



TSD 6208 B

# PLANT STANDARD BHOPAL

BP 684 1126

Rev. No. 02

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SUPERSEDES

BP 6841126 (Rev. 01)

## TAPPING ADAPTORS - ASQUITH

### 1. SCOPE

This standard covers dimensions and other requirements of Tapping Adaptors for 'Asquith' Tapping Attachments.

### 2. DESIGNATION

A Tapping Adaptor for M10 / P $\frac{1}{8}$  size taps with 6.30 mm driving square and suitable for use on Model No. 2VT of Asquith Tapping Attachment shall be designated as:-

2.1 On Indents - Tapping Adaptor M10 x 6.30 driving square for Model No. 2 VT Tapping Attachment of M/s William Asquith, England - BP 684 11 26.

\* 2.2 For Issuing Enquiries and Purchase Orders - Delete the factory standard No. from the above designation and add the information given under clause-3.

2.3 Abbreviated Description - TAPPING ADPTR M10x6.30 -2VT

### 3. COMPLIANCE WITH STANDARDS

3.1 Dimensions, Tolerances & Material etc. - As per Manufacturer's standard.

### 4. NOTE

\* 4.1 Based on the development and actual past performance, it is recommended to procure this item only from the following suppliers:-

4.1.1 Indigenous - M/s IMI Ahmedabad.

4.1.2 Imported - M/S William Asquith, England.

4.2 For 'Asquith' Tapping Attachments refer Plant Standard BP 684 17 02.

4.3 This standard incorporates the recommendations of Tool Standardization Committee.

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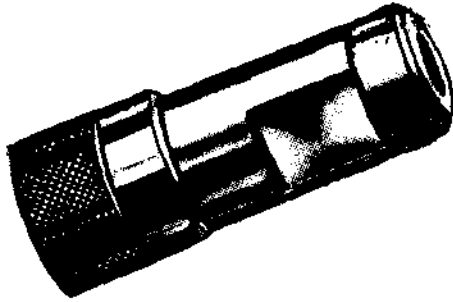
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STOCKING/USER DEPARTMENTS IS SHOWN  
AGAINST EACH SIZE.

- ⊗ Denotes proposed stock size.
- Denotes stock size.
- △ Denotes non-preferred size,  
stocked for the time being only.

All dimensions are in mm.

| SIZE<br>(TAP SIZE)        |                                   | TAP DIMENSIONS |                |      | MODEL NO.<br>OF ASQUITH TAPP-<br>ING ATTA-<br>CHMENT ON<br>(WHICH<br>ADAPTORS<br>ARE TO BE<br>USED) | PROPO-<br>SED/<br>STOCK<br>SIZE | 12 DIGIT CODE<br>NO. | STOCK-<br>ING/<br>USER<br>DEPT. |
|---------------------------|-----------------------------------|----------------|----------------|------|---|---------------------------------|----------------------|---------------------------------|
| METRIC<br>COARSE<br>PITCH | METRIC<br>PIPE<br>(PARA-<br>LLEL) | SHANK<br>DIA   | DRIVING SQUARE |      |   |                                 |                      |                                 |
|                           |                                   |                |                | SIDE | LENGTH  |                                 |                      |                                 |
| M6                        | -                                 | 4.50           | 3.55           | 6    | 2VT   | ●                               | BP 6841126992        | CTX                             |
| M8                        | -                                 | 6.30           | 5.00           | 8    | 2VT   | ●                               | BP 6841126980        | CTX                             |
| M10                       | -                                 | 7.10           | 5.60           | 8    | 2VT   |                                 |                      |                                 |
|                           |                                   |                |                |      | 3AVT  |                                 |                      |                                 |
| M10                       | P <sup>1</sup> / <sub>8</sub>     | 8.00           | 6.30           | 9    | 2VT   | ●                               | BP 6841126955        | CTX                             |
|                           |                                   |                |                |      | 3AVT  | ●                               | BP 6841126947        | CTX                             |
| M12                       | -                                 | 9.00           | 7.10           | 10   | 2VT   | ●                               | BP 6841126939        | CTX                             |
|                           |                                   |                |                |      | 3AVT  | ●                               | BP 6841126920        | CTX                             |
| -                         | P <sup>1</sup> / <sub>4</sub>     | 10.00          | 8.00           | 11   | 2VT   | ●                               | BP 6841126912        | CTX                             |
| M16                       | P <sup>3</sup> / <sub>8</sub>     | 12.50          | 10.00          | 13   | 2VT   | ●                               | BP 6841126904        | CTX                             |
|                           |                                   |                |                |      | 3AVT  | ●                               | BP 6841126890        | CTX                             |
| M20                       | -                                 | 14.00          | 11.20          | 14   | 2VT   | ●                               | BP 6841126882        | CTX                             |
|                           |                                   |                |                |      | 3AVT  | ●                               | BP 6841126874        | CTX                             |
|                           |                                   |                |                |      | 4VT   | ●                               | BP 6841126866        | CTX                             |
| -                         | P <sup>1</sup> / <sub>2</sub>     | 16.00          | 12.50          | 16   | 3AVT  | ●                               | BP 6841126808        | CTX                             |
| M24                       | -                                 | 18.00          | 14.00          | 18   | 3AVT  | ●                               | BP 6841126840        | CTX                             |
|                           |                                   |                |                |      | 4VT   | ●                               | BP 6841126831        | CTX                             |
| M30                       | P <sup>3</sup> / <sub>4</sub>     | 20.00          | 16.00          | 20   | 3AVT  | ●                               | BP 6841126823        | CTX                             |
|                           |                                   |                |                |      | 4VT   | ●                               | BP 6841126815        | WTM                             |
| M36                       | P <sup>1</sup>                    | 25.00          | 20.00          | 24   | 4VT   | ●                               | BP 6841126807        | CTX                             |
| M42                       | -                                 | 28.00          | 22.40          | 26   | 4VT   | ●                               | BP 6841126793        | PIM/<br>HQ                      |
| M48                       | P <sup>1</sup> / <sub>4</sub>     | 31.50          | 25.00          | 28   | 4VT   | ●                               | BP 6841126785        | CTX                             |
| M56                       | P <sup>1</sup> / <sub>2</sub>     | 35.50          | 28.00          | 31   | 4VT   | ●                               | BP 6841126777        | CTX                             |