

High-Performance HSS-E Taps • **WIDIA-GTD™**

Our family of Exotic Material (EM) taps are specially designed to thread a broad assortment of materials for unrivaled high-performance tapping.

EM-SS available until stock is depleted.

See EM-SS cross reference list to VariTap™ on pages A52–A62.



EM Series

- Enhanced tool geometry.
- Less tapping torque.
- Better chip removal.



Unmatched Performance

The WIDIA-GTD™ EM Series taps are designed and manufactured to successfully thread high- and low-volume applications in aluminum, stainless steel, nickel alloys, titanium alloys, mold steels, irons, brass, bronze, and plastics. The formulation of premium steel tap base material is unique for every application. The combination of a special geometry, tap surface treatment, and premium steep gives these taps the highest level of performance.

Premium Steels

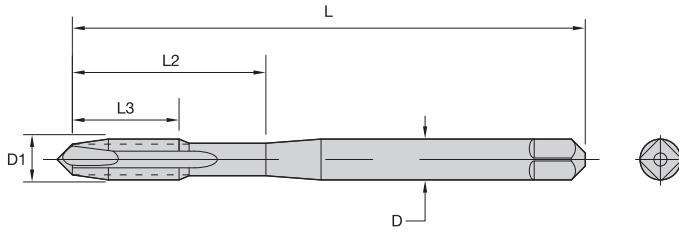
EM Series taps use special HSS-E compositions containing high-vanadium and/or cobalt content depending on the application. The right combination improves tap-life as measured by product finish and/or pitch diameter size.

Broad Offering of Diameter Limits

Pitch diameters from H2–H7 and metric pitch diameters from D3–D7 are stocked as standards in many styles, at no premium in price. With rigid setups, higher pitch diameter limits can be used for longer tool life. The EM Series offers many size options to produce the class of thread desired.



Available until stock is depleted.
See VariTap™ cross reference chart
on pages A52–A62.



- first choice
- alternate choice

High-Performance Taps

■ Series 8351 • Plug Chamfer • Metric ANSI

				inch dimensions					number of flutes	pitch diameter limit
				D1 size	L	L3	L2	D		
TiCN	TiN	oxide	uncoated							
72815	72915	72615	72615B	M3 X 0,5	1.94	.31	.63	.141	3	D3
—	—	72616	72616B	M3,5 X 0,6	2.00	.38	.69	.141	3	D4
72817	72917	72617	72617B	M4 X 0,7	2.13	.38	.75	.168	3	D4
72819	72919	72619	72619B	M5 X 0,8	2.38	.50	.88	.194	3	D4
72820	72920	72620	72620B	M6 X 1	2.50	.63	1.00	.255	3	D5
—	—	72621	72621B	M7 X 1	2.72	.69	1.13	.318	3	D5
—	—	72622	72622B	M8 X 1	2.72	.69	1.13	.318	3	D5
72823	72923	72623	72623B	M8 X 1,25	2.72	.69	1.13	.318	3	D5
—	—	72624	72624B	M10 X 1,25	2.94	.75	1.25	.381	3	D5
72825	72925	72625	72625B	M10 X 1,5	2.94	.75	1.25	.381	3	D6
—	—	72626	72626B	M12 X 1,25	3.38	.94	—	.367	3	D5
72827	72927	72627	72627B	M12 X 1,75	3.38	.94	—	.367	3	D6
—	—	72628	72628B	M14 X 1,5	3.59	1.00	—	.429	3	D6
—	—	72629	72629B	M14 X 2	3.59	1.00	—	.429	3	D7
—	72930	72630	72630B	M16 X 1,5	3.81	1.09	—	.480	3	D6
72831	72931	72631	72631B	M16 X 2	3.81	1.09	—	.480	3	D7
—	—	72632	72632B	M18 X 1,5	4.03	1.09	—	.542	3	D6
—	—	72633	—	M18 X 2,5	4.03	1.09	—	.542	3	D7
—	—	—	72633B	M18 X 2,5	4.03	1.09	—	.542	4	D7

NOTE: Metric taps for 6H class of fit are suitable for MJ aerospace internal threading applications.
Metric taps are manufactured to USCTI specifications and dimensions.
Metric tap blank dimensions are equivalent to inch taps.
See page A275 for the recommended pitch diameter limit for 6H class of fit.