

Heli-Coil® STI Tapping Facts**Cutting Taps****Inch Series**The following information is taken from **Heli-Coil's®** product catalogs

Threads Per Inch	Suggested Drill Size		Suggested Tap Limits		Internal Thread			Minor Diameter		Straight		Bottoming		Spirol		High Spiral Flute			
					Pitch Diameter Limits			After Tapping		Plug		Plug		Bottoming					
					Min	Max	Max	Min	Max	3B	2B	3B	2B	3B	2B	3B	2B		
2	56		3/32	#41	H1	H2	.0976	.0989	.0996	.0899	.0961	02CPB	02CPA	02CBB	02CBA	02CSB	02CSA	5905-02	6905-02
3	48		#36	7/64	H1	H2	.1126	.1140	.1148	.1036	.1104	03CPB	03CPA	03CBB	03CBA	03CSB	03CSA	5905-03	6906-03
		56	#37	#36	H1	H2	.1106	.1119	.1126	.1029	.1086	03FPB	03FPA	03FBB	03FBA	03FSB	03FSA	5906-03	6906-03
4	40		#31		H1	H2	.1283	.1299	.1308	.1175	.1252	04CPB	04CPA	04CBB	04CBA	04CSB	04CSA	5905-04	6905-04
		48	3MM	#31	H1	H2	.1256	.1271	.1279	.1166	.1229	04FPB	04FPA	04FBB	04FBA	04FSB	04FSA	5906-04	6906-04
5	40		3.4MM	#29	H1	H2	.1413	.1430	.1438	.1305	.1373	05CPB	05CPA	05CBB	05CBA	05CSB	05CSA	5905-05	6905-05
6	32		#26	#25	H2	H3	.1583	.1601	.1611	.1448	.1527	06CPB	06CPA	06CBB	06CBA	06CSB	06CSA	5905-06	6905-06
		40	#26	#25	H1	H2	.1543	.1560	.1569	.1435	.1503	06FPB	06FPA	06CFBB	06FBA	06FSB	06FSA	5906-06	6906-06
8	32		#17	#17	H2	H3	.1843	.1862	.1872	.1708	.1871	2CPB	2CPA	2CBB	2CBA	2CSB	2CSA	5905-2	6905-2
		36	#17	#16	H1	H2	.1821	.1840	.1849	.1701	.1771	2FPB	2FPA	2FBB	2FBA	2FSB	2FSA	5906-2	6906-2
10	24		13/64	#5	H2	H3	.2170	.2192	.2203	.1990	.2080	3CPB	3CPA	3CBB	3CBA	3CSB	3CSA	5905-3	6905-3
		32	#7	13/64	H2	H3	.2103	.2123	.2133	.1968	.2041	3FPB	3FPA	3FBB	3FBA	3FSB	3FSA	5906-3	6906-3
12	24		#1	#1	H2	H3	.2430	.2453	.2464	.2250	.2340	1CPB	1CPA	1CBB	1CBA	1CSB	1CSA	5905-1	6905-1
1/4	20		H	H	H2	H3	.2825	.2851	.2864	.2608	.2704	4CPB	4CPA	4CBB	4CBA	4CSB	4CSA	5905-4	6905-4
		28	G	6.7MM	H2	H3	.2732	.2754	.2765	.2577	.2646	4FPB	4FPA	4CFBB	4FBA	4FSB	4FSA	5906-4	6906-4
5/16	18		Q	Q	H3	H4	.3486	.3515	.3529	.3245	.3342	5CPB	5CPA	5CBB	5CBA	5CSB	5CSA	5905-5	6905-5
		24	21/64	21/64	H2	H3	.3395	.3421	.3433	.3215	.3288	5FPB	5FPA	5FBB	5FBA	5FSB	5FSA	5906-5	6906-5
3/8	16		X	X	H3	H4	.4156	.4189	.4203	.3885	.3987	6CPB	6CPA	6CBB	6CBA	6CSB	6CSA	5905-6	6905-6
		24	25/64	25/64	H2	H3	.4020	.4047	.4059	.3840	.3910	6FPB	6FPA	6FBB	6FBA	6FSB	6FSA	5906-6	6906-6
7/16	14		29/64	29/64	H3	H4	.4839	.4875	.4890	.4530	.4639	7CPB	7CPA	7CBB	7CBA	7CSB	7CSA	5905-7	6905-7
		20	29/64	29/64	H3	H4	.4700	.4731	.4744	.4483	.4561	7FPB	7FPA	7FBB	7FBA	7FSB	7FSA	5906-7	6906-7
1/2	13		33/64	17/32	H3	H4	.5499	.5537	.5554	.5166	.5273	8CPB	8CPA	8CBB	8CBA	8CSB	8CSA	5905-8	6905-8
		20	33/64	33/64	H3	H4	.5325	.5357	.5371	.5108	.5186	8FPB	8FPA	8FBB	8FBA	8FSB	8FSA	5906-8	6906-8

Heli-Coil® STI Tapping Facts

Cutting Taps

Metric Series

The following information is taken from **Heli-Coil's®** product catalogs

Thread Pitch			Suggested Drill Size		Internal Thread Minor Diameter AFTER TAPPING		Pitch Diameter			Straight Plug		Bottoming		Spirol Plug		High Spiral Flute Bottoming		Roughing Tap
Size	Coarse	Fine	Alum	Steel	Min	Max	Basic	4HMAX	5H MAX	4H5H	5H	4H5H	5H	4H5H	5H	4H5H	5H	
M2	0.4		2.1MM	2.1MM	2.087	2.199	2.260	2.295	2.310	4687-2	2087-2	4693-2	2093-2	4863-2	4763-2	5081-2	4681-2	
M2.2	0.45		2.3MM	2.35MM	2.297	2.422	2.492	2.532	2.547	4687-2.2	2087-2.2	4693-2.2	2093-2.2	4863-2.2	4763-2.2	5081-2.2	4681-2.2	
M2.5	0.45		2.55MM	2.65MM	2.597	2.722	2.792	2.832	2.847	4687-2.5	2087-2.5	4693-2.5	2093-2.5	4863-2.5	4763-2.5	5081-2.5	4681-2.5	
M3	0.5		3.15MM	3.2MM	3.108	3.243	3.325	3.367	3.384	4687-3	2087-3	4693-3	2093-3	4863-3	4763-3	5081-3	4681-3	
M3.5	0.6		3.7MM	3.7MM	3.630	3.790	3.890	3.940	3.959	4687-3.5	2087-3.5	4693-3.5	2093-3.5	4863-3.5	4763-3.5	5081-3.5	4681-3.5	
M4	0.7		4.2MM	4.25MM	4.152	4.332	4.455	4.509	4.529	4687-4	2087-4	4693-4	2093-4	4863-4	4763-4	5081-4	4681-4	
M5	0.8		5.2MM	5.3MM	5.174	5.374	5.520	5.577	5.597	4687-5	2087-5	4693-5	2093-5	4863-5	4763-5	5081-5	4681-5	
M6	1.0	40	6.25MM	6.3MM	6.217	6.407	6.650	6.719	6.742	4687-6	2087-6	4693-6	2093-6	4863-6	4763-6	5081-6	4681-6	
M7	1.0		7.25MM	7.3MM	7.217	7.407	7.650	7.719	7.742	4687-7	2087-7	4693-7	2093-7	4863-7	4763-7	5081-7	4681-7	
M8	1.25	36	8.3MM	8.4MM	8.271	8.483	8.812	8.886	83911	4687-8	2087-8	4693-8	2093-8	4863-8	4763-8	5081-8	4681-8	
		1.0	8.25MM	8.3MM	8.217	8.407	8.650	8.719	8.742	5484-8	4984-8	5486-8	4986-8	4864-8	4764-8	5066-8	4666-8	
M10	1.5		10.5MM	10.5MM	10.234	10.560	10.974	11.061	11.089	4687-10	2087-10	4693-10	2093-10	4863-10	4763-10	5081-10	4681-10	
		1.0	10.25MM	10.25MM	10.217	10.407	10.650	10.719	10.742	5484-10	4984-10	5486-10	4986-10	4864-10	4764-10	5066-10	4666-10	
M12	1.75		12.5MM	12.5MM	12.379	12.644	13.137	13.236	13.271	4687-12	2087-12	4693-12	2093-12	4863-12	4763-12	5081-12	4681-12	3765-12
		1.25	12.25MM	12.25MM	12.271	12.483	12.812	12.898	12.926	5444-12	4944-12	5445-12	4945-12	4865-12	4765-12	5067-12	4667-12	3767-12
M14	2.0		14.5MM	14.5MM	14.433	14.733	15.299	15.406	15.444	4687-14	2087-14	4693-14	2093-14					3765-14
		1.5	14.25MM	14.5MM	14.324	14.560	14.974	15.067	15.099	5476-14	4976-14	5477-14	4977-14					3768-14
M16	2.0		16.5MM	16.5MM	16.433	16.733	17.299	17.406	17.444	4687-16	2087-16	4693-16	2093-16					3765-16
		1.5	16.25MM	16.25MM	16.324	16.560	16.974	17.067	17.099	5476-16	4976-16	5477-16	4977-16					3768-16
M18	2.5		18.75MM	18.75MM	18.541	18.896	193624	19.738	19.778	4687-18	2087-18	4693-18	2093-18					3765-18
		1.5	18.25MM	18.25MM	18.324	18.560	18.974	19.067	19.099	5476-18	4976-18	5477-18	4977-18					3768-18
M18		2.0	18.5MM	18.5MM	18.433	18.733	19.299	19.406	19.444	5490-18	4990-18	5492-18	4992-18					3769-18
M20	2.5		20.75MM	20.75MM	20.541	20.896	21.624	21.738	21.778	4687-20	2087-20	4693-20	2093-20					3765-20
		1.5	20.25MM	20.5MM	20.324	20.560	20.974	21.067	21.099	5476-20	4976-20	5477-20	4977-20					3768-20
M20		2.0	20.5MM	20.5MM	20.433	20.733	21.299	21.406	21.444	5490-20	4990-20	5492-20	4992-20					3769-20