

# REGAL CUTTING TOOLS

**NEW and EXPANDED**  
SuperTuf MATERIAL SPECIFIC  
HIGH PERFORMANCE TAPS  
MADE IN U.S.A.



## REGAL'S FOCUS – YOU, THE CUSTOMER



We are extremely pleased to introduce our new expanded line of SuperTuf High Performance Tooling. Additional sizes and “H” limits in all material specific styles have been added and a wide variety of treatments and coatings, which can be quickly added to any tool, are now available. We believe these American made tools and the ability to manufacture High Performance Coated Specials with quick delivery will bring the solutions our customers are seeking.

Thank you for choosing Regal Cutting Tools as your source for metal cutting tools. We value your business and look forward to a long-term, mutually beneficial business partnership.

### **SUPERTUF SPECIAL TAPS FROM BLANKS**

*The goal in developing the Regal SuperTuf line of high performance tools was to engineer a line of material specific tooling that could be manufactured with a short lead time, but cost effectively. We achieved this goal and proudly introduce our additional capability of making SuperTuf special taps from blanks.*

Regal Cutting Tools can now deliver the following:

- **Expansive Range of Sizes Available**

We can provide material specific special tools from blanks ranging from #4 to 1" or M3 to M24 in full ANSI or DIN/ANSI dimensions.

- **Tooling Materials Offered**

We utilize various HSSE particle metals and a PMX proprietary super micro particle metal with high vanadium. This super HSS provides the tooling you need when extreme wear resistance and red hardness is part of the tooling equation.

- **Material Specific Applications**

The SuperTuf tools and geometries were designed specifically for difficult to machine materials, including Titanium, Nickel, High Carbon Steels, Stainless Steel and High Silicon Aluminum.

- **American Made**

These tools are manufactured in our Roscoe, Illinois, plant for consistent dependability and the high quality you expect.

- **Quick Delivery**

We have capitalized on our experience and expertise in manufacturing HSS taps in 24 hours with our SuperTuf specials from blanks and solved the long lead time issues plaguing the industry. Regal SuperTuf High Performance Taps can be manufactured in 3 to 5 working days uncoated or 10 days or less coated.

- **Edge Preparation**

This value-added manufacturing process extends tool life by conditioning the cutting surfaces to remove micro burrs and micro cracks from the cutting edges. The conditioned smooth surface reduces drag, lessens torque required for tapping and provides a better surface for coatings to adhere to high performance tooling. The surface goes through this process prior to and following completion of the coating application.

- **Test Policy**

Tell us the job specifications, and we will provide recommendations and prices through your local distributor. Satisfaction guaranteed!

- **Engineering Support**

If you have questions and need technical support, we enjoy providing our customers with tooling recommendations. Simply contact Customer Support at 800-435-2948.

Regal's ability to provide an American-made high performance coated tool shipping from Roscoe, Illinois, in less than 10 days resolves the frustration of long lead times.

We are looking forward to helping with the next opportunity you uncover. You will not be disappointed.

# SuperTuf DM

## Taps for Difficult Materials with TiALN



Designed specifically for: Hardened Steels 4140, 4340, 8620, 8286 and 52100; Duplex Stainless; Precipitation Hardened Stainless Ferritic and Martensitic Stainless 13-3, 15-5, 17-4, 440, 416, and 446; Hardness: 300-400 BHN; Tensile Strength: 600-1000 MPA

- The optimum tap for heat treated alloy steels up to 35 HRC
- Exceptional edge support and consistent cutting angles for excellent chip control
- Proprietary PMX micro-particle steel supports the cutting edge in these difficult materials

- Closely controlled cutting action provides excellent tool life
- Titanium Aluminum Nitride coating insures long life and superior thread finish



Size	Spiral Point – Plug						Spiral Flute – Modified Bottom					
	Thread Limit	# of Flutes	TiALN	Bright	TiCN	Steam Oxide	Thread Limit	# of Flutes	TiALN	Bright	TiCN	Steam Oxide
#2-56 NC	H2	2	072370MS	071370MS	071370MS85	071370MS43	H2	2	072380MS	071380MS	071380MS85	071380MS43
#4-40 NC	H2	2	072300MS	071300MS	071300MS85	071300MS43	H2	3	072340MS	071340MS	071340MS85	071340MS43
#6-32 NC	H3	3	072301MS	071301MS	071301MS85	071301MS43	H3	3	072341MS	071341MS	071341MS85	071341MS43
#8-32 NC	H3	3	072302MS	071302MS	071302MS85	071302MS43	H3	3	072342MS	071342MS	071342MS85	071342MS43
#10-24 NC	H3	3	072303MS	071303MS	071303MS85	071303MS43	H3	3	072343MS	071343MS	071343MS85	071343MS43
#10-32 NF	H3	3	072304MS	071304MS	071304MS85	071304MS43	H3	3	072344MS	071344MS	071344MS85	071344MS43
1/4"-20 NC	H5	3	072371MS	071371MS	071371MS85	071371MS43	H5	3	072381MS	071381MS	071381MS85	071381MS43
1/4"-20 NC	H3	3	072305MS	071305MS	071305MS85	071305MS43	H3	3	072345MS	071345MS	071345MS85	071345MS43
1/4"-28 NF	H3	3	072306MS	071306MS	071306MS85	071306MS43	H3	3	072346MS	071346MS	071346MS85	071346MS43
5/16"-18 NC	H5	3	072372MS	071372MS	071372MS85	071372MS43	H5	3	072382MS	071382MS	071382MS85	071382MS43
5/16"-18 NC	H3	3	072307MS	071307MS	071307MS85	071307MS43	H3	3	072347MS	071347MS	071347MS85	071347MS43
5/16"-24 NF	H3	3	072308MS	071308MS	071308MS85	071308MS43	H3	3	072348MS	071348MS	071348MS85	071348MS43
3/8"-16 NC	H5	3	072373MS	071373MS	071373MS85	071373MS43	H5	3	072383MS	071383MS	071383MS85	071383MS43
3/8"-16 NC	H3	3	072309MS	071309MS	071309MS85	071309MS43	H3	3	072349MS	071349MS	071349MS85	071349MS43
3/8"-24 NF	H3	3	072310MS	071310MS	071310MS85	071310MS43	H3	3	072350MS	071350MS	071350MS85	071350MS43
7/16"-14 NC	H5	3	072374MS	071374MS	071374MS85	071374MS43	H5	3	072384MS	071384MS	071384MS85	071384MS43
7/16"-14 NC	H3	3	072311MS	071311MS	071311MS85	071311MS43	H3	3	072351MS	071351MS	071351MS85	071351MS43
7/16"-20 NF	H3	3	072312MS	071312MS	071312MS85	071312MS43	H3	3	072352MS	071352MS	071352MS85	071352MS43
1/2"-13 NC	H5	3	072375MS	071375MS	071375MS85	071375MS43	H5	3	072385MS	071385MS	071385MS85	071385MS43
1/2"-13 NC	H3	3	072313MS	071313MS	071313MS85	071313MS43	H3	3	072353MS	071353MS	071353MS85	071353MS43
1/2"-20 NF	H3	3	072314MS	071314MS	071314MS85	071314MS43	H3	3	072354MS	071354MS	071354MS85	071354MS43
5/8"-11 NC	H5	3	072376MS	071376MS	071376MS85	071376MS43	H5	4	072386MS	071386MS	071386MS85	071386MS43
5/8"-11 NC	H3	3	072315MS	071315MS	071315MS85	071315MS43	H3	4	072355MS	071355MS	071355MS85	071355MS43
5/8"-18 NF	H3	3	072316MS	071316MS	071316MS85	071316MS43	H3	4	072356MS	071356MS	071356MS85	071356MS43
3/4"-10 NC	H5	4	072377MS	071377MS	071377MS85	071377MS43	H5	4	072387MS	071387MS	071387MS85	071387MS43
3/4"-10 NC	H3	4	072317MS	071317MS	071317MS85	071317MS43	H3	4	072357MS	071357MS	071357MS85	071357MS43
3/4"-16 NF	H3	4	072318MS	071318MS	071318MS85	071318MS43	H3	4	072358MS	071358MS	071358MS85	071358MS43
M3 x 0.5	D3	3	072330MS	071330MS	071330MS85	071330MS43	D3	3	072360MS	071360MS	071360MS85	071360MS43
M4 x 0.7	D4	3	072331MS	071331MS	071331MS85	071331MS43	D4	3	072361MS	071361MS	071361MS85	071361MS43
M5 x 0.8	D4	3	072332MS	071332MS	071332MS85	071332MS43	D4	3	072362MS	071362MS	071362MS85	071362MS43
M6 x 1	D5	3	072333MS	071333MS	071333MS85	071333MS43	D5	3	072363MS	071363MS	071363MS85	071363MS43
M8 x 1.25	D5	3	072334MS	071334MS	071334MS85	071334MS43	D5	3	072364MS	071364MS	071364MS85	071364MS43
M10 x 1.5	D6	3	072335MS	071335MS	071335MS85	071335MS43	D5	3	072365MS	071365MS	071365MS85	071365MS43
M10 x 1.25	D5	3	072336MS	071336MS	071336MS85	071336MS43	D5	3	072366MS	071366MS	071366MS85	071366MS43
M12 x 1.75	D6	3	072337MS	071337MS	071337MS85	071337MS43	D6	3	072367MS	071367MS	071367MS85	071367MS43

# SuperTuf SS

## Taps for Stainless Steel with TiN

HSS  
E

UNC

UNF

M

MF

302A

TiN

SuperTuf  
SS

Designed for: Free Machining and Austenitic and Ferritic Stainless Steels

Suitable for: Low and Medium Carbon Steel, as well as Structural Steel with Hardness Less Than BHN 250

- Uniquely designed tap for free machining stainless steels and tough carbon steels
- Consistent cutting angles for excellent chip control
- Our proprietary micro-particle steel supports the cutting edge
- Extreme toughness and wear resistance provides excellent tool life
- Titanium Nitride coating is provided for extended tool life



Size	Spiral Point – Plug					Spiral Flute – Modified Bottom				
	Thread Limit	# of Flutes	TiN	Bright	Steam Oxide	Thread Limit	# of Flutes	TiN	Bright	Steam Oxide
#2-56 NC	H2	2	073470MS	071470MS	071470MS43	H2	2	073480MS	071480MS	071480MS43
#4-40 NC	H2	2	073400MS	071400MS	071400MS43	H2	3	073440MS	071440MS	071440MS43
#6-32 NC	H3	2	073401MS	071401MS	071401MS43	H3	3	073441MS	071441MS	071441MS43
#8-32 NC	H3	3	073402MS	071402MS	071402MS43	H3	3	073442MS	071442MS	071442MS43
#10-24 NC	H3	3	073403MS	071403MS	071403MS43	H3	3	073443MS	071443MS	071443MS43
#10-32 NF	H3	3	073404MS	071404MS	071404MS43	H3	3	073444MS	071444MS	071444MS43
1/4"-20 NC	H5	3	073471MS	071471MS	071471MS43	H5	3	073481MS	071481MS	071481MS43
1/4"-20 NC	H3	3	073405MS	071405MS	071405MS43	H3	3	073445MS	071445MS	071445MS43
1/4"-28 NF	H3	3	073406MS	071406MS	071406MS43	H3	3	073446MS	071446MS	071446MS43
5/16"-18 NC	H5	3	073472MS	071472MS	071472MS43	H5	3	073482MS	071482MS	071482MS43
5/16"-18 NC	H3	3	073407MS	071407MS	071407MS43	H3	3	073447MS	071447MS	071447MS43
5/16"-24 NF	H3	3	073408MS	071408MS	071408MS43	H3	3	073448MS	071448MS	071448MS43
3/8"-16 NC	H5	3	073473MS	071473MS	071473MS43	H5	3	073483MS	071483MS	071483MS43
3/8"-16 NC	H3	3	073409MS	071409MS	071409MS43	H3	3	073449MS	071449MS	071449MS43
3/8"-24 NF	H3	3	073410MS	071410MS	071410MS43	H3	3	073450MS	071450MS	071450MS43
7/16"-14 NC	H5	3	073474MS	071474MS	071474MS43	H5	3	073484MS	071484MS	071484MS43
7/16"-14 NC	H3	3	073411MS	071411MS	071411MS43	H3	3	073451MS	071451MS	071451MS43
7/16"-20 NF	H3	3	073412MS	071412MS	071412MS43	H3	3	073452MS	071452MS	071452MS43
1/2"-13 NC	H5	3	073475MS	071475MS	071475MS43	H5	3	073485MS	071485MS	071485MS43
1/2"-13 NC	H3	3	073413MS	071413MS	071413MS43	H3	3	073453MS	071453MS	071453MS43
1/2"-20 NF	H3	3	073414MS	071414MS	071414MS43	H3	3	073454MS	071454MS	071454MS43
5/8"-11 NC	H5	3	073476MS	071476MS	071476MS43	H5	4	073486MS	071486MS	071486MS43
5/8"-11 NC	H3	3	073415MS	071415MS	071415MS43	H3	4	073455MS	071455MS	071455MS43
5/8"-18 NF	H3	3	073416MS	071416MS	071416MS43	H3	4	073456MS	071456MS	071456MS43
3/4"-10 NC	H5	3	073477MS	071477MS	071477MS43	H5	4	073487MS	071487MS	071487MS43
3/4"-10 NC	H3	3	073417MS	071417MS	071417MS43	H3	4	073457MS	071457MS	071457MS43
3/4"-16 NF	H3	3	073418MS	071418MS	071418MS43	H3	4	073458MS	071458MS	071458MS43
M3 x 0.5	D3	3	073430MS	071430MS	071430MS43	D3	3	073460MS	071460MS	071460MS43
M4 x 0.7	D4	3	073431MS	071431MS	071431MS43	D4	3	073461MS	071461MS	071461MS43
M5 x 0.8	D4	3	073432MS	071432MS	071432MS43	D4	3	073462MS	071462MS	071462MS43
M6 x 1	D5	3	073433MS	071433MS	071433MS43	D5	3	073463MS	071463MS	071463MS43
M8 x 1.25	D5	3	073434MS	071434MS	071434MS43	D5	3	073464MS	071464MS	071464MS43
M10 x 1.5	D6	3	073435MS	071435MS	071435MS43	D6	3	073465MS	071465MS	071465MS43
M10 x 1.25	D5	3	073436MS	071436MS	071436MS43	D5	3	073466MS	071466MS	071466MS43
M12 x 1.75	D6	3	073437MS	071437MS	071437MS43	D6	3	073467MS	071467MS	071467MS43

# SuperTuf SS-DA

## Taps for Stainless Steel in DIN/ANSI with TiN



Designed for: Free Machining and Austenitic and Ferritic Stainless Steels  
 Suitable for: Low and Medium Carbon Steel, as well as Structural Steel with Hardness Less Than BHN 250

- Uniquely designed tap for free machining stainless steels and tough carbon steels
- SS-DA lengths combine the overall length of DIN lengths with ANSI thread specifications
- Long lengths for hard-to-reach tapping
- Consistent cutting angles on both chamfer and flute faces for excellent chip control
- Our proprietary micro-particle steel supports the cutting edge in these stainless and carbon steels
- Titanium Nitride coating is provided for extended tool life



Size	Spiral Point – Plug					Spiral Flute – Modified Bottom				
	Thread Limit	# of Flutes	TiN	Bright	Steam Oxide	Thread Limit	# of Flutes	TiN	Bright	Steam Oxide
#2-56 NC	H2	2	073570MS	071570MS	071570MS43	H2	2	073580MS	071580MS	071580MS43
#4-40 NC	H2	2	073500MS	071500MS	071500MS43	H2	3	073540MS	071540MS	071540MS43
#6-32 NC	H3	2	073501MS	071501MS	071501MS43	H3	3	073541MS	071541MS	071541MS43
#8-32 NC	H3	3	073502MS	071502MS	071502MS43	H3	3	073542MS	071542MS	071542MS43
#10-24 NC	H3	3	073503MS	071503MS	071503MS43	H3	3	073543MS	071543MS	071543MS43
#10-32 NF	H3	3	073504MS	071504MS	071504MS43	H3	3	073544MS	071544MS	071544MS43
1/4"-20 NC	H5	3	073571MS	071571MS	071571MS43	H5	3	073581MS	071581MS	071581MS43
1/4"-20 NC	H3	3	073505MS	071505MS	071505MS43	H3	3	073545MS	071545MS	071545MS43
1/4"-28 NF	H3	3	073506MS	071506MS	071506MS43	H3	3	073546MS	071546MS	071546MS43
5/16"-18 NC	H5	3	073572MS	071572MS	071572MS43	H5	3	073582MS	071582MS	071582MS43
5/16"-18 NC	H3	3	073507MS	071507MS	071507MS43	H3	3	073547MS	071547MS	071547MS43
5/16"-24 NF	H3	3	073508MS	071508MS	071508MS43	H3	3	073548MS	071548MS	071548MS43
3/8"-16 NC	H5	3	073573MS	071573MS	071573MS43	H5	3	073583MS	071583MS	071583MS43
3/8"-16 NC	H3	3	073509MS	071509MS	071509MS43	H3	3	073549MS	071549MS	071549MS43
3/8"-24 NF	H3	3	073510MS	071510MS	071510MS43	H3	3	073550MS	071550MS	071550MS43
7/16"-14 NC	H5	3	073574MS	071574MS	071574MS43	H5	3	073584MS	071584MS	071584MS43
7/16"-14 NC	H3	3	073511MS	071511MS	071511MS43	H3	3	073551MS	071551MS	071551MS43
7/16"-20 NF	H3	3	073512MS	071512MS	071512MS43	H3	3	073552MS	071552MS	071552MS43
1/2"-13 NC	H5	3	073575MS	071575MS	071575MS43	H5	3	073585MS	071585MS	071585MS43
1/2"-13 NC	H3	3	073513MS	071513MS	071513MS43	H3	3	073553MS	071553MS	071553MS43
1/2"-20 NF	H3	3	073514MS	071514MS	071514MS43	H3	3	073554MS	071554MS	071554MS43
5/8"-11 NC	H5	3	073576MS	071576MS	071576MS43	H5	4	073586MS	071586MS	071586MS43
5/8"-11 NC	H3	3	073515MS	071515MS	071515MS43	H3	4	073555MS	071555MS	071555MS43
5/8"-18 NF	H3	3	073516MS	071516MS	071516MS43	H3	4	073556MS	071556MS	071556MS43
3/4"-10 NC	H5	3	073577MS	071577MS	071577MS43	H5	4	073587MS	071587MS	071587MS43
3/4"-10 NC	H3	3	073517MS	071517MS	071517MS43	H3	4	073557MS	071557MS	071557MS43
3/4"-16 NF	H3	3	073518MS	071518MS	071518MS43	H3	4	073558MS	071558MS	071558MS43
M3 x 0.5	D3	2	073530MS	071530MS	071530MS43	D3	3	073560MS	071560MS	071560MS43
M4 x 0.7	D4	3	073531MS	071531MS	071531MS43	D4	3	073561MS	071561MS	071561MS43
M5 x 0.8	D4	3	073532MS	071532MS	071532MS43	D4	3	073562MS	071562MS	071562MS43
M6 x 1	D5	3	073533MS	071533MS	071533MS43	D5	3	073563MS	071563MS	071563MS43
M8 x 1.25	D5	3	073534MS	071534MS	071534MS43	D5	3	073564MS	071564MS	071564MS43
M10 x 1.5	D6	3	073535MS	071535MS	071535MS43	D6	3	073565MS	071565MS	071565MS43
M10 x 1.25	D5	3	073536MS	071536MS	071536MS43	D5	3	073566MS	071566MS	071566MS43
M12 x 1.75	D6	3	073537MS	071537MS	071537MS43	D6	3	073567MS	071567MS	071567MS43

# SuperTuf Ti

## Taps for Titanium Alloys with TiCN



Designed for:  
All Titanium Alloys  
to 400 BHN

- PMX super micro-particle metal makes this the optimum tap for Titanium alloys up to 35 HRC
- Exceptional edge support, this free cutting tap uses consistent cutting angles for excellent chip control
- PMX micro-particle steel supports the cutting edge in these difficult Titanium Alloy materials
- Extreme toughness and wear resistance for excellent tool life
- Titanium Carbo Nitride coating insures long life and superior thread finish



Size	Spiral Point – Plug				Spiral Flute – Modified Bottom			
	Thread Limit	# of Flutes	TiCN	Bright	Thread Limit	# of Flutes	TiCN	Bright
#2-56 NC	H2	2	074670MS	071670MS	H2	2	074680MS	071680MS
#4-40 NC	H2	3	074600MS	071600MS	H2	3	074640MS	071640MS
#6-32 NC	H3	3	074601MS	071601MS	H3	3	074641MS	071641MS
#8-32 NC	H3	3	074602MS	071602MS	H3	3	074642MS	071642MS
#10-24 NC	H3	3	074603MS	071603MS	H3	3	074643MS	071643MS
#10-32 NF	H3	3	074604MS	071604MS	H3	3	074644MS	071644MS
1/4"-20 NC	H5	3	074671MS	071671MS	H5	3	074681MS	071681MS
1/4"-20 NC	H3	3	074605MS	071605MS	H3	3	074645MS	071645MS
1/4"-28 NF	H3	3	074606MS	071606MS	H3	3	074646MS	071646MS
5/16"-18 NC	H5	3	074672MS	071672MS	H5	3	074682MS	071682MS
5/16"-18 NC	H3	3	074607MS	071607MS	H3	3	074647MS	071647MS
5/16"-24 NF	H3	3	074608MS	071608MS	H3	3	074648MS	071648MS
3/8"-16 NC	H5	3	074673MS	071673MS	H5	3	074683MS	071683MS
3/8"-16 NC	H3	3	074609MS	071609MS	H3	3	074649MS	071649MS
3/8"-24 NF	H3	3	074610MS	071610MS	H3	3	074650MS	071650MS
7/16"-14 NC	H5	3	074674MS	071674MS	H5	3	074684MS	071684MS
7/16"-14 NC	H3	3	074611MS	071611MS	H3	3	074651MS	071651MS
7/16"-20 NF	H3	3	074612MS	071612MS	H3	3	074652MS	071652MS
1/2"-13 NC	H5	3	074675MS	071675MS	H5	3	074685MS	071685MS
1/2"-13 NC	H3	3	074613MS	071613MS	H3	3	074653MS	071653MS
1/2"-20 NF	H3	3	074614MS	071614MS	H3	3	074654MS	071654MS
5/8"-11 NC	H5	3	074676MS	071676MS	H5	4	074686MS	071686MS
5/8"-11 NC	H3	3	074615MS	071615MS	H3	4	074655MS	071655MS
5/8"-18 NF	H3	3	074616MS	071616MS	H3	4	074656MS	071656MS
3/4"-10 NC	H5	4	074677MS	071677MS	H5	4	074687MS	071687MS
3/4"-10 NC	H3	4	074617MS	071617MS	H3	4	074657MS	071657MS
3/4"-16 NF	H3	4	074618MS	071618MS	H3	4	074658MS	071658MS
7/8"-9 NC					H6	4	074688MS	071688MS
1"-8 NC					H6	4	074689MS	071689MS
1"-12 NF					H6	4	074690MS	071690MS
M3 x 0.5	D3	3	074630MS	071630MS	D3	3	074660MS	071660MS
M4 x 0.7	D4	3	074631MS	071631MS	D4	3	074661MS	071661MS
M5 x 0.8	D4	3	074632MS	071632MS	D4	3	074662MS	071662MS
M6 x 1	D5	3	074633MS	071633MS	D5	3	074663MS	071663MS
M8 x 1.25	D5	3	074634MS	071634MS	D5	3	074664MS	071664MS
M10 x 1.5	D6	3	074635MS	071635MS	D6	3	074665MS	071665MS
M10 x 1.25	D5	3	074636MS	071636MS	D5	3	074666MS	071666MS
M12 x 1.75	D6	3	074637MS	071637MS	D6	3	074667MS	071667MS

# SuperTuf Ni

## Taps for Nickel Alloys with TiAlN



Designed for:  
All Nickel Alloys, including  
Monel, Waspaloy and Hastaloy  
to 350 BHN

- The optimum tap for Nickel alloys up to 38 HRC
- Exceptional edge support and consistent cutting angles for excellent chip control
- PMX micro-particle steel supports the cutting edge in these difficult Nickel Alloy materials
- Wear resistance and closely controlled cutting action provides excellent tool life
- Titanium Aluminum Nitride coating ensures long life and superior thread finish



Size	Spiral Point – Plug					Spiral Flute – Modified Bottom				
	Thread Limit	# of Flutes	TiAlN	Bright	Steam Oxide	Thread Limit	# of Flutes	TiAlN	Bright	Steam Oxide
#2-56 NC	H2	2	075770MS	071770MS	071770MS43	H2	2	075780MS	071780MS	071780MS43
#4-40 NC	H2	3	075700MS	071700MS	071700MS43	H2	3	075740MS	071740MS	071740MS43
#6-32 NC	H3	3	075701MS	071701MS	071701MS43	H3	3	075741MS	071741MS	071741MS43
#8-32 NC	H3	3	075702MS	071702MS	071702MS43	H3	3	075742MS	071742MS	071742MS43
#10-24 NC	H3	3	075703MS	071703MS	071703MS43	H3	3	075743MS	071743MS	071743MS43
#10-32 NF	H3	3	075704MS	071704MS	071704MS43	H3	3	075744MS	071744MS	071744MS43
1/4"-20 NC	H5	3	075771MS	071771MS	071771MS43	H5	3	075781MS	071781MS	071781MS43
1/4"-20 NC	H3	3	075705MS	071705MS	071705MS43	H3	3	075745MS	071745MS	071745MS43
1/4"-28 NF	H3	3	075706MS	071706MS	071706MS43	H3	3	075746MS	071746MS	071746MS43
5/16"-18 NC	H5	3	075772MS	071772MS	071772MS43	H5	3	075782MS	071782MS	071782MS43
5/16"-18 NC	H3	3	075707MS	071707MS	071707MS43	H3	3	075747MS	071747MS	071747MS43
5/16"-24 NF	H3	3	075708MS	071708MS	071708MS43	H3	3	075748MS	071748MS	071748MS43
3/8"-16 NC	H5	3	075773MS	071773MS	071773MS43	H5	3	075783MS	071783MS	071783MS43
3/8"-16 NC	H3	3	075709MS	071709MS	071709MS43	H3	3	075749MS	071749MS	071749MS43
3/8"-24 NF	H3	3	075710MS	071710MS	071710MS43	H3	3	075750MS	071750MS	071750MS43
7/16"-14 NC	H5	3	075774MS	071774MS	071774MS43	H5	3	075784MS	071784MS	071784MS43
7/16"-14 NC	H3	3	075711MS	071711MS	071711MS43	H3	3	075751MS	071751MS	071751MS43
7/16"-20 NF	H3	3	075712MS	071712MS	071712MS43	H3	3	075752MS	071752MS	071752MS43
1/2"-13 NC	H5	3	075775MS	071775MS	071775MS43	H5	3	075785MS	071785MS	071785MS43
1/2"-13 NC	H4	3	075713MS	071713MS	071713MS43	H3	3	075753MS	071753MS	071753MS43
1/2"-20 NF	H3	3	075714MS	071714MS	071714MS43	H3	3	075754MS	071754MS	071754MS43
5/8"-11 NC	H5	3	075776MS	071776MS	071776MS43	H5	4	075786MS	071786MS	071786MS43
5/8"-11 NC	H4	3	075715MS	071715MS	071715MS43	H3	4	075755MS	071755MS	071755MS43
5/8"-18 NF	H3	3	075716MS	071716MS	071716MS43	H3	4	075756MS	071756MS	071756MS43
3/4"-10 NC	H5	3	075777MS	071777MS	071777MS43	H5	4	075787MS	071787MS	071787MS43
3/4"-10 NC	H4	3	075717MS	071717MS	071717MS43	H3	4	075757MS	071757MS	071757MS43
3/4"-16 NF	H4	4	075718MS	071718MS	071718MS43	H3	4	075758MS	071758MS	071758MS43
7/8"-9 NC						H6	4	075788MS	071788MS	071788MS43
1"-8 NC						H6	4	075789MS	071789MS	071789MS43
1"-12 NF						H6	4	075790MS	071790MS	071790MS43
M3 x 0.5	D3	3	075730MS	071730MS	071730MS43	D3	3	075760MS	071760MS	071760MS43
M4 x 0.7	D4	3	075731MS	071731MS	071731MS43	D4	3	075761MS	071761MS	071761MS43
M5 x 0.8	D4	3	075732MS	071732MS	071732MS43	D4	3	075762MS	071762MS	071762MS43
M6 x 1	D5	3	075733MS	071733MS	071733MS43	D5	3	075763MS	071763MS	071763MS43
M8 x 1.25	D5	3	075734MS	071734MS	071734MS43	D5	3	075764MS	071764MS	071764MS43
M10 x 1.5	D6	3	075735MS	071735MS	071735MS43	D6	3	075765MS	071765MS	071765MS43
M10 x 1.25	D5	3	075736MS	071736MS	071736MS43	D5	3	075766MS	071766MS	071766MS43
M12 x 1.75	D6	3	075737MS	071737MS	071737MS43	D6	3	075767MS	071767MS	071767MS43

# SuperTuf AL

## Taps for Aluminum with Chrome

HSS  
E

UNC

UNF

M

302A

CHROME



Designed for:  
Aluminum Alloys up  
to 10% Silicate

- Uniquely designed tap for free cutting action in all alloyed aluminum
- Exceptional edge support and consistent cutting angles insure excellent chip control
- Proprietary micro-particle steel supports the cutting edge to provide excellent tool life
- Chrome finish ensures free cutting without chips adhering to the cutting edges

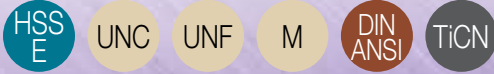


Size	Spiral Point – Plug					Spiral Flute – Modified Bottom				
	Thread Limit	# of Flutes	Chrome	Bright	TICN	Thread Limit	# of Flutes	Chrome	Bright	TICN
#2-56 NC	H2	2	076870MS	071870MS	071870MS85	H2	2	076880MS	071880MS	071880MS85
#4-40 NC	H2	2	076800MS	071800MS	071800MS85	H3	2	076840MS	071840MS	071840MS85
#6-32 NC	H3	3	076801MS	071801MS	071801MS85	H3	2	076841MS	071841MS	071841MS85
#8-32 NC	H3	3	076802MS	071802MS	071802MS85	H3	2	076842MS	071842MS	071842MS85
#10-24 NC	H3	3	076803MS	071803MS	071803MS85	H3	2	076843MS	071843MS	071843MS85
#10-32 NF	H3	3	076804MS	071804MS	071804MS85	H3	2	076844MS	071844MS	071844MS85
1/4"-20 NC	H5	3	076871MS	071871MS	071871MS85	H5	2	076881MS	071881MS	071881MS85
1/4"-20 NC	H3	3	076805MS	071805MS	071805MS85	H3	2	076845MS	071845MS	071845MS85
1/4"-28 NF	H3	3	076806MS	071806MS	071806MS85	H3	2	076846MS	071846MS	071846MS85
5/16"-18 NC	H5	3	076872MS	071872MS	071872MS85	H5	2	076882MS	071882MS	071882MS85
5/16"-18 NC	H3	3	076807MS	071807MS	071807MS85	H3	2	076847MS	071847MS	071847MS85
5/16"-24 NF	H3	3	076808MS	071808MS	071808MS85	H3	2	076848MS	071848MS	071848MS85
3/8"-16 NC	H5	3	076873MS	071873MS	071873MS85	H5	2	076883MS	071883MS	071883MS85
3/8"-16 NC	H3	3	076809MS	071809MS	071809MS85	H3	2	076849MS	071849MS	071849MS85
3/8"-24 NF	H3	3	076810MS	071810MS	071810MS85	H3	2	076850MS	071850MS	071850MS85
7/16"-14 NC	H5	3	076874MS	071874MS	071874MS85					
7/16"-14 NC	H3	3	076811MS	071811MS	071811MS85					
7/16"-20 NF	H3	3	076812MS	071812MS	071812MS85					
1/2"-13 NC	H5	3	076875MS	071875MS	071875MS85					
1/2"-13 NC	H3	3	076813MS	071813MS	071813MS85					
1/2"-20 NF	H3	3	076814MS	071814MS	071814MS85					
M3 x 0.5	D3	3	076830MS	071830MS	071830MS85	D3	2	076860MS	071860MS	071860MS85
M4 x 0.7	D4	3	076831MS	071831MS	071831MS85	D4	2	076861MS	071861MS	071861MS85
M5 x 0.8	D5	3	076832MS	071832MS	071832MS85	D5	2	076862MS	071862MS	071862MS85
M6 x 1	D5	3	076833MS	071833MS	071833MS85	D5	2	076863MS	071863MS	071863MS85
M8 x 1.25	D5	3	076834MS	071834MS	071834MS85	D5	2	076864MS	071864MS	071864MS85
M10 x 1.25	D5	3	076835MS	071835MS	071835MS85	D5	2	076865MS	071865MS	071865MS85
M12 x 1.75	D6	3	076836MS	071836MS	071836MS85	D5	2	076866MS	071866MS	071866MS85



# SuperTuf MF-DA

## Forming Taps with TiCN



Designed for:  
Aluminum and other  
non-ferrous materials

- Used in applications when forming taps and longer lengths are required
- MetFlo® form tapping eliminates chip removal problems
- Stronger threads as tapped material contours to the thread form

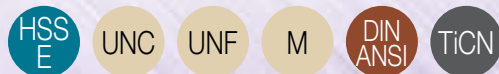


Size	Forming – Plug					Forming – Bottom				
	Thread Limit	TiCN	Bright	Steam Oxide	TiN	Thread Limit	TiCN	Bright	Steam Oxide	TiN
#4-40 NC	H5	077900MS	071900MS	071900MS43	071900MS25	H5	077941MS	071941MS	071941MS43	071941MS25
#4-40 NC	H3	077942MS	071942MS	071942MS43	071942MS25	H3	077943MS	071943MS	071943MS43	071943MS25
#6-32 NC	H5	077901MS	071901MS	071901MS43	071901MS25	H5	077945MS	071945MS	071945MS43	071945MS25
#6-32 NC	H3	077946MS	071946MS	071946MS43	071946MS25	H3	077947MS	071947MS	071947MS43	071947MS25
#8-32 NC	H5	077902MS	071902MS	071902MS43	071902MS25	H5	077949MS	071949MS	071949MS43	071949MS25
#8-32 NC	H3	077950MS	071950MS	071950MS43	071950MS25	H3	077951MS	071951MS	071951MS43	071951MS25
#10-24 NC	H6	077903MS	071903MS	071903MS43	071903MS25	H6	077952MS	071952MS	071952MS43	071952MS25
#10-24 NC	H4	077953MS	071953MS	071953MS43	071953MS25	H4	077954MS	071954MS	071954MS43	071954MS25
#10-32 NF	H6	077904MS	071904MS	071904MS43	071904MS25	H6	077955MS	071955MS	071955MS43	071955MS25
#10-32 NF	H4	077956MS	071956MS	071956MS43	071956MS25	H4	077957MS	071957MS	071957MS43	071957MS25
1/4"-20 NC	H6	077905MS	071905MS	071905MS43	071905MS25	H6	077958MS	071958MS	071958MS43	071958MS25
1/4"-20 NC	H4	077959MS	071959MS	071959MS43	071959MS25	H4	077960MS	071960MS	071960MS43	071960MS25
1/4"-28 NF	H6	077906MS	071906MS	071906MS43	071906MS25	H6	077961MS	071961MS	071961MS43	071961MS25
1/4"-28 NF	H4	077962MS	071962MS	071962MS43	071962MS25	H4	077963MS	071963MS	071963MS43	071963MS25
5/16"-18 NC	H7	077907MS	071907MS	071907MS43	071907MS25	H7	077964MS	071964MS	071964MS43	071964MS25
5/16"-18 NC	H5	077965MS	071965MS	071965MS43	071965MS25	H5	077966MS	071966MS	071966MS43	071966MS25
5/16"-24 NF	H7	077908MS	071908MS	071908MS43	071908MS25	H7	077967MS	071967MS	071967MS43	071967MS25
5/16"-24 NF	H4	077968MS	071968MS	071968MS43	071968MS25	H4	077969MS	071969MS	071969MS43	071969MS25
3/8"-16 NC	H7	077909MS	071909MS	071909MS43	071909MS25	H7	077970MS	071970MS	071970MS43	071970MS25
3/8"-16 NC	H5	077971MS	071971MS	071971MS43	071971MS25	H5	077972MS	071972MS	071972MS43	071972MS25
3/8"-24 NF	H7	077910MS	071910MS	071910MS43	071910MS25	H7	077973MS	071973MS	071973MS43	071973MS25
3/8"-24 NF	H5	077974MS	071974MS	071974MS43	071974MS25	H5	077975MS	071975MS	071975MS43	071975MS25
1/2"-13 NC	H9	077976MS	071976MS	071976MS43	071976MS25	H9	077977MS	071977MS	071977MS43	071977MS25
1/2"-13 NC	H7	077978MS	071978MS	071978MS43	071978MS25	H7	077979MS	071979MS	071979MS43	071979MS25
1/2"-20 NF	H9	077980MS	071980MS	071980MS43	071980MS25	H9	077981MS	071981MS	071981MS43	071981MS25
1/2"-20 NF	H6	077982MS	071982MS	071982MS43	071982MS25	H6	077983MS	071983MS	071983MS43	071983MS25
5/8"-11 NC	H10	077984MS	071984MS	071984MS43	071984MS25	H10	077985MS	071985MS	071985MS43	071985MS25
5/8"-11 NC	H7	077986MS	071986MS	071986MS43	071986MS25	H7	077987MS	071987MS	071987MS43	071987MS25
5/8"-18 NF	H9	077988MS	071988MS	071988MS43	071988MS25	H9	077989MS	071989MS	071989MS43	071989MS25
5/8"-18 NF	H6	077990MS	071990MS	071990MS43	071990MS25	H6	077991MS	071991MS	071991MS43	071991MS25
3/4"-10 NC	H12	077992MS	071992MS	071992MS43	071992MS25	H12	077993MS	071993MS	071993MS43	071993MS25
3/4"-10 NC	H9	077994MS	071994MS	071994MS43	071994MS25	H9	077995MS	071995MS	071995MS43	071995MS25
3/4"-16 NF	H10	077996MS	071996MS	071996MS43	071996MS25	H10	077997MS	071997MS	071997MS43	071997MS25
3/4"-16 NF	H8	077998MS	071998MS	071998MS43	071998MS25	H8	077999MS	071999MS	071999MS43	071999MS25

Continued on page 10

# SuperTuf MF-DA

## Forming Taps with TiCN



Designed for:  
Aluminum and other  
non-ferrous materials

Continued from page 9

Size	Forming – Plug					Forming – Bottom				
	Thread Limit	TiCN	Bright	Steam Oxide	TiN	Thread Limit	TiCN	Bright	Steam Oxide	TiN
M4 x 0.7	D7	077931MS	071931MS	071931MS43	071931MS25	D7	078000MS	072000MS	072000MS43	072000MS25
M4 x 0.7	D4	078001MS	072001MS	072001MS43	072001MS25	D4	078002MS	072002MS	072002MS43	072002MS25
M5 x 0.8	D8	077932MS	071932MS	071932MS43	071932MS25	D8	078003MS	072003MS	072003MS43	072003MS25
M5 x 0.8	D4	078004MS	072004MS	072004MS43	072004MS25	D4	078005MS	072005MS	072005MS43	072005MS25
M6 x 1	D9	077933MS	071933MS	071933MS43	071933MS25	D9	078006MS	072006MS	072006MS43	072006MS25
M6 x 1	D5	078007MS	072007MS	072007MS43	072007MS25	D5	078008MS	072008MS	072008MS43	072008MS25
M8 x 1.25	D10	077934MS	071934MS	071934MS43	071934MS25	D10	078009MS	072009MS	072009MS43	072009MS25
M8 x 1.25	D5	078010MS	072010MS	072010MS43	072010MS25	D5	078011MS	072011MS	072011MS43	072011MS25
M10 x 1.5	D11	077935MS	071935MS	071935MS43	071935MS25	D11	078012MS	072012MS	072012MS43	072012MS25
M10 x 1.5	D6	078013MS	072013MS	072013MS43	072013MS25	D6	078014MS	072014MS	072014MS43	072014MS25
M12 x 1.75	D12	078015MS	072015MS	072015MS43	072015MS25	D12	078016MS	072016MS	072016MS43	072016MS25
M12 x 1.75	D6	078017MS	072017MS	072017MS43	072017MS25	D6	078018MS	072018MS	072018MS43	072018MS25
M14 x 1.5	D11	078019MS	072019MS	072019MS43	072019MS25	D11	078020MS	072020MS	072020MS43	072020MS25
M14 x 1.5	D6	078021MS	072021MS	072021MS43	072021MS25	D6	078022MS	072022MS	072022MS43	072022MS25
M16 x 1.5	D11	078023MS	072023MS	072023MS43	072023MS25	D11	078024MS	072024MS	072024MS43	072024MS25
M16 x 1.5	D6	078025MS	072025MS	072025MS43	072025MS25	D6	078026MS	072026MS	072026MS43	072026MS25

## SuperTuf Tap Dimensions

Size	Overall Length 302A	Overall Length DIN ANSI	Thread Length	Neck Length	Square Length	Shank Dia.	Size of Square	Size	Overall Length 302A	Overall Length DIN ANSI	Thread Length	Neck Length	Square Length	Shank Dia.	Size of Square
#2-56 NC	1-7/8"	2-7/32"	5/16"	.25	3/16"	.141	.110	M3 x 0.5	1-15/16"	2-7/32"	5/16"	.31	3/16"	.141	.110
#4-40 NC			3/8"	.31				M4 x 0.7	2-1/8"	2-1/2"	3/8"	.38	1/4"	.168	.131
#6-32 NC	2"	2-1/2"	3/8"	.31	1/4"	.168	.131	M5 x 0.8	2-3/8"	2-3/4"	1/2"	.38	1/4"	.194	.152
#8-32 NC	2-1/8"							M6 x 1	2-1/2"	3-5/32"			5/16"	.255	.191
#10-24 NC	2-3/8"	2-3/4"	1/2"	.38	1/4"	.194	.152	M8 x 1.25	2-23/32"	3-35/64"	11/16"	.44	3/8"	.318	.238
#10-32 NF								M10 x 1.25	2-15/16"	3-15/16"	3/4"	.50	7/16"	.381	.286
1/4"-20 NC	2-1/2"	3-5/32"	5/8"	5/16"	.255	.191	M10 x 1.5	3-3/8"							
1/4"-28 NF							M12 x 1.75		3-3/8"	15/16"	-	7/16"	.367	.275	
5/16"-18 NC	2-23/32"	3-35/64"	11/16"	.44	3/8"	.318	.238	M14 x 1.5	3-19/32"	4-21/64"	1"	-	1/2"	.429	.322
5/16"-24 NF								M16 x 1.5	3-13/16"		1-3/32"	-	9/16"	.480	.380
3/8"-16 NC	2-15/16"	3-15/16"	3/4"	.50	7/16"	.381	.286								
3/8"-24 NF								7/8"	-	13/32"	.323	.242			
7/16"-14 NC	3-5/32"	4-21/64"	7/8"	-	13/32"	.323	.242								
7/16"-20 NF								15/16"	-	7/16"	.367	.275			
1/2"-13 NC	3-3/8"	4-21/64"	15/16"	-	7/16"	.367	.275								
1/2"-20 NF								1-3/32"	-	9/16"	.480	.360			
5/8"-11 NC	3-13/16"	5"	1-7/32"	-	11/16"	.590	.442								
5/8"-18 NF								4-11/16"	-	1-11/32"	-	3/4"	.697	.523	
3/4"-10 NC	4-11/16"	-	1-11/32"	-	3/4"	.697	.523								
3/4"-16 NF								5-1/8"	-	1-1/2"	-	13/16"	.800	.600	
7/8"-9 NC	5-1/8"	-	1-1/2"	-	13/16"	.800	.600								
1"-8 NC															
1"-12 NF															

# TAP RECOMMENDED SPEED TABLES

Material	Stainless Steels			Carbon Steels		
	Free Machining	Duplex	Precipitation Hardened	Low Carbon	Medium Carbon	High Carbon
	303, 304, 316	RDN 903, 2101 LDX, 2304, DX 2202	13-3, 15-5, 17-4, 440, 416, 446, A286	1010, 1018	1038, 1045	4140, 4340, 8620, 8286, 52100
SuperTuf DM		15-25 SFM	12-20 SFM			10-20 SFM
SuperTuf SS & SS-DA	25-50 SFM			25-80 SFM	20-50 SFM	
SuperTuf Ti						
SuperTuf Ni						
SuperTuf Al						
SuperTuf MF-DA	40-80 SFM		20-40 SFM	60-100 SFM	70-120 SFM	20-50 SFM

Material	Titanium Alloys						
	Ti-3Al-2.5V-0.05Pd	Ti-3Al-2.5V-0.1R	Ti-SA 1-2.5Sn	Ti-8Al 1Mo-1V	Ti-6Al 2Sm-4Zr-.1Si	Ti-6Al-4V	Ti-6Al-6V-2Sn
SuperTuf DM							
SuperTuf SS & SS-DA							
SuperTuf Ti	10-20 SFM	10-20 SFM	10-20 SFM	10-20 SFM	15-20 SFM	15-20 SFM	5-7 SFM
SuperTuf Ni							
SuperTuf Al							
SuperTuf MF-DA						20-50 SFM	

Material	Nickel Alloys														Nickel/ Iron Alloys	Tool Steel
	Corrosion/Heat Resistant					Nickel Copper Alloys				Cobalt/Nickel						
	Hastelloy B, C-276, C4C, C22, S	Haynes 120, 230	Inconel 600, 617, 625, 718, 825	R30155 (Mil Grade)	Nimonic, 75, 80	Monel 400, 500	A494	B369	AMS 5385, 5382	IN 718, 909, 100, 713	Rene 77, 220	Waspalloy	Rene 41	Invar		
SuperTuf DM															5-20 SFM	5-20 SFM
SuperTuf SS & SS-DA																
SuperTuf Ti																
SuperTuf Ni	8-15 SFM	10-15 SFM	8-15 SFM	8-15 SFM	5-20 SFM	5-20 SFM	8-15 SFM	8-15 SFM	8-15 SFM	8-15 SFM	10-15 SFM	5-20 SFM	10-15 SFM			
SuperTuf Al																

Material	Aluminum Alloys					
	Aluminum Wrought				Cast	Unalloyed
	T6063, T6061, T7075	5052, 5083, 5400, 6013	3003, 3004	2011, 2014, 2017, 2024	Sand Cast, Die Cast	1050, 1100, 1200, 1350
SuperTuf DM						
SuperTuf SS & SS-DA						
SuperTuf Ti						
SuperTuf Ni						
SuperTuf Al	30-80 SFM	40-65 SFM	40-65 SFM	40-65 SFM	40-65 SFM	30-80 SFM
SuperTuf MF-DA	50-100 SFM	80-120 SFM	80-120 SFM	80-120 SFM	80-120 SFM	50-100 SFM

	Recommended
	Suitable
	Not Recommended



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