Z-PRO

# Spiral Fluted Tap

# VUSP


Z-Pro PM VUSP offers improved tool life from using a high speed steel with a special coating. Improved chip evacuation and cutting resistance from a unique flute shape excellent internal threads. The Z-Pro OM VUSP utilizes a longer overall length to avoid the chips interfering with the holder. It is designed for use with water-soluble cutting fluid where there is a good coolant supply.

For unified threads

| Size | Class | EDP | Chamfer | L (inch) | ℓ (inch) | ℓn (inch) | ℓs (inch) | Ds (inch) | No. of flutes | Type |
|---|---|---|---|---|---|---|---|---|---|---|
| 5-40UNC | GH2 | 394703 | 2.5P | 2.205 | 0.197 | 0.736 | 1.339 | 0.141 | 2 | 1 |
| 5-44UNF | GH2 | 394792 | 2.5P | 2.205 | 0.197 | 0.736 | 1.339 | 0.141 | 2 | 1 |
| 6-32UNC | GH2 | 394604 | 2.5P | 2.205 | 0.276 | 0.748 | 1.339 | 0.141 | 2 | 1 |
| 6-40UNF | GH2 | 394784 | 2.5P | 2.205 | 0.276 | 0.748 | 1.339 | 0.141 | 2 | 1 |
| 8-32UNC | GH3 | 394707 | 2.5P | 2.48 | 0.276 | 0.827 | 1.535 | 0.168 | 2 | 1 |
| 8-36UNF | GH3 | 394787 | 2.5P | 2.48 | 0.276 | 0.827 | 1.535 | 0.168 | 2 | 1 |
| 10-24UNC | GH3 | 394709 | 2.5P | 2.756 | 0.354 | 0.945 | 1.654 | 0.194 | 2 | 1 |
| 10-32UNF | GH3 | 394710 | 2.5P | 2.756 | 0.354 | 0.945 | 1.654 | 0.194 | 2 | 1 |
| 12-24UNC | GH3 | 394788 | 2.5P | 3.15 | 0.354 | 0.984 | 1.953 | 0.22 | 2 | 1 |
| 12-28UNF | GH3 | 394789 | 2.5P | 3.15 | 0.354 | 0.984 | 1.953 | 0.22 | 2 | 1 |
| 1/4-20UNC | GH3 | 394713 | 2.5P | 3.15 | 0.433 | 1.181 | 1.713 | 0.255 | 2 | 1 |
| 1/4-20UNC | GH5 | 394744 | 2.5P | 3.15 | 0.433 | 1.181 | 1.713 | 0.255 | 2 | 1 |
| 1/4-28UNF | GH3 | 394714 | 2.5P | 3.15 | 0.433 | 1.181 | 1.713 | 0.255 | 2 | 1 |
| 1/4-28UNF | GH5 | 394764 | 2.5P | 3.15 | 0.433 | 1.181 | 1.713 | 0.255 | 2 | 1 |
| 5/16-18UNC | GH5 | 394745 | 2.5P | 3.543 | 0.472 | 1.378 | 1.831 | 0.318 | 3 | 2 |
| 3/8-16UNC | GH5 | 394747 | 2.5P | 3.937 | 0.512 | 1.535 | 2.028 | 0.381 | 3 | 2 |
| 7/16-14UNC | GH5 | 394749 | 2.5P | 3.937 | 0.512 | - | 2.008 | 0.323 | 3 | 3 |
| 1/2-13UNC | GH5 | 397451 | 2.5P | 4.331 | 0.591 | - | 2.205 | 0.367 | 3 | 3 |
| 9/16-12UNC | GH5 | 394780 | 2.5P | 4.331 | 0.709 | - | 2.205 | 0.429 | 3 | 3 |
| 5/8-11UNC | GH5 | 394755 | 2.5P | 4.331 | 0.709 | - | 2.205 | 0.48 | 3 | 3 |

For metric threads

| Size | Class | EDP | Chamfer | L (inch) | ℓ (inch) | ℓn (inch) | ℓs (inch) | Ds (inch) | No. of flutes | Type |
|---|---|---|---|---|---|---|---|---|---|---|
| M3 X 0.5 | D4 | 394615 | 2.5P | 2.205 | 0.196 | 0.736 | 1.339 | 0.141 | 3 | 1 |
| M3 X 0.35 | D4 | 394644 | 2.5P | 2.205 | 0.196 | 0.736 | 1.339 | 0.141 | 3 | 1 |
| M4 X 0.7 | D5 | 394617 | 2.5P | 2.48 | 0.275 | 0.815 | 1.535 | 0.168 | 3 | 1 |
| M4 X 0.5 | D4 | 394643 | 2.5P | 2.48 | 0.196 | 0.815 | 1.535 | 0.168 | 3 | 1 |
| M5 X 0.8 | D5 | 394619 | 2.5P | 2.756 | 0.354 | 0.984 | 1.654 | 0.194 | 3 | 1 |
| M5 X 0.5 | D4 | 394642 | 2.5P | 2.756 | 0.236 | 0.984 | 1.654 | 0.194 | 3 | 1 |
| M6 X 1 | D6 | 394620 | 2.5P | 3.15 | 0.433 | 1.181 | 1.713 | 0.255 | 3 | 1 |
| M6 X 0.75 | D6 | 394735 | 2.5P | 3.15 | 0.315 | 1.181 | 1.713 | 0.255 | 3 | 1 |
| M6 X 0.5 | D4 | 394641 | 2.5P | 3.15 | 0.315 | 1.181 | 1.713 | 0.255 | 3 | 1 |
| M8 X 1.25 | D7 | 394623 | 2.5P | 3.543 | 0.472 | 1.378 | 1.831 | 0.318 | 3 | 2 |
| M8 X 1 | D6 | 394622 | 2.5P | 3.543 | 0.472 | 1.378 | 1.831 | 0.318 | 3 | 2 |
| M10 X 1.5 | D8 | 394625 | 2.5P | 3.937 | 0.512 | 1.535 | 2.126 | 0.381 | 3 | 2 |
| M10 X 1.25 | D6 | 394624 | 2.5P | 3.937 | 0.512 | 1.535 | 2.126 | 0.381 | 3 | 2 |
| M10 X 1 | D6 | 394601 | 2.5P | 3.937 | 0.512 | 1.535 | 2.126 | 0.381 | 3 | 2 |
| M12 X 1.75 | D8 | 394627 | 2.5P | 4.331 | 0.591 | - | 2.205 | 0.367 | 3 | 3 |
| M12 X 1.5 | D7 | 394626 | 2.5P | 4.331 | 0.591 | - | 2.205 | 0.367 | 3 | 3 |
| M12 X 1.25 | D7 | 394636 | 2.5P | 4.331 | 0.591 | - | 2.205 | 0.367 | 3 | 3 |
| M14 X 2 | D9 | 394629 | 2.5P | 4.331 | 0.709 | - | 2.205 | 0.429 | 3 | 3 |
| M14 X 1.5 | D8 | 394628 | 2.5P | 4.331 | 0.551 | - | 2.205 | 0.429 | 3 | 3 |
| M16 X 2 | D9 | 394630 | 2.5P | 4.331 | 0.709 | - | 2.205 | 0.48 | 3 | 3 |
| M16 X 1.5 | D8 | 394631 | 2.5P | 4.331 | 0.551 | - | 2.205 | 0.48 | 3 | 3 |
| M18 X 2.5 | D9 | 394633 | 2.5P | 4.921 | 0.787 | - | 2.52 | 0.542 | 4 | 3 |
| M18 X 1.5 | D8 | 394632 | 2.5P | 4.921 | 0.551 | - | 2.52 | 0.542 | 3 | 3 |
| M20 X 2.5 | D9 | 394634 | 2.5P | 5.512 | 0.787 | - | 2.795 | 0.652 | 4 | 3 |
| M20 X 1.5 | D8 | 394635 | 2.5P | 5.512 | 0.551 | - | 2.795 | 0.652 | 3 | 3 |
| M22 X 2.5 | D9 | 394640 | 2.5P | 5.512 | 0.787 | - | 2.795 | 0.697 | 4 | 3 |
| M22 X 1.5 | D8 | 394637 | 2.5P | 5.512 | 0.551 | - | 2.795 | 0.697 | 3 | 3 |
| M24 X 3 | D10 | 394638 | 2.5P | 6.299 | 0.984 | - | 3.228 | 0.76 | 4 | 3 |
| M24 X 1.5 | D8 | 394639 | 2.5P | 6.299 | 0.984 | - | 3.228 | 0.76 | 3 | 3 |