

**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