

# OPTIONAL SPRINGS AND COLLARS

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## Spring and collar options for ANSI taps.

- Choose heavier or lighter springs for a more precise chamfer depth when machining different types of materials.
- Use Deep Hole de-burring spring and collar sets when tapping deeper holes.
- Use Straight Spring and collars with CNC style or European style DIN taps (Taps that have a reduced section between the threaded portion and the tap shank).

### BURR-BIT SPRINGS AND COLLARS FOR AMERICAN STANDARD TAPS

Dimensional data (inches). See diagrams on opposite page.

Tap Size	Std. Conical Spring				Straight Spring				Deep Hole Spring			
	B	C	D	S	B	C	D	S	B	C	E	S
#2-#4 --	.85	.56	.375	.141	1.20	.80	.375	.141	--	--	--	.141
#5-#6 M3	.87	.56	.375	.141	1.20	.80	.375	.141	--	--	--	.141
#8 M4	1.00	.62	.375	.168	1.20	.80	.375	.168	--	--	--	.168
#10 M5	1.60	.62	.375	.194	1.30	.83	.375	.194	--	--	--	.194
#12 --	1.60	.62	.375	.220	1.30	.83	.375	.220	--	--	--	.220
1/4 M6	1.20	.75	.500	.255	1.60	1.00	.500	.255	1.12	.75	1.25	.255
5/16 M8	1.25	.85	.562	.318	1.65	1.06	.562	.318	1.13	.80	1.25	.318
3/8 M10	1.37	.87	.656	.381	1.70	1.00	.656	.381	1.27	.80	1.25	.381
7/16 --	1.75	.87	.812	.323	1.90	1.14	.812	.323	1.25	.80	1.25	.323
1/2 M12	1.80	1.00	.812	.367	1.90	1.14	.812	.367	1.25	.80	1.25	.367
9/16 M14	2.06	1.12	1.00	.429	2.00	1.26	1.00	.429	1.75	1.00	1.50	.429
5/8 M16	2.06	1.12	1.00	.480	2.00	1.26	1.00	.480	1.75	1.00	1.50	.480
11/16 --	2.06	1.12	1.00	.542	2.00	1.26	1.00	.542	1.75	1.00	1.50	.542
-- M18	2.00	1.18	1.12	.542	2.19	1.26	1.12	.542	1.75	1.00	1.50	.542
3/4 --	2.00	1.18	1.12	.590	2.19	1.26	1.12	.590	1.75	1.00	1.50	.590
-- M20	--	--	--	--	2.19	1.26	1.12	.652	1.75	1.00	1.50	.652

### BURR-BIT SPRINGS AND COLLARS FOR AMERICAN STANDARD TAPS

Part Numbers

Tap Size	Standard Conical Spring & Collar			Straight Spring & Collar	Deep Hole Spring & Collar
	UNC/UNF Metric	Extra Light	Std. Heavy	Extra Heavy	Standard
#2-#4 --		08020404	08020405	08020406	08020402
#5-#6 M3		08020604	08020605	08020606	08020602
#8 M4		08020704	08020705	08020706	08020702
#10 M5		08020804	08020805	08020806	08020802
#12 --		08020904	08020905	08020906	08020902
1/4 M6		08021104	08021105	08021106	08021102
5/16 M8		08021204	08021205	08021206	08021202
3/8 M10		08021304	08021305	08021306	08021302
7/16 --		08021404	08021405	08021406	08021402
1/2 M12		08021504	08021505	08021506	08021502
9/16 M14		08021604	08021605	08021606	08021602
5/8 M16		08021704	08021705	08021706	08021702
11/16 M18		08021804	08021805	08021806	08021802
3/4 M20		08021904	08021905	08021906	08021902

## Spring and collar options for ISO and JIS taps

- Convert standard metric Burrbits to European DIN or Japanese JIS standards.

### CONVERTS STANDARD BURR-BITS TO JIS STANDARD

See diagrams on opposite page.

Tap Size	B (mm)	C (mm)	D (mm)	S (mm)	PART#
M3	23.0	16.5	9.5	4.0	08030304
M4	25.0	16.5	9.5	5.0	08030404
M5	26.0	16.5	9.5	5.5	08030504
M6	28.5	18.0	12.7	6.0	08030604
M8	33.0	19.0	8.0	6.2	08030804
M10	36.0	21.5	16.6	7.0	08031004
M12	43.5	24.0	20.6	8.5	08031204
M14	42.0	25.5	25.4	10.5	08031404
M16	47.5	28.5	25.4	12.5	08031604
M18	54.0	34.0	28.5	14.0	08031804

### CONVERTS STANDARD BURR-BITS TO EUROPEAN ISO STANDARDS DIN 371 AND DIN 376

Part Numbers and Dimensional data (MM) See diagrams on opposite page.

Tap Size	Dimensions			DIN 371	DIN 371	DIN 376	DIN 376
	B	C	D	S	PART#	S	PART#
M3	30.5	20.0	9.5	3.5	08030301	2.2	08030302
M4	30.5	20.0	9.5	4.5	08030401	2.8	08030402
M5	33.0	21.0	9.5	6.0	08030501	3.5	08030502
M6	39.5	25.5	13.0	6.0	08030601	4.5	08030602
M8	41.0	27.0	14.5	8.0	08030801	6.0	08030802
M10	43.0	25.0	16.6	10.0	08031001	7.0	08031002
M12	48.0	29.0	20.6	12.0	08031201	9.0	08031202
M14	50.5	32.0	25.4	--	--	11.0	08031402
M16	50.5	32.0	25.4	--	--	12.0	08031602
M18	55.5	32.0	28.5	--	--	14.0	08031802
M20	55.5	32.0	28.5	--	--	16.0	08032002