

SERIES BXB

Bottom Chamfer Thredfloers



Chamfer length: 1-3/4 to 2 threads.

See page 58 for blank dimensions.

| Thredfloer Size | H2 | H3 | H4 | H5 | H6 | H7 | H8 | H9 | H10 | H11 | H12 | H13 | H14 |
|-----------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| 0-80 | 10002 | 10003 | 10004 | 10005 | 10006 | 10007 | | | | | | | |
| 1-64 | 10122 | 10123 | 10124 | 10125 | 10126 | 10127 | | | | | | | |
| 1-72 | 10242 | 10243 | 10244 | 10245 | 10246 | 10247 | | | | | | | |
| 2-56 | 10282 | 10283 | 10284 | 10285 | 10286 | 10287 | | | | | | | |
| 2-64 | 10422 | 10423 | 10424 | 10425 | 10426 | 10427 | | | | | | | |
| 3-48 | 10522 | 10523 | 10524 | 10525 | 10526 | 10527 | | | | | | | |
| 3-56 | 10622 | 10623 | 10624 | 10625 | 10626 | 10627 | | | | | | | |
| 4-40 | 10722 | 10723 | 10724 | 10725 | 10726 | 10727 | | | | | | | |
| 4-48 | 10942 | 10943 | 10944 | 10945 | 10946 | 10947 | | | | | | | |
| 5-40 | 11042 | 11043 | 11044 | 11045 | 11046 | 11047 | | | | | | | |
| 5-44 | 11162 | 11163 | 11164 | 11165 | 11166 | 11167 | | | | | | | |
| 6-32 | 11282 | 11283 | 11284 | 11285 | 11286 | 11287 | 11288 | 11289 | 11290 | | | | |
| 6-40 | 11502 | 11503 | 11504 | 11505 | 11506 | 11507 | 11508 | 11509 | 11510 | | | | |
| 8-32 | 11622 | 11623 | 11624 | 11625 | 11626 | 11627 | 11628 | 11629 | 11630 | | | | |
| 8-36 | 11842 | 11843 | 11844 | 11845 | 11846 | 11847 | 11848 | 11849 | 11850 | | | | |
| 10-24 | 11962 | 11963 | 11964 | 11965 | 11966 | 11967 | 11968 | 11969 | 11970 | | | | |
| 10-32 | 12182 | 12183 | 12184 | 12185 | 12186 | 12187 | 12188 | 12189 | 12190 | | | | |
| 12-24 | 12402 | 12403 | 12404 | 12405 | 12406 | 12407 | 12408 | 12409 | 12410 | | | | |
| 12-28 | 12522 | 12523 | 12524 | 12525 | 12526 | 12527 | 12528 | 12529 | 12530 | | | | |
| 1/4-20 | 12642 | 12643 | 12644 | 12645 | 12646 | 12647 | 12648 | 12649 | 12650 | | | | |
| 1/4-28 | 12862 | 12863 | 12864 | 12865 | 12866 | 12867 | 12868 | 12869 | 12870 | | | | |
| 5/16-18 | 13082 | 13083 | 13084 | 13085 | 13086 | 13087 | 13088 | 13089 | 13090 | | | | |
| 5/16-24 | 13262 | 13263 | 13264 | 13265 | 13266 | 13267 | 13268 | 13269 | 13270 | | | | |
| 3/8-16 | | | 13444 | 13445 | 13446 | 13447 | 13448 | 13449 | 13450 | 13451 | 13452 | | |
| 3/8-24 | | | 13624 | 13625 | 13626 | 13627 | 13628 | 13629 | 13630 | 13631 | 13632 | | |
| 7/16-14 | | | 13804 | 13805 | 13806 | 13807 | 13808 | 13809 | 13810 | 13811 | 13812 | | |
| 7/16-20 | | | 13924 | 13925 | 13926 | 13927 | 13928 | 13929 | 13930 | 13931 | 13932 | | |
| 1/2-13 | | | 14044 | 14045 | 14046 | 14047 | 14048 | 14049 | 14050 | 14051 | 14052 | | |
| 1/2-20 | | | 14164 | 14165 | 14166 | 14167 | 14168 | 14169 | 14170 | 14171 | 14172 | | |
| 9/16-12 | | | 14284 | 14285 | 14286 | 14287 | 14288 | 14289 | 14290 | 14291 | 14292 | | |
| 9/16-18 | | | 14404 | 14405 | 14406 | 14407 | 14408 | 14409 | 14410 | 14411 | 14412 | | |
| 5/8-11 | | | 14524 | 14525 | 14526 | 14527 | 14528 | 14529 | 14530 | 14531 | 14532 | | |
| 5/8-18 | | | 14644 | 14645 | 14646 | 14647 | 14648 | 14649 | 14650 | 14651 | 14652 | | |
| 3/4-10 | | | | | 14766 | 14767 | 14768 | 14769 | 14770 | 14771 | 14772 | 14773 | 14774 |
| 3/4-16 | | | | | 14886 | 14887 | 14888 | 14889 | 14890 | 14891 | 14892 | 14893 | 14894 |
| 7/8-9 | | | | | 15006 | 15007 | 15008 | 15009 | 15010 | 15011 | 15012 | 15013 | 15014 |
| 7/8-14 | | | | | 15126 | 15127 | 15128 | 15129 | 15130 | 15131 | 15132 | 15133 | 15134 |
| 1-8 | | | | | 15246 | 15247 | 15248 | 15249 | 15250 | 15251 | 15252 | 15253 | 15254 |
| 1-12 | | | | | 15366 | 15367 | 15368 | 15369 | 15370 | 15371 | 15372 | 15373 | 15374 |

SERIES BXP

Plug Chamfer Thredfloers



Chamfer length: 3-1/4 to 3-3/4 threads.

See page 58 for blank dimensions.

| Thredfloer Size | H2 | H3 | H4 | H5 | H6 | H7 | H8 | H9 | H10 | H11 | H12 | H13 | H14 |
|-----------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| 4-40 | 10742 | 10743 | 10744 | 10745 | 10746 | 10747 | | | | | | | |
| 5-40 | 11062 | 11063 | 11064 | 11065 | 11066 | 11067 | | | | | | | |
| 6-32 | 11302 | 11303 | 11304 | 11305 | 11306 | 11307 | 11308 | 11309 | 11310 | | | | |
| 6-40 | 11522 | 11523 | 11524 | 11525 | 11526 | 11527 | 11528 | 11529 | 11530 | | | | |
| 8-32 | 11642 | 11643 | 11644 | 11645 | 11646 | 11647 | 11648 | 11649 | 11650 | | | | |
| 8-36 | 11862 | 11863 | 11864 | 11865 | 11866 | 11867 | 11868 | 11869 | 11870 | | | | |
| 10-24 | 11982 | 11983 | 11984 | 11985 | 11986 | 11987 | 11988 | 11989 | 11990 | | | | |
| 10-32 | 12202 | 12203 | 12204 | 12205 | 12206 | 12207 | 12208 | 12209 | 12210 | | | | |
| 12-24 | 12422 | 12423 | 12424 | 12425 | 12426 | 12427 | 12428 | 12429 | 12430 | | | | |
| 12-28 | 12542 | 12543 | 12544 | 12545 | 12546 | 12547 | 12548 | 12549 | 12550 | | | | |
| 1/4-20 | 12662 | 12663 | 12664 | 12665 | 12666 | 12667 | 12668 | 12669 | 12670 | | | | |
| 1/4-28 | 12882 | 12883 | 12884 | 12885 | 12886 | 12887 | 12888 | 12889 | 12890 | | | | |
| 5/16-18 | 13102 | 13103 | 13104 | 13105 | 13106 | 13107 | 13108 | 13109 | 13110 | | | | |
| 5/16-24 | 13282 | 13283 | 13284 | 13285 | 13286 | 13287 | 13288 | 13289 | 13290 | | | | |
| 3/8-16 | | | 13464 | 13465 | 13466 | 13467 | 13468 | 13469 | 13470 | 13471 | 13472 | | |
| 3/8-24 | | | 13644 | 13645 | 13646 | 13647 | 13648 | 13649 | 13650 | 13651 | 13652 | | |
| 7/16-14 | | | 13824 | 13825 | 13826 | 13827 | 13828 | 13829 | 13830 | 13831 | 13832 | | |
| 7/16-20 | | | 13944 | 13945 | 13946 | 13947 | 13948 | 13949 | 13950 | 13951 | 13952 | | |
| 1/2-13 | | | 14064 | 14065 | 14066 | 14067 | 14068 | 14069 | 14070 | 14071 | 14072 | | |
| 1/2-20 | | | 14184 | 14185 | 14186 | 14187 | 14188 | 14189 | 14190 | 14191 | 14192 | | |
| 9/16-12 | | | 14304 | 14305 | 14306 | 14307 | 14308 | 14309 | 14310 | 14311 | 14312 | | |
| 9/16-18 | | | 14424 | 14425 | 14426 | 14427 | 14428 | 14429 | 14430 | 14431 | 14432 | | |
| 5/8-11 | | | 14544 | 14545 | 14546 | 14547 | 14548 | 14549 | 14550 | 14551 | 14552 | | |
| 5/8-18 | | | 14664 | 14665 | 14666 | 14667 | 14668 | 14669 | 14670 | 14671 | 14672 | | |
| 3/4-10 | | | | | 14786 | 14787 | 14788 | 14789 | 14790 | 14791 | 14792 | 14793 | 14794 |
| 3/4-16 | | | | | 14906 | 14907 | 14908 | 14909 | 14910 | 14911 | 14912 | 14913 | 14914 |
| 7/8-9 | | | | | 15026 | 15027 | 15028 | 15029 | 15030 | 15031 | 15032 | 15033 | 15034 |
| 7/8-14 | | | | | 15146 | 15147 | 15148 | 15149 | 15150 | 15151 | 15152 | 15153 | 15154 |
| 1-8 | | | | | 15266 | 15267 | 15268 | 15269 | 15270 | 15271 | 15272 | 15273 | 15274 |
| 1-12 | | | | | 15386 | 15387 | 15388 | 15389 | 15390 | 15391 | 15392 | 15393 | 15394 |

SERIES BXMB

Metric Bottom Chamfer Thredfloers



Chamfer length: 1-3/4 to 2 threads.

See page 58 for blank dimensions.

| Thredfloer Size | D3 | D4 | D5 | D6 | D7 | D8 | D9 | D10 | D11 | D12 | D13 | D14 |
|-----------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-----|-------|
| M1.6 x 0.35 | 17003 | | 17005 | | 17007 | | | | | | | |
| M1.7 x 0.35 | 17143 | | 17145 | | 17147 | | | | | | | |
| M2.0 x 0.4 | 17283 | | 17285 | | 17287 | | | | | | | |
| M2.5 x 0.45 | 17423 | | | 17426 | | 17428 | | | | | | |
| M2.6 x 0.45 | 17513 | | | 17516 | | | | | | | | |
| M3.0 x 0.5 | 17563 | | | 17566 | | 17568 | | | | | | |
| M3.5 x 0.6 | | 17744 | | | 17747 | | 17749 | | | | | |
| M4.0 x 0.7 | | 17944 | | | 17947 | | 17949 | | | | | |
| M5.0 x 0.8 | | 18144 | | | | 18148 | | 18150 | | | | |
| M6.0 x 1.0 | | | 18345 | | | | 18349 | | 18351 | | | |
| M8.0 x 1.25 | | | 18545 | | | | | 18550 | | 18562 | | |
| M10 x 1.5 | | | | 18746 | | | | | 18751 | | | |
| M12 x 1.75 | | | | 18946 | | | | | | 18952 | | |
| M14 x 1.5 | | | | 19106 | | | | | 19111 | | | |
| M14 x 2.0 | | | | | 19147 | | | | | | | 19154 |
| M16 x 1.5 | | | | 19226 | | | | | 19231 | | | |
| M16 x 2.0 | | | | | 19267 | | | | | | | 19274 |
| M18 x 1.5 | | | | 19306 | | | | | 19331 | | | |

SERIES BXMP

Metric Plug Chamfer Thredfloers



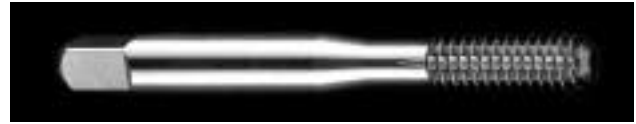
Chamfer length: 3-1/4 to 3-3/4 threads.

See page 58 for blank dimensions.

| Thredfloer Size | D4 | D5 | D6 | D7 | D8 | D9 | D10 | D11 | D12 | D13 | D14 |
|-----------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-----|-------|
| M3.5 x 0.6 | 17764 | | | 17767 | | | | | | | |
| M4.0 x 0.7 | 17964 | | | 17967 | | | | | | | |
| M5.0 x 0.8 | 18164 | | | | 18168 | | | | | | |
| M6.0 x 1.0 | | 18365 | | | | 18369 | | | | | |
| M8.0 x 1.25 | | 18565 | | | | | 18570 | | | | |
| M10 x 1.5 | | | 18766 | | | | | 18771 | | | |
| M12 x 1.75 | | | 18966 | | | | | | 18972 | | |
| M14 x 1.25 | | 19095 | | | | | 19100 | | | | |
| M14 x 1.5 | | | 19126 | | | | | 19131 | | | |
| M14 x 2.0 | | | | 19167 | | | | | | | 19174 |
| M16 x 1.5 | | | 19246 | | | | | 19251 | | | |
| M16 x 2.0 | | | | 19287 | | | | | | | 19294 |
| M18 x 1.5 | | | 19326 | | | | | 19311 | | | |

SERIES BXOTL

CNC One Thread Lead Thredfloers



Chamfer length: 1 to 1-1/2 threads.

See page 59 for blank dimensions.

| Thredfloer Size | H2 | H3 | H4 | H5 | H6 | H7 | H8 | H9 |
|-----------------|-----------|-----------|-----------|-----------|-----------|-----------|-----------|-----------|
| 0-80 | 10032-010 | 10033-010 | | | | | | |
| 1-72 | 10272-010 | 10273-010 | | | | | | |
| 2-56 | 10332-010 | 10333-010 | 10334-010 | | | | | |
| 4-40 | | 10763-010 | 10764-010 | 10765-010 | | | | |
| 6-32 | | 11323-010 | 11324-010 | 11325-010 | | | | |
| 8-32 | | 11663-010 | 11664-010 | 11665-010 | | | | |
| 10-24 | | 12003-010 | 12004-010 | 12005-010 | | | | |
| 10-32 | | 12223-010 | 12224-010 | 12225-010 | | | | |
| 1/4-20 | | | | 12685-010 | 12686-010 | 12687-010 | 12688-010 | |
| 1/4-28 | | | 12904-010 | 12905-010 | 12906-010 | 12907-010 | | |
| 5/16-18 | | | | | 13126-010 | 13127-010 | 13128-010 | 13129-010 |
| 5/16-24 | | | | 13305-010 | 13306-010 | 13307-010 | 13308-010 | |
| 3/8-16 | | | | | 13486-010 | 13487-010 | 13488-010 | 13489-010 |
| 3/8-24 | | | | 13665-010 | 13666-010 | 13667-010 | 13668-010 | |

Note: BXOTL Taps are furnished with front point removed.

SERIES BXMOTL

Metric CNC One Thread Lead Thredfloers



Chamfer length: 1 to 1-1/2 threads.

See page 59 for blank dimensions.

| Thredfloer Size | D3 | D4 | D5 | D6 | D7 | D8 | D9 | D10 | D11 | D12 |
|-----------------|-----------|-----------|-----------|-----------|-----------|-----------|-----------|-----------|-----------|-----------|
| M2.0 x 0.4 | 17353-010 | | 17355-010 | | | | | | | |
| M2.5 x 0.45 | 17493-010 | | | 17496-010 | | | | | | |
| M3.0 x 0.5 | 17583-010 | | | 17586-010 | | | | | | |
| M3.5 x 0.6 | | 17784-010 | | | 17787-010 | | | | | |
| M4.0 x 0.7 | | 17984-010 | | | 17987-010 | | | | | |
| M5.0 x 0.8 | | 18184-010 | | | | 18188-010 | | | | |
| M6.0 x 1.0 | | | 18385-010 | | | | 18389-010 | | | |
| M8.0 x 1.25 | | | 18585-010 | | | | | 18590-010 | | |
| M10 x 1.5 | | | | 18786-010 | | | | | 18791-010 | |
| M12 x 1.75 | | | | 18986-010 | | | | | | 18992-010 |

Note: BXMOTL Taps are furnished with front point removed.

SERIES BXSG "Special Grind" Bottom Thredfloers



- Made from premium powdered metal tool steel for toughness and wear resistance
- Unique forming lobe geometry for longer life and difficult materials to tap

Chamfer length: 1-3/4 to 2 threads.

See page 59 for blank dimensions.

| Thredfloer Size | H3 | H4 | H5 | H6 | H7 | H8 | H9 |
|-----------------|-------|-------|-------|-------|-------|-------|-------|
| 4-40 | 10853 | 10854 | 10855 | | | | |
| 6-32 | 11413 | 11414 | 11415 | 11416 | | | |
| 8-32 | 11753 | 11754 | 11755 | 11756 | | | |
| 10-24 | 12093 | 12094 | 12095 | 12096 | | | |
| 10-32 | 12313 | 12314 | 12315 | 12316 | | | |
| 1/4-20 | | | 12775 | 12776 | 12777 | 12778 | |
| 1/4-28 | | 12994 | 12995 | 12996 | 12997 | | |
| 5/16-18 | | | | 13176 | 13177 | 13178 | 13179 |
| 5/16-24 | | | 13355 | 13356 | 13357 | 13358 | |
| 3/8-16 | | | | 13536 | 13537 | 13538 | 13539 |
| 3/8-24 | | | 13715 | 13716 | 13717 | 13718 | |

SERIES BXMSG "Special Grind" Metric Bottom Thredfloers



- Made from premium powdered metal tool steel for toughness and wear resistance
- Unique forming lobe geometry for longer life and difficult materials to tap

Chamfer length: 1-3/4 to 2 threads.

See page 59 for blank dimensions.

| Thredfloer Size | D3 | D4 | D5 | D6 | D7 | D8 | D9 | D10 | D11 | D12 |
|-----------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| M3 x 0.5 | 17673 | | | 17676 | | | | | | |
| M3.5 x 0.6 | | 17874 | | | 17877 | | | | | |
| M4.0 x 0.7 | | 18074 | | | 18077 | | | | | |
| M5.0 x 0.8 | | 18274 | | | | 18278 | | | | |
| M6.0 x 1.0 | | | 18475 | | | | 18479 | | | |
| M8.0 x 1.25 | | | 18675 | | | | | 18680 | | |
| M10 x 1.5 | | | | 18856 | | | | | 18861 | |
| M12 x 1.75 | | | | 19056 | | | | | | 19062 |

SERIES BXSGP "Special Grind" Plug Thredfloers



- Made from premium powdered metal tool steel for toughness and wear resistance
- Unique forming lobe geometry for longer life and difficult materials to tap

Chamfer length: 3-1/4 to 3-3/4 threads.

See page 59 for blank dimensions.

| Thredfloer Size | H7 | H8 | H9 |
|-----------------|-------|-------|-------|
| 1/4-20 | | 12808 | |
| 1/4-28 | 13027 | | |
| 5/16-18 | | | 13209 |
| 5/16-24 | | 13378 | |
| 3/8-16 | | | 13569 |
| 3/8-24 | | 13738 | |

SERIES BXMSGP "Special Grind" Metric Plug Thredfloers



- Made from premium powdered metal tool steel for toughness and wear resistance
- Unique forming lobe geometry for longer life and difficult materials to tap

Chamfer length: 3-1/4 to 3-3/4 threads.

See page 59 for blank dimensions.

| Thredfloer Size | D9 | D10 | D11 | D12 |
|-----------------|-------|-------|-------|-------|
| M6.0 x 1.0 | 18519 | | | |
| M8.0 x 1.25 | | 18710 | | |
| M10 x 1.5 | | | 18891 | |
| M12 x 1.75 | | | | 19092 |

SERIES BXDIN371 DIN 371 Thredfloers, Bottom Chamfer



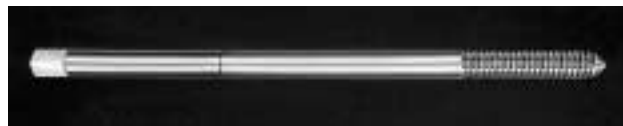
Chamfer length: 1-3/4 to 2 threads.

See page 60 for blank dimensions.

| Thredfloer Size | D3 | D4 | D5 | D6 | D7 | D8 | D9 | D10 | D11 | D12 |
|-----------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| M1.6 x 0.35 | 17023 | | 17025 | | | | | | | |
| M1.7 x 0.35 | 17163 | | 17165 | | | | | | | |
| M2.0 x 0.4 | 17303 | | 17305 | | | | | | | |
| M2.5 x 0.45 | 17443 | | | 17446 | | | | | | |
| M3.0 x 0.5 | 17623 | | | 17626 | | | | | | |
| M3.5 x 0.6 | | 17824 | | | 17827 | | | | | |
| M4.0 x 0.7 | | 18024 | | | 18027 | | | | | |
| M5.0 x 0.8 | | 18224 | | | | 18228 | | | | |
| M6.0 x 1.0 | | | 18425 | | | | 18429 | | | |
| M8.0 x 1.25 | | | 18625 | | | | | 18630 | | |
| M10 x 1.5 | | | | 18826 | | | | | 18831 | |
| M12 x 1.75 | | | | 19026 | | | | | | 19032 |

SERIES BXEXT

Bottom Extension Thredfloers



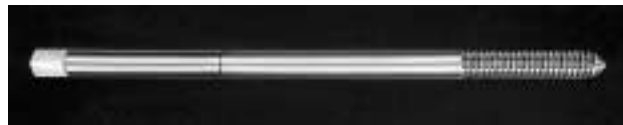
Chamfer length: 1-3/4 to 2 threads.

See page 58 for shank and square dimensions.

| Tap Size | OAL (In.) | H3 | H4 | H5 | H6 | H7 | H8 | H9 |
|----------|-----------|-------|-------|-------|-------|-------|-------|-------|
| 4-40 | 3 | 10783 | 10784 | 10785 | | | | |
| | 4 | 10803 | 10804 | 10805 | | | | |
| 6-32 | 3 | 11343 | 11344 | 11345 | 11346 | | | |
| | 4 | 11363 | 11364 | 11365 | 11366 | | | |
| 8-32 | 3 | 11683 | 11684 | 11685 | 11686 | | | |
| | 4 | 11703 | 11704 | 11705 | 11706 | | | |
| 10-24 | 4 | 12023 | 12024 | 12025 | 12026 | 12027 | | |
| | 6 | 12043 | 12044 | 12045 | 12046 | 12047 | | |
| 10-32 | 4 | 12243 | 12244 | 12245 | 12246 | | | |
| | 6 | 12263 | 12264 | 12265 | 12266 | | | |
| 1/4-20 | 4 | | | 12705 | 12706 | 12707 | 12708 | |
| | 6 | | | 12725 | 12726 | 12727 | 12728 | |
| 1/4-28 | 4 | | 12924 | 12925 | 12926 | 12927 | | |
| | 6 | | 12944 | 12945 | 12946 | 12947 | | |
| 5/16-18 | 4 | | | 13145 | 13146 | 13147 | 13148 | 13149 |
| | 6 | | | 13165 | 13166 | 13167 | 13168 | 13169 |
| 5/16-24 | 4 | | 13324 | 13325 | 13326 | 13327 | 13328 | |
| | 6 | | 13344 | 13345 | 13346 | 13347 | 13348 | |
| 3/8-16 | 4 | | | 13505 | 13506 | 13507 | 13508 | 13509 |
| | 6 | | | 13525 | 13526 | 13527 | 13528 | 13529 |
| 3/8-24 | 4 | | 13684 | 13685 | 13686 | 13687 | 13688 | |
| | 6 | | 13704 | 13705 | 13706 | 13707 | 13708 | |

SERIES BXMEXT

Bottom Metric Extension Thredfloers



Chamfer length: 1-3/4 to 2 threads.

See page 58 for shank and square dimensions.

| Tap Size | OAL (In.) | D3 | D4 | D5 | D6 | D7 | D8 | D9 | D10 | D11 | D12 |
|-------------|-----------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| M3.0 x 0.5 | 3 | 17593 | | | 17596 | | | | | | |
| | 4 | 17603 | | | 17606 | | | | | | |
| M3.5 x 0.6 | 3 | | 17794 | | | 17797 | | | | | |
| | 4 | | 17804 | | | 17807 | | | | | |
| M4.0 x 0.7 | 3 | | 17994 | | | 17997 | | | | | |
| | 4 | | 18004 | | | 18007 | | | | | |
| M5.0 x 0.8 | 4 | | 18204 | | | | 18208 | | | | |
| | 6 | | 18214 | | | | 18218 | | | | |
| M6.0 x 1.0 | 4 | | | 18405 | | | | 18409 | | | |
| | 6 | | | 18415 | | | | 18419 | | | |
| M8.0 x 1.25 | 4 | | | 18595 | | | | | 18600 | | |
| | 6 | | | 18605 | | | | | 18610 | | |
| M10 x 1.5 | 4 | | | | 18796 | | | | | 18801 | |
| | 6 | | | | 18806 | | | | | 18811 | |
| M12 x 1.75 | 4 | | | | 18996 | | | | | | 19002 |
| | 6 | | | | 19006 | | | | | | 19012 |

SERIES BXSTI**Bottom "STI" Screw Thread Insert Thredfloers**

Chamfer length: 1-3/4 to 2 threads.

See page 58 for blank dimensions.

| Thredfloer Size | Tap Blank Size | H2 | H3 | H4 | H5 |
|-----------------|----------------|-------|-------|-------|-------|
| 2-56 | #6 | 10322 | 10323 | | |
| 4-40 | #8 | 10842 | 10843 | | |
| 6-32 | #10 | 11402 | 11403 | | |
| 8-32 | #12 | 11742 | 11743 | 11744 | |
| 10-24 | 1/4 | 12082 | 12083 | 12084 | |
| 10-32 | 1/4 | 12302 | 12303 | 12304 | |
| 1/4-20 | 5/16 | 12762 | 12763 | 12764 | |
| 1/4-28 | 5/16 | 12982 | 12983 | 12984 | |
| 5/16-18 | 3/8 | | 13183 | 13184 | 13185 |
| 3/8-16 | 3/8 | | 13543 | 13544 | 13545 |

SERIES BXMSTI**Bottom Metric "STI" Screw Thread Insert Thredfloers**

Chamfer length: 1-3/4 to 2 threads.

See page 58 for blank dimensions.

| Thredfloer Size | Tap Blank Size | H2 | H3 | H4 | H5 | H6 |
|-----------------|----------------|-------|-------|-------|-------|-------|
| M2.0 x 0.4 | #4 | 17342 | 17343 | | | |
| M2.5 x 0.45 | #5 | 17482 | 17483 | | | |
| M3.0 x 0.5 | #8 | 17662 | 17663 | | | |
| M3.5 x 0.6 | #10 | | 17863 | 17864 | | |
| M4.0 x 0.7 | 1/4 | | 18063 | 18064 | | |
| M5.0 x 0.8 | 1/4 | | 18263 | 18264 | | |
| M6.0 x 1.0 | 5/16 | | | 18464 | 18465 | |
| M8.0 x 1.25 | 3/8 | | | | 18665 | 18666 |

SERIES BXJIS

JIS Thredfloers, Bottom Chamfer



Chamfer length: 1-3/4 to 2 threads.

See page 60 for blank dimensions.

| Thredfloer Size | H2 | H3 | H4 | H5 | H6 | H7 | H8 | H9 | H10 |
|-----------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| 0-80 | 10022 | 10023 | | | | | | | |
| 1-64 | | 10143 | 10144 | 10145 | | | | | |
| 1-72 | | 10263 | 10264 | 10265 | | | | | |
| 2-56 | | 10303 | 10304 | 10305 | | | | | |
| 4-40 | 10822 | 10823 | 10824 | 10825 | 10826 | 10827 | | | |
| 6-32 | 11382 | 11383 | 11384 | 11385 | 11386 | 11387 | 11388 | 11389 | 11390 |
| 8-32 | 11722 | 11723 | 11724 | 11725 | 11726 | 11727 | 11728 | 11729 | 11730 |
| 10-24 | | 12063 | 12064 | 12065 | 12066 | 12067 | 12068 | 12069 | 12070 |
| 10-32 | 12282 | 12283 | 12284 | 12285 | 12286 | 12287 | 12288 | 12289 | 12290 |
| 1/4-20 | | 12743 | 12744 | 12745 | 12746 | 12747 | 12748 | 12749 | 12750 |
| 1/4-28 | | 12963 | 12964 | 12965 | 12966 | 12967 | 12968 | 12969 | 12970 |

SERIES BXMJIS

Metric JIS Thredfloers, Bottom Chamfer



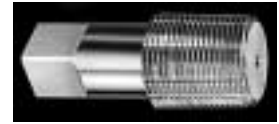
Chamfer length: 1-3/4 to 2 threads.

See page 60 for blank dimensions.

| Thredfloer Size | D3 | D4 | D5 | D6 | D7 | D8 | D9 | D10 | D11 | D12 |
|-----------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| M1.6 x 0.35 | 17043 | | 17045 | | | | | | | |
| M1.7 x 0.35 | 17183 | | 17185 | | | | | | | |
| M2.0 x 0.4 | 17323 | | 17325 | | | | | | | |
| M2.5 x 0.45 | 17463 | | | 17466 | | | | | | |
| M3.0 x 0.5 | 17643 | | | 17646 | | | | | | |
| M3.5 x 0.6 | | 17844 | | | 17847 | | | | | |
| M4.0 x 0.7 | | 18044 | | | 18047 | | | | | |
| M5.0 x 0.8 | | 18244 | | | | 18248 | | | | |
| M6.0 x 1.0 | | | 18445 | | | | 18449 | | | |
| M8.0 x 1.25 | | | 18645 | | | | | 18650 | | |
| M10 x 1.5 | | | | 18846 | | | | | 18851 | |
| M12 x 1.75 | | | | 19046 | | | | | | 19052 |

SERIES BXPT

NPT & NPTF Taper Thredfloer Pipe Taps



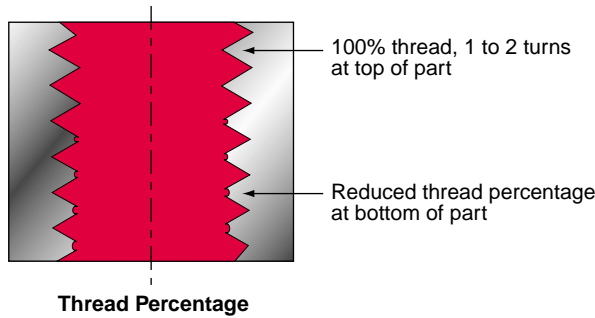
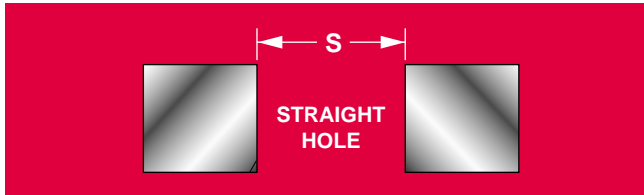
Cold forming pipe taps may offer significant advantages compared to cutting taps when correctly applied. Benefits include smooth, burnished threads with no burrs or stop marks, better tap life, and the absence of chips during tapping.

To ensure successful results with a minimum of effort,

a discussion of taper pipe tap applications with Balax "Application Engineers" is suggested prior to their purchase and use.

Two options exist in preparing the pre-tap hole. In both cases use of a torque limiting tap holder and a rapid positive reversing action is recommended.

Straight Hole Option

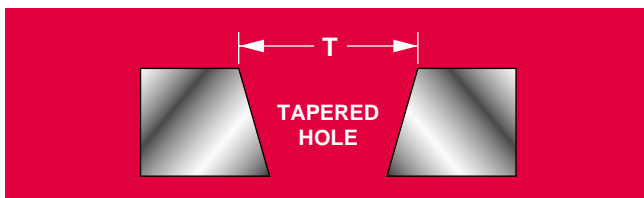


Recommended for steel and stainless steel applications, straight hole tapping will reduce tapping torque and increase tap life. Use a straight hole in accordance with the "S" sizes in the Taper Pipe Hole Size Chart.

Using the straight pre-tap hole, the tapered pipe tap will produce the correct tapered thread in the part by rearranging or cold forming metal from the top to the bottom of the hole.

This procedure will result in a very full, sharp crested thread at the top of the hole (usually 2 to 3 turns of complete thread), however, the thread at the bottom will have partially formed crests containing a cup or "U". For many applications, the highly polished and accurate threads at the top of the hole provide superior appearance and excellent sealing capability.

Tapered Hole Option



Recommended for softer materials, such as copper and aluminum, where tapping torque is not a problem. The use of a tapered hole will result in a uniform thread height and crest configuration for the entire depth of thread in the part.

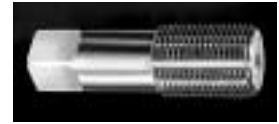
Use the taper hole sizes "T" in the table below.

| Stock Size NPT or NPTF | NPT EDP No. | NPTF EDP No. | Taper Hole Size "T" | | | Straight Hole Size "S" | | |
|---------------------------|----------------|-----------------|---------------------|----------------------------|-----------|------------------------|----------------------------|-----------|
| | | | Ductile Metals | Thick Wall* Diecastings | Tolerance | Ductile Metals | Thick Wall* Diecastings | Tolerance |
| 1/16-27 | 02000 | 02010 | .283" | .276" | +.002" | .274" | .270" | +.002" |
| 1/8-27 SM (.3125 shank) | 02100 | 02110 | .376" | .369" | +.002" | .367" | .363" | +.002" |
| 1/8-27 LG (.4375 shank) | 02200 | 02210 | .376" | .369" | +.002" | .367" | .363" | +.002" |
| 1/4-18 | 02300 | 02310 | .492" | .481" | +.003" | .478" | .474" | +.003" |
| 3/8-18 | 02400 | 02410 | .642" | .630" | +.003" | .628" | .624" | +.003" |
| 1/2-14 | 02500 | 02510 | .781" | .766" | +.003" | .763" | .759" | +.003" |
| 3/4-14 | 02600 | 02610 | .992" | .977" | +.004" | .974" | .970" | +.004" |

* Sizes may have to be reduced for thin wall applications.

SERIES BXPS

NPS & NPSF Straight Thredfloer Pipe Taps



NPS and NPSF threads require reamed pre-tap holes because of the requirement for 100% threads with controlled crest dimensions. NPSF taps are being successfully used in diecast applications, however,

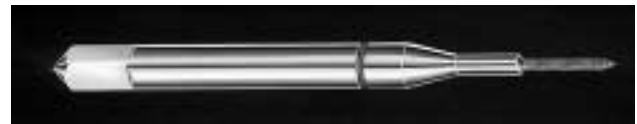
care in their application and use is required. High silicon diecast aluminum becomes brittle when cold formed and may crumble at the crest of the thread.

| Stock Size | NPS EDP No. | NPSC EDP No. | NPSM EDP No. | NPSF EDP No. | * Hole Size for 75% Thread For NPS | |
|-------------------------|----------------|-----------------|-----------------|-----------------|---------------------------------------|--------------|
| | | | | | NPSC, NPSM | For NPSF |
| 1/16-27 | 02020 | 02022 | 02024 | 02030 | — | .282 - .283" |
| 1/8-27 SM (.3125 shank) | 02120 | 02122 | 02124 | 02130 | — | .374 - .375" |
| 1/8-27 LG (.4375 shank) | 02220 | 02222 | 02224 | 02230 | .379 - .380" | .374 - .375" |
| 1/4-18 | 02320 | 02322 | 02324 | 02330 | .499 - .500" | .493 - .494" |
| 3/8-18 | 02420 | 02422 | 02424 | 02430 | .639 - .640" | .628 - .629" |
| 1/2-14 | 02520 | 02522 | 02524 | 02530 | .788 - .790" | .780 - .782" |
| 3/4-14 | 02620 | 02622 | 02624 | 02630 | .998 - 1.000" | .990 - .992" |

* For diecast parts, subtract .001" - .002" to compensate for porosity.

SERIES BXMIN

Miniature Thredfloers



Miniature Thredfloer Taps are used in most ductile materials. Because of their very fine pitch, they can successfully tap materials 25-35 Rockwell C hardness.

Miniature Thredfloers are much stronger than comparable cutting taps and solve many tap life, tap breakage, thread gaging, and chip removal problems.

All Miniature Thredfloers are furnished in bottoming style to the following dimensions:

Overall Length - 1-5/8"
Shank Diameter - .141"
Thread Length - 1/4"
Square Length - 3/16"
Square Size - .110"

| Size | H2 EDP No. | Threads per Inch | Hole Size Required | | | Tap Drill Size |
|---------------|---------------|------------------------|--------------------|------------|------------|----------------------|
| | | | 75% Thread | 65% Thread | 55% Thread | |
| 000 - 120 | 00102 | 120 | .0303 | .0307 | .0311 | #68 |
| 00 - 96 | 00202 | 96 | .0420 | .0425 | .0430 | #58 |
| 00 - 90 | 00302 | 90 | .0417 | .0422 | .0428 | #58 |
| 0.9 mm x .225 | 01002 | 113 | .0314 | .0319 | .0323 | 1/32 |
| 1.0 mm x .250 | 01102 | 102 | .0348 | .0353 | .0358 | #65 |
| 1.1 mm x .250 | 01202 | 102 | .0387 | .0392 | .0397 | #61 |
| 1.2 mm x .250 | 01302 | 102 | .0427 | .0432 | .0437 | #58 |
| 1.4 mm x .300 | 01402 | 85 | .0493 | .0499 | .0505 | 1.25 mm |

SERIES BXIT

Inline Tapper Stub Thredfloers



Balax BXIT Inline Tapper Stub Thredfloers feature a bottom style thread chamfer and the front point is removed for improved clearance in close bottoming applications. Their controlled blank dimensions and

chamfer length provide optimum inline tapping results. They are available with TiN, TiCN and TiAlN surface treatments. Please consult factory for pricing.

| Thredfloer Size | H4 | H5 | H6 | H7 | H8 |
|-----------------|-------|-------|----|-------|-------|
| 2-56 | 10344 | | | | |
| 3-48 | | 10535 | | | |
| 4-40 | | 10865 | | | |
| 6-32 | | 11425 | | | |
| 8-32 | | 11765 | | | |
| 10-24 | | | | 12107 | |
| 10-32 | | 12325 | | | |
| 1/4-20 | | | | | 12788 |
| 1/4-28 | | | | 13007 | |

SERIES BXMIT

Metric Inline Tapper Stub Thredfloers



Balax BXMIT Inline Tapper Stub Thredfloers feature a bottom style thread chamfer and the front point is removed for improved clearance in close bottoming applications. Their controlled blank dimensions and

chamfer length provide optimum inline tapping results. They are available with TiN, TiCN and TiAlN surface treatments. Please consult factory for pricing.

| Thredfloer Size | D5 | D6 | D7 | D8 | D9 |
|-----------------|-------|-------|-------|-------|-------|
| M2.0 x 0.4 | 17365 | | | | |
| M2.5 x 0.45 | | 17506 | | | |
| M3.0 x 0.5 | | 17686 | | | |
| M3.5 x 0.6 | | | 17887 | | |
| M4.0 x 0.7 | | | 18087 | | |
| M5.0 x 0.8 | | | | 18288 | |
| M6.0 x 1.0 | | | | | 18489 |

Specifying Thredfloer EDP Numbers

Thredfloer part numbers consist of a five-digit EDP number followed by a three digit suffix. The EDP number describes the basic tap, and the suffix specifies the desired options.

1 1 2 8 5 - 4 1 4

EDP Number

Found in the tables.
Describes the tap type,
size, and H/D number.

Number of Grooves

0 = Standard configuration.
6-32 or M3.5 and larger
have one groove. Smaller
taps have no groove.
1 = One groove (for taps
smaller than 6-32 or M3.5)
2 = Two grooves
4 = Four grooves
6 = Six grooves (for 1/2" and
M14 & larger)

Front Point

0 = Front point
1 = Front point removed

Surface Treatment

0 = Bright Finish
1 = Nitride
2 = Steam Oxide
3 = Chrome Plate
4 = Balwear
5 = Balube
6 = Nitride/Steam Oxide
7 = Nitride/Chrome Plate
A = Titanium Aluminum Nitride
C = Titanium Carbonitride
T = Titanium Nitride
U = Super TiN

The part number above is for a Series BXB Bottom Chamfer Thredfloer, size 6-32, H5 (see the table on page 2).
The options specified are: 4 grooves, front point removed, and balwear surface treatment.