



FILTEC[®]+

Taps

APPLICATIONS

In order to receive the FILTEC⁺ thread insert, the tapping should be made with a specially designed FILTEC⁺ tap.

PRODUCT SPECIFICATIONS

- Specifically adapted for thread inserts, FILTEC⁺ tap is over dimensioned compared with a classical screw tap.
- This tap can be handled manually or adapted on a tool.



FILTEC⁺ tap can be used for the different ranges of thread inserts.

Selection of a tap

These 5 types of taps can be selected according to various criteria defined in the table below.

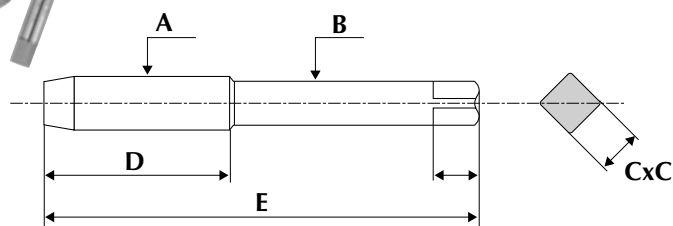
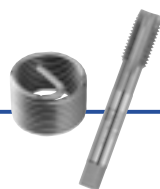
XX Optimum use

X Possible use

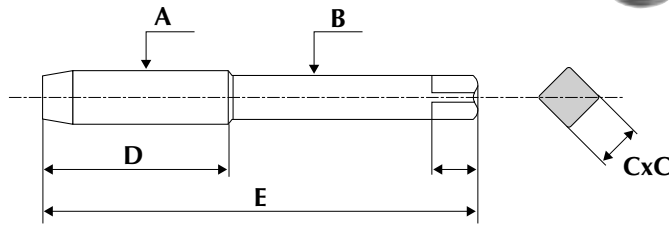
0 Not recommended

		Gun section (Code GUN) Prefix 203	Spiral gudgeon (Code GH) Prefix 204	Undersized tap (Code EB) Prefix 201	Finishing tap without run-out (Code SE) Prefix 202	Finishing tap with run-out (Code AE) Prefix 200
Usable tap						
Advantages		With its carefully designed profile, chips can be pushed out of the open ended hole. The result is a clean thread with no stuffing of chips during the operation.	Ideal for blind holes, this tap extracts chips from the hole and avoids stuffing.	It should be used before the finishing tap without run-out and particularly with hard materials and pitches >200. It can not be used alone.	It should be used after undersized tap.	This standard tap is commonly used, especially for manual tapping.
Type of hole	Open	XX	0	X	X	X
	Blind	0	XX	X	X	X
Manual tapping		XX	X	X	X	XX
Tool tapping		XX	XX	XX	XX	X
Soft material R < 80 kg		XX	XX	X	X	XX
Hard material R > 80 kg		XX	X	XX	XX	0
pitch < 200		XX	X	X	X	XX
pitch > 200		0	0	XX	XX	0

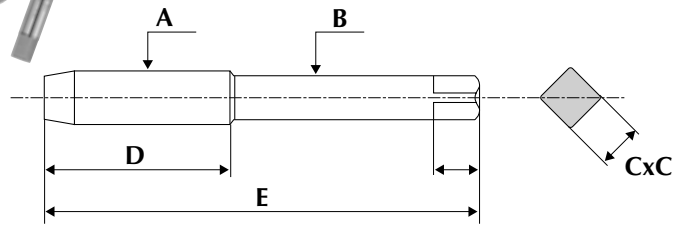




METRIC

Ø and nominal pitch	A Wall Ø in mm	B Tail Ø in mm	C x C Square dimen- sion (mm)	D Threaded length (mm)	E Total length (mm)	CODE
						200 : AE - 201 : EB 202 : SE - 203 : GUN 204 : GH
M 2 x 0,40	2,50	2,80	2,00	11	46	... 02 40 00 00
M 2,5 x 0,45	3,11	3,15	2,50	13	48	... 02 45 00 00
M 3 x 0,50	3,67	4,00	3,15	16	53	... 03 50 00 00
M 3,5 x 0,60	4,31	4,50	3,55	16	53	... 04 60 00 00
M 4 x 0,70	4,94	5,00	4,00	15	58	... 04 70 00 00
M 5 x 0,80	6,07	6,30	5,00	17	66	... 05 80 00 00
M 6 x 1,00	7,34	8,00	6,30	20	72	... 06 01 00 00
M 7 x 1,00	8,34	9,00	7,10	20	72	... 07 01 00 00
M 8 x 1,00	9,34	10,00	8,00	22	80	... 08 01 00 00
M 8 x 1,25	9,67	10,00	8,00	22	80	... 08 02 00 00
M 9 x 1,25	10,67	8,00	6,30	23	85	... 09 02 00 00
M 10 x 1,00	11,34	8,00	6,30	23	85	... 10 01 00 00
M 10 x 1,25	11,67	8,00	6,30	23	85	... 10 02 00 00
M 10 x 1,50	12,01	9,00	7,10	26	89	... 10 03 00 00
M 11 x 1,50	13,01	9,00	7,10	26	89	... 11 03 00 00
M 12 x 1,00	13,33	11,20	9,00	27	95	... 12 01 00 00
M 12 x 1,25	13,67	11,20	9,00	27	95	... 12 02 00 00
M 12 x 1,50	14,01	11,20	9,00	27	95	... 12 03 00 00
M 12 x 1,75	14,33	11,20	9,00	27	95	... 12 04 00 00
M 14 x 1,25	15,67	12,50	10,00	29	102	... 14 02 00 00
M 14 x 1,50	16,01	12,50	10,00	29	102	... 14 03 00 00
M 14 x 2,00	16,66	12,50	10,00	29	102	... 14 05 00 00
M 16 x 1,50	18,01	14,00	11,20	34	112	... 16 03 00 00
M 16 x 2,00	18,66	14,00	11,20	34	112	... 16 05 00 00
M 18 x 1,50	20,01	14,00	11,20	34	112	... 18 03 00 00
M 18 x 2,00	20,66	14,00	11,20	34	112	... 18 05 00 00
M 18 x 2,50	21,31	16,00	12,50	35	118	... 18 06 00 00
M 20 x 1,50	22,01	16,00	12,50	35	118	... 20 03 00 00
M 20 x 2,00	22,66	16,00	12,50	35	118	... 20 05 00 00
M 20 x 2,50	23,31	16,00	12,50	35	118	... 20 06 00 00
M 22 x 1,50	24,01	18,00	14,00	42	130	... 22 03 00 00
M 22 x 2,00	24,66	18,00	14,00	42	130	... 22 05 00 00
M 22 x 2,50	25,31	18,00	14,00	42	130	... 22 06 00 00
M 24 x 1,50	26,01	18,00	14,00	42	130	... 24 03 00 00
M 24 x 2,00	26,66	20,00	16,00	34	127	... 24 05 00 00
M 24 x 3,00	27,97	20,00	16,00	42	135	... 24 07 00 00
M 26 x 1,50	28,01	20,00	16,00	34	127	... 26 03 00 00
M 27 x 1,50	29,01	20,00	16,00	34	127	... 27 03 00 00
M 27 x 2,00	29,66	20,00	16,00	34	127	... 27 05 00 00
M 27 x 3,00	30,97	22,40	18,00	48	151	... 27 07 00 00
M 28 x 1,50	30,01	20,00	16,00	34	127	... 28 03 00 00
M 30 x 1,50	32,01	22,40	18,00	34	137	... 30 03 00 00
M 30 x 2,00	32,66	22,40	18,00	34	137	... 30 05 00 00
M 30 x 3,50	34,63	25,00	20,00	54	162	... 30 08 00 00
M 32 x 1,50	34,01	25,00	20,00	36	144	... 32 03 00 00
M 33 x 2,00	35,66	25,00	20,00	36	144	... 33 05 00 00
M 33 x 3,00	36,97	25,00	20,00	54	162	... 33 07 00 00
M 33 x 3,50	37,63	28,00	22,40	57	170	... 33 08 00 00
M 36 x 1,50	38,01	28,00	22,40	36	149	... 36 03 00 00
M 36 x 2,00	38,66	28,00	22,40	36	149	... 36 05 00 00
M 36 x 3,00	39,97	28,00	22,40	57	170	... 36 07 00 00
M 36 x 4,00	44,28	28,00	22,40	57	170	... 36 09 00 00
M 39 x 3,00	42,97	31,50	25,00	63	187	... 39 07 00 00
M 39 x 4,00	44,28	31,50	25,00	63	187	... 39 09 00 00
M 42 x 3,00	45,97	31,50	25,00	63	187	... 42 07 00 00
M 42 x 4,50	47,94	31,50	25,00	63	187	... 42 10 00 00


FILTEC[®]+
UNC-UNF

Ø and nominal pitch		A Wall Ø in mm	B Tail Ø in mm	C x C Square dimen- sion (mm)	D Threaded length (mm)	E Total length (mm)	CODE 220 : AE - 221 : EB 222 : SE - 223 : GUN 224 : GH
Inches	Metric conversion						
UNC							
2-56	2,18 x 0,453	2,790	2,8	2,24	9,5	44,5	... 12 10 00 00
4-40	2,84 x 0,635	3,690	4	3,15	16	53	... 15 10 00 00
5-40	3,17 x 0,635	4,025	4	3,15	16	53	... 14 10 00 00
6-32	3,51 x 0,794	4,565	5	4	15	58	... 17 10 00 00
8-32	4,17 x 0,794	5,225	5,6	4,5	16	62	... 19 10 00 00
10-24	4,83 x 1,058	6,235	6,3	5	17	66	... 21 10 00 00
1/4-20	6,35 x 1,270	8,040	8	6,3	20	72	... 23 20 00 00
5/16-18	7,94 x 1,411	9,810	10	8	22	80	... 25 20 00 00
3/8-16	9,52 x 1,588	11,635	8	6,3	23	85	... 27 30 00 00
7/16-14	11,11 x 1,814	13,520	11,2	9	27	95	... 29 30 00 00
1/2-13	12,70 x 1,954	15,295	12,5	10	29	102	... 31 40 00 00
9/16-12	14,29 x 2,117	17,095	14	11,2	34	112	... 33 40 00 00
5/8-11	15,87 x 2,309	18,935	14	11,2	34	112	... 35 40 00 00
3/4-10	19,05 x 2,540	22,415	16	12,5	35	118	... 37 50 00 00
7/8-9	22,22 x 2,822	25,960	18	14	42	130	... 39 50 00 00
1"-8	25,40 x 3,175	29,600	20	16	45	138	... 41 50 00 00
1 1/8-7	28,57 x 3,629	33,370	22,4	18	48	151	... 43 50 00 00
1 1/4-7	31,75 x 3,629	36,545	25	20	54	162	... 45 50 00 00
1 3/8-6	34,92 x 4,234	40,515	28	22,4	57	170	... 47 50 00 00
1 1/2-6	38,10 x 4,234	43,690	31,5	25	63	187	... 49 50 00 00
UNF							
6-40	3,51 x 0,635	4,355	4,5	3,55	16	53	... 16 10 00 00
8-36	4,16 x 0,705	5,110	5,6	4,5	16	62	... 18 10 00 00
10-32	4,83 x 0,794	5,885	6,3	5	17	66	... 20 10 00 00
1/4-28	6,35 x 0,907	7,560	8	6,3	20	72	... 24 20 00 00
5/16-24	7,94 x 1,058	9,350	10	8	22	80	... 26 20 00 00
3/8-24	9,52 x 1,058	10,940	8	6,3	23	85	... 28 30 00 00
7/16-20	11,11 x 1,270	12,805	9	7,1	26	89	... 30 30 00 00
1/2-20	12,70 x 1,270	14,395	11,2	9	27	95	... 32 40 00 00
9/16-18	14,29 x 1,411	16,170	12,5	10	29	102	... 34 40 00 00
5/8-18	15,88 x 1,411	17,700	14	11,2	34	112	... 36 40 00 00
3/4-16	19,05 x 1,588	21,170	16	12,5	35	118	... 38 50 00 00
7/8-14	22,22 x 1,814	24,640	18	14	42	180	... 40 50 00 00
1"-14	25,40 x 1,814	27,820	20	16	34	127	... 52 50 00 00
1"-12	25,40 x 2,117	28,215	20	16	34	127	... 42 50 00 00
1 1/8-12	28,57 x 2,117	31,935	22,4	18	34	137	... 44 50 00 00
1 1/4-12	31,75 x 2,117	34,570	25	20	36	144	... 46 50 00 00
1 3/8-12	34,92 x 2,117	37,700	28	22,4	36	149	... 48 50 00 00
1 1/2-12	38,10 x 2,117	40,925	28	22,4	36	149	... 50 50 00 00


FILTEC®+
**BSP
BSW-BSF**


Ø and nominal pitch		A Wall Ø in mm	B Tail Ø in mm	C x C Square dimen- sion (mm)	D Threaded length (mm)	E Total length (mm)	CODE 230 : AE - 231 : EB 232 : SE
Inches	Metric conversion						
BSP							
1/8-28	9,728 x 0,907	10,309	8	6,3	15	59	... 120 100 00
1/4-19	13,157 x 1,337	14,013	10	8	19	67	... 140 150 00
3/8-19	16,662 x 1,337	17,518	12,5	10	21	75	... 140 200 00
1/2-14	20,955 x 1,814	22,117	16	12,5	26	87	... 150 250 00
5/8-14	22,911 x 1,814	24,073	18	14	26	91	... 150 300 00
3/4-14	26,441 x 1,814	27,603	20	16	28	96	... 150 350 00
7/8-14	30,201 x 1,814	31,363	22,4	18	29	102	... 150 400 00
1"-11	33,249 x 2,309	34,728	25	20	33	109	... 150 450 00
BSW							
1/4-20	6,350 x 1,270	7,163	8	6,3	20	72	... 220 100 00
5/16-18	7,938 x 1,411	8,839	10	8	22	80	... 220 150 00
3/8-16	9,525 x 1,588	10,541	8	6,3	23	85	... 230 200 00
7/16-14	11,113 x 1,814	12,276	11,2	9	27	95	... 230 250 00
1/2-12	12,700 x 2,117	14,054	12,5	10	29	102	... 240 300 00
9/16-12	14,290 x 2,117	15,641	12,5	10	29	102	... 240 350 00
5/8-11	15,876 x 2,309	17,353	14	11,2	34	112	... 240 400 00
3/4-10	19,051 x 2,540	20,678	16	12,5	35	118	... 250 450 00
7/8-9	22,226 x 2,822	24,033	18	14	42	130	... 250 500 00
1"-8	25,400 x 3,175	27,435	20	16	45	138	... 250 550 00
BSF							
1/4-26	6,350 x 0,977	6,975	8	6,3	20	72	... 320 100 00
5/16-22	7,938 x 1,156	8,676	10	8	22	80	... 320 150 00
3/8-20	9,525 x 1,270	10,337	8	6,3	23	85	... 330 200 00
7/16-18	11,113 x 1,411	12,015	9	7,1	26	89	... 330 250 00
1/2-16	12,700 x 1,588	13,716	11,2	9	27	95	... 340 300 00
9/16-16	14,288 x 1,588	15,303	12,5	10	29	102	... 340 350 00
5/8-14	15,875 x 1,814	17,036	14	11,2	34	112	... 340 400 00
3/4-12	19,050 x 2,117	20,404	16	12,5	35	118	... 350 450 00
7/8-11	22,225 x 2,309	23,702	18	14	42	130	... 350 500 00
1"-10	25,400 x 2,540	27,025	20	16	45	138	... 350 550 00