

SUPERIOR PERFORMANCE



ISO TAPS BLUE WIZARD/MERLIN



IDEAL FOR MATERIAL GROUPS



HAND & ISO TAPS





INDEX

STRAIGHT FLUTE HAND TAPS & SETS

	Code	Item	Description	Page No.
	F011 G011		Metric Bright M1 - M20	P.94
	F021 G021		Metric Fine Bright M3 - M20	P.95
	F091 G091		UNC Bright No.1 - 1"	P.96
	F101 G101		UNF Bright No.0 - 1"	P.97
	F301 G301		BSPF Bright 1/8" - 1"	P.98
	F311 G311		BSPT Bright 1/8" - 1"	P.99

ISO SPIRAL POINT BLUE WIZARD

	F013		Metric Vap M1.6 - M20	P.100
	F023 F033		Metric Fine Vap M4 - M20	P.101
	F093		UNC Vap No.1 - 1"	P.102
	F103		UNF Vap No.0 - 1"	P.103

ISO SPIRAL FLUTE BLUE MERLIN

	F015		Metric Vap M3 - M20	P.104
	F025 F035		Metric Fine Vap M4 - M20	P.105
	F095		UNC Vap No.4 - 1"	P.106
	F105		UNF Vap No.4 - 1"	P.107

METRIC COARSE HAND TAPS



HSS Bright ISO529 / BS949 6H

Series No. F011, G011



Size	Pitch	Overall Length	Flute Length	Square Length	Shank Dia	Square A/F	Z	EUROPA CODE			SET No. (3 TAPS)
								Taper Lead	Second Lead	Bottoming Lead	
M1.6	0.35	41	8.0	4	2.5	2.0	3	F0110063	F0110064	F0110065	G0110063
M2	0.40	41	9.5	4	2.5	2.0	3	F0110079	F0110080	F0110081	G0110079
M2.2	0.45	44.5	9.5	5	2.8	2.24	3	F0110087	F0110088	F0110089	G0110087
M2.5	0.45	44.5	9.5	5	2.8	2.24	3	F0110098	F0110099	F0110100	G0110098
M3	0.50	48	15.0	5	3.15	2.5	3	F0110117	F0110118	F0110119	G0110117
M3.5	0.60	50	17.0	5	3.55	2.8	3	F0110137	F0110138	F0110139	G0110137
M4	0.70	53	17.0	6	4.0	3.15	3	F0110158	F0110159	F0110160	G0110158
M4.5	0.75	53	17.0	6	4.5	3.55	3	F0110177	F0110178	F0110179	G0110177
M5	0.80	58	16.0	7	5.0	4.0	3	F0110197	F0110198	F0110199	G0110197
M6	1.00	66	19.0	8	6.3	5.0	3	F0110236	F0110237	F0110238	G0110236
M7	1.00	66	19.0	8	7.1	5.6	4	F0110276	F0110277	F0110278	G0110276
M8	1.25	72	22.0	9	8.0	6.3	4	F0110315	F0110316	F0110317	G0110315
M9	1.25	72	22.0	10	9.0	7.1	4	F0110354	F0110355	F0110356	G0110354
M10	1.50	80	24.0	11	10.0	8.0	4	F0110394	F0110395	F0110396	G0110394
M11	1.50	85	25.0	9	8.0	6.3	4	F0110433	F0110434	F0110435	G0110433
M12	1.75	89	29.0	10	9.0	7.1	4	F0110472	F0110473	F0110474	G0110472
M14	2.00	95	30.0	12	11.2	9.0	4	F0110551	F0110552	F0110553	G0110551
M16	2.00	102	32.0	13	12.5	10.0	4	F0110630	F0110631	F0110632	G0110630
M18	2.50	112	37.0	14	14.0	11.2	4	F0110709	F0110710	F0110711	G0110709
M20	2.50	112	37.0	14	14.0	11.2	4	F0110787	F0110788	F0110789	G0110787

► LARGER SIZES AVAILABLE ON REQUEST MANY STOCKED

METRIC FINE HAND TAPS



HSS Bright ISO529 / BS949 6H

Series No. F021, G021



Size	Pitch	Overall Length	Flute Length	Square Length	Shank Dia	Square A/F	Z	EUROPA CODE			SET No. (3 TAPS)
								Taper Lead	Second Lead	Bottoming Lead	
M3	0.35	48	15.0	5	3.15	2.5	3	F0210117	F0210118	F0210119	G0210117
M3.5	0.35	50	17.0	5	3.55	2.8	3	F0210137	F0210138	F0210139	G0210137
M4	0.50	53	17.0	6	4.0	3.15	3	F0210158	F0210159	F0210160	G0210158
M4.5	0.50	53	17.0	6	4.5	3.55	3	F0210177	F0210178	F0210179	G0210177
M5	0.50	58	16.0	7	5.0	4.0	3	F0210197	F0210198	F0210199	G0210197
M6	0.50	66	19.0	8	6.3	5.0	3	F0310236	F0310237	F0310238	G0310236
M6	0.75	66	19.0	8	6.3	5.0	3	F0210236	F0210237	F0210238	G0210236
M7	0.75	66	19.0	8	7.1	5.6	4	F0210276	F0210277	F0210278	G0210276
M8	0.50	72	22.0	9	8.0	6.3	4	F0410315	F0410316	F0410317	G0410315
M8	0.75	72	22.0	9	8.0	6.3	4	F0310315	F0310316	F0310317	G0310315
M8	1.00	72	22.0	9	8.0	6.3	4	F0210315	F0210316	F0210317	G0210315
M9	1.00	72	22.0	10	9.0	7.1	4	F0210354	F0210355	F0210356	G0210354
M10	0.75	80	24.0	11	10.0	8.0	4	F0410394	F0410395	F0410396	G0410394
M10	1.00	80	24.0	11	10.0	8.0	4	F0310394	F0310395	F0310396	G0310394
M10	1.25	80	24.0	11	10.0	8.0	4	F0210394	F0210395	F0210396	G0210394
M11	0.75	85	25.0	9	8.0	6.3	4	F0410433	F0410434	F0410435	G0410433
M11	1.00	85	25.0	9	8.0	6.3	4	F0210433	F0210434	F0210435	G0210433
M12	1.00	89	29.0	10	9.0	7.1	4	F0410472	F0410473	F0410474	G0410472
M12	1.25	89	29.0	10	9.0	7.1	4	F0210472	F0210473	F0210474	G0210472
M12	1.50	89	29.0	10	9.0	7.1	4	F0310472	F0310473	F0310474	G0310472
M14	1.00	95	30.0	12	11.2	9.0	4	F0410551	F0410552	F0410553	G0410551
M14	1.25	95	30.0	12	11.2	9.0	4	F0310551	F0310552	F0310553	G0310551
M14	1.50	95	30.0	12	11.2	9.0	4	F0210551	F0210552	F0210553	G0210551
M16	1.00	102	32.0	13	12.5	10.0	4	F0410630	F0410631	F0410632	G0410630
M16	1.50	102	32.0	13	12.5	10.0	4	F0210630	F0210631	F0210632	G0210630
M18	1.00	112	37.0	14	14.0	11.2	4	F0410709	F0410710	F0410711	G0410709
M18	1.50	112	37.0	14	14.0	11.2	4	F0210709	F0210710	F0210711	G0210709
M18	2.00	112	37.0	14	14.0	11.2	4	F0310709	F0310710	F0310711	G0310709
M20	1.00	112	37.0	14	14.0	11.2	4	F0410787	F0410788	F0410789	G0410787
M20	1.50	112	37.0	14	14.0	11.2	4	F0210787	F0210788	F0210789	G0210787
M20	2.00	112	37.0	14	14.0	11.2	4	F0310787	F0310788	F0310789	G0310787

► LARGER SIZES AVAILABLE ON REQUEST MANY STOCKED

UNC HAND TAPS



HSS Bright ISO529 / BS949 2B

Series No. F091, G091



Size	TPI	Overall Length	Flute Length	Square Length	Shank Dia	Square A/F	z	EUROPA CODE			SET No. (3 TAPS)
								Taper Lead	Second Lead	Bottoming Lead	
No.1	64	41	8.0	4	2.5	2.0	3	F0910073	F0910074	F0910075	G0910073
No.2	56	44.5	9.5	5	2.8	2.24	3	F0910086	F0910087	F0910088	G0910086
No.3	48	44.5	9.5	5	2.8	2.24	3	F0910099	F0910100	F0910101	G0910099
No.4	40	48	15.0	5	3.15	2.5	3	F0910112	F0910113	F0910114	G0910112
No.5	40	48	15.0	5	3.15	2.5	3	F0910124	F0910125	F0910126	G0910124
No.6	32	50	17.0	5	3.55	2.8	3	F0910138	F0910139	F0910140	G0910138
No.8	32	53	17.0	6	4.5	3.55	3	F0910164	F0910165	F0910166	G0910164
No.10	24	58	16.0	7	5.0	4.0	3	F0910190	F0910191	F0910192	G0910190
No.12	24	62	17.0	7	5.6	4.5	3	F0910216	F0910217	F0910218	G0910216
1/4	20	66	19.0	8	6.3	5.0	4	F0910250	F0910251	F0910252	G0910250
5/16	18	72	22.0	9	8.0	6.3	4	F0910312	F0910313	F0910314	G0910312
3/8	16	80	24.0	11	10.0	8.0	4	F0910375	F0910376	F0910377	G0910375
7/16	14	85	25.0	9	8.0	6.3	4	F0910438	F0910439	F0910440	G0910438
1/2	13	89	29.0	10	9.0	7.1	4	F0910500	F0910501	F0910502	G0910500
9/16	12	95	30.0	12	11.2	9.0	4	F0910562	F0910563	F0910564	G0910562
5/8	11	102	32.0	13	12.5	10.0	4	F0910625	F0910626	F0910627	G0910625
3/4	10	112	37.0	14	14.0	11.2	4	F0910750	F0910751	F0910752	G0910750
7/8	9	118	38.0	16	16.0	12.5	4	F0910875	F0910876	F0910877	G0910875
1"	8	130	45.0	18	18.0	14.0	4	F0911000	F0911001	F0911002	G0911000

► LARGER SIZES AVAILABLE ON REQUEST MANY STOCKED

UNF HAND TAPS



HSS Bright ISO529 / BS949 2B

Series No. F101, G101



Size	TPI	Overall Length	Flute Length	Square Length	Shank Dia	Square A/F	z	EUROPA CODE			SET No. (3 TAPS)
								Taper Lead	Second Lead	Bottoming Lead	
No.0	80	41	8.0	4	2.5	2.0	3	F1010060	F1010061	F1010062	G1010060
No.1	72	41	8.0	4	2.5	2.0	3	F1010073	F1010074	F1010075	G1010073
No.2	64	44.5	9.5	5	2.8	2.24	3	F1010086	F1010087	F1010088	G1010086
No.3	56	44.5	9.5	5	2.8	2.24	3	F1010099	F1010100	F1010101	G1010099
No.4	48	48	15.0	5	3.15	2.5	3	F1010112	F1010113	F1010114	G1010112
No.5	44	48	15.0	5	3.15	2.5	3	F1010124	F1010125	F1010126	G1010124
No.6	40	50	17.0	5	3.55	2.8	3	F1010138	F1010139	F1010140	G1010138
No.8	36	53	17.0	6	4.5	3.55	3	F1010164	F1010165	F1010166	G1010164
No.10	32	58	16.0	7	5.0	4.0	3	F1010190	F1010191	F1010192	G1010190
No.12	28	62	17.0	7	5.6	4.5	3	F1010216	F1010217	F1010218	G1010216
1/4	28	66	19.0	8	6.3	5.0	4	F1010250	F1010251	F1010252	G1010250
5/16	24	72	22.0	9	8.0	6.3	4	F1010312	F1010313	F1010314	G1010312
3/8	24	80	24.0	11	10.0	8.0	4	F1010375	F1010376	F1010377	G1010375
7/16	20	85	25.0	9	8.0	6.3	4	F1010438	F1010439	F1010440	G1010438
1/2	20	89	29.0	10	9.0	7.1	4	F1010500	F1010501	F1010502	G1010500
9/16	18	95	30.0	12	11.2	9.0	4	F1010562	F1010563	F1010564	G1010562
5/8	18	102	32.0	13	12.5	10.0	4	F1010625	F1010626	F1010627	G1010625
3/4	16	112	37.0	14	14.0	11.2	4	F1010750	F1010751	F1010752	G1010750
7/8	14	118	38.0	16	16.0	12.5	4	F1010875	F1010876	F1010877	G1010875
1"	12	130	45.0	18	18.0	14.0	4	F1011000	F1011001	F1011002	G1011000

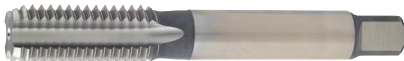
► LARGER SIZES AVAILABLE ON REQUEST MANY STOCKED

BSPF HAND TAPS



HSSBrightISO2284 / BS949G-Series

Series No. F301, G301



Size	TPI	Overall Length	Flute Length	Square Length	Shank Dia	Square A/F	z	EUROPA CODE			SET No. (3 TAPS)
								Taper Lead	Second Lead	Bottoming Lead	
1/8	28	59	15.0	9	8.0	6.3	4	F3010125	F3010126	F3010127	G3010125
1/4	19	67	19.0	11	10.0	8.0	4	F3010250	F3010251	F3010252	G3010250
3/8	19	75	21.0	13	12.5	10.0	4	F3010375	F3010376	F3010377	G3010375
1/2	14	87	26.0	16	16.0	12.5	4	F3010500	F3010501	F3010502	G3010500
5/8	14	91	26.0	18	18.0	14.0	4	F3010625	F3010626	F3010627	G3010625
3/4	14	96	28.0	20	20.0	16.0	4	F3010750	F3010751	F3010752	G3010750
7/8	14	102	29.0	22	22.4	18.0	4	F3010875	F3010876	F3010877	G3010875
1"	11	109	33.0	24	25.0	20.0	6	F3011000	F3011001	F3011002	G3011000

► LARGER SIZES AVAILABLE ON REQUEST MANY STOCKED

BSPT HAND TAPS



HSSBrightISO2284 / BS949Rc-Series

Series No. F311, G311



Size	TPI	Overall Length	Flute Length	Square Length	Shank Dia	Square A/F	z	EUROPA CODE			SET No. (3 TAPS)
								Taper Lead	Second Lead	Bottoming Lead	
1/8	28	59	15.0	9	8.0	6.3	3	F3110125	F3110126	F3110127	G3110125
1/4	19	67	19.0	11	10.0	8.0	5	F3110250	F3110251	F3110252	G3110250
3/8	19	75	21.0	13	12.5	10.0	5	F3110375	F3110376	F3110377	G3110375
1/2	14	87	26.0	16	16.0	12.5	5	F3110500	F3110501	F3110502	G3110500
3/4	14	96	28.0	20	20.0	16.0	5	F3110750	F3110751	F3110752	G3110750
7/8	14	102	29.0	22	22.4	18.0	5	F3110875	F3110876	F3110877	G3110875
1"	11	109	33.0	24	25.0	20.0	5	F3111000	F3111001	F3111002	G3111000

► LARGER SIZES AVAILABLE ON REQUEST MANY STOCKED

BLUE WIZARD SPIRAL POINT
METRIC COARSE



HSS VAP ISO529 / BS949 6H

Series No. F013



Size	Pitch	Overall Length	Flute Length	Square Length	Shank Dia	Square A/F	z	EUROPA CODE
M1.6	0.35	41	8.0	4	2.5	2.0	2	F0130066
M2	0.40	41	9.5	4	2.5	2.0	2	F0130082
M2.5	0.45	44	9.5	5	2.8	2.24	2	F0130101
M3	0.50	48	15.0	5	3.15	2.5	2	F0130120
M3.5	0.60	50	17.0	5	3.55	2.8	2	F0130140
M4	0.70	53	17.0	6	4.0	3.15	2	F0130161
M4.5	0.75	53	17.0	6	4.5	3.55	2	F0130180
M5	0.80	58	16.0	7	5.0	4.0	3	F0130200
M6	1.00	66	19.0	8	6.3	5.0	3	F0130239
M7	1.00	66	19.0	8	7.1	5.6	3	F0130279
M8	1.25	72	22.0	9	8.0	6.3	3	F0130318
M10	1.50	80	24.0	11	10.0	8.0	3	F0130397
M12	1.75	89	29.0	10	9.0	7.1	3	F0130475
M14	2.00	95	30.0	12	11.2	9.0	3	F0130554
M16	2.00	102	32.0	13	12.5	10.0	3	F0130633
M18	2.50	112	37.0	14	14.0	11.2	3	F0130712
M20	2.50	112	37.0	14	14.0	11.2	3	F0130790

► LARGER SIZES AVAILABLE ON REQUEST MANY STOCKED

Cutting Speed

		P			K		N	
		11	12	13	31	33	71	72
V _c (m/min)		10 - 15			8 - 10		10 - 20	

BLUE WIZARD SPIRAL POINT
METRIC FINE



HSS VAP ISO529 / BS949 6H

Series No. F023, F033



Size	Pitch	Overall Length	Flute Length	Square Length	Shank Dia	Square A/F	z	EUROPA CODE
M4	0.50	53	17.0	6	4.0	3.15	2	F0230161
M5	0.50	58	16.0	7	5.0	4.0	3	F0230200
M6	0.75	66	19.0	8	6.3	5.0	3	F0230239
M8	1.00	72	22.0	9	8.0	6.3	3	F0230318
M10	1.00	80	24.0	11	10.0	8.0	3	F0330397
M10	1.25	80	24.0	11	10.0	8.0	3	F0230397
M12	1.25	89	29.0	10	9.0	7.1	3	F0230475
M12	1.50	89	29.0	10	9.0	7.1	3	F0330475
M14	1.25	95	30.0	12	11.2	9.0	3	F0330554
M14	1.50	95	30.0	12	11.2	9.0	3	F0230554
M16	1.50	102	32.0	13	12.5	10.0	3	F0230633
M18	1.50	112	37.0	14	14.0	11.2	3	F0230712
M20	1.50	112	37.0	14	14.0	11.2	3	F0230790

Cutting Speed

	P			K		N	
	11	12	13	31	33	71	72
V _c (m/min)	10 - 15			8 - 10		10 - 20	

BLUE WIZARD SPIRAL POINT
UNC



HSS VAP ISO529 / BS949 2B

Series No. F093



Size	TPI	Overall Length	Flute Length	Square Length	Shank Dia	Square A/F	z	EUROPA CODE
No.1	64	41	8.0	4	2.5	2.0	2	F0930076
No.2	56	44	9.5	5	2.8	2.24	2	F0930089
No.3	48	44	9.5	5	2.8	2.24	2	F0930102
No.4	40	48	15.0	5	3.15	2.5	2	F0930115
No.5	40	48	15.0	5	3.15	2.5	2	F0930127
No.6	32	50	17.0	5	3.55	2.8	2	F0930141
No.8	32	53	17.0	6	4.5	3.55	2	F0930167
No.10	24	58	16.0	7	5.0	4.0	3	F0930193
No.12	24	62	17.0	7	5.6	4.5	3	F0930219
1/4	20	66	19.0	8	6.3	5.0	3	F0930253
5/16	18	72	22.0	9	8.0	6.3	3	F0930315
3/8	16	80	24.0	11	10.0	8.0	3	F0930378
7/16	14	85	25.0	9	8.0	6.3	3	F0930441
1/2	13	89	29.0	10	9.0	7.1	3	F0930503
9/16	12	95	30.0	12	11.2	9.0	3	F0930565
5/8	11	102	32.0	13	12.5	10.0	3	F0930628
3/4	10	112	37.0	14	14.0	11.2	3	F0930753
7/8	9	118	38.0	16	16.0	12.5	3	F0930878
1"	8	130	45.0	18	18.0	14.0	3	F0931003

Cutting Speed

	P			K		N	
	11	12	13	31	33	71	72
V _c (m/min)	10 - 15			8 - 10		10 - 20	

BLUE WIZARD SPIRAL POINT
UNF



HSS VAP ISO529 / BS949 2B

Series No. F103



Size	TPI	Overall Length	Flute Length	Square Length	Shank Dia	Square A/F	z	EUROPA CODE
No.0	80	41	8.0	4	2.5	2.0	2	F1030063
No.1	72	41	8.0	4	2.5	2.0	2	F1030076
No.2	64	44	9.5	5	2.8	2.24	2	F1030089
No.3	56	44	9.5	5	2.8	2.24	2	F1030102
No.4	48	48	15.0	5	3.15	2.5	2	F1030115
No.5	44	48	15.0	5	3.15	2.5	2	F1030127
No.6	40	50	17.0	5	3.55	2.8	2	F1030141
No.8	36	53	17.0	6	4.5	3.55	2	F1030167
No.10	32	58	16.0	7	5.0	4.0	3	F1030193
No.12	28	62	17.0	7	5.6	4.5	3	F1030219
1/4	28	66	19.0	8	6.3	5.0	3	F1030253
5/16	24	72	22.0	9	8.0	6.3	3	F1030315
3/8	24	80	24.0	11	10.0	8.0	3	F1030378
7/16	20	85	25.0	9	8.0	6.3	3	F1030441
1/2	20	89	29.0	10	9.0	7.1	3	F1030503
9/16	18	95	30.0	12	11.2	9.0	3	F1030565
5/8	18	102	32.0	13	12.5	10.0	3	F1030628
3/4	16	112	37.0	14	14.0	11.2	3	F1030753
7/8	14	118	38.0	16	16.0	12.5	3	F1030878
1"	12	130	45.0	18	18.0	14.0	3	F1031003

Cutting Speed

	P			K		N	
	11	12	13	31	33	71	72
V _c (m/min)	10 - 15			8 - 10		10 - 20	

BLUE MERLIN SPIRAL FLUTE
METRIC COARSE



HSS VAP ISO529 / BS949 6H

Series No. F015



Size	Pitch	Overall Length	Flute Length	Square Length	Shank Dia	Square A/F	z	EUROPA CODE
M3	0.50	48	15.0	5	3.15	2.5	2	F0150121
M3.5	0.60	50	17.0	5	3.55	2.8	2	F0150141
M4	0.70	53	17.0	6	4.0	3.15	2	F0150161
M5	0.80	58	16.0	7	5.0	4.0	3	F0150200
M6	1.00	66	19.0	8	6.3	5.0	3	F0150240
M7	1.00	66	19.0	8	7.1	5.6	3	F0150280
M8	1.25	72	22.0	9	8.0	6.3	3	F0150319
M10	1.50	80	24.0	11	10.0	8.0	3	F0150398
M12	1.75	89	29.0	10	9.0	7.1	3	F0150476
M14	2.00	95	30.0	12	11.2	9.0	3	F0150555
M16	2.00	102	32.0	13	12.5	10.0	3	F0150634
M18	2.50	112	37.0	14	14.0	11.2	3	F0150713
M20	2.50	112	37.0	14	14.0	11.2	3	F0150791

► LARGER SIZES AVAILABLE ON REQUEST MANY STOCKED

Cutting Speed

		P			K		N	
		11	12	13	31	33	71	72
V _c (m/min)		10 - 15			8 - 10		10 - 20	

BLUE MERLIN SPIRAL FLUTE
METRIC FINE



HSS VAP ISO529 / BS949 6H

Series No. F025, F035



Size	Pitch	Overall Length	Flute Length	Square Length	Shank Dia	Square A/F	z	EUROPA CODE
M4	0.50	53	17.0	6	4.0	3.15	2	F0250161
M5	0.50	58	16.0	7	5.0	4.0	3	F0250200
M6	0.75	66	19.0	8	6.3	5.0	3	F0250240
M8	1.00	72	22.0	9	8.0	6.3	3	F0250319
M10	1.00	80	24.0	11	10.0	8.0	3	F0350398
M10	1.25	80	24.0	11	10.0	8.0	3	F0250399
M12	1.25	89	29.0	10	9.0	7.1	3	F0250476
M12	1.50	89	29.0	10	9.0	7.1	3	F0350476
M14	1.25	95	30.0	12	11.2	9.0	3	F0350555
M14	1.50	95	30.0	12	11.2	9.0	3	F0250555
M16	1.50	102	32.0	13	12.5	10.0	3	F0250634
M18	1.50	112	37.0	14	14.0	11.2	3	F0250713
M20	1.50	112	37.0	14	14.0	11.2	3	F0250791

Cutting Speed

	P			K		N	
	11	12	13	31	33	71	72
V _c (m/min)	10 - 15			8 - 10		10 - 20	

BLUE MERLIN SPIRAL FLUTE
UNC



HSS VAP ISO529 / BS949 2B

Series No. F095



Size	TPI	Overall Length	Flute Length	Square Length	Shank Dia	Square A/F	z	EUROPA CODE
No.4	40	48	15.0	5	3.15	2.5	2	F0950116
No.5	40	48	15.0	5	3.15	2.5	2	F0950128
No.6	32	50	17.0	5	3.55	2.8	3	F0950142
No.8	32	53	17.0	6	4.5	3.55	3	F0950168
No.10	24	58	16.0	7	5.0	4.0	3	F0950194
1/4	20	66	19.0	8	6.3	5.0	3	F0950254
5/16	18	72	22.0	9	8.0	6.3	3	F0950316
3/8	16	80	24.0	11	10.0	8.0	3	F0950379
7/16	14	85	25.0	9	8.0	6.3	3	F0950442
1/2	13	89	29.0	10	9.0	7.1	3	F0950504
9/16	12	95	30.0	12	11.2	9.0	3	F0950566
5/8	11	102	32.0	13	12.5	10.0	3	F0950629
3/4	10	112	37.0	14	14.0	11.2	3	F0950754
7/8	9	118	38.0	16	16.0	12.5	3	F0950879
1"	8	130	45.0	18	18.0	14.0	3	F0951004

Cutting Speed

	P			K		N		
	11	12	13	31	33	71	72	
V _c (m/min)	10 - 15			8 - 10		10 - 20		

BLUE MERLIN SPIRAL FLUTE
UNF



HSS VAP ISO529 / BS949 2B

Series No. F105



Size	TPI	Overall Length	Flute Length	Square Length	Shank Dia	Square A/F	z	EUROPA CODE
No.4	48	48	15.0	5	3.15	2.5	2	F1050116
No.5	44	48	15.0	5	3.15	2.5	2	F1050128
No.6	40	50	17.0	5	3.55	2.8	2	F1050142
No.8	36	53	17.0	6	4.5	3.55	2	F1050168
No.10	32	58	16.0	7	5.0	4.0	3	F1050194
1/4	28	66	19.0	8	6.3	5.0	3	F1050254
5/16	24	72	22.0	9	8.0	6.3	3	F1050316
3/8	24	80	24.0	11	10.0	8.0	3	F1050379
7/16	20	85	25.0	9	8.0	6.3	3	F1050442
1/2	20	89	29.0	10	9.0	7.1	3	F1050504
9/16	18	95	30.0	12	11.2	9.0	3	F1050566
5/8	18	102	32.0	13	12.5	10.0	3	F1050629
3/4	16	112	37.0	14	14.0	11.2	3	F1050754
7/8	14	118	38.0	16	16.0	12.5	3	F1050879
1"	12	130	45.0	18	18.0	14.0	3	F1051004

Cutting Speed

	P			K		N		
	11	12	13	31	33	71	72	
V _c (m/min)	10 - 15			8 - 10		10 - 20		