

## About tap class of DIN standard cutting taps

### 【Consultation】



I was looking at the electronic catalog page to purchase a **DIN** standard cutting tap, and the tap class was listed as “ISO2X”. What does this “X” mean?

### 【Answer】

Cutting taps with an “X” in the tap class means that they are oversized compared to the standard class (ISO2/ISO3). The amount of oversize depends on the pitch.



### 【Explanation】

DIN tap class are represented as ISO2/ISO2X/ISO3X/7GX for metric threads and 2B/2BX for unified threads. The amount of oversize depends on the pitch. The table below shows the amount of oversize for each pitch size.

Pitch (mm)	0.2 ~ 0.7	0.75 ~ 1	1.25 ~ 2.5	2.5 ~
Oversize value(μm)	15	20	25	30

If JIS dimension tap is not available, DIN dimension tap can be substituted if the tap class is close. In that case, please check the tap dimension in the catalog before use, as the overall length, shank diameter, and other dimensions may different even if the nominal dimensions are the same.

Also, check to see if the tap can be used with your collet in your hand.



Comparison of tap dimensions between JIS and DIN taps (Example: Size M10X1.5)

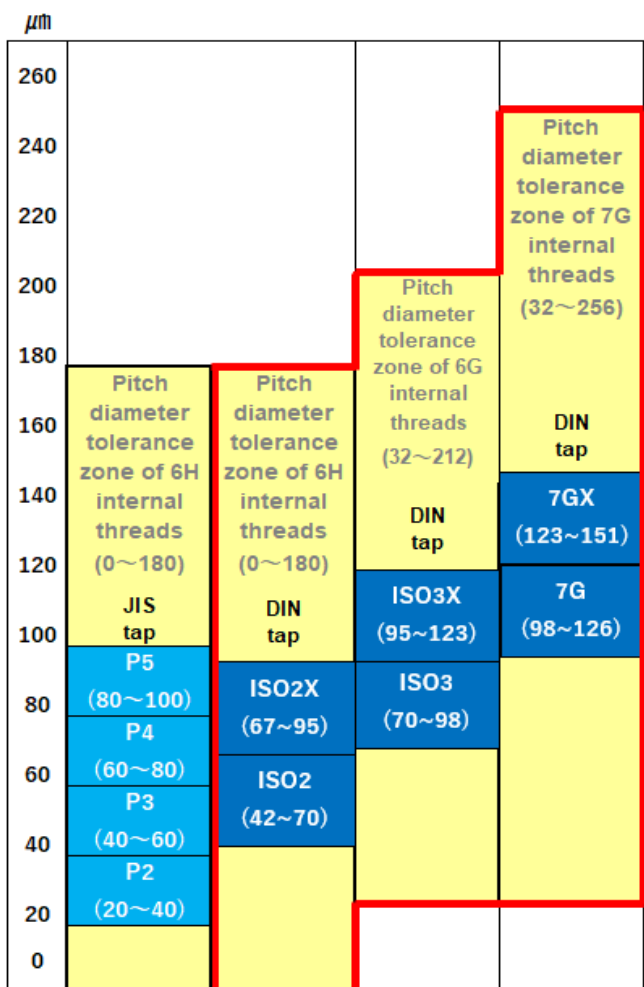
**JIS** 【SU-SP】 

**DIN** 【SP-VA】 

Unit: mm

Dimension	Product symbol	Overall length L	Thread length ℓ	Shank dia. Ds
JIS	SU-SP	75	23	7
DIN	SP-VA	100	13	10

Pitch diameter tolerance table of DIN and JIS tap and internal threads (Example: M10X1.5)



Basic pitch diameter: 9.026mm