		K	Cast Iron		N	Non-Ferrous Metals		S	Titanium & Super Alloys		H	Hard Materials																										●	Optimal		●	Effective								

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

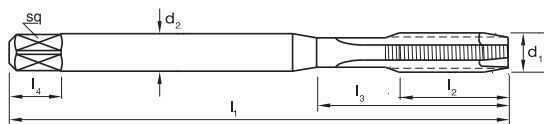
• Optimal ○ Effective



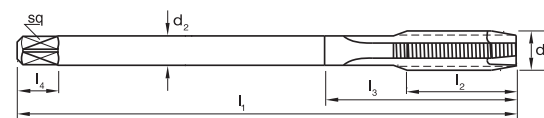
Catalogue Code	T120
Discount Group	D0408
Material	PM-HSSE V3
Surface Finish	TICN
Sutton Designation	VA DH
Geometry	Short Pod
Chamfer	Form B / 4.5 x P
Limit & Nut Tolerance	6HX



- Suitable for harder short chipping materials up to 42 HRC
- Through holes
- Depths up to 3 x d₁

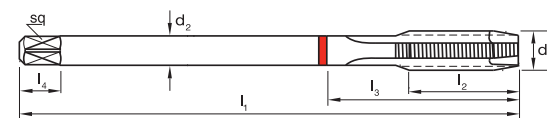
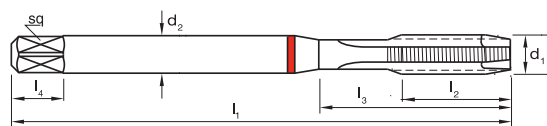


Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #	Item #	Item #
0200	M 2	x 0.4	45	8	-	2.8	2.1	5	3	1.6	•	•	•
0220	M 2.2	x 0.45	45	9	-	2.8	2.1	5	3	1.75	•	•	•
0230	M 2.3	x 0.4	45	9	-	2.8	2.1	5	3	1.9	•	•	•
0250	M 2.5	x 0.45	50	9	-	2.8	2.1	5	3	2.05	•	•	•
0260	M 2.6	x 0.45	50	9	-	2.8	2.1	5	3	2.15	•	•	•
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			●	●	●		●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○			○	○	○	○	○	○	○	○													○											



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					●			●	●		●	○	●			○	●	●	●	●	●							○	○	●										○	○	●	●	●	●	●	●					●	

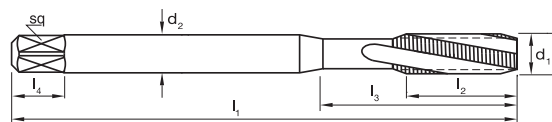
● Optimal ○ Effective

194

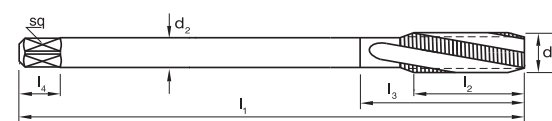
DIN Taps Metric, Spiral Flute, R15 N

suttontools

- General purpose use
- Suitable for materials up to 1000N/mm²
- Blind holes
- Depths up to 1.5 x d₁



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	•



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

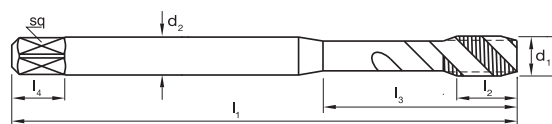
• Available on request as special manufacture. Subject to lead time.



M

suttontools

- General purpose use
- Suitable for materials up to 1000N/mm²
- Blind holes
- Depths up to 2.5 x d₁

[illegible][illegible]

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

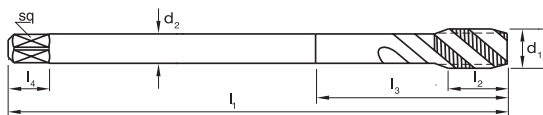
● Optimal ○ Effective

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



suttontools

- General purpose use
- Suitable for materials up to 1000N/mm²
- Blind holes
- Depths up to 2.5 x d₁

[illegible]

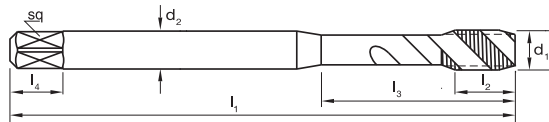
● Optimal ○ Effective



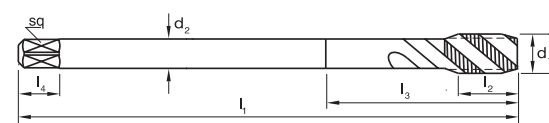
Catalogue Code	T188	T190
Discount Group	D0402	D0402
Material	HSSE V3	HSSE V3
Surface Finish	<i>Brt</i>	<i>Blu</i>
Sutton Designation	N	N
Geometry	R40	R40
Chamfer	Form C / 2.5 x P	Form C / 2.5 x P
Limit & Nut Tolerance	ISO 2 / 6H	ISO 2 / 6H

suttontools

- General purpose use
- Suitable for materials up to 1000N/mm²
- Blind holes
- Depths up to 2.5 x d₁



Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø
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
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
0500	M 5	x 0.8	70	8	25	6.0	4.9	8	3	4.2
0600	M 6	x 1	80	10	30	6.0	4.9	8	3	5.0
0800	M 8	x 1.25	90	13	35	8.0	6.2	9	3	6.8
1000	M 10	x 1.5	100	15	39	10.0	8.0	11	3	8.5



Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø
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
1400	M 14	x 2	110	20	-	11.0	9.0	12	3	12.0
1600	M 16	x 2	110	20	-	12.0	9.0	12	3	14.0
1800	M 18	x 2.5	125	25	-	14.0	11.0	14	4	15.5
2000	M 20	x 2.5	140	25	-	16.0	12.0	15	4	17.5

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

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

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



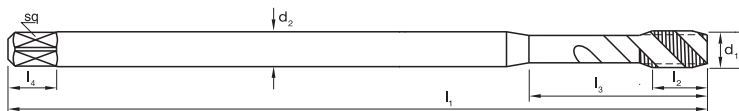
T191	T193	T195
D0402	D0402	D0402
HSSE V3	HSSE V3	HSSE V3
<i>Brt</i>	<i>Brt</i>	<i>Brt</i>
N	N	N
R40 - 6G	R40 - 4H	L40
Form C / 2.5 x P	Form C / 2.5 x P	Form C / 2.5 x P
ISO 3 / 6G	ISO 1 / 4H	ISO 2 / 6H
Item #	Item #	Item #
T191 0200	T193 0200	•
•	•	•
•	•	•
T191 0250	T193 0250	•
•	•	•
T191 0300	T193 0300	T195 0300
•	•	•
T191 0400	T193 0400	T195 0400
T191 0500	T193 0500	T195 0500
T191 0600	T193 0600	T195 0600
T191 0800	T193 0800	T195 0800
T191 1000	T193 1000	T195 1000



Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #	Item #	Item #
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

suttontools

- For long reach applications
- Suitable for materials up to 1000N/mm²
- Depths up to 2.5 x d₁
- d₂ and sq in accordance to DIN376



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

Catalogue Code

T339

Discount Group

D0402

Material

HSSE V3

Surface Finish

Brt

Sutton Designation

N

Geometry

R40 - Extra Length

Chamfer

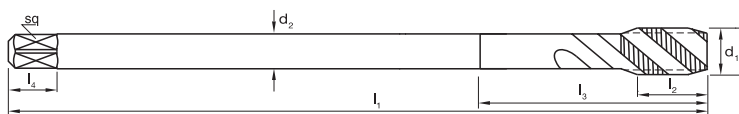
Form C / 2.5 x P

Limit & Nut Tolerance

ISO 2 / 6H



M



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

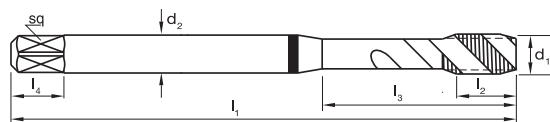
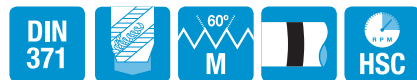
● Optimal ○ Effective

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

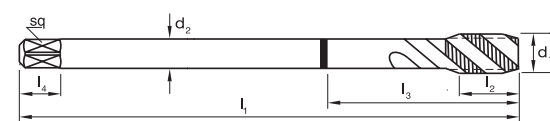
DIN Taps Metric, Spiral Flute, R45 Al

suttontools

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



Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø
0200	M 2	x 0.4	45	8	-	2.8	2.1	5	2	1.6
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
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
0350	M 3.5	x 0.6	56	6	20	4.0	3.0	6	2	2.9
0400	M 4	x 0.7	63	7	21	4.5	3.4	6	2	3.3
0500	M 5	x 0.8	70	8	25	6.0	4.9	8	2	4.2
0600	M 6	x 1	80	10	30	6.0	4.9	8	2	5.0
0800	M 8	x 1.25	90	12.5	35	8.0	6.2	9	2	6.8
1000	M 10	x 1.5	100	15	39	10.0	8.0	11	2	8.5



Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø
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
1400	M 14	x 2	110	20	-	11.0	9.0	12	2	12.0
1600	M 16	x 2	110	20	-	12.0	9.0	12	2	14.0
1800	M 18	x 2.5	125	25	-	14.0	11.0	14	2	15.5
2000	M 20	x 2.5	140	25	-	16.0	12.0	15	2	17.5

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
T231																							●	●	●	●		○		○																			
T233																							●	●	●	●		●		●																			

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

● Optimal ○ Effective



Catalogue Code	T231	T233
Discount Group	D0402	D0404
Material	HSSE V3	HSSE V3
Surface Finish	<i>Brt</i>	<i>CrN</i>
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
	Item #	Item #
	T231 0200	•
	•	•
	•	•
	T231 0250	•
	•	•
	T231 0300	T233 0300
	T231 0350	•
	T231 0400	T233 0400
	T231 0500	T233 0500
	T231 0600	T233 0600
	T231 0800	T233 0800
	T231 1000	T233 1000



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	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

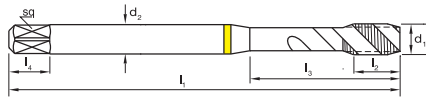
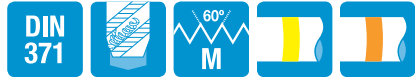
ISO	P													M	K					N										S										H									
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T231																							●	●	●	●		○		○																			
T233																							●	●	●	●		●		●																			

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

DIN Taps Metric, Spiral Flute, R45 W & Cu

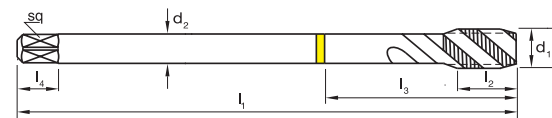
suttontools

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



Catalogue Code
Discount Group
Material
Surface Finish
Sutton Designation
Geometry
Chamfer
Limit & Nut Tolerance

T235	T237	T241	T239
D0402	D0402	D0406	D0404
HSSE V3	HSSE V3	HSSE V3	HSSE V3
Ni	Blu	TiN	CrN
W	W	W	Cu
R45	R45	R45	R45
Form C / 2.5 x P	Form C / 2.5 x P	Form C / 2.5 x P	Form C / 2.5 x P
ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H
Item #	Item #	Item #	Item #
T235 0200	•	•	•
•	•	•	•
•	•	•	•
T235 0250	•	•	•
•	•	•	•
T235 0300	T237 0300	T241 0300	T239 0300
T235 0350	•	T241 0350	•
T235 0400	T237 0400	T241 0400	T239 0400
T235 0500	T237 0500	T241 0500	T239 0500
T235 0600	T237 0600	T241 0600	T239 0600
T235 0800	T237 0800	T241 0800	T239 0800
T235 1000	T237 1000	T241 1000	T239 1000



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

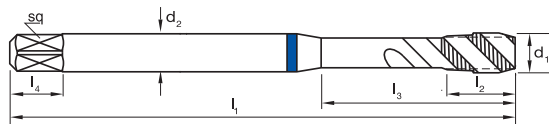
• Available on request as special manufacture. Subject to lead time.

M

DIN Taps Metric, Spiral Flute, R45 VA DH

suttontools

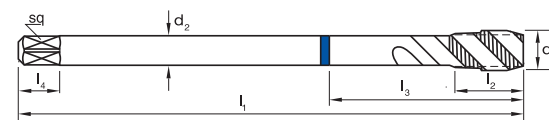
- Suitable for controlled tapping in deep holes
- Use in stainless steels and high strength steels up to 850N/mm²
- Blind holes
- Depths up to 3 x d₁



Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø
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
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
0500	M 5	x 0.8	70	8	25	6.0	4.9	8	3	4.2
0600	M 6	x 1	80	10	30	6.0	4.9	8	3	5.0
0800	M 8	x 1.25	90	12.5	35	8.0	6.2	9	3	6.8
1000	M 10	x 1.5	100	15	39	10.0	8.0	11	3	8.5

Catalogue Code
Discount Group
Material
Surface Finish
Sutton Designation
Geometry
Chamfer
Limit & Nut Tolerance

T197	T198	T201
D0402	D0402	D0408
HSSE V3	HSSE V3	HSSE V3
Blu	Blu	TiCN
VA DH	VA DH	VA DH
R45 Back Chamf.	R45 Back Chamf.	R45 Back Chamf.
Form C / 2.5 x P	Form C / 2.5 x P	Form C / 2.5 x P
ISO 2 / 6H	ISO 3 / 6G	ISO 2 / 6H
Item #	Item #	Item #
•	•	•
•	•	•
•	•	•
•	•	•
•	•	•
T197 0300	•	T201 0300
•	•	•
T197 0400	•	T201 0400
T197 0500	•	T201 0500
T197 0600	•	T201 0600
T197 0800	•	T201 0800
T197 1000	•	T201 1000



Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø
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
1400	M 14	x 2	110	20	-	11.0	9.0	12	3	12.0
1600	M 16	x 2	110	20	-	12.0	9.0	12	4	14.0
1800	M 18	x 2.5	125	25	-	14.0	11.0	14	4	15.5
2000	M 20	x 2.5	140	25	-	16.0	12.0	15	4	17.5
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
3600	M 36	x 4	200	40	-	28.0	22.0	25	4	32.0
4200	M 42	x 4.5	200	45	-	32.0	24.0	27	4	37.5



Item #	Item #	Item #
T199	T200	T202
T199 0600	•	T202 0600
T199 0800	•	T202 0800
T199 1000	•	T202 1000
T199 1200	•	T202 1200
T199 1400	•	T202 1400
T199 1600	•	T202 1600
T199 1800	•	T202 1800
T199 2000	•	T202 2000
T199 2200	•	T202 2200
T199 2400	•	T202 2400
T199 2700	•	T202 2700
T199 3000	•	T202 3000
T199 3600	•	T202 3600
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

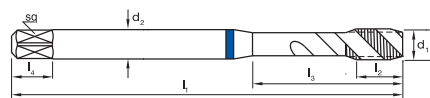
• Optimal ○ Effective

• 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 d₁



Catalogue Code

Discount Group

Material

Surface Finish

Sutton Designation

Geometry

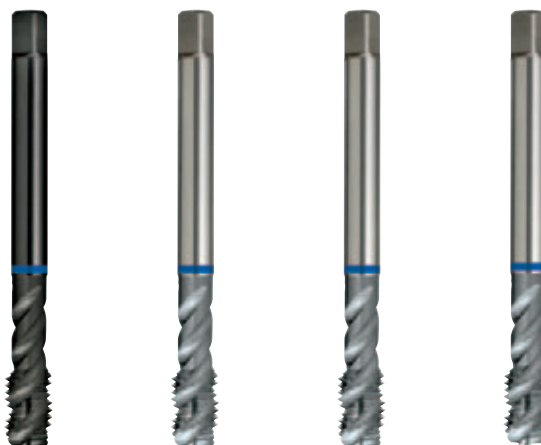
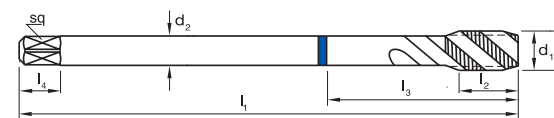
Chamfer

Limit & Nut Tolerance

Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø
0160	M 1.6	x 0.35	40	8	-	2.5	2.1	5	3	1.25
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
0300	M 3	x 0.5	56	5	18	3.5	2.7	6	3	2.5
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
0500	M 5	x 0.8	70	8	25	6.0	4.9	8	3	4.2
0600	M 6	x 1	80	10	30	6.0	4.9	8	3	5.0
0800	M 8	x 1.25	90	12.5	35	8.0	6.2	9	3	6.8
1000	M 10	x 1.5	100	15	39	10.0	8.0	11	3	8.5



T203	T205	T678	T676
D0402	D0408	D0408	D0408
PM-HSSE V3	PM-HSSE V3	PM-HSSE V3	PM-HSSE V3
Blu	TiCN	TiCN	TiCN
VA PM	VA PM	VA PM	VA PM
R50	R50	R50	R50
Form C / 2.5 x P	Form C / 2.5 x P	Form C / 2.5 x P	Form E / 1.5 x P
6HX	6HX	6GX	6HX
Item #	Item #	Item #	Item #
•	T205 0160	•	•
•	T205 0200	T678 0200	T676 0200
•	•	•	•
•	•	•	•
•	T205 0250	T678 0250	T676 0250
T203 0300	T205 0300	T678 0300	T676 0300
•	T205 0350	T678 0350	T676 0350
T203 0400	T205 0400	T678 0400	T676 0400
T203 0500	T205 0500	T678 0500	T676 0500
T203 0600	T205 0600	T678 0600	T676 0600
T203 0800	T205 0800	T678 0800	T676 0800
T203 1000	T205 1000	T678 1000	T676 1000



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	●	●	○	○		○	○	○	○	○		●	○	○	○	○								○	○	○	○		○				●			○															

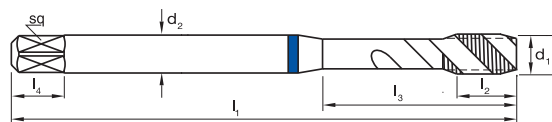
P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials

• Optimal ○ Effective

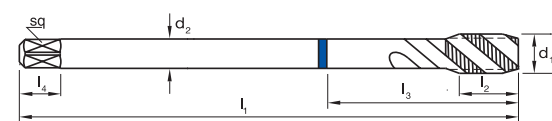
* HSSE V3 >20mm • Available on request as special manufacture. Subject to lead time.

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 d₁



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																																																																																														

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

• Optimal ○ Effective



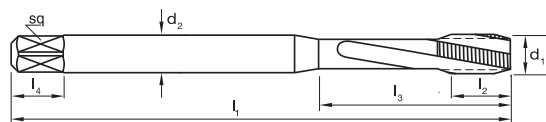
Catalogue Code	T207
Discount Group	D0408
Material	PM-HSSE V3
Surface Finish	TiCN
Sutton Designation	VA PM
Geometry	R50 IK
Chamfer	Form C / 2.5 x P
Limit & Nut Tolerance	6HX



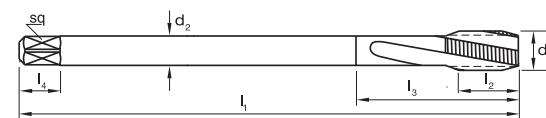
DIN Taps Metric, Spiral Flute, R40 NH

suttontools

- Suitable for harder short chipping materials up to 42 HRC
- Blind holes
- Depths up to 2.5 x d₁



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 #
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			●	●	●		●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○			○	○	○	○	○	○	○																	○	

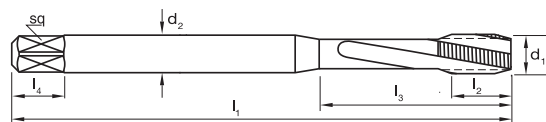
P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials

• Optimal ○ Effective

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

suttontools

- For Titanium based alloys
- For duplex and super duplex stainless steels
- For Nickel based alloys >850N/mm² <1150N/mm²
- Tight tolerances and optimised microfinish for optimal process reliability and excellent thread quality
- Blind holes up to approx. 1.5 x d₁



Catalogue Code	T215
Discount Group	D0408
Material	PM-HSS Co
Surface Finish	TTCN
Sutton Designation	Ti
Geometry	R15
Chamfer	Form C / 3 x P
Limit & Nut Tolerance	6HX

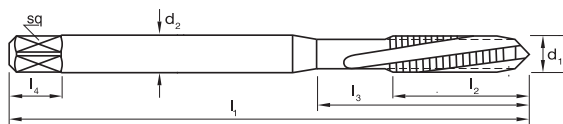
Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #
DIN 371											
0200	M 2	x 0.4	45	4	-	2.8	2.1	5	3	1.6	
0250	M 2.5	x 0.45	50	4	-	2.8	2.1	5	3	2.05	
0300	M 3	x 0.5	56	6	18	3.5	2.7	6	3	2.5	T215 0300
0350	M 3.5	x 0.6	56	6	20	4.0	3.0	6	3	2.9	
0400	M 4	x 0.7	63	7	21	4.5	3.4	6	3	3.3	T215 0400
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
0805	M 8	x 1	90	12.5	35	8.0	6.2	9	3	7.0	
0800	M 8	x 1.25	90	12.5	35	8.0	6.2	9	3	6.8	T215 0800
1006	M 10	x 1.25	100	15	39	10.0	8.0	11	3	8.8	
1000	M 10	x 1.5	100	15	39	10.0	8.0	11	3	8.5	T215 1000
DIN 376											
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
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																
T215					○			○	○	○	○		○																							○			○		●	●	○	●	○																				
P	Steel	M	Stainless Steel													K	Cast Iron								N	Non-Ferrous Metals												S	Titanium & Super Alloys												H	Hard Materials				●	Optimal				○	Effective			

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



- For Titanium based alloys
- For duplex and super duplex stainless steels
- For Nickel based alloys $>850\text{N/mm}^2$ $<1150\text{N/mm}^2$
- Tight tolerances and optimised microfinish for optimal process reliability and excellent thread quality
- Through holes up to approx. $1.5 \times d_i$

[illegible]

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

●

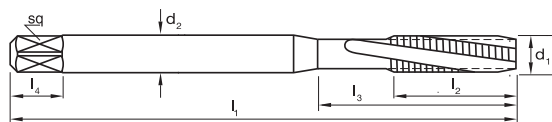
Optimal

○

Effective

suttontools

- For Nickel alloys / age-hardened super alloys >1150M/mm²
- Tight tolerances and optimised microfinish for optimal process reliability and excellent thread quality
- Blind or through holes
- Depths up to approx. 1.5 x d₁



Catalogue Code	T217
Discount Group	D0408
Material	PM-HSS Co
Surface Finish	TTCN
Sutton Designation	Ni
Geometry	R10
Chamfer	Form C / 3 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 #
DIN 371											
0200	M 2	x 0.4	45	8	-	2.8	2.1	5	3		
0250	M 2.5	x 0.45	50	9	-	2.8	2.1	5	3		
0300	M 3	x 0.5	56	11	18	3.5	2.7	6	3		T217 0300
0350	M 3.5	x 0.6	56	13	20	4.0	3.0	6	3		
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											
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
1800	M 18	x 2.5	125	34	-	14.0	11.0	14	4		•
2000	M 20	x 2.5	140	34	-	16.0	12.0	15	4		T218 2000
2200	M 22	x 2.5	140	34	-	18.0	14.5	17	4		
2400	M 24	x 3	160	38	-	18.0	14.5	17	4		
2700	M 27	x 3	160	38	-	20.0	16.0	19	4		
3000	M 30	x 3.5	180	45	-	22.0	18.0	21	4		

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

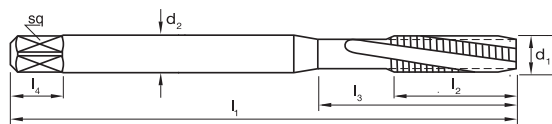
P Steel **M** Stainless Steel **K** Cast Iron **N** Non-Ferrous Metals **S** Titanium & Super Alloys **H** Hard Materials

● Optimal ○ Effective

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

suttontools

- For Nickel alloys / age-hardened super alloys >1150M/mm²
- Blind or through holes
- Tight tolerances and optimised microfinish for optimal process reliability and excellent thread quality
- Depths up to approx. 1.5 x d₁



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

Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø [†]	Item #
DIN 371											
0300	MJ 3	x 0.5	56	11	18	3.5	2.7	6	3		•
0400	MJ 4	x 0.7	63	13	21	4.5	3.4	6	3		•
0500	MJ 5	x 0.8	70	16	25	6.0	4.9	8	3		•
0600	MJ 6	x 1	80	19	30	6.0	4.9	8	3		•
0805	MJ 8	x 1	90	22	35	8.0	6.2	9	3		•
0800	MJ 8	x 1.25	90	22	35	8.0	6.2	9	3		•
1006	MJ 10	x 1.25	100	24	39	10.0	8.0	11	3		•
1000	MJ 10	x 1.5	100	24	39	10.0	8.0	11	3		•
DIN 376											
1200	MJ 12	x 1.75	110	29	-	9.0	7.0	10	3		
1400	MJ 14	x 2	110	30	-	11.0	9.0	12	3		
1600	MJ 16	x 2	110	32	-	12.0	9.0	12	3		
1800	MJ 18	x 2.5	125	34	-	14.0	11.0	14	4		
2000	MJ 20	x 2.5	140	34	-	16.0	12.0	15	4		
2200	MJ 22	x 2.5	140	34	-	18.0	14.5	17	4		
2400	MJ 24	x 3	160	38	-	18.0	14.5	17	4		
2700	MJ 27	x 3	160	38	-	20.0	16.0	19	4		
3000	MJ 30	x 3.5	180	45	-	22.0	18.0	21	4		
T793											

[†] 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		
T792																																																			

P Steel

M Stainless Steel

K Cast Iron

N Non-Ferrous Metals

S Titanium & Super Alloys

H Hard Materials

● Optimal

○ Effective

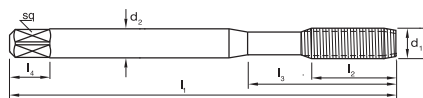
P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials

● Optimal ○ Effective

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

suttontools

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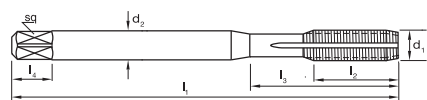


Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #	Item #	Item #	Item #
0100	M 1	x 0.25	40	6	-	2.5	2.1	3		0.9	T309 0100	T313 0100	T311 0100	T315 0100
0120	M 1.2	x 0.25	40	6	-	2.5	2.1	3		1.1	T309 0120	T313 0120	T311 0120	T315 0120
0140	M 1.4	x 0.3	40	6	-	2.5	2.1	3		1.28	T309 0140	T313 0140	T311 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

[illegible]

suttontools

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



Catalogue Code

Discount Group

Material

Surface Finish

Sutton Designation

Geometry

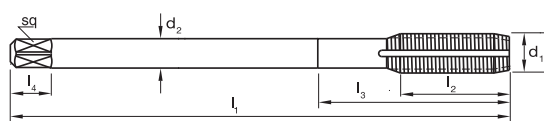
Chamfer

Limit & Nut Tolerance

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



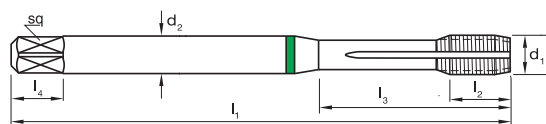
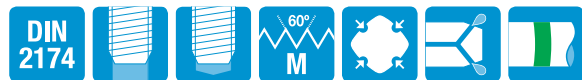
T319	T321	T323	T329
D0408	D0408	D0408	D0404
HSSE V3	HSSE V3	HSSE V3	HSSE V3
<i>TiCN</i>	<i>TiCN</i>	<i>TiCN</i>	<i>CrN</i>
N	N	N	Cu
Multi Coolant Groove	Multi Coolant Groove	Multi Coolant Groove	Single-Coolant Groove
Form C / 2.5 x P	Form D / 4 x P	Form C / 2.5 x P	Form C / 2.5 x P
6HX	6HX	6GX	6HX
Item #	Item #	Item #	Item #
T319 0100	•	•	•
T319 0140	•	•	•
T319 0160	•	•	•
T319 0200	•	•	•
T319 0250	•	•	•
T319 0300	T321 0300	T323 0300	T329 0300
T319 0350	T321 0350	T323 0350	T329 0350
T319 0400	T321 0400	T323 0400	T329 0400
T319 0500	T321 0500	T323 0500	T329 0500
T319 0600	T321 0600	T323 0600	T329 0600
T319 0800	T321 0800	T323 0800	T329 0800
T319 1000	T321 1000	T323 1000	T329 1000

[illegible][illegible]

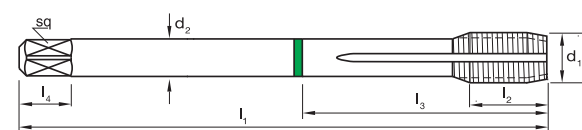
• Available on request as special manufacture. Subject to lead time. † Made to ~DIN 376 standard.

suttontools

- SPM for superior performance
- Application specific geometry
- Suitable for materials with >10% elongation
- Through or blind holes
- Depths up to 3 x d₁



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

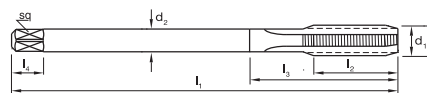
• Optimal ○ Effective

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

DIN Taps Metric Fine, Straight Flute, GG

suttontools

- HSSE V3, 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 d₁



Catalogue Code
Discount Group
Material
Surface Finish
Sutton Designation
Geometry
Chamfer
Limit & Nut Tolerance



Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #	Item #	Item #	Item #
DIN 374														
0302	MF 3	x 0.35	56	8	-	2.2	-	-	4	2.65	•	•		
0403	MF 4	x 0.5	63	10	-	2.8	2.1	5	4	3.5	T300 0403	T301 0403		
0503	MF 5	x 0.5	70	12	-	3.5	2.7	6	4	4.5	T300 0503	T301 0503		
0604	MF 6	x 0.75	80	14	-	4.5	3.4	6	4	5.3	T300 0604	T301 0604		
0803	MF 8	x 0.5	80	18	-	6.0	4.9	8	4	7.5	•	•		
0804	MF 8	x 0.75	80	18	-	6.0	4.9	8	4	7.3	•	•		
0805	MF 8	x 1	90	22	-	6.0	4.9	8	4	7.0	T300 0805	T301 0805		
1004	MF 10	x 0.75	90	20	-	7.0	5.5	8	4	9.3	•	•		
1005	MF 10	x 1	90	20	-	7.0	5.5	8	4	9.0	T300 1005	T301 1005		
1006	MF 10	x 1.25	100	24	-	7.0	5.5	8	4	8.8	T300 1006	T301 1006		
1205	MF 12	x 1	100	22	-	9.0	7.0	10	4	11.0	•	•		
1206	MF 12	x 1.25	100	22	-	9.0	7.0	10	4	10.8	T300 1206	T301 1206		
1207	MF 12	x 1.5	100	22	-	9.0	7.0	10	4	10.5	T300 1207	T301 1207		
1405	MF 14	x 1	100	22	-	11.0	9.0	12	4	13.0	•	•		
1406	MF 14	x 1.25	100	22	-	11.0	9.0	12	4	12.8	T300 1406	T301 1406		
1407	MF 14	x 1.5	100	22	-	11.0	9.0	12	4	12.5	T300 1407	T301 1407		
1605	MF 16	x 1	100	22	-	12.0	9.0	12	4	15.0	•	•		
1607	MF 16	x 1.5	100	22	-	12.0	9.0	12	4	14.5	T300 1607	T301 1607		
1805	MF 18	x 1	110	25	-	14.0	11.0	14	4	17.0	•	•		
1807	MF 18	x 1.5	110	25	-	14.0	11.0	14	4	16.5	T300 1807	T301 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	•	•		
2007	MF 20	x 1.5	125	25	-	16.0	12.0	15	4	18.5	T300 2007	T301 2007		
2008	MF 20	x 2	140	34	-	16.0	12.0	15	4	18.0	•	•		
DIN 371														
0805	MF 8	x 1	90	22	35	8.0	6.2	9	4	7.0			•	•
1005	MF 10	x 1	100	24	39	10.0	8.0	11	4	9.0			•	•
DIN 376														
1207	MF 12	x 1.5	110	28	-	9.0	7.0	10	4	10.5			•	•
1407	MF 14	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				

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

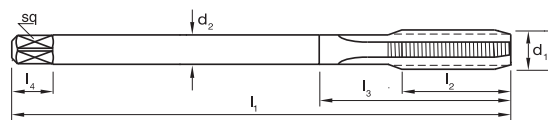
• Optimal ○ Effective

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

MF

suttontools

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



Size Ref.	d ₁	Pitch	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø
1006	MF 10	x 1.25	100	24	-	7.0	5.5	8	4	8.8
1207	MF 12	x 1.5	100	22	-	9.0	7.0	10	4	10.5
1407	MF 14	x 1.5	100	22	-	11.0	9.0	12	4	12.5
1607	MF 16	x 1.5	100	22	-	12.0	9.0	12	4	14.5

Catalogue Code	T668	T669
Discount Group	D0408	D0408
Material	PM-HSS Co	PM-HSS Co
Surface Finish	<i>TiCN</i>	<i>TiCN</i>
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
	Item #	Item #
	T668 1006	T669 1006
	T668 1207	T669 1207
	T668 1407	T669 1407
	T668 1607	T669 1607

[illegible]

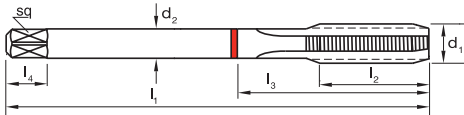
P Steel **M** Stainless Steel **K** Cast Iron **N** Non-Ferrous Metals **S** Titanium & Super Alloys **H** Hard Materials

● Optimal ○ Effective

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

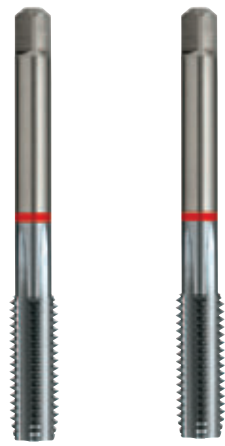
suttontools

-



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					○			○	●		●		●					●		●										○													●				●		

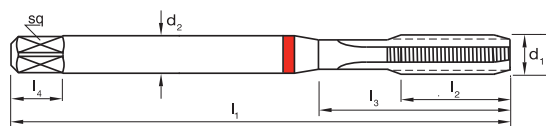
P	Steel	M	Stainless Steel	K	Cast Iron	N	Non-Ferrous Metals	S	Titanium & Super Alloys	H	Hard Materials	●	Optimal	○	Effective
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Catalogue Code	T343	T344
Discount Group	D0408	D0408
Material	SPM	SPM
Surface Finish	<i>TICN</i>	<i>TICN</i>
Sutton Designation	XH	XH
Geometry	Special Relief	Special Relief
Chamfer	Form C / 3 x P	Form D / 5 x P
Limit & Nut Tolerance	6HX	6HX

MF

- Use in hardened steels 50-60 HRC
- Through & blind holes
- Suitable for machine operations
- Depths up to approx. $1.5 \times d$



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

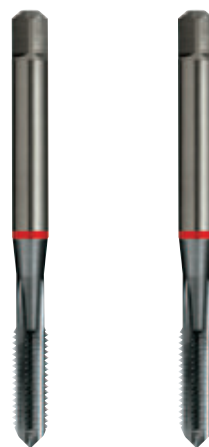
N Non-Ferrous Metals

S Titanium & Super Alloys

H Hard Materials

● Optimal

○ Effective

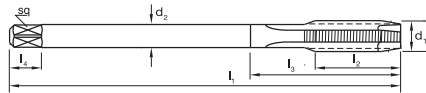


Catalogue Code	T345	T346
Discount Group	D0414	D0414
Material	VHM	VHM
Surface Finish	TICN	TICN
Sutton Designation	VH	VH
Geometry	Special Relief	Special Relief
Chamfer	Form C / 3 x P	Form D / 5 x P
Limit & Nut Tolerance	6HX	6HX

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 d₁



Catalogue Code
Discount Group
Material
Surface Finish
Sutton Designation
Geometry
Chamfer
Limit & Nut Tolerance

T154	T155	T156	T157
D0402	D0402	D0402	D0406
HSSE V3	HSSE V3	HSSE V3	HSSE V3
BrT	BrT	Blu	TiN
N	N	N	N
6G	6G	6G	6G
Form B / 4.5 x P	Form B / 4.5 x P	Form B / 4.5 x P	Form B / 4.5 x P
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	●	●	●	●	○	●	●	○			●				○	○	○	○	○	○	○	○	○	○	●	●	○			●	○																			

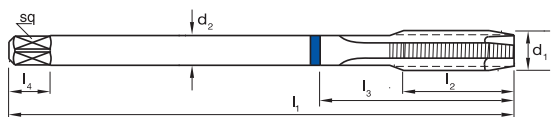
P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials

• Optimal ○ Effective

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

MF

-
- DIN 374**
- MF**
- 60°**

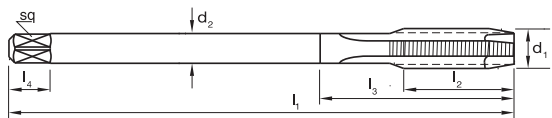
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● Optimal ○ Effective



Catalogue Code	T158	T161
Discount Group	D0402	D0408
Material	HSSE V3	HSSE V3
Surface Finish	<i>Blu</i>	<i>TICN</i>
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

-
- DIN 374**
- MF**
- 60°**



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	
T163			●	●	●		●	●		●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

P Steel

M Stainless Steel

K Cast Iron

N Non-Ferrous Metals

S Titanium & Super Alloys

H Hard Materials

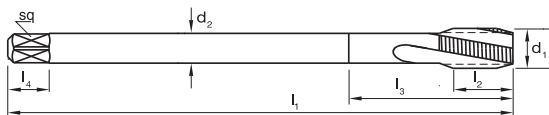
● Optimal

○ Effective



suttontools

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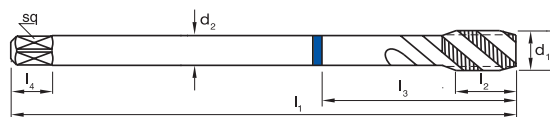
● Optimal ○ Effective



Catalogue Code	T243	T244
Discount Group	D0402	D0406
Material	HSSE V3	HSSE V3
Surface Finish	<i>Brt</i>	<i>TIN</i>
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

MF

- 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.

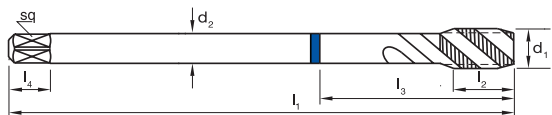
[illegible]

● Optimal ○ Effective

230

suttontools

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[illegible]

● Optimal ○ Effective



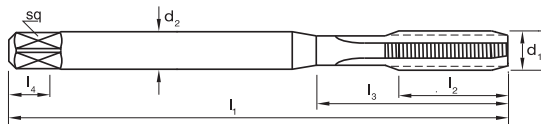
Catalogue Code	T250	T252
Discount Group	D0402	D0408
Material	PM-HSSE V3	PM-HSSE V3
Surface Finish	<i>Blu</i>	<i>TICN</i>
Sutton Designation	VA PM	VA PM
Geometry	R50	R50
Chamfer	Form C / 2.5 x P	Form C / 2.5 x P
Limit & Nut Tolerance	6HX	6HX

MF

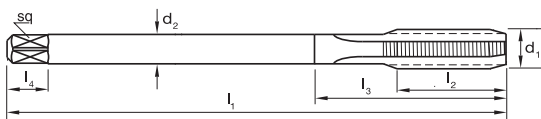
DIN Taps UNC, Straight Flute, GG

suttontools

- Use in grey cast iron (GG), brittle plastics, hard bronzes to a hardness of 850 N/mm²
- Through & blind holes
- Suitable for machine operations
- Depths up to approx. 3 x d₁



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					

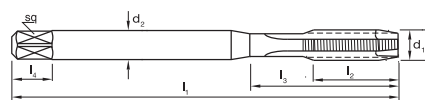
P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials

• Optimal ○ Effective

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

UNC

- General purpose use, materials up to approx. 1000 N/mm²
- Through holes
- Suitable for machine operations
- Depths up to approx. 3 x d₁



Catalogue Code

Discount Group

Material

Surface Finish

Sutton Designation

Geometry

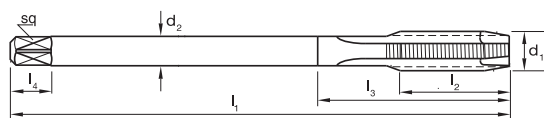
Chamfer

Limit & Nut Tolerance

Size Ref.	d ₁	TPI	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø
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
0794	5/16	18	90	22	34	8.0	6.2	9	3	6.6
0953	3/8	16	100	22	35	10.0	7.0	10	3	8.0



T164	T165	T166	T167
D0402	D0402	D0402	D0406
HSSE V3	HSSE V3	HSSE V3	HSSE V3
Br	Br	Blu	TiN
N	N	N	N
Form B / 4.5 x P	Form B / 4.5 x P	Form B / 4.5 x P	Form B / 4.5 x P
2B	3B	2B	2B
Item #	Item #	Item #	Item #
T164 0218	•	T166 0218	T167 0218
T164 0251	•	T166 0251	T167 0251
T164 0284	•	T166 0284	T167 0284
T164 0318	•	T166 0318	T167 0318
T164 0351	•	T166 0351	T167 0351
T164 0417	•	T166 0417	T167 0417
T164 0483	•	T166 0483	T167 0483
T164 0549	•	T166 0549	T167 0549
T164 0635	•	T166 0635	T167 0635
T164 0794	•	T166 0794	T167 0794
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					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	
T164	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○
T165	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○
T166	●	●	●	●	●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○
T167	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

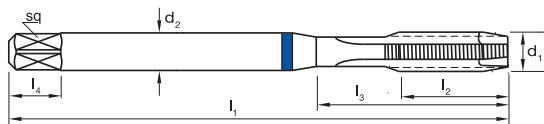
P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials

• Optimal ○ Effective

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

suttontools

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Technical drawing of a bolt with dimensions. The bolt has a total length l_1 , a head diameter d_1 , a head length l_2 , a shank diameter d_2 , and a shank length l_3 . A section line 'sq' is shown on the left end.

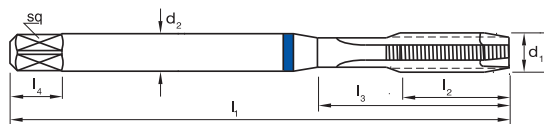
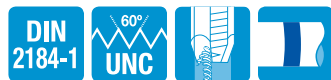
[illegible]

● Optimal ○ Effective

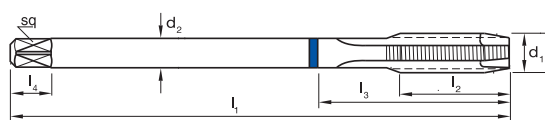


suttontools

- 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 d₁



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								

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

● Optimal ○ Effective



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

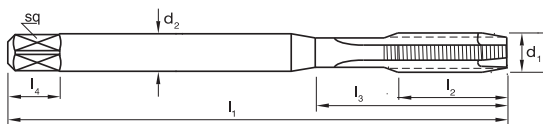
Limit & Nut Tolerance

2BX



suttontools

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[illegible]

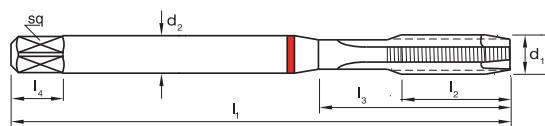
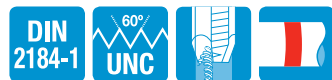
ISO	P													M	K					N										S										H									
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T168			●	●	○		●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○																									○		
T169			●	●	●		●	●	○	●	○	○	○	○	○	○	●	○	○	○	○	○			○	○	○	○	●	○	○														○			○	

● Optimal ○ Effective

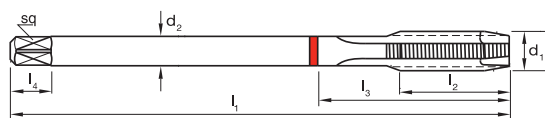


suttontools

- Use in harder short chipping materials up to 45 HRC
- Through holes
- Suitable for machine operations
- Depths up to approx. $3 \times d_1$



Size Ref.	d ₁	TPI	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø
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
0794	5/16	18	90	22	34	8.0	6.2	9	3	6.6
0953	3/8	16	100	22	35	10.0	7.0	10	3	8.0

[illegible]

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



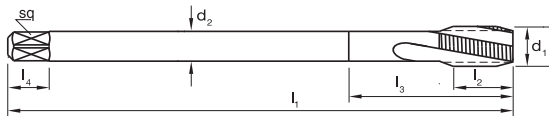
Catalogue Code	T172	T666
Discount Group	D0402	D0408
Material	PM-HSS Co	PM-HSS Co
Surface Finish	Blu	TiCN
Sutton Designation	H	H
Geometry	Low Relief	Low Relief
Chamfer	Form C / 3 x P	Form C / 3 x P
Limit & Nut Tolerance	2BX	2BX
	Item #	Item #
	•	•
	•	•
	•	•
	•	•
	•	•
	•	•
	•	•
	•	•
	T172 0635	T666 0635
	T172 0794	T666 0794
	T172 0953	T666 0953

[illegible]

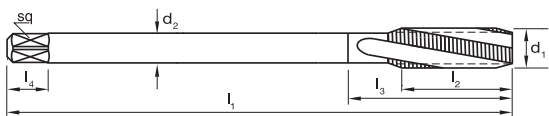
DIN Taps UNC, Spiral Flute, R15 N

suttontools

- General purpose use, materials up to approx. 1000 N/mm²
- Blind holes
- Suitable for machine operations
- Depths up to approx. 1.5 x d₁



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	•	•	•

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	
T255	●	●	○	○		●	○			○				○			○		○			○	○	●	●	○	○		○	○																				
T256	●	●	●	●	○	●	○	○		●		○		○			○		○		○		○	●	●	○	○		○	○																				
T257	●	●	○	○	○	●	○			○				○			○		○		○		○	●	●	○	○		○	○																				

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

• Optimal ○ Effective

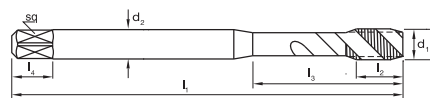
• Available on request as special manufacture. Subject to lead time.

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 d₁



Catalogue Code

Discount Group

Material

Surface Finish

Sutton Designation

Geometry

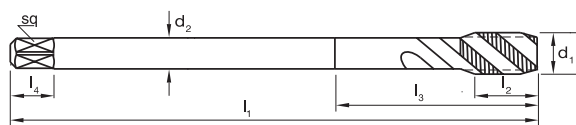
Chamfer

Limit & Nut Tolerance

Size Ref.	d ₁	TPI	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø
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



T258	T259	T260	T273
D0402	D0402	D0402	D0406
HSSE V3	HSSE V3	HSSE V3	HSSE V3
BrT	BrT	Blu	TiN
N	N	N	N
R40	R40	R40	R40
Form C / 2.5 x P	Form C / 2.5 x P	Form C / 2.5 x P	Form C / 2.5 x P
2B	3B	2B	2B
Item #	Item #	Item #	Item #
T258 0218	•	T260 0218	T273 0218
•	•	T260 0251	T273 0251
T258 0284	•	T260 0284	T273 0284
T258 0318	•	T260 0318	T273 0318
T258 0351	•	T260 0351	T273 0351
T258 0417	•	T260 0417	T273 0417
T258 0483	•	T260 0483	T273 0483
T258 0549	•	T260 0549	T273 0549
T258 0635	•	T260 0635	T273 0635
T258 0794	•	T260 0794	T273 0794
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

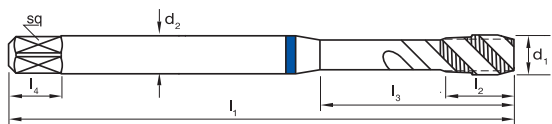
• Optimal ○ Effective

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

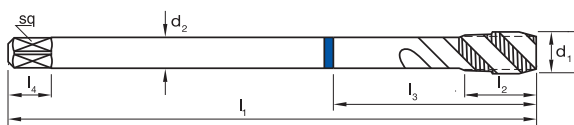
DIN Taps UNC, Spiral Flute, R45 VA DH

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 d₁



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										

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

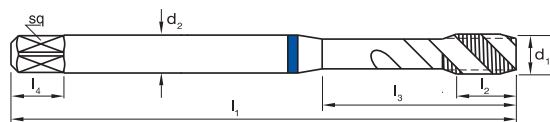
• Optimal ○ Effective

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

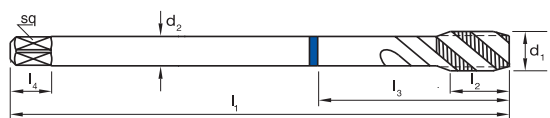
UNC

suttontools

- PM-HSSE V3 offers superior tool life
- Use in stainless steels and high strength steels up to 850N/mm²
- Blind holes up to 3 x d₁
- Suitable for synchronous tapping in machine operations



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												

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

● Optimal ○ Effective



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



suttontools

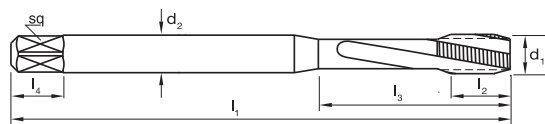
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● Optimal ○ Effective

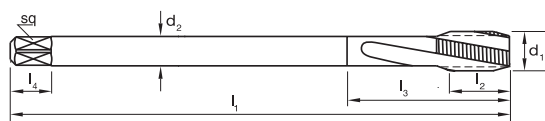
DIN Taps UNC, Spiral Flute, R40 NH

suttontools

- Use in harder short chipping materials up to 42 HRC
- Blind holes
- Suitable for machine operations
- Depths up to approx. 2.5 x d₁



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	•	•
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

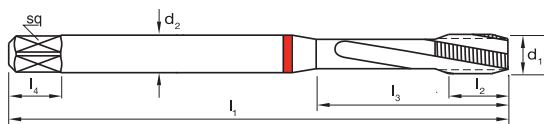
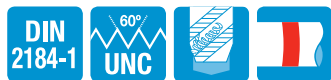
• Available on request as special manufacture. Subject to lead time. * HSSE V3 > 3/4



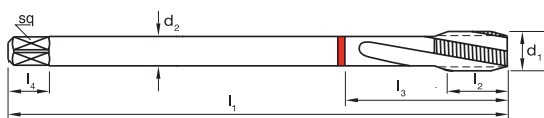
DIN Taps UNC, Spiral Flute, R15 H

suttontools

- Use in harder short chipping materials up to 45 HRC
- Blind holes
- Suitable for machine operations
- Depths up to approx. 1.5 x d₁



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



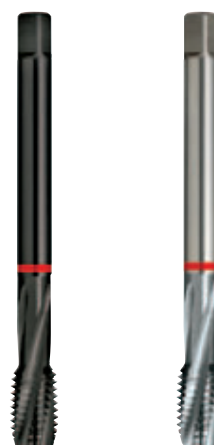
Size Ref.	d ₁	TPI	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #	Item #
1111	7/16	14	100	15	-	8.0	6.2	8	3	9.4	T265 1111	T667 1111
1270	1/2	13	110	18	-	9.0	7.0	10	4	10.8	T265 1270	T667 1270
1429	9/16	12	110	20	-	11.0	9.0	12	4	12.2	T265 1429	T667 1429
1588	5/8	11	110	20	-	12.0	9.0	12	4	13.5	T265 1588	T667 1588
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

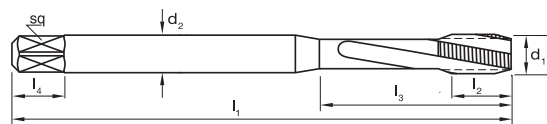
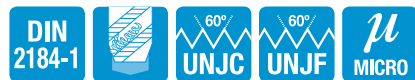
• Available on request as special manufacture. Subject to lead time. * HSSE V3 > 3/4



UNC

suttontools

- For Titanium based alloys
- For duplex and super duplex stainless steels
- For Nickel based alloys >850N/mm² <1150N/mm²
- Tight tolerances and optimised microfinish for optimal process reliability and excellent thread quality
- Blind holes up to approx. 1.5 x d₁



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										
0218	# 2	56	45	9	10	2.8	2.1	5	2	
0251	# 3	48	50	9	10	2.8	2.1	5	2	
0284	# 4	40	56	5	18	3.5	2.7	6	2	•
0318	# 5	40	56	6	18	3.5	2.7	6	3	
0351	# 6	32	56	6	19	4.0	3.0	6	3	•
0417	# 8	32	63	7	19	4.5	3.4	6	3	•
0483	# 10	24	70	8	20	6.0	4.9	8	3	•
0549	# 12	24	80	10	29	6.0	4.9	8	3	
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
1111	7/16	14	100	15	-	8.0	6.2	8	3	
1270	1/2	13	110	18	-	9.0	7.0	10	3	•
1429	9/16	12	110	20	-	11.0	9.0	12	3	
1588	5/8	11	110	20	-	12.0	9.0	12	3	•
1905	3/4	10	125	25	-	14.0	11.0	14	4	•
2223	7/8	9	140	28	-	18.0	14.5	17	4	
2540	1	8	160	32	-	18.0	14.5	17	4	•
UNJF										
0218	# 2	64	45	9	10	2.8	2.1	5	2	
0251	# 3	56	50	9	10	2.8	2.1	5	2	
0284	# 4	48	56	5	18	3.5	2.7	6	2	•
0318	# 5	44	56	6	18	3.5	2.7	6	3	
0351	# 6	40	56	6	19	4.0	3.0	6	3	•
0417	# 8	36	63	7	19	4.5	3.4	6	3	•
0483	# 10	32	70	8	20	6.0	4.9	8	3	•
0549	# 12	28	80	10	29	6.0	4.9	8	3	
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
1111	7/16	20	100	15	-	8.0	6.2	8	3	
1270	1/2	20	110	18	-	9.0	7.0	10	3	•
1429	9/16	18	110	20	-	11.0	9.0	12	3	
1588	5/8	18	110	20	-	12.0	9.0	12	3	•
1905	3/4	16	125	25	-	14.0	11.0	14	4	•
2223	7/8	14	140	28	-	18.0	14.5	17	4	
2540	1	12	160	32	-	18.0	14.5	17	4	•

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				

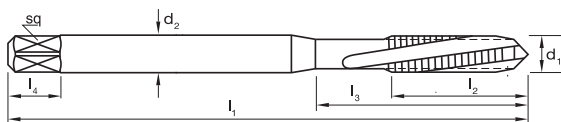
P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials

● Optimal ○ Effective

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

suttontools

- For Titanium based alloys
- For duplex and super duplex stainless steels
- For Nickel based alloys >850N/mm² <1150N/mm²
- Tight tolerances and optimised microfinish for optimal process reliability and excellent thread quality
- Through holes up to approx. 1.5 x d₁



Catalogue Code	T786
Discount Group	D0408
Material	PM-HSS Co
Surface Finish	TTCN
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											
0218	# 2	56	45	9	10	2.8	2.1	5	2		
0251	# 3	48	50	9	10	2.8	2.1	5	2		
0284	# 4	40	56	11	18	3.5	2.7	6	2		•
0318	# 5	40	56	11	18	3.5	2.7	6	3		
0351	# 6	32	56	13	19	4.0	3.0	6	3		•
0417	# 8	32	63	13	19	4.5	3.4	6	3		•
0483	# 10	24	70	16	20	6.0	4.9	8	3		•
0549	# 12	24	80	19	29	6.0	4.9	8	3		
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
1111	7/16	14	100	24	-	8.0	6.2	8	3		
1270	1/2	13	110	28	-	9.0	7.0	10	3		•
1429	9/16	12	110	32	-	11.0	9.0	12	3		
1588	5/8	11	110	32	-	12.0	9.0	12	3		•
1905	3/4	10	125	34	-	14.0	11.0	14	4		•
2223	7/8	9	140	34	-	18.0	14.5	17	4		
2540	1	8	160	38	-	18.0	14.5	17	4		•
UNJF											
											T787
0218	# 2	64	45	9	10	2.8	2.1	5	2		
0251	# 3	56	50	9	10	2.8	2.1	5	2		
0284	# 4	48	56	11	18	3.5	2.7	6	2		•
0318	# 5	44	56	11	18	3.5	2.7	6	3		
0351	# 6	40	56	13	19	4.0	3.0	6	3		•
0417	# 8	36	63	13	19	4.5	3.4	6	3		•
0483	# 10	32	70	16	20	6.0	4.9	8	3		•
0549	# 12	28	80	19	29	6.0	4.9	8	3		
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
1111	7/16	20	100	24	-	8.0	6.2	8	3		
1270	1/2	20	110	28	-	9.0	7.0	10	3		•
1429	9/16	18	110	32	-	11.0	9.0	12	3		
1588	5/8	18	110	32	-	12.0	9.0	12	3		•
1905	3/4	16	125	34	-	14.0	11.0	14	4		•
2223	7/8	14	140	34	-	18.0	14.5	17	4		
2540	1	12	160	38	-	18.0	14.5	17	4		•

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	
T796																																																		
P	Steel			M	Stainless Steel			K	Cast Iron			N	Non-Ferrous Metals			S	Titanium & Super Alloys			H	Hard Materials																							●	Optimal		○	Effective		

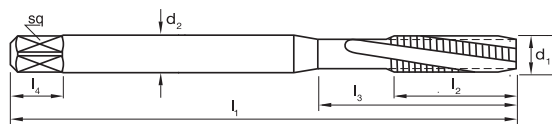
P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials

● Optimal ○ Effective

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

suttontools

- For Nickel alloys / age-hardened super alloys >1150M/mm²
- Tight tolerances and optimised microfinish for optimal process reliability and excellent thread quality
- Blind or through holes
- Depths up to approx. 1.5 x d₁



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											
0218	# 2	56	45	9	10	2.8	2.1	5	2		
0251	# 3	48	50	9	10	2.8	2.1	5	2		
0284	# 4	40	56	11	18	3.5	2.7	6	2		•
0318	# 5	40	56	11	18	3.5	2.7	6	3		
0351	# 6	32	56	13	19	4.0	3.0	6	3		•
0417	# 8	32	63	13	19	4.5	3.4	6	3		•
0483	# 10	24	70	16	20	6.0	4.9	8	3		•
0549	# 12	24	80	19	29	6.0	4.9	8	3		
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
1111	7/16	14	100	24	-	8.0	6.2	8	3		
1270	1/2	13	110	28	-	9.0	7.0	10	3		T794 1270
1429	9/16	12	110	30	-	11.0	9.0	12	3		
1588	5/8	11	110	32	-	12.0	9.0	12	3		•
1905	3/4	10	125	34	-	14.0	11.0	14	4		•
2223	7/8	9	140	34	-	18.0	14.5	17	4		
2540	1	8	160	38	-	18.0	14.5	17	4		•
UNJF											
											T795
0218	# 2	64	45	9	10	2.8	2.1	5	2		
0251	# 3	56	50	9	10	2.8	2.1	5	2		
0284	# 4	48	56	11	18	3.5	2.7	6	2		•
0318	# 5	44	56	11	18	3.5	2.7	6	3		
0351	# 6	40	56	13	19	4.0	3.0	6	3		•
0417	# 8	36	63	13	19	4.5	3.4	6	3		•
0483	# 10	32	70	16	20	6.0	4.9	8	3		•
0549	# 12	28	80	19	29	6.0	4.9	8	3		
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
1111	7/16	20	100	24	-	8.0	6.2	8	3		•
1270	1/2	20	110	28	-	9.0	7.0	10	3		•
1429	9/16	18	110	30	-	11.0	9.0	12	3		
1588	5/8	18	110	32	-	12.0	9.0	12	3		
1905	3/4	16	125	34	-	14.0	11.0	14	4		
2223	7/8	14	140	34	-	18.0	14.5	17	4		
2540	1	12	160	38	-	18.0	14.5	17	4		

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

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

• Optimal ○ Effective

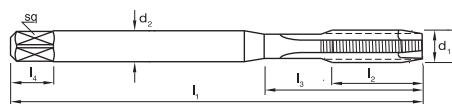
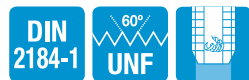
* Available on request as special manufacture. Subject to lead time.

† 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.

DIN Taps UNF, Gun, N

suttontools

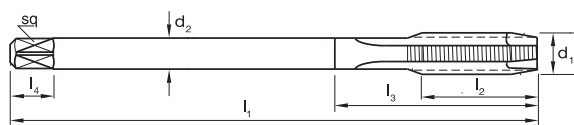
- General purpose use, materials up to approx. 1000 N/mm²
- Through holes
- Suitable for machine operations
- Depths up to approx. 3 x d₁



Catalogue Code
Discount Group
Material
Surface Finish
Application
Geometry
Chamfer
Limit & Nut Tolerance



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	•	•	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	•	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	•	T702 1111	T175 1111
1270	1/2	20	110	28	-	9.0	7.0	10	3	11.5	T173 1270	•	T702 1270	T175 1270
1429	9/16	18	110	32	-	11.0	9.0	12	3	12.8	T173 1429	•	T702 1429	T175 1429
1588	5/8	18	110	32	-	12.0	9.0	12	3	14.5	T173 1588	•	T702 1588	T175 1588
1905	3/4	16	125	34	-	14.0	11.0	14	4	17.5	T173 1905	•	T702 1905	T175 1905
2223	7/8	14	140	34	-	18.0	14.5	17	4	20.5	T173 2223	•	T702 2223	T175 2223
2540	1	12	160	38	-	18.0	14.5	17	4	23.5	T173 2540	•	T702 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	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●

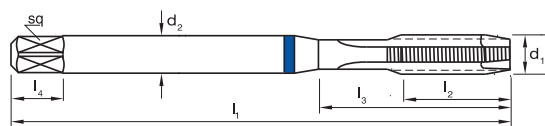
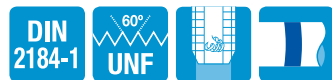
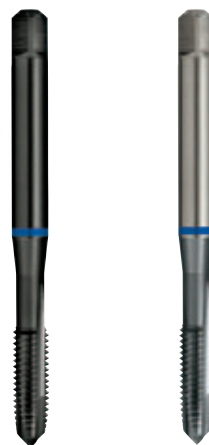
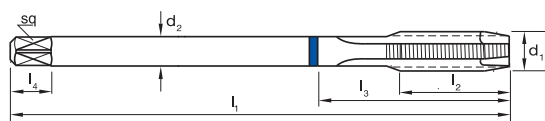
P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metals S Titanium & Super Alloys H Hard Materials

• Optimal ○ Effective

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

UNF

- Use in stainless steels and high strength steels up to 1000N/mm²
- Through holes
- Suitable for machine operations
- Depths up to approx. 3 x d₁

[illegible]

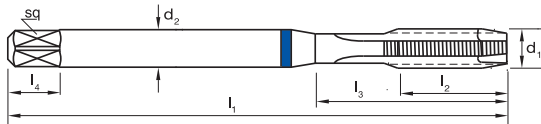
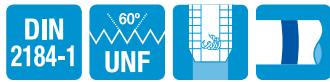
Catalogue Code	T176	T177
Discount Group	D0402	D0408
Material	HSSE V3	HSSE V3
Surface Finish	<i>Blu</i>	<i>TICN</i>
Sutton Designation	VA	VA
Geometry	Special Relief	Special Relief
Chamfer	Form B / 4.5 x P	Form B / 4.5 x P
Limit & Nut Tolerance	2B	2B
	Item #	Item #
	•	•
	•	•
	T176 0284	•
	•	•
	T176 0351	•
	T176 0417	•
	T176 0483	T177 0483
	•	•
	T176 0635	T177 0635
	T176 0794	T177 0794
	T176 0953	T177 0953

[illegible]

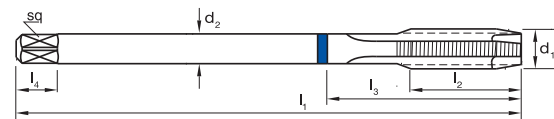
ISO	P													M			K					N										S										H							
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T176	●	●	●	○		●	○					○		●	●	○								○	○	○	○	○	○		○			●	○	○													
T177	●	●	○			○	○				○		●	○	○									○	○	○	○	○	○		○			○	○														
P	Steel	M	Stainless Steel		K	Cast Iron		N	Non-Ferrous Metals		S	Titanium & Super Alloys		H	Hard Materials																											●	Optimal		○	Effective			

● Optimal ○ Effective

- 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 d₁



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	

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

● Optimal ○ Effective



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



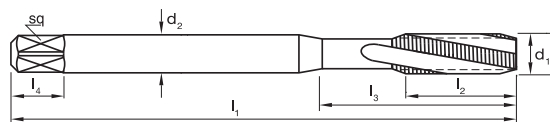
DIN Taps UNF, Spiral Flute, R15 N

suttontools

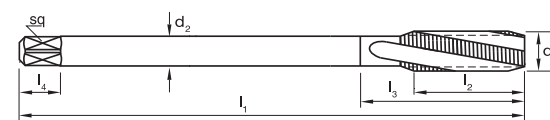
- General purpose use, materials up to approx. 1000 N/mm²
- Blind holes
- Suitable for machine operations
- Depths up to approx. 1.5 x d₁

DIN
2184-1

60°
UNF



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



Catalogue Code

T274

Discount Group

D0402

Material

HSSE V3

Surface Finish

Brt

Sutton Designation

N

Geometry

R15

Chamfer

Form C / 2.5 x P

Limit & Nut Tolerance

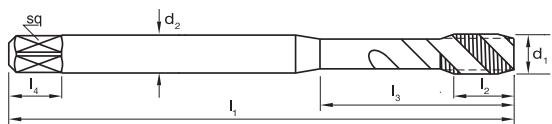
2B



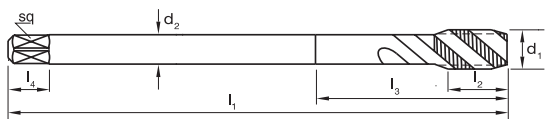
DIN Taps UNF, Spiral Flute, R40 N

suttontools

- General purpose use, materials up to approx. 1000 N/mm²
- Blind holes
- Suitable for machine operations
- Depths up to approx. 2.5 x d₁



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.



Catalogue Code	T275	T701
Discount Group	D0402	D0402
Material	HSSE V3	HSSE V3
Surface Finish	Br	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

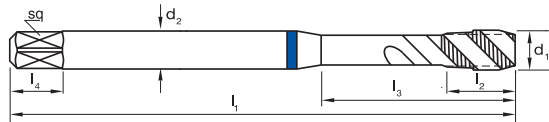


UNF

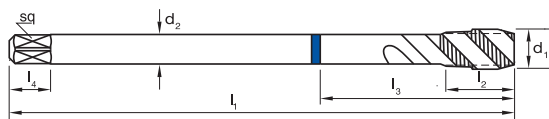
DIN Taps UNF, Spiral Flute, R45 VA DH

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 d₁



Size Ref.	d ₁	TPI	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø
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

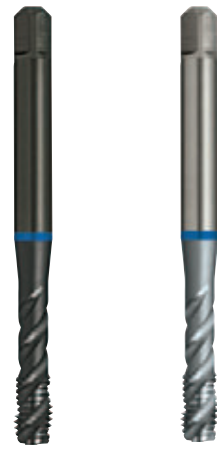


Size Ref.	d ₁	TPI	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø
1429	7/16	20	100	15	-	8.0	6.2	8	3	9.8
1270	1/2	20	110	18	-	9.0	7.0	10	3	11.5
1429	9/16	18	110	20	-	11.0	9.0	12	3	12.8
1588	5/8	18	110	20	-	12.0	9.0	12	3	14.5
1905	3/4	16	125	25	-	14.0	11.0	14	4	17.5
2223	7/8	14	140	28	-	18.0	14.5	17	4	20.5
2540	1	12	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					
T276	●	●	○			○	○					○		●	●	○																																						
T277	●	●	○	○		○	○	○		○		●		●	●	●								○	○	○	○		○				●		○																			

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

● Optimal ○ Effective



Catalogue Code	T276	T277
Discount Group	D0402	D0408
Material	HSSE V3	HSSE V3
Surface Finish	<i>Blu</i>	<i>TiCN</i>
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
	Item #	Item #
	●	●
	●	●
	●	●
	●	●
	T276 0351	●
	T276 0417	●
	T276 0483	●
	●	●
	T276 0635	T277 0635
	T276 0794	T277 0794
	T276 0953	T277 0953



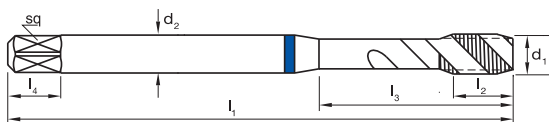
Size Ref.	d ₁	TPI	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #	Item #
1429	7/16	20	100	15	-	8.0	6.2	8	3	9.8	T276 1111	T277 1111
1270	1/2	20	110	18	-	9.0	7.0	10	3	11.5	T276 1270	T277 1270
1429	9/16	18	110	20	-	11.0	9.0	12	3	12.8	●	●
1588	5/8	18	110	20	-	12.0	9.0	12	3	14.5	T276 1588	T277 1588
1905	3/4	16	125	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	●	●	○	○		○	○	○		○		●		●	●	●								○	○	○	○		○				●		○																			

• 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 d₁
- Suitable for synchronous tapping in machine operations

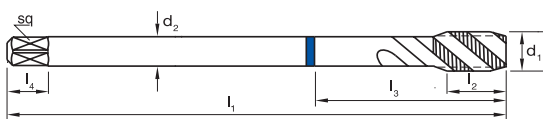


Size Ref.	d ₁	TPI	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	Item #
0284	# 4	48	56	5	18	3.5	2.7	6	2	2.35	T696 0284
0351	# 6	40	56	6	20	4.0	3.0	6	3	2.9	T696 0351
0417	# 8	36	63	7	21	4.5	3.4	6	3	3.5	T696 0417
0483	# 10	32	70	8	25	6.0	4.9	8	3	4.1	T696 0483
0635	1/4	28	80	10	30	7.0	5.5	8	3	5.5	T696 0635



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

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	-	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



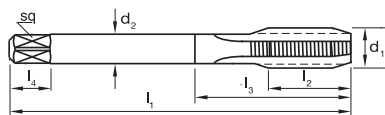
ISO	P													M	K								N										S										H						
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T696	●	●	●	○		●	○	○		○		●		●	●	●								○	○	○	○	○	○		○			●		●													
P	Steel			M	Stainless Steel			K	Cast Iron			N	Non-Ferrous Metals			S	Titanium & Super Alloys			H	Hard Materials													●	Optimal			○	Effective										

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

● Optimal ○ Effective

suttontools

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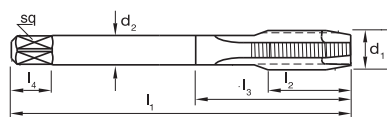
● Optimal ○ Effective



Catalogue Code	T306	T307
Discount Group	D0402	D0408
Material	HSSE V3	HSSE V3
Surface Finish	<i>Ni + Blu</i>	<i>TiCN</i>
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

suttontools

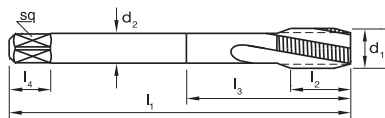
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Catalogue Code	T178	T179	T180
Discount Group	D0402	D0402	D0406
Material	HSSE V3	HSSE V3	HSSE V3
Surface Finish	<i>Brt</i>	<i>Blu</i>	<i>TiN</i>
Sutton Designation	N	N	N
Geometry			
Chamfer	Form B / 4.5 x P	Form B / 4.5 x P	Form B / 4.5 x P
Limit & Nut Tolerance	ISO 228	ISO 228	ISO 228

suttontools

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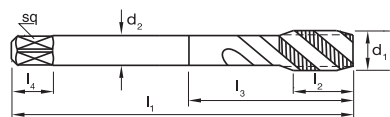
● Optimal ○ Effective



Catalogue Code	T278	T279
Discount Group	D0402	D0406
Material	HSSE V3	HSSE V3
Surface Finish	<i>Brt</i>	<i>TiN</i>
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

suttontools

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Size Ref.	d ₁	TPI	l ₁	l ₂	l ₃	d ₂	sq	l ₄	z	drill Ø	100 L20	100 L20	100 L20
0973	G 1/8	28	90	20	-	7.0	5.5	8	3	8.8	T281 0973	T282 0973	T283 0973
1316	G 1/4	19	100	22	-	11.0	9.0	12	3	11.8	T281 1316	T282 1316	T283 1316
1666	G 3/8	19	100	22	-	12.0	9.0	12	3	15.3	T281 1666	T282 1666	T283 1666
2096	G 1/2	14	125	25	-	16.0	12.0	15	4	19.0	T281 2096	T282 2096	T283 2096
2291	G 5/8	14	125	25	-	18.0	14.5	17	4	21.0	T281 2291	T282 2291	T283 2291
2644	G 3/4	14	140	28	-	20.0	16.0	19	4	24.5	T281 2644	T282 2644	T283 2644
3020	G 7/8	14	150	28	-	22.0	18.0	21	4	28.5	T281 3020	T282 3020	T283 3020
3325	G 1	11	160	30	-	25.0	20.0	23	4	31.0	T281 3325	T282 3325	T283 3325
3790	G 1-1/8	11	170	30	-	28.0	22.0	25	4	35.5	•	•	•
4191	G 1-1/4	11	170	30	-	32.0	24.0	27	6	39.5	•	•	•
4432	G 1-3/8	11	180	32	-	36.0	29.0	32	6	42.0	•	•	•
4780	G 1-1/2	11	190	32	-	36.0	29.0	32	6	45.5	•	•	•

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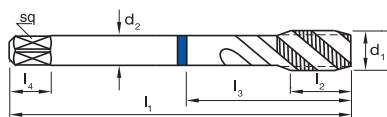
P Steel **M** Stainless Steel **K** Cast Iron **N** Non-Ferrous Metals **S** Titanium & Super Alloys **H** Hard Materials

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

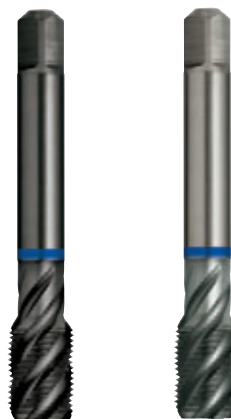
● Optimal ○ Effective

suttontools

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● Optimal ○ Effective



Catalogue Code	T284	T285
Discount Group	D0402	D0408
Material	HSSE V3	HSSE V3
Surface Finish	<i>Blu</i>	<i>TICN</i>
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

