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Vol 1

Ultra-Premium Design for a Wide Range of Materials

HY-PRO[®] SIGMA

SIGMA POT • SIGMA SFT



SIGMA

HY-PRO SIGMA SFT & POT Taps are the ultimate “Do It All” spiral point and spiral flute taps for a wide range of materials. OSG’s unique geometry along with our premium vanadium high-speed steel substrate provide exceptional tool life with unequaled consistency. With a comprehensive lineup covering 2B & 3B classes of fit, there is a HY-PRO SIGMA tap to meet your needs.

Sharp Cutting Edge

for stabilizing chip shape and decreasing cutting resistance.

Special Flute Form

that improves chip formation and evacuation.

Superior Durability

Geometry designed to last longer in harder materials.

DIN Length

for improved chip evacuation in blind hole applications.



Chip Formation and Evacuation



4140



6061

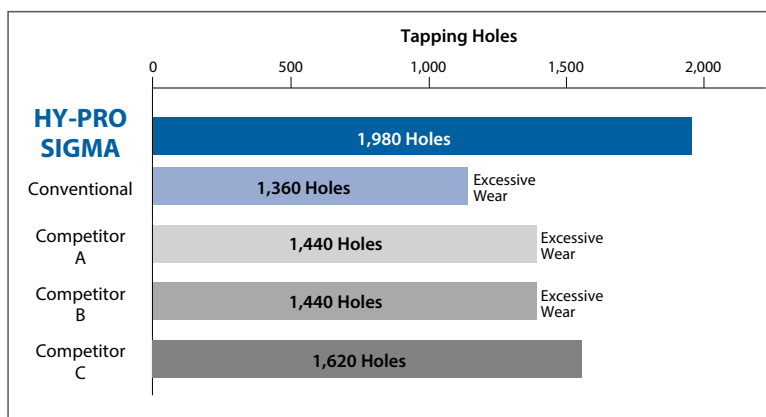


304L

Stable Performance & Long Tool Life in Carbon Steel

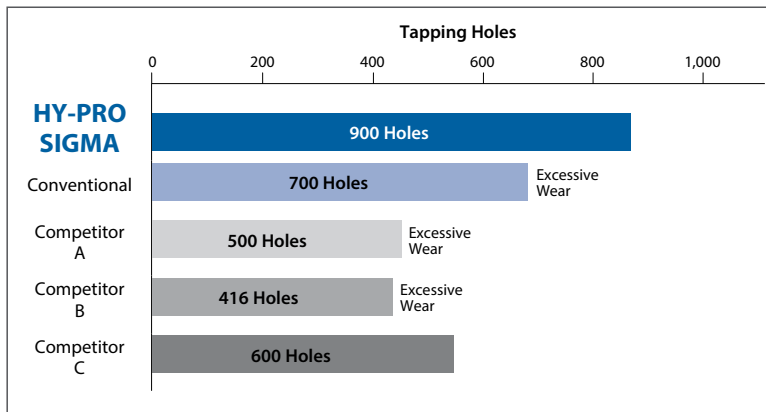
POT

Tool	HY-PRO® SIGMA	Conventional	Competitor A	Competitor B	Competitor C
Coating	Steam Oxide				
Size	1/4-20 UNC POT (S/O)				
Material	1045				
Drill Hole Size	Ø5.3 x 15mm				
Tapping Depth	0.5" (12.7mm)				
Cutting Speed	32.8 SFM (10m/min)				
Coolant	Water Soluble				
Machine	Vertical Machining Center				



SFT

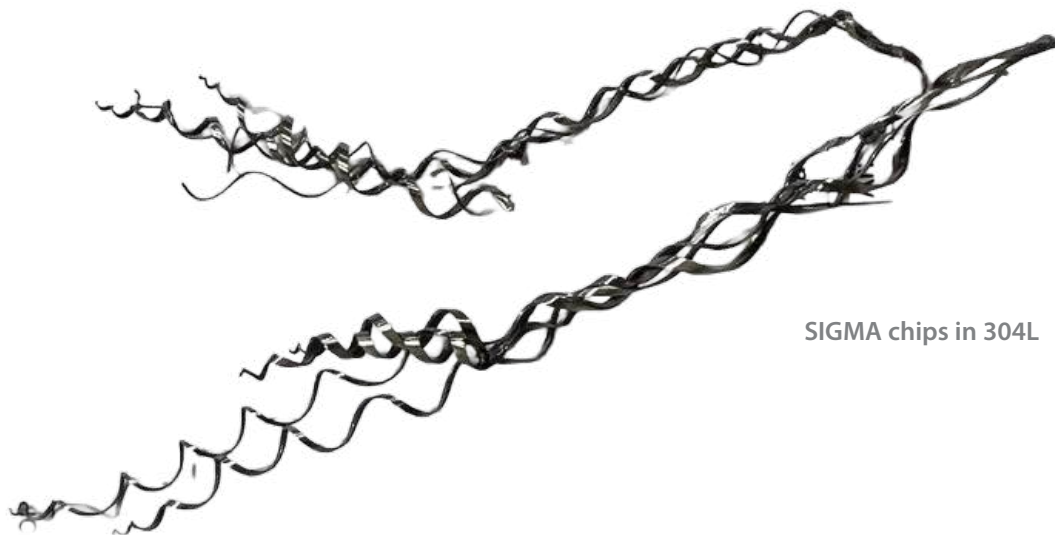
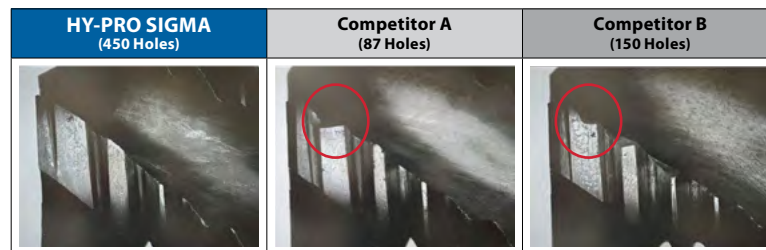
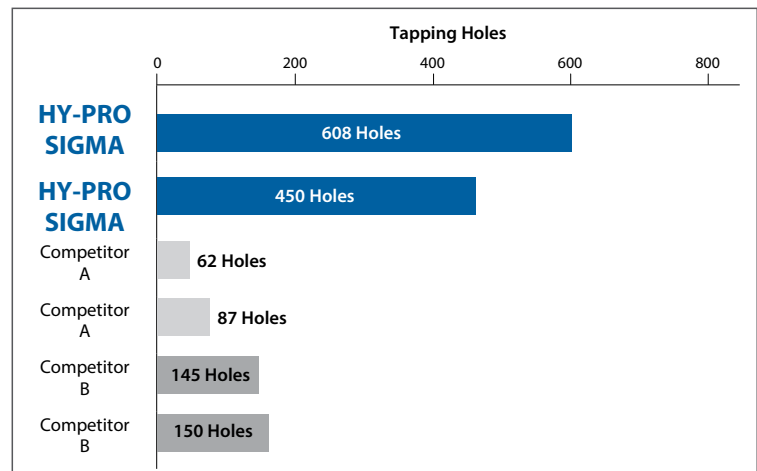
Tool	HY-PRO® SIGMA	Conventional	Competitor A	Competitor B	Competitor C
Coating	Steam Oxide				
Size	1/4-20 UNC SFT				
Material	1045				
Drill Hole Size	Ø5.3 x 15mm				
Tapping Depth	0.5" (12.7mm)				
Cutting Speed	32.8 SFM (10m/min)				
Coolant	Water Soluble				
Machine	Vertical Machining Center				



Excellent Chip Control & Long Tool Life in Stainless Steel

304L Stainless

Tool	HY-PRO® SIGMA	Competitor A	Competitor B
Coating	Steam Oxide		
Size	3/8-16 UNC SFT		
Material	304L Stainless		
Drill Hole Size	Ø8.1 x 23mm		
Tapping Depth	0.75" (19.1mm)		
Cutting Speed	30 SFM (9.15m/min)		
Coolant	10% Water Soluble		
Machine	Vertical Machining Center		

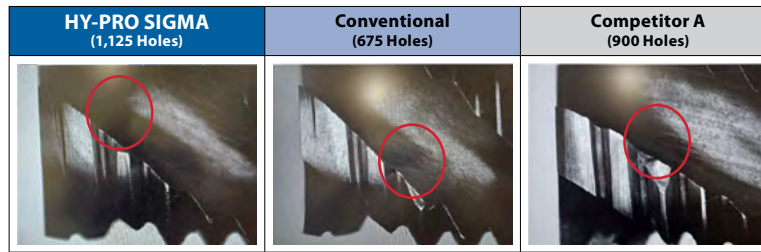
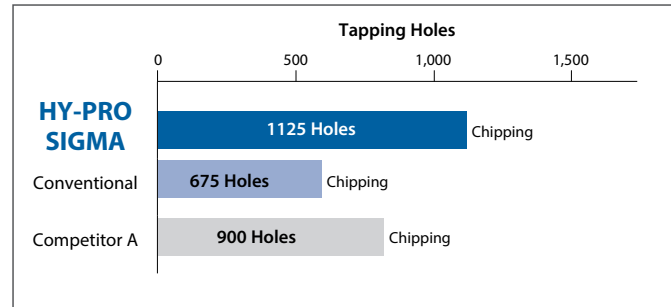


SIGMA chips in 304L

Enhanced Performance in Carbon Steel with S/O & TiCN

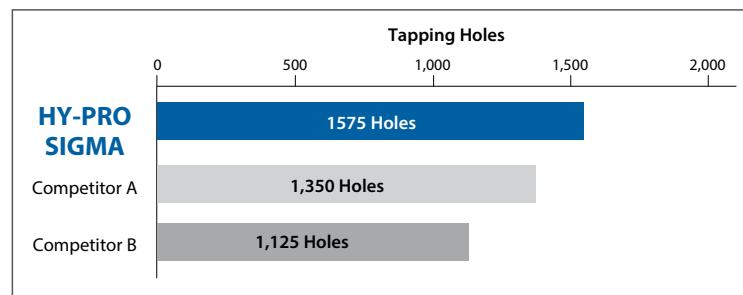
Steam Oxide

Tool	HY-PRO® SIGMA	Conventional	Competitor A
Coating	Steam Oxide		
Size	3/8-16 UNC SFT		
Material	1045		
Drill Hole Size	Ø8.1 x 23mm		
Tapping Depth	0.75" (19.1mm)		
Cutting Speed	50 SFM (15.24 m/min)		
Coolant	Water Soluble		
Machine	Vertical Machining Center		



TiCN

Tool	HY-PRO® SIGMA	Competitor A	Competitor B
Coating	TiCN		
Size	3/8-16 UNC SFT		
Material	1045		
Drill Hole Size	Ø8.1 x 23mm		
Tapping Depth	0.75" (19.1mm)		
Cutting Speed	50 SFM (15.24 m/min)		
Coolant	Water Soluble		
Machine	Vertical Machining Center		



List 10280

HY-PRO SIGMA



EDP Number		Thread Size	Thread Limit	Overall Length	Length of Cut	Neck Length	Shank Diameter	Square Width	Square Length	Number of Flutes	Surface Treatment
				L (Inch)	Lc (Inch)	L1 (Inch)	d (Inch)	k (Inch)	lk (Inch)		
1028000101	●	No. 2 - 56 UNC	H1	1.772	0.437	0.476	0.141	0.110	0.188	2	Steam Oxide
1028000108	●	No. 2 - 56 UNC	H1	1.772	0.437	0.476	0.141	0.110	0.188	2	TiCN
1028000001	●	No. 2 - 56 UNC	H2	1.772	0.437	0.476	0.141	0.110	0.188	2	Steam Oxide
1028000008	●	No. 2 - 56 UNC	H2	1.772	0.437	0.476	0.141	0.110	0.188	2	TiCN
1028000301	●	No. 2 - 64 UNF	H1	1.772	0.437	0.476	0.141	0.110	0.188	2	Steam Oxide
1028000308	●	No. 2 - 64 UNF	H1	1.772	0.437	0.476	0.141	0.110	0.188	2	TiCN
1028000201	●	No. 2 - 64 UNF	H2	1.772	0.437	0.476	0.141	0.110	0.188	2	Steam Oxide
1028000208	●	No. 2 - 64 UNF	H2	1.772	0.437	0.476	0.141	0.110	0.188	2	TiCN
1028000501	●	No. 3 - 48 UNC	H1	1.969	0.500	0.539	0.141	0.110	0.188	2	Steam Oxide
1028000508	●	No. 3 - 48 UNC	H1	1.969	0.500	0.539	0.141	0.110	0.188	2	TiCN
1028000401	●	No. 3 - 48 UNC	H2	1.969	0.500	0.539	0.141	0.110	0.188	2	Steam Oxide
1028000408	●	No. 3 - 48 UNC	H2	1.969	0.500	0.539	0.141	0.110	0.188	2	TiCN
1028000701	●	No. 3 - 56 UNF	H1	1.969	0.500	0.539	0.141	0.110	0.188	2	Steam Oxide
1028000708	●	No. 3 - 56 UNF	H1	1.969	0.500	0.539	0.141	0.110	0.188	2	TiCN
1028000601	●	No. 3 - 56 UNF	H2	1.969	0.500	0.539	0.141	0.110	0.188	2	Steam Oxide
1028000608	●	No. 3 - 56 UNF	H2	1.969	0.500	0.539	0.141	0.110	0.188	2	TiCN
1028000801	●	No. 4 - 40 UNC	H2	2.205	0.295	0.704	0.141	0.110	0.188	2	Steam Oxide
1028000808	●	No. 4 - 40 UNC	H2	2.205	0.295	0.704	0.141	0.110	0.188	2	TiCN
1028001001	●	No. 4 - 48 UNF	H1	2.205	0.295	0.704	0.141	0.110	0.188	2	Steam Oxide
1028001008	●	No. 4 - 48 UNF	H1	2.205	0.295	0.704	0.141	0.110	0.188	2	TiCN
1028000901	●	No. 4 - 48 UNF	H2	2.205	0.295	0.704	0.141	0.110	0.188	2	Steam Oxide
1028000908	●	No. 4 - 48 UNF	H2	2.205	0.295	0.704	0.141	0.110	0.188	2	TiCN
1028001101	●	No. 5 - 40 UNC	H2	2.205	0.299	0.708	0.141	0.110	0.188	3	Steam Oxide
1028001108	●	No. 5 - 40 UNC	H2	2.205	0.299	0.708	0.141	0.110	0.188	3	TiCN
1028001301	●	No. 5 - 48 UNF	H1	2.205	0.299	0.708	0.141	0.110	0.188	3	Steam Oxide
1028001308	●	No. 5 - 48 UNF	H1	2.205	0.299	0.708	0.141	0.110	0.188	3	TiCN
1028001201	●	No. 5 - 48 UNF	H2	2.205	0.299	0.708	0.141	0.110	0.188	3	Steam Oxide
1028001208	●	No. 5 - 48 UNF	H2	2.205	0.299	0.708	0.141	0.110	0.188	3	TiCN
1028001401	●	No. 6 - 32 UNC	H2	2.205	0.370	0.783	0.141	0.110	0.188	3	Steam Oxide
1028001408	●	No. 6 - 32 UNC	H2	2.205	0.370	0.783	0.141	0.110	0.188	3	TiCN
1028001501	●	No. 6 - 32 UNC	H3	2.205	0.370	0.783	0.141	0.110	0.188	3	Steam Oxide
1028001508	●	No. 6 - 32 UNC	H3	2.205	0.370	0.783	0.141	0.110	0.188	3	TiCN
1028001601	●	No. 6 - 40 UNF	H2	2.205	0.370	0.783	0.141	0.110	0.188	3	Steam Oxide
1028001608	●	No. 6 - 40 UNF	H2	2.205	0.370	0.783	0.141	0.110	0.188	3	TiCN
1028001701	●	No. 8 - 32 UNC	H2	2.481	0.374	0.826	0.168	0.131	0.250	3	Steam Oxide
1028001708	●	No. 8 - 32 UNC	H2	2.481	0.374	0.826	0.168	0.131	0.250	3	TiCN
1028001801	●	No. 8 - 32 UNC	H3	2.481	0.374	0.826	0.168	0.131	0.250	3	Steam Oxide
1028001808	●	No. 8 - 32 UNC	H3	2.481	0.374	0.826	0.168	0.131	0.250	3	TiCN
1028001901	●	No. 8 - 36 UNF	H2	2.481	0.374	0.826	0.168	0.131	0.250	3	Steam Oxide
1028001908	●	No. 8 - 36 UNF	H2	2.481	0.374	0.826	0.168	0.131	0.250	3	TiCN
1028002001	●	No. 10 - 24 UNC	H3	2.756	0.492	0.976	0.194	0.152	0.250	3	Steam Oxide
1028002008	●	No. 10 - 24 UNC	H3	2.756	0.492	0.976	0.194	0.152	0.250	3	TiCN
1028002101	●	No. 10 - 32 UNF	H2	2.756	0.492	0.976	0.194	0.152	0.250	3	Steam Oxide
1028002108	●	No. 10 - 32 UNF	H2	2.756	0.492	0.976	0.194	0.152	0.250	3	TiCN
1028002201	●	No. 10 - 32 UNF	H3	2.756	0.492	0.976	0.194	0.152	0.250	3	Steam Oxide
1028002208	●	No. 10 - 32 UNF	H3	2.756	0.492	0.976	0.194	0.152	0.250	3	TiCN
1028002301	●	No. 12 - 24 UNC	H3	3.150	0.496	1.177	0.220	0.165	0.281	3	Steam Oxide
1028002308	●	No. 12 - 24 UNC	H3	3.150	0.496	1.177	0.220	0.165	0.281	3	TiCN
1028002401	●	No. 12 - 28 UNF	H3	3.150	0.496	1.177	0.220	0.165	0.281	3	Steam Oxide
1028002408	●	No. 12 - 28 UNF	H3	3.150	0.496	1.177	0.220	0.165	0.281	3	TiCN
1028002501	●	1/4 - 20 UNC	H3	3.150	0.594	1.177	0.255	0.191	0.313	3	Steam Oxide
1028002508	●	1/4 - 20 UNC	H3	3.150	0.594	1.177	0.255	0.191	0.313	3	TiCN
1028002601	●	1/4 - 20 UNC	H5	3.150	0.594	1.177	0.255	0.191	0.313	3	Steam Oxide

● Stocked ▲ Globally Stocked ○ Made to Order; contact an OSG representative for details

Note: For internal threads only.



List 10280 (Continued)

HY-PRO SIGMA



EDP Number		Thread Size	Thread Limit	Overall Length	Length of Cut	Neck Length	Shank Diameter	Square Width	Square Length	Number of Flutes	Surface Treatment
				L (Inch)	Lc (Inch)	L1 (Inch)	d (Inch)	k (Inch)	lk (Inch)		
1028002608	●	1/4 - 20 UNC	H5	3.150	0.594	1.177	0.255	0.191	0.313	3	TiCN
1028002701	●	1/4 - 28 UNF	H3	3.150	0.594	1.173	0.255	0.191	0.313	3	Steam Oxide
1028002708	●	1/4 - 28 UNF	H3	3.150	0.594	1.173	0.255	0.191	0.313	3	TiCN
1028002801	●	1/4 - 28 UNF	H4	3.150	0.594	1.173	0.255	0.191	0.313	3	Steam Oxide
1028002808	●	1/4 - 28 UNF	H4	3.150	0.594	1.173	0.255	0.191	0.313	3	TiCN
1028002901	●	5/16 - 18 UNC	H3	3.543	0.665	1.377	0.318	0.238	0.375	3	Steam Oxide
1028002908	●	5/16 - 18 UNC	H3	3.543	0.665	1.377	0.318	0.238	0.375	3	TiCN
1028003001	●	5/16 - 18 UNC	H5	3.543	0.665	1.377	0.318	0.238	0.375	3	Steam Oxide
1028003008	●	5/16 - 18 UNC	H5	3.543	0.665	1.377	0.318	0.238	0.375	3	TiCN
1028003101	●	5/16 - 24 UNF	H3	3.543	0.657	1.374	0.318	0.238	0.375	3	Steam Oxide
1028003108	●	5/16 - 24 UNF	H3	3.543	0.657	1.374	0.318	0.238	0.375	3	TiCN
1028003201	●	5/16 - 24 UNF	H4	3.543	0.657	1.374	0.318	0.238	0.375	3	Steam Oxide
1028003208	●	5/16 - 24 UNF	H4	3.543	0.657	1.374	0.318	0.238	0.375	3	TiCN
1028003301	●	3/8 - 16 UNC	H3	3.937	0.752	1.535	0.381	0.286	0.438	3	Steam Oxide
1028003308	●	3/8 - 16 UNC	H3	3.937	0.752	1.535	0.381	0.286	0.438	3	TiCN
1028003401	●	3/8 - 16 UNC	H5	3.937	0.752	1.535	0.381	0.286	0.438	3	Steam Oxide
1028003408	●	3/8 - 16 UNC	H5	3.937	0.752	1.535	0.381	0.286	0.438	3	TiCN
1028003501	●	3/8 - 24 UNF	H3	3.543	0.740	1.377	0.381	0.286	0.438	3	Steam Oxide
1028003508	●	3/8 - 24 UNF	H3	3.543	0.740	1.377	0.381	0.286	0.438	3	TiCN
1028003601	●	3/8 - 24 UNF	H4	3.543	0.740	1.377	0.381	0.286	0.438	3	Steam Oxide
1028003608	●	3/8 - 24 UNF	H4	3.543	0.740	1.377	0.381	0.286	0.438	3	TiCN
1028003701	●	7/16 - 14 UNC	H3	3.937	0.858	1.291	0.323	0.242	0.406	3	Steam Oxide
1028003708	●	7/16 - 14 UNC	H3	3.937	0.858	1.291	0.323	0.242	0.406	3	TiCN
1028003801	●	7/16 - 14 UNC	H5	3.937	0.858	1.291	0.323	0.242	0.406	3	Steam Oxide
1028003808	●	7/16 - 14 UNC	H5	3.937	0.858	1.291	0.323	0.242	0.406	3	TiCN
1028003901	●	7/16 - 20 UNF	H3	3.937	0.858	1.291	0.323	0.242	0.406	3	Steam Oxide
1028003908	●	7/16 - 20 UNF	H3	3.937	0.858	1.291	0.323	0.242	0.406	3	TiCN
1028004001	●	7/16 - 20 UNF	H5	3.937	0.858	1.291	0.323	0.242	0.406	3	Steam Oxide
1028004008	●	7/16 - 20 UNF	H5	3.937	0.858	1.291	0.323	0.242	0.406	3	TiCN
1028004101	●	1/2 - 13 UNC	H3	4.331	0.921	1.354	0.367	0.275	0.438	3	Steam Oxide
1028004108	●	1/2 - 13 UNC	H3	4.331	0.921	1.354	0.367	0.275	0.438	3	TiCN
1028004201	●	1/2 - 13 UNC	H5	4.331	0.921	1.354	0.367	0.275	0.438	3	Steam Oxide
1028004208	●	1/2 - 13 UNC	H5	4.331	0.921	1.354	0.367	0.275	0.438	3	TiCN
1028004301	●	1/2 - 20 UNF	H3	3.937	0.921	1.354	0.367	0.275	0.438	3	Steam Oxide
1028004308	●	1/2 - 20 UNF	H3	3.937	0.921	1.354	0.367	0.275	0.438	3	TiCN
1028004401	●	1/2 - 20 UNF	H5	3.937	0.921	1.354	0.367	0.275	0.438	3	Steam Oxide
1028004408	●	1/2 - 20 UNF	H5	3.937	0.921	1.354	0.367	0.275	0.438	3	TiCN
1028004501	●	9/16 - 12 UNC	H3	4.331	0.921	1.472	0.429	0.322	0.500	3	Steam Oxide
1028004508	●	9/16 - 12 UNC	H3	4.331	1.000	1.472	0.429	0.322	0.500	3	TiCN
1028004601	●	9/16 - 12 UNC	H5	4.331	1.000	1.472	0.429	0.322	0.500	3	Steam Oxide
1028004608	●	9/16 - 12 UNC	H5	4.331	1.000	1.472	0.429	0.322	0.500	3	TiCN
1028004701	●	9/16 - 18 UNF	H3	3.937	1.000	1.472	0.429	0.322	0.500	3	Steam Oxide
1028004708	●	9/16 - 18 UNF	H3	3.937	1.000	1.472	0.429	0.322	0.500	3	TiCN
1028004801	●	9/16 - 18 UNF	H5	3.937	1.000	1.472	0.429	0.322	0.500	3	Steam Oxide
1028004808	●	9/16 - 18 UNF	H5	3.937	1.000	1.472	0.429	0.322	0.500	3	TiCN
1028004901	●	5/8 - 11 UNC	H3	4.331	1.091	1.563	0.480	0.360	0.563	3	Steam Oxide
1028004908	●	5/8 - 11 UNC	H3	4.331	1.091	1.563	0.480	0.360	0.563	3	TiCN
1028005001	●	5/8 - 11 UNC	H5	4.331	1.091	1.563	0.480	0.360	0.563	3	Steam Oxide
1028005008	●	5/8 - 11 UNC	H5	4.331	1.091	1.563	0.480	0.360	0.563	3	TiCN
1028005101	●	5/8 - 18 UNF	H3	3.937	1.091	1.563	0.480	0.360	0.563	3	Steam Oxide
1028005108	●	5/8 - 18 UNF	H3	3.937	1.091	1.563	0.480	0.360	0.563	3	TiCN
1028005201	●	5/8 - 18 UNF	H5	3.937	1.091	1.563	0.480	0.360	0.563	3	Steam Oxide

● Stocked ▲ Globally Stocked ○ Made to Order; contact an OSG representative for details

Note: For internal threads only.

 CONTINUED ➔ **HY5**

P					M			K	N		S	H				
Steel					Stainless Steel			Cast Iron	Non-Ferrous		HRSA		Hardened Steel			
Carbon Steel			Alloy Steel	Die Steel					Aluminum		Nickel Alloy	Titanium				
Low	Medium	High							6061	Casting	Inconel	6Al4V (30 HRC)				
1010 1018	1035 1045	1065	4140 4340	Die Steel	300	400	17-4 PH	Cast Iron	6061 7075	Casting	Inconel	6Al4V (30 HRC)	~35 HRC	35-45 HRC	45-50 HRC	50-70 HRC
○	⊗	⊗	⊗		○	○							○			
50-90 SPM	40-80 SPM	40-60 SPM	40-65 SPM	20-60 SPM	15-50 SPM	15-50 SPM	8-20 SPM	30-80 SPM					20-60 SPM			

○ Good ⊗ Best



List 10280 (Continued)

HY-PRO SIGMA



EDP Number		Thread Size	Thread Limit	Overall Length	Length of Cut	Neck Length	Shank Diameter	Square Width	Square Length	Number of Flutes	Surface Treatment
				L (Inch)	Lc (Inch)	L1 (Inch)	d (Inch)	k (Inch)	Lk (Inch)		
1028005208	●	5/8 - 18 UNF	H5	3.937	1.091	1.563	0.480	0.360	0.563	3	TiCN
1028005301	●	3/4 - 10 UNC	H3	4.921	1.201	1.713	0.590	0.442	0.688	3	Steam Oxide
1028005308	●	3/4 - 10 UNC	H3	4.921	1.201	1.713	0.590	0.442	0.688	3	TiCN
1028005401	●	3/4 - 10 UNC	H5	4.921	1.201	1.713	0.590	0.442	0.688	3	Steam Oxide
1028005408	●	3/4 - 10 UNC	H5	4.921	1.201	1.713	0.590	0.442	0.688	3	TiCN
1028005501	●	3/4 - 16 UNF	H3	4.331	1.201	1.713	0.590	0.442	0.688	3	Steam Oxide
1028005508	●	3/4 - 16 UNF	H3	4.331	1.201	1.713	0.590	0.442	0.688	3	TiCN
1028005601	●	3/4 - 16 UNF	H5	4.331	1.201	1.713	0.590	0.442	0.688	3	Steam Oxide
1028005608	●	3/4 - 16 UNF	H5	4.331	1.201	1.713	0.590	0.442	0.688	3	TiCN
1028005701	●	7/8 - 9 UNC	H4	5.512	1.335	1.886	0.697	0.523	0.720	3	Steam Oxide
1028005708	●	7/8 - 9 UNC	H4	5.512	1.335	1.886	0.697	0.523	0.720	3	TiCN
1028005801	●	7/8 - 9 UNC	H6	5.512	1.335	1.886	0.697	0.523	0.720	3	Steam Oxide
1028005808	●	7/8 - 9 UNC	H6	5.512	1.335	1.886	0.697	0.523	0.720	3	TiCN
1028005901	●	7/8 - 14 UNF	H4	4.921	1.335	1.886	0.697	0.523	0.720	3	Steam Oxide
1028005908	●	7/8 - 14 UNF	H4	4.921	1.335	1.886	0.697	0.523	0.720	3	TiCN
1028006001	●	7/8 - 14 UNF	H6	4.921	1.335	1.886	0.697	0.523	0.720	3	Steam Oxide
1028006008	●	7/8 - 14 UNF	H6	4.921	1.335	1.886	0.697	0.523	0.720	3	TiCN
1028006201	●	1 - 8 UNC	H4	6.299	1.500	2.091	0.800	0.600	0.813	3	Steam Oxide
1028006208	●	1 - 8 UNC	H4	6.299	1.500	2.091	0.800	0.600	0.813	3	TiCN
1028006101	●	1 - 8 UNC	H6	6.299	1.500	2.091	0.800	0.600	0.813	3	Steam Oxide
1028006108	●	1 - 8 UNC	H6	6.299	1.500	2.091	0.800	0.600	0.813	3	TiCN
1028006401	●	1 - 12 UNF	H4	5.512	1.500	2.091	0.800	0.600	0.813	3	Steam Oxide
1028006408	●	1 - 12 UNF	H4	5.512	1.500	2.091	0.800	0.600	0.813	3	TiCN
1028006301	●	1 - 12 UNF	H6	5.512	1.500	2.091	0.800	0.600	0.813	3	Steam Oxide
1028006308	●	1 - 12 UNF	H6	5.512	1.500	2.091	0.800	0.600	0.813	3	TiCN

● Stocked ▲ Globally Stocked ○ Made to Order; contact an OSG representative for details

Note: For internal threads only.



P					M			K	N		S		H			
Steel					Stainless Steel			Cast Iron	Non-Ferrous		HRSA		Hardened Steel			
Carbon Steel			Alloy Steel	Aluminum					Nickel Alloy	Titanium						
Low	Medium	High														
1010	1035	1065	4140	Die Steel	300	400	17-4 PH	6061 7075	Casting	Inconel	6Al4V (30 HRC)	~35 HRC	35-45 HRC	45-50 HRC	50-70 HRC	
1018	1045	1065	4340		300	400	17-4 PH	6061 7075	Casting	Inconel	6Al4V (30 HRC)	~35 HRC	35-45 HRC	45-50 HRC	50-70 HRC	
○	⊗	⊗	⊗	○	⊗	⊗	○	○				○				
50-90 SFM	40-80 SFM	40-60 SFM	40-65 SFM	20-60 SFM	15-50 SFM	15-50 SFM	8-20 SFM	30-80 SFM					20-60 SFM			

○ Good ○ Best



List 10289

HY-PRO SIGMA



EDP Number		Thread Size	Thread Limit	Overall Length	Length of Cut	Neck Length	Shank Diameter	Square Width	Square Length	Number of Flutes	Surface Treatment
				L (mm)	Lc (mm)	L1 (mm)	d (mm)	k (mm)	lk (mm)		
1028900001	●	M3 x 0.5	D3	56.00	6.00	18.10	3.58	2.79	4.76	3	Steam Oxide
1028900008	●	M3 x 0.5	D3	56.00	6.00	18.10	3.58	2.79	4.76	3	TiCN
1028900101	●	M3.5 x 0.6	D4	56.00	7.20	19.80	3.58	2.79	4.76	3	Steam Oxide
1028900108	●	M3.5 x 0.6	D4	56.00	7.20	19.80	3.58	2.79	4.76	3	TiCN
1028900201	●	M4 x 0.7	D4	63.00	8.30	21.00	4.93	3.33	6.35	3	Steam Oxide
1028900208	●	M4 x 0.7	D4	63.00	8.30	21.00	4.93	3.33	6.35	3	TiCN
1028900301	●	M5 x 0.8	D4	70.00	9.70	24.80	4.93	3.86	6.35	3	Steam Oxide
1028900308	●	M5 x 0.8	D4	70.00	9.70	24.80	4.93	3.86	6.35	3	TiCN
1028900401	●	M6 x 1	D5	80.00	11.90	29.70	6.48	4.85	7.94	3	Steam Oxide
1028900408	●	M6 x 1	D5	80.00	11.90	29.70	6.48	4.85	7.94	3	TiCN
1028900501	●	M7 x 1	D5	80.00	12.10	29.70	8.08	6.05	9.53	3	Steam Oxide
1028900508	●	M7 x 1	D5	80.00	12.10	29.70	8.08	6.05	9.53	3	TiCN
1028900601	●	M8 x 1	D5	90.00	15.00	34.80	8.08	6.05	9.53	3	Steam Oxide
1028900608	●	M8 x 1	D5	90.00	15.00	34.80	8.08	6.05	9.53	3	TiCN
1028900701	●	M8 x 1.25	D5	90.00	15.00	34.80	8.08	6.05	9.53	3	Steam Oxide
1028900708	●	M8 x 1.25	D5	90.00	15.00	34.80	8.08	6.05	9.53	3	TiCN
1028900801	●	M10 x 1.0	D5	90.00	18.00	34.80	9.68	7.26	11.11	3	Steam Oxide
1028900808	●	M10 x 1.0	D5	90.00	18.00	34.80	9.68	7.26	11.11	3	TiCN
1028900901	●	M10 x 1.25	D5	100.00	18.00	38.90	9.68	7.26	11.11	3	Steam Oxide
1028900908	●	M10 x 1.25	D5	100.00	18.00	38.90	9.68	7.26	11.11	3	TiCN
1028901001	●	M10 x 1.5	D6	100.00	18.00	38.90	9.68	7.26	11.11	3	Steam Oxide
1028901008	●	M10 x 1.5	D6	100.00	18.00	38.90	9.68	7.26	11.11	3	TiCN
1028901101	●	M12 x 1.25	D5	100.00	21.00	32.00	9.32	6.99	11.11	3	Steam Oxide
1028901108	●	M12 x 1.25	D5	100.00	21.00	32.00	9.32	6.99	11.11	3	TiCN
1028901201	●	M12 x 1.5	D6	100.00	21.00	32.00	9.32	6.99	11.11	3	Steam Oxide
1028901208	●	M12 x 1.5	D6	100.00	21.00	32.00	9.32	6.99	11.11	3	TiCN
1028901301	●	M12 x 1.75	D6	110.00	21.00	32.00	9.32	6.99	11.11	3	Steam Oxide
1028901308	●	M12 x 1.75	D6	110.00	21.00	32.00	9.32	6.99	11.11	3	TiCN
1028901401	●	M14 x 1.5	D6	100.00	24.00	36.00	10.90	8.18	12.70	4	Steam Oxide
1028901408	●	M14 x 1.5	D6	100.00	24.00	36.00	10.90	8.18	12.70	4	TiCN
1028901501	●	M14 x 2.0	D7	110.00	24.00	36.00	10.90	8.18	12.70	3	Steam Oxide
1028901508	●	M14 x 2.0	D7	110.00	24.00	36.00	10.90	8.18	12.70	3	TiCN
1028901601	●	M16 x 1.5	D6	100.00	24.00	36.00	12.19	9.14	14.29	4	Steam Oxide
1028901608	●	M16 x 1.5	D6	100.00	24.00	36.00	12.19	9.14	14.29	4	TiCN
1028901701	●	M16 x 2.0	D7	110.00	24.00	36.00	12.19	9.14	14.29	3	Steam Oxide
1028901708	●	M16 x 2.0	D7	110.00	24.00	36.00	12.19	9.14	14.29	3	TiCN
1028901801	●	M18 x 1.5	D6	110.00	30.00	43.00	13.77	10.31	15.88	4	Steam Oxide
1028901808	●	M18 x 1.5	D6	110.00	30.00	43.00	13.77	10.31	15.88	4	TiCN
1028901901	●	M18 x 2.5	D7	125.00	30.00	43.00	13.77	10.31	15.88	3	Steam Oxide
1028901908	●	M18 x 2.5	D7	125.00	30.00	43.00	13.77	10.31	15.88	3	TiCN
1028902001	●	M20 x 1.5	D6	125.00	30.00	44.00	16.56	12.42	17.46	4	Steam Oxide
1028902008	●	M20 x 1.5	D6	125.00	30.00	44.00	16.56	12.42	17.46	4	TiCN
1028902101	●	M20 x 2.5	D7	140.00	30.00	44.00	16.56	12.42	17.46	3	Steam Oxide
1028902108	●	M20 x 2.5	D7	140.00	30.00	44.00	16.56	12.42	17.46	3	TiCN

● Stocked ▲ Globally Stocked ○ Made to Order; contact an OSG representative for details

Note: For internal threads only.

CONTINUED 

P					M			K	N		S		H			
Steel					Stainless Steel			Cast Iron	Non-Ferrous		HRSA		Hardened Steel			
Carbon Steel			Alloy Steel	Die Steel					Aluminum		Nickel Alloy	Titanium				
Low	Medium	High							6061 7075	Casting	Inconel	6Al4V (30 HRC)				
1010	1035	1065	4140	Die Steel	300	400	17-4 PH	Cast Iron					~35 HRC	35-45 HRC	45-50 HRC	50-70 HRC
1018	1045	1065	4340													
○	⊗	⊗	⊗	○	⊗	⊗	○	○					○			
50-90 SFM	40-80 SFM	40-60 SFM	40-65 SFM	20-60 SFM	15-50 SFM	15-50 SFM	8-20 SFM	30-80 SFM					20-60 SFM			

○ Good ○ Best

List 10289 (Continued)

HY-PRO SIGMA



EDP Number		Thread Size	Thread Limit	Overall Length	Length of Cut	Neck Length	Shank Diameter	Square Width	Square Length	Number of Flutes	Surface Treatment
				L (mm)	Lc (mm)	L1 (mm)	d (mm)	k (mm)	lk (mm)		
1028902201	●	M22 x 1.5	D6	125.00	30.00	44.00	17.70	13.28	19.05	4	Steam Oxide
1028902208	●	M22 x 1.5	D6	125.00	30.00	44.00	17.70	13.28	19.05	4	TiCN
1028902301	●	M22 x 2.5	D8	140.00	30.00	44.00	17.70	13.28	19.05	4	Steam Oxide
1028902308	●	M22 x 2.5	D8	140.00	30.00	44.00	17.70	13.28	19.05	3	TiCN
1028902401	●	M24 x 1.5	D6	140.00	36.00	51.00	19.30	14.48	19.05	4	Steam Oxide
1028902408	●	M24 x 1.5	D6	140.00	36.00	51.00	19.30	14.48	19.05	4	TiCN
1028902501	●	M24 x 3.0	D8	160.00	36.00	51.00	19.30	14.48	19.05	3	Steam Oxide
1028902508	●	M24 x 3.0	D8	160.00	36.00	51.00	19.30	14.48	19.05	3	TiCN

● Stocked ▲ Globally Stocked ○ Made to Order; contact an OSG representative for details

Note: For internal threads only.

HYS

P					M			K	N		S		H			
Steel					Stainless Steel			Cast Iron	Non-Ferrous		HRSA		Hardened Steel			
Carbon Steel			Alloy Steel	Die Steel					Aluminum		Nickel Alloy	Titanium				
Low	Medium	High														
1010 1018	1035 1045	1065	4140 4340		300	400	17-4 PH		6061 7075	Casting	Inconel	6Al4V (30 HRC)	~35 HRC	35-45 HRC	45-50 HRC	50-70 HRC
○	⊗	⊗	⊗	○	⊗	⊗	○	○					○			
50-90 SFM	40-80 SFM	40-60 SFM	40-65 SFM	20-60 SFM	15-50 SFM	15-50 SFM	8-20 SFM	30-80 SFM					20-60 SFM			

○ Good ⊗ Best



List 10290

HY-PRO SIGMA



EDP Number		Thread Size	Thread Limit	Overall Length	Length of Cut	Neck Length	Shank Diameter	Square Width	Square Length	Number of Flutes	Surface Treatment
				L (Inch)	Lc (Inch)	L1 (Inch)	d (Inch)	k (Inch)	lk (Inch)		
1029000101	●	No. 2 - 56 UNC	H1	1.772	0.437	0.472	0.141	0.110	0.188	2	Steam Oxide
1029000108	●	No. 2 - 56 UNC	H1	1.772	0.437	0.472	0.141	0.110	0.188	2	TiCN
1029000001	●	No. 2 - 56 UNC	H2	1.772	0.437	0.472	0.141	0.110	0.188	2	Steam Oxide
1029000008	●	No. 2 - 56 UNC	H2	1.772	0.437	0.472	0.141	0.110	0.188	2	TiCN
1029000301	●	No. 2 - 64 UNF	H1	1.772	0.437	0.472	0.141	0.110	0.188	2	Steam Oxide
1029000308	●	No. 2 - 64 UNF	H1	1.772	0.437	0.472	0.141	0.110	0.188	2	TiCN
1029000201	●	No. 2 - 64 UNF	H2	1.772	0.437	0.472	0.141	0.110	0.188	2	Steam Oxide
1029000208	●	No. 2 - 64 UNF	H2	1.772	0.437	0.472	0.141	0.110	0.188	2	TiCN
1029000501	●	No. 3 - 48 UNC	H1	1.969	0.496	0.531	0.141	0.110	0.188	2	Steam Oxide
1029000508	●	No. 3 - 48 UNC	H1	1.969	0.496	0.531	0.141	0.110	0.188	2	TiCN
1029000401	●	No. 3 - 48 UNC	H2	1.969	0.496	0.531	0.141	0.110	0.188	2	Steam Oxide
1029000408	●	No. 3 - 48 UNC	H2	1.969	0.496	0.531	0.141	0.110	0.188	2	TiCN
1029000701	●	No. 3 - 56 UNF	H1	1.969	0.496	0.531	0.141	0.110	0.188	2	Steam Oxide
1029000708	●	No. 3 - 56 UNF	H1	1.969	0.496	0.531	0.141	0.110	0.188	2	TiCN
1029000601	●	No. 3 - 56 UNF	H2	1.969	0.496	0.531	0.141	0.110	0.188	2	Steam Oxide
1029000608	●	No. 3 - 56 UNF	H2	1.969	0.496	0.531	0.141	0.110	0.188	2	TiCN
1029000801	●	No. 4 - 40 UNC	H2	2.205	0.196	0.74	0.141	0.110	0.188	3	Steam Oxide
1029000808	●	No. 4 - 40 UNC	H2	2.205	0.196	0.74	0.141	0.110	0.188	3	TiCN
1029001001	●	No. 4 - 48 UNF	H1	2.205	0.196	0.74	0.141	0.110	0.188	3	Steam Oxide
1029001008	●	No. 4 - 48 UNF	H1	2.205	0.196	0.74	0.141	0.110	0.188	3	TiCN
1029000901	●	No. 4 - 48 UNF	H2	2.205	0.196	0.74	0.141	0.110	0.188	3	Steam Oxide
1029000908	●	No. 4 - 48 UNF	H2	2.205	0.196	0.74	0.141	0.110	0.188	3	TiCN
1029001101	●	No. 5 - 40 UNC	H2	2.205	0.200	0.78	0.141	0.110	0.188	3	Steam Oxide
1029001108	●	No. 5 - 40 UNC	H2	2.205	0.200	0.78	0.141	0.110	0.188	3	TiCN
1029001301	●	No. 5 - 48 UNF	H1	2.205	0.200	0.78	0.141	0.110	0.188	3	Steam Oxide
1029001308	●	No. 5 - 48 UNF	H1	2.205	0.200	0.78	0.141	0.110	0.188	3	TiCN
1029001201	●	No. 5 - 48 UNF	H2	2.205	0.200	0.78	0.141	0.110	0.188	3	Steam Oxide
1029001208	●	No. 5 - 48 UNF	H2	2.205	0.200	0.78	0.141	0.110	0.188	3	TiCN
1029001401	●	No. 6 - 32 UNC	H2	2.205	0.248	0.783	0.141	0.110	0.188	3	Steam Oxide
1029001408	●	No. 6 - 32 UNC	H2	2.205	0.248	0.783	0.141	0.110	0.188	3	TiCN
1029001501	●	No. 6 - 32 UNC	H3	2.205	0.248	0.783	0.141	0.110	0.188	3	Steam Oxide
1029001508	●	No. 6 - 32 UNC	H3	2.205	0.248	0.783	0.141	0.110	0.188	3	TiCN
1029001601	●	No. 6 - 40 UNF	H2	2.205	0.248	0.783	0.141	0.110	0.188	3	Steam Oxide
1029001608	●	No. 6 - 40 UNF	H2	2.205	0.248	0.783	0.141	0.110	0.188	3	TiCN
1029001701	●	No. 8 - 32 UNC	H2	2.481	0.251	0.826	0.168	0.131	0.250	3	Steam Oxide
1029001708	●	No. 8 - 32 UNC	H2	2.481	0.251	0.826	0.168	0.131	0.250	3	TiCN
1029001801	●	No. 8 - 32 UNC	H3	2.481	0.251	0.826	0.168	0.131	0.250	3	Steam Oxide
1029001808	●	No. 8 - 32 UNC	H3	2.481	0.251	0.826	0.168	0.131	0.250	3	TiCN
1029001901	●	No. 8 - 36 UNF	H2	2.481	0.251	0.826	0.168	0.131	0.250	3	Steam Oxide
1029001908	●	No. 8 - 36 UNF	H2	2.481	0.251	0.826	0.168	0.131	0.250	3	TiCN
1029002001	●	No. 10 - 24 UNC	H3	2.756	0.326	0.976	0.194	0.152	0.250	3	Steam Oxide
1029002008	●	No. 10 - 24 UNC	H3	2.756	0.326	0.976	0.194	0.152	0.250	3	TiCN
1029002101	●	No. 10 - 32 UNF	H2	2.756	0.326	0.976	0.194	0.152	0.250	3	Steam Oxide
1029002108	●	No. 10 - 32 UNF	H2	2.756	0.326	0.976	0.194	0.152	0.250	3	TiCN

● Stocked ▲ Globally Stocked ○ Made to Order; contact an OSG representative for details

Note: For internal threads only.

CONTINUED ➔ **HY5**

P					M			K	N		S		H			
Steel					Stainless Steel			Cast Iron	Non-Ferrous		HRSA		Hardened Steel			
Carbon Steel			Alloy Steel	Die Steel					Aluminum		Nickel Alloy	Titanium				
Low	Medium	High							6061 7075	Casting	Inconel	6Al4V (30 HRC)				
1010 1018	1035 1045	1065	4140 4340	Die Steel	300	400	17-4 PH	Cast Iron					~35 HRC	35-45 HRC	45-50 HRC	50-70 HRC
○	⊗	⊗	⊗		○	⊗	○		○				○			
50-90 SFM	40-80 SFM	40-60 SFM	40-65 SFM	20-60 SFM	15-50 SFM	15-50 SFM	8-20 SFM	30-80 SFM					20-60 SFM			

○ Good ○ Best



List 10290 (Continued)

HY-PRO SIGMA



EDP Number		Thread Size	Thread Limit	Overall Length	Length of Cut	Neck Length	Shank Diameter	Square Width	Square Length	Number of Flutes	Surface Treatment
				L (Inch)	Lc (Inch)	L1 (Inch)	d (Inch)	k (Inch)	lk (Inch)		
1029002201	●	No. 10 - 32 UNF	H3	2.756	0.326	0.976	0.194	0.152	0.250	3	Steam Oxide
1029002208	●	No. 10 - 32 UNF	H3	2.756	0.326	0.976	0.194	0.152	0.250	3	TiCN
1029002301	●	No. 12 - 24 UNC	H3	3.150	0.330	1.177	0.220	0.165	0.281	3	Steam Oxide
1029002308	●	No. 12 - 24 UNC	H3	3.150	0.330	1.177	0.220	0.165	0.281	3	TiCN
1029002401	●	No. 12 - 28 UNF	H3	3.150	0.330	1.177	0.220	0.165	0.281	3	Steam Oxide
1029002408	●	No. 12 - 28 UNF	H3	3.150	0.330	1.177	0.220	0.165	0.281	3	TiCN
1029002501	●	1/4 - 20 UNC	H3	3.150	0.397	1.177	0.255	0.191	0.313	3	Steam Oxide
1029002508	●	1/4 - 20 UNC	H3	3.150	0.397	1.177	0.255	0.191	0.313	3	TiCN
1029002601	●	1/4 - 20 UNC	H5	3.150	0.397	1.177	0.255	0.191	0.313	3	Steam Oxide
1029002608	●	1/4 - 20 UNC	H5	3.150	0.397	1.177	0.255	0.191	0.313	3	TiCN
1029002701	●	1/4 - 28 UNF	H3	3.150	0.397	1.177	0.255	0.191	0.313	3	Steam Oxide
1029002708	●	1/4 - 28 UNF	H3	3.150	0.397	1.177	0.255	0.191	0.313	3	TiCN
1029002801	●	1/4 - 28 UNF	H4	3.150	0.397	1.177	0.255	0.191	0.313	3	Steam Oxide
1029002808	●	1/4 - 28 UNF	H4	3.150	0.397	1.177	0.255	0.191	0.313	3	TiCN
1029002901	●	5/16 - 18 UNC	H3	3.543	0.444	1.377	0.318	0.238	0.375	3	Steam Oxide
1029002908	●	5/16 - 18 UNC	H3	3.543	0.444	1.377	0.318	0.238	0.375	3	TiCN
1029003001	●	5/16 - 18 UNC	H5	3.543	0.444	1.377	0.318	0.238	0.375	3	Steam Oxide
1029003008	●	5/16 - 18 UNC	H5	3.543	0.444	1.377	0.318	0.238	0.375	3	TiCN
1029003101	●	5/16 - 24 UNF	H3	3.543	0.444	1.377	0.318	0.238	0.375	3	Steam Oxide
1029003108	●	5/16 - 24 UNF	H3	3.543	0.444	1.377	0.318	0.238	0.375	3	TiCN
1029003201	●	5/16 - 24 UNF	H4	3.543	0.444	1.377	0.318	0.238	0.375	3	Steam Oxide
1029003208	●	5/16 - 24 UNF	H4	3.543	0.444	1.377	0.318	0.238	0.375	3	TiCN
1029003301	●	3/8 - 16 UNC	H3	3.937	0.500	1.535	0.381	0.286	0.438	3	Steam Oxide
1029003308	●	3/8 - 16 UNC	H3	3.937	0.500	1.535	0.381	0.286	0.438	3	TiCN
1029003401	●	3/8 - 16 UNC	H5	3.937	0.500	1.535	0.381	0.286	0.438	3	Steam Oxide
1029003408	●	3/8 - 16 UNC	H5	3.937	0.500	1.535	0.381	0.286	0.438	3	TiCN
1029003501	●	3/8 - 24 UNF	H3	3.543	0.500	1.377	0.381	0.286	0.438	3	Steam Oxide
1029003508	●	3/8 - 24 UNF	H3	3.543	0.500	1.377	0.381	0.286	0.438	3	TiCN
1029003601	●	3/8 - 24 UNF	H4	3.543	0.500	1.377	0.381	0.286	0.438	3	Steam Oxide
1029003608	●	3/8 - 24 UNF	H4	3.543	0.500	1.377	0.381	0.286	0.438	3	TiCN
1029003701	●	7/16 - 14 UNC	H3	3.937	0.570	1.712	0.323	0.242	0.406	3	Steam Oxide
1029003708	●	7/16 - 14 UNC	H3	3.937	0.570	1.712	0.323	0.242	0.406	3	TiCN
1029003801	●	7/16 - 14 UNC	H5	3.937	0.570	1.712	0.323	0.242	0.406	3	Steam Oxide
1029003808	●	7/16 - 14 UNC	H5	3.937	0.570	1.712	0.323	0.242	0.406	3	TiCN
1029003901	●	7/16 - 20 UNF	H3	3.937	0.570	1.712	0.323	0.242	0.406	3	Steam Oxide
1029003908	●	7/16 - 20 UNF	H3	3.937	0.570	1.712	0.323	0.242	0.406	3	TiCN
1029004001	●	7/16 - 20 UNF	H5	3.937	0.570	1.712	0.323	0.242	0.406	3	Steam Oxide
1029004008	●	7/16 - 20 UNF	H5	3.937	0.570	1.712	0.323	0.242	0.406	3	TiCN
1029004101	●	1/2 - 13 UNC	H3	4.331	0.614	1.933	0.367	0.275	0.438	3	Steam Oxide
1029004108	●	1/2 - 13 UNC	H3	4.331	0.614	1.933	0.367	0.275	0.438	3	TiCN
1029004201	●	1/2 - 13 UNC	H5	4.331	0.614	1.933	0.367	0.275	0.438	3	Steam Oxide
1029004208	●	1/2 - 13 UNC	H5	4.331	0.614	1.933	0.367	0.275	0.438	3	TiCN
1029004301	●	1/2 - 20 UNF	H3	4.331	0.614	1.933	0.367	0.275	0.438	3	Steam Oxide
1029004308	●	1/2 - 20 UNF	H3	4.331	0.614	1.933	0.367	0.275	0.438	3	TiCN
1029004401	●	1/2 - 20 UNF	H5	3.937	0.614	1.933	0.367	0.275	0.438	3	Steam Oxide
1029004408	●	1/2 - 20 UNF	H5	3.937	0.614	1.933	0.367	0.275	0.438	3	TiCN
1029004501	●	9/16 - 12 UNC	H3	4.331	0.665	1.972	0.429	0.322	0.500	4	Steam Oxide
1029004508	●	9/16 - 12 UNC	H3	4.331	0.665	1.972	0.429	0.322	0.500	4	TiCN
1029004601	●	9/16 - 12 UNC	H5	4.331	0.665	1.972	0.429	0.322	0.500	4	Steam Oxide
1029004608	●	9/16 - 12 UNC	H5	4.331	0.665	1.972	0.429	0.322	0.500	4	TiCN
1029004701	●	9/16 - 18 UNF	H3	3.937	0.665	1.972	0.429	0.322	0.500	4	Steam Oxide
1029004708	●	9/16 - 18 UNF	H3	3.937	0.665	1.972	0.429	0.322	0.500	4	TiCN
1029004801	●	9/16 - 18 UNF	H5	3.937	0.665	1.972	0.429	0.322	0.500	4	Steam Oxide

● Stocked ▲ Globally Stocked ○ Made to Order; contact an OSG representative for details

Note: For internal threads only.



List 10290 (Continued)

HY-PRO SIGMA



EDP Number		Thread Size	Thread Limit	Overall Length	Length of Cut	Neck Length	Shank Diameter	Square Width	Square Length	Number of Flutes	Surface Treatment
				L (Inch)	Lc (Inch)	L1 (Inch)	d (Inch)	k (Inch)	lk (Inch)		
1029004808	●	9/16 - 18 UNF	H5	3.937	0.665	1.972	0.429	0.322	0.500	4	TiCN
1029004901	●	5/8 - 11 UNC	H3	4.331	0.728	2.125	0.480	0.360	0.563	4	Steam Oxide
1029004908	●	5/8 - 11 UNC	H3	4.331	0.728	2.125	0.480	0.360	0.563	4	TiCN
1029005001	●	5/8 - 11 UNC	H5	4.331	0.728	2.125	0.480	0.360	0.563	4	Steam Oxide
1029005008	●	5/8 - 11 UNC	H5	4.331	0.728	2.125	0.480	0.360	0.563	4	TiCN
1029005101	●	5/8 - 18 UNF	H3	3.937	0.728	2.125	0.480	0.360	0.563	4	Steam Oxide
1029005108	●	5/8 - 18 UNF	H3	3.937	0.728	2.125	0.480	0.360	0.563	4	TiCN
1029005201	●	5/8 - 18 UNF	H5	3.937	0.728	2.125	0.480	0.360	0.563	4	Steam Oxide
1029005208	●	5/8 - 18 UNF	H5	3.937	0.728	2.125	0.480	0.360	0.563	4	TiCN
1029005301	●	3/4 - 10 UNC	H3	4.921	0.799	2.433	0.590	0.442	0.688	4	Steam Oxide
1029005308	●	3/4 - 10 UNC	H3	4.921	0.799	2.433	0.590	0.442	0.688	4	TiCN
1029005401	●	3/4 - 10 UNC	H5	4.921	0.799	2.433	0.590	0.442	0.688	4	Steam Oxide
1029005408	●	3/4 - 10 UNC	H5	4.921	0.799	2.433	0.590	0.442	0.688	4	TiCN
1029005501	●	3/4 - 16 UNF	H3	4.331	0.799	2.433	0.590	0.442	0.688	4	Steam Oxide
1029005508	●	3/4 - 16 UNF	H3	4.331	0.799	2.433	0.590	0.442	0.688	4	TiCN
1029005601	●	3/4 - 16 UNF	H5	4.331	0.818	2.433	0.590	0.442	0.688	4	Steam Oxide
1029005608	●	3/4 - 16 UNF	H5	4.331	0.818	2.433	0.590	0.442	0.688	4	TiCN
1029005701	●	7/8 - 9 UNC	H4	5.512	0.889	2.653	0.697	0.523	0.720	4	Steam Oxide
1029005708	●	7/8 - 9 UNC	H4	5.512	0.889	2.653	0.697	0.523	0.720	4	TiCN
1029005801	●	7/8 - 9 UNC	H6	5.512	0.889	2.653	0.697	0.523	0.720	4	Steam Oxide
1029005808	●	7/8 - 9 UNC	H6	5.512	0.889	2.653	0.697	0.523	0.720	4	TiCN
1029005901	●	7/8 - 14 UNF	H4	4.921	0.889	2.653	0.697	0.523	0.720	4	Steam Oxide
1029005908	●	7/8 - 14 UNF	H4	4.921	0.889	2.653	0.697	0.523	0.720	4	TiCN
1029006001	●	7/8 - 14 UNF	H6	4.921	0.889	2.653	0.697	0.523	0.720	4	Steam Oxide
1029006008	●	7/8 - 14 UNF	H6	4.921	0.889	2.653	0.697	0.523	0.720	4	TiCN
1029006201	●	1 - 8 UNC	H4	6.299	1.000	3.012	0.800	0.600	0.813	4	Steam Oxide
1029006208	●	1 - 8 UNC	H4	6.299	1.000	3.012	0.800	0.600	0.813	4	TiCN
1029006101	●	1 - 8 UNC	H6	6.299	1.000	3.012	0.800	0.600	0.813	4	Steam Oxide
1029006108	●	1 - 8 UNC	H6	6.299	1.000	3.012	0.800	0.600	0.813	4	TiCN
1029006401	●	1 - 12 UNF	H4	5.512	1.000	3.012	0.800	0.600	0.813	4	Steam Oxide
1029006408	●	1 - 12 UNF	H4	5.512	1.000	3.012	0.800	0.600	0.813	4	TiCN
1029006301	●	1 - 12 UNF	H6	5.512	1.000	3.012	0.800	0.600	0.813	4	Steam Oxide
1029006308	●	1 - 12 UNF	H6	5.512	1.000	3.012	0.800	0.600	0.813	4	TiCN

● Stocked ▲ Globally Stocked ○ Made to Order; contact an OSG representative for details

Note: For internal threads only.



P					M			K	N		S		H				
Steel					Stainless Steel			Cast Iron	Non-Ferrous		HRSA		Hardened Steel				
Carbon Steel			Alloy Steel	Aluminum					Nickel Alloy	Titanium							
Low	Medium	High															
1010	1035	1065	4140	Die Steel	300	400	17-4 PH		6061	Casting	Inconel	6Al4V (30 HRC)	~35 HRC	35-45 HRC	45-50 HRC	50-70 HRC	
1018	1045		4340														
○	⊗	⊗	⊗	○	⊗	⊗	○	○					○				
50-90 SFM	40-80 SFM	40-60 SFM	40-65 SFM	20-60 SFM	15-50 SFM	15-50 SFM	8-20 SFM	30-80 SFM					20-60 SFM				

○ Good ⊗ Best

List 10299

HY-PRO SIGMA



EDP Number		Thread Size	Thread Limit	Overall Length	Length of Cut	Neck Length	Shank Diameter	Square Width	Square Length	Number of Flutes	Surface Treatment
				L (mm)	Lc (mm)	L1 (mm)	d (mm)	k (mm)	Ik (mm)		
1029900001	●	M3 x 0.5	D3	56.00	4.08	18.00	3.58	2.79	4.76	3	Steam Oxide
1029900008	●	M3 x 0.5	D3	56.00	4.08	18.00	3.58	2.79	4.76	3	TiCN
1029900101	●	M3.5 x 0.6	D4	56.00	4.08	20.00	3.58	2.79	4.76	3	Steam Oxide
1029900108	●	M3.5 x 0.6	D4	56.00	4.08	20.00	3.58	2.79	4.76	3	TiCN
1029900201	●	M4 x 0.7	D4	63.00	4.80	20.90	4.93	3.33	6.35	3	Steam Oxide
1029900208	●	M4 x 0.7	D4	63.00	4.80	20.90	4.93	3.33	6.35	3	TiCN
1029900301	●	M5 x 0.8	D4	70.00	5.58	25.10	4.93	3.86	6.35	3	Steam Oxide
1029900308	●	M5 x 0.8	D4	70.00	5.58	25.10	4.93	3.86	6.35	3	TiCN
1029900401	●	M6 x 1	D5	80.00	8.00	29.90	6.48	4.85	7.94	3	Steam Oxide
1029900408	●	M6 x 1	D5	80.00	8.00	29.90	6.48	4.85	7.94	3	TiCN
1029900501	●	M7 x 1	D5	80.00	8.00	30.00	8.08	6.05	9.53	3	Steam Oxide
1029900508	●	M7 x 1	D5	80.00	8.00	30.00	8.08	6.05	9.53	3	TiCN
1029900601	●	M8 x 1	D5	90.00	10.00	35.00	8.08	6.05	9.53	3	Steam Oxide
1029900608	●	M8 x 1	D5	90.00	10.00	35.00	8.08	6.05	9.53	3	TiCN
1029900701	●	M8 x 1.25	D5	90.00	10.00	35.00	8.08	6.05	9.53	3	Steam Oxide
1029900708	●	M8 x 1.25	D5	90.00	10.00	35.00	8.08	6.05	9.53	3	TiCN
1029900801	●	M10 x 1.0	D5	90.00	11.98	35.00	9.68	7.26	11.11	3	Steam Oxide
1029900808	●	M10 x 1.0	D5	90.00	11.98	35.00	9.68	7.26	11.11	3	TiCN
1029900901	●	M10 x 1.25	D5	100.00	11.98	39.00	9.68	7.26	11.11	3	Steam Oxide
1029900908	●	M10 x 1.25	D5	100.00	11.98	39.00	9.68	7.26	11.11	3	TiCN
1029901001	●	M10 x 1.5	D6	100.00	11.98	39.00	9.68	7.26	11.11	3	Steam Oxide
1029901008	●	M10 x 1.5	D6	100.00	11.98	39.00	9.68	7.26	11.11	3	TiCN
1029901101	●	M12 x 1.25	D5	100.00	13.99	49.10	9.32	6.99	11.11	3	Steam Oxide
1029901108	●	M12 x 1.25	D5	100.00	13.99	49.10	9.32	6.99	11.11	3	TiCN
1029901201	●	M12 x 1.5	D6	100.00	13.99	49.10	9.32	6.99	11.11	3	Steam Oxide
1029901208	●	M12 x 1.5	D6	100.00	13.99	49.10	9.32	6.99	11.11	3	TiCN
1029901301	●	M12 x 1.75	D6	110.00	13.99	49.10	9.32	6.99	11.11	3	Steam Oxide
1029901308	●	M12 x 1.75	D6	110.00	13.99	49.10	9.32	6.99	11.11	3	TiCN
1029901401	●	M14 x 1.5	D6	100.00	16.00	50.10	10.90	8.18	12.70	3	Steam Oxide
1029901408	●	M14 x 1.5	D6	100.00	16.00	50.10	10.90	8.18	12.70	3	TiCN
1029901501	●	M14 x 2.0	D7	110.00	16.00	50.10	10.90	8.18	12.70	3	Steam Oxide
1029901508	●	M14 x 2.0	D7	110.00	16.00	50.10	10.90	8.18	12.70	3	TiCN
1029901601	●	M16 x 1.5	D6	100.00	16.00	54.00	12.19	9.14	14.29	3	Steam Oxide
1029901608	●	M16 x 1.5	D6	100.00	16.00	54.00	12.19	9.14	14.29	3	TiCN
1029901701	●	M16 x 2.0	D7	110.00	16.00	54.00	12.19	9.14	14.29	3	Steam Oxide
1029901708	●	M16 x 2.0	D7	110.00	16.00	54.00	12.19	9.14	14.29	3	TiCN
1029901801	●	M18 x 1.5	D6	110.00	19.98	55.00	13.77	10.31	15.88	4	Steam Oxide
1029901808	●	M18 x 1.5	D6	110.00	19.98	55.00	13.77	10.31	15.88	4	TiCN
1029901901	●	M18 x 2.5	D7	125.00	19.98	55.00	13.77	10.31	15.88	4	Steam Oxide
1029901908	●	M18 x 2.5	D7	125.00	19.98	55.00	13.77	10.31	15.88	4	TiCN
1029902001	●	M20 x 1.5	D6	125.00	19.98	61.80	16.56	12.42	17.46	4	Steam Oxide
1029902008	●	M20 x 1.5	D6	125.00	19.98	61.80	16.56	12.42	17.46	4	TiCN
1029902101	●	M20 x 2.5	D7	140.00	19.98	61.80	16.56	12.42	17.46	4	Steam Oxide
1029902108	●	M20 x 2.5	D7	140.00	19.98	61.80	16.56	12.42	17.46	4	TiCN
1029902201	●	M22 x 1.5	D6	125.00	19.98	67.40	17.70	13.28	19.05	4	Steam Oxide
1029902208	●	M22 x 1.5	D6	125.00	19.98	67.40	17.70	13.28	19.05	4	TiCN
1029902301	●	M22 x 2.5	D8	140.00	19.98	67.40	17.70	13.28	19.05	4	Steam Oxide
1029902308	●	M22 x 2.5	D8	140.00	19.98	67.40	17.70	13.28	19.05	4	TiCN
1029902401	●	M24 x 1.5	D6	140.00	24.00	68.40	19.30	14.48	19.05	4	Steam Oxide

● Stocked ▲ Globally Stocked ○ Made to Order; contact an OSG representative for details

Note: For internal threads only.

HYS



List 10299 (Continued)

HY-PRO SIGMA



EDP Number		Thread Size	Thread Limit	Overall Length	Length of Cut	Neck Length	Shank Diameter	Square Width	Square Length	Number of Flutes	Surface Treatment
				L (mm)	Lc (mm)	L1 (mm)	d (mm)	k (mm)	lk (mm)		
1029902408	●	M24 x 1.5	D6	140.00	24.00	68.40	19.30	14.48	19.05	4	TiCN
1029902501	●	M24 x 3.0	D8	160.00	24.00	68.40	19.30	14.48	19.05	4	Steam Oxide
1029902508	●	M24 x 3.0	D8	160.00	24.00	68.40	19.30	14.48	19.05	4	TiCN

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Note: For internal threads only.

HYS

P					M			K	N		S	H				
Steel					Stainless Steel			Cast Iron	Non-Ferrous		HRSA		Hardened Steel			
Carbon Steel			Alloy Steel	Die Steel					Aluminum		Nickel Alloy	Titanium				
Low	Medium	High							300	400	17-4 PH	6061 7075	Casting	Inconel	6Al4V (30 HRC)	~35 HRC
1010 1018	1035 1045	1065	4140 4340		300	400	17-4 PH						~35 HRC	35-45 HRC	45-50 HRC	50-70 HRC
○	⊗	⊗	⊗	○	⊗	⊗	○	○					○			
50-90 SFM	40-80 SFM	40-60 SFM	40-65 SFM	20-60 SFM	15-50 SFM	15-50 SFM	8-20 SFM	30-80 SFM					20-60 SFM			

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