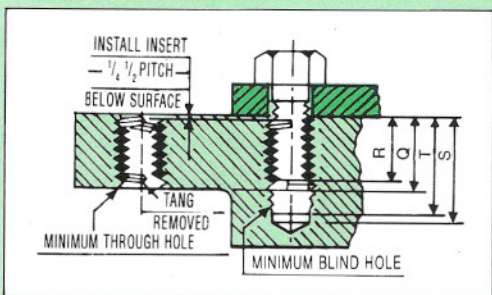


FORMULAE FOR CALCULATING MINIMUM DRILLING & TAPPING DEPTHS.

P = PITCH in MM.
 Q = Minimum full form tapped thread length. Values for Q are the same as the values listed in columns 4 to 10.
 R = Entering portion of Screw (max.) if tang is not removed = Q - 1P.
 S = Drill Depth (min.) excluding point.
 = Q + 4½ P (if finishing taps are used).
 or S = Q + 2½ P (if bottoming taps are used)
 T = Tap Depth (min.)
 = Q + 3½ P (if finishing taps are used)
 or T = Q + 1½ P (if bottoming taps are used).
 Depths of counterbores or countersinks, if any, must be added to values for Q, R, S & T.



HOW TO ORDER-INSERT - Select Part No. from Cols 2 or 3 & add basic length of insert taken from Cols. 4 to 10 **Example SL-C16CN x 24** represents an M16x2 Screw-lock insert of 24 mm basic length.

TOOLS - Simply state part Nos. of Tools from columns below.

TAPS			GAUGES	TOOLS			NOMINAL THREAD SIZE		SCREW THREAD SERIES
17	18	19	20	21	22	23	DIA. MM.	PITCH MM.	
ROUGHING TAP	FINISHING PLUG TAP	FINISHING BOTTOMING TAP	FASTMAN GAUGE	PREWINDER TYPE INSERTING TOOL	TANG BREAK OFF TOOL	EXTRACTING TOOL			METRIC COARSE SERIES
MC2 R	MC2 P	MC2 B	MC2-GN	MC2-IM	MC2-TB	1227-06	M2	0.4	
MC2.2 R	MC2.2 P	MC2.2 B	MC2.2-GN	MC2.2-IM	MC2.2-TB	1227-06	M2.2	0.45	
MC2.5 R	MC2.5 P	MC2.5 B	MC2.5-GN	MC2.5-IM	MC2.5-TB	1227-06	M2.5	0.45	
MC3 R	MC3 P	MC3 B	MC3-GN	MC3-IP	MC3-TB	1227-06	M3	0.5	
MC4 R	MC4 P	MC4 B	MC4-GN	MC4-IP	MC4-TB	1227-06	M4	0.7	
MC5 R	MC5 P	MC5 B	MC5-GN	MC5-IP	MC5-TB	1227-6	M5	0.8	
MC6 R	MC6 P	MC6 B	MC6-GN	MC6-IP	MC6-TB	1227-6	M6	1	
MC7 R	MC7 P	MC7 B	MC7-GN	MC7-IP	MC7-TB	1227-6	M7	1	
MC8 R	MC8 P	MC8 B	MC8-GN	MC8-IP	MC8-TB	1227-6	M8	1.25	
MC10 R	MC10 P	MC10 B	MC10-GN	MC10-IP	MC10-TB	1227-6	M10	1.5	
MC12 R	MC12 P	MC12 B	MC12-GN	MC12-IP	MC12-TB	1227-16	M12	1.75	
MC14 R	MC14 P	MC14 B	MC14-GN	MC14-IP	MC14-TB	1227-16	M14	2	
MC16 R	MC16 P	MC16 B	MC16-GN	MC16-IP	MC16-TB	1227-16	M16	2	
MC18 R	MC18 P	MC18 B	MC18-GN	MC18-IP	MC18-TB	1227-16	M18	2.5	
MC20 R	MC20 P	MC20 B	MC20-GN	MC20-IP	MC20-TB	1227-16	M20	2.5	
MC22 R	MC22 P	MC22 B	MC22-GN	MC22-IP	MC22-TB	1227-16	M22	2.5	
MC24 R	MC24 P	MC24 B	MC24-GN	MC24-IP	MC24-TB	1227-16	M24	3	
MC27 R	MC27 P	MC27 B	MC27-GN	MC27-IP	USE LONG-NOSED PLIERS	1227-24	M27	3	
MC30 R	MC30 P	MC30 B	MC30-GN	MC30-IP		1227-24	M30	3.5	
MC33 R	MC33 P	MC33 B	MC33-GN	MC33-IP		1227-24	M33	3.5	
MC36 R	MC36 P	MC36 B	MC36-GN	MC36-IP		1227-24	M36	4	
MC39 R	MC39 P	MC39 B	MC39-GN	MC39-IP		1227-24	M39	4	
MF8 R	MF8 P	MF8 B	MF8-GN	MF8-IP	MF8-TB	1227-6	M8	1	METRIC FINE SERIES
MF10 R	MF10 P	MF10 B	MF10-GN	MF10-IP	MF10-TB	1227-6	M10	1.25	
MF12 R	MF12 P	MF12 B	MF12-GN	MF12-IP	MF12-TB	1227-16	M12	1.25	
MF14 R	MF14 P	MF14 B	MF14-GN	MF14-IP	MF14-TB	1227-16	M14	1.5	
MF16 R	MF16 P	MF16 B	MF16-GN	MF16-IP	MF16-TB	1227-16	M16	1.5	
MF18 R	MF18 P	MF18 B	MF18-GN	MF18-IP	MF18-TB	1227-16	M18	1.5	
MF20 R	MF20 P	MF20 B	MF20-GN	MF20-IP	MF20-TB	1227-16	M20	1.5	
MF22 R	MF22 P	MF22 B	MF22-GN	MF22-IP	MF22-TB	1227-16	M22	1.5	
MF24 R	MF24 P	MF24 B	MF24-GN	MF24-IP	MF24-TB	1227-16	M24	2	
MF27 R	MF27 P	MF27 B	MF27-GN	MF27-IP	USE LONG-NOSED PLIERS	1227-24	M27	2	
MF30 R	MF30 P	MF30 B	MF30-GN	MF30-IP		1227-24	M30	2	
MF33 R	MF33 P	MF33 B	MF33-GN	MF33-IP		1227-24	M33	2	
MF36 R	MF36 P	MF36 B	MF36-GN	MF36-IP		1227-24	M36	3	
MF39 R	MF39 P	MF39 B	MF39-GN	MF39-IP		1227-24	M39	3	
SP14 R	SP14 P	SP14 B	SP14-GN	SP14-IP	USE PLIERS	1227-16	M 14	1.25	SPARK PLUG SERIES
SP18 R	SP18 P	SP18 B	SP18-GN	SP18-IP	DO	1227-16	M 18	1.5	

NOTES

DRILLS - Tapping drills listed in col.16 are suitable for Aluminium. For Steel, Magnesium and Plastics, the alternative larger size drills (col.16A) should be used.

TAPS - Finishing Taps (cols.18 & 19) will ordinarily produce both Normal 5H & Fine 4H5H fits.

GAUGES - Thread Plug Gauges (col.20) are for Normal 5H fit. These are used to check **FASTMAN** tapped holes before installation of the insert.

INSERTING TOOLS - Prewinder Type (col.20) recommended for all sizes of Inserts.

SPARK PLUG - Inserts listed are suitable for 14 mm spark plugs according to Indian Standard Specification No IS : 1063 - 1963.

* INSERTING TOOLS are of Mandrel type for sizes M2, M2.2 and M2.5.