

KOREAN INDUSTRIAL STANDARD

Nut Taps for Metric Coarse Thread

1. Scope

This Korea Industrial Standard specifies nut taps, hereinafter referred to as "taps" of designation M 2.5 to M 30 used for tapping of KS B 0201.

2. Classification

Nut taps shall be divided into two classes; long tap and short tap, according to the overall length(L).

3. Grade

Nut taps shall be divided into Grade 2 and Grade 3 according to the threaded part (Table 2 to 4) and tolerance of the run-out (Table 5).

Grade 2 shall be sub-divided into Grade 2a and Grade 2b according to the difference of the tolerance position.

The grade symbols shall be as follows:

Grade	Grade 2		Grade 3
	Grade 2a	Grade 2b	
Symbol	IIa	IIb	III

4. Material

Material shall be STS 2 of KS D 3753 or SKH 9 of KS D 3522 or superior to these in use. In case where materials for the threaded part and the shank are not the same, the material of the shank shall, in principle, be STC 7 of KS D 3751.

Related Standards:

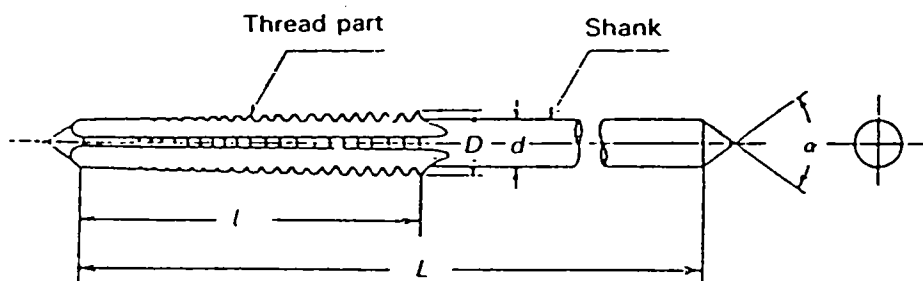
KS B 0201	Metric Coarse Screw Thread
KS B 3245	Square Portion of Shanks for Small Tools
KS D 3522	High Speed Tool Steels
KS D 3751	Carbon Tool Steels
KS D 3753	Alloy Tool Steels

5. Shapes and Dimension

The shapes and dimensions shall conform to Table 1.

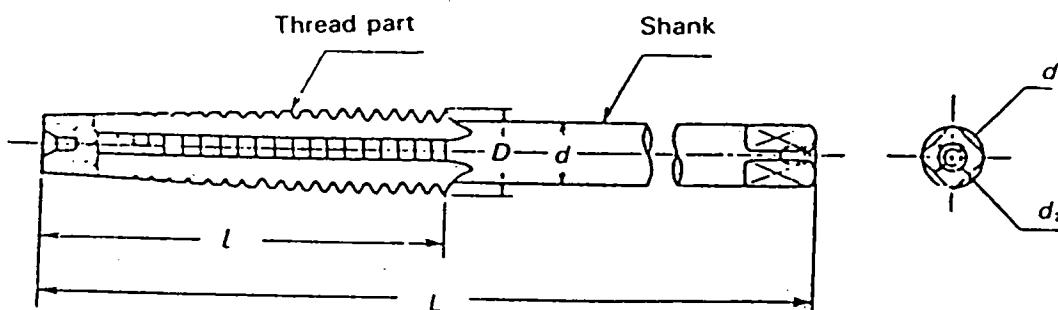
Table 1. Shapes and dimensions of nut taps for metric coarse thread

Designation M 4 and smaller



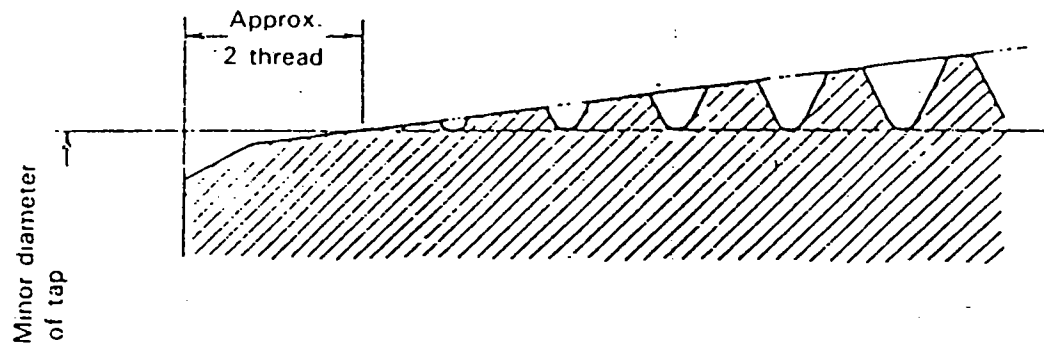
Center point of shank end α is 60° as a rule.

Designation M 4.5 and larger



Nut taps M 4 and smaller shall be with center points, over M 4 to M 10 incl. shall be with center point or center holes, and over M 10 shall be with center holes.

Detail of chamfer



Unit: mm

Designation	Basic major diameter D	Pitch	L				l		d		Reference		
			Long tap		Short tap		Basic dimension	Tolerance	Basic dimension	Tolerance	Number of flutes	d ₁	d ₂
			Basic dimension	Tolerance	Basic dimension	Tolerance							
M2.5	2.500	0.45	85	±1.2	50	±0.7	15	±1.0	2	0 -0.1	3	-	-
M2.6	2.600	0.45	85	±1.2	50	±0.7	15	±1.0	2	0 -0.1	3	-	-
M3	3.000	0.5	90	±1.2	55	±0.7	20	±1.4	2.1	0 -0.1	3	-	-
M3.5	3.500	0.6	95	±1.2	55	±0.7	20	±1.4	2.6	0 -0.1	3	-	-
M4	4.000	0.7	100	±1.2	60	±0.7	25	±1.4	2.8	0 -0.1	3	-	-
M4.5	4.500	0.75	105	±1.2	60	±0.7	25	±1.4	3.3	0 -0.1	3	-	-
M5	5.000	0.8	110	±1.2	70	±1.2	30	±1.4	3.6	0 -0.1	3	-	-
M6	6.000	1.0	120	±1.2	75	±1.2	35	±1.4	4.5	0 -0.13	3 or 4	-	-
M7	7.000	1.0	130	±1.2	75	±1.2	35	±1.4	5.5	0 -0.13	3 or 4	1	2.2
M8	8.000	1.25	140	±1.2	85	±1.2	40	±1.4	6.2	0 -0.13	3 or 4	1	2.2
M9	9.000	1.25	150	±1.2	90	±1.2	45	±1.4	7.2	0 -0.13	3 or 4	1.5	2.5
M10	10.000	1.5	160	±1.2	100	±1.2	50	±1.4	7.8	0 -0.13	3 or 4	1.5	2.5
M11	11.000	1.5	165	±1.2	110	±1.2	55	±1.4	8.8	0 -0.13	3 or 4	1.5	2.5
M12	12.000	1.75	170	±1.2	115	±1.2	60	±1.4	9	0 -0.13	3 or 4	1.5	2.8
M14	14.000	2.0	190	±1.2	125	±1.2	65	±2.4	11	0 -0.16	3 or 4	1.5	3
M16	16.000	2.0	200	±1.2	135	±1.2	70	±2.4	13	0 -0.16	3 or 4	1.5	3.2
M18	18.000	2.5	220	±1.2	145	±1.2	80	±2.4	14	0 -0.16	3 or 4	1.5	3.2
M20	20.000	2.5	230	±1.2	155	±1.2	85	±2.4	16	0 -0.16	3 or 4	2	3.5
M22	22.000	2.5	250	±1.2	165	±1.2	90	±2.4	18	0 -0.16	3 or 4	2	3.5
M24	24.000	3.0	260	±2.0	175	±1.2	100	±2.4	19	0 -0.16	3 or 4	2	4
M27	27.000	3.0	280	±2.0	190	±1.2	110	±2.4	22	0 -0.2	3 or 4	2	4
M30	30.000	3.5	300	±2.0	210	±1.2	120	±2.4	24	0 -0.2	3 or 4	2	4.5