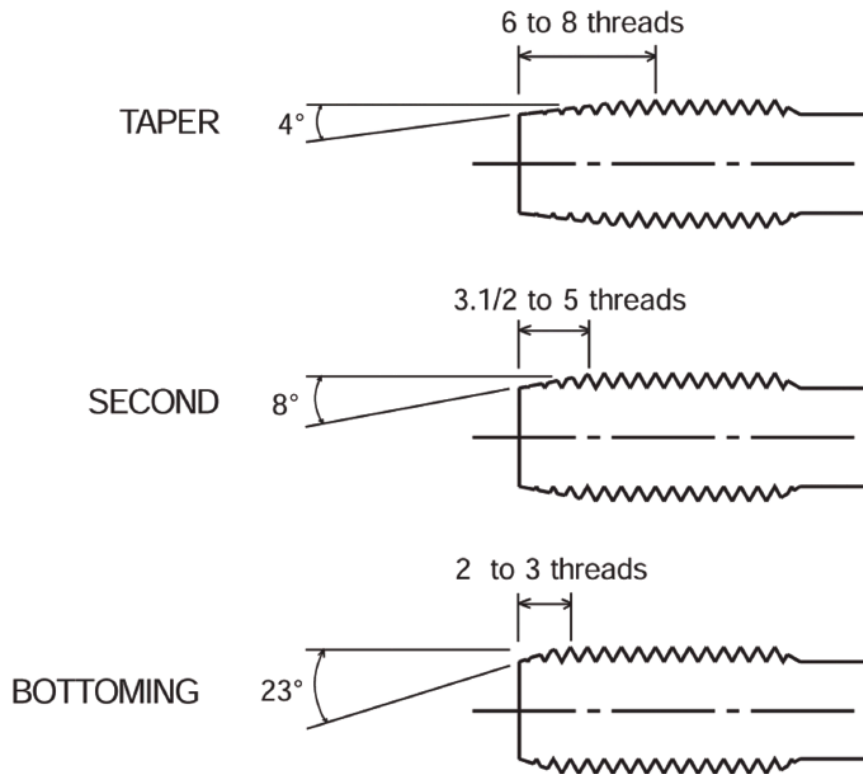


Standard Lead / Chamfer Angles



In some countries, the name "PLUG" is commonly used to indicate a Bottoming Tap. In America, it is used to indicate a second tap. To avoid confusion with American Terms, the terminology adopted by British Standard 949 1979 as shown above, should be used.

Short Hand and Machine, Long Shank Machine and Pipe Taps	4° (6-8 threads) Taper
	8° (3 1/2-5 threads) Second
	23° (2-3 threads) bottoming
Spiral Flute Taps	8° (4-50 threads)
Spiral Flute Taps	23° (2-3 threads)
Fluteless Taps	23° (2-3 threads)