

BURR-BIT® Optional Springs and Collars

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).

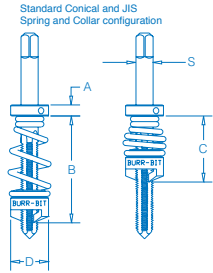


Fig. A

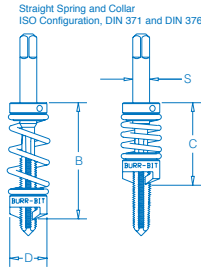


Fig. B

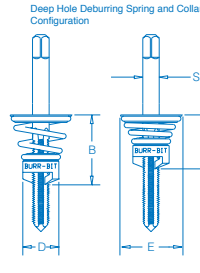


Fig. C

CONICAL SPRINGS AND COLLARS

for American Standard Taps (See Fig. A)

Tap Size	B (in)	C (in)	D (in)	S (in)	Part Numbers			
					Extra Light	Std. Heavy	Extra Heavy	
#2-#4	—	0.85	.56	.375	.141	8020404	8020405	8020406
#5-#6	M3	0.87	.56	.375	.141	8020604	8020605	8020606
#8	M4	0.87	.62	.375	.168	8020704	8020705	8020706
#10	M5	1.06	.62	.375	.194	8020804	8020805	8020806
#12	—	1.06	.62	.375	.22	8020904	8020905	8020906
1/4	M6	1.14	.75	.5	.255	8021104	8021105	8021106
5/16	M8	1.25	.85	.562	.318	8021204	8021205	8021206
3/8	M10	1.37	.87	.656	.381	8021304	8021305	8021306
7/16	—	1.75	.87	.812	.323	8021404	8021405	8021406
1/2	M12	1.8	1.0	.812	.367	8021504	8021505	8021506
9/16	M14	1.89	1.12	1.0	.429	8021604	8021605	8021606
5/8	M16	1.89	1.12	1.0	.48	8021704	8021705	8021706
11/16	—	1.89	1.12	1.0	.542	8021804	8021805	8021806
3/4	—	1.93	1.18	1.12	.59	8021904	8021905	8021906

DEEP HOLE SPRINGS AND COLLARS

(DHD) for American Standard Taps (See Fig. C)

Tap Size	B (in)	C (in)	E (in)	S (in)	Part Number	
#2-#4	—	—	—	.141	—	
#5-#6	M3	—	—	.141	—	
#8	M4	—	—	.168	—	
#10	M5	—	—	.194	—	
#12	—	—	—	.22	—	
1/4	M6	1.12	.75	1.25	.255	8021103
5/16	M8	1.13	.8	1.25	.318	8021203
3/8	M10	1.27	.8	1.25	.381	8021303
7/16	—	1.25	.8	1.25	.323	8021403
1/2	M12	1.25	.8	1.25	.367	8021503
9/16	M14	1.75	1.0	1.5	.429	8021603
5/8	M16	1.75	1.0	1.5	.48	8021703
11/16	—	1.75	1.0	1.5	.542	8021803
—	M18	1.75	1.0	1.5	.542	8021803
3/4	—	1.75	1.0	1.5	.59	8021903
—	M20	1.75	1.0	1.5	.652	8021903

STRAIGHT SPRINGS AND COLLARS

for CNC / European style shank taps: "Reduced Shank Taps" with standard ANSI shank diameters. (See Fig. B)

Tap Size	B (in)	C (in)	D (in)	S (in)	Part Number	
#2-#4	—	1.2	.8	.375	.141	8020402
#5-#6	M3	1.2	.8	.375	.141	8020602
#8	M4	1.2	.8	.375	.168	8020702
#10	M5	1.3	.83	.375	.194	8020802
#12	—	1.3	.83	.375	.22	8020902
1/4	M6	1.6	1.0	.5	.255	8021102
5/16	M8	1.65	1.06	.562	.318	8021202
3/8	M10	1.7	1.0	.656	.381	8021302
7/16	—	1.9	1.14	.812	.323	8021402
1/2	M12	1.9	1.14	.812	.367	8021502
9/16	M14	2.0	1.26	1.0	.429	8021602
5/8	M16	2.0	1.26	1.0	.48	8021702
11/16	—	2.0	1.26	1.0	.542	8021802
—	M18	2.19	1.26	1.12	.542	8021802
3/4	—	2.19	1.26	1.12	.59	8021902
—	M20	2.19	1.26	1.12	.652	8021902

Spring and collar options for ISO and JIS taps.

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

CONVERTS STANDARD BURR-BIT TO EUROPEAN ISO STANDARDS: DIN 371 AND DIN 376 (See Fig. B)
Part Numbers and Dimensional data (metric)

Tap Size	Dimensions (mm)			DIN 371		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

CONVERTS STANDARD ANSI BURR-BIT TO JIS STANDARD (See Fig. A)

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