

Shear TapTM

MADE IN
AMERICA

HIGH PRODUCTION TAPS

- OPTIMIZED FOR STEEL AND STAINLESS STEEL UP TO 35 Rc ■
- 400% HIGHER PERFORMANCE OVER STANDARD TAPS ■
- LOWER COST PER TAPPED HOLE ■
- CON-ECCENTRIC RELIEF FOR FREER CUTTING ACTION ■
- CONTROLLED TAP LENGTH FOR CNC APPLICATIONS ■
- REDUCED NECK FOR ENHANCED COOLANT FLOW AND CHIP EVACUATION ■
- SPIRAL POINT FOR THROUGH HOLES ■
- SPIRAL FLUTE FOR BLIND HOLES ■
- ISO 9002 REGISTERED ■



U.S.A. VERSION

High Production Spiral Point SHEARTAP™

Primarily designed for tapping through holes. The spiral point forces the chips ahead of the tap.

Premium High Speed Steel Plug Style

New and completely reengineered for improved performance – the **NEW "ShearTap"** offers exceptional value for high volume production tapping in carbon steels, high tensile steels and stainless steels up to 35 Rc hardness.

Black Oxide Over Nitride resists chip welding, increases lubricity and helps to retain cutting fluid. **TiN Coating** increases hardness and lubricity for improved thread quality, higher speeds and longer tool life.



List No. 2090 — Black Oxide Over Nitride

List No. 2090G — TiN Coated

STANDARD Machine Screw Sizes — 12 each

PACKAGE Fractional Sizes 1/4" thru 1/2" — 12 each
9/16" thru 3/4" — 3 each
7/8" thru 2" — 1 each

ShearTap Cutting Speeds: Page 113

SIZE	THREAD TYPE	# OF FLUTES	THREAD LENGTH	NECK LENGTH	OAL	SURFACE TREATED					LIST	TIN COATED				
						H2	H3	H4	H5	H2		H3	H4	H5	LIST	
#4-40	NC	2	.313	.250	1 7/8	34400	34401	—	34402	\$13.71	94400	94401	—	94402	\$15.52	
#6-32	NC	2	.375	.313	2	34404	34405	—	34406	11.52	94404	94405	—	94406	14.07	
#8-32	NC	3	.375	.375	2 1/8	34407	34408	—	34409	11.62	94407	94408	—	94409	16.18	
#10-24	NC	3	.500	.375	2 3/8	—	34410	—	—	11.62	—	94410	—	—	16.18	
#10-32	NF	3	.500	.375	2 3/8	34411	34412	—	34413	11.62	94411	94412	—	94413	16.18	
1/4-20	NC	3	.625	.375	2 1/2	34416	34417	—	34418	12.81	94416	94417	—	94418	17.28	
1/4-28	NF	3	.625	.375	2 1/2	34419	34420	34421	—	12.81	94419	94420	94421	—	17.28	
5/16-18	NC	3	.688	.438	2 23/32	—	34422	—	34423	14.10	—	94422	—	94423	21.63	
5/16-24	NF	3	.688	.438	2 23/32	—	34424	34425	—	14.10	—	94424	94425	—	21.63	
3/8-16	NC	3	.750	.500	2 15/16	—	34426	—	34427	15.91	—	94426	—	94427	23.30	
3/8-24	NF	3	.750	.500	2 15/16	—	34428	34429	—	15.91	—	94428	94429	—	23.30	
7/16-14	NC	3	.875	.563	3 5/32	—	34430	—	34431	20.33	—	94430	—	94431	27.38	
7/16-20	NF	3	.875	.563	3 5/32	—	34432	—	34433	20.33	—	94432	—	94433	27.38	
1/2-13	NC	3	.938	.719	3 3/8	—	34434	—	34435	23.48	—	94434	—	94435	30.29	
1/2-20	NF	3	.938	.719	3 3/8	—	34436	—	34437	23.48	—	94436	—	94437	30.29	
9/16-12	NC	4	1.000	.673	3 19/32	—	34438	—	—	37.95	—	94438	—	—	51.21	
9/16-18	NF	4	1.000	.673	3 19/32	—	34439	—	—	37.95	—	94439	—	—	51.21	
5/8-11	NC	4	1.125	.673	3 13/16	—	34440	—	—	42.19	—	94440	—	—	55.12	
5/8-18	NF	4	1.125	.673	3 13/16	—	34441	—	—	42.19	—	94441	—	—	55.12	
3/4-10	NC	4	1.219	.766	4 1/4	—	34444	—	—	60.52	—	94444	—	—	74.33	
3/4-16	NF	4	1.219	.766	4 1/4	—	34445	—	—	60.52	—	94445	—	—	74.33	
7/8-9	NC	4	1.344	.875	4 11/16	—	—	34500	—	89.67	—	—	94500	—	111.65	
7/8-14	NF	4	1.344	.875	4 11/16	—	—	34501	—	89.67	—	—	94501	—	111.65	
1-8	NC	4	1.500	1.000	5 1/8	—	—	34502	—	117.58	—	—	94502	—	146.90	
1-12	NF	4	1.500	1.000	5 1/8	—	—	34503	—	117.58	—	—	94503	—	146.90	
1 1/8-7	NC	4	1.719	.843	5 7/16	—	—	34504	—	182.42	—	—	94504	—	215.38	
1 1/8-12	NF	4	1.719	.843	5 7/16	—	—	34505	—	182.42	—	—	94505	—	215.38	
1 1/4-7	NC	4	1.719	.843	5 3/4	—	—	34506	—	195.51	—	—	94506	—	244.30	
1 1/4-12	NF	4	1.719	.843	5 3/4	—	—	34507	—	195.51	—	—	94507	—	244.30	
1 3/8-6	NC	4	2.000	1.000	6 1/16	—	—	34508	—	305.93	—	—	94508	—	371.87	
1 3/8-12	NF	4	2.000	1.000	6 1/16	—	—	34509	—	305.93	—	—	94509	—	371.87	
1 1/2-6	NC	6	2.000	1.000	6 3/8	—	—	34510	—	358.42	—	—	94510	—	424.35	
1 1/2-12	NF	6	2.000	1.000	6 3/8	—	—	34511	—	358.42	—	—	94511	—	424.35	
1 3/4-5*	NC	6	2.406	.782	7	—	—	—	34512*	485.49	—	—	—	94512*	606.80	
2-4 1/2*	NC	6	2.688	.874	7 5/8	—	—	—	34514*	774.29	—	—	—	94514*	939.12	

*H7 Thread Limit

Metric Sizes: Page 112

High Production Spiral Flute SHEARTAP™

Primarily designed for tapping blind holes. The spiral flutes draws the chips out of the hole.



Premium High Speed Steel – 48° Helix Angle
Modified Bottoming Style

New and completely reengineered for improved performance – the **NEW “ShearTap”** offers exceptional value for high volume production tapping in carbon steels, high tensile steels and stainless steels up to 35 Rc Hardness

Black Oxide Over Nitride resists chip welding, increases lubricity and helps to retain cutting fluid. **TiN Coating** increases hardness and lubricity for improved thread quality, higher speeds and longer tool life.

List No. 2091 — Black Oxide Over Nitride

List No. 2091G — TiN Coated

STANDARD PACKAGE Machine Screw Sizes — 12 each
Fractional Sizes 1/4" thru 1/2" — 12 each
9/16" thru 3/4" — 3 each
7/8" thru 2" — 1 each

ShearTap Cutting Speeds: Page 113

SIZE	THREAD TYPE	# OF FLUTES	THREAD LENGTH	NECK LENGTH	OAL	SURFACE TREATED					LIST	TiN COATED				
						H2	H3	H4	H5	H2		H3	H4	H5	LIST	
#4-40	NC	3	.236	.327	1 7/8	34450	34451	—	—	\$22.86	94450	94451	—	—	\$23.96	
#6-32	NC	3	.236	.452	2	34453	34454	—	34455	17.48	94453	94454	—	94455	19.56	
#8-32	NC	3	.236	.514	2 1/8	34456	34457	—	34458	17.48	94456	94457	—	94458	21.58	
#10-24	NC	3	.354	.521	2 3/8	34459	34460	—	—	17.48	94459	94460	—	—	21.58	
#10-32	NF	3	.354	.521	2 3/8	34461	34462	—	34463	17.48	94461	94462	—	94463	21.58	
1/4-20	NC	3	.433	.567	2 1/2	—	34466	—	34467	19.38	—	94466	—	94467	23.34	
1/4-28	NF	3	.433	.567	2 1/2	—	34468	34469	—	19.38	—	94468	94469	—	23.34	
5/16-18	NC	3	.472	.653	2 23/32	—	34470	—	34471	21.76	—	94470	—	94471	28.70	
5/16-24	NF	3	.472	.653	2 23/32	—	34472	34473	—	21.76	—	94472	94473	—	28.70	
3/8-16	NC	3	.551	.699	2 15/16	—	34474	—	34475	23.90	—	94474	—	94475	30.68	
3/8-24	NF	3	.551	.699	2 15/16	—	34476	34477	—	23.90	—	94476	94477	—	30.68	
7/16-14	NC	3	.591	.847	3 5/32	—	34478	—	34479	30.91	—	94478	—	94479	37.14	
7/16-20	NF	3	.591	.847	3 5/32	—	34480	—	34481	30.91	—	94480	—	94481	37.14	
1/2-13	NC	3	.630	1.026	3 3/8	—	34482	—	34483	35.81	—	94482	—	94483	41.67	
1/2-20	NF	3	.630	1.026	3 3/8	—	34484	—	34485	35.81	—	94484	—	94485	41.67	
9/16-12	NC	3	.690	.983	3 19/32	—	34486	—	—	55.10	—	94486	—	—	67.03	
9/16-18	NF	3	.690	.983	3 19/32	—	34487	—	—	55.10	—	94487	—	—	67.03	
5/8-11	NC	3	.745	1.052	3 1/16	—	34488	—	—	64.57	—	94488	—	—	75.78	
5/8-18	NF	3	.745	1.052	3 1/16	—	34489	—	—	64.57	—	94489	—	—	75.78	
3/4-10	NC	4	.820	1.165	4 1/4	—	34492	—	—	80.43	—	94492	—	—	92.70	
3/4-16	NF	4	.820	1.165	4 1/4	—	34493	—	—	80.43	—	94493	—	—	92.70	
7/8-9	NC	4	.911	1.308	4 1/16	—	—	34520	—	116.92	—	—	94520	—	138.90	
7/8-14	NF	4	.911	1.308	4 1/16	—	—	34521	—	116.92	—	—	94521	—	138.90	
1-8	NC	4	1.025	1.475	5 1/8	—	—	34522	—	152.31	—	—	94522	—	185.27	
1-12	NF	4	1.025	1.475	5 1/8	—	—	34523	—	152.31	—	—	94523	—	185.27	
1 1/8-7	NC	4	1.143	1.419	5 7/16	—	—	34524	—	238.02	—	—	94524	—	270.99	
1 1/8-12	NF	4	1.143	1.419	5 7/16	—	—	34525	—	238.02	—	—	94525	—	270.99	
1 1/4-7	NC	4	1.143	1.419	5 3/4	—	—	34526	—	286.45	—	—	94526	—	347.67	
1 1/4-12	NF	4	1.143	1.419	5 3/4	—	—	34527	—	286.45	—	—	94527	—	347.67	
1 3/8-6	NC	4	1.333	1.667	6 1/16	—	—	34528	—	373.41	—	—	94528	—	439.34	
1 3/8-12	NF	4	1.333	1.667	6 1/16	—	—	34529	—	373.41	—	—	94529	—	439.34	
1 1/2-6	NC	4	1.333	1.667	6 3/8	—	—	34530	—	440.88	—	—	94530	—	503.91	
1 1/2-12	NF	4	1.333	1.667	6 3/8	—	—	34531	—	440.88	—	—	94531	—	503.91	
1 3/4-5*	NC	6	1.600	1.588	7	—	—	—	34532*	654.07	—	—	—	94532*	777.14	
2-4 1/2*	NC	6	1.777	1.588	7 5/8	—	—	—	34533*	1029.01	—	—	—	94534*	1193.85	

*H7 Thread Limit

Metric Sizes: Page 112

Metric Spiral Point SHEARTAP™

List No. 2090M — Black Oxide Over Nitride

List No. 2090G — TiN Coated

SIZE	PITCH	PITCH DIA. LIMIT	# OF FLUTES	THREAD LENGTH	NECK LENGTH	OAL	SURFACE TREATED		TiN COATED	
							EDP NO.	LIST	EDP NO.	LIST
M3	0.5	D3	2	.313	.313	1 ¹⁵ / ₁₆	35240	\$13.87	95240	\$15.81
M3.5	0.6	D4	2	.375	.313	2	35241	13.25	95241	15.86
M4	0.7	D4	3	.375	.375	2 ¹ / ₈	35242	12.62	95242	17.48
M5	0.8	D4	3	.500	.375	2 ³ / ₈	35243	13.35	95243	18.14
M6	1	D5	3	.625	.375	2 ¹ / ₂	35244	13.97	95244	18.71
M7	1	D5	3	.688	.438	2 ²³ / ₃₂	35245	14.70	95245	22.81
M8	1	D5	3	.688	.438	2 ²³ / ₃₂	35246	15.38	95246	23.43
M8	1.25	D5	3	.688	.438	2 ²³ / ₃₂	35247	15.38	95247	23.43
M10	1.25	D5	3	.750	.500	2 ¹⁵ / ₁₆	35248	19.84	95248	27.52
M10	1.5	D6	3	.750	.500	2 ¹⁵ / ₁₆	35249	19.84	95249	27.52
M12	1.25	D5	3	.938	.719	3 ³ / ₈	35250	25.56	95250	32.76
M12	1.75	D6	3	.938	.719	3 ³ / ₈	35251	25.56	95251	32.76
M14	1.5	D6	4	1.000	.673	3 ¹⁹ / ₃₂	35252	42.13	95252	56.14
M14	2	D7	4	1.000	.673	3 ¹⁹ / ₃₂	35253	42.13	95253	56.14
M16	1.5	D6	4	1.125	.673	3 ¹³ / ₁₆	35254	46.29	95254	59.95
M16	2	D7	4	1.125	.673	3 ¹³ / ₁₆	35255	46.29	95255	59.95
M18	1.5	D6	4	1.125	.719	4 ¹ / ₃₂	35256	56.13	95256	69.27
M18	2.5	D7	4	1.125	.719	4 ¹ / ₃₂	35257	56.13	95257	69.27
M20	1.5	D6	4	1.188	.812	4 ¹⁵ / ₃₂	35280	94.51	95280	118.10
M20	2.5	D7	4	1.188	.812	4 ¹⁵ / ₃₂	35281	94.51	95281	118.10
M22	1.5	D6	4	1.188	1.031	4 ¹¹ / ₁₆	35282	130.64	95282	163.30
M22	2.5	D7	4	1.188	1.031	4 ¹¹ / ₁₆	35283	130.64	95283	163.30
M24	2	D7	4	1.422	.797	4 ²⁹ / ₃₂	35284	137.54	95284	170.51
M24	3	D8	4	1.422	.797	4 ²⁹ / ₃₂	35285	137.54	95285	170.51



STANDARD PACKAGE

M3-M12 – 12 each
M14-M18 – 3 each
M20-M24 – 1 each

**ShearTap Cutting
Speeds:
Page 113**

Metric Spiral Flute SHEARTAP™

List No. 2091M — Black Oxide Over Nitride

List No. 2091G — TiN Coated

SIZE	PITCH	PITCH DIA. LIMIT	# OF FLUTES	THREAD LENGTH	NECK LENGTH	OAL	SURFACE TREATED		TiN COATED	
							EDP NO.	LIST	EDP NO.	LIST
M3	0.5	D3	3	.236	.389	1 ¹⁵ / ₁₆	35258	\$21.09	95258	\$22.43
M3.5	0.6	D4	3	.236	.452	2	35259	20.10	95259	22.14
M4	0.7	D4	3	.236	.514	2 ¹ / ₈	35260	19.07	95260	23.38
M5	0.8	D4	3	.354	.521	2 ³ / ₈	35261	20.42	95261	24.62
M6	1	D5	3	.433	.567	2 ¹ / ₂	35262	21.09	95262	25.24
M7	1	D5	3	.472	.653	2 ²³ / ₃₂	35263	22.39	95263	29.86
M8	1	D5	3	.472	.653	2 ²³ / ₃₂	35264	23.69	95264	31.05
M8	1.25	D5	3	.472	.653	2 ²³ / ₃₂	35265	23.69	95265	31.05
M10	1.25	D5	3	.551	.699	2 ¹⁵ / ₁₆	35266	28.10	95266	35.10
M10	1.5	D6	3	.551	.699	2 ¹⁵ / ₁₆	35267	28.10	95267	35.10
M12	1.25	D5	3	.630	1.026	3 ³ / ₈	35268	39.07	95268	45.14
M12	1.75	D6	3	.630	1.026	3 ³ / ₈	35269	39.07	95269	45.14
M14	1.5	D6	3	.690	.983	3 ¹⁹ / ₃₂	35270	60.68	95270	73.14
M14	2	D7	3	.690	.983	3 ¹⁹ / ₃₂	35271	60.68	95271	73.14
M16	1.5	D6	3	.745	1.052	3 ¹³ / ₁₆	35272	70.75	95272	82.38
M16	2	D7	3	.745	1.052	3 ¹³ / ₁₆	35273	70.75	95273	82.38
M18	1.5	D6	4	.813	.983	4 ¹ / ₃₂	35274	87.90	95274	100.57
M18	2.5	D7	4	.813	.983	4 ¹ / ₃₂	35275	87.90	95275	100.57
M20	1.5	D6	4	.790	1.210	4 ¹⁵ / ₃₂	35290	126.59	95290	158.20
M20	2.5	D7	4	.790	1.210	4 ¹⁵ / ₃₂	35291	126.59	95291	158.20
M22	1.5	D6	4	.790	1.428	4 ¹¹ / ₁₆	35292	154.62	95292	186.13
M22	2.5	D7	4	.790	1.428	4 ¹¹ / ₁₆	35293	154.62	95293	186.13
M24	2	D7	4	.940	1.279	4 ²⁹ / ₃₂	35294	166.86	95294	195.43
M24	3	D8	4	.940	1.279	4 ²⁹ / ₃₂	35295	166.86	95295	195.43



STANDARD PACKAGE

M3-M12 – 12 each
M14-M18 – 3 each
M20-M24 – 1 each

Pitch diameters are those recommended for 6H class of thread.