









THREAD INSERTS

	DRILLS		TAPS			GAUGES	TOOLS		
NOMINAL THREAD SIZE									
1	16	16A	17	18	19	20	21	22	23

METRIC COARSE SERIES	Dia x pitch mm	Recommended Size	Alternative Size	Roughing Tap	Finishing Plug Tap	Finishing Bottoming Tap	Gauge	Inserting Tool	Tang Break Off Tool	Extracting Tool
	M2 x 0.4	2.1	2.15	MC2 R	MC2 P	MC2 B	MC2-GN	MC3-IP	MC2-TB	1227-06
	M2.2 x 0.45	2.3	2.35	MC2.2 R	MC2.2 P	MC2.2 B	MC2.2-GN	MC3-IP	MC2.2-TB	1227-06
	M2.5 x 0.45	2.6	2.65	MC2.5 R	MC2.5 P	MC2.5 B	MC2.5-GN	MC3-IP	MC2.5-TB	1227-06
	M3 x 0.5	3.1	3.2	MC3 R	MC3 P	MC3 B	MC3-GN	MC3-IP	MC3-TB	1227-06
	M4 x 0.7	4.1	4.2	MC4 R	MC4 P	MC4 B	MC4-GN	MC4-IP	MC4-TB	1227-06
	M5 x 0.8	5.1	5.2	MC5 R	MC5 P	MC5 B	MC5-GN	MC5-IP	MC5-TB	1227-6
	M6 x 1	6.2	6.3	MC6 R	MC6 P	MC6 B	MC6-GN	MC6-IP	MC6-TB	1227-6
	M7 x 1	7.2	7.3	MC7 R	MC7 P	MC7 B	MC7-GN	MC7-IP	MC7-TB	1227-6
	M8 x 1.25	8.2	8.3	MC8 R	MC8 P	MC8 B	MC8-GN	MC8-IP	MC8-TB	1227-6
	M10 x 1.5	10.2	10.3	MC10 R	MC10 P	MC10 B	MC10-GN	MC10-IP	MC10-TB	1227-6
	M12 x 1.75	12.25	31/64"	MC12 R	MC12 P	MC12 B	MC12-GN	MC12-IP	MC12-TB	1227-16
	M14 x 2	14.25	14.5	MC14 R	MC14 P	MC14 B	MC14-GN	MC14-IP	MC14-TB	1227-16
	M16 x 2	16.25	16.5	MC16 R	MC16 P	MC16 B	MC16-GN	MC16-IP	MC16-TB	1227-16
	M18 x 2.5	18.5	18.75	MC18 R	MC18 P	MC18 B	MC18-GN	MC18-IP	MC18-TB	1227-16
	M20 x 2.5	20.5	20.75	MC20 R	MC20 P	MC20 B	MC20-GN	MC20-IP	MC20-TB	1227-16
M22 x 2.5	22.5	22.75	MC22 R	MC22 P	MC22 B	MC22-GN	MC22-IP	MC22-TB	1227-16	
M24 x 3	24.5	24.75	MC24 R	MC24 P	MC24 B	MC24-GN	MC24-IP	MC24-TB	1227-16	
M27 x 3	27.5	27.75	MC27 R	MC27 P	MC27 B	MC27-GN	MC27-IP	USE LONG NOSED PLIERS	1227-24	
M30 x 3.5	30.5	30.75	MC30 R	MC30 P	MC30 B	MC30-GN	MC30-IP		1227-24	
M33 x 3.5	33.5	33.75	MC33 R	MC33 P	MC33 B	MC33-GN	MC33-IP		1227-24	
M36 x 4	36.75	37	MC36 R	MC36 P	MC36 B	MC36-GN	MC36-IP		1227-24	
M39 x 4	39.75	40	MC39 R	MC39 P	MC39 B	MC39-GN	MC39-IP		1227-24	

M8 x 1	8.2	8.3	MF8 R	MF8 P	MF8 B	MF8-GN	MF8-IP	MF8-TB	1227-6
M10 x 1.25	10.2	10.3	MF10 R	MF10 P	MF10 B	MF10-GN	MF10-IP	MF10-TB	1227-6
M12 x 1.25	12.2	12.3	MF12 R	MF12 P	MF12 B	MF12-GN	MF12-IP	MF12-TB	1227-16
M14 x 1.5	14.25	9/16"	MF14 R	MF14 P	MF14 B	MF14-GN	MF14-IP	MF14-TB	1227-16
M16 x 1.5	16.25	41/64"	MF16 R	MF16 P	MF16 B	MF16-GN	MF16-IP	MF16-TB	1227-16
M18 x 1.5	18.25		MF18 R	MF18 P	MF18 B	MF18-GN	MF18-IP	MF18-TB	1227-16
M20 x 1.5	20.25		MF20 R	MF20 P	MF20 B	MF20-GN	MF20-IP	MF20-TB	1227-16
M22 x 1.5	22.25		MF22 R	MF22 P	MF22 B	MF22-GN	MF22-IP	MF22-TB	1227-16
M24 x 2	24.25	24.5	MF24 R	MF24 P	MF24 B	MF24-GN	MF24-IP	MF24-TB	1227-16
M27 x 2	27.25	27.5	MF27 R	MF27 P	MF27 B	MF27-GN	MF27-IP	USE LONG NOSED PLIERS	1227-24
M30 x 2	30.25	30.5	MF30 R	MF30 P	MF30 B	MF30-GN	MF30-IP		1227-24
M33 x 2	33.25	33.5	MF33 R	MF33 P	MF33 B	MF33-GN	MF33-IP		1227-24
M36 x 3	36.5	36.75	MF36 R	MF36 P	MF36 B	MF36-GN	MF36-IP		1227-24
M39 x 3	39.5	39.75	MC39 R	MC39 P	MF39 B	MF39-GN	MF39-IP		1227-24

SPARK PLUG SERIES	M14 x 1.25	14.25	9/16"	SP14 R	SP14 P	SP14 B	SP14-GN	SP14-IP	USE PLIERS	1227-16
	M18 x 1.5	18.25		SP18 R	SP18 P	SP18 B	SP18-GN	SP18IP	DO	1227-16

NOTES :

- DRILLS : Tapping drills listed in col. 16 are suitable for Aluminum for steel Magnesium and Plastics, the alternative larger size drills (Col. 16A) should be used.
- TAPS : Finishing taps (Col. 18 & 19) will ordinary produce both normal SH & fine 4H5H fits.
- GAUGES : Thread Plug Gauges (Col.20) are for normal 5H fit. This are used to check tapped holes before installation of the insert.
- INSERTING TOOLS : Prewinder type (Col. 20) recommends 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 types for sizes M2 & M2.5