



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.



Coated Spiral Fluted Taps 1.5P VUSP 1.5P

V
U
S
P

For metric threads

| Size | Class | EDP | Chamfer | L (inch) | ℓ (inch) | ℓ _n (inch) | ℓ _s (inch) | D _s (inch) | No. of flutes | Type |
|------------|-------|--------|---------|-------------|-------------|--------------------------|--------------------------|--------------------------|------------------|------|
| M3 X 0.5 | D4 | 394015 | 1.5P | 2.205 | 0.197 | 0.736 | 1.339 | 0.141 | 3 | 1 |
| M3 X 0.35 | D4 | 394016 | 1.5P | 2.205 | 0.197 | 0.736 | 1.339 | 0.141 | 3 | 1 |
| M4 X 0.7 | D5 | 394017 | 1.5P | 2.48 | 0.276 | 0.815 | 1.535 | 0.168 | 3 | 1 |
| M4 X 0.5 | D4 | 394018 | 1.5P | 2.48 | 0.197 | 0.815 | 1.535 | 0.168 | 3 | 1 |
| M5 X 0.8 | D5 | 394019 | 1.5P | 2.756 | 0.354 | 0.984 | 1.654 | 0.194 | 3 | 1 |
| M5 X 0.5 | D4 | 394021 | 1.5P | 2.756 | 0.236 | 0.984 | 1.654 | 0.194 | 3 | 1 |
| M6 X 1 | D6 | 394020 | 1.5P | 3.15 | 0.433 | 1.181 | 1.713 | 0.255 | 3 | 1 |
| M6 X 0.75 | D6 | 394035 | 1.5P | 3.15 | 0.315 | 1.181 | 1.713 | 0.255 | 3 | 1 |
| M6 X 0.5 | D4 | 394036 | 1.5P | 3.15 | 0.315 | 1.181 | 1.713 | 0.255 | 3 | 1 |
| M8 X 1.25 | D7 | 394023 | 1.5P | 3.543 | 0.472 | 1.378 | 1.831 | 0.318 | 3 | 2 |
| M8 X 1 | D6 | 394022 | 1.5P | 3.543 | 0.472 | 1.378 | 1.831 | 0.318 | 3 | 2 |
| M10 X 1.5 | D8 | 394025 | 1.5P | 3.937 | 0.512 | 1.535 | 2.126 | 0.381 | 3 | 2 |
| M10 X 1.25 | D6 | 394024 | 1.5P | 3.937 | 0.512 | 1.535 | 2.126 | 0.381 | 3 | 2 |
| M10 X 1 | D6 | 394037 | 1.5P | 3.937 | 0.512 | 1.535 | 2.126 | 0.381 | 3 | 2 |
| M12 X 1.75 | D8 | 394027 | 1.5P | 4.331 | 0.591 | - | 2.205 | 0.367 | 3 | 3 |
| M12 X 1.5 | D7 | 394038 | 1.5P | 4.331 | 0.591 | - | 2.205 | 0.367 | 3 | 3 |
| M12 X 1.25 | D7 | 394026 | 1.5P | 4.331 | 0.591 | - | 2.205 | 0.367 | 3 | 3 |
| M14 X 2 | D9 | 394029 | 1.5P | 4.331 | 0.709 | - | 2.205 | 0.429 | 3 | 3 |
| M14 X 1.5 | D8 | 394039 | 1.5P | 4.331 | 0.551 | - | 2.205 | 0.429 | 3 | 3 |
| M16 X 2 | D9 | 394031 | 1.5P | 4.331 | 0.709 | - | 2.205 | 0.48 | 3 | 3 |
| M16X1.5 | D8 | 394030 | 1.5P | 4.331 | 0.551 | - | 2.205 | 0.48 | 3 | 3 |

Coated Spiral Fluted Taps with Coolant Through Hole VUSP CH

Tapping Data

For unified threads

| Size | Class | EDP | Chamfer | L (inch) | ℓ (inch) | ℓ _n (inch) | ℓ _s (inch) | D _s (inch) | No. of flutes | Type |
|------------|-------|--------|---------|-------------|-------------|--------------------------|--------------------------|--------------------------|------------------|------|
| 5/16-18UNC | GH5 | 394845 | 2.5P | 3.543 | 0.472 | 1.378 | 1.831 | 0.318 | 3 | 1 |
| 3/8-16UNC | GH5 | 394847 | 2.5P | 3.937 | 0.512 | 1.535 | 2.028 | 0.381 | 3 | 1 |
| 1/2-13UNC | GH5 | 394851 | 2.5P | 4.331 | 0.591 | - | 2.205 | 0.367 | 3 | 2 |