



REGAL



CUTTING TOOLS

SPECIAL TAPS
CUSTOM TAPS

MADE IN U.S.A.

Effective June 1, 2019



INNOVATION BY DESIGN

We at Regal Cutting Tools are extremely excited to introduce the 2018 edition of our Popular Special Taps catalog. Included are many unique additions based on our distributor requests to what is already considered the most extensive special tap offering in the world. Micro-finish edge prep is now applied to all taps under one inch, which greatly improves thread quality and extends tool life.

Regal recently introduced our Standard SuperTuf Material Specific tap line. We now offer custom-designed material-specific taps in either USCTI 302A or DIN/ANSI standards. A variety of performance steel alloys are utilized, and taps are designed using our proprietary in-house CAD system, ensuring that you receive the optimum tap for your toughest jobs.

Within ten days, that's right, TEN days, we will ship material-specific taps coated to your exact requirements. This enhances our current 24-hour program and adds another dimension to Regal's outstanding commitment to service.

The custom SuperTuf program is possible only because of the dedication of everyone involved, from Jeannie (34 years of service) in the blank department to Dan (41 years) in our in-house surface and heat treat systems to Tom (34 years) in fluting and Donny (34 years) in our CNC threading operations. Youth has picked up this commitment, too. Kassie (8 years) has mastered setup and operating CNC spiral point grinders, and Kristin (6 years) controls the CNC laser marking machines. Monica (6 years) ensures shipments are accurate and on time. These dedicated employees represent the entire team that is focused on delivering quality tools when you need them.

We believe you will find this catalog provides all the solutions to your custom tapping needs.

The Regal Team

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SELECTION PROCESS

Several factors should be considered to determine the best tap to provide optimum thread quality and maximum tool life for ensuring the highest possible productivity. Whether you select Regal Premium, SuperTuf or Carbide, you can be assured you are receiving the finest American-made cutting tools.

Our years of experience assure you we can design the ideal tool that will deliver cost effectiveness if we know the following:

- Diameter, threads per inch or pitch in millimeters, class of fit
- Shank size and length
- Material to be threaded and condition or hardness
- Drilled hole size and depth, through or blind hole, and thread depth
- Type of machine used and horizontal or vertical
- Coolant type: synthetic, water soluble or oil, or dry

This information allows us to calculate the degree of hook or rake on the tap, number of flutes, land width, and the best surface treatment or coating. We will determine the chamfer point diameter, length of chamfer and back taper based on the material, hole size and depth.

SAME DAY SHIPMENT

Order the Popular Special Taps on pages 2-21 before 6:00 p.m. Central Time and receive same day shipment.

To order visit
www.regalcuttingtools.com,
phone 1-800-435-2948, or
fax 1-800-992-1674.

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SPECIAL TAPS & DIES



#00-90 To #4-40

Call for pricing on Special Gages for these taps.

Size/Pitch	Type	GH#	#FI	Taper	Plug	Bottom	1	2	3	6	8	12	24	48
#00-90 NS	Spiral Pt.	H1	0		011150AS		87.30	69.80	48.90	40.20	34.00	30.60	27.90	24.40
#00-96 NS	Spiral Pt.	H1	0		011155AS		87.30	69.80	48.90	40.20	34.00	30.60	27.90	24.40
#0-80 NF*	Hand Tap	H3	2		011162AS		67.40	53.90	37.70	31.00	26.30	23.60	21.60	18.90
	Spiral Pt.	H3	0		011157AS		76.90	61.50	43.10	35.40	30.00	26.90	24.60	21.50
	Spiral Pt.	H3	2		099421AS		76.90	61.50	43.10	35.40	30.00	26.90	24.60	21.50
	LH Hand Tap	H1	2		017015AS		67.40	53.90	37.70	31.00	26.30	23.60	21.60	18.90
	LH Spiral Pt.	H1	0		011159AS		79.40	63.50	44.50	36.50	31.00	27.80	25.40	22.20
	LH Spiral Pt.	H1	2		011160AS		72.20	57.80	40.40	33.20	28.20	25.30	23.10	20.20
	Micrograin Carbide	H2	2	018009RS	018010RS	018011RS	79.90	78.70	76.70	63.90	47.90	40.00	38.40	33.60
#1-56 NS	Hand Tap	H1	2	011164AS	011165AS	011166AS	66.70	53.40	37.40	30.70	26.00	23.30	21.30	18.70
	Spiral Pt.	H1	0		011158AS		30.00	24.00	16.80	13.80	11.70	10.50	9.60	8.40
#1-64 NC*	1" O.D. Die				041201AS		80.80	79.60	77.60	64.60	48.50	40.40	38.80	33.90
#1-72 NF*	1" O.D. Die				041202AS		80.80	79.60	77.60	64.60	48.50	40.40	38.80	33.90
#2-56 NC*	Hand Tap	H4	2		011167AS	011168AS	77.30	61.80	43.30	35.60	30.10	27.10	24.70	21.60
	Spiral Pt.	H3	2		099400AS		79.00	63.20	44.20	36.30	30.80	27.70	25.30	22.10
	Spiral Pt.	H4	2		011002AS		79.00	63.20	44.20	36.30	30.80	27.70	25.30	22.10
	Spiral Pt.	H5	2		099401AS		79.00	63.20	44.20	36.30	30.80	27.70	25.30	22.10
	+.003 Spiral Pt.	H7	2		011004AS		79.00	63.20	44.20	36.30	30.80	27.70	25.30	22.10
	LH Hand Tap	H2	2	017023AS	017024AS	017025AS	63.10	50.50	35.30	29.00	24.60	22.10	20.20	17.70
	LH Spiral Pt.	H2	2		017022AS		66.80	53.40	37.40	30.70	26.10	23.40	21.40	18.70
	Micrograin Carbide	H2	2	018072RS	018073RS	018074RS	79.90	79.90	79.90	79.90	79.90	69.50	67.90	66.30
	Micrograin Carbide Spiral Pt.	H2	2		018075RS		83.60	83.60	83.60	83.60	83.60	72.70	71.10	69.40
	LH 1" O.D. Die				041003AS		76.50	75.40	73.40	61.20	45.90	38.30	36.70	32.10
#3-48 NC*	Spiral Pt.	H3	2		099402AS		25.30	22.80	21.50	20.20	19.70	19.00	18.20	17.70
	Spiral Pt.	H5	2		099403AS		25.30	22.80	21.50	20.20	19.70	19.00	18.20	17.70
	LH Hand Tap	H2	3	017026AS	017027AS	017028AS	53.60	42.90	30.00	24.70	20.90	18.80	17.20	15.00
	LH Spiral Pt.	H2	2		017055AS		56.40	45.10	31.60	25.90	22.00	19.70	18.00	15.80
	1 O.D. Die				041205AS		76.90	75.70	73.80	61.50	46.10	38.50	36.90	32.30
	LH 1" O.D. Die				041005AS		76.90	75.70	73.80	61.50	46.10	38.50	36.90	32.30
#4-32 NS	Hand Tap	H2	3	011169AS	011170AS	011171AS	49.00	39.20	27.40	22.50	19.10	17.20	15.70	13.70
#4-36 NS*	1" O.D. Die				041208AS		68.00	67.00	65.30	54.40	40.80	34.00	32.60	28.60
#4-40 NC*	Hand Tap	H3	3		011173AS	011175AS	40.30	39.50	36.30	30.20	22.20	18.10	14.10	11.30
	Hand Tap	H4	3		011005AS		40.30	39.50	36.30	30.20	22.20	18.10	14.10	11.30
	Hand Tap	H5	3		011006AS		40.30	39.50	36.30	30.20	22.20	18.10	14.10	11.30
	Hand Tap	H6	3		011007AS		40.30	39.50	36.30	30.20	22.20	18.10	14.10	11.30
	+.003 Hand Tap	H7	3		011008AS		40.30	39.50	36.30	30.20	22.20	18.10	14.10	11.30
	+.005 Hand Tap	H11	3		011009AS		40.30	39.50	36.30	30.20	22.20	18.10	14.10	11.30
	Spiral Pt.	H3	2		099404AS		46.10	45.20	41.50	34.60	25.40	20.70	16.10	12.90
	Spiral Pt.	H4	2		011011AS		46.10	45.20	41.50	34.60	25.40	20.70	16.10	12.90
	Spiral Pt.	H5	2		099405AS		46.10	45.20	41.50	34.60	25.40	20.70	16.10	12.90
	Spiral Pt.	H6	2		011013AS		46.10	45.20	41.50	34.60	25.40	20.70	16.10	12.90
	Spiral Pt.	H8	2		011014AS		46.10	45.20	41.50	34.60	25.40	20.70	16.10	12.90
	Spiral Pt.	H9	2		011015AS		46.10	45.20	41.50	34.60	25.40	20.70	16.10	12.90
	+.005 Spiral Pt.	H11	2		011016AS		46.10	45.20	41.50	34.60	25.40	20.70	16.10	12.90

*The most popular limits and flute configurations, both Right- and Left-Hand sizes, are shown in our Industrial Metalworking catalog and on our website.

SPECIAL TAPS & DIES



#4-40 To #6-32

Call for pricing on Special Gages for these taps.

Size/Pitch	Type	GH#	#FI	Taper	Plug	Bottom	1	2	3	6	8	12	24	48	
#4-40 NC*	LH Hand Tap	H2	3	017029AS	017030AS	017031AS	23.00	20.70	18.40	17.30	16.60	16.10	15.60	15.00	
	LH Spiral Pt.	H2	2		017032AS		24.20	21.80	19.40	18.20	17.40	16.90	16.50	15.70	
	Micrograin Carbide	H2	2		018190RS	018191RS	73.00	73.00	73.00	73.00	73.00	63.50	62.10	60.60	
	Micrograin Carbide Spiral Pt.	H2	2		018192RS		76.30	76.30	76.30	76.30	76.30	66.40	64.90	63.30	
	1" O.D. Die				041209AS		68.00	67.00	65.30	54.40	40.80	34.00	32.60	28.60	
	LH 1" O.D. Die				041008AS		68.00	67.00	65.30	54.40	40.80	34.00	32.60	28.60	
#4-48 NF*	+.003 Hand Tap	H7	3		011017AS		40.30	35.50	34.30	28.20	20.20	12.90	11.30	10.10	
	Spiral Pt.	H3	2		011018AS		49.00	43.10	41.70	34.30	24.50	15.70	13.70	12.30	
	Spiral Pt.	H5	2		011019AS		49.00	43.10	41.70	34.30	24.50	15.70	13.70	12.30	
	+.003 Spiral Pt.	H7	2		011020AS		49.00	43.10	41.70	34.30	24.50	15.70	13.70	12.30	
	LH Hand Tap	H2	3		017057AS	011012AS	45.20	39.80	38.40	31.60	22.60	14.50	12.70	11.30	
	LH Spiral Pt.	H2	2		017058AS		47.20	41.50	40.10	33.00	23.60	15.10	13.20	11.80	
	Micrograin Carbide	H2	2		018220RS	018221RS	73.00	73.00	73.00	73.00	73.00	63.50	62.10	60.60	
	Micrograin Carbide Spiral Pt.	H2	2		018222RS		76.30	76.30	76.30	76.30	76.30	66.40	64.90	63.30	
	1" O.D. Die				041210AS		68.00	67.00	65.30	54.40	40.80	34.00	32.60	28.60	
	#5-40 NC*	Hand Tap	H6	3		011022AS		45.20	39.80	38.40	31.60	22.60	14.50	12.70	11.30
	+.003 Hand Tap	H7	3		011023AS		49.00	43.10	41.70	34.30	24.50	15.70	13.70	12.30	
	+.005 Hand Tap	H11	3		011024AS		49.00	43.10	41.70	34.30	24.50	15.70	13.70	12.30	
	Spiral Pt.	H3	2		011025AS		48.70	42.90	41.40	34.10	24.40	15.60	13.60	12.20	
	Spiral Pt.	H4	2		011026AS		48.70	42.90	41.40	34.10	24.40	15.60	13.60	12.20	
	Spiral Pt.	H5	2		099406AS		48.70	42.90	41.40	34.10	24.40	15.60	13.60	12.20	
	Spiral Pt.	H6	2		011028AS		48.70	42.90	41.40	34.10	24.40	15.60	13.60	12.20	
	+.003 Spiral Pt.	H7	2		008122AS		48.70	42.90	41.40	34.10	24.40	15.60	13.60	12.20	
	+.005 Spiral Pt.	H11	2		011029AS		25.50	25.50	25.50	21.20	16.80	12.50	9.90	8.90	
	LH Hand Tap	H2	3	017033AS	017034AS	017035AS	45.20	39.80	38.40	31.60	22.60	14.50	12.70	11.30	
	LH Spiral Pt.	H2	2		017059AS		41.90	41.10	37.70	31.40	23.00	18.90	14.70	11.70	
	Micrograin Carbide	H2	3		018248RS	018249RS	73.00	73.00	73.00	73.00	73.00	63.50	62.10	60.60	
	Micrograin Carbide Spiral Pt.	H2	2		018250RS		76.30	76.30	76.30	76.30	76.30	66.40	64.90	63.30	
	LH 1" O.D. Die				041010AS		68.00	67.00	65.30	54.40	40.80	34.00	32.60	28.60	
#6-32 NC*	Hand Tap	H4	3		011030AS		35.20	34.50	33.80	28.20	21.10	16.90	13.00	9.50	
	Hand Tap	H5	3	011178AS	011179AS	011180AS	35.20	34.50	33.80	28.20	21.10	16.90	13.00	9.50	
	Hand Tap	H6	3		011031AS		35.20	34.50	33.80	28.20	21.10	16.90	13.00	9.50	
	+.005 Hand Tap	H11	3		014503AS	014504AS	7.00	7.00	7.00	7.00	7.00	6.10	6.00	5.80	
	Spiral Pt.	H4	2		011174AS		37.20	36.50	33.50	27.90	20.50	16.70	13.00	10.40	
	Spiral Pt.	H5	2		011177AS		37.20	36.50	33.50	27.90	20.50	16.70	13.00	10.40	
	Spiral Pt.	H6	2		011033AS		40.10	39.30	36.10	30.10	22.10	18.00	14.00	11.20	
	Spiral Pt.	H8	2		011034AS		40.10	39.30	36.10	30.10	22.10	18.00	14.00	11.20	
	Spiral Pt.	H9	2		011035AS		40.10	39.30	36.10	30.10	22.10	18.00	14.00	11.20	
	+.005 Spiral Pt.	H11	2		014500AS		7.80	7.80	7.80	7.80	7.80	6.80	6.60	6.50	
	Spiral Flute	H3	3		011036AS	011037AS		16.60	16.40	15.90	13.30	10.00	8.30	8.00	7.00
	LH Spiral Pt.	H3	2		017039AS			16.60	16.60	16.60	16.60	14.40	14.10	13.80	
	Micrograin Carbide	H3	3		018309RS	018310RS		73.60	73.60	73.60	73.60	73.60	64.00	62.60	61.10
	Micrograin Carbide Spiral Pt.	H3	2		018307RS			76.90	76.90	76.90	76.90	76.90	66.90	65.40	63.80
LH 1" O.D. Die				041012AS			68.00	67.00	65.30	54.40	40.80	34.00	32.60	28.60	

*The most popular limits and flute configurations, both Right- and Left-Hand sizes, are shown in our Industrial Metalworking catalog and on our website.

SPECIAL TAPS & DIES



#6-40 To #10-24

Call for pricing on Special Gages for these taps.

Size/Pitch	Type	GH#	#FI	Taper	Plug	Bottom	1	2	3	6	8	12	24	48
#6-40 NF*	Spiral Pt.	H3	2		011182AS		36.20	36.20	36.20	30.00	23.90	17.70	14.10	12.70
	Spiral Pt.	H4	2		011038AS		36.20	36.20	36.20	30.00	23.90	17.70	14.10	12.70
	Spiral Pt.	H5	2		011039AS		36.20	36.20	36.20	30.00	23.90	17.70	14.10	12.70
	LH Hand Tap	H2	3	017042AS	017043AS	017044AS	33.00	33.00	33.00	27.40	21.80	16.20	12.90	11.60
	Micrograin Carbide	H2	3		018355RS	018356RS	73.60	73.60	73.60	73.60	73.60	64.00	62.60	61.10
	LH 1" O.D. Die				041013AS		68.00	67.00	65.30	54.40	40.80	34.00	32.60	28.60
#6-48 NS	Hand Tap	H2	3	011184AS	011185AS	011186AS	34.70	34.00	31.20	26.00	19.10	15.60	12.10	9.70
	Spiral Pt.	H2	2		011187AS		37.20	36.50	33.50	27.90	20.50	16.70	13.00	10.40
	1" O.D. Die				041211AS		68.00	67.00	65.30	54.40	40.80	34.00	32.60	28.60
#8-24 NS	Hand Tap	H3	4	011189AS	011190AS	011191AS	36.60	35.90	32.90	27.50	20.10	16.50	12.80	10.20
#8-32 NC*	Hand Tap	H1	3		099407AS		36.60	35.90	32.90	27.50	20.10	16.50	12.80	10.20
	Hand Tap	H4	4		011041AS		36.60	35.90	32.90	27.50	20.10	16.50	12.80	10.20
	Hand Tap	H5	4	011209AS	011210AS	011211AS	36.60	35.90	32.90	27.50	20.10	16.50	12.80	10.20
	Hand Tap	H6	4		011042AS		36.60	35.90	32.90	27.50	20.10	16.50	12.80	10.20
	+.005 Hand Tap	H11	4		014517AS	014518AS	8.70	8.70	8.70	8.70	8.70	7.60	7.40	7.20
	LH Spiral Pt.	H3	2		017051AS		17.40	15.70	14.80	13.90	13.60	13.10	12.50	12.20
	Spiral Pt.	H4	2		011205AS		39.00	31.20	21.80	17.90	15.20	13.70	12.50	10.90
	Spiral Pt.	H5	2		011208AS		39.00	31.20	21.80	17.90	15.20	13.70	12.50	10.90
	Spiral Pt.	H6	2		011043AS		37.60	30.10	21.10	17.30	14.70	13.20	12.00	10.50
	Spiral Pt.	H8	2		011044AS		37.60	30.10	21.10	17.30	14.70	13.20	12.00	10.50
	Spiral Pt.	H9	2		011045AS		37.60	30.10	21.10	17.30	14.70	13.20	12.00	10.50
	+.005 Spiral Pt.	H11	2		014514AS		9.70	9.70	9.70	9.70	9.70	8.40	8.20	8.10
	Micrograin Carbide	H3	4		018406RS	018407RS	75.10	75.10	75.10	75.10	75.10	65.30	63.80	62.30
	Micrograin Carbide Spiral Pt.	H3	2		018401RS		78.70	78.70	78.70	78.70	78.70	68.50	66.90	65.30
	LH 1" O.D. Die				041014AS		68.00	67.00	65.30	54.40	40.80	34.00	32.60	28.60
#8-36 NF*	Spiral Pt.	H1	2		011046AS		40.00	35.20	34.00	28.00	20.00	12.80	11.20	10.00
	Spiral Pt.	H3	2		011216AS		41.10	36.20	34.90	28.80	20.60	13.20	11.50	10.30
	Spiral Pt.	H4	2		011048AS		41.10	36.20	34.90	28.80	20.60	13.20	11.50	10.30
	LH Hand Tap	H2	4		011215AS	011047AS	38.00	33.40	32.30	26.60	19.00	12.20	10.60	9.50
	LH Spiral Pt.	H2	2		017061AS		40.10	35.30	34.10	28.10	20.10	12.80	11.20	10.00
	Micrograin Carbide	H2	4		018450RS	018451RS	76.70	76.70	76.70	76.70	76.70	66.70	65.20	63.70
	1" O.D. Die				041015AS		68.00	67.00	65.30	54.40	40.80	34.00	32.60	28.60
#8-40 NS	Hand Tap	H2	4	011217AS	011220AS	011218AS	37.00	36.30	35.50	29.60	22.20	17.80	13.70	10.00
	Spiral Pt.	H2	2		011219AS		39.30	38.50	37.70	31.40	23.60	18.90	14.50	10.60
	1" O.D. Die				041212AS		68.00	67.00	65.30	54.40	40.80	34.00	32.60	28.60
#10-24 NC*	Hand Tap	H4	2		011050AS		36.60	35.90	35.10	29.30	22.00	17.60	13.50	9.90
	Hand Tap	H4	4		011051AS		36.60	35.90	35.10	29.30	22.00	17.60	13.50	9.90
	Hand Tap	H5	4	011221AS	011222AS	011223AS	36.60	35.90	35.10	29.30	22.00	17.60	13.50	9.90
	Hand Tap	H6	4		011052AS		40.60	35.70	34.50	28.40	20.30	13.00	11.40	10.20
	+.003 Hand Tap	H7	3		011053AS		40.60	35.70	34.50	28.40	20.30	13.00	11.40	10.20
	+.005 Hand Tap	H11	4		014531AS	014532AS	6.90	6.90	6.90	6.90	6.90	6.00	5.90	5.70
	Spiral Pt.	H5	2		011224AS		40.60	35.70	34.50	28.40	20.30	13.00	11.40	10.20
	Spiral Pt.	H6	2		011055AS		40.60	35.70	34.50	28.40	20.30	13.00	11.40	10.20
	+.005 Spiral Pt.	H11	2		014528AS		7.80	7.80	7.80	7.80	7.80	6.80	6.60	6.50
LH Spiral Pt.	H3	2		017069AS		17.50	17.50	17.50	17.50	17.50	15.20	14.90	14.50	

*The most popular limits and flute configurations, both Right- and Left-Hand sizes, are shown in our Industrial Metalworking catalog and on our website.

SPECIAL TAPS & DIES



#10-24 To #14-24

Call for pricing on Special Gages for these taps.

Size/Pitch	Type	GH#	#FI	Taper	Plug	Bottom	1	2	3	6	8	12	24	48
#10-24 NC*	Micrograin Carbide	H3	4		018497RS	018498RS	76.70	76.70	76.70	76.70	76.70	66.70	65.20	63.70
	Micrograin Carbide Spiral Pt.	H3	2		018492RS		80.00	80.00	80.00	80.00	80.00	69.60	68.00	66.40
	Double Lead	H3	4		017080AS	017081AS	45.90	45.20	44.10	36.70	27.50	23.00	22.00	19.30
	LH 1" O.D. Die				041016AS		68.00	67.00	65.30	54.40	40.80	34.00	32.60	28.60
#10-28 NS	Hand Tap	H3	4	011228AS	011229AS	011230AS	37.60	33.10	32.00	26.30	18.80	12.00	10.50	9.40
#10-30 NS	Hand Tap	H3	4	011236AS	011237AS	011238AS	37.60	33.10	32.00	26.30	18.80	12.00	10.50	9.40
#10-32 NF*	Hand Tap	H5	4	011248AS	011249AS	011250AS	37.60	33.10	32.00	26.30	18.80	12.00	10.50	9.40
	Hand Tap	H6	4		011058AS		37.60	33.10	32.00	26.30	18.80	12.00	10.50	9.40
	+.005 Hand Tap	H11	4		014538AS	014539AS	6.90	6.90	6.90	6.90	6.90	6.00	5.90	5.70
	Spiral Pt.	H4	2		011244AS		39.70	38.90	38.10	31.80	23.80	19.10	14.70	10.70
	Spiral Pt.	H5	2		011247AS		39.70	38.90	38.10	31.80	23.80	19.10	14.70	10.70
	Spiral Pt.	H6	2		011059AS		39.70	38.90	38.10	31.80	23.80	19.10	14.70	10.70
	Spiral Pt.	H8	2		011060AS		39.70	38.90	38.10	31.80	23.80	19.10	14.70	10.70
	+.005 Spiral Pt.	H11	2		014535AS		7.50	7.50	7.50	7.50	7.50	6.50	6.40	6.20
	LH Spiral Pt.	H3	2		017079AS		17.60	17.60	17.60	17.60	17.60	15.30	15.00	14.60
	Micrograin Carbide	H3	4		018557RS	018558RS	76.70	76.70	76.70	76.70	76.70	66.70	65.20	63.70
Micrograin Carbide Spiral Pt.	H3	2		018552RS		80.00	80.00	80.00	80.00	80.00	69.60	68.00	66.40	
Double Lead	H3	4	014918AS	014919AS	014920AS	46.40	45.70	44.50	37.10	27.80	23.20	22.30	19.50	
LH 1" O.D. Die				041017AS		68.00	67.00	65.30	54.40	40.80	34.00	32.60	28.60	
#10-36 NS	Hand Tap	H2	4	011259AS	011260AS	011261AS	36.60	35.90	32.90	27.50	20.10	16.50	12.80	10.20
	1" O.D. Die				041214AS		68.00	67.00	65.30	54.40	40.80	34.00	32.60	28.60
#10-40 NS	Hand Tap	H2	4	011268AS	011269AS	011270AS	36.60	35.90	32.90	27.50	20.10	16.50	12.80	10.20
	Spiral Pt.	H2	2		011267AS		39.80	39.00	35.80	29.90	21.90	17.90	13.90	11.10
	1" O.D. Die				041215AS		68.00	67.00	65.30	54.40	40.80	34.00	32.60	28.60
#10-48 NS	Hand Tap	H2	4	011274AS	011275AS	011276AS	36.60	35.90	32.90	27.50	20.10	16.50	12.80	10.20
	1" O.D. Die				041216AS		68.00	67.00	65.30	54.40	40.80	34.00	32.60	28.60
#10-56 NS	Hand Tap	H2	4	011284AS	011285AS	011286AS	36.60	35.90	32.90	27.50	20.10	16.50	12.80	10.20
	1" O.D. Die				041217AS		68.00	67.00	65.30	54.40	40.80	34.00	32.60	28.60
#10-64 NS	Hand Tap	H2	4	011308AS	011309AS	011310AS	36.60	35.90	32.90	27.50	20.10	16.50	12.80	10.20
#12-24 NC*	LH Hand Tap	H3	4	017082AS	017083AS	017084AS	38.70	37.90	34.80	29.00	21.30	17.40	13.50	10.80
	Micrograin Carbide	H3	4		018604RS	018605RS	78.10	78.10	78.10	78.10	78.10	67.90	66.40	64.80
	Micrograin Carbide Spiral Pt.	H3	2		018603RS		81.60	81.60	81.60	81.60	81.60	71.00	69.40	67.70
	LH 1" O.D. Die				041018AS		68.00	67.00	65.30	54.40	40.80	34.00	32.60	28.60
#12-28 NF*	LH Hand Tap	H3	4	017097AS	017098AS	017099AS	38.70	37.90	34.80	29.00	21.30	17.40	13.50	10.80
	Micrograin Carbide	H3	4		018617RS	018618RS	78.10	78.10	78.10	78.10	78.10	67.90	66.40	64.80
	Micrograin Carbide Spiral Pt.	H3	2		018616RS		81.60	81.60	81.60	81.60	81.60	71.00	69.40	67.70
	LH 1" O.D. Die				041019AS		68.00	67.00	65.30	54.40	40.80	34.00	32.60	28.60
#12-32 NEF	Hand Tap	H3	4	011358AS	011359AS	011360AS	7.60	7.60	7.60	7.60	7.60	6.60	6.50	6.30
	Spiral Pt.	H3	2		011361AS		17.50	17.50	17.50	17.50	17.50	15.20	14.90	14.50
	1" O.D. Die				041218AS		68.00	67.00	65.30	54.40	40.80	34.00	32.60	28.60
#12-36 NS	Hand Tap	H2	4	011371AS	011372AS	011373AS	37.90	30.30	21.20	17.40	14.80	13.30	12.10	10.60
	1" O.D. Die				041219AS		68.00	67.00	65.30	54.40	40.80	34.00	32.60	28.60
#14-20 NS	Hand Tap	H3	4	011413AS	011414AS	011415AS	42.60	41.70	38.30	32.00	23.40	19.20	14.90	11.90
	1" O.D. Die				041221AS		68.00	67.00	65.30	54.40	40.80	34.00	32.60	28.60
#14-24 NS	Hand Tap	H3	4	011427AS	011428AS	011429AS	42.60	41.70	38.30	32.00	23.40	19.20	14.90	11.90
	1" O.D. Die				041222AS		68.00	67.00	65.30	54.40	40.80	34.00	32.60	28.60

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SPECIAL TAPS & DIES



1/16-27 To 1/4-24

Call for pricing on Special Gages for these taps.

Size/Pitch	Type	GH#	#FI	Taper	Plug	Bottom	1	2	3	6	8	12	24	48
1/16-27 NPTF*	LH Pipe		4		017521AS		38.00	37.40	36.50	30.40	22.80	19.00	18.20	16.00
	Micrograin Carbide Pipe		4		018900RS		93.40	93.40	93.40	93.40	93.40	81.30	79.40	77.50
1/8-27 NPSI	Straight Pipe		4		015850AS		44.90	44.20	43.10	35.90	26.90	22.50	21.60	18.90
1/8-27 NPTF*	LH Pipe		4		017522AS		40.10	39.50	38.50	32.10	24.10	20.10	19.20	16.80
	Carbo-Clad Pipe		4		019381US		212.20	212.20	212.20	212.20	212.20	212.20	208.00	203.70
1/8-27 NPSF*	Carbide Pipe		4		018902RS		171.50	171.50	171.50	171.50	171.50	149.20	145.80	142.30
1/8-28 BSPT	55° Mod. Whit Taper		4		015730AS		22.20	22.20	22.20	22.20	22.20	22.20	22.20	22.20
	55° Full Form Taper		4		015729AS	015717AS	56.50	56.50	56.50	56.50	56.50	49.20	48.00	46.90
1/8-28 BSPP	55° Mod. Whit Parallel		4		015700AS		22.20	22.20	22.20	22.20	22.20	22.20	22.20	22.20
	55° Full Form Parallel		4		015690AS	015718AS	56.50	56.50	56.50	56.50	56.50	49.20	48.00	46.90
5/32-32 NS	Hand Tap	H3	4	011432AS	011433AS	011434AS	38.80	38.00	34.90	29.10	21.30	17.50	13.60	10.90
3/16-24 NS	Hand Tap	H3	4	011437AS	011438AS	011439AS	38.80	38.00	34.90	29.10	21.30	17.50	13.60	10.90
3/16-32 NS	Hand Tap	H3	4	011455AS	011456AS	011457AS	38.80	38.00	34.90	29.10	21.30	17.50	13.60	10.90
.210-36 NS	Hand Tap	H3	4	011061AS	011062AS	011063AS	46.80	41.20	39.80	32.80	23.40	15.00	13.10	11.70
	Hand Tap	H4	4	011063AS	011064AS	011065AS	46.80	41.20	39.80	32.80	23.40	15.00	13.10	11.70
7/32-32 NS	Hand Tap	H3	4	011501AS	011502AS	011503AS	38.80	38.00	34.90	29.10	21.30	17.50	13.60	10.90
1/4-18 NPSI	Straight Pipe		4		015852AS		58.90	58.00	56.50	47.10	35.30	29.50	28.30	24.70
1/4-18 NPTF*	LH Pipe		4		017524AS		50.30	49.50	48.30	40.20	30.20	25.20	24.10	21.10
1/4-18 PTF-SAE	Short Proj .361		4		015660AS	015661AS	51.20	51.20	51.20	42.50	33.80	25.10	20.00	17.90
1/4-18 NPT	Carbo-Clad Pipe		4		019382US		220.20	220.20	220.20	220.20	220.20	220.20	215.80	211.40
1/4-19 BSPT	55° Mod. Whit Taper		4		015732AS		24.30	24.30	24.30	24.30	24.30	24.30	24.30	24.30
	55° Full Form Taper		4		015731AS	015719AS	62.10	62.10	62.10	62.10	62.10	54.00	52.80	51.50
1/4-19 BSPP	55° Mod. Whit Parallel		4		015702AS		24.30	24.30	24.30	24.30	24.30	24.30	24.30	24.30
	55° Full Form Parallel		4		015701AS	015720AS	62.10	62.10	62.10	62.10	62.10	54.00	52.80	51.50
1/4-20 NC*	Hand Tap	H6	4		011066AS		38.20	38.20	38.20	31.70	25.20	18.70	14.90	13.40
	+ .003 Hand Tap	H7	4	011533AS	011534AS	011535AS	38.20	38.20	38.20	31.70	25.20	18.70	14.90	13.40
	+ .005 Hand Tap	H11	4			017778AS	8.60	8.60	8.60	8.60	8.60	8.60	8.60	8.60
	+ .010 Hand Tap	H21	4	014670AS	014671AS	014672AS	35.80	35.10	34.40	28.60	21.50	17.20	13.20	9.70
	Spiral Pt.	H6	2		011067AS		40.70	40.70	40.70	33.80	26.90	19.90	15.90	14.20
	+ .003 Spiral Pt.	H7	2		011532AS		40.70	40.70	40.70	33.80	26.90	19.90	15.90	14.20
	LH Spiral Pt.	H3	2		017108AS		18.00	18.00	18.00	18.00	18.00	15.70	15.30	14.90
1/4-20 BSW	55° Mod. Whit Hand Tap	H3	4		015630AS	015631AS	78.80	78.80	78.80	65.40	52.00	38.60	30.70	27.60
1/4-20 NC*	Micrograin Carbide	H3	4		018636RS	018637RS	86.80	86.80	86.80	86.80	86.80	75.50	73.80	72.00
	Micrograin Carbide Spiral Pt.	H3	2		018631RS		90.90	90.90	90.90	90.90	90.90	79.10	77.30	75.40
	Double Lead	H3	4	014930AS	014931AS	014932AS	48.80	48.10	46.80	39.00	29.30	24.40	23.40	20.50
	LH 1" O.D. Die				041022AS		68.00	67.00	65.30	54.40	40.80	34.00	32.60	28.60
1/4-24 NS	Hand Tap	H3	4	011551AS	011552AS	011553AS	26.50	26.10	25.40	21.20	15.90	13.30	12.70	11.10
	Spiral Pt.	H3	2		011548AS		29.40	29.00	28.20	23.50	17.60	14.70	14.10	12.30
	1" O.D. Die				041226AS		68.00	67.00	65.30	54.40	40.80	34.00	32.60	28.60

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SPECIAL TAPS & DIES



1/4-26 To 5/16-18

Call for pricing on Special Gages for these taps.

Size/Pitch	Type	GH#	#FI	Taper	Plug	Bottom	1	2	3	6	8	12	24	48
1/4-26 BSF	55° Mod. Whitworth	H3	4		015770AS	015771AS	78.80	78.80	78.80	65.40	52.00	38.60	30.70	27.60
1/4-27 NS	Hand Tap	H3	4	011556AS	011557AS	011558AS	26.50	26.10	25.40	21.20	15.90	13.30	12.70	11.10
	1" O.D. Die				041227AS		68.00	67.00	65.30	54.40	40.80	34.00	32.60	28.60
1/4-28 NF*	Hand Tap	H1	4	011068AS			34.40	33.70	33.00	27.50	20.60	16.50	12.70	9.30
	Hand Tap	H5	4	011568AS	011569AS	011570AS	34.40	33.70	33.00	27.50	20.60	16.50	12.70	9.30
	+ .003 Hand Tap	H7	4	011580AS	011581AS	011582AS	34.50	33.80	33.10	27.60	20.70	16.60	12.80	9.30
	+ .005 Hand Tap	H11	4		014552AS	014553AS	8.60	8.60	8.60	8.60	8.60	8.60	8.60	8.60
	Spiral Pt.	H5	2		011069AS		36.20	35.50	34.80	29.00	21.70	17.40	13.40	9.80
	Spiral Pt.	H6	2		011070AS		36.20	35.50	34.80	29.00	21.70	17.40	13.40	9.80
	+ .003 Spiral Pt.	H7	2		011578AS		36.20	35.50	34.80	29.00	21.70	17.40	13.40	9.80
	+ .005 Spiral Pt.	H11	2		014549AS		9.80	9.80	9.80	9.80	9.80	9.80	9.80	9.80
	LH Spiral Pt.	H3	2		017120AS		19.40	19.40	19.40	19.40	19.40	16.90	16.50	16.10
	Micrograin Carbide	H3	4		018661RS	018662RS	86.80	86.80	86.80	86.80	86.80	75.50	73.80	72.00
	Micrograin Carbide Spiral Pt.	H3	2		018656RS		90.90	90.90	90.90	90.90	90.90	79.10	77.30	75.40
	Double Lead	H3	4		014933AS	014934AS	48.80	48.10	46.80	39.00	29.30	24.40	23.40	20.50
	LH 1" O.D. Die				041025AS		68.00	67.00	65.30	54.40	40.80	34.00	32.60	28.60
1/4-32 NEF	Hand Tap	H3	4	011596AS	011597AS	011598AS	7.80	7.80	7.80	7.80	7.80	6.80	6.60	6.50
	Hand Tap	H5	4	011600AS	011601AS	011602AS	18.50	18.20	17.80	14.80	11.10	9.30	8.90	7.80
	Spiral Pt.	H3	2		011594AS		20.90	20.60	20.10	16.70	12.50	10.50	10.00	8.80
	LH Hand Tap	H3	4		017018AS	017019AS	51.20	45.10	43.50	35.80	25.60	16.40	14.30	12.80
	1" O.D. Die				041228AS		68.00	67.00	65.30	54.40	40.80	34.00	32.60	28.60
1/4-36 NS	Hand Tap	H2	4	011609AS	011610AS	011611AS	26.50	26.10	25.40	21.20	15.90	13.30	12.70	11.10
	Hand Tap	H3	4		011071AS	011072AS	34.40	33.70	33.00	27.50	20.60	16.50	12.70	9.30
	Spiral Pt.	H2	2		011073AS		20.30	20.30	20.30	20.30	20.30	17.70	17.30	16.80
	Spiral Pt.	H3	2		011074AS		20.30	20.30	20.30	20.30	20.30	17.70	17.30	16.80
	1" O.D. Die				041229AS		68.00	67.00	65.30	54.40	40.80	34.00	32.60	28.60
1/4-40 NS	Hand Tap	H2	4	011621AS	011622AS	011623AS	34.40	33.70	33.00	27.50	20.60	16.50	12.70	9.30
	Hand Tap	H3	4	011624AS	011625AS	011626AS	34.40	33.70	33.00	27.50	20.60	16.50	12.70	9.30
	Spiral Pt.	H2	2		011620AS		29.40	29.00	28.20	23.50	17.60	14.70	14.10	12.30
	1" O.D. Die				041230AS		68.00	67.00	65.30	54.40	40.80	34.00	32.60	28.60
1/4-48 NS	Hand Tap	H2	4	011632AS	011633AS	011634AS	34.40	33.70	33.00	27.50	20.60	16.50	12.70	9.30
	1" O.D. Die				041231AS		68.00	67.00	65.30	54.40	40.80	34.00	32.60	28.60
1/4-56 NS	Hand Tap	H2	4	011643AS	011644AS	011645AS	34.40	33.70	33.00	27.50	20.60	16.50	12.70	9.30
	1" O.D. Die				041232AS		68.00	67.00	65.30	54.40	40.80	34.00	32.60	28.60
1/4-80 NS	Hand Tap	H2	4	011660AS	011661AS	011662AS	40.80	40.00	36.70	30.60	22.40	18.40	14.30	11.40
	1" O.D. Die				041233AS		68.00	67.00	65.30	54.40	40.80	34.00	32.60	28.60
9/32-32 NS	Hand Tap	H3	4	011672AS	011673AS	011674AS	37.00	36.30	35.50	29.60	22.20	17.80	13.70	10.00
5/16-18 NC*	Hand Tap	H1	3		011075AS		35.30	34.60	33.90	28.20	21.20	16.90	13.10	9.50
	Hand Tap	H5	2		011076AS		40.40	39.60	36.40	30.30	22.20	18.20	14.10	11.30
	Hand Tap	H5	3		011077AS	011078AS	40.40	39.60	36.40	30.30	22.20	18.20	14.10	11.30
	Hand Tap	H6	4		011079AS		42.20	41.40	38.00	31.70	23.20	19.00	14.80	11.80
	+ .003 Hand Tap	H7	4	011720AS	011721AS	011722AS	35.30	34.60	33.90	28.20	21.20	16.90	13.10	9.50
	+ .010 Hand Tap	H21	4	014678AS	014679AS	014680AS	42.80	41.90	38.50	32.10	23.50	19.30	15.00	12.00

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SPECIAL TAPS & DIES



5/16-18 To 3/8-16

Call for pricing on Special Gages for these taps.

Size/Pitch	Type	GH#	#FI	Taper	Plug	Bottom	1	2	3	6	8	12	24	48	
5/16-18 NC*	LH Spiral Pt.	H3	2		017146AS		19.10	18.80	18.30	15.30	11.50	9.60	9.20	8.00	
	Spiral Pt.	H6	2		011080AS		37.20	36.50	35.70	29.80	22.30	17.90	13.80	10.00	
	+.003 Spiral Pt.	H7	2		011723AS		37.20	36.50	35.70	29.80	22.30	17.90	13.80	10.00	
5/16-18 BSW	55° Mod. Whitworth	H3	4		015632AS	015633AS	72.30	72.30	72.30	60.00	47.70	35.40	28.20	25.30	
5/16-18 NC*	Micrograin Carbide	H3	4		018695RS	018696RS	99.00	99.00	99.00	99.00	99.00	86.10	84.20	82.20	
	Micrograin Carbide Spiral Pt.	H3	2		018690RS		102.30	102.30	102.30	102.30	102.30	89.00	87.00	84.90	
	Double Lead	H3	4		014935AS	014936AS	33.40	33.40	33.40	33.40	33.40	29.10	28.40	27.70	
	LH 1" O.D. Die				041027AS		68.00	67.00	65.30	54.40	40.80	34.00	32.60	28.60	
5/16-20 NS	Hand Tap	H3	4	011731AS	011732AS	011733AS	27.50	27.10	26.40	22.00	16.50	13.80	13.20	11.60	
	1" O.D. Die				041236AS		68.00	67.00	65.30	54.40	40.80	34.00	32.60	28.60	
5/16-22 BSF	55° Mod. Whitworth	H3	4		015772AS	015773AS	72.30	72.30	72.30	60.00	47.70	35.40	28.20	25.30	
5/16-24 NF*	Hand Tap	H1	3		011081AS		37.90	37.10	36.40	30.30	22.70	18.20	14.00	10.20	
	Hand Tap	H4	4	011082AS			37.90	37.10	36.40	30.30	22.70	18.20	14.00	10.20	
	Hand Tap	H5	4		011083AS	011084AS	35.90	35.20	34.50	28.70	21.50	17.20	13.30	9.70	
	Hand Tap	H6	4		011085AS	011086AS	35.90	35.20	34.50	28.70	21.50	17.20	13.30	9.70	
	+.003 Hand Tap	H7	4	011758AS	011759AS	011760AS	35.90	35.20	34.50	28.70	21.50	17.20	13.30	9.70	
	+.005 Hand Tap	H11	4		014568AS	014569AS	12.60	12.60	12.60	12.60	12.60	11.00	10.70	10.50	
	Spiral Pt.	H5	2		011087AS		37.20	37.20	37.20	30.90	24.60	18.20	14.50	13.00	
	Spiral Pt.	H6	2		011088AS		37.20	37.20	37.20	30.90	24.60	18.20	14.50	13.00	
	+.005 Spiral Pt.	H11	2		014565AS		13.00	13.00	13.00	13.00	13.00	11.30	11.10	10.80	
	LH Spiral Pt.	H3	2		017157AS		19.30	19.30	19.30	19.30	19.30	16.80	16.40	16.00	
	Micrograin Carbide	H3	4		018729RS	018730RS	99.00	89.10	84.20	79.20	77.20	74.30	71.30	69.30	
		Micrograin Carbide Spiral Pt.	H3	2		018727RS		102.30	92.10	87.00	81.80	79.80	76.70	73.70	71.60
		LH 1" O.D. Die				041029AS		68.00	67.00	65.30	54.40	40.80	34.00	32.60	28.60
	5/16-27 NS	Hand Tap	H3	4	011772AS	011773AS	011774AS	27.50	27.10	26.40	22.00	16.50	13.80	13.20	11.60
1" O.D. Die					041237AS		68.00	67.00	65.30	54.40	40.80	34.00	32.60	28.60	
5/16-28 NS	Hand Tap	H3	4	011785AS	011786AS	011787AS	27.50	27.10	26.40	22.00	16.50	13.80	13.20	11.60	
5/16-32 NEF	Hand Tap	H3	4	011804AS	011805AS	011806AS	9.10	9.10	9.10	9.10	9.10	7.90	7.70	7.60	
	Hand Tap	H5	4	011814AS	011815AS	011816AS	20.90	20.60	20.10	16.70	12.50	10.50	10.00	8.80	
	Spiral Pt.	H3	2		011801AS		23.80	23.40	22.80	19.00	14.30	11.90	11.40	10.00	
	1" O.D. Die				041238AS		68.00	67.00	65.30	54.40	40.80	34.00	32.60	28.60	
5/16-40 NS	Hand Tap	H2	4	011821AS	011822AS	011823AS	27.50	27.10	26.40	22.00	16.50	13.80	13.20	11.60	
	1" O.D. Die				041239AS		68.00	67.00	65.30	54.40	40.80	34.00	32.60	28.60	
11/32-32 NS	Hand Tap	H3	4	011850AS	011851AS	011852AS	39.50	38.90	37.90	31.60	23.70	19.80	19.00	16.60	
3/8-12 ACME	Acme Tandem Unipass	2G	4		015000AS		162.50	130.00	104.00	91.00	81.30	81.30	81.30	81.30	
3/8-16 NC*	Hand Tap	H1	3		011089AS	011090AS	39.30	38.70	37.70	31.40	23.60	19.70	18.90	16.50	
	Hand Tap	H5	3		011092AS	011093AS	39.30	38.70	37.70	31.40	23.60	19.70	18.90	16.50	
	+.003 Hand Tap	H7	4	011899AS	011900AS	011901AS	39.30	38.70	37.70	31.40	23.60	19.70	18.90	16.50	
	+.010 Hand Tap	H21	4	014686AS	014687AS	014688AS	37.80	37.20	36.30	30.20	22.70	18.90	18.10	15.90	
	Small Shank Hand	H3	4	011870AS	011871AS	011872AS	38.00	37.40	36.50	30.40	22.80	19.00	18.20	16.00	
	Spiral Pt.	H3	2		011884AS		20.70	20.70	20.70	17.20	13.70	10.10	8.10	7.20	
	Spiral Pt.	H6	3		011200AS		45.90	45.90	45.90	38.10	30.30	22.50	17.90	16.10	
	+.003 Spiral Pt.	H7	3		011201AS		45.90	45.90	45.90	38.10	30.30	22.50	17.90	16.10	

*The most popular limits and flute configurations, both Right- and Left-Hand sizes, are shown in our Industrial Metalworking catalog and on our website.

SPECIAL TAPS & DIES



3/8-16 To 7/16-14

Call for pricing on Special Gages for these taps.

Size/Pitch	Type	GH#	#FI	Taper	Plug	Bottom	1	2	3	6	8	12	24	48
3/8-16 NC*	LH Spiral Pt.	H3	3		017174AS		20.10	20.10	20.10	20.10	20.10	17.50	17.10	16.70
	Micrograin Carbide	H3	4		018756RS	018757RS	123.70	111.30	105.10	99.00	96.50	92.80	89.10	86.60
	Micrograin Carbide Spiral Pt.	H3	3		018751RS		127.10	114.40	108.00	101.70	99.10	95.30	91.50	89.00
	Double Lead	H3	4	014954AS	014955AS	014956AS	52.50	51.70	50.40	42.00	31.50	26.30	25.20	22.10
	LH 1" O.D. Die				041032AS		68.00	67.00	65.30	54.40	40.80	34.00	32.60	28.60
3/8-18 NS	Hand Tap	H3	4	011916AS	011917AS	011918AS	31.20	30.70	30.00	25.00	18.70	15.60	15.00	13.10
3/8-18 NPSI*	Straight Pipe		4		015854AS		73.20	72.10	70.30	58.60	43.90	36.60	35.10	30.70
3/8-18 NPTF*	LH Pipe		4		017526AS		73.20	72.10	70.30	58.60	43.90	36.60	35.10	30.70
	Carbo-Clad Pipe		4		019383US		292.20	292.20	292.20	292.20	292.20	292.20	286.40	280.50
	1" O.D. Die				041242AS		68.00	67.00	65.30	54.40	40.80	34.00	32.60	28.60
3/8-19 BSPT	55° Mod. Whit Taper		4		015734AS		30.50	30.50	30.50	30.50	30.50	30.50	30.50	30.50
	55° Full Form Taper		4		015733AS	015721AS	78.40	78.40	78.40	78.40	78.40	68.20	66.60	65.10
3/8-19 BSPP	55° Mod. Whit Parallel		4		015704AS		30.50	30.50	30.50	30.50	30.50	30.50	30.50	30.50
	55° Full Form Parallel		4		015703AS	015722AS	78.40	78.40	78.40	78.40	78.40	68.20	66.60	65.10
3/8-20 NS	Hand Tap	H3	4	011924AS	011925AS	011926AS	30.40	29.90	29.20	24.30	18.20	15.20	14.60	12.80
3/8-20 BSF	55° Mod. Whitworth	H3	4		015774AS	015775AS	75.30	75.30	75.30	62.50	49.70	36.90	29.40	26.40
	1" O.D. Die				041243AS		68.00	67.00	65.30	54.40	40.80	34.00	32.60	28.60
3/8-24 NF*	Hand Tap	H5	4	011932AS	011933AS	011934AS	40.50	39.70	38.90	32.40	24.30	19.40	15.00	10.90
	+0.003 Hand Tap	H7	4	011944AS	011945AS	011946AS	40.50	39.70	38.90	32.40	24.30	19.40	15.00	10.90
	Hand Tap	H8	4		011096AS	011097AS	40.50	39.70	38.90	32.40	24.30	19.40	15.00	10.90
	+0.005 Hand Tap	H11	4		014582AS	014583AS	30.70	30.20	29.50	24.60	18.40	15.40	14.70	12.90
	Spiral Pt.	H5	3		011098AS		43.40	43.40	43.40	36.00	28.60	21.30	16.90	15.20
	Spiral Pt.	H6	3		011099AS		43.40	43.40	43.40	36.00	28.60	21.30	16.90	15.20
	+0.003 Spiral Pt.	H7	3		011100AS		43.40	43.40	43.40	36.00	28.60	21.30	16.90	15.20
	+0.005 Spiral Pt.	H11	3		014579AS		33.20	32.70	31.90	26.60	19.90	16.60	15.90	13.90
	LH Spiral Pt.	H3	3		017189AS		20.20	20.20	20.20	20.20	20.20	17.60	17.20	16.80
	Micrograin Carbide	H3	4		018792RS	018793RS	123.70	111.30	105.10	99.00	96.50	92.80	89.10	86.60
	Micrograin Carbide Spiral Pt.	H3	3		018791RS		127.10	114.40	108.00	101.70	99.10	95.30	91.50	89.00
	LH 1" O.D. Die				041034AS		68.00	67.00	65.30	54.40	40.80	34.00	32.60	28.60
3/8-27 NS	Hand Tap	H3	4	011958AS	011959AS	011960AS	30.70	30.20	29.50	24.60	18.40	15.40	14.70	12.90
	1" O.D. Die				041244AS		68.00	67.00	65.30	54.40	40.80	34.00	32.60	28.60
3/8-28 NS	Hand Tap	H3	4	011977AS	011978AS	011979AS	30.70	30.20	29.50	24.60	18.40	15.40	14.70	12.90
3/8-32 NEF	Hand Tap	H3	4	012003AS	012004AS	012005AS	9.90	9.90	9.90	9.90	9.90	8.60	8.40	8.20
	Hand Tap	H5	4	012013AS	012014AS	012015AS	24.20	23.80	23.20	19.40	14.50	12.10	11.60	10.20
	Spiral Pt.	H3	3		012002AS		26.80	26.40	25.70	21.40	16.10	13.40	12.90	11.30
	1" O.D. Die				041246AS		68.00	67.00	65.30	54.40	40.80	34.00	32.60	28.60
3/8-40 NS	Hand Tap	H2	4	012026AS	012027AS	012028AS	30.70	30.20	29.50	24.60	18.40	15.40	14.70	12.90
	Hand Tap	H3	4	012031AS	012032AS	012033AS	36.80	36.20	35.30	29.40	22.10	18.40	17.70	15.50
	1" O.D. Die				041248AS		68.00	67.00	65.30	54.40	40.80	34.00	32.60	28.60
3/8-48 NS	Hand Tap	H2	4	012039AS	012040AS	012041AS	36.80	36.20	35.30	29.40	22.10	18.40	17.70	15.50
13/32-32 NS	Hand Tap	H3	4	012073AS	012074AS	012075AS	43.70	42.80	42.00	35.00	26.20	21.00	16.20	11.80
7/16-14 NC*	Hand Tap	H2	4		011101AS		43.20	42.30	41.50	34.60	25.90	20.70	16.00	11.70
	+0.010 Hand Tap	H21	4	014694AS	014695AS	014696AS	43.20	42.30	41.50	34.60	25.90	20.70	16.00	11.70
	LH Spiral Pt.	H3	3		017203AS		48.80	47.80	46.80	39.00	29.30	23.40	18.10	13.20

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SPECIAL TAPS & DIES



7/16-14 To 1/2-13

Call for pricing on Special Gages for these taps.

Size/Pitch	Type	GH#	#Fl	Taper	Plug	Bottom	1	2	3	6	8	12	24	48
7/16-14 NC*	Carbo-Clad	H3	4		019049US	019050US	167.00	167.00	167.00	167.00	167.00	145.30	142.00	138.60
	Micrograin Carbide Spiral Pt.	H3	3		018732RS		142.40	128.20	121.00	113.90	111.10	106.80	102.50	99.70
	LH 1-1/2" O.D. Die				041050AS		88.30	87.00	84.80	70.60	53.00	44.20	42.40	37.10
7/16-16 NS	Hand Tap	H3	4	012099AS	012100AS	012101AS	34.40	33.90	33.00	27.50	20.60	17.20	16.50	14.40
	1-1/2" O.D. Die				041275AS		88.30	87.00	84.80	70.60	53.00	44.20	42.40	37.10
7/16-18 NS	Hand Tap	H3	4	012110AS	012111AS	012112AS	34.40	33.90	33.00	27.50	20.60	17.20	16.50	14.40
	1-1/2" O.D. Die				041276AS		88.30	87.00	84.80	70.60	53.00	44.20	42.40	37.10
7/16-20 NF*	Hand Tap	H2	4		011103AS		36.60	36.10	35.10	29.30	22.00	18.30	17.60	15.40
	Hand Tap	H6	4		011105AS	011106AS	20.60	20.60	20.60	20.60	20.60	17.90	17.50	17.10
	+0.005 Hand Tap	H11	4		014596AS	014597AS	20.60	20.60	20.60	20.60	20.60	17.90	17.50	17.10
	+0.005 Spiral Pt.	H11	3		014593AS		22.10	22.10	22.10	22.10	22.10	19.20	18.80	18.30
	Carbo-Clad	H3	4		019062US	019063US	168.30	168.30	168.30	168.30	168.30	146.40	143.10	139.70
	LH 1-1/2" O.D. Die				041051AS		88.30	87.00	84.80	70.60	53.00	44.20	42.40	37.10
7/16-24 NS	Hand Tap	H3	4	012141AS	012142AS	012143AS	34.40	33.90	33.00	27.50	20.60	17.20	16.50	14.40
	Hand Tap	H5	4	012152AS	012153AS	012154AS	41.80	41.20	40.10	33.40	25.10	20.90	20.10	17.60
	1-1/2" O.D. Die				041277AS		88.30	87.00	84.80	70.60	53.00	44.20	42.40	37.10
7/16-27 NS	Hand Tap	H3	4	012164AS	012165AS	012166AS	34.40	33.90	33.00	27.50	20.60	17.20	16.50	14.40
	1-1/2" O.D. Die				041278AS		88.30	87.00	84.80	70.60	53.00	44.20	42.40	37.10
7/16-28 NEF	Hand Tap	H3	4	012176AS	012177AS	012178AS	12.40	12.40	12.40	12.40	12.40	10.80	10.50	10.30
	Hand Tap	H5	4	012186AS	012187AS	012188AS	27.70	27.30	26.60	22.20	16.60	13.90	13.30	11.60
	1-1/2" O.D. Die				041279AS		88.30	87.00	84.80	70.60	53.00	44.20	42.40	37.10
7/16-32 NS	Hand Tap	H3	4	012199AS	012200AS	012201AS	34.40	33.90	33.00	27.50	20.60	17.20	16.50	14.40
	1-1/2" O.D. Die				041280AS		88.30	87.00	84.80	70.60	53.00	44.20	42.40	37.10
7/16-40 NS	Hand Tap	H2	4	012218AS	012219AS	012220AS	34.40	33.90	33.00	27.50	20.60	17.20	16.50	14.40
	1-1/2" O.D. Die				041282AS		88.30	87.00	84.80	70.60	53.00	44.20	42.40	37.10
15/32-32 NS	Hand Tap	H3	6	012233AS	012234AS	012235AS	49.20	48.50	47.20	39.40	29.50	24.60	23.60	20.70
	Spiral Pt.	H3	3		011107AS		51.50	50.70	49.40	41.20	30.90	25.80	24.70	21.60
1/2-10 ACME	Acme Hand	2G	4		015240AS		69.00	68.00	66.20	55.20	41.40	34.50	33.10	29.00
	LH Acme Tap	2G	4		017630AS		69.00	68.00	66.20	55.20	41.40	34.50	33.10	29.00
	Acme Tandem Unipass	2G	4		015002AS		145.70	116.60	93.20	81.60	72.90	72.90	72.90	72.90
	LH Acme Tandem Unipass	2G	4		017602AS		177.00	141.60	113.30	99.10	88.50	88.50	88.50	88.50
1/2-12 NS	Hand Tap	H3	4	012241AS	012242AS	012243AS	40.30	39.70	38.70	32.20	24.20	20.20	19.30	16.90
1/2-12 BSW	55° Mod. Whitworth	H3	4	015640AS	015641AS	015642AS	40.30	39.70	38.70	32.20	24.20	20.20	19.30	16.90
1/2-12 NS	1-1/2" O.D. Die				041284AS		88.30	87.00	84.80	70.60	53.00	44.20	42.40	37.10
1/2-13 NC*	+0.003 Hand Tap	H7	4		011108AS	011109AS	48.90	48.20	46.90	39.10	29.30	24.50	23.50	20.50
	+0.010 Hand Tap	H21	4	014702AS	014703AS	014704AS	48.90	48.20	46.90	39.10	29.30	24.50	23.50	20.50
	LH Spiral Pt.	H3	3		017231AS		25.40	25.40	25.40	25.40	25.40	22.10	21.60	21.10
	Carbo-Clad	H3	4		019081US	019082US	193.30	193.30	193.30	193.30	193.30	168.20	164.30	160.40
	Micrograin Carbide Spiral Pt.	H3	3		018738RS		158.60	142.70	134.80	126.90	123.70	119.00	114.20	111.00
	Double Lead	H3	4		014957AS	014958AS	27.20	27.20	27.20	27.20	27.20	27.20	26.70	26.10

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SPECIAL TAPS & DIES



1/2-13 To 9/16-18

Call for pricing on Special Gages for these taps.

Size/Pitch	Type	GH#	#FI	Taper	Plug	Bottom	1	2	3	6	8	12	24	48
1/2-13 NC*	LH 1-1/2" O.D. Die				041055AS		88.30	87.00	84.80	70.60	53.00	44.20	42.40	37.10
1/2-14 NS	Hand Tap	H3	4	012274AS	012275AS	012276AS	40.30	39.70	38.70	32.20	24.20	20.20	19.30	16.90
1/2-14 NPSI*	Straight Pipe		4		015856AS		99.10	97.60	95.10	79.30	59.50	49.60	47.60	41.60
1/2-14 NPTF*	LH Pipe		4		017528AS		89.40	88.10	85.80	71.50	53.60	44.70	42.90	37.50
1/2-14 BSPT	55° Mod. Whit Taper		4		015736AS		48.70	48.70	48.70	48.70	48.70	48.70	48.70	48.70
	55° Full Form Taper		4		015735AS	015723AS	124.60	124.60	124.60	124.60	124.60	108.40	105.90	103.40
1/2-14 BSPP	55° Mod. Whit Parallel		4		015706AS		48.70	48.70	48.70	48.70	48.70	48.70	48.70	48.70
	55° Full Form Parallel		4		015705AS	015724AS	124.60	124.60	124.60	124.60	124.60	108.40	105.90	103.40
1/2-14 NPTF	Carbo-Clad Pipe		4		019384US		312.20	312.20	312.20	312.20	312.20	312.20	306.00	299.70
1/2-14 NS	1-1/2" O.D. Die				041285AS		88.30	87.00	84.80	70.60	53.00	44.20	42.40	37.10
1/2-16 NS	Hand Tap	H3	4	012288AS	012289AS	012290AS	40.30	39.70	38.70	32.20	24.20	20.20	19.30	16.90
	1-1/2" O.D. Die				041286AS		88.30	87.00	84.80	70.60	53.00	44.20	42.40	37.10
1/2-18 NS	Hand Tap	H3	4	012295AS	012296AS	012297AS	40.30	39.70	38.70	32.20	24.20	20.20	19.30	16.90
	1-1/2" O.D. Die				041287AS		88.30	87.00	84.80	70.60	53.00	44.20	42.40	37.10
1/2-20 NF*	+0.03 Hand Tap	H7	4	012328AS	012329AS	012330AS	43.40	42.70	41.70	34.70	26.00	21.70	20.80	18.20
	+0.05 Spiral Pt.	H11	3		014607AS		26.60	26.60	26.60	26.60	26.60	23.10	22.60	22.10
	+0.05 Hand Tap	H11	4		014614AS	014615AS	24.40	24.40	24.40	24.40	24.40	21.20	20.70	20.30
	LH Spiral Pt.	H3	3		017244AS		25.90	25.90	25.90	25.90	25.90	22.50	22.00	21.50
	Carbo-Clad	H3	4		019086US	019087US	194.60	194.60	194.60	194.60	194.60	169.30	165.40	161.50
	Micrograin Carbide Spiral Pt.	H3	3		018741RS		165.90	149.30	141.00	132.70	129.40	124.40	119.40	116.10
	LH 1-1/2" O.D. Die				041056AS		88.30	87.00	84.80	70.60	53.00	44.20	42.40	37.10
1/2-24 NS	Hand Tap	H3	4	012336AS	012337AS	012338AS	40.30	39.70	38.70	32.20	24.20	20.20	19.30	16.90
	1-1/2" O.D. Die				041288AS		88.30	87.00	84.80	70.60	53.00	44.20	42.40	37.10
1/2-27 NS	Hand Tap	H3	4		011111AS	011112AS	40.30	39.70	38.70	32.20	24.20	20.20	19.30	16.90
	Hand Tap	H3	6	012343AS	012344AS	012345AS	40.30	39.70	38.70	32.20	24.20	20.20	19.30	16.90
	1-1/2" O.D. Die				041289AS		88.30	87.00	84.80	70.60	53.00	44.20	42.40	37.10
1/2-28 NEF	Hand Tap	H3	4	012357AS	012358AS	012359AS	14.70	14.70	14.70	14.70	14.70	12.80	12.50	12.20
	Hand Tap	H5	4	012372AS	012373AS	012374AS	32.80	32.30	31.50	26.20	19.70	16.40	15.70	13.80
	Spiral Pt.	H3	3		012356AS		32.80	32.30	31.50	26.20	19.70	16.40	15.70	13.80
	1-1/2" O.D. Die				041290AS		88.30	87.00	84.80	70.60	53.00	44.20	42.40	37.10
1/2-32 NS	Hand Tap	H3	6	012390AS	012391AS	012392AS	40.30	39.70	38.70	32.20	24.20	20.20	19.30	16.90
	1-1/2" O.D. Die				041291AS		88.30	87.00	84.80	70.60	53.00	44.20	42.40	37.10
1/2-40 NS	Hand Tap	H2	6	012397AS	012398AS	012399AS	40.30	39.70	38.70	32.20	24.20	20.20	19.30	16.90
	1-1/2" O.D. Die				041292AS		88.30	87.00	84.80	70.60	53.00	44.20	42.40	37.10
33/64-13 NS	Hand Tap	H3	4	012404AS	012405AS	012406AS	51.20	50.40	49.20	41.00	30.70	25.60	24.60	21.50
9/16-12 NC*	Hand Tap	H1	4	011113AS			55.20	54.10	53.00	44.20	33.10	26.50	20.40	14.90
	Fast Spiral Flute	H3	3		012533AS	012534AS	67.10	65.80	60.40	50.30	36.90	30.20	23.50	18.80
	Carbo-Clad	H3	4		019096US	019097US	214.90	214.90	214.90	214.90	214.90	187.00	182.70	178.40
	LH 1-1/2" O.D. Die				041058AS		88.30	87.00	84.80	70.60	53.00	44.20	42.40	37.10
9/16-16 NS	Hand Tap	H3	4	012437AS	012438AS	012439AS	44.30	43.60	42.50	35.40	26.60	22.20	21.30	18.60
	1-1/2" O.D. Die				041293AS		88.30	87.00	84.80	70.60	53.00	44.20	42.40	37.10
9/16-18 NF	Hand Tap	H1	4		011115AS		55.20	54.10	53.00	44.20	33.10	26.50	20.40	14.90

*The most popular limits and flute configurations, both Right- and Left-Hand sizes, are shown in our Industrial Metalworking catalog and on our website.

SPECIAL TAPS & DIES



9/16-18 To 5/8-28

Call for pricing on Special Gages for these taps.

Size/Pitch	Type	GH#	#FI	Taper	Plug	Bottom	1	2	3	6	8	12	24	48
9/16-18 NF*	+ .005 Hand Tap	H11	4		014618AS	014619AS	55.20	54.10	53.00	44.20	33.10	26.50	20.40	14.90
	Fast Spiral Flute	H3	3		012535AS	012538AS	67.10	65.80	60.40	50.30	36.90	30.20	23.50	18.80
	+ .005 Spiral Pt.	H11	3		012459AS		55.20	54.40	53.00	44.20	33.10	27.60	26.50	23.20
	Carbo-Clad	H3	4		019104US	019105US	214.90	214.90	214.90	214.90	214.90	187.00	182.70	178.40
	LH 1-1/2" O.D. Die				041059AS		88.30	87.00	84.80	70.60	53.00	44.20	42.40	37.10
9/16-20 NS	Hand Tap	H3	4	012455AS	012456AS	012457AS	44.30	43.60	42.50	35.40	26.60	22.20	21.30	18.60
	Spiral Pt.	H3	3		012460AS		46.70	46.00	44.80	37.40	28.00	23.40	22.40	19.60
	1-1/2" O.D. Die				041294AS		88.30	87.00	84.80	70.60	53.00	44.20	42.40	37.10
9/16-24 NEF	Hand Tap	H3	4	012467AS	012468AS	012469AS	18.10	18.10	18.10	18.10	18.10	15.70	15.40	15.00
	Hand Tap	H5	4	012482AS	012483AS	012484AS	35.40	34.90	34.00	28.30	21.20	17.70	17.00	14.90
	1-1/2" O.D. Die				041295AS		88.30	87.00	84.80	70.60	53.00	44.20	42.40	37.10
9/16-27 NS	Hand Tap	H3	6	012494AS	012495AS	012496AS	44.30	43.60	42.50	35.40	26.60	22.20	21.30	18.60
	1-1/2" O.D. Die				041296AS		88.30	87.00	84.80	70.60	53.00	44.20	42.40	37.10
9/16-32 NS	Hand Tap	H3	6	012509AS	012510AS	012511AS	44.30	43.60	42.50	35.40	26.60	22.20	21.30	18.60
	1-1/2" O.D. Die				041297AS		88.30	87.00	84.80	70.60	53.00	44.20	42.40	37.10
5/8-8 ACME	Acme Hand	2G	4		015241AS		85.60	84.30	82.20	68.50	51.40	42.80	41.10	36.00
	LH Acme Tap	2G	4		017632AS		85.60	84.30	82.20	68.50	51.40	42.80	41.10	36.00
	Acme Tandem Unipass	2G	4		015007AS		182.50	146.00	116.80	102.20	91.30	91.30	91.30	91.30
	LH Acme Tandem Unipass	2G	4		017604AS		182.50	146.00	116.80	102.20	91.30	91.30	91.30	91.30
5/8-10 NS	Hand Tap	H3	4	012524AS	012525AS	012526AS	62.70	61.80	60.20	50.20	37.60	31.40	30.10	26.30
5/8-11 NC*	+ .010 Hand Tap	H21	4	014710AS	014711AS	014712AS	64.10	63.10	61.50	51.30	38.50	32.10	30.80	26.90
	Spiral Flute	H3	4		012536AS	012537AS	82.20	80.60	74.00	61.70	45.20	37.00	28.80	23.00
	LH Spiral Pt.	H3	3		017287AS		36.30	35.60	32.70	27.20	20.00	16.30	12.70	10.20
5/8-11 BSW	55° Mod. Whitworth	H3	4	015648AS	015649AS	015650AS	63.00	62.10	60.50	50.40	37.80	31.50	30.20	26.50
5/8-11 NC*	Carbo-Clad	H3	4		019112US	019113US	242.00	242.00	242.00	242.00	242.00	210.50	205.70	200.90
	LH 1-1/2" O.D. Die				041060AS		88.30	87.00	84.80	70.60	53.00	44.20	42.40	37.10
5/8-12 NS	Hand Tap	H3	4	012542AS	012543AS	012544AS	55.20	54.40	53.00	44.20	33.10	27.60	26.50	23.20
	1-1/2" O.D. Die				041299AS		88.30	87.00	84.80	70.60	53.00	44.20	42.40	37.10
5/8-16 NS	Hand Tap	H3	4	012557AS	012558AS	012559AS	55.20	54.40	53.00	44.20	33.10	27.60	26.50	23.20
	1-1/2" O.D. Die				041301AS		88.30	87.00	84.80	70.60	53.00	44.20	42.40	37.10
5/8-18 NF*	+ .003 Hand Tap	H7	4		011118AS	011119AS	30.20	30.20	30.20	30.20	30.20	26.30	25.70	25.10
	Hand Tap	H8	4		011120AS	011121AS	30.20	30.20	30.20	30.20	30.20	26.30	25.70	25.10
	+ .005 Hand Tap	H11	4		014627AS	014628AS	30.20	30.20	30.20	30.20	30.20	26.30	25.70	25.10
	+ .005 Spiral Pt.	H11	3		012461AS		32.90	32.90	32.90	32.90	32.90	28.60	28.00	27.30
	Spiral Flute	H3	4		012564AS	012565AS	82.20	80.60	74.00	61.70	45.20	37.00	28.80	23.00
	Carbo-Clad	H3	4		019120US	019121US	248.50	248.50	248.50	248.50	248.50	216.20	211.20	206.30
	LH 1-1/2" O.D. Die				041061AS		88.30	87.00	84.80	70.60	53.00	44.20	42.40	37.10
5/8-20 NS	Hand Tap	H3	4	012576AS	012577AS	012578AS	55.20	54.40	53.00	44.20	33.10	27.60	26.50	23.20
	1-1/2" O.D. Die				041302AS		88.30	87.00	84.80	70.60	53.00	44.20	42.40	37.10
5/8-24 NEF	Hand Tap	H3	6	012588AS	012589AS	012590AS	20.80	20.80	20.80	20.80	20.80	18.10	17.70	17.30
	Hand Tap	H5	6	012598AS	012599AS	012600AS	43.10	42.50	41.40	34.50	25.90	21.60	20.70	18.10
	1-1/2" O.D. Die				041303AS		88.30	87.00	84.80	70.60	53.00	44.20	42.40	37.10
5/8-27 NS	Hand Tap	H3	6	012610AS	012611AS	012612AS	55.20	54.40	53.00	44.20	33.10	27.60	26.50	23.20
	1-1/2" O.D. Die				041304AS		88.30	87.00	84.80	70.60	53.00	44.20	42.40	37.10
5/8-28 NS	Hand Tap	H3	6	012617AS	012618AS	012619AS	55.20	54.40	53.00	44.20	33.10	27.60	26.50	23.20

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SPECIAL TAPS & DIES



5/8-28 To 3/4-16

Call for pricing on Special Gages for these taps.

Size/Pitch	Type	GH#	#FI	Taper	Plug	Bottom	1	2	3	6	8	12	24	48
5/8-28 NS	1-1/2" O.D. Die				041305AS		88.30	87.00	84.80	70.60	53.00	44.20	42.40	37.10
5/8-32 NS	Hand Tap	H3	6	012625AS	012626AS	012627AS	55.20	54.40	53.00	44.20	33.10	27.60	26.50	23.20
	1-1/2" O.D. Die				041306AS		88.30	87.00	84.80	70.60	53.00	44.20	42.40	37.10
41/64-11 NS	Hand Tap	H4	4	012640AS	012641AS	012642AS	65.20	64.20	62.60	52.20	39.10	32.60	31.30	27.40
11/16-18 NS	Hand Tap	H3	6	012680AS	012681AS	012682AS	62.50	61.60	60.00	50.00	37.50	31.30	30.00	26.30
	LH Hand Tap	H3	4		017291AS	017292AS	62.50	61.60	60.00	50.00	37.50	31.30	30.00	26.30
	2" O.D. Die				041326AS		184.90	182.10	177.50	147.90	110.90	92.50	88.80	77.70
11/16-20 NS	Hand Tap	H3	6	012699AS	012700AS	012701AS	62.50	61.60	60.00	50.00	37.50	31.30	30.00	26.30
	2" O.D. Die				041327AS		184.90	182.10	177.50	147.90	110.90	92.50	88.80	77.70
11/16-24 NEF	Hand Tap	H3	6	012716AS	012717AS	012718AS	23.80	23.80	23.80	23.80	23.80	20.70	20.20	19.80
	Hand Tap	H5	6	012726AS	012727AS	012728AS	48.90	48.20	46.90	39.10	29.30	24.50	23.50	20.50
	2" O.D. Die				041328AS		184.90	182.10	177.50	147.90	110.90	92.50	88.80	77.70
11/16-28 NS	Hand Tap	H3	6	012739AS	012740AS	012741AS	62.50	61.60	60.00	50.00	37.50	31.30	30.00	26.30
11/16-32 NS	Hand Tap	H3	6	012749AS	012750AS	012751AS	62.50	61.60	60.00	50.00	37.50	31.30	30.00	26.30
	2" O.D. Die				041330AS		184.90	182.10	177.50	147.90	110.90	92.50	88.80	77.70
3/4-5 ACME	Acme Hand	2G	4		015242AS	015247AS	97.30	95.80	93.40	77.80	58.40	48.70	46.70	40.90
3/4-6 ACME	Acme Hand	2G	4		015243AS		90.50	89.10	86.90	72.40	54.30	45.30	43.40	38.00
	LH Acme Tap	2G	4		017634AS		90.50	89.10	86.90	72.40	54.30	45.30	43.40	38.00
	Acme Tandem Unipass	2G	4		015004AS		194.70	155.80	124.60	109.00	97.40	97.40	97.40	97.40
	LH Acme Tandem Unipass	2G	4		017606AS		194.70	155.80	124.60	109.00	97.40	97.40	97.40	97.40
3/4-8 ACME	Acme Hand	2G	4		015244AS		100.40	98.90	96.40	80.30	60.20	50.20	48.20	42.20
	Acme Tandem Unipass	2G	4		015006AS		205.70	164.60	131.60	115.20	102.90	102.90	102.90	102.90
	LH Acme Tandem Unipass	2G	4		017608AS		205.70	164.60	131.60	115.20	102.90	102.90	102.90	102.90
3/4-10 NC*	Hand Tap	H1	4		011122AS	011124AS	55.90	55.90	55.90	46.40	36.90	27.40	21.80	19.60
	+0.005 Hand Tap	H11	4		014631AS	014632AS	37.20	37.20	37.20	30.90	24.60	18.20	14.50	13.00
	+0.010 Hand Tap	H21	4	014718AS	014719AS	014720AS	77.70	76.50	74.60	62.20	46.60	38.90	37.30	32.60
	+0.005 Spiral Pt.	H11	3		008603AS		41.80	41.80	41.80	34.70	27.60	20.50	16.30	14.60
	Spiral Flute	H3	4		012780AS	012781AS	99.70	97.70	89.70	74.80	54.80	44.90	34.90	27.90
	Carbo-Clad	H3	4		019140US	019141US	284.10	284.10	284.10	284.10	284.10	247.20	241.50	235.80
3/4-10 ACME	Acme Hand	2G	4		015245AS		96.40	95.00	92.50	77.10	57.80	48.20	46.30	40.50
	LH 2" O.D. Die				041078AS		184.90	182.10	177.50	147.90	110.90	92.50	88.80	77.70
3/4-11-1/2 NH	Garden Hose		4		015965AS	015966AS	120.80	119.00	116.00	96.60	72.50	60.40	58.00	50.70
3/4-12 NS	Hand Tap	H4	4	012818AS	012819AS	012820AS	69.30	68.30	66.50	55.40	41.60	34.70	33.30	29.10
	2" O.D. Die				041331AS		184.90	182.10	177.50	147.90	110.90	92.50	88.80	77.70
3/4-14 NPSI	Straight Pipe		5		015858AS		121.60	119.80	116.70	97.30	73.00	60.80	58.40	51.10
3/4-14 NPTF	LH Pipe		5		017530AS		107.90	106.30	103.60	86.30	64.70	54.00	51.80	45.30
3/4-14 BSPT	55° Mod. Whit. Taper		5		015738AS		67.20	67.20	67.20	67.20	67.20	67.20	67.20	67.20
	55° Full Form Taper		5		015737AS	015725AS	136.30	136.30	136.30	136.30	136.30	118.60	115.90	113.10
3/4-14 BSPP	55° Mod. Whit. Parallel		5		015708AS		67.20	67.20	67.20	67.20	67.20	67.20	67.20	67.20
	55° Full Form Parallel		5		015707AS	015726AS	136.30	136.30	136.30	136.30	136.30	118.60	115.90	113.10
3/4-14 NPT	Carbo-Clad Pipe		5		019385US		348.50	348.50	348.50	348.50	348.50	348.50	341.50	334.60
3/4-16 NF*	+0.003 Hand Tap	H7	4		011126AS	011127AS	55.90	55.90	55.90	46.40	36.90	27.40	21.80	19.60
	Hand Tap	H8	4		011128AS	011129AS	55.90	55.90	55.90	46.40	36.90	27.40	21.80	19.60
	+0.005 Hand Tap	H11	4		014635AS	014636AS	37.90	37.90	37.90	31.50	25.00	18.60	14.80	13.30

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SPECIAL TAPS & DIES



3/4-16 To 7/8-9

Call for pricing on Special Gages for these taps.

Size/Pitch	Type	GH#	#FI	Taper	Plug	Bottom	1	2	3	6	8	12	24	48
3/4-16 NF*	Spiral Pt.	H5	3		099412AS		44.10	44.10	44.10	36.60	29.10	21.60	17.20	15.40
	+005 Spiral Pt.	H11	3		012841AS		44.10	44.10	44.10	36.60	29.10	21.60	17.20	15.40
	LH Hand Tap	H5	4		017300AS	017293AS	40.70	40.70	40.70	40.70	40.70	35.40	34.60	33.80
	Spiral Flute	H3	4		012833AS	012834AS	99.60	97.60	89.60	74.70	54.80	44.80	34.90	27.90
	Carbo-Clad	H3	4		019148US	019149US	275.40	275.40	275.40	275.40	275.40	239.60	234.10	228.60
	LH 2" O.D. Die				041079AS		184.90	182.10	177.50	147.90	110.90	92.50	88.80	77.70
3/4-18 NS	Hand Tap	H3	4	012858AS	012859AS	012860AS	69.30	68.30	66.50	55.40	41.60	34.70	33.30	29.10
	2" O.D. Die				041333AS		184.90	182.10	177.50	147.90	110.90	92.50	88.80	77.70
3/4-20 NEF	Hand Tap	H3	6	012870AS	012871AS	012872AS	27.80	27.80	27.80	27.80	27.80	24.20	23.60	23.10
	Hand Tap	H5	6	012880AS	012881AS	012882AS	55.70	54.90	53.50	44.60	33.40	27.90	26.70	23.40
	LH Hand Tap	H3	6		017294AS	017295AS	40.70	40.70	40.70	40.70	40.70	35.40	34.60	33.80
	2" O.D. Die				041334AS		184.90	182.10	177.50	147.90	110.90	92.50	88.80	77.70
3/4-24 NS	Hand Tap	H3	6	012887AS	012888AS	012889AS	69.30	68.30	66.50	55.40	41.60	34.70	33.30	29.10
	2" O.D. Die				041335AS		184.90	182.10	177.50	147.90	110.90	92.50	88.80	77.70
3/4-27 NS	Hand Tap	H3	6	012906AS	012907AS	012908AS	69.30	68.30	66.50	55.40	41.60	34.70	33.30	29.10
	2" O.D. Die				041336AS		184.90	182.10	177.50	147.90	110.90	92.50	88.80	77.70
3/4-32 NS	Hand Tap	H3	6	012921AS	012922AS	012923AS	69.30	68.30	66.50	55.40	41.60	34.70	33.30	29.10
	2" O.D. Die				041337AS		184.90	182.10	177.50	147.90	110.90	92.50	88.80	77.70
3/4-40 NS	Hand Tap	H3	6	012928AS	012929AS	012930AS	77.00	75.80	73.90	61.60	46.20	38.50	37.00	32.30
49/64-10 NS	Hand Tap	H4	4	012936AS	012937AS	012938AS	102.30	90.00	87.00	71.60	51.20	32.70	28.60	25.60
25/32-10 NS	Hand Tap	H4	4	012944AS	012945AS	012946AS	102.30	90.00	87.00	71.60	51.20	32.70	28.60	25.60
.800-36 AMO	55° Mod. Whitworth	H2	6	015656AS	015657AS	015658AS	86.00	84.70	82.60	68.80	51.60	43.00	41.30	36.10
13/16-10 NS	Hand Tap	H4	4	012952AS	012953AS	012954AS	76.20	75.10	73.20	61.00	45.70	38.10	36.60	32.00
13/16-12 NS	Hand Tap	H4	4	012960AS	012961AS	012962AS	76.20	75.10	73.20	61.00	45.70	38.10	36.60	32.00
13/16-16 NS	Hand Tap	H3	4	012974AS	012975AS	012976AS	76.20	75.10	73.20	61.00	45.70	38.10	36.60	32.00
	2" O.D. Die				041340AS		184.90	182.10	177.50	147.90	110.90	92.50	88.80	77.70
13/16-18 NS	Hand Tap	H3	4	012981AS	012982AS	012983AS	76.20	75.10	73.20	61.00	45.70	38.10	36.60	32.00
	2" O.D. Die				041341AS		184.90	182.10	177.50	147.90	110.90	92.50	88.80	77.70
13/16-20 NEF	Hand Tap	H3	6	012993AS	012994AS	012995AS	42.30	42.30	42.30	42.30	42.30	36.80	36.00	35.10
	Hand Tap	H5	6	013003AS	013004AS	013005AS	65.20	64.20	62.60	52.20	39.10	32.60	31.30	27.40
	2" O.D. Die				041342AS		184.90	182.10	177.50	147.90	110.90	92.50	88.80	77.70
13/16-24 NS	Hand Tap	H3	6	013015AS	013016AS	013017AS	76.20	75.10	73.20	61.00	45.70	38.10	36.60	32.00
	2" O.D. Die				041343AS		184.90	182.10	177.50	147.90	110.90	92.50	88.80	77.70
7/8-6 ACME	Acme Hand	2G	4		015246AS		98.20	96.70	94.30	78.60	58.90	49.10	47.10	41.20
	LH Acme Tap	2G	4		015009AS		98.20	96.70	94.30	78.60	58.90	49.10	47.10	41.20
	Acme Tandem Unipass	2G	4		015008AS		226.10	180.90	144.70	126.60	113.10	113.10	113.10	113.10
	LH Acme Tandem Unipass	2G	4		017610AS		226.10	180.90	144.70	126.60	113.10	113.10	113.10	113.10
7/8-9 NC*	Hand Tap	H1	4			011131AS	75.40	75.40	75.40	62.60	49.80	36.90	29.40	26.40
	Hand Tap	H2	4			011132AS	75.40	75.40	75.40	62.60	49.80	36.90	29.40	26.40
	+005 Hand Tap	H11	4		014639AS	014640AS	54.00	54.00	54.00	44.80	35.60	26.50	21.10	18.90
	Spiral Pt.	H4	3		013033AS		103.60	101.50	93.20	77.70	57.00	46.60	36.30	29.00
	Spiral Flute	H4	4		013034AS	013035AS	120.20	117.80	108.20	90.20	66.10	54.10	42.10	33.70
	Carbo-Clad	H4	4		019156US	019157US	343.90	343.90	343.90	343.90	343.90	299.20	292.30	285.40
	LH 2" O.D. Die				041081AS		184.90	182.10	177.50	147.90	110.90	92.50	88.80	77.70

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SPECIAL TAPS & DIES



7/8-10 To 1"-8

Call for pricing on Special Gages for these taps.

Size/Pitch	Type	GH#	#FI	Taper	Plug	Bottom	1	2	3	6	8	12	24	48
7/8-10 NS	Hand Tap	H4	4	013040AS	013041AS	013042AS	88.30	87.00	84.80	70.60	53.00	44.20	42.40	37.10
7/8-12 NS	Hand Tap	H4	4	013054AS	013055AS	013056AS	88.30	87.00	84.80	70.60	53.00	44.20	42.40	37.10
	2" O.D. Die				041345AS		184.90	182.10	177.50	147.90	110.90	92.50	88.80	77.70
7/8-14 NF*	Hand Tap	H5	4		011134AS	011135AS	75.40	75.40	75.40	62.60	49.80	36.90	29.40	26.40
	+.005 Hand Tap	H11	4		014643AS	014644AS	54.00	54.00	54.00	44.80	35.60	26.50	21.10	18.90
	Spiral Pt.	H4	3		013060AS		104.80	102.70	94.30	78.60	57.60	47.20	36.70	29.30
	Carbo-Clad	H4	4		019166US	019167US	347.90	347.90	347.90	347.90	347.90	302.70	295.70	288.80
	LH 2" O.D. Die				041082AS		184.90	182.10	177.50	147.90	110.90	92.50	88.80	77.70
7/8-16 NS	Hand Tap	H3	4	013075AS	013076AS	013077AS	88.40	87.10	84.90	70.70	53.00	44.20	42.40	37.10
	2" O.D. Die				041346AS		184.90	182.10	177.50	147.90	110.90	92.50	88.80	77.70
7/8-18 NS	Hand Tap	H3	6	013094AS	013095AS	013096AS	88.40	87.10	84.90	70.70	53.00	44.20	42.40	37.10
	2" O.D. Die				041347AS		184.90	182.10	177.50	147.90	110.90	92.50	88.80	77.70
7/8-20 NEF	Hand Tap	H3	6	013101AS	013102AS	013103AS	37.50	37.50	37.50	37.50	37.50	32.60	31.90	31.10
	Hand Tap	H5	6	013106AS	013107AS	013108AS	72.60	71.50	69.70	58.10	43.60	36.30	34.80	30.50
	2" O.D. Die				041348AS		184.90	182.10	177.50	147.90	110.90	92.50	88.80	77.70
7/8-24 NS	Hand Tap	H3	6	013113AS	013114AS	013115AS	97.00	95.10	87.30	72.80	53.40	43.70	34.00	27.20
	2" O.D. Die				041349AS		184.90	182.10	177.50	147.90	110.90	92.50	88.80	77.70
7/8-27 NS	Hand Tap	H3	6	013121AS	013122AS	013123AS	97.00	95.10	87.30	72.80	53.40	43.70	34.00	27.20
7/8-32 NS	Hand Tap	H3	6	013129AS	013130AS	013131AS	97.00	95.10	87.30	72.80	53.40	43.70	34.00	27.20
	2" O.D. Die				041350AS		184.90	182.10	177.50	147.90	110.90	92.50	88.80	77.70
15/16-12 NS	Hand Tap	H4	4	013137AS	013138AS	013139AS	92.00	90.60	88.30	73.60	55.20	46.00	44.20	38.60
	2" O.D. Die				041351AS		184.90	182.10	177.50	147.90	110.90	92.50	88.80	77.70
15/16-14 NS	Hand Tap	H4	4	013144AS	013145AS	013146AS	92.40	91.00	88.70	73.90	55.40	46.20	44.40	38.80
	2" O.D. Die				041352AS		184.90	182.10	177.50	147.90	110.90	92.50	88.80	77.70
15/16-16 NS	Hand Tap	H3	6	013152AS	013153AS	013154AS	92.80	91.40	89.10	74.20	55.70	46.40	44.50	39.00
	2" O.D. Die				041353AS		184.90	182.10	177.50	147.90	110.90	92.50	88.80	77.70
15/16-18 NS	Hand Tap	H3	6	013159AS	013160AS	013161AS	92.80	91.40	89.10	74.20	55.70	46.40	44.50	39.00
	2" O.D. Die				041354AS		184.90	182.10	177.50	147.90	110.90	92.50	88.80	77.70
15/16-20 NEF	Hand Tap	H3	6	013166AS	013167AS	013168AS	42.30	42.30	42.30	42.30	42.30	36.80	36.00	35.10
	Hand Tap	H5	6	013176AS	013177AS	013178AS	66.90	65.90	64.20	53.50	40.10	33.50	32.10	28.10
	2" O.D. Die				041355AS		184.90	182.10	177.50	147.90	110.90	92.50	88.80	77.70
15/16-32 NS	Hand Tap	H3	6	013183AS	013184AS	013185AS	102.20	100.20	92.00	76.70	56.20	46.00	35.80	28.60
	2" O.D. Die				041356AS		184.90	182.10	177.50	147.90	110.90	92.50	88.80	77.70
1-5 ACME	Acme Hand	2G	4		015248AS		119.10	117.30	114.30	95.30	71.50	59.60	57.20	50.00
	LH Acme Tap	2G	4		017638AS		119.10	117.30	114.30	95.30	71.50	59.60	57.20	50.00
	Acme Tandem Unipass	2G	4		015010AS		254.10	203.30	162.60	142.30	127.10	127.10	127.10	127.10
	LH Acme Tandem Unipass	2G	4		017612AS		254.10	203.30	162.60	142.30	127.10	127.10	127.10	127.10
1-8 NC*	Hand Tap	H1	4		011137AS	011138AS	99.70	99.70	99.70	82.80	65.80	48.90	38.90	34.90
	+.005 Hand Tap	H11	4		014647AS	014648AS	71.00	71.00	71.00	58.90	46.90	34.80	27.70	24.90
	Spiral Pt.	H4	3		013191AS		123.50	121.00	111.20	92.60	67.90	55.60	43.20	34.60
	Spiral Flute	H4	4		013194AS	013195AS	161.10	128.90	90.20	74.10	62.80	56.40	51.60	45.10
	Carbo-Clad	H4	4		019176US	019177US	268.60	268.60	268.60	268.60	268.60	233.70	228.30	222.90
1-8 ACME	Acme Hand	2G	4		015249AS		119.10	117.30	114.30	95.30	71.50	59.60	57.20	50.00
	2" O.D. Die				041357AS		184.90	182.10	177.50	147.90	110.90	92.50	88.80	77.70
	LH 2" O.D. Die				041084AS		184.90	182.10	177.50	147.90	110.90	92.50	88.80	77.70

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SPECIAL TAPS & DIES



1-10 To 1-1/16 - 24

Call for pricing on Special Gages for these taps.

Size/Pitch	Type	GH#	#FI	Taper	Plug	Bottom	1	2	3	6	8	12	24	48
1-10 NS	Hand Tap	H4	4	013200AS	013201AS	013202AS	100.20	98.70	96.20	80.20	60.10	50.10	48.10	42.10
1-11 BSPP	55° Mod. Whit. Parallel		5		015710AS		117.00	115.20	112.30	93.60	70.20	58.50	56.20	49.10
	55° Full Form Parallel		5		015709AS	015728AS	264.20	264.20	264.20	264.20	264.20	229.90	224.60	219.30
1-11 BSPT	55° Mod. Whit. Taper		5		015740AS		117.00	115.20	112.30	93.60	70.20	58.50	56.20	49.10
	55° Full Form Taper		5		015739AS	015727AS	264.20	264.20	264.20	264.20	264.20	229.90	224.60	219.30
1-11-1/2 NPTF	LH Pipe		5		017532AS		175.30	172.70	168.30	140.20	105.20	87.70	84.10	73.60
	Carbo-Clad Pipe		5		019386US		416.10	416.10	416.10	416.10	416.10	416.10	407.80	399.50
1-12 NF*	Hand Tap	H1	4		011136AS		117.60	115.20	105.80	88.20	64.70	52.90	41.20	32.90
	Hand Tap	H6	4	013214AS	013215AS	013216AS	117.60	115.20	105.80	88.20	64.70	52.90	41.20	32.90
	+0.005 Hand Tap	H11	4		014651AS	014652AS	71.00	71.00	71.00	58.90	46.90	34.80	27.70	24.90
	Spiral Pt.	H4	3		013227AS		121.10	118.70	109.00	90.80	66.60	54.50	42.40	33.90
	Carbo-Clad	H4	4		019186US	019187US	340.40	340.40	340.40	340.40	340.40	296.10	289.30	282.50
	LH 2" O.D. Die				041085AS		184.90	182.10	177.50	147.90	110.90	92.50	88.80	77.70
1-14 NS	Hand Tap	H6	4	013228AS	013229AS	013230AS	118.50	116.10	106.70	88.90	65.20	53.30	41.50	33.20
	+0.005 Hand Tap	H11	4		014655AS	014656AS	71.00	71.00	71.00	58.90	46.90	34.80	27.70	24.90
	Spiral Pt.	H4	3		013231AS		123.50	121.00	111.20	92.60	67.90	55.60	43.20	34.60
	LH 2" O.D. Die				041086AS		184.90	182.10	177.50	147.90	110.90	92.50	88.80	77.70
1-16 NS	Hand Tap	H3	6	013236AS	013237AS	013238AS	100.20	98.70	96.20	80.20	60.10	50.10	48.10	42.10
	LH Hand Tap	H3	6		017296AS	017297AS	124.50	122.00	112.10	93.40	68.50	56.00	43.60	34.90
	2" O.D. Die				041360AS		184.90	182.10	177.50	147.90	110.90	92.50	88.80	77.70
1-18 NS	Hand Tap	H3	6	013243AS	013244AS	013245AS	100.20	98.70	96.20	80.20	60.10	50.10	48.10	42.10
	2" O.D. Die				041361AS		184.90	182.10	177.50	147.90	110.90	92.50	88.80	77.70
1-20 NEF	Hand Tap	H3	6	013250AS	013251AS	013252AS	65.00	64.00	62.40	52.00	39.00	32.50	31.20	27.30
	Hand Tap	H5	6	013260AS	013261AS	013262AS	94.00	92.60	90.20	75.20	56.40	47.00	45.10	39.50
	LH Hand Tap	H3	6		017298AS	017299AS	71.10	70.00	68.30	56.90	42.70	35.60	34.10	29.90
	2" O.D. Die				041362AS		184.90	182.10	177.50	147.90	110.90	92.50	88.80	77.70
1-24 NS	Hand Tap	H3	6	013267AS	013268AS	013269AS	100.20	98.70	96.20	80.20	60.10	50.10	48.10	42.10
	2" O.D. Die				041363AS		184.90	182.10	177.50	147.90	110.90	92.50	88.80	77.70
1-27 NS	Hand Tap	H3	6	013274AS	013275AS	013276AS	100.20	98.70	96.20	80.20	60.10	50.10	48.10	42.10
	2" O.D. Die				041364AS		184.90	182.10	177.50	147.90	110.90	92.50	88.80	77.70
1-32 NS	Hand Tap	H3	6	013286AS	013287AS	013288AS	100.20	98.70	96.20	80.20	60.10	50.10	48.10	42.10
	2" O.D. Die				041365AS		184.90	182.10	177.50	147.90	110.90	92.50	88.80	77.70
1-1/16-12 NS	Hand Tap	H4	4		011140AS	011141AS	69.30	69.30	69.30	69.30	69.30	69.30	69.30	69.30
	Hand Tap	H5	4	013289AS	013290AS	013291AS	69.30	69.30	69.30	69.30	69.30	69.30	69.30	69.30
	Hand Tap	H7	4	013297AS	013298AS	013299AS	69.30	69.30	69.30	69.30	69.30	69.30	69.30	69.30
1-1/16-14 NS	Hand Tap	H5	6	013301AS	013302AS	013303AS	99.00	97.50	95.00	79.20	59.40	49.50	47.50	41.60
1-1/16-16 NS	Hand Tap	H4	6	013308AS	013309AS	013310AS	99.00	97.50	95.00	79.20	59.40	49.50	47.50	41.60
	Hand Tap	H6	6	013318AS	013319AS	013320AS	99.00	97.50	95.00	79.20	59.40	49.50	47.50	41.60
1-1/16-18 NEF	Hand Tap	H4	6	013330AS	013331AS	013332AS	80.20	79.00	77.00	64.20	48.10	40.10	38.50	33.70
	Hand Tap	H6	6	013340AS	013341AS	013342AS	87.40	86.10	83.90	69.90	52.40	43.70	42.00	36.70
1-1/16-20 NS	Hand Tap	H4	6	013347AS	013348AS	013349AS	111.00	108.80	99.90	83.30	61.10	50.00	38.90	31.10
1-1/16-24 NS	Hand Tap	H4	6	013352AS	013353AS	013354AS	111.00	108.80	99.90	83.30	61.10	50.00	38.90	31.10

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SPECIAL TAPS & DIES



1-1/8-5 To 1-1/4-7

Call for pricing on Special Gages for these taps.

Size/Pitch	Type	GH#	#FI	Taper	Plug	Bottom	1	2	3	6	8	12	24	48
1-1/8-5 ACME	Acme Hand	2G	4		015250AS		136.20	134.20	130.80	109.00	81.70	68.10	65.40	57.20
	LH Acme Tap	2G	4		017640AS		136.20	134.20	130.80	109.00	81.70	68.10	65.40	57.20
	Acme Tandem Unipass	2G	4		015012AS		279.30	223.40	178.80	156.40	139.70	139.70	139.70	139.70
	LH Acme Tandem Unipass	2G	4		017614AS		279.30	223.40	178.80	156.40	139.70	139.70	139.70	139.70
1-1/8-7 NC*	2-1/2" O.D. Die				041390AS		280.60	276.40	269.40	224.50	168.40	140.30	134.70	117.90
	LH 2-1/2" O.D. Die				041100AS		280.60	276.40	269.40	224.50	168.40	140.30	134.70	117.90
1-1/8-10 NS	Hand Tap	H5	4	013364AS	013365AS	013366AS	155.70	124.60	87.20	71.60	60.70	54.50	49.80	43.60
1-1/8-12 NF*	Hand Tap	H6	4	013374AS	013375AS	013376AS	155.70	124.60	87.20	71.60	60.70	54.50	49.80	43.60
	+ .005 Hand Tap	H12	4		011142AS	011143AS	169.00	135.20	94.60	77.70	65.90	59.20	54.10	47.30
	2-1/2" O.D. Die				041392AS		280.60	276.40	269.40	224.50	168.40	140.30	134.70	117.90
	LH 2-1/2" O.D. Die				041101AS		280.60	276.40	269.40	224.50	168.40	140.30	134.70	117.90
	1-1/8-14 NS	Hand Tap	H5	6	013381AS	013382AS	013383AS	125.70	110.60	106.80	88.00	62.90	40.20	35.20
	2-1/2" O.D. Die				041393AS		280.60	276.40	269.40	224.50	168.40	140.30	134.70	117.90
	1-1/8-16 NS	Hand Tap	H4	6	013388AS	013389AS	013390AS	65.90	65.90	65.90	65.90	65.90	57.30	56.00
	2-1/2" O.D. Die				041394AS		280.60	276.40	269.40	224.50	168.40	140.30	134.70	117.90
	1-1/8-18 NEF	Hand Tap	H4	6	013400AS	013401AS	013402AS	82.00	80.80	78.70	65.60	49.20	41.00	39.40
	Hand Tap	H6	6	013410AS	013411AS	013412AS	111.40	98.00	94.70	78.00	55.70	35.60	31.20	27.90
	2-1/2" O.D. Die				041395AS		280.60	276.40	269.40	224.50	168.40	140.30	134.70	117.90
1-1/8-20 NS	Hand Tap	H4	6	013417AS	013418AS	013419AS	103.30	103.30	103.30	85.70	68.20	50.60	40.30	36.20
	2-1/2" O.D. Die				041396AS		280.60	276.40	269.40	224.50	168.40	140.30	134.70	117.90
1-1/8-24 NS	Hand Tap	H4	6	013422AS	013423AS	013424AS	125.40	110.40	106.60	87.80	62.70	40.10	35.10	31.40
1-1/8-28 NS	Hand Tap	H4	6	013427AS	013428AS	013429AS	125.40	110.40	106.60	87.80	62.70	40.10	35.10	31.40
1-1/8-32 NS	Hand Tap	H4	6	013432AS	013433AS	013434AS	125.40	110.40	106.60	87.80	62.70	40.10	35.10	31.40
1-3/16-12 NS	Hand Tap	H5	6	013439AS	013440AS	013441AS	80.90	80.90	80.90	80.90	80.90	80.90	80.90	80.90
	2-1/2" O.D. Die				041397AS		280.60	276.40	269.40	224.50	168.40	140.30	134.70	117.90
1-3/16-14 NS	Hand Tap	H5	6	013446AS	013447AS	013448AS	134.80	118.60	114.60	94.40	67.40	43.10	37.70	33.70
	2-1/2" O.D. Die				041398AS		280.60	276.40	269.40	224.50	168.40	140.30	134.70	117.90
1-3/16-16 NS	Hand Tap	H4	6	013453AS	013454AS	013455AS	76.40	75.30	73.30	61.10	45.80	38.20	36.70	32.10
	Hand Tap	H6	6	013463AS	013464AS	013465AS	67.30	67.30	67.30	67.30	67.30	67.30	67.30	67.30
1-3/16-18 NEF	Hand Tap	H4	6	013475AS	013476AS	013477AS	67.30	66.30	64.60	53.80	40.40	33.70	32.30	28.30
	Hand Tap	H6	6		011144AS	011145AS	75.00	73.90	72.00	60.00	45.00	37.50	36.00	31.50
	2-1/2" O.D. Die				041399AS		280.60	276.40	269.40	224.50	168.40	140.30	134.70	117.90
1-3/16-20 NS	Hand Tap	H4	6	013492AS	013493AS	013494AS	141.60	124.60	120.40	99.10	70.80	45.30	39.60	35.40
1-1/4-5 ACME	Acme Hand	2G	4		015251AS		172.60	170.00	165.70	138.10	103.60	86.30	82.80	72.50
	LH Acme Tap	2G	4		017642AS		172.60	170.00	165.70	138.10	103.60	86.30	82.80	72.50
	Acme Tandem Unipass	2G	4		015014AS		329.60	263.70	210.90	184.60	164.80	164.80	164.80	164.80
	LH Acme Tandem Unipass	2G	4		017616AS		329.60	263.70	210.90	184.60	164.80	164.80	164.80	164.80
	1-1/4-7 NC*	Hand Tap	H8	4	013504AS	013505AS	013506AS	191.20	153.00	107.10	88.00	74.60	66.90	61.20
	+ .005 Hand Tap	H12	4		011146AS	011147AS	191.20	153.00	107.10	88.00	74.60	66.90	61.20	53.50
	Spiral Pt.	H4	3		013232AS		198.00	158.40	110.90	91.10	77.20	69.30	63.40	55.40
	Carbo-Clad	H4	4		019216US	019217US	353.50	353.50	353.50	353.50	353.50	307.50	300.50	293.40
	2-1/2" O.D. Die				041401AS		280.60	276.40	269.40	224.50	168.40	140.30	134.70	117.90
	LH 2-1/2" O.D. Die				041102AS		280.60	276.40	269.40	224.50	168.40	140.30	134.70	117.90

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SPECIAL TAPS & DIES



1-1/4-10 To 1-3/8-16

Call for pricing on Special Gages for these taps.

Size/Pitch	Type	GH#	#FI	Taper	Plug	Bottom	1	2	3	6	8	12	24	48
1-1/4-10 NS	Hand Tap	H5	4	013518AS	013519AS	013520AS	191.20	153.00	107.10	88.00	74.60	66.90	61.20	53.50
1-1/4-11 BSPT	55° Mod. Whit. Taper		5		015742AS		151.60	151.60	151.60	151.60	151.60	151.60	151.60	151.60
	55° Full Form Taper		5		015741AS	015750AS	383.80	383.80	383.80	383.80	383.80	333.90	326.20	318.60
1-1/4-11 BSPP	55° Mod. Whit. Parallel		5		015712AS		151.60	151.60	151.60	151.60	151.60	151.60	151.60	151.60
	55° Full Form Parallel		5		015711AS	015751AS	383.80	383.80	383.80	383.80	383.80	333.90	326.20	318.60
1-1/4-11-1/2 NPS*	Straight Pipe		5		015951AS		182.40	182.40	182.40	151.40	120.40	89.40	71.10	63.80
1-1/4-11-1/2 NPSF*	Straight Pipe		5		015950AS		182.40	182.40	182.40	151.40	120.40	89.40	71.10	63.80
1-1/4-11-1/2 NPTF*	LH Pipe		5		017534AS		182.40	182.40	182.40	151.40	120.40	89.40	71.10	63.80
	Carbo-Clad Pipe		5		019387US		479.00	479.00	479.00	479.00	479.00	479.00	469.40	459.80
1-1/4-12 NF*	Hand Tap	H6	6	013530AS	013531AS	013532AS	191.20	153.00	107.10	88.00	74.60	66.90	61.20	53.50
	2-1/2" O.D. Die				041403AS		280.60	276.40	269.40	224.50	168.40	140.30	134.70	117.90
	LH 2-1/2" O.D. Die				041103AS		280.60	276.40	269.40	224.50	168.40	140.30	134.70	117.90
1-1/4-14 NS	Hand Tap	H5	6	013537AS	013538AS	013539AS	116.20	116.20	116.20	96.40	76.70	56.90	45.30	40.70
1-1/4-16 NS	Hand Tap	H4	6	013544AS	013545AS	013546AS	116.20	116.20	116.20	96.40	76.70	56.90	45.30	40.70
	2-1/2" O.D. Die				041404AS		280.60	276.40	269.40	224.50	168.40	140.30	134.70	117.90
1-1/4-18 NEF	Hand Tap	H4	6	013556AS	013557AS	013558AS	103.20	101.70	99.10	82.60	61.90	51.60	49.50	43.30
	Hand Tap	H6	6	013566AS	013567AS	013568AS	122.50	120.70	117.60	98.00	73.50	61.30	58.80	51.50
	2-1/2" O.D. Die				041405AS		280.60	276.40	269.40	224.50	168.40	140.30	134.70	117.90
1-1/4-20 NS	Hand Tap	H4	6	013573AS	013574AS	013575AS	126.30	123.80	113.70	94.70	69.50	56.80	44.20	35.40
	2-1/2" O.D. Die				041406AS		280.60	276.40	269.40	224.50	168.40	140.30	134.70	117.90
1-1/4-24 NS	Hand Tap	H4	6	013580AS	013581AS	013582AS	151.50	121.20	84.80	69.70	59.10	53.00	48.50	42.40
	2-1/2" O.D. Die				041407AS		280.60	276.40	269.40	224.50	168.40	140.30	134.70	117.90
1-1/4-32 NS	Hand Tap	H4	6	013587AS	013588AS	013589AS	151.50	121.20	84.80	69.70	59.10	53.00	48.50	42.40
1-5/16-12 NS	Hand Tap	H5	6	013594AS	013595AS	013596AS	82.30	82.30	82.30	82.30	82.30	82.30	82.30	82.30
	Hand Tap	H8	6	013609AS	013610AS	013611AS	82.30	82.30	82.30	82.30	82.30	82.30	82.30	82.30
	2-1/2" O.D. Die				041408AS		289.80	285.50	278.20	231.80	173.90	144.90	139.10	121.70
1-5/16-14 NS	Hand Tap	H5	6	013613AS	013614AS	013615AS	162.10	129.70	90.80	74.60	63.20	56.70	51.90	45.40
	2-1/2" O.D. Die				041409AS		289.80	285.50	278.20	231.80	173.90	144.90	139.10	121.70
1-5/16-16 NS	Hand Tap	H4	6	013618AS	013619AS	013620AS	138.60	135.80	124.70	104.00	76.20	62.40	48.50	38.80
	Hand Tap	H6	6	013628AS	013629AS	013630AS	138.60	122.00	117.80	97.00	69.30	44.40	38.80	34.70
	2-1/2" O.D. Die				041410AS		289.80	285.50	278.20	231.80	173.90	144.90	139.10	121.70
1-5/16-18 NEF	Hand Tap	H4	6	013640AS	013641AS	013642AS	138.60	135.80	124.70	104.00	76.20	62.40	48.50	38.80
	Hand Tap	H6	6	013650AS	013651AS	013652AS	140.10	137.30	126.10	105.10	77.10	63.00	49.00	39.20
	2-1/2" O.D. Die				041411AS		289.80	285.50	278.20	231.80	173.90	144.90	139.10	121.70
1-5/16-20 NS	Hand Tap	H4	6	013655AS	013656AS	013657AS	162.10	129.70	90.80	74.60	63.20	56.70	51.90	45.40
1-3/8-4 ACME	Acme Hand	2G	4		015252AS		208.70	205.60	200.40	167.00	125.20	104.40	100.20	87.70
	LH Acme Tap	2G	4		017644AS		208.70	205.60	200.40	167.00	125.20	104.40	100.20	87.70
	Acme Tandem Unipass	2G	4		015016AS		379.90	303.90	243.10	212.70	190.00	190.00	190.00	190.00
1-3/8-6 NC*	LH Acme Tandem Unipass	2G	4		017618AS		379.90	303.90	243.10	212.70	190.00	190.00	190.00	190.00
	2-1/2" O.D. Die				041412AS		289.80	285.50	278.20	231.80	173.90	144.90	139.10	121.70
1-3/8-10 NS	LH 2-1/2" O.D. Die				041104AS		289.80	285.50	278.20	231.80	173.90	144.90	139.10	121.70
	Hand Tap	H5	6	013667AS	013668AS	013669AS	151.50	149.20	145.40	121.20	90.90	75.80	72.70	63.60
1-3/8-12 NF*	Carbo-Clad	H4	4		019240US	019241US	419.90	419.90	419.90	419.90	419.90	365.30	356.90	348.50
	2-1/2" O.D. Die				041414AS		289.80	285.50	278.20	231.80	173.90	144.90	139.10	121.70
	LH 2-1/2" O.D. Die				041105AS		289.80	285.50	278.20	231.80	173.90	144.90	139.10	121.70
1-3/8-16 NS	Hand Tap	H4	6	013674AS	013675AS	013676AS	151.50	133.30	128.80	106.10	75.80	48.50	42.40	37.90

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SPECIAL TAPS & DIES



1-3/8-16 To 1-5/8-12

Call for pricing on Special Gages for these taps.

Size/Pitch	Type	GH#	#FI	Taper	Plug	Bottom	1	2	3	6	8	12	24	48
1-3/8-16 NS	2-1/2" O.D. Die				041416AS		289.80	285.50	278.20	231.80	173.90	144.90	139.10	121.70
1-3/8-18 NEF	Hand Tap	H4	6	013686AS	013689AS	013690AS	126.30	123.80	121.20	101.00	75.80	60.60	46.70	34.10
	Hand Tap	H6	6	013692AS	013695AS	013697AS	130.70	128.10	125.50	104.60	78.40	62.70	48.40	35.30
	2-1/2" O.D. Die				041417AS		289.80	285.50	278.20	231.80	173.90	144.90	139.10	121.70
1-3/8-20 NS	Hand Tap	H4	6	013705AS	013706AS	013707AS	177.00	141.60	99.10	81.40	69.00	62.00	56.60	49.60
	2-1/2" O.D. Die				041418AS		289.80	285.50	278.20	231.80	173.90	144.90	139.10	121.70
1-7/16-18 NEF	Hand Tap	H4	6	013729AS	013730AS	013731AS	122.50	120.10	110.30	91.90	67.40	55.10	42.90	34.30
	Hand Tap	H6	6	013739AS	013740AS	013741AS	122.50	120.10	110.30	91.90	67.40	55.10	42.90	34.30
	2-1/2" O.D. Die				041422AS		289.80	285.50	278.20	231.80	173.90	144.90	139.10	121.70
1-1/2-4 ACME	Acme Hand	2G	4		015253AS		258.70	258.70	258.70	214.70	170.70	126.80	100.90	90.50
	LH Acme Tap	2G	4		017646AS		258.70	258.70	258.70	214.70	170.70	126.80	100.90	90.50
	Acme Tandem Unipass	2G	4		015020AS		365.30	292.20	233.80	204.60	182.70	182.70	182.70	182.70
	LH Acme Tandem Unipass	2G	4		017620AS		365.30	292.20	233.80	204.60	182.70	182.70	182.70	182.70
1-1/2-6 NC*	Carbo-Clad	H4	4		019248US	019249US	428.40	428.40	428.40	428.40	428.40	372.70	364.10	355.60
	2-1/2" O.D. Die				041424AS		289.80	285.50	278.20	231.80	173.90	144.90	139.10	121.70
	LH 2-1/2" O.D. Die				041106AS		289.80	285.50	278.20	231.80	173.90	144.90	139.10	121.70
1-1/2-10 NS	Hand Tap	H5	6	013751AS	013752AS	013753AS	187.10	184.30	179.60	149.70	112.30	93.60	89.80	78.60
1-1/2-11 BSPT	55° Mod. Whit. Taper		7		015744AS		199.90	199.90	199.90	199.90	199.90	199.90	199.90	199.90
	55° Full Form Taper		7		015743AS	015752AS	511.80	511.80	511.80	511.80	511.80	445.30	435.00	424.80
1-1/2-11 BSPP	55° Mod. Whit. Parallel		7		015714AS		199.90	199.90	199.90	199.90	199.90	199.90	199.90	199.90
	55° Full Form Parallel		7		015713AS	015753AS	511.80	511.80	511.80	511.80	511.80	445.30	435.00	424.80
1-1/2-11-1/2 NPS	Straight Pipe		7		015952AS		242.00	242.00	242.00	200.90	159.70	118.60	94.40	84.70
1-1/2-11-1/2 NPTF	LH Pipe		7		017536AS		242.00	242.00	242.00	200.90	159.70	118.60	94.40	84.70
	Carbo-Clad Pipe		7		019388US		578.00	578.00	578.00	578.00	578.00	578.00	566.40	554.90
1-1/2-12 NF	Hand Tap	H6	6	013761AS	013762AS	013763AS	187.10	184.30	179.60	149.70	112.30	93.60	89.80	78.60
	2-1/2" O.D. Die				041426AS		289.80	285.50	278.20	231.80	173.90	144.90	139.10	121.70
	LH 2-1/2" O.D. Die				041107AS		289.80	285.50	278.20	231.80	173.90	144.90	139.10	121.70
1-1/2-16 NS	Hand Tap	H4	6	013768AS	013769AS	013770AS	187.10	149.70	104.80	86.10	73.00	65.50	59.90	52.40
	2-1/2" O.D. Die				041428AS		289.80	285.50	278.20	231.80	173.90	144.90	139.10	121.70
1-1/2-18 NEF	Hand Tap	H4	6	013780AS	013781AS	013782AS	175.10	154.10	148.80	122.60	87.60	56.00	49.00	43.80
	Hand Tap	H6	6	013790AS	013791AS	013792AS	175.10	154.10	148.80	122.60	87.60	56.00	49.00	43.80
	2-1/2" O.D. Die				041429AS		289.80	285.50	278.20	231.80	173.90	144.90	139.10	121.70
1-1/2-20 NS	Hand Tap	H4	6	013797AS	013798AS	013799AS	187.10	149.70	104.80	86.10	73.00	65.50	59.90	52.40
	2-1/2" O.D. Die				041430AS		289.80	285.50	278.20	231.80	173.90	144.90	139.10	121.70
1-1/2-24 NS	Hand Tap	H4	6	013804AS	013805AS	013806AS	211.40	169.10	118.40	97.20	82.40	74.00	67.60	59.20
1-9/16-16 NS	Hand Tap	H5	6	013811AS	013812AS	013813AS	257.40	205.90	144.10	118.40	100.40	90.10	82.40	72.10
	3" O.D. Die				041451AS		512.30	504.60	491.80	409.80	307.40	256.20	245.90	215.20
1-9/16-18 NEF	Hand Tap	H5	6	013816AS	013817AS	013818AS	184.60	181.80	177.20	147.70	110.80	92.30	88.60	77.50
	3" O.D. Die				041452AS		512.30	504.60	491.80	409.80	307.40	256.20	245.90	215.20
1-5/8-5-1/2 NS	Hand Tap	H7	6	013823AS	013824AS	013825AS	271.40	217.10	152.00	124.80	105.80	95.00	86.80	76.00
1-5/8-12 NS	Hand Tap	H4	6		011148AS	011149AS	121.80	120.00	116.90	97.40	73.10	60.90	58.50	51.20

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SPECIAL TAPS & DIES



1-5/8-12 To 2-1/4-16

Call for pricing on Special Gages for these taps.

Size/Pitch	Type	GH#	#FI	Taper	Plug	Bottom	1	2	3	6	8	12	24	48
1-5/8-12 NS	Hand Tap	H6	6	013833AS	013834AS	013835AS	121.80	120.00	116.90	97.40	73.10	60.90	58.50	51.20
	3" O.D. Die				041455AS		512.30	504.60	491.80	409.80	307.40	256.20	245.90	215.20
1-5/8-16 NS	Hand Tap	H5	6	013838AS	013839AS	013840AS	218.30	174.60	122.20	100.40	85.10	76.40	69.90	61.10
	3" O.D. Die				041456AS		512.30	504.60	491.80	409.80	307.40	256.20	245.90	215.20
1-5/8-18 NEF	Hand Tap	H5	6	013843AS	013844AS	013845AS	218.30	174.60	122.20	100.40	85.10	76.40	69.90	61.10
	3" O.D. Die				041457AS		512.30	504.60	491.80	409.80	307.40	256.20	245.90	215.20
1-3/4-5 NC	Hand Tap	H7	6	013857AS	013858AS	013859AS	272.40	239.70	231.50	190.70	136.20	87.20	76.30	68.10
	3" O.D. Die				041460AS		512.30	504.60	491.80	409.80	307.40	256.20	245.90	215.20
1-3/4-10 NS	Hand Tap	H6	6	013882AS	013883AS	013884AS	272.40	217.90	152.50	125.30	106.20	95.30	87.20	76.30
1-3/4-12 NS	Hand Tap	H6	6	013887AS	013888AS	013889AS	143.80	140.90	129.40	107.90	79.10	64.70	50.30	40.30
	Hand Tap	H8	6	013897AS	013898AS	013899AS	242.00	193.60	135.50	111.30	94.40	84.70	77.40	67.80
	3" O.D. Die				041462AS		512.30	504.60	491.80	409.80	307.40	256.20	245.90	215.20
1-3/4-16 NS	Hand Tap	H5	6	013902AS	013903AS	013904AS	242.00	193.60	135.50	111.30	94.40	84.70	77.40	67.80
	Hand Tap	H7	6	013912AS	013913AS	013914AS	254.10	203.30	142.30	116.90	99.10	88.90	81.30	71.10
	3" O.D. Die				041464AS		512.30	504.60	491.80	409.80	307.40	256.20	245.90	215.20
1-3/4-18 NS	Hand Tap	H5	6	013917AS	013918AS	013919AS	254.10	203.30	142.30	116.90	99.10	88.90	81.30	71.10
1-7/8-5 NS	Hand Tap	H7	6	013924AS	013925AS	013926AS	309.90	247.90	173.50	142.60	120.90	108.50	99.20	86.80
	3" O.D. Die				041470AS		512.30	504.60	491.80	409.80	307.40	256.20	245.90	215.20
1-7/8-12 NS	Hand Tap	H6	6	013934AS	013935AS	013936AS	153.70	153.70	153.70	153.70	153.70	133.70	130.60	127.60
	Hand Tap	H8	6	013944AS	013945AS	013946AS	153.70	123.00	86.10	70.70	59.90	53.80	49.20	43.00
	3" O.D. Die				041473AS		512.30	504.60	491.80	409.80	307.40	256.20	245.90	215.20
1-7/8-16 NS	Hand Tap	H5	6	013949AS	013950AS	013951AS	153.70	123.00	86.10	70.70	59.90	53.80	49.20	43.00
	3" O.D. Die				041474AS		512.30	504.60	491.80	409.80	307.40	256.20	245.90	215.20
2-4 ACME	Acme Tandem Unipass	2G	6		015022AS		521.20	417.00	333.60	291.90	260.60	260.60	260.60	260.60
	LH Acme Tandem Unipass	2G	6		017652AS		521.20	417.00	333.60	291.90	260.60	260.60	260.60	260.60
2-4-1/2 NC	Hand Tap	H7	6	013956AS	013957AS	013958AS	217.50	217.50	217.50	217.50	217.50	189.20	184.90	180.50
	3" O.D. Die				041478AS		551.30	543.00	529.20	441.00	330.80	275.70	264.60	231.50
2-11 BSPT	55° Mod. Whit. Taper		7		015746AS		282.30	282.30	282.30	282.30	282.30	282.30	282.30	282.30
	55° Full Form Taper		7		015745AS	015754AS	715.60	715.60	715.60	715.60	715.60	622.60	608.30	593.90
2-11 BSPP	55° Mod. Whit. Parallel		7		015716AS		282.30	282.30	282.30	282.30	282.30	282.30	282.30	282.30
	55° Full Form Parallel		7		015715AS	015755AS	715.60	715.60	715.60	715.60	715.60	622.60	608.30	593.90
2-11-1/2 NPS	Straight Pipe		7		015953AS		313.30	308.60	300.80	250.60	188.00	156.70	150.40	131.60
2-11-1/2 NPTF	LH Pipe		7		017538AS		446.30	439.60	428.40	357.00	267.80	223.20	214.20	187.40
2-12 NS	Hand Tap	H6	6	013966AS	013967AS	013968AS	169.30	169.30	169.30	169.30	169.30	147.30	143.90	140.50
	Hand Tap	H8	6	013976AS	013977AS	013978AS	217.50	217.50	217.50	180.50	143.60	106.60	84.80	76.10
	3" O.D. Die				041482AS		551.30	543.00	529.20	441.00	330.80	275.70	264.60	231.50
2-16 NS	Hand Tap	H5	6	013983AS	013984AS	013985AS	169.30	169.30	169.30	169.30	169.30	147.30	143.90	140.50
	3" O.D. Die				041484AS		551.30	543.00	529.20	441.00	330.80	275.70	264.60	231.50
2-20 NS	Hand Tap	H5	6	013993AS	013994AS	013995AS	241.60	217.40	193.30	181.20	174.00	169.10	164.30	157.00
	3" O.D. Die				041486AS		551.30	543.00	529.20	441.00	330.80	275.70	264.60	231.50
2-1/8-12 NS	Hand Tap	H6	6	014005AS	014006AS	014007AS	226.70	204.00	192.70	181.40	176.80	170.00	163.20	158.70
2-1/8-16 NS	Hand Tap	H5	6	014010AS	014011AS	014012AS	267.70	263.70	257.00	214.20	160.60	133.90	128.50	112.40
2-1/4-4-1/2 NC	Hand Tap	H7	6	014017AS	014018AS	014019AS	406.10	365.50	324.90	304.60	292.40	284.30	276.10	264.00
2-1/4-12 NS	Hand Tap	H6	6	014027AS	014028AS	014029AS	234.80	234.80	234.80	234.80	234.80	204.30	199.60	194.90
2-1/4-16 NS	Hand Tap	H5	6	014032AS	014033AS	014034AS	284.40	280.10	273.00	227.50	170.60	142.20	136.50	119.40

*The most popular limits and flute configurations, both Right- and Left-Hand sizes, are shown in our Industrial Metalworking catalog and on our website.

SPECIAL TAPS & DIES



2-3/8-12 To 6-12

Call for pricing on Special Gages for these taps.

Size/Pitch	Type	GH#	#Fl	Taper	Plug	Bottom	1	2	3	6	8	12	24	48
2-3/8-12 NS	Hand Tap	H6	6	014039AS	014040AS	014041AS	291.00	261.90	247.40	232.80	227.00	218.30	209.50	203.70
2-3/8-16 NS	Hand Tap	H5	6	014044AS	014045AS	014046AS	331.90	325.30	298.70	248.90	182.50	149.40	116.20	92.90
2-1/2-4 NC	Hand Tap	H7	6	014051AS	014052AS	014053AS	473.10	378.50	264.90	217.60	184.50	165.60	151.40	132.50
2-1/2-8 NPTF	Taper Pipe		7		015935AS		467.80	460.80	449.10	374.20	280.70	233.90	224.50	196.50
	Interrupted Taper Pipe		7		015993AS		655.20	645.40	629.00	524.20	393.10	327.60	314.50	275.20
2-1/2-12 NS	Hand Tap	H6	6	014061AS	014062AS	014063AS	287.00	287.00	287.00	287.00	287.00	249.70	244.00	238.20
2-1/2-16 NS	Hand Tap	H5	6	014066AS	014067AS	014068AS	384.60	346.10	307.70	288.50	276.90	269.20	261.50	250.00
2-3/4-12 NS	Hand Tap	H7	6	014078AS	014079AS	014080AS	346.80	312.10	277.40	260.10	249.70	242.80	235.80	225.40
3-4 NC	Hand Tap	H9	6	014092AS	014093AS	014094AS	538.90	530.80	517.30	517.30	517.30	517.30	517.30	517.30
3-8 NPTF	Taper Pipe		7		015936AS		625.40	616.00	600.40	600.40	600.40	600.40	600.40	600.40
	Interrupted Taper Pipe		7		015994AS		875.20	862.10	840.20	840.20	840.20	840.20	840.20	840.20
3-12 NS	Hand Tap	H7	8	014102AS	014103AS	014104AS	425.40	419.00	408.40	408.40	408.40	408.40	408.40	408.40
3-16 NS	Hand Tap	H7	8	014107AS	014108AS	014109AS	513.30	462.00	410.60	385.00	369.60	359.30	349.00	333.60
3-1/8-12 NS	Hand Tap	H7	8		014110AS	014111AS	630.60	504.50	353.10	290.10	245.90	220.70	201.80	176.60
3-1/4-12 NS	Hand Tap	H7	8		014121AS	014122AS	671.30	537.00	375.90	308.80	261.80	235.00	214.80	188.00
3-1/2-4 NC	Hand Tap	H9	6		014123AS	014124AS	825.60	743.00	660.50	619.20	594.40	577.90	561.40	536.60
3-1/2-8 NPTF	Taper Pipe		9		015937AS		820.70	808.40	787.90	787.90	787.90	787.90	787.90	787.90
	Interrupted Taper Pipe		9		015996AS		1149.00	1131.80	1103.00	1103.00	1103.00	1103.00	1103.00	1103.00
3-1/2-12 NS	Hand Tap	H7	8		014127AS	014128AS	611.50	550.40	489.20	458.60	440.30	428.10	415.80	397.50
3-3/4-4 NC	Hand Tap	H9	6		014129AS	014130AS	851.80	839.00	817.70	817.70	817.70	817.70	817.70	817.70
3-3/4-12 NS	Hand Tap	H7	8		014133AS	014134AS	703.60	633.20	562.90	527.70	506.60	492.50	478.40	457.30
4-4 NC	Hand Tap	H9	8		014135AS	014136AS	1106.20	995.60	885.00	829.70	796.50	774.30	752.20	719.00
4-8 NPTF	Taper Pipe		9		015938AS		1017.80	1002.50	977.10	977.10	977.10	977.10	977.10	977.10
	Interrupted Taper Pipe		9		015995AS		1424.70	1403.30	1367.70	1367.70	1367.70	1367.70	1367.70	1367.70
4-12 NS	Hand Tap	H7	8		014139AS	014140AS	779.40	701.50	623.50	584.60	561.20	545.60	530.00	506.60
4-1/4-8 NS	Hand Tap	H8	10		014141AS		1484.80	1462.50	1425.40	1425.40	1425.40	1425.40	1425.40	1425.40
4-1/4-12 NS	Hand Tap	H7	10		014142AS		1038.70	1023.10	997.20	997.20	997.20	997.20	997.20	997.20
4-1/2-8 NS	Hand Tap	H8	10		014143AS		1559.70	1536.30	1497.30	1497.30	1497.30	1497.30	1497.30	1497.30
4-1/2-12 NS	Hand Tap	H7	10		014144AS		1091.50	1075.10	1047.80	1047.80	1047.80	1047.80	1047.80	1047.80
4-3/4-8 NS	Hand Tap	H8	10		014145AS		1638.10	1613.50	1572.60	1572.60	1572.60	1572.60	1572.60	1572.60
4-3/4-12 NS	Hand Tap	H7	10		014146AS		1147.50	1130.30	1101.60	1101.60	1101.60	1101.60	1101.60	1101.60
5-8 NS	Hand Tap	H8	10		014147AS		1719.70	1693.90	1650.90	1650.90	1650.90	1650.90	1650.90	1650.90
5-12 NS	Hand Tap	H7	10		014148AS		1205.00	1186.90	1156.80	1156.80	1156.80	1156.80	1156.80	1156.80
5-1/4-8 NS	Hand Tap	H8	10		014149AS		1805.90	1778.80	1733.70	1733.70	1733.70	1733.70	1733.70	1733.70
5-1/4-12 NS	Hand Tap	H7	10		014150AS		1262.50	1243.60	1212.00	1212.00	1212.00	1212.00	1212.00	1212.00
5-1/2-8 NS	Hand Tap	H8	10		014151AS		1901.60	1873.10	1825.50	1825.50	1825.50	1825.50	1825.50	1825.50
5-1/2-12 NS	Hand Tap	H7	10		014152AS		1334.50	1314.50	1281.10	1281.10	1281.10	1281.10	1281.10	1281.10
5-3/4-8 NS	Hand Tap	H8	10		014153AS		1997.60	1967.60	1917.70	1917.70	1917.70	1917.70	1917.70	1917.70
5-3/4-12 NS	Hand Tap	H7	10		014154AS		1398.50	1377.50	1342.60	1342.60	1342.60	1342.60	1342.60	1342.60
6-8 NS	Hand Tap	H8	10		014155AS		2093.60	2062.20	2009.90	2009.90	2009.90	2009.90	2009.90	2009.90
6-12 NS	Hand Tap	H7	10		014156AS		1470.30	1448.20	1411.50	1411.50	1411.50	1411.50	1411.50	1411.50

*The most popular limits and flute configurations, both Right- and Left-Hand sizes, are shown in our Industrial Metalworking catalog and on our website.

METRIC SPECIAL TAPS & DIES



M1.5 x 0.35 To M5 x 0.5

Call for pricing on Special Gages for these taps.

Size/Pitch	Type	D#	#Fl	Taper	Plug	Bottom	1	2	3	6	8	12	24	48
M1.5 x 0.35	Hand Tap	D1	2	025000AS	025001AS	025002AS	45.60	44.90	43.80	36.50	27.40	22.80	21.90	19.20
M1.6 x 0.35*	Hand Tap	D1	2	020008AS	020009AS	020010AS	13.40	13.40	13.40	13.40	13.40	13.40	13.40	13.40
M1.8 x 0.35*	Hand Tap	D1	2	020024AS	020025AS	020026AS	14.30	14.30	14.30	14.30	14.30	12.40	12.20	11.90
M2 x 0.4*	Hand Tap	D1	3	020040AS	020041AS	020042AS	14.30	14.30	14.30	14.30	14.30	12.40	12.20	11.90
	LH 25.4mm O.D. Die				045750AS		66.20	65.20	63.60	53.00	39.70	33.10	31.80	27.80
M2 x 0.45	Hand Tap	D2	3	025048AS	025049AS	025050AS	13.80	13.80	13.80	13.80	13.80	12.00	11.70	11.50
M2.2 x 0.45*	Hand Tap	D1	3	020056AS	020057AS	020058AS	13.80	13.80	13.80	13.80	13.80	12.00	11.70	11.50
M2.5 x 0.45*	Hand Tap	D1	3	020072AS	020073AS	020074AS	9.70	9.70	9.70	9.70	9.70	9.70	9.70	9.70
	Spiral Pt.	D1	2		020075AS		15.00	15.00	15.00	15.00	15.00	13.10	12.80	12.50
M2.6 x 0.45	Hand Tap	D2	3	025096AS	025097AS	025098AS	19.70	19.40	18.90	15.80	11.80	9.90	9.50	8.30
	Hand Tap	D3	3		025099AS	025100AS	19.70	19.40	18.90	15.80	11.80	9.90	9.50	8.30
	25.4mm O.D. Die				045406AS		66.20	65.20	63.60	53.00	39.70	33.10	31.80	27.80
M3 x 0.5*	Hand Tap	D1	3	020088AS	020089AS	020090AS	17.00	16.70	16.30	13.60	10.20	8.50	8.20	7.10
	Spiral Pt.	D1	2		020091AS		19.70	19.40	18.90	15.80	11.80	9.90	9.50	8.30
	Spiral Pt.	D5	2		020092AS		19.70	19.40	18.90	15.80	11.80	9.90	9.50	8.30
	Spiral Pt.	D7	2		020093AS		19.70	19.40	18.90	15.80	11.80	9.90	9.50	8.30
	Micrograin Carbide	D3	3		018794RS	018795RS	79.90	79.90	79.90	79.90	79.90	69.50	67.90	66.30
	Micrograin Carbide Spiral Pt.	D3	2		018796RS		83.60	83.60	83.60	83.60	83.60	72.70	71.10	69.40
	LH 25.4mm O.D. Die				045756AS		66.20	65.20	63.60	53.00	39.70	33.10	31.80	27.80
M3 x 0.6	Hand Tap	D2	3	025120AS	025121AS	025122AS	17.00	16.70	16.30	13.60	10.20	8.50	8.20	7.10
	25.4mm O.D. Die				045408AS		66.20	65.20	63.60	53.00	39.70	33.10	31.80	27.80
M3.5 x 0.6*	Hand Tap	D1	3	020104AS	020105AS	020106AS	14.70	14.50	14.10	11.80	8.80	7.40	7.10	6.20
	Spiral Pt.	D1	2		020107AS		16.70	16.40	16.00	13.40	10.00	8.40	8.00	7.00
	Spiral Pt.	D11	2		024275AS		18.60	18.30	17.90	14.90	11.20	9.30	8.90	7.80
	Micrograin Carbide	D4	3		018797RS	018798RS	79.90	79.90	79.90	79.90	79.90	69.50	67.90	66.30
	Micrograin Carbide Spiral Pt.	D4	2		018799RS		83.60	83.60	83.60	83.60	83.60	72.70	71.10	69.40
	LH 25.4mm O.D. Die				045758AS		66.20	65.20	63.60	53.00	39.70	33.10	31.80	27.80
M4 x 0.7*	Hand Tap	D2	4	020120AS	020121AS	020122AS	14.70	14.50	14.10	11.80	8.80	7.40	7.10	6.20
	Spiral Pt.	D1	2		020124AS		16.70	16.40	16.00	13.40	10.00	8.40	8.00	7.00
	Spiral Pt.	D2	2		020123AS		16.70	16.40	16.00	13.40	10.00	8.40	8.00	7.00
	Spiral Pt.	D5	2		020125AS		18.60	18.60	18.60	18.60	18.60	16.20	15.80	15.40
	Spiral Pt.	D7	2		020126AS		18.60	18.60	18.60	18.60	18.60	16.20	15.80	15.40
	Spiral Pt.	D11	2		024276AS		18.60	18.60	18.60	18.60	18.60	16.20	15.80	15.40
	Micrograin Carbide	D4	4		018800RS	018802RS	73.60	73.60	73.60	73.60	73.60	64.00	62.60	61.10
	Micrograin Carbide Spiral Pt.	D4	2		018830RS		76.90	76.90	76.90	76.90	76.90	66.90	65.40	63.80
	LH 25.4mm O.D. Die				045760AS		66.20	65.20	63.60	53.00	39.70	33.10	31.80	27.80
M4 x 0.75	Hand Tap	D4	4		020127AS	020128AS	16.70	16.40	16.00	13.40	10.00	8.40	8.00	7.00
M4.5 x 0.75*	Hand Tap	D2	4	020136AS	020137AS	020138AS	14.70	14.50	14.10	11.80	8.80	7.40	7.10	6.20
	Spiral Pt.	D2	2		020139AS		16.70	16.40	16.00	13.40	10.00	8.40	8.00	7.00
	Spiral Pt.	D11	2		024277AS		18.60	18.60	18.60	18.60	18.60	16.20	15.80	15.40
	Micrograin Carbide	D4	4		018815RS	018816RS	73.60	73.60	73.60	73.60	73.60	64.00	62.60	61.10
	Micrograin Carbide Spiral Pt.	D4	2		018831RS		76.90	76.90	76.90	76.90	76.90	66.90	65.40	63.80
M5 x 0.5	Hand Tap	D3	4		020140AS	020141AS	17.70	17.40	17.00	14.20	10.60	8.90	8.50	7.40
	Spiral Pt.	D3	2		020150AS		19.80	19.50	19.00	15.80	11.90	9.90	9.50	8.30

*The most popular D limits and flute configurations for Metric, both Right- and Left-Hand sizes, are shown in our Industrial Metalworking catalog and on our website.

METRIC SPECIAL TAPS & DIES



M5 x 0.8 To M9 x 1.0

Call for pricing on Special Gages for these taps.

Size/Pitch	Type	D#	#Fl	Taper	Plug	Bottom	1	2	3	6	8	12	24	48
M5 x 0.8*	Hand Tap	D2	4	020152AS	020153AS	020154AS	17.70	17.40	17.00	14.20	10.60	8.90	8.50	7.40
	Spiral Pt.	D1	2		020156AS		19.80	19.50	19.00	15.80	11.90	9.90	9.50	8.30
	Spiral Pt.	D2	2		020155AS		19.80	19.50	19.00	15.80	11.90	9.90	9.50	8.30
	Spiral Pt.	D7	2		020157AS		18.80	18.80	18.80	18.80	18.80	16.40	16.00	15.60
	Spiral Pt.	D11	2		024278AS		18.80	18.80	18.80	18.80	18.80	16.40	16.00	15.60
	Micrograin Carbide	D4	4		018803RS	018804RS	76.70	76.70	76.70	76.70	76.70	66.70	65.20	63.70
M5 x 0.9	Micrograin Carbide Spiral Pt.	D4	2		018833RS		80.00	80.00	80.00	80.00	80.00	69.60	68.00	66.40
	LH 25.4mm O.D. Die				045764AS		66.20	65.20	63.60	53.00	39.70	33.10	31.80	27.80
	Hand Tap	D3	4	025181AS	025182AS	025183AS	17.70	17.40	17.00	14.20	10.60	8.90	8.50	7.40
M5.5 x 0.9	Spiral Pt.	D3	2		025184AS		19.80	19.50	19.00	15.80	11.90	9.90	9.50	8.30
	25.4mm O.D. Die				045414AS		66.20	65.20	63.60	53.00	39.70	33.10	31.80	27.80
	Hand Tap	D3	4	025213AS	025214AS	025215AS	20.10	19.80	19.30	16.10	12.10	10.10	9.60	8.40
M6 x 0.50	Spiral Pt.	D3	2		025216AS		22.30	22.00	21.40	17.80	13.40	11.20	10.70	9.40
	25.4mm O.D. Die				045416AS		66.20	65.20	63.60	53.00	39.70	33.10	31.80	27.80
	Hand Tap	D3	4		020175AS	020176AS	18.50	18.20	17.80	14.80	11.10	9.30	8.90	7.80
M6 x 0.75	Hand Tap	D3	4	025229AS	025230AS	025231AS	18.50	18.20	17.80	14.80	11.10	9.30	8.90	7.80
	Spiral Pt.	D3	2		025232AS		21.20	20.90	20.40	17.00	12.70	10.60	10.20	8.90
	25.4mm O.D. Die				045418AS		66.20	65.20	63.60	53.00	39.70	33.10	31.80	27.80
M6 x 1*	Hand Tap	D3	4	020168AS	020169AS	020170AS	20.10	19.80	19.30	16.10	12.10	10.10	9.60	8.40
	Spiral Pt.	D3	2		020171AS		22.30	22.00	21.40	17.80	13.40	11.20	10.70	9.40
	Spiral Pt.	D11	2		024279AS		10.10	10.10	10.10	10.10	10.10	8.80	8.60	8.40
	Micrograin Carbide	D5	4		018805RS	018807RS	76.70	76.70	76.70	76.70	76.70	66.70	65.20	63.70
	Micrograin Carbide Spiral Pt.	D5	2		018835RS		80.00	80.00	80.00	80.00	80.00	69.60	68.00	66.40
	LH 25.4mm O.D. Die				045768AS		66.20	65.20	63.60	53.00	39.70	33.10	31.80	27.80
M6.3 x 1.0	Hand Tap	D5	4		090946AS	090948AS	29.50	29.50	29.50	24.50	19.50	14.50	11.50	10.30
	Spiral Pt.	D3	2		020187AS		29.50	29.50	29.50	24.50	19.50	14.50	11.50	10.30
	Spiral Pt.	D5	2		020179AS		29.50	29.50	29.50	24.50	19.50	14.50	11.50	10.30
M7 x 1*	Hand Tap	D3	4	020200AS	020201AS	020202AS	20.70	20.40	19.90	16.60	12.40	10.40	9.90	8.70
	Spiral Pt.	D3	2		020203AS		23.90	23.50	22.90	19.10	14.30	12.00	11.50	10.00
	Spiral Pt.	D11	2		024280AS		11.80	11.80	11.80	11.80	11.80	10.30	10.00	9.80
	Micrograin Carbide	D5	4		018814RS	018813RS	78.10	78.10	78.10	78.10	78.10	67.90	66.40	64.80
	Micrograin Carbide Spiral Pt.	D5	2		018836RS		81.60	81.60	81.60	81.60	81.60	71.00	69.40	67.70
	Hand Tap	D4	4		020220AS	020221AS	12.30	12.30	12.30	12.30	12.30	10.70	10.50	10.20
M8 x 0.5	Hand Tap	D5	4		020222AS	020223AS	12.30	12.30	12.30	12.30	12.30	10.70	10.50	10.20
	Hand Tap	D3	4	020232AS	020233AS	020234AS	20.70	20.40	19.90	16.60	12.40	10.40	9.90	8.70
	Spiral Pt.	D3	2		020235AS		20.70	20.40	19.90	16.60	12.40	10.40	9.90	8.70
M8 x 0.75	Spiral Pt.	D11	2		024282AS		11.80	11.80	11.80	11.80	11.80	10.30	10.00	9.80
	Micrograin Carbide	D5	4		018808RS	018809RS	78.10	78.10	78.10	78.10	78.10	67.90	66.40	64.80
	Hand Tap	D3	4	020216AS	020217AS	020218AS	20.70	20.40	19.90	16.60	12.40	10.40	9.90	8.70
	Spiral Pt.	D3	2		020219AS		23.90	23.50	22.90	19.10	14.30	12.00	11.50	10.00
	Spiral Pt.	D11	2		024281AS		11.80	11.80	11.80	11.80	11.80	10.30	10.00	9.80
	Micrograin Carbide	D5	4		018810RS	018812RS	78.10	78.10	78.10	78.10	78.10	67.90	66.40	64.80
M8 x 1.25*	Micrograin Carbide Spiral Pt.	D5	3		018840RS		81.60	81.60	81.60	81.60	81.60	71.00	69.40	67.70
	Hand Tap	D5	4		020236AS	020237AS	33.60	33.10	32.30	26.90	20.20	16.80	16.10	14.10

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METRIC SPECIAL TAPS & DIES



M9 x 1.25 To M16 x 1.5

Size/Pitch	Type	D#	#Fl	Taper	Plug	Bottom	1	2	3	6	8	12	24	48
M9 x 1.25	Hand Tap	D3	4		090966AS	090968AS	33.60	33.10	32.30	26.90	20.20	16.80	16.10	14.10
	Hand Tap	D5	4		090970AS	090972AS	33.60	33.10	32.30	26.90	20.20	16.80	16.10	14.10
M10 x 1.0	Hand Tap	D3	4		020240AS	020241AS	33.60	33.10	32.30	26.90	20.20	16.80	16.10	14.10
	LH Hand Tap	D5	4		029220AS	029221AS	34.70	34.20	33.30	27.80	20.80	17.40	16.70	14.60
	Spiral Pt.	D5	3		025306AS		34.70	34.20	33.30	27.80	20.80	17.40	16.70	14.60
	Hand Tap	D5	4	025312AS	025308AS	025310AS	18.10	18.10	18.10	18.10	18.10	18.10	17.70	17.40
M10 x 1.25*	Hand Tap	D3	4	020264AS	020265AS	020266AS	33.60	33.10	32.30	26.90	20.20	16.80	16.10	14.10
	Spiral Pt.	D3	3		020267AS		34.70	34.20	33.30	27.80	20.80	17.40	16.70	14.60
	Spiral Pt.	D11	3		024284AS		19.80	19.80	19.80	19.80	19.80	17.20	16.80	16.40
	Micrograin Carbide	D5	4		018825RS	018827RS	99.00	99.00	99.00	99.00	99.00	86.10	84.20	82.20
	Micrograin Carbide Spiral Pt.	D5	3		018855RS		102.30	102.30	102.30	102.30	102.30	89.00	87.00	84.90
M10 x 1.5*	Hand Tap	D3	4	020248AS	020249AS	020250AS	33.60	33.10	32.30	26.90	20.20	16.80	16.10	14.10
	Spiral Pt.	D3	3		020251AS		34.70	34.20	33.30	27.80	20.80	17.40	16.70	14.60
	Spiral Pt.	D7	3		020252AS		34.70	34.20	33.30	27.80	20.80	17.40	16.70	14.60
	Spiral Pt.	D11	3		024283AS		19.80	19.80	19.80	19.80	19.80	17.20	16.80	16.40
	Micrograin Carbide	D6	4		018820RS	018822RS	124.50	122.60	119.50	119.50	119.50	119.50	119.50	119.50
	Micrograin Carbide Spiral Pt.	D6	3		018858RS		128.90	127.00	123.70	123.70	123.70	123.70	123.70	123.70
	LH 38mm O.D. Die				045800AS		88.30	87.00	84.80	70.60	53.00	44.20	42.40	37.10
M11 x 1.0	Hand Tap	D5	4		020270AS	020271AS	33.60	33.10	32.30	26.90	20.20	16.80	16.10	14.10
M11 x 1.5*	Hand Tap	D5	4	025317AS	025318AS	025319AS	33.60	33.10	32.30	26.90	20.20	16.80	16.10	14.10
	Spiral Pt.	D5	3		025320AS		34.70	34.20	33.30	27.80	20.80	17.40	16.70	14.60
	38mm O.D. Die				045452AS		88.30	87.00	84.80	70.60	53.00	44.20	42.40	37.10
M12 x 1.0	Hand Tap	D3	4		090978AS	090980AS	32.80	32.30	31.50	26.20	19.70	16.40	15.70	13.80
	Hand Tap	D5	4		020254AS	020253AS	32.80	32.30	31.50	26.20	19.70	16.40	15.70	13.80
	Spiral Pt.	D5	3		020290AS		36.20	35.70	34.80	29.00	21.70	18.10	17.40	15.20
M12 x 1.25*	Hand Tap	D3	4	020296AS	020297AS	020298AS	32.80	32.30	31.50	26.20	19.70	16.40	15.70	13.80
	Spiral Pt.	D3	3		020299AS		36.20	35.70	34.80	29.00	21.70	18.10	17.40	15.20
M12 x 1.5	Hand Tap	D5	4		090986AS	090988AS	32.80	32.30	31.50	26.20	19.70	16.40	15.70	13.80
	Hand Tap	D6	4		020300AS	020301AS	32.80	32.30	31.50	26.20	19.70	16.40	15.70	13.80
	Spiral Pt.	D6	3		020302AS		36.20	35.70	34.80	29.00	21.70	18.10	17.40	15.20
M12 x 1.75*	Hand Tap	D3	4	020280AS	020281AS	020282AS	32.80	32.30	31.50	26.20	19.70	16.40	15.70	13.80
	Spiral Pt.	D3	3		020283AS		36.20	35.70	34.80	29.00	21.70	18.10	17.40	15.20
	Spiral Pt.	D11	3		024285AS		23.90	23.90	23.90	23.90	23.90	20.80	20.30	19.80
	Carbo-Clad	D6	4		018859US	018860US	163.20	163.20	163.20	163.20	163.20	142.00	138.70	135.50
	Micrograin Carbide Spiral Pt.	D6	3		018861RS		128.90	128.90	128.90	128.90	128.90	112.10	109.60	107.00
	LH 38mm O.D. Die				045804AS		88.30	87.00	84.80	70.60	53.00	44.20	42.40	37.10
M14 x 1.0	Hand Tap	D5	4		020317AS	020318AS	45.20	44.50	43.40	36.20	27.10	22.60	21.70	19.00
M14 x 1.25	Hand Tap	D6	4	020320AS	020321AS	020322AS	51.10	50.30	49.10	40.90	30.70	25.60	24.50	21.50
	Spark Plug	D4	4		029002AS	029003AS	51.10	50.30	49.10	40.90	30.70	25.60	24.50	21.50
M14 x 1.5*	Hand Tap	D3	4	020328AS	020329AS	020330AS	45.20	44.50	43.40	36.20	27.10	22.60	21.70	19.00
	Spiral Pt.	D3	3		020331AS		51.10	50.30	49.10	40.90	30.70	25.60	24.50	21.50
M14 x 2*	Hand Tap	D3	4	020312AS	020313AS	020314AS	45.20	44.50	43.40	36.20	27.10	22.60	21.70	19.00
	Spiral Pt.	D3	3		020315AS		51.10	50.30	49.10	40.90	30.70	25.60	24.50	21.50
	LH 38mm O.D. Die				045806AS		88.30	87.00	84.80	70.60	53.00	44.20	42.40	37.10
M15 x 1.0	Hand Tap	D5	4		020352AS	020353AS	54.00	53.20	51.80	43.20	32.40	27.00	25.90	22.70
M16 x 1.0	Hand Tap	D5	4		020350AS	020351AS	54.00	53.20	51.80	43.20	32.40	27.00	25.90	22.70
M16 x 1.5	Hand Tap	D3	4	020360AS	020361AS	020362AS	54.00	53.20	51.80	43.20	32.40	27.00	25.90	22.70
	Spiral Pt.	D3	3		020363AS		61.20	60.30	58.80	49.00	36.70	30.60	29.40	25.70

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METRIC SPECIAL TAPS & DIES



M16 x 2 To M42 x 4.5

Call for pricing on Special Gages for these taps.

Size/Pitch	Type	D#	#Fl	Taper	Plug	Bottom	1	2	3	6	8	12	24	48
M16 x 2*	Hand Tap	D4	4	020344AS	020345AS	020346AS	54.00	53.20	51.80	43.20	32.40	27.00	25.90	22.70
	Spiral Pt.	D4	3		020347AS		61.20	60.30	58.80	49.00	36.70	30.60	29.40	25.70
	Spiral Pt.	D11	3		024286AS		80.00	78.40	72.00	60.00	44.00	36.00	28.00	22.40
	LH 38mm O.D. Die				045810AS		88.30	87.00	84.80	70.60	53.00	44.20	42.40	37.10
M18 x 1.0	Hand Tap	D5	4		020380AS	020381AS	78.70	77.10	70.80	59.00	43.30	35.40	27.50	22.00
M18 x 1.5*	Hand Tap	D3	4	020393AS	020394AS	020395AS	78.70	77.10	70.80	59.00	43.30	35.40	27.50	22.00
	Spark Plug	D4	4		029004AS	029005AS	78.70	78.70	78.70	65.30	51.90	38.60	30.70	27.50
	LH 38mm O.D. Die				045814AS		88.30	87.00	84.80	70.60	53.00	44.20	42.40	37.10
M18 x 2.5*	Hand Tap	D4	4	020375AS	020376AS	020377AS	78.70	77.10	70.80	59.00	43.30	35.40	27.50	22.00
	LH 38mm O.D. Die				045812AS		88.30	87.00	84.80	70.60	53.00	44.20	42.40	37.10
M20 x 1.0	Hand Tap	D6	4		020420AS	020421AS	92.20	90.40	83.00	69.20	50.70	41.50	32.30	25.80
M20 x 1.5	Hand Tap	D3	4	020429AS	020430AS	020431AS	92.20	90.40	83.00	69.20	50.70	41.50	32.30	25.80
M20 x 2	Hand Tap	D6	4	025491AS	025492AS	025493AS	92.20	90.40	83.00	69.20	50.70	41.50	32.30	25.80
	50.8mm O.D. Die				045482AS		184.90	182.10	177.50	147.90	110.90	92.50	88.80	77.70
M20 x 2.5*	Hand Tap	D4	4	020411AS	020412AS	020413AS	92.20	90.40	83.00	69.20	50.70	41.50	32.30	25.80
M22 x 1.5*	Hand Tap	D3	4	020465AS	020466AS	020467AS	96.50	95.10	92.60	77.20	57.90	48.30	46.30	40.50
M22 x 2.5*	Hand Tap	D4	4	020447AS	020448AS	020449AS	96.50	95.10	92.60	77.20	57.90	48.30	46.30	40.50
M24 x 1.5	Hand Tap	D6	4		020450AS	020451AS	109.50	87.60	61.30	50.40	42.70	38.30	35.00	30.70
M24 x 2*	Hand Tap	D4	4	020501AS	020502AS	020503AS	109.50	87.60	61.30	50.40	42.70	38.30	35.00	30.70
M24 x 3*	Hand Tap	D4	4	020483AS	020484AS	020485AS	109.50	87.60	61.30	50.40	42.70	38.30	35.00	30.70
	Spiral Pt.	D8	3		020486AS		109.50	107.90	105.10	87.60	65.70	54.80	52.60	46.00
M25 x 1.5	Hand Tap	D6	4		020505AS	020506AS	127.50	102.00	71.40	58.70	49.70	44.60	40.80	35.70
M26 x 1.5	Hand Tap	D6	6		020507AS	020508AS	127.50	102.00	71.40	58.70	49.70	44.60	40.80	35.70
M27 x 1.5	Hand Tap	D6	6		020509AS	020510AS	127.50	102.00	71.40	58.70	49.70	44.60	40.80	35.70
M27 x 2*	Hand Tap	D5	4	020537AS	020538AS	020539AS	182.90	146.30	102.40	84.10	71.30	64.00	58.50	51.20
M27 x 3*	Hand Tap	D5	4	020519AS	020520AS	020521AS	182.90	146.30	102.40	84.10	71.30	64.00	58.50	51.20
	Hand Tap	D9	4		020522AS		182.90	146.30	102.40	84.10	71.30	64.00	58.50	51.20
	Hand Tap LH	D5	4	029242AS	029243AS	029244AS	182.90	146.30	102.40	84.10	71.30	64.00	58.50	51.20
M30 x 1.5	Hand Tap	D6	6		020577AS	020578AS	198.20	174.40	168.50	138.70	99.10	63.40	55.50	49.60
M30 x 2*	Hand Tap	D5	4	020573AS	020574AS	020575AS	198.20	158.60	111.00	91.20	77.30	69.40	63.40	55.50
M30 x 3.5	Hand Tap	D5	4	020555AS	020556AS	020557AS	198.20	158.60	111.00	91.20	77.30	69.40	63.40	55.50
	Hand Tap LH	D5	4	029261AS	029262AS	029263AS	198.20	158.60	111.00	91.20	77.30	69.40	63.40	55.50
M32 x 1.5	Hand Tap	D6	6		020561AS	020562AS	198.20	158.60	111.00	91.20	77.30	69.40	63.40	55.50
M32 x 2	Hand Tap	D7	6	025706AS	025707AS	025708AS	198.20	158.60	111.00	91.20	77.30	69.40	63.40	55.50
M33 x 2*	Hand Tap	D5	4	020609AS	020610AS	020611AS	234.50	187.60	131.30	107.90	91.50	82.10	75.00	65.70
M33 x 3.5*	Hand Tap	D5	4	020591AS	020592AS	020593AS	234.50	187.60	131.30	107.90	91.50	82.10	75.00	65.70
M35 x 1.5	Hand Tap	D6	6		020600AS	020601AS	255.00	204.00	142.80	117.30	99.50	89.30	81.60	71.40
M36 x 1.5	Hand Tap	D6	6		020602AS	020603AS	255.00	204.00	142.80	117.30	99.50	89.30	81.60	71.40
M36 x 2	Hand Tap	D7	6		020604AS	020605AS	255.00	204.00	142.80	117.30	99.50	89.30	81.60	71.40
M36 x 3*	Hand Tap	D5	4	020645AS	020646AS	020647AS	263.20	210.60	147.40	121.10	102.60	92.10	84.20	73.70
M36 x 4*	Hand Tap	D5	4	020627AS	020628AS	020629AS	263.20	210.60	147.40	121.10	102.60	92.10	84.20	73.70
M39 x 3*	Hand Tap	D6	6	020681AS	020682AS	020683AS	275.10	220.10	154.10	126.50	107.30	96.30	88.00	77.00
M39 x 4*	Hand Tap	D6	6	020663AS	020664AS	020665AS	275.10	220.10	154.10	126.50	107.30	96.30	88.00	77.00
M40 x 1.5	Hand Tap	D6	6		020690AS	020691AS	253.90	203.10	142.20	116.80	99.00	88.90	81.20	71.10
M42 x 1.5	Hand Tap	D6	6		020692AS	020693AS	253.90	203.10	142.20	116.80	99.00	88.90	81.20	71.10
M42 x 4.5	Hand Tap	D10	6		020694AS	020695AS	301.50	241.20	168.80	138.70	117.60	105.50	96.50	84.40

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SPECIAL TAPS FROM BLANKS

SPECIAL STRAIGHT FLUTE & SPIRAL POINT TAPS

From Blanks

Quantities 1 to 48

Right and left taps available. Special Gages available. Call for pricing.



Straight Flute

Size	Max. Thread per Inch	Max. Decimal	Size (mm)	Min. Pitch (mm)	Overall Length	Thread Length	Square Length	Shank Diameter	Size of Square
0	100	.065	-	0.3	1-5/8	5/16	3/16	.141	.110
1	100	.078	M1.8	0.3	1-11/16	3/8	3/16	.141	.110
2	100	.091	M2, M2.2	0.3	1-3/4	7/16	3/16	.141	.110
3	100	.104	M2.3, M2.5, M2.6	0.3	1-13/16	1/2	3/16	.141	.110
4	100	.117	-	-	1-7/8	9/16	3/16	.141	.110
5	100	.130	M3	0.3	1-15/16	5/8	3/16	.141	.110
6	100	.145	M3.5	0.3	2	11/16	3/16	.141	.110
8	100	.171	M4	0.3	2-1/8	3/4	1/4	.168	.131
10	100	.197	M4.5, M5	0.3	2-3/8	7/8	1/4	.194	.152
12	100	.223	M5.5	0.3	2-3/8	15/16	9/32	.220	.165
14	80	.260	M6	0.3	2-1/2	1	5/16	.255	.191
1/4	80	.260	-	-	2-1/2	1	5/16	.255	.191
5/16	80	.323	M7, M8	0.3	2-23/32	1-1/8	3/8	.318	.238
3/8	80	.385	M9, M10	0.3	2-15/16	1-1/4	7/16	.381	.286
7/16	80	.448	M11	0.3	3-5/32	1-7/16	13/32	.323	.242
1/2	80	.510	M12	0.3	3-3/8	1-21/32	7/16	.367	.275
9/16	64	.573	M14	0.4	3-19/32	1-21/32	1/2	.429	.322
5/8	64	.635	M16	0.4	3-13/16	1-13/16	9/16	.480	.360
11/16	64	.709	M18	0.4	4-1/32	1-13/16	5/8	.542	.406
3/4	64	.760	-	-	4-1/4	2	11/16	.590	.442
13/16	64	.823	M20	0.4	4-15/32	2	11/16	.652	.489
7/8	64	.885	M22	0.4	4-11/16	2-7/32	3/4	.697	.523
15/16	64	.948	M24	0.4	4-29/32	2-7/32	3/4	.760	.570
1"	64	1.010	M25	0.4	5-1/8	2-1/2	13/16	.800	.600



Spiral Point

Size	Max. Thread per Inch	Max. Decimal	Size (mm)	Min. Pitch (mm)	Overall Length	Thread Length	Square Length	Shank Diameter	Size of Square
0	100	.065	-	0.3	1-5/8	5/16	3/16	.141	.110
1	100	.078	M1.8	0.3	1-11/16	3/8	3/16	.141	.110
2	100	.091	M2, M2.2	0.3	1-3/4	7/16	3/16	.141	.110
3	100	.104	M2.3, M2.5, M2.6	0.3	1-13/16	1/2	3/16	.141	.110
4	100	.117	-	-	1-7/8	9/16	3/16	.141	.110
5	100	.130	M3	0.3	1-15/16	5/8	3/16	.141	.110
6	100	.145	M3.5	0.3	2	11/16	3/16	.141	.110
8	100	.171	M4	0.3	2-1/8	3/4	1/4	.168	.131
10	100	.197	M4.5, M5	0.3	2-3/8	7/8	1/4	.194	.152
12	100	.223	M5.5	0.3	2-3/8	15/16	9/32	.220	.165
14	80	.260	M6	0.3	2-1/2	1	5/16	.255	.191
1/4	80	.260	-	-	2-1/2	1	5/16	.255	.191
5/16	80	.323	M7, M8	0.3	2-23/32	1-1/8	3/8	.318	.238
3/8	80	.385	M9, M10	0.3	2-15/16	1-1/4	7/16	.381	.286
7/16	80	.448	M11	0.3	3-5/32	1-7/16	13/32	.323	.242
1/2	80	.510	M12	0.3	3-3/8	1-21/32	7/16	.367	.275
9/16	64	.573	M14	0.4	3-19/32	1-21/32	1/2	.429	.322
5/8	64	.635	M16	0.4	3-13/16	1-13/16	9/16	.480	.360
11/16	64	.709	M18	0.4	4-1/32	1-13/16	5/8	.542	.406
3/4	64	.760	-	-	4-1/4	2	11/16	.590	.442
13/16	64	.823	M20	0.4	4-15/32	2	11/16	.652	.489
7/8	64	.885	M22	0.4	4-11/16	2-7/32	3/4	.697	.523
15/16	64	.948	M24	0.4	4-29/32	2-7/32	3/4	.760	.570
1"	64	1.010	M25	0.4	5-1/8	2-1/2	13/16	.800	.600

Dimensions as shown in Table 302 on page 43.

SPECIAL TAPS FROM BLANKS



SPECIAL STRAIGHT FLUTE TAPS

From Blanks

Up to 2-7/8" quantity of 12. 3" to 4" quantities up to 3.

Right and left taps available. Special Gages available. Call for pricing.

Size	Max. Thread per Inch	Size (mm)	Min. Pitch (mm)	Length Overall	Length of Full Thread	Long Table 302/ Short Table 303	No. of Flutes	Shank Diameter	Square Length	Size of Square
1-1/16	13	M27	2	5-1/8	2-1/2	L	4	0.896	7/8	.672
	55	M27	0.5	4	1-1/2	S	6	0.896	7/8	.672
1-1/8	13			5-7/16	2-9/16	L	4	0.896	7/8	.672
	55			4	1-1/2	S	6	0.896	7/8	.672
1-3/16	13	M30	2	5-7/16	2-9/16	L	4, 6	1.021	1	.766
	55	M30	0.5	4	1-1/2	S	6	1.021	1	.766
1-1/4	13			5-3/4	2-9/16	L	4, 6	1.021	1	.766
	55			4	1-1/2	S	6	1.021	1	.766
1-5/16	13	M33	2	5-3/4	2-9/16	L	4, 6	1.108	1-1/16	.831
	55	M33	0.5	4	1-1/2	S	6	1.108	1	.831
1-3/8	13			6-1/16	3	L	4, 6	1.108	1-1/16	.831
	55			4	1-1/2	S	6	1.108	1	.831
1-7/16	13	M36	2	6-1/16	3	L	4, 6	1.233	1-1/8	.925
	55	M36	0.5	4	1-1/2	S	6	1.233	1	.925
1-1/2	13	M38	2	6-3/8	3	L	4, 6	1.233	1-1/8	.925
	55	M38	0.5	4	1-1/2	S	6	1.233	1	.925
1-5/8	9	M39	3	6-11/16	3-3/16	L	6	1.305	1-1/8	.979
	55	M39	0.5	5	2	S	6	1.305	1-1/8	.979
1-3/4	9	M42	3	7	3-3/16	L	6	1.430	1-1/4	1.072
	55	M42	0.5	5	2	S	6	1.430	1-1/4	1.072
1-7/8	9	M45	3	7-5/16	3-9/16	L	6	1.519	1-1/4	1.139
	55	M45	0.5	5	2	S	6	1.519	1-1/4	1.139
2"	9	M48	3	7-5/8	3-9/16	L	6	1.644	1-3/8	1.233
	47	M48	0.5	5	2	S	6	1.644	1-3/8	1.233
2-1/8	9			8	3-9/16	L	6	1.769	1-3/8	1.327
	47			5-1/4	2	S	6	1.769	1-3/8	1.327
2-1/4	9	M56	3	8-1/4	3-9/16	L	6	1.894	1-7/16	1.420
	47	M56	0.5	5-1/4	2	S	6	1.894	1-7/16	1.420
2-3/8	9			8-1/2	4	L	6	2.019	1-7/16	1.514
	47			5-1/4	2	S	6	2.019	1-7/16	1.514
2-1/2	9			8-3/4	4	L	6	2.100	1-1/2	1.575
	47			5-1/4	2	S	6	2.100	1-1/2	1.575
2-5/8	9	M64	3	8-3/4	4	L	6	2.225	1-1/2	1.669
	47	M64	0.5	5-1/2	2	S	6	2.100	1-1/2	1.575
2-3/4	9			9-1/4	4	L	6	2.350	1-9/16	1.762
	47			5-1/2	2	S	6	2.100	1-1/2	1.575
2-7/8	9	M72	3	9-1/4	4	L	6	2.475	1-9/16	1.856
	47	M72	0.5	5-1/2	2	S	6	2.100	1-1/2	1.575
3"	9			9-3/4	4-9/16	L	6	2.543	1-5/8	1.907
	47			5-1/2	2	S	8	2.100	1-1/2	1.575
3-1/8	9			9-3/4	4-9/16	L	6	2.668	1-5/8	2.001
	35			5-3/4	2	S	8	2.100	1-1/2	1.575
3-1/4	9	M80	3	10	4-9/16	L	6	2.793	1-3/4	2.095
	35	M80	0.7	5-3/4	2	S	8	2.100	1-1/2	1.575
3-1/2	9			10-1/4	4-15/16	L	6	3.008	2	2.256
	35			5-3/4	2	S	8	2.100	1-1/2	1.575
3-5/8	9	M90	3	10-1/4	4-15/16	L	6	3.133	2	2.350
	35	M90	0.7	6	2	S	8	2.100	1-3/4	1.575
3-3/4	9			10-1/2	5-5/16	L	6	3.217	2-1/8	2.413
	35			6	2	S	8	2.100	1-3/4	1.575
3-7/8	9			10-1/2	5-5/16	L	6	3.342	2-1/8	2.506
	35			6	2	S	8	2.100	1-3/4	1.575
4"	9	M100	3	10-3/4	5-5/16	L	8	3.467	2-1/4	2.600
	35	M100	0.7	6	2	S	8	2.100	1-3/4	1.575

Dimensions as shown in Table 302/303 on page 44.

SPECIAL TAPS FROM BLANKS



SPECIAL STRAIGHT FLUTE TAPS (CON'T)

From Blanks

Up to 2-7/8" quantity of 12. 3" to 4" quantities up to 3.

Right and left taps available. Special Gages available. Call for pricing.

Size	Max. Thread per Inch	Size (mm)	Min. Pitch (mm)	Length Overall	Length of Full Thread	Long/Short	No. of Flutes	Shank Diameter	Square Length	Size of Square
4-1/8	9			10-3/4	5-5/16	L	10	3.467	2-1/4	2.600
	24			6	2	S	10	2.100	1-3/4	1.575
4-1/4	9			10-3/4	5-5/16	L	10	3.467	2-1/4	2.600
	24			6	2	S	10	2.100	1-3/4	1.575
4-1/2	9			10-3/4	5-5/16	L	10	3.825	2-1/4	2.868
	24			6	2	S	10	2.100	1-3/4	1.575
4-3/4	9			10-3/4	5-5/16	L	10	3.950	2-1/4	2.965
	24			6	2	S	10	2.100	1-3/4	1.575
5"	9			11-3/4	5-1/2	L	10	4.200	2-1/2	3.150
	24			6-1/2	2-1/2	S	10	3.467	2	2.600
5-1/4	9			11-3/4	5-1/2	L	10	4.450	2-1/2	3.340
	24			6-1/2	2-1/2	S	10	3.467	2	2.600
5-1/2	9			12	5-3/4	L	10	4.700	2-3/4	3.525
	24			6-1/2	2-1/2	S	10	3.467	2	2.600
5-3/4	9			12	5-3/4	L	10	4.950	2-3/4	3.715
	24			6-1/2	2-1/2	S	10	3.467	2	2.600
6"	9			12	6	L	10	5.200	2-3/4	3.900
	24			7	3	S	10	3.715	2	2.785

Dimensions shown on page 44.

Fast Delivery Special Taps

The key to Regal's successful Fast Delivery Special Program has always been the use of semi-finished blanks. Unfluted blanks are stocked and ready to be fluted, thread ground, and chamfered to meet specific requirements on a timely basis.

Special Features:

- Surface Treatments
- K-grinds
- Interrupted Threads
- Multiple Leads

To order, call: 1-800-435-2948



SPECIAL TAPS FROM BLANKS

CARBIDE SPECIAL STRAIGHT FLUTE & SPIRAL POINT TAPS

From Blanks

Right and left taps available. Special Gages available. Call for pricing.

Straight Flute

Size	Max. Thread per Inch	Max. Decimal Size	Size (mm)	Min. Pitch (mm)	Overall Length	Thread Length	Square Length	Shank Diameter	Size of Square
0	80	.065	-	0.3	1-5/8	5/16	3/16	.141	.110
1	80	.078	M1.8	0.3	1-11/16	3/8	3/16	.141	.110
2	64	.091	M2, M2.2	0.3	1-3/4	7/16	3/16	.141	.110
3	64	.104	M2.3, M2.5, M2.6	0.3	1-13/16	1/2	3/16	.141	.110
4	55	.117	-	-	1-7/8	9/16	3/16	.141	.110
5	47	.130	M3	0.3	1-15/16	5/8	3/16	.141	.110
6	47	.145	M3.5	0.3	2	11/16	3/16	.141	.110
8	47	.171	M4	0.3	2-1/8	3/4	1/4	.168	.131
10	47	.197	M4.5, M5	0.3	2-3/8	7/8	1/4	.194	.152
12	47	.223	M5.5	0.3	2-3/8	15/16	9/32	.220	.165
14	47	.260	M6	0.3	2-1/2	1	5/16	.255	.191
1/4	47	.260	-	-	2-1/2	1	5/16	.255	.191
5/16	35	.323	M7, M8	0.3	2-23/32	1-1/8	3/8	.318	.238
3/8	35	.385	M9, M10	0.3	2-15/16	1-1/4	7/16	.381	.286
7/16	-	.448	M11	0.3	3-5/32	1-7/16	13/32	.323	.242
1/2*	-	.510	M12	0.3	3-3/8	1-21/32	7/16	.367	.275

*Carbo-clad carbide tipped blank. Dimensions as shown in Table 302 on page 43.

Spiral Point

Size	Max. Thread per Inch	Max. Decimal Size	Size (mm)	Min. Pitch (mm)	Overall Length	Thread Length	Square Length	Shank Diameter	Size of Square
0	80	.065	-	0.3	1-5/8	5/16	3/16	.141	.110
1	80	.078	M1.8	0.3	1-11/16	3/8	3/16	.141	.110
2	64	.091	M2, M2.2	0.3	1-3/4	7/16	3/16	.141	.110
3	64	.104	M2.3, M2.5, M2.6	0.3	1-13/16	1/2	3/16	.141	.110
4	55	.117	-	-	1-7/8	9/16	3/16	.141	.110
5	47	.130	M3	0.3	1-15/16	5/8	3/16	.141	.110
6	47	.145	M3.5	0.3	2	11/16	3/16	.141	.110
8	47	.171	M4	0.3	2-1/8	3/4	1/4	.168	.131
10	47	.197	M4.5, M5	0.3	2-3/8	7/8	1/4	.194	.152
12	47	.223	M5.5	0.3	2-3/8	15/16	9/32	.220	.165
14	47	.260	M6	0.3	2-1/2	1	5/16	.255	.191
1/4	47	.260	-	-	2-1/2	1	5/16	.255	.191
5/16	35	.323	M7, M8	0.3	2-23/32	1-1/8	3/8	.318	.238
3/8	35	.385	M9, M10	0.3	2-15/16	1-1/4	7/16	.381	.286
7/16	-	.448	M11	0.3	3-5/32	1-7/16	13/32	.323	.242
1/2*	-	.510	M12	0.3	3-3/8	1-21/32	7/16	.367	.275

*Carbo-clad carbide tipped blank. Dimensions as shown in Table 302 on page 43.

SPECIAL TAPS FROM BLANKS



Quantities 1 to 24

SPECIAL EXTENSION TAPS

From Blanks

Right and left taps available. Special Gages available. Call for pricing.



Straight Flute

Machine Screw/Fractional		Max. Decimal Size	Metric		Length Overall (inches)	Thread Length	Square Length	Shank Diameter	Size of Square
Size	Max. Thread per Inch		Size (mm)	Min. Pitch (mm)					
1/4	80	.260	-	-	4	1	5/16	.255	.191
5/16	80	.323	M7, M8	0.3	4	1-1/8	3/8	.318	.238
3/8	80	.385	M9, M10	0.3	4	1-1/4	7/16	.381	.286

1/4	80	.260	-	-	6	1	5/16	.255	.191
5/16	80	.323	M7, M8	0.3	6	1-1/8	3/8	.318	.238
3/8	80	.385	M9, M10	0.3	6	1-1/4	7/16	.381	.286
7/16	80	.448	M11	0.3	6	1-7/16	13/32	.323	.242
1/2	80	.510	M12	0.3	6	1-21/32	7/16	.367	.275
9/16	64	.573	M14	0.4	6	1-21/32	1/2	.429	.322
5/8	64	.635	M16	0.4	6	1-13/16	9/16	.480	.360
3/4	64	.760	-	-	6	2	11/16	.590	.442
7/8	64	.885	M22	0.4	6	2-7/32	3/4	.697	.523

1/4	80	.260	-	-	8	1	5/16	.255	.191
5/16	80	.323	M7, M8	0.3	8	1-1/8	3/8	.318	.238
3/8	80	.385	M9, M10	0.3	8	1-1/4	7/16	.381	.286
1/2	80	.510	M12	0.3	8	1-21/32	7/16	.367	.275
5/8	64	.635	M16	0.4	8	1-13/16	9/16	.480	.360
3/4	64	.760	-	-	8	2	11/16	.590	.442
1"	64	1.010	M25	0.4	8	2-1/2	13/16	.800	.600

3/8	80	.385	M9, M10	0.3	10	1-1/4	7/16	.381	.286
3/4	64	.760	-	-	10	2	11/16	.590	.442
1"	64	1.010	M25	0.4	10	2-1/2	13/16	.800	.600

1"	64	1.010	M25	0.4	12	2-1/2	13/16	.800	.600
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Spiral Point

Machine Screw/Fractional		Max. Decimal Size	Metric		Length Overall (inches)	Thread Length	Square Length	Shank Diameter	Size of Square
Size	Max. Thread per Inch		Size (mm)	Min. Pitch (mm)					
1/4	80	.260	-	-	4	1	5/16	.255	.191
5/16	80	.323	M7, M8	0.3	4	1-1/8	3/8	.318	.238
3/8	80	.385	M9, M10	0.3	4	1-1/4	7/16	.381	.286

1/4	80	.260	-	-	6	1	5/16	.255	.191
5/16	80	.323	M7, M8	0.3	6	1-1/8	3/8	.318	.238
3/8	80	.385	M9, M10	0.3	6	1-1/4	7/16	.381	.286
7/16	80	.448	M11	0.3	6	1-7/16	13/32	.323	.242
1/2	80	.510	M12	0.3	6	1-21/32	7/16	.367	.275
5/8	64	.635	M16	0.4	6	1-13/16	9/16	.480	.360
3/4	64	.760	-	-	6	2	11/16	.590	.442

Dimensions as shown in Table 303A on page 45.

SPECIAL TAPS FROM BLANKS



Quantities 1 to 48

SPECIAL SPIRAL FLUTE TAPS

From Blanks

Right and left taps available. Special Gages available. Call for pricing.



Slow Spiral - 30° Helix
Available in Plug or Bottoming. RH or LH.



Hi - Spiral
Available in Bottoming and Semi-Bottoming. For Plug, add 10%. RH listed. For LH, consult factory.

Size (Inches)	Max. Thread per Inch	Size (mm)	Min. Pitch (mm)	Overall Length	Thread Length	Square Length	Shank Diameter	Size of Square
3	100	M2.3, M2.5, M2.6	0.3	1-13/16	1/2	3/16	.141	.110
4	100	—	—	1-7/8	9/16	3/16	.141	.110
5	100	M3	0.3	1-15/16	5/8	3/16	.141	.110
6	100	M3.5	0.3	2	11/16	3/16	.141	.110
8	100	M4	0.3	2-1/8	3/4	1/4	.168	.131
10	100	M4.5, M5	0.3	2-3/8	7/8	1/4	.194	.152
12	100	M5.5	0.3	2-3/8	15/16	9/32	.220	.165
14	80	M6	0.3	2-1/2	1	5/16	.255	.191
1/4	80	—	—	2-1/2	1	5/16	.255	.191
5/16	80	M7, M8	0.3	2-23/32	1-1/8	3/8	.318	.238
3/8	80	M9, M10	0.3	2-15/16	1-1/4	7/16	.381	.286
7/16	80	M11	0.3	3-5/32	1-7/16	13/32	.323	.242
1/2	80	M12	0.3	3-3/8	1-21/32	7/16	.367	.275
9/16	64	M14	0.4	3-19/32	1-21/32	1/2	.429	.322
5/8	64	M16	0.4	3-13/16	1-13/16	9/16	.480	.360
11/16	64	M18	0.4	4-1/32	1-13/16	5/8	.542	.406
3/4	64	—	—	4-1/4	2	11/16	.590	.442
7/8	64	M22	0.4	4-11/16	2-7/32	3/4	.697	.523
1"	64	M25	0.4	5-1/8	2-1/2	13/16	.800	.600

Dimensions as shown in Table 302 on page 43.

SPECIAL MET-FLO COLD FORMING TAPS

From Blanks

Size (Inches)	Max. Thread per Inch	Size (mm)	Min. Pitch (mm)	Overall Length	Thread Length	Square Length	Shank Diameter	Size of Square
#2	100	M2, M2.2	0.091	1-3/4	7/16	3/16	.141	.110
#3	100	M2.3, M2.5, M2.6	0.3	1-13/16	1/2	3/16	.141	.110
#4	100	—	—	1-7/8	9/16	3/16	.141	.110
#5	100	M3	0.3	1-15/16	5/8	3/16	.141	.110
#6	100	M3.5	0.3	2	11/16	3/16	.141	.110
#8	100	M4	0.3	2-1/8	3/4	1/4	.168	.131
#10	100	M4.5, M5	0.3	2-3/8	7/8	1/4	.194	.152
#12	100	M5.5	0.3	2-3/8	15/16	9/32	.220	.165
1/4	80	M6	0.3	2-1/2	1	5/16	.255	.191
5/16	80	M7, M8	0.3	2-23/32	1-1/8	3/8	.318	.238
3/8	80	M9, M10	0.3	2-15/16	1-1/4	7/16	.381	.286
7/16	80	M11	0.3	3-5/32	1-7/16	13/32	.323	.242
1/2	80	M12	0.3	3-3/8	1-21/32	7/16	.367	.275
9/16	64	M14	0.4	3-19/32	1-21/32	1/2	.429	.322
5/8	64	M16	0.4	3-13/16	1-13/16	9/16	.480	.360
11/16	64	M18	0.4	4-1/32	1-13/16	5/8	.542	.406
3/4	64	—	—	4-1/4	2	11/16	.590	.442
13/16	64	M20	0.4	4-15/32	2	11/16	.652	.489
7/8	64	M22	0.4	4-11/16	2-7/32	3/4	.697	.523
15/16	64	M24	0.4	4-29/32	2-7/32	3/4	.760	.570
1"	64	M25	0.4	5-1/8	2-1/2	13/16	.800	.600

Dimensions as shown in Table 302 on page 43.

SPECIAL TAPS FROM BLANKS

SPECIAL MET-FLO COLD FORMING TAPS

From Blanks HSSE 302A

Right and left taps available. Special Gages available. Call for pricing.

Size (Inches)	Max. Thread per Inch	Size (mm)	Min. Pitch (mm)	Overall Length	Thread Length	Neck Length	Square Length	Shank Diameter	Size of Square
#2	100	M2, M2.2	0.091	1-3/4	5/16	.25	3/16	.141	.110
#3	100	M2.3, M2.5, M2.6	0.3	1-13/16	5/16	.25	3/16	.141	.110
#4	100	—	—	1-7/8	5/16	.25	3/16	.141	.110
#5	100	M3	0.3	1-15/16	5/16	.25	3/16	.141	.110
#6	100	M3.5	0.3	2	3/8	.31	3/16	.141	.110
#8	100	M4	0.3	2-1/8	3/8	.38	1/4	.168	.131
#10	100	M4.5, M5	0.3	2-3/8	1/2	.38	1/4	.194	.152
#12	100	M5.5	0.3	2-3/8	1/2	.38	9/32	.220	.165
1/4	80	M6	0.3	2-1/2	5/8	.38	5/16	.255	.191
5/16	80	M7, M8	0.3	2-23/32	11/16	.44	3/8	.318	.238
3/8	80	M9, M10	0.3	2-15/16	3/4	.50	7/16	.381	.286
7/16	80	M11	0.3	3-5/32	7/8	-	13/32	.323	.242
1/2	80	M12	0.3	3-3/8	15/16	-	7/16	.367	.275
9/16	64	M14	0.4	3-19/32	1	-	1/2	.429	.322
5/8	64	M16	0.4	3-13/16	1-3/32	-	9/16	.480	.360
11/16	64	M18	0.4	4-1/32	1-3/32	-	5/8	.542	.406
3/4	64	—	—	4-1/4	1-7/32	-	11/16	.590	.442
13/16	64	M20	0.4	4-15/32	1-7/32	-	11/16	.652	.489
7/8	64	M22	0.4	4-11/16	1-11/32	-	3/4	.697	.523
15/16	64	M24	0.4	4-29/32	1-11/32	-	3/4	.760	.570
1"	64	M25	0.4	5-1/8	1-1/2	-	13/16	.800	.600

SPECIAL MET-FLO COLD FORMING TAPS

From Blanks PMX 302A

Size (Inches)	Max. Thread per Inch	Size (mm)	Min. Pitch (mm)	Overall Length	Thread Length	Neck Length	Square Length	Shank Diameter	Size of Square
#2	100	M2, M2.2	0.091	1-3/4	5/16	.25	3/16	.141	.110
#3	100	M2.3, M2.5, M2.6	0.3	1-13/16	5/16	.25	3/16	.141	.110
#4	100	—	—	1-7/8	5/16	.25	3/16	.141	.110
#5	100	M3	0.3	1-15/16	5/16	.25	3/16	.141	.110
#6	100	M3.5	0.3	2	3/8	.31	3/16	.141	.110
#8	100	M4	0.3	2-1/8	3/8	.38	1/4	.168	.131
#10	100	M4.5, M5	0.3	2-3/8	1/2	.38	1/4	.194	.152
#12	100	M5.5	0.3	2-3/8	1/2	.38	9/32	.220	.165
1/4	80	M6	0.3	2-1/2	5/8	.38	5/16	.255	.191
5/16	80	M7, M8	0.3	2-23/32	11/16	.44	3/8	.318	.238
3/8	80	M9, M10	0.3	2-15/16	3/4	.50	7/16	.381	.286
7/16	80	M11	0.3	3-5/32	7/8	-	13/32	.323	.242
1/2	80	M12	0.3	3-3/8	15/16	-	7/16	.367	.275
9/16	64	M14	0.4	3-19/32	1	-	1/2	.429	.322
5/8	64	M16	0.4	3-13/16	1-3/32	-	9/16	.480	.360
11/16	64	M18	0.4	4-1/32	1-3/32	-	5/8	.542	.406
3/4	64	—	—	4-1/4	1-7/32	-	11/16	.590	.442
13/16	64	M20	0.4	4-15/32	1-7/32	-	11/16	.652	.489
7/8	64	M22	0.4	4-11/16	1-11/32	-	3/4	.697	.523
15/16	64	M24	0.4	4-29/32	1-11/32	-	3/4	.760	.570
1"	64	M25	0.4	5-1/8	1-1/2	-	13/16	.800	.600

Dimensions as shown in Table 302A on page 45.

SPECIAL TAPS FROM BLANKS



Call for availability.

SPECIAL PIPE TAPS

From Blanks

Available with special projections, right hand and left hand, tapered or straight threads. For interrupted threads add 15%.



Size	Standard Projection	Minimum Projection	Pipe Tap Drill Size		Overall Length	Thread Length	Square Length	Shank Diameter	Size of Square
			NPT	NPS					
1/16-27	.312	Flush ("0" Proj)	D	1/4	2-1/8	11/16	3/8	.3125	.234
1/8-27	.312	Flush ("0" Proj)	Q	11/32	2-1/8	3/4	3/8	.4375	.328
1/4-18	.459	.218	7/16	7/16	2-7/16	1-1/16	7/16	.5625	.421
3/8-18	.454	.150	9/16	37/64	2-9/16	1-1/16	1/2	.7000	.531
1/2-14	.579	.260	45/64	23/32	3-1/8	1-3/8	5/8	.6875	.515
3/4-14	.565	.245	29/32	59/64	3-1/4	1-3/8	11/16	.9063	.679
1"-11-1/2	.678	.275	1-9/64	1-5/32	3-3/4	1-3/4	13/16	1.1250	.843
1-1/4-11-1/2	.686	.285	1-31/64	1-1/2	4	1-3/4	15/16	1.3125	.984
1-1/2-11-1/2	.699	.300	1-47/64	1-3/4	4-1/4	1-3/4	1	1.5000	1.125
2"-11-1/2	.667	.267	2-13/16	2-7/32	4-1/2	1-3/4	1-1/8	1.8750	1.406
2-1/2-8	.925	.525	2-5/8	2-21/32	5-1/2	2-9/16	1-1/4	2.2500	1.687
3"-8	.925	.525	3-1/4	3-1/4	6	2-5/8	1-3/8	2.6250	1.968
3-1/2-8	.938	.525	3-3/4	-	6-1/2	2-11/16	1-1/2	2.8125	2.108
4"-8	.950	.525	4-1/4	4-1/4	6-3/4	2-3/4	1-5/8	3.0000	2.250

Dimensions as shown in Table 311 on page 46. For interrupted threads, add 15%.

SPECIAL EXTENSION PIPE TAPS

From Blanks

Size	Standard Projection	Minimum Projection	Overall Length (Inches)	Pipe Tap Drill Size		Thread Length	Square Length	Shank Diameter	Size of Square
				NPT	NPS				
1/8-27	.312	Flush ("0" Proj)	4	Q	11/32	3/4	3/8	.4375	.328
1/4-18	.459	.218	4	7/16	7/16	1-1/16	7/16	.5625	.421
1/8-27	.312	Flush ("0" Proj)	6	Q	11/32	3/4	3/8	.4375	.328
1/4-18	.459	.218	6	7/16	7/16	1-1/16	7/16	.5625	.421
3/8-18	.454	.150	6	9/16	37/64	1-1/16	1/2	.7000	.531
1/2-14	.579	.260	6	45/64	23/32	1-3/8	5/8	.6875	.515
3/4-14	.565	.245	6	29/32	59/64	1-3/8	11/16	.9063	.679
1"-11-1/2	.678	.275	6	1-9/64	1-5/32	1-3/4	13/16	1.1250	.843
1/8-27	.312	Flush ("0" Proj)	8	Q	11/32	3/4	3/8	.4375	.328
1/4-18	.459	.218	8	7/16	7/16	1-1/16	7/16	.5625	.421
3/8-18	.454	.150	8	9/16	37/64	1-1/16	1/2	.7000	.531
1/2-14	.579	.260	8	45/64	23/32	1-3/8	5/8	.6875	.515
3/4-14	.565	.245	8	29/32	59/64	1-3/8	11/16	.9063	.679
1/8-27	.312	Flush ("0" Proj)	10	Q	11/32	3/4	3/8	.4375	.328
1/4-18	.459	.218	10	7/16	7/16	1-1/16	7/16	.5625	.421
3/8-18	.454	.150	10	9/16	37/64	1-1/16	1/2	.7000	.531
1/2-14	.579	.260	10	45/64	23/32	1-3/8	5/8	.6875	.515
3/4-14	.565	.245	10	29/32	59/64	1-3/8	11/16	.9063	.679
1"-11-1/2	.678	.275	10	1-9/64	1-5/32	1-3/4	13/16	1.1250	.843
1/8-27	.312	Flush ("0" Proj)	12	Q	11/32	3/4	3/8	.4375	.328
1/4-18	.459	.218	12	7/16	7/16	1-1/16	7/16	.5625	.421

For interrupted threads, add 15%.

SPECIAL TAPS FROM BLANKS

SPECIAL ACME TANDEM & ACME PLUS LENGTH TAPS *From Blanks*

Right and left taps available. Special Gages available. Call for pricing.



Threads of these types are widely used for producing traversing motions on machine tools and are also extensively employed in the manufacture of valves, jacks and other mechanisms.

Longer length Acmes for the tough jobs.

Size	Overall Length	Length Thread End	Round Shank		Square	
			Length	Diameter	Length	Across Flats
1/4	3	1-3/4	1	.168	1/4	.131
5/16	3-13/32	1-7/8	1-1/4	.220	9/32	.165
3/8	4-1/16	2-1/8	1-5/8	.255	5/16	.191
1/2	5	2-9/16	2	.367	7/16	.275
5/8	6-1/4	3-3/16	2-1/2	.480	9/16	.360
3/4	7-15/16	4-5/16	3	.542	5/8	.406
7/8	8-5/8	4-3/8	2-1/2	.697	3/4	.523
1"	10-1/8	5-1/4	4	.697	7/8	.523
1-1/8	10-3/4	5-1/4	4-1/2	.800	1	.600
1-1/4	11-1/8	5-1/4	4-3/4	.896	1-1/8	.672
1-3/8	12-1/4	5-7/8	5-1/8	1.108	1-1/4	.831
1-1/2	12-5/8	5-7/8	5-1/2	1.233	1-1/4	.925
1-3/4	13-3/8	5-7/8	6-1/4	1.430	1-1/4	1.072
2"	14-7/8	6-1/2	7	1.644	1-3/8	1.233

3-day shipment.

SPECIAL ACME HAND TAPS *From Blanks*

Size	Max. Thread per Inch	Max. Decimal Size	Metric		Overall Length	Thread Length	Square Length	Shank Diameter	Size of Square
			Size (mm)	Min. Pitch (mm)					
1/2	80	.510	M12	0.3	3-3/8	1-21/32	7/16	.367	.275
5/8	64	.635	M16	0.4	3-13/16	1-13/16	9/16	.480	.360
3/4	64	.760	-	-	4-1/4	2	11/16	.590	.442
7/8	64	.885	M22	0.4	4-11/16	2-7/32	3/4	.697	.523
1"	64	1.010	M25	0.4	5-1/8	2-1/2	13/16	.800	.600
1-1/8	13	-	-	-	5-7/16	2-9/16	7/8	.896	.672
1-1/4	13	-	-	-	5-3/4	2-9/16	1	1.021	.766
1-3/8	13	-	-	-	6-1/16	3	1-1/16	1.108	.831
1-1/2	13	-	M38	2.0	6-3/8	3	1-1/8	1.233	.925

Dimensions as shown in Table 302 on page 43. 3-day shipment.

How to Order Special Acmes

Be prepared with this information:

- Nominal size
- Threads per inch
- Right hand or left hand thread
- Class of fit (if not to commercial standards)
- Tapping depth
- Material to be tapped
- Diameter of the hole before tapping
- Will tap be backed out of hole?
- Type of tapping machine used
- Are taps to be used for sizing only of rough chased threads?
- Will fixture used affect length of tap?

SPECIAL TAPS FROM BLANKS

SUPERTUF HSSE SPIRAL POINT TAPS

From Blanks

Size	Max. Thread per Inch	Max. Decimal Size	Metric		Overall Length	Thread Length	Neck Length	Square Length	Shank Diameter	Size of Square
			Size (mm)	Min. Pitch (mm)						
#4	100	.117	-	-	1-7/8	5/16	.25	3/16	.141	.110
#6	100	.145	M3.5	0.3	2	3/8	.31	3/16	.141	.110
#8	100	.171	M4	0.3	2-1/8	3/8	.38	1/4	.168	.131
#10	100	.197	M4.5, M5	0.3	2-3/8	1/2	.38	1/4	.194	.152
1/4	80	.260	-	-	2-1/2	5/8	.38	5/16	.255	.191
5/16	80	.323	M7, M8	0.3	2-23/32	11/16	.44	3/8	.318	.238
3/8	80	.385	M9, M10	0.3	2-15/16	3/4	.50	7/16	.381	.286
7/16	80	.448	M11	0.3	3-5/32	7/8	-	13/32	.323	.242
1/2	80	.510	M12	0.3	3-3/8	15/16	-	7/16	.367	.275
5/8	64	.635	M16	0.4	3-13/16	1-3/32	-	9/16	.480	.360
3/4	64	.760	-	-	4-1/4	1-7/32	-	11/16	.590	.442
1"	64	1.010	M25	0.4	5-1/8	1-1/2	-	3/4	.800	.600

Dimensions as shown in Table 302A on page 45. 10-day shipment of all quantities.

SUPERTUF HSSE SPIRAL FLUTE TAPS

From Blanks

Size	Max. Thread per Inch	Max. Decimal Size	Metric		Overall Length	Thread Length	Neck Length	Square Length	Shank Diameter	Size of Square
			Size (mm)	Min. Pitch (mm)						
#4	100	.117	-	-	1-7/8	5/16	.25	3/16	.141	.110
#6	100	.145	M3.5	0.3	2	3/8	.31	3/16	.141	.110
#8	100	.171	M4	0.3	2-1/8	3/8	.38	1/4	.168	.131
#10	100	.197	M4.5, M5	0.3	2-3/8	1/2	.38	1/4	.194	.152
1/4	80	.260	-	-	2-1/2	5/8	.38	5/16	.255	.191
5/16	80	.323	M7, M8	0.3	2-23/32	11/16	.44	3/8	.318	.238
3/8	80	.385	M9, M10	0.3	2-15/16	3/4	.50	7/16	.381	.286
7/16	80	.448	M11	0.3	3-5/32	7/8	-	13/32	.323	.242
1/2	80	.510	M12	0.3	3-3/8	15/16	-	7/16	.367	.275
5/8	64	.635	M16	0.4	3-13/16	1-3/32	-	9/16	.480	.360
3/4	64	.760	-	-	4-1/4	1-7/32	-	11/16	.590	.442
1"	64	1.010	M25	0.4	5-1/8	1-1/2	-	3/4	.800	.600

Dimensions as shown in Table 302A on page 45. 10-day shipment of all quantities.

SPECIAL TAPS FROM BLANKS

SUPERTUF PMX SPIRAL POINT SPECIAL TAPS

From Blanks

Size	Max. Thread per Inch	Max. Decimal Size	Metric		Overall Length	Thread Length	Neck Length	Square Length	Shank Diameter	Size of Square
			Size (mm)	Min. Pitch (mm)						
#4	100	.117	-	-	1-7/8	5/16	.25	3/16	.141	.110
#6	100	.145	M3.5	0.3	2	3/8	.31	3/16	.141	.110
#8	100	.171	M4	0.3	2-1/8	3/8	.38	1/4	.168	.131
#10	100	.197	M4.5, M5	0.3	2-3/8	1/2	.38	1/4	.194	.152
1/4	80	.260	-	-	2-1/2	5/8	.38	5/16	.255	.191
5/16	80	.323	M7, M8	0.3	2-23/32	11/16	.44	3/8	.318	.238
3/8	80	.385	M9, M10	0.3	2-15/16	3/4	.50	7/16	.381	.286
7/16	80	.448	M11	0.3	3-5/32	7/8	-	13/32	.323	.242
1/2	80	.510	M12	0.3	3-3/8	15/16	-	7/16	.367	.275
5/8	64	.635	M16	0.4	3-13/16	1-3/32	-	9/16	.480	.360
3/4	64	.760	-	-	4-1/4	1-7/32	-	11/16	.590	.442
1"	64	1.010	M25	0.4	5-1/8	1-1/2	-	3/4	.800	.600

Dimensions as shown in Table 302A on page 45. 10-day shipment of all quantities.

SUPERTUF PMX SPIRAL FLUTE SPECIAL TAPS

From Blanks

Size	Max. Thread per Inch	Max. Decimal Size	Metric		Overall Length	Thread Length	Neck Length	Square Length	Shank Diameter	Size of Square
			Size (mm)	Min. Pitch (mm)						
#4	100	.117	-	-	1-7/8	5/16	.25	3/16	.141	.110
#6	100	.145	M3.5	0.3	2	3/8	.31	3/16	.141	.110
#8	100	.171	M4	0.3	2-1/8	3/8	.38	1/4	.168	.131
#10	100	.197	M4.5, M5	0.3	2-3/8	1/2	.38	1/4	.194	.152
1/4	80	.260	-	-	2-1/2	5/8	.38	5/16	.255	.191
5/16	80	.323	M7, M8	0.3	2-23/32	11/16	.44	3/8	.318	.238
3/8	80	.385	M9, M10	0.3	2-15/16	3/4	.50	7/16	.381	.286
7/16	80	.448	M11	0.3	3-5/32	7/8	-	13/32	.323	.242
1/2	80	.510	M12	0.3	3-3/8	15/16	-	7/16	.367	.275
5/8	64	.635	M16	0.4	3-13/16	1-3/32	-	9/16	.480	.360
3/4	64	.760	-	-	4-1/4	1-7/32	-	11/16	.590	.442
1"	64	1.010	M25	0.4	5-1/8	1-1/2	-	3/4	.800	.600

Dimensions as shown in Table 302A on page 45. 10-day shipment of all quantities.

SPECIAL TAPS FROM BLANKS

SUPERTUF HSSE DIN/ANSI SPIRAL POINT TAPS

From Blanks

Size	Max. Thread per Inch	Max. Decimal Size	Metric		Overall Length	Thread Length	Neck Length	Square Length	Shank Diameter	Size of Square
			Size (mm)	Min. Pitch (mm)						
#4	100	.117	-	-	2-7/32	5/16	.25	3/16	.141	.110
#6	100	.145	M3.5	0.3	2-7/32	3/8	.31	3/16	.141	.110
#8	100	.171	M4	0.3	2-1/2	3/8	.38	1/4	.168	.131
#10	100	.197	M4.5, M5	0.3	2-3/4	1/2	.38	1/4	.194	.152
1/4	80	.260	-	-	3-5/32	5/8	.38	5/16	.255	.191
5/16	80	.323	M7, M8	0.3	3-35/64	11/16	.44	3/8	.318	.238
3/8	80	.385	M9, M10	0.3	3-15/16	3/4	.50	7/16	.381	.286
7/16	80	.448	M11	0.3	3-15/16	7/8	-	13/32	.323	.242
1/2	80	.510	M12	0.3	4-21/64	15/16	-	7/16	.367	.275
5/8	64	.635	M16	0.4	4-21/64	1-3/32	-	9/16	.480	.360
3/4	64	.760	-	-	5	1-7/32	-	11/16	.590	.442
1"	64	1.010	M25	0.4	6-19/64	1-1/2	-	3/4	.800	.600

10-day shipment of all quantities.

SUPERTUF HSSE DIN/ANSI SPIRAL FLUTE TAPS

From Blanks

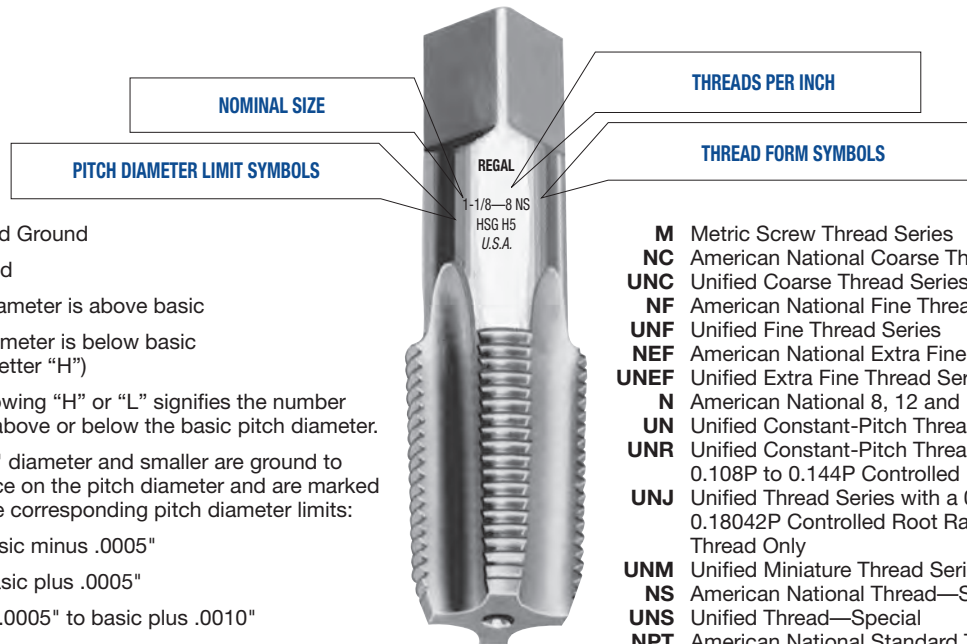
Size	Max. Thread per Inch	Max. Decimal Size	Metric		Overall Length	Thread Length	Neck Length	Square Length	Shank Diameter	Size of Square
			Size (mm)	Min. Pitch (mm)						
#4	100	.117	-	-	2-7/32	5/16	.25	3/16	.141	.110
#6	100	.145	M3.5	0.3	2-7/32	3/8	.31	3/16	.141	.110
#8	100	.171	M4	0.3	2-1/2	3/8	.38	1/4	.168	.131
#10	100	.197	M4.5, M5	0.3	2-3/4	1/2	.38	1/4	.194	.152
1/4	80	.260	-	-	3-5/32	5/8	.38	5/16	.255	.191
5/16	80	.323	M7, M8	0.3	3-35/64	11/16	.44	3/8	.318	.238
3/8	80	.385	M9, M10	0.3	3-15/16	3/4	.50	7/16	.381	.286
7/16	80	.448	M11	0.3	3-15/16	7/8	-	13/32	.323	.242
1/2	80	.510	M12	0.3	4-21/64	15/16	-	7/16	.367	.275
5/8	64	.635	M16	0.4	4-21/64	1-3/32	-	9/16	.480	.360
3/4	64	.760	-	-	5	1-7/32	-	11/16	.590	.442
1"	64	1.010	M25	0.4	6-19/64	1-1/2	-	3/4	.800	.600

10-day shipment of all quantities.

ENGINEERING DATA

STANDARD SYSTEM OF MARKING GROUND THREAD TAPS

Recognizing the importance of a standard system of marking, most tap manufacturers mark their product with the nominal size, number of threads per inch and the proper symbols to identify the thread form and the pitch diameter. Shown below are some of the symbols used.



HSG: High Speed Ground

G: Ground Thread

H: High; pitch diameter is above basic

L: Low; pitch diameter is below basic
(replaces the letter "H")

The number following "H" or "L" signifies the number of .0005" steps above or below the basic pitch diameter.

Standard taps 1" diameter and smaller are ground to a .0005" tolerance on the pitch diameter and are marked with one of these corresponding pitch diameter limits:

L1 = Basic to basic minus .0005"

H1 = Basic to basic plus .0005"

H2 = Basic plus .0005" to basic plus .0010"

H3 = Basic plus .0010" to basic plus .0015"

H4 = Basic plus .0015" to basic plus .0020"

H5 = Basic plus .0020" to basic plus .0025"

H6 = Basic plus .0025" to basic plus .0030"

Standard taps larger than 1" diameter are ground to a .0010" tolerance on the pitch diameter and are marked with this pitch diameter limit:

H4 = Basic plus .0010" to basic .0020"

SPECIAL TAPS

This catalog has been developed to easily locate the diameter and number of threads for special taps and dies. If the tap you need is not listed call your nearest Regal manufacturing facility.

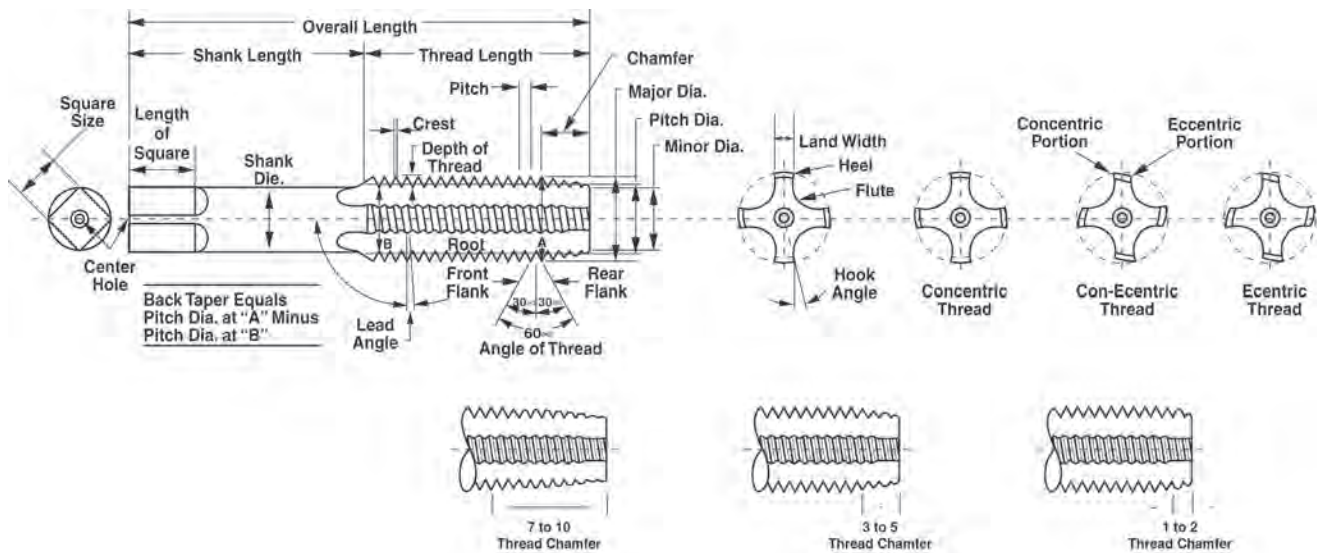
- All hand taps conform to Table 302 and the National Standards for overall length, shank diameter, squares and flute lengths.
- Thread tolerances conform to United States Cutting Tool Institute (USCTI) Standards.
- All pipe taps and extension pipe tap shank dimensions conform to USCTI standards.
- All stock Acme taps are 2G; for any variations, consult the nearest plant.
- All taps are straight flute unless otherwise specified in the "type" column.
- British pipe taps have 55° modified threads; full form threads available on request.
- Tools in larger quantities or special features not shown may be priced through your nearest Regal manufacturing facility.

- M** Metric Screw Thread Series
- NC** American National Coarse Thread Series
- UNC** Unified Coarse Thread Series
- NF** American National Fine Thread Series
- UNF** Unified Fine Thread Series
- NEF** American National Extra Fine Thread Series
- UNEF** Unified Extra Fine Thread Series
- N** American National 8, 12 and 16 Thread Series
- UN** Unified Constant-Pitch Thread Series
- UNR** Unified Constant-Pitch Thread Series with a 0.108P to 0.144P Controlled Root Radius
- UNJ** Unified Thread Series with a 0.15011P to 0.18042P Controlled Root Radius—External Thread Only
- UNM** Unified Miniature Thread Series
- NS** American National Thread—Special
- UNS** Unified Thread—Special
- NPT** American National Standard Taper Pipe Thread
- NPTF** Dryseal American National Standard Taper Pipe Thread (Fuel)
- PTF** Dryseal SAE Short Taper Pipe Thread
- ANPT** Aeronautical National Form Taper Pipe Thread (MIL-P-7105)
- NPS** For Tap Marking Only (see NPSC, NPSM)
- NPSC** American National Standard Straight Pipe Thread in Pipe Couplings (tap marked NPS)
- NPSF** Dryseal American National Standard Internal Straight Pipe Thread (Fuel)
- NPSH** American National Standard Straight Pipe Thread for Hose Couplings and Nipples
- NPSI** Dryseal American National Standard Intermediate Internal Straight Pipe Thread
- NPSL** American National Standard Straight Pipe Thread for Loose Fitting Mechanical Joints with Locknuts
- NPSM** American National Standard Straight Pipe Thread for Free Fitting Mechanical Joints for Fixtures (tap marked NPS)
- NPTR** American National Standard Taper Pipe Thread for Railing Joints (tap marked NPT)
- NGO** National Gas Outlet Thread
- NH** American National Hose Coupling and Fire Hose Coupling Threads
- AMO** American Standard Microscope Objective Thread
- ACME C** Acme Thread—Centralizing
- ACME G** Acme Thread—General Purpose
- N BUTT** American Buttress Screw Thread
- STI** Special Threads for Helical Coil Wire Screw Thread Inserts

Symbols used for British Threads are:

- BSW** British Standard Whitworth Coarse Thread Series
- BSF** British Standard Fine Thread Series
- BSP (BSP.TR)** British Standard Taper Pipe Thread
- BSPP (BSP.PL)** British Standard Pipe (Parallel) Thread
- WHIT** Whitworth Standard Special Thread
- BA** British Association Standard Thread

TAP TERMINOLOGY



Angle of Thread – The angle included between the flanks of the thread measured in an axial plane.

Back Taper – A slight axial relief of the tap which makes the pitch diameter of the thread near the shank somewhat smaller than that of the chamfered end.

Basic – The theoretical or nominal standard size from which all variations are made.

Chamfer – The tapering of the threads at the front end of each land of a tap by cutting away and relieving the crest of the first few teeth to distribute the cutting action over several teeth. When the tapering amounts to 7 to 10 threads, the tap is called a “taper” tap; 3 to 5 threads, a “plug” tap; and 1 to 2 threads, a “bottoming” tap.

Chamfer Relief – The gradual decrease in land height from cutting edge to heel on the chamfered portion. Provides clearance for the cutting action as the tap advances.

Crest – The top surface joining the two flanks of a thread. The crest of an external thread is at its major diameter, while the crest of an internal thread is at its minor diameter.

Cutting Face – The leading side of the land in the direction of rotation for cutting on which the chip impinges.

Dryseal – A pipe threaded fuel connection for both external and internal application designed for use where the assembled product must withstand high fluid or gas pressures without the use of a sealing compound, or where a sealer is functionally objectionable.

Flutes – The longitudinal channels formed in a tap to create cutting edges on the thread profile and to provide chip spaces and cutting fluid passages.

Height of Thread – The distance between the crest and the base of a thread measured normal to the axis.

Helical Flute – A flute with uniform axial lead and constant helix in a helical path around the axis of a cylindrical tap.

Hook Face – A concave cutting face, usually specified either as chordal hook or tangential hook.

Chordal Hook Angle – The angle between the chord passing through the root and crest of a thread form at the cutting face and a radial line through the crest at the cutting edge.

Tangential Hook Angle – The angle between a line tangent to a hook cutting face at the cutting edge and a radial line to the same point.

Interrupted Thread – A tap having an odd number of lands, with every other tooth along the thread helix removed.

Lead – The distance a screw thread advances axially in one complete turn. On a single lead screw or tap, the lead and pitch are identical. On a double lead screw or tap, the lead is twice the pitch, etc.

Threads Per Inch – The number of threads in one inch of length.

Pitch – The distance from any point on a screw or tap thread to a corresponding point on the next thread, measured parallel to the axis. The pitch equals one divided by the number of threads per inch.

Pitch Diameter – On a straight thread, the diameter of an imaginary coaxial cylinder, the surface of which would pass through the thread profile at such points as to make equal the width of the threads and the width of the spaces cut by the surface of the cylinder.

On a taper thread, the diameter at a given distance from a reference plane perpendicular to the axis of an imaginary coaxial cone, the surface of which would pass through the thread profile at such points as to make equal the width of the threads and the width of the spaces cut by the surface of the cone.

Rake – Any deviation of a straight cutting face of the tooth from a radial line. Positive rake means that the crest of the cutting face is angularly advanced ahead of the balance of the face of the tooth. Negative rake means that the same point is angularly behind the balance of the cutting face of the tooth. Zero rake means that the cutting face is directly on the center line.

Root – The bottom surface joining the flanks of two adjacent threads. The root of an external thread is at its minor diameter, while the root of an internal thread is at its major diameter.

Spiral Point (Chip Driver) – A supplementary angular fluting cut in the cutting face of the land at the chamfer end. It is slightly longer than the chamfer on the tap and of the opposite hand to that of rotation.

Thread Relief – The clearance produced by removal of metal from behind the cutting edge. When the thread angle is relieved from the heel to cutting edge, the tap is said to have “eccentric” relief. If relieved from the heel for only a portion of land width, the tap is said to have “con-eccentric” relief.

ENGINEERING DATA

GROUND THREAD TAP LIMITS

In addition to the nominal size and pitch of a tap, there is another important dimensional factor to be considered in selecting a ground thread tap for a given job. This is the matter of the H and L pitch diameter tap limits. H (HIGH) means high above basic pitch diameter, and L (LOW) means below basic pitch diameter. Tap limits have been established to provide a choice in the selection of the tap size best suited to produce the class of thread desired.

Figure 1 illustrates the numbering system and the .0005" diameter increment separation between successive limits. Since the starting point is basic pitch diameter, dividing the limit number by two establishes, in thousandths of an inch, the amount the maximum tap diameter is above the basic in the H series. It also shows the amount the minimum tap pitch diameter is under basic in the L series.

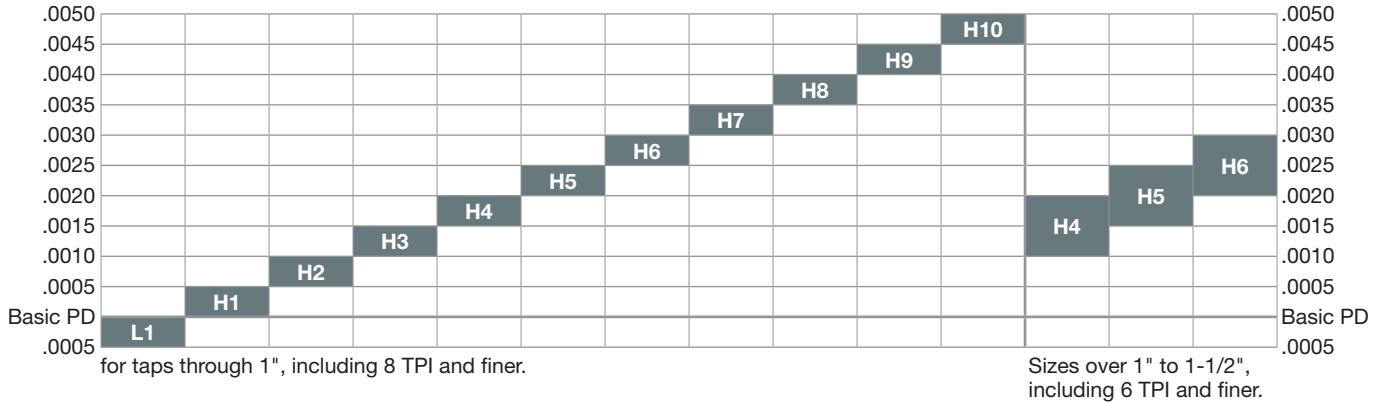
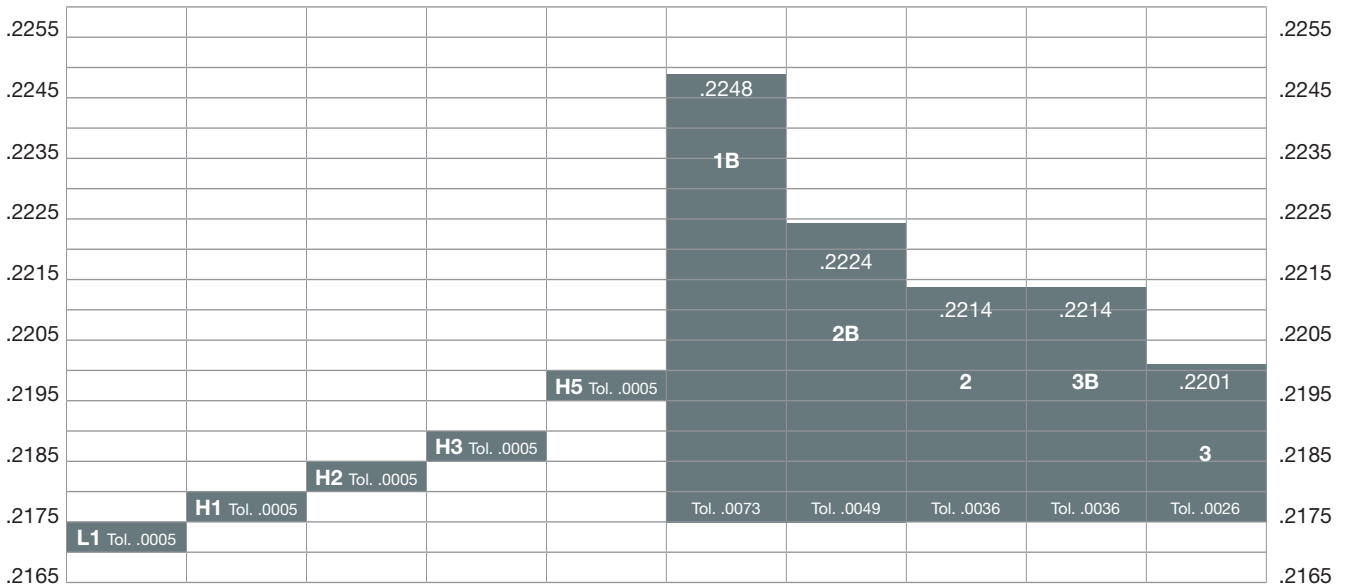


Figure 1

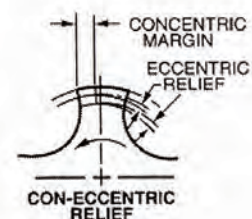
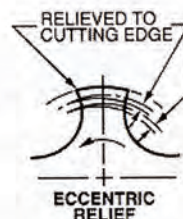
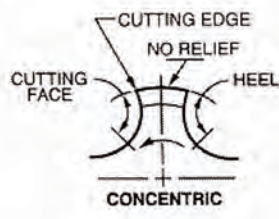
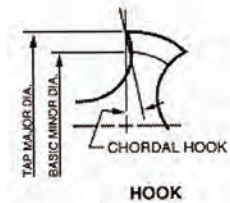
Figure 2 illustrates the positioning of the tap limits in relation to the various classes of threads for a 1/4 to 20 size.



ENGINEERING DATA

MATERIAL HOOK/RAKE ANGLE

Material	Hook or Rake Angle	Treatment Suggestion
Aluminum (Wrought)	11° - 15° Hook	Chrome, TiCN
Aluminum (wWe Casting)	8° - 10° Rake	TiCN, CrN
Aluminum Bronze	0° - 3° Rake	Nitride, TiCN
Duralumin	12° - 14° Hook	TiAlN+WC/C, CrN
Brass	0° - 3° Rake	Bright, TiCN
Cast Brass	2° - 5° Rake	Nitride, TiCN
Naval Brass	0° - 3° Rake	Nitride
Bronze (Free Machining)	2° - 6° Hook	Bright, TiCN, Nitride
Manganese Bronze	0° - 3° Rake	Nitride, TiCN
Naval Bronze	2° - 6° Hook	Bright, TiCN
Silicon Bronze	0° - 3° Rake	Nitride, TiCN
Tungsten	5° - 10° Rake	Tin
Cast Iron (Gray)	0° - 3° Rake	Nitride, TiCN
Ductile Iron	3° - 6° Hook	Nitride Oxide, Tin, TiCN
Malleable Iron	3° Rake	Nitride Oxide, Tin, TiCN
Ferro-tic	0° - 3° Negative Rake	Bright
Copper (Pure)	18° Hook	TiAlN+WC/C, CrN, N+O
Beryllium Copper	12° - 14° Hook	TiAlN+WC/C, CrN, Nitride
Copper-Nickel	12° Hook	Nitride, TiCN
Magnesium	18° - 20° Hook	CrN
Monel (Steel Casting)	12° - 15° Hook	Nitride, TiCN, CrN
Nitralloy	0° Rake	Nitride, TiCN
Nylon	5° - 8° Hook	Nitride, Tin
Plastic (Thermoplastic)	5° - 8° Hook	Nitride, Tin
Plastic (Thermosetting)	0° - 3° Rake	TiCN
Fiberglass	0° - 3° Rake	TiCN
Carbon Steel	10° - 12° Hook	Oxide, Nitride, Tin
Cold Rolled Steel	10° - 12° Hook	Oxide, Nitride, Tin
Forged Steel	10° - 12° Hook	Oxide, Nitride, Tin
Leaded Steel	8° - 12° Hook	Oxide, Nitride, Tin
Stainless Steel (Free Machining)	4° - 8° Hook	Nitride, Tin, TiCN
Stainless Steel (Prec Hardening)	5° - 8° Rake	Nitride, Tin, TiCN
Tool Steel	0° - 3° Rake	Nitride, Tin, TiCN
Powdered Metal (Sintered)	0° Rake	TiCN
Titanium	15° - 20° Hook	Oxide, Nitride, CrN
Inconel (600)	12° - 15° Hook	Nitride + Oxide, CrN
Inconel (718)	5° - 10° Hook	Nitride + Oxide, CrN
Inconel (925)	3° - 5° Rake	Alcrona
Hastaloy B	12° - 15° Hook	CrN
Hastaloy C	5° - 10° Hook	CrN



ENGINEERING DATA

TAP DRILL FORMULAS

Tap Drill Sizes - Cutting Taps

$$\text{Drilled Hole Size (inches)} = \text{Basic Major Dia. of Thread (inches)} - \frac{.013 \times \% \text{ of Full Thread}}{\text{No. of Threads per Inch}}$$

$$\text{Drilled Hole Size (mm)} = \text{Basic Major Dia. of Thread (mm)} - \frac{\% \text{ of Full Thread} \times \text{mm Pitch}}{76.98}$$

Note: Enter % of full thread in percent form (75% = 75, not 0.75)

Tap Drill Sizes - Thread Forming Taps

$$\text{Drilled Hole Size (inches)} = \text{Basic Major Dia. of Thread (inches)} - \frac{.0068 \times \% \text{ of Full Thread}}{\text{No. of Threads per Inch}}$$

$$\text{Drilled Hole Size (mm)} = \text{Basic Major Dia. of Thread (mm)} - \frac{\% \text{ of Full Thread} \times \text{mm Pitch}}{147.06}$$

Acme Tap Drill Size Formulas

Class of Fit 2G, 3G, 4G

$$\begin{aligned} \text{Min. Hole Size} &= \text{Nominal O.D.} - \text{Pitch} \\ \text{Max. Hole Size} &= \text{Min. Hole Size} + (.05 \times \text{Pitch}) \end{aligned}$$

Class of Fit 2C, 3C, 4C

$$\begin{aligned} \text{Min. Hole Size} &= \text{Nominal O.D.} - \text{Pitch} + (.1 \times \text{Pitch}) \\ \text{Max. Hole Size} &= \text{Min. Hole Size} + (.05 \times \text{Pitch}) \end{aligned}$$

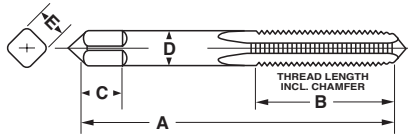
$$\text{Note: Pitch} = \frac{1}{\text{No. Threads per Inch}}$$

$$\text{RPM} = \frac{\text{SFM}}{.26 \times \text{Tap O.D.}}$$

To use this formula for metric, convert metric size to inch equivalent by multiplying metric dimension by .03937.

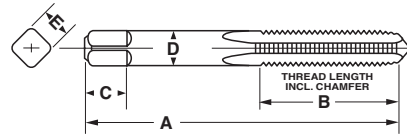
ENGINEERING DATA

STANDARD TAP DIMENSIONS Table 302 - Up to 1" Diameter



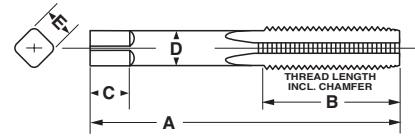
Size #0-12 Machine Screw
Sizes 1.6-6.3mm

STYLE-1



Size #14 Machine Screw
Sizes 7-10mm

STYLE-2



Sizes larger than 3/8"
Sizes 12mm and larger

STYLE-3

Nominal Diameter Range - Inches		Mach. Screw Size Number	Nominal Fractional Diameter (Inches)	Nominal Metric Diameter (Millimeters)	Style*	Tap Dimensions - Inches				
Over	To (Incl.)					A Overall Length	B Thread Length	C Square Length	D Shank Diameter	E Size of Square
.052	.065	0	1/16	M1.6	1	1-5/8	5/16	3/16	.141	.110
.065	.078	1	—	M1.8	1	1-11/16	3/8	3/16	.141	.110
.078	.091	2	—	M2, M2.2	1	1-3/4	7/16	3/16	.141	.110
.091	.104	3	3/32	M2.5	1	1-13/16	1/2	3/16	.141	.110
.104	.117	4	—	—	1	1-7/8	9/16	3/16	.141	.110
.117	.130	5	1/8	M3, M3.15	1	1-15/16	5/8	3/16	.141	.110
.130	.145	6	—	M3.5	1	2	11/16	3/16	.141	.110
.145	.171	8	5/32	M4	1	2-1/8	3/4	1/4	.168	.131
.171	.197	10	3/16	M4.5, M5	1	2-3/8	7/8	1/4	.194	.152
.197	.223	12	7/32	—	1	2-3/8	15/16	9/32	.220	.165
.223	.260	14	1/4	M6, M6.3	2	2-1/2	1	5/16	.255	.191
.260	.323	—	5/16	M7, M8	2	2-23/32	1-1/8	3/8	.318	.238
.323	.395	—	3/8	M10	2	2-15/16	1-1/4	7/16	.381	.286
.395	.448	—	7/16	—	3	3-5/32	1-7/16	13/32	.323	.242
.448	.510	—	1/2	M12, M12.5	3	3-3/8	1-21/32	7/16	.367	.275
.510	.573	—	9/16	M14	3	3-19/32	1-21/32	1/2	.429	.322
.573	.635	—	5/8	M16	3	3-13/16	1-13/16	9/16	.480	.360
.635	.709	—	11/16	M18	3	4-1/32	1-13/16	5/8	.542	.406
.709	.760	—	3/4	—	3	4-1/4	2	11/16	.590	.442
.760	.823	—	13/16	M20	3	4-15/32	2	11/16	.652	.489
.823	.885	—	7/8	M22	3	4-11/16	2-7/32	3/4	.697	.523
.885	.948	—	15/16	M24	3	4-29/32	2-7/32	3/4	.760	.570
.948	1.010	—	1	M25	3	5-1/8	2-1/2	13/16	.800	.600
1.010	1.073	—	1-1/16	M27	3	5-1/8	2-1/2	7/8	.896	.672

* Styles shown are for ground thread taps.

Notes:

- 1) Special ground thread taps are made to limits shown in USCTI Table 331 for Unified Inch Screw Threads and USCTI Table 341 for Metric M-Profile Screw Threads.
- 2) Ground thread taps, sizes .395" and smaller, have external center on thread end (may be removed on bottoming taps).
- 3) For eccentricity tolerances of tap elements refer to Table 317, published by the United States Cutting Tool Institute.

ENGINEERING DATA

STANDARD TAP DIMENSIONS Table 302/303 - Over 1" Diameter

Nominal Diameter Range - Inches		Nominal Fractional Diameter (Inches)	Nominal Metric Diameter (Millimeters)	Style	Table 302 Long Length					Table 303 Short Length			
Over	To (Incl.)				D Shank Diameter	A Overall Length	B Thread Length	C Square Length	E Size of Square	A Overall Length	B Thread Length	C Square Length	E Size of Square
1.010	1.073	1-1/16	M27	3	.896	5-1/8	2-1/2	7/8	.672	4	1-1/2	7/8	.672
1.073	1.135	1-1/8		3	.896	5-7/16	2-9/16	7/8	.672	4	1-1/2	7/8	.672
1.135	1.198	1-3/16	M30	3	1.021	5-7/16	2-9/16	1	.766	4	1-1/2	1	.766
1.198	1.260	1-1/4		3	1.021	5-3/4	2-9/16	1	.766	4	1-1/2	1	.766
1.260	1.323	1-5/16	M33	3	1.108	5-3/4	2-9/16	1-1/16	.831	4	1-1/2	1	.831
1.323	1.385	1-3/8		3	1.108	6-1/16	3	1-1/16	.831	4	1-1/2	1	.831
1.385	1.448	1-7/16	M36	3	1.233	6-1/16	3	1-1/8	.925	4	1-1/2	1	.925
1.448	1.510	1-1/2		3	1.233	6-3/8	3	1-1/8	.925	4	1-1/2	1	.925
1.510	1.635	1-5/8	M39	3	1.305	6-11/16	3-3/16	1-1/8	.979	5	2	1-1/8	.979
1.635	1.760	1 3/4	M42	3	1.430	7	3-3/16	1-1/4	1.072	5	2	1-1/4	1.072
1.760	1.885	1-7/8		3	1.519	7-5/16	3-9/16	1-1/4	1.139	5	2	1-1/4	1.139
1.885	2.010	2	M48	3	1.644	7-5/8	3-9/16	1-3/8	1.233	5	2	1-3/8	1.233
2.010	2.135	2-1/8		3	1.769	8	3-9/16	1-3/8	1.327	5-1/4	2	1-3/8	1.327
2.135	2.260	2-1/4	M56	3	1.894	8-1/4	3-9/16	1-7/16	1.420	5-1/4	2	1-7/16	1.420
2.260	2.385	2-3/8		3	2.019	8-1/2	4	1-7/16	1.514	5-1/4	2	1-7/16	1.514
2.385	2.510	2-1/2		3	2.100	8-3/4	4	1-1/2	1.575	5-1/4	2	1-1/2	1.575
2.510	2.635	2-5/8	M64	3	2.225	8-3/4	4	1-1/2	1.669	5-1/2	2	1-1/2	1.575
2.635	2.760	2-3/4		3	2.350	9-1/4	4	1-9/16	1.762	5-1/2	2	1-1/2	1.575
2.760	2.885	2-7/8	M72	3	2.475	9-1/4	4	1	1.856	5-1/2	2	1-1/2	1.575
2.885	3.010	3		3	2.543	9-3/4	4-9/16	1-5/8	1.907	5-1/2	2	1-1/2	1.575
3.010	3.135	3-1/8		3	2.668	9-3/4	4-9/16	1-5/8	2.001	5-3/4	2	1-1/2	1.575
3.135	3.260	3-1/4	M80	3	2.793	10	4-9/16	1-3/4	2.095	5-3/4	2	1-1/2	1.575
3.260	3.385	3-3/8		3	2.883	10	4-9/16	1-3/4	2.162	5-3/4	2	1-1/2	1.575
3.385	3.510	3-1/2		3	3.008	10-1/4	4-15/16	2	2.256	5-3/4	2	1-1/2	1.575
3.510	3.635	3-5/8	M90	3	3.133	10-1/4	4-15/16	2	2.350	6	2	1-3/4	1.575
3.635	3.760	3-3/4		3	3.217	10-1/2	5-5/16	2-1/8	2.413	6	2	1-3/4	1.575
3.760	3.885	3-7/8		3	3.342	10-1/2	5-5/16	2-1/8	2.506	6	2	1-3/4	1.575
3.885	4.010	4	M100	3	3.467	10-3/4	5-5/16	2-1/4	2.600	6	2	1-3/4	1.575

Short length blanks, 2.385" diameter through 4.010", have a 2.100" shank diameter.

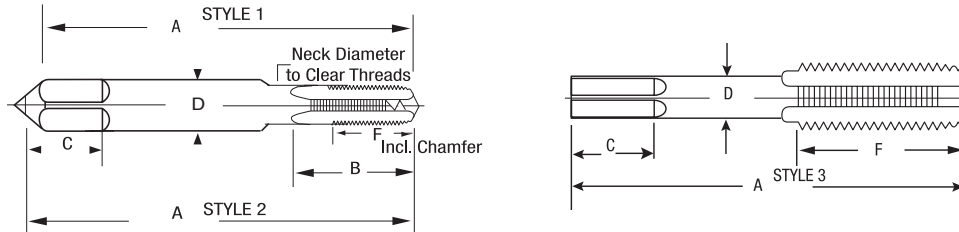
Note: Unless otherwise specified, special taps over 1.010" to 1.510" diameter inclusive, having 14 or more threads per inch or 1.75 millimeter pitch and finer, and sizes over 1.510" diameter with 10 or more threads per inch or 2.5 millimeter pitch and finer, are made to general dimensions, Table 303, United States Cutting Tool Institute (USCTI) standards.

STANDARD TAP DIMENSIONS Over 4" to 6" Diameter

Nominal Fractional Diameter (Inches)	Style	Long Length					Short Length				
		D Shank Diameter	A Overall Length	B Thread Length	C Square Length	E Size of Square	D Shank Diameter	A Overall Length	B Thread Length	C Square Length	E Size of Square
4-1/4	3	3.467	10-3/4	5-5/16	2-1/4	2.600	2.100	6	2	1-3/4	1.575
4-1/2	3	3.825	10-3/4	5-5/16	2-1/4	2.868	2.100	6	2	1-3/4	1.575
4-3/4	3	3.950	10-3/4	5-5/16	2-1/4	2.965	2.100	6	2	1-3/4	1.575
5	3	4.200	11-3/4	5-1/2	2-1/2	3.150	3.467	6-1/2	2-1/2	2	2.600
5-1/4	3	4.450	11-3/4	5-1/2	2-1/2	3.340	3.467	6-1/2	2-1/2	2	2.600
5-1/2	3	4.700	12	5-3/4	2-3/4	3.525	3.467	6-1/2	2-1/2	2	2.600
5-3/4	3	4.950	12	5-3/4	2-3/4	3.715	3.467	6-1/2	2-1/2	2	2.600
6	3	5.200	12-1/4	6	2-3/4	3.900	3.715	7	3	2	2.785

ENGINEERING DATA

SHORT THREAD LENGTH TAP DIMENSIONS Table 302A



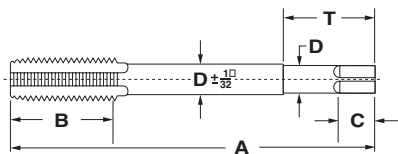
Nominal Diameter Range - Inches		Machine Screw Size Number	Nominal Fractional Diameter (Inches)	Nominal Metric Diameter (Millimeters)	Style	Tap Dimensions					
Over	To (Incl.)					A Overall Length	B* Length	C Square Length	D Shank Diameter	E Square Size	F** Thread Length
.104	.117	4	—	—	1	1-7/8	9/16	3/16	.141	.110	5/16
.117	.130	5	1/8	M3, M3.15	1	1-15/16	5/8	3/16	.141	.110	5/16
.130	.145	6	—	M3.5	1	2	11/16	3/16	.141	.110	3/8
.145	.171	8	5/32	M4	1	2-1/8	3/4	1/4	.168	.131	3/8
.171	.197	10	3/16	M4.5, M5	1	2-3/8	7/8	1/4	.194	.152	1/2
.197	.223	12	7/32	—	1	2-3/8	15/16	9/32	.220	.165	1/2
.223	.260	14	1/4	M6, M6.3	2	2-1/2	1	5/16	.255	.191	5/8
.260	.323		5/16	M7, M8	2	2-23/32	1-1/8	3/8	.318	.238	11/16
.323	.395		3/8	M10	2	2-15/16	1-1/4	7/16	.381	.286	3/4
.395	.448		7/16	—	3	3-5/32	*	13/32	.323	.242	7/8
.448	.510		1/2	M12, M12.5	3	3-3/8	*	7/16	.367	.275	15/16
.510	.573		9/16	M14	3	3-19/32	*	1/2	.429	.322	1
.573	.635		5/8	M16	3	3-13/16	*	9/16	.480	.360	1-3/32
.635	.709		11/16	M18	3	4-1/32	*	5/8	.542	.406	1-3/32
.709	.760		3/4	—	3	4-1/4	*	11/16	.590	.442	1-7/32
.760	.823		13/16	M20	3	4-15/32	*	11/16	.652	.489	1-7/32
.823	.885		7/8	M22	3	4-11/16	*	3/4	.697	.523	1-11/32
.885	.948		15/16	M24	3	4-29/32	*	3/4	.760	.570	1-11/32
.948	1.010		1	M25	3	5-1/8	*	13/16	.800	.600	1-1/2

* "B" based on Table 302, column B and shall be no less than minimum Table 302 thread length.

** "F" based on the length of 12 pitches of the UNC series.

Notes: 1) "F" is minimum value and has no tolerance. 2) Unless otherwise specified, all tolerances are in accordance with Table 302.

EXTENSION TAP DIMENSIONS Table 303A



The "T" length of the shank diameter of extension taps is ground to close tolerances, whereas the remaining portion of the shank has ordinary bar tolerances. In special applications where the shank is used with a bushing, the entire shank length may be ground to close tolerance upon request.

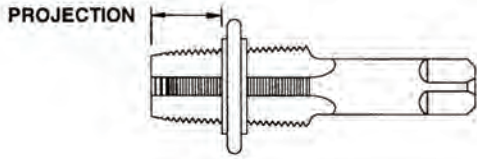
Size	B Thread Length	D Shank Diameter	C Square Length	Square Size	T Ground Shank Size
6	11/16	.141	3/16	.110	1-1/8
8	3/4	.168	1/4	.131	1-1/4
10	7/8	.194	1/4	.152	1-3/8
1/4	1	.255	5/16	.191	1-1/2
1/4*	1	.185	1/4	.138	1-1/2
5/16	1-1/8	.318	3/8	.238	1-9/16
5/16*	1-1/8	.240	9/32	.180	1-9/16
3/8	1-1/4	.381	7/16	.286	1-5/8
3/8*	1-1/4	.275	3/8	.206	1-5/8
7/16	1-7/16	.323	13/32	.242	1-11/16

Size	B Thread Length	D Shank Diameter	C Square Length	Square Size	T Ground Shank Size
1/2	1-21/32	.367	7/16	.275	1-11/16
9/16	1-21/32	.429	1/2	.322	1-7/8
5/8	1-13/16	.480	9/16	.360	2
3/4	2	.590	11/16	.442	2-1/4
7/8	2-7/32	.697	3/4	.523	2-1/2
1	2-1/2	.800	13/16	.600	2-5/8
1-1/8	2-9/16	.896	7/8	.672	2-3/4
1-1/4	2-9/16	1.021	1	.766	2-7/8
1-3/8	3	1.108	1-1/16	.831	3
1-1/2	3	1.233	1-1/8	.925	3

*Small shank

ENGINEERING DATA

TAPER PIPE TAP, THREAD LIMITS, GROUND THREAD



NPT - American National Standard Taper Pipe Threaded Form
 ANPT - Aeronautical National Standard Taper Pipe Threaded Form
 NPFT - Dryseal American National Standard Taper Pipe Threaded Form

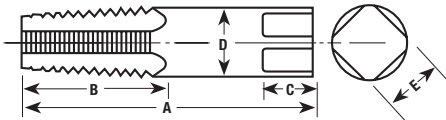
Nominal Size Inches	Threads Per Inch	Tap Thread Limits				Reference Dimensions	
		Projection* Inches	Projection Tolerances + or -	Taper Per Foot Limits		L1 Length	Tap Drill Size** NPT, ANPT, NPTF
				Minimum	Maximum		
1/16	27	.312	.063	.719	.781	.160	C
1/8	27	.312	.063	.719	.781	.1615	Q
1/4	18	.459	.063	.719	.781	.2278	7/18
3/8	18	.454	.063	.719	.781	.240	9/16
1/2	14	.579	.063	.719	.781	.320	45/64
3/4	14	.565	.063	.719	.781	.339	29/32
1	11-1/2	.678	.094	.719	.781	.400	1-9/64
1-1/4	11-1/2	.686	.094	.719	.781	.420	1-31/64
1-1/2	11-1/2	.699	.094	.719	.781	.420	1-23/32
2	11-1/2	.667	.094	.719	.781	.436	2-3/16
2-1/2	8	.925	.094	.734	.781	.682	2-39/64
3	8	.925	.094	.734	.781	.766	3-15/64
3-1/2	8	.938	.125	.734	.781	.821	—
4	8	.950	.125	.734	.781	.844	—

* Distance small end of tap projects through L1 Taper Thread Ring Gage.

** Recommended size given permits direct tapping without reaming the hole, but only give a full thread for approx. the L1 length.
 Lead Tolerance: A maximum lead deviation of plus or minus .0005" within any two threads not farther than 1" is permitted.

PIPE TAP DIMENSIONS Table 311

Straight and Taper



Nominal Size Inches	Standard Projection	Minimum Projection	Length Overall A	Length of Thread B	Length of Square C	Diameter of Shank D	Size of Square E
1/16	.312 ± .0625	Flush ("0" Proj.)	2-1/8	11/16	3/8	.3125	.234
1/8	.312 ± .0625	Flush ("0" Proj.)	2-1/8	3/4	3/8	.3125	.234
1/8	.312 ± .0625	Flush ("0" Proj.)	2-1/8	3/4	3/8	.4375	.328
1/4	.459 ± .0625	.218	2-7/16	1-1/16	7/16	.5625	.421
3/8	.454 ± .0625	.150	2-9/16	1-1/16	1/2	.7000	.531
1/2	.579 ± .0625	.260	3-1/8	1-3/8	5/8	.6875	.515
3/4	.565 ± .0625	.245	3-1/4	1-3/8	11/16	.9063	.679
1	.678 ± .0937	.275	3-3/4	1-3/4	13/16	1.1250	.843
1-1/4	.686 ± .0937	.285	4	1-3/4	15/16	1.3125	.984
1-1/2	.699 ± .0937	.300	4-1/4	1-3/4	1	1.5000	1.125
2	.667 ± .0937	.267	4-1/2	1-3/4	1-1/8	1.8750	1.406
2-1/2	.925 ± .0937	.525	5-1/2	2-9/16	1-1/4	2.2500	1.687
3	.925 ± .0937	.525	6	2-5/8	1-3/8	2.6250	1.968
3-1/2	.938 ± .125	.525	6-1/2	2-11/16	1-1/2	2.8125	2.108
4	.950 ± .125	.525	6-3/4	2-3/4	1-5/8	3.0000	2.250

ENGINEERING DATA

TAP RECOMMENDATIONS & THREAD LIMITS

For Classes 2B & 3B – Machine Screw & Fractional Sizes

Size	Recommended Tap for Class of Thread						Tap Recommendations and Thread Limits		
	Class 2B			Class 3B			Minimum All Classes (Basic)	Maximum Class 2B	Maximum Class 3B
	H Limit	Minimum	Maximum	H Limit	Minimum	Maximum			
#0-80 UNF	H2	.0524	.0529	H1	.0519	.0524	.0519	.0542	.0536
#1-64 UNC	H2	.0634	.0639	H1	.0629	.0634	.0629	.0655	.0648
#1-72 UNF	H2	.0645	.0650	H1	.0640	.0645	.0640	.0665	.0659
#2-56 UNC	H2	.0749	.0754	H1	.0744	.0749	.0744	.0772	.0765
#2-64 UNF	H2	.0764	.0769	H1	.0759	.0764	.0759	.0786	.0779
#3-48 UNC	H2	.0860	.0865	H1	.0855	.0860	.0855	.0885	.0877
#3-56 UNF	H2	.0879	.0884	H1	.0874	.0879	.0874	.0902	.0895
#4-40 UNC	H2	.0963	.0968	H2	.0963	.0968	.0958	.0991	.0982
#4-48 UNF	H2	.0990	.0995	H1	.0985	.0990	.0985	.1016	.1008
#5-40 UNC	H2	.1093	.1098	H2	.1093	.1098	.1088	.1121	.1113
#5-44 UNF	H2	.1107	.1112	H1	.1102	.1107	.1102	.1134	.1126
#6-32 UNC	H3	.1187	.1192	H2	.1182	.1187	.1177	.1214	.1204
#6-40 UNF	H2	.1223	.1228	H2	.1223	.1228	.1218	.1252	.1243
#8-32 UNC	H3	.1447	.1452	H2	.1442	.1447	.1437	.1475	.1465
#8-36 UNF	H2	.1465	.1470	H2	.1465	.1470	.1460	.1496	.1487
#10-24 UNC	H3	.1639	.1644	H3	.1639	.1644	.1629	.1672	.1661
#10-32 UNF	H3	.1707	.1712	H2	.1702	.1707	.1697	.1736	.1726
#12-24 UNC	H3	.1899	.1904	H3	.1899	.1904	.1889	.1933	.1922
#12-28 UNF	H3	.1938	.1942	H3	.1938	.1942	.1928	.1970	.1959
1/4-20 UNC	H5	.2195	.2200	H3	.2185	.2190	.2175	.2224	.2211
1/4-28 UNF	H4	.2283	.2288	H3	.2278	.2283	.2268	.2311	.2300
5/16-18 UNC	H5	.2784	.2789	H3	.2774	.2779	.2764	.2817	.2803
5/16-24 UNF	H4	.2869	.2874	H3	.2864	.2869	.2854	.2902	.2890
3/8-16 UNC	H5	.3364	.3369	H3	.3354	.3359	.3344	.3401	.3387
3/8-24 UNF	H4	.3494	.3499	H3	.3489	.3494	.3479	.3528	.3516
7/16-14 UNC	H5	.3931	.3936	H3	.3921	.3926	.3911	.3972	.3957
7/16-20 UNF	H5	.4070	.4075	H3	.4060	.4065	.4050	.4104	.4091
1/2-13 UNC	H5	.4520	.4525	H3	.4510	.4515	.4500	.4565	.4548
1/2-20 UNF	H5	.4695	.4700	H3	.4685	.4690	.4675	.4731	.4717
9/16-12 UNC	H5	.5104	.5109	H3	.5094	.5099	.5084	.5152	.5135
9/16-18 UNF	H5	.5284	.5289	H3	.5274	.5279	.5264	.5323	.5308
5/8-11 UNC	H5	.5680	.5685	H3	.5670	.5675	.5660	.5732	.5714
5/8-18 UNF	H5	.5909	.5914	H3	.5899	.5904	.5889	.5949	.5934
3/4-10 UNC	H5	.6870	.6875	H5	.6870	.6875	.6850	.6927	.6907
3/4-16 UNF	H5	.7114	.7119	H3	.7104	.7109	.7094	.7159	.7143
7/8-9 UNC	H6	.8053	.8058	H4	.8043	.8048	.8028	.8110	.8089
7/8-14 UNF	H6	.8311	.8316	H4	.8301	.8306	.8286	.8356	.8339
1-8 UNC	H6	.9213	.9218	H4	.9203	.9208	.9188	.9276	.9254
1-12 UNF	H6	.9484	.9489	H4	.9474	.9479	.9459	.9535	.9516
1-14 UNS	H6	.9561	.9566	H4	.9551	.9556	.9536	.9609	.9590
1 1/8-7 UNC	H8	1.0352	1.0357	H4	1.0332	1.0337	1.0322	1.0416	1.0393
1 1/8-12 UNF	H6	1.0739	1.0749	H4	1.0719	1.0729	1.0709	1.0787	1.0768
1 1/4-7 UNC	H8	1.1622	1.1632	H4	1.1582	1.1592	1.1572	1.1668	1.1644
1 1/4-12 UNF	H6	1.1989	1.1999	H4	1.1969	1.1979	1.1959	1.2039	1.2019
1 3/8-6 UNC	H8	1.2717	1.2727	H4	1.2677	1.2687	1.2667	1.2771	1.2745
1 3/8-12 UNF	H6	1.3239	1.3249	H4	1.3219	1.3229	1.3209	1.3291	1.3270
1 1/2-6 UNC	H8	1.3967	1.3977	H4	1.3927	1.3937	1.3917	1.4022	1.3996
1 1/2-12 UNF	H6	1.4489	1.4499	H4	1.4469	1.4479	1.4459	1.4542	1.4522

ENGINEERING DATA

METRIC TAP THREAD LIMITS Table 337

Nominal Dia. mm	Pitch mm	Major Diameter (Inches)			Basic	Pitch Diameter Limits (Inches)							
		Basic	Min.	Max.		D3		D4		D5		D6	
						Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.
1.6	0.35	.0630	.0641	.0651	.0541	.0550	.0556	—	—	—	—	—	—
2	0.4	.0787	.0800	.0810	.0685	.0695	.0700	—	—	—	—	—	—
2.5	0.45	.0984	.0998	.1008	.0869	.0879	.0885	—	—	—	—	—	—
3	0.5	.1181	.1197	.1207	.1053	.1063	.1069	—	—	—	—	—	—
3.5	0.6	.1378	.1397	.1407	.1224	—	—	.1237	.1245	—	—	—	—
4	0.7	.1575	.1597	.1613	.1396	—	—	.1408	.1416	—	—	—	—
4.5	0.75	.1772	.1795	.1811	.1580	—	—	.1593	.1600	—	—	—	—
5	0.8	.1969	.1994	.2010	.1764	—	—	.1776	.1784	—	—	—	—
6	1	.2362	.2394	.2410	.2106	—	—	—	—	.2122	.2132	—	—
7	1	.2756	.2787	.2804	.2500	—	—	—	—	.2516	.2526	—	—
8	1.25	.3150	.3189	.3214	.2830	—	—	—	—	.2843	.2856	—	—
10	1.5	.3937	.3987	.4009	.3554	—	—	—	—	—	—	.3572	.3584
12	1.75	.4724	.4780	.4805	.4277	—	—	—	—	—	—	.4295	.4308

Nominal Dia. mm	Pitch mm	Major Diameter (Inches)			Basic	Pitch Diameter Limits (Inches)					
		Basic	Min.	Max.		D7		D8		D9	
						Min.	Max.	Min.	Max.	Min.	Max.
14	2	.5512	.5575	.5600	.5000	.5020	.5036	—	—	—	—
16	2	.6299	.6362	.6387	.5788	.5808	.5824	—	—	—	—
20	2.5	.7874	.7953	.7978	.7235	.7254	.7271	—	—	—	—
24	3	.9449	.9547	.9583	.8682	—	—	.8706	.8722	—	—
30	3.5	1.1811	1.1921	1.1961	1.0916	—	—	—	—	1.0942	1.0962
36	4	1.4173	1.4299	1.4339	1.3150	—	—	—	—	1.3176	1.3197

Basic pitch diameter is the same as minimum pitch diameter of Internal Thread Class 6H - Table 21, ANSI B1.13M-1979

METRIC TAP LIMITS Table 341

HSG: High Speed Ground

D: Pitch Diameter is above basic (Go Gage)

DU: Pitch diameter is below basic

Each .0005" represents one D number.

The number following "D" or "DU" signifies the number of .0005" steps above or below basic pitch diameter.

(Go Gage)

- DU1 = Basic minus .0005" = MIN PD
MIN PD plus Tol = MAX PD
- D1 = Basic plus .0005" = MAX PD
MAX PD minus Tol = MIN PD
- D2 = Basic plus .0010" = MAX PD
MAX PD minus Tol = MIN PD
- D3 = Basic plus .0015" = MAX PD
MAX PD minus Tol = MIN PD
- D4 = Basic plus .0020" = MAX PD
MAX PD minus Tol = MIN PD

Pitch mm	Tolerance			
	M1.6 - M6 Inclusive	Over M6 - M25 Inclusive	Over M25 - M90 Inclusive	Over M90
0.3	.0006	.0006	.0008	.0008
0.35	.0006	.0006	.0008	.0008
0.4	.0006	.0006	.0008	.0010
0.45	.0006	.0008	.0008	.0010
0.5	.0006	.0008	.0010	.0010
0.6	.0008	.0008	.0010	.0010
0.7	.0008	.0008	.0010	.0010
0.75	.0008	.0010	.0010	.0012
0.8	.0008	.0010	.0010	.0012
0.9	.0008	.0010	.0010	.0012
1	.0010	.0010	.0012	.0012
1.25	.0010	.0012	.0012	.0016
1.5	.0010	.0012	.0012	.0016
1.75	.0010	.0012	.0016	.0016
2	—	.0016	.0016	.0016
2.5	—	.0016	.0016	.0020
3	—	.0016	.0020	.0020
3.5	—	.0016	.0020	.0020
4	—	.0020	.0020	.0025
4.5	—	.0020	.0020	.0025
5	—	—	.0025	.0025
5.5	—	—	.0025	.0025
6	—	—	.0025	.0025

ENGINEERING DATA

METRIC TAP RECOMMENDATIONS For Classes of Threads

Size mm	Pitch mm	Recommended Tap for Class of Thread		Pitch Diameter Limits for Class of Thread (mm)		
		4H	6H	Minimum (Basic)	Maximum 4H	Maximum 6H
M1.5	0.35	D1	D2	1.273	1.326	1.358
M1.6	0.35	D1	D3	1.373	1.426	1.458
M1.8	0.35	D1	D3	1.573	1.626	1.658
M2	0.45	D1	D2	1.708	1.768	1.803
M2	0.40	D1	D3	1.740	1.796	1.830
M2.2	0.45	D1	D3	1.908	1.968	2.003
M2.3	0.40	D1	D2	2.040	2.096	2.130
M2.5	0.45	D1	D3	2.208	2.268	2.303
M2.6	0.45	D1	D2	2.308	2.368	2.403
M3	0.60	D1	D2	2.610	2.681	2.722
M3	0.50	D1	D3	2.675	2.738	2.775
M3.5	0.60	D1	D4	3.110	3.181	3.222
M4	0.75	D2	D3	3.513	3.588	3.631
M4	0.70	D2	D4	3.545	3.620	3.663
M4.5	0.75	D2	D4	4.013	4.088	4.131
M5	1.00	D2	D3	4.350	4.440	4.490
M5	0.90	D2	D3	4.415	4.501	4.549
M5	0.80	D2	D4	4.480	4.560	4.605
M5.5	0.90	D2	D3	4.915	5.002	5.050
M6	1.00	D3	D5	5.350	5.445	5.500
M6	0.75	D3	D4	5.513	5.598	5.645
M7	1.00	D3	D5	6.350	6.445	6.500
M7	0.75	D2	D4	6.513	6.598	6.645
M8	1.25	D3	D5	7.188	7.288	7.348
M8	1.00	D3	D5	7.350	7.445	7.500
M9	1.25	D3	D5	8.188	8.288	8.348
M9	1.00	D3	D5	8.350	8.445	8.500
M10	1.50	D3	D6	9.026	9.138	9.206
M10	1.25	D3	D5	9.188	9.288	9.348
M10	1.00	D3	D5	9.350	9.445	9.500
M11	1.50	D3	D5	10.026	10.138	10.206
M12	1.75	D3	D6	10.863	10.988	11.063
M12	1.50	D3	D5	11.026	11.144	11.216
M12	1.25	D3	D5	11.188	11.300	11.368
M14	2.00	D3	D7	12.701	12.833	12.913
M14	1.50	D3	D6	13.026	13.144	13.216
M14	1.25	D3	D5	13.188	13.300	13.368
M16	2.00	D4	D7	14.701	14.833	14.913

These are general tap recommendations to produce the Class of Thread indicated in average materials when used with reasonable care. However, if the tap specified does not give a satisfactory gage fit in the work, please consult the factory.

METRIC MET-FLO TAP DRILLS

Size	75% Thread	65% Thread	55% Thread	Tap Size	75% Thread	65% Thread	55% Thread	Tap Size
M1.6 x .35	.057	.058	.059	1.45 mm	.056	.057	.058	#54
M1.7 x .35	.061	.062	.063	1.55 mm	.060	.061	.062	#53
M2 x .4	.072	.073	.074	1.85 mm	.071	.072	.073	1.80 mm
M2.5 x .45	.091	.092	.093	2.30 mm	.089	.090	.091	#43
M2.6 x .45	.095	.096	.097	2.40 mm	.093	.094	.095	2.35 mm
M3 x .5	.110	.111	.112	#35	.108	.109	.110	2.75 mm
M3.5 x .6	.128	.129	.130	#30	.126	.127	.128	3.2 mm
M4 x .7	.145	.146	.148	3.7 mm	.144	.145	.147	#27
M5 x .8	.183	.184	.185	#14	.181	.182	.184	4.6 mm
M6 x 1	.218	.220	.222	5.5 mm	.216	.218	.220	5.5 mm
M8 x 1.25	.291	.294	.296	7.4 mm	.289	.291	.294	7.3 mm
M10 x 1	.375	.377	.379	9.5 mm	.373	.375	.377	9.5 mm
M10 x 1.25	.370	.373	.375	9.4 mm	.368	.370	.373	9.3 mm
M10 x 1.5	.365	.368	.371	9.3 mm	.362	.365	.368	9.2 mm
M12 x 1.75	.439	.442	.446	7/16"	.436	.439	.443	11.0 mm
M14 x 1.25	.527	.530	.532	13.4 mm	.525	.528	.530	13.3 mm
M14 x 1.5	.522	.525	.528	13.3 mm	.519	.522	.525	13.2 mm
M14 x 2	.512	.516	.520	13.0 mm	.509	.513	.517	12.9 mm
M16 x 1.5	.601	.604	.607	15.3 mm	.598	.601	.604	15.2 mm
M16 x 2	.591	.595	.599	15.0 mm	.588	.592	.596	14.9 mm
M18 x 1.5	.680	.683	.686	17.3 mm	.677	.680	.683	17.2 mm

ENGINEERING DATA

METRIC TAP RECOMMENDATIONS For Classes of Threads

Size mm	Pitch mm	Recommended Tap for Class of Thread		Pitch Diameter Limits for Class of Thread (mm)		
		4H	6H	Minimum (Basic)	Maximum 4H	Maximum 6H
M16	1.50	D3	D6	15.026	15.144	15.216
M17	1.50	D3	D5	16.026	16.144	16.216
M18	2.50	D4	D7	16.376	16.516	16.600
M18	2.00	D4	D6	16.701	16.833	16.913
M18	1.50	D3	D6	17.026	17.144	17.216
M19	2.50	D4	D6	17.376	17.516	17.600
M20	2.50	D4	D7	18.376	18.516	18.600
M20	2.00	D4	D6	18.701	18.833	18.913
M20	1.50	D3	D6	19.026	19.144	19.216
M22	2.50	D4	D7	20.376	20.516	20.600
M22	2.00	D4	D6	20.701	20.833	20.913
M22	1.50	D3	D6	21.026	21.144	21.216
M24	3.00	D4	D8	22.051	22.221	22.316
M24	2.00	D4	D7	22.701	22.841	22.925
M24	1.50	D3	D5	23.026	23.151	23.226
M25	2.00	D4	D7	23.701	23.841	23.925
M25	1.50	D3	D5	24.026	24.151	24.226
M26	3.00	D5	D8	24.051	24.221	24.316
M27	3.00	D5	D8	25.051	25.221	25.316
M27	2.00	D5	D7	25.701	25.841	25.925
M28	3.00	D5	D8	26.051	26.221	26.316
M28	2.00	D5	D7	26.701	26.841	26.925
M30	3.50	D5	D9	27.727	27.907	28.007
M30	3.00	D5	D8	28.051	28.221	28.316
M30	2.00	D5	D7	28.701	28.841	28.925
M32	3.50	D5	D9	29.727	29.907	30.007
M32	2.00	D5	D7	30.701	30.841	30.925
M33	3.50	D5	D9	30.727	30.900	31.007
M33	3.00	D5	D8	31.051	31.221	31.316
M33	2.00	D5	D7	31.701	31.841	31.925
M34	3.50	D5	D9	31.727	31.907	32.007
M36	4.00	D5	D9	33.402	33.592	33.702
M36	3.00	D5	D8	34.051	34.221	34.316
M36	2.00	D5	D7	34.701	34.841	34.925
M38	4.00	D5	D9	35.402	35.592	35.702
M39	4.00	D6	D9	36.402	36.592	36.702
M39	3.00	D6	D8	37.051	37.221	37.316
M39	2.00	D6	D7	37.701	37.841	37.925

These are general tap recommendations to produce the Class of Thread indicated in average materials when used with reasonable care. However, if the tap specified does not give a satisfactory gage fit in the work, please consult the factory.

SFM/RPM Equations

$$\text{SFM} = 0.26 \times \text{RPM} \times \text{Tool Diameter}$$

$$\text{RPM} = \frac{3.82 \times \text{SFM}}{\text{Tool Diameter}}$$

Factors to be considered when determining tapping speeds:

- Material to be tapped
- Length of chamfer on tap
- Percentage of full thread to be cut
- Machine equipment and rigidity
- Depth of hole
- Pitch of thread
- Lubrication
- Horizontal or vertical tapping

ENGINEERING DATA

TABLE OF SPEED FOR TAPS

Machine Screw and Fractional Sizes

Tap Size (UNC/ UNF)	Taper Pipe (NPT/ NPTF)	Surface Feet Per Minute (SFM)																	
		5'	10'	15'	20'	25'	30'	40'	50'	60'	70'	80'	90'	100'	110'	120'	130'	140'	150'
		Revolutions Per Minute (RPM)																	
0 (.060)		318	637	955	1273	1592	1910	2546	3183	3820	4456	5093	5729	6366	7003	7639	8276	8913	9549
1 (.073)		273	546	819	1046	1308	1570	2093	2617	3140	3663	4186	4710	5233	5756	6279	6805	7326	7849
2 (.086)		212	424	637	888	1110	1333	1777	2221	2665	3109	3554	3999	4442	4886	5330	5774	6218	6662
3 (.099)		191	382	573	772	964	1157	1543	1929	2315	2701	3086	3472	3858	4244	4629	5015	5401	5787
4 (.112)		174	347	521	682	853	1023	1364	1705	2046	2387	2728	3069	3411	3751	4092	4434	4775	5116
5 (.125)		147	294	441	611	764	917	1222	1528	1833	2139	2445	2750	3056	3361	3667	3973	4278	4584
6 (.138)		136	273	409	553	691	829	1106	1382	1659	1935	2212	2488	2766	3042	3318	3595	3871	4148
8 (.164)		119	239	358	466	583	699	932	1165	1398	1631	1864	2097	2330	2563	2796	3029	3262	3495
10 (.190)		101	201	302	402	502	603	804	1005	1205	1406	1607	1808	2009	2210	2411	2612	2813	3014
12 (.216)		87	174	260	354	442	531	707	884	1061	1238	1415	1592	1769	1945	2122	2300	2476	2653
14 (.242)		79	158	237	316	395	474	631	789	947	1105	1263	1421	1579	1736	1894	2052	2210	2368
1/4		76	153	229	306	382	458	611	764	917	1070	1222	1375	1528	1681	1833	1986	2139	2292
5/16	1/16	62	123	185	245	306	367	489	611	733	856	978	1100	1222	1345	1467	1589	1711	1833
3/8		50	101	151	204	255	305	407	509	611	713	815	917	1019	1120	1222	1324	1426	1528
7/16	1/8	43	87	130	175	219	262	349	437	524	611	698	786	873	960	1048	1135	1222	1310
1/2		38	76	115	153	191	229	305	382	458	535	611	688	764	840	917	993	1070	1146
9/16	1/4	34	68	102	137	172	206	274	342	410	478	547	616	683	752	820	888	952	1020
5/8		32	64	96	122	153	183	244	306	367	428	489	550	611	672	733	794	856	917
11/16	3/8	28	55	83	111	138	167	222	278	333	389	444	500	556	611	667	722	778	833
3/4		25	51	76	102	128	153	203	255	305	357	407	458	509	560	611	662	713	764
7/8	1/2	22	43	65	87	109	131	175	218	262	306	350	392	437	480	524	568	611	655
1"		19	38	57	76	96	115	153	191	230	268	305	344	382	420	458	497	535	573
1 1/8	3/4	17	34	51	68	84	102	136	170	204	238	272	306	340	373	407	441	475	509
1 1/4		15	31	46	61	76	92	122	153	183	214	244	275	305	336	367	397	428	458
1 3/8	1	14	28	42	56	69	83	111	139	167	194	222	250	278	306	333	361	389	417
1 1/2		13	25	38	51	63	76	102	127	153	178	204	229	255	280	305	331	356	382
1 5/8		12	23	35	47	59	71	94	118	141	165	188	212	235	259	282	306	329	353
1 3/4	1 1/4	11	22	33	44	55	65	87	109	131	153	175	196	218	240	262	284	306	327
1 7/8	1 1/2	10	20	30	41	51	61	81	102	122	143	163	183	204	224	244	265	285	306
2"		9	19	29	38	48	57	76	96	115	134	153	172	191	210	229	248	267	287

Metric Sizes

Tap Size (UNC/ UNF)	Taper Pipe (NPT/ NPTF)	Surface Feet Per Minute (SFM)																	
		5'	10'	15'	20'	25'	30'	40'	50'	60'	70'	80'	90'	100'	110'	120'	130'	140'	150'
		Revolutions Per Minute (RPM)																	
M1	.0394	490	979	1469	1959	2449	2938	3918	4897	5877	6856	7836	8815	9795	10774	11754	12733	13713	14692
M2	.0787	242	484	725	967	1209	1451	1934	2418	2901	3385	3868	4352	4835	5319	5803	6286	6770	7253
M3	.1181	162	324	486	647	809	971	1295	1619	1942	2266	2590	2914	3237	3561	3885	4208	4532	4856
M3.5	.1378	138	277	415	554	692	830	1107	1384	1661	1938	2214	2491	2768	3045	3322	3599	3875	4152
M4	.1575	122	243	365	487	608	730	973	1217	1460	1703	1946	2190	2433	2676	2920	3163	3406	3650
M5	.1969	97	194	291	388	495	582	776	970	1163	1357	1551	1744	1939	2133	2327	2521	2715	2909
M6	.2362	81	162	243	324	405	486	647	809	971	1133	1295	1457	1619	1784	1942	2104	2266	2428
M7	.2756	69	138	208	277	346	415	554	692	830	969	1107	1246	1384	1522	1661	1799	1938	2076
M8	.3150	61	121	182	243	303	364	485	606	728	849	970	1091	1213	1334	1455	1577	1698	1819
M10	.3937	48	97	145	194	242	291	388	485	582	679	776	873	970	1067	1163	1260	1357	1454
M12	.4724	40	81	121	162	202	243	324	405	486	567	647	728	809	890	971	1052	1133	1214
M14	.5512	35	69	104	139	173	208	277	347	416	485	555	624	693	763	865	901	971	1040
M16	.6299	30	61	91	121	152	182	243	303	364	424	485	546	606	667	728	788	849	910
M18	.7087	27	54	81	108	135	162	216	269	323	377	431	485	539	593	647	700	754	808
M20	.7874	24	49	73	97	121	146	194	243	291	340	355	437	485	534	582	631	680	728
M22	.8661	22	44	66	88	110	132	176	221	265	309	353	397	441	485	529	573	618	662
M24	.9449	20	40	61	81	101	121	162	202	243	283	323	364	404	445	485	526	566	606

ENGINEERING DATA

MATERIAL SPECIFIC Recommended Speed Tables

Stainless Steel

Material Types	Free Machining	Ferritic	Austenitic	Martensitic	Precipitation Hardened	
Material Examples	303, 303SE, 416, 420F, 430F	405, 430	302, 304, 316, 329, 436 <275	403, 410, 420, 431	15-5PH 17-4PH 17-7PH	
Hardness BHN RC	<250 <23	<260 <26	<28 —	<275 <28	<275 <28	350-440 <48
Thread Forming Taps	50-100 SFM	70-100 SFM	—	—	—	—
Carbide Taps	—	—	20-35 SFM	—	—	—
HSS	15-35 SFM	25-35 SFM	—	15-35 SFM	15-35 SFM	—
SuperTuf DM	—	—	—	—	12-20 SFM	12-20 SFM
SuperTuf SS	25-50 SFM	25-50 SFM	25-50 SFM	25-50 SFM	—	—

Carbon Steel

Material Types	Free Machining	Low Carbon	Alloy-Low Carbon	Medium Carbon	High Carbon	Alloy-High Carbon	Tool Steel	
Material Examples	1118, 1114, 1212, 12L14, 12L15, 1215	1008, 1010, 1011, 1015, 1018, 1029	3310, 4620, 4820, 8620	1030, 1035, 1040, 4045, 1050	1050, 1065, 1070, 1080, 1090	4140, 4150, 4340	01, A-2, D-2, H-13, P-20	
Hardness BHN RC	<180 <20	<180 <20	<240 <24	<275 <28	<300 <32	<390 <42	<340 <35	350-440 <48
Thread Forming Taps	120-180 SFM	60-129 SFM	50-90 SFM	—	—	—	—	—
Carbide Taps	—	—	—	—	—	—	—	—
HSS	45-65 SFM	20-45 SFM	20-30 SFM	15-35 SFM	20-30 SFM	12-19 SFM	15-25 SFM	10-20 SFM
SuperTuf DM	—	—	—	—	—	10-20 SFM	10-20 SFM	
SuperTuf SS	25-80 SFM	25-80 SFM	20-50 SFM	20-50 SFM	20-50 SFM	—	—	—

Cast Iron & Sintered Metals

Material Types	Pearlitic-Martensitic	Martensitic (Malleable)	Martensitic (Ductile)	Martensitic (Malleable)	Precipitation (Malleable)	Austenitic (Gray)	Austenitic (Ductile)	Austenitic (Ductile)
Material Examples	100-70-03	120-90-02	53004, 60003, 60000	70002, 70003	80002, 90001	ASTM A436 Type 1-6	ASTM A439 TYPE D-2 D-2C, D-5, D3A, D5B	ASTM A439 Type D-2B D-3, D-4
Hardness BHN	240-300	270-300	200-255	220-260	240-320	100-250	120-200	140-275
Carbide Taps	15-26 SFM	12-20 SFM	35-45 SFM	30-40 SFM	29-30 SFM	35-60 SFM	20-30 SFM	15-25 SFM
HSS	12-20 SFM	9-15 SFM	25-35 SFM	23-30 SFM	20-23 SFM	25-45 SFM	15-23 SFM	13-20 SFM

Titanium

Material Types	Commercial Pure	& - Alloy		& - Alloy
Material Examples	99.5, 99.2, 98.9	6Al-4V		6Al4V ELT 6Al-6V-2Sn
Hardness BHN RC	<275 <28	300-350 <36	300-400 <42	330-420 <45
HSS	12-23 SFM	9-15 SFM	8-15 SFM	4-7 SFM
SuperTuf TI	10-30 SFM	15-20 SFM	10-20 SFM	5-7 SFM

ENGINEERING DATA

MATERIAL SPECIFIC Recommended Speed Tables

Aluminum

Material Types	Unalloyed	Wrought	Cast (Sand)	Die Castings
Material Examples	1000 Series	2000, 3000, 5000, 6000, 7000 Series	308, 319, 328, 365	360, 380, 383, 390, 392 50-125
Hardness BHN	<30	30-80	40-100	—
Thread Forming Taps	240 SFM	200-250 SFM	180-200 SFM	180-300 SFM
Carbide Taps	240-360 SFM	250-375 SFM	200-300 SFM	300-450 SFM
HSS	90 SFM	75-95 SFM	65-75 SFM	65-110 SFM
SuperTuf AL	30-80 SFM	40-65 SFM	40-65 SFM	40-65 SFM

Cast Iron & Sintered Metals

Material Types	Pearlitic-Ferritic	Pearlitic (Gray)	Pearlitic (Malleable)	Pearlitic with Free Carbide	
Material Examples	ASTM A48: Class 25	ASTM A48: Classes 30, 35, 40	40010, 43010, 45006, 45008, 48005, 50005	ASTM A48: Classes 45, 50	ASTM A48: Classes 55, 60
Hardness BHN	160-200	190-220	160-200	220-260	250-320
Carbide Taps	140-210 SFM	120-180 SFM	100-150 SFM	80-120 SFM	50-75 SFM
HSS	35-50 SFM	30-45 SFM	30-35 SFM	20-30 SFM	12-19 SFM

Brass/Bronze Alloys

Material Types	—
Material Examples	—
HSS	30-80 SFM

Copper Alloys

Material Types	—
Material Examples	—
HSS	80-200 SFM

Nickel Alloys

Material Types	Nickel Alloys	Nickel Alloys	Nickel Alloys	High Temp Alloys (Nickel Base)	High Temp Alloys (Nickel Base)	High Temp Alloys (Nickel Base)	High Temp Alloys (Nickel Base)	High Temp Alloys (Nickel Base)	High Temp Alloys (Nickel Base)
Material Examples	Nickel 200, 201, 205	Monel 400, 401, 404	Duranickel Monel K800	Inconel 700718	Waspaloy Rene41	Hastaloy BC, G, X	Inconel 600 Inconel 500700	Haynes 25188	A286, Inconel 800
Hardness BHN RC	80-170 <20	115-240 <24	150-360 <38	200-300 <30	300-400 <42	140-220 <23	240-310 <32	180-270 <28	180-230 <23
HSS	15-20 SFM	8-20 SFM	4-9 SFM	6-9 SFM	4-8 SFM	8-11 SFM	5-7 SFM	4-7 SFM	11-15 SFM
SuperTuf NI	8-15 SFM	10-30 SFM	5-20 SFM	8-15 SFM	5-20 SFM	—	8-15 SFM	10-15 SFM	5-20 SFM

ENGINEERING DATA

SURFACE TREATMENTS

Regal Cutting Tools offers many surface treatments which provide higher surface hardness to resist wear and make your taps resistant to galling or chip loading.

Surface Treatments		Benefits & Applications
Titanium Nitride	#25	Provides increased surface hardness, adhesive (lower C.O.F.) resistance and tool life.
Nitride Treatment	#33	Provides increased surface hardness. Recommended general purpose surface treatment for increasing tool life in a wide variety of applications.
Steam Oxide Treatment	#43	Acts as a solid lubricant and also retains liquid lubricant at cutting edges. Prevents chip welding, reduces friction, and acts as thermal insulator between the tap and the workpiece.
Nitride & Steam Oxide Combination	#53	This combination of both surface treatments affords the characteristics of both treatments.
Chrome Plate Over Nitride	#64	An effective treatment when tapping nonferrous metals and some soft steels.
Chrome Plate	#74	Adds lubricating and heat dissipation qualities at the cutting edge. Excellent for nonferrous materials and soft steel.
Chromium Nitride	#82	The combination of toughness and lubricity makes this an excellent coating for forming taps.
Titanium Carbo Nitride	#85	Developed for machining difficult steel alloys. Adds life to tools in high speed machining.
Titanium Aluminum Nitride	#88	Coating with hardness to resist abrasive materials and heat resistant for better tool life.
Aluminum Titanium Nitride	#95	A multi-layer coating. Excellent for machining cast iron, stainless steel and nickel based alloys.

Note: Other coatings available upon request.

HSS Surface Treatment Application Guide

Type	Class (Speed compared to uncoated)	Surface Treatment Suitability						
		TiN (+50%)	TiCN (+50%)	AlTiN (+50%)	Cr (+100%)	Nitride	Oxide	Nitride, Oxide
Steels	Carbon, plain, low alloy, free cutting, heat treatable	Best	Best	Good	NR	Good	Good	Good
Stainless Steels	Heat Treatable to 44 RC	Best	Best	Best	NR	Good	Good	Good
Tool Steels	Non-Heat Treatable	Best	Best	Best	NR	Good	Good	Good
Cast Irons	Gray	Best	Best	Best	NR	Good	Good	Good
	Malleable	Best	Best	Best	NR	Fair	Fair	Good
	Nodular/Ductile	Best	Best	Best	NR	Fair	Fair	Good
Aluminums	Wrought	NR	Best	NR	Good	Good	NR	NR
	Cast	NR	Good	NR	Fair	Good	NR	NR
Coppers	Pure	NR	Best	NR	Good	Good	NR	NR
Brasses	Wrought Alloy	Fair	Best	Fair	Good	NR	NR	NR
Bronzes	Cast Alloy	Fair	Best	Fair	Good	Good	NR	NR
Zincs	Wrought	NR	Best	NR	Good	Good	NR	NR
	Cast	Fair	Good	NR	Good	NR	NR	NR
Magnesiums	Wrought	NR	Best	NR	Good	Good	NR	NR
	Cast	NR	Good	NR	Good	NR	NR	NR
Titaniums	Pure	NR	Best	Good	Fair	Good	Good	Good
	Alloy	NR	Best	Good	Fair	Fair	Fair	Good
High Temperature Alloys	Nickel Base	Good	Best	Best	NR	Fair	Fair	Fair
	Iron Based	Better	Best	Best	NR	Fair	Fair	Fair
Alloys	Cobalt Based	Good	Best	Best	NR	Fair	Fair	Fair
Plastics	Hard	Fair	Good	Good	Fair	Good	NR	NR

Best = First Choice among all commercially available coatings.

Better = Great Choice; while not the best choice, this marks a solid selection that will provide additional benefit over a "good" coating.

Good = Good Choice; this provides a significant performance benefit over an uncoated tool, and may improve tool life, productivity, size, finish, etc., or a combination of benefits.

Fair = Fair Choice among all commercially available coatings as this provides benefits over uncoated tool, but may not be as cost-justifiable.

NR = Not Recommended; not compatible with the selected material and will likely perform worse than an uncoated tool.

REGAL CUTTING TOOLS

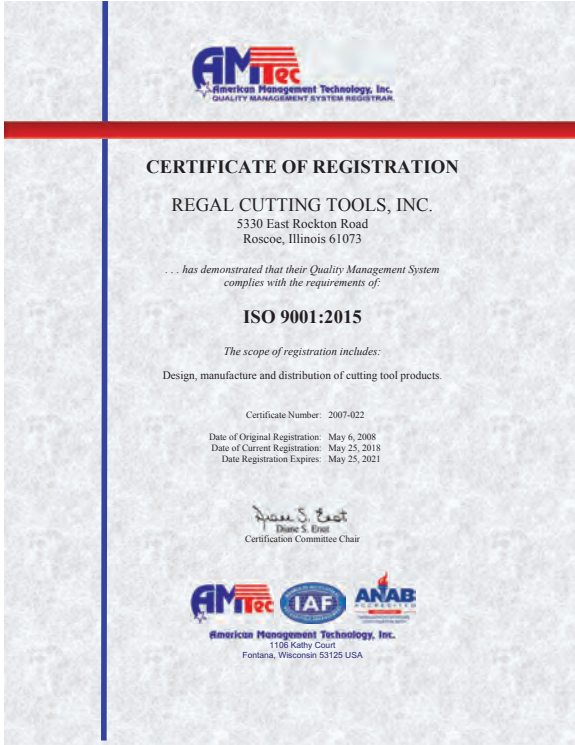
TERMS & CONDITIONS OF SALE

1. **AGREEMENT AND LIMITATIONS.** The agreement between Seller and Buyer ("Sales Contract") with respect to the sale of goods shall consist exclusively of the terms appearing herein. Seller objects to and shall not be bound by additional or different terms, whether printed or otherwise, in Buyer's purchase order or in any other communication from Buyer to Seller. Such additions and differences in terms shall be considered material and Seller's terms and conditions shall govern. The Sales Contract shall be for the benefit of Seller and Buyer and not for the benefit of any other person. Prior courses of dealing, trade usage and verbal agreements not reduced to a writing signed by Seller, to the extent they modify, add to or detract from the Sales Contract, shall not be binding on Seller.
 2. **TERMINATION OR MODIFICATION.** The Sales Contract may be modified or terminated only upon Seller's express written consent. If all or part of the Sales Contract is terminated, Buyer, in the absence of a contrary written agreement signed by Seller, shall pay termination charges based upon expenses and costs incurred in the production of the goods to the date such termination is accepted by Seller including, without limitation, expenses of disposing of materials on hand or on order from suppliers and losses resulting from such disposition, plus a reasonable profit, except that any goods completed on or before Seller's acceptance of such termination shall be accepted and paid for in full by Buyer.
 3. **PRICE AND PAYMENT.** Fulfillment of Buyer's order is contingent upon the availability of materials. The price of the goods sold pursuant to the Sales Contract shall be based upon Seller's price in effect at the time of shipment and any acceptance of the order will be on the basis of the freight rates now in effect. In the event of an increase or decrease in the applicable freight charges before the material is shipped, such changes in freight charges will be for the account of Buyer. Price advances, discounts, extras and terms and conditions are subject to changes without notice. Any sales or other tax or duty that Seller may be required to collect or pay upon the sale of the goods will be added to the quoted price. If such amount is not included in an invoice for the goods, it may be invoiced separately later. If the Sales Contract is for more than one unit of goods, the goods may be shipped in several lots at the discretion of Seller, and each such shipment shall be paid for separately. Seller may require full or partial payment or payment guarantee in advance of shipment whenever, in its opinion, the financial condition of Buyer so warrants. In addition, Seller may at any time or times, suspend performance of any order or require payment in cash, security or other adequate assurance satisfactory to Seller when, in Seller's opinion, the financial condition of Buyer warrants such action.

BLANKET ORDER WITH SCHEDULED RELEASES

 - (a) **Stock Item.** Blanket orders of stock items with scheduled releases are predicated on total units released for shipment within the specified period. All blanket orders will be adjusted for price levels based on actual releases within the specified period.
 - (b) **Special Items.** In the event Buyer has not taken delivery by the end of the specified period of all special items covered by a blanket order with scheduled releases, Seller shall, on that date, ship the remaining number of special items and invoice the Buyer accordingly. Any deviation from the policy set forth in (a) or (b) above must have prior written approval signed by Seller's authorized representative.
- TERMS**
- Terms of payment, minimum order charges, broken package charges, and transportation charges are as set forth. C.O.D. shipments are not entitled to a cash discount or prepaid transportation. Shipment of specials may be 10% over/under quantity ordered unless otherwise stated on the order. All prices are F.O.B. shipping point. Methods and route of shipment are at Seller's discretion unless the Buyer supplies explicit instruction. Seller may assess a delinquency charge of 1-1 1/2% per month on invoices not paid within stated terms.- 4. **TAXES.** Prices do not include federal, state or local taxes. Buyer shall pay to Seller, in addition to the price of the goods, all applicable taxes and other governmental charges upon the production, sale, delivery or use of the goods, to the extent required or not forbidden by law to be collected by Seller from Buyer, unless Buyer furnished Seller with valid exemption certificates acceptable to the appropriate taxing authorities before the date of acknowledgment.
- 5. **RISK OF LOSS.** Delivery shall occur, and risk of loss shall pass to Buyer, upon delivery of the material to a carrier at the point of shipment. Transportation shall be at Buyer's sole risk and expense, and any claim for loss or damage in transit shall be against the carrier only.
- 6. **DELIVERY AND QUANTITIES.**
 - (a) Promises of delivery from stock are subject to prior sales. Delivery dates are not guaranteed but are estimated on the basis of immediate receipt by Seller of all information to be furnished by Buyer and the absence of delay, direct or indirect, resulting from or contributed to by circumstances beyond Seller's reasonable control. Seller shall in good faith endeavor to meet estimated delivery dates. Seller shall not be liable to Buyer for damages as a result of any delay caused or contributed to by circumstances beyond Seller's reasonable control. If the goods are non-catalog goods, Seller may ship overages or underages to the extent of 10% of quantity ordered, and Buyer shall pay for such quantity supplied based upon the unit price of the goods. Seller shall not be required to maintain closer control of quantity, unless specifically agreed to by Seller in writing. Quantities of all items may be determined by weight. Any claims for shortage must be made within 10 days from the date of receipt of the goods by Buyer, and in every case the weights found in any particular shipment, including tare, must be given and Seller advised as to the method used by Buyer in computing the count of parts.
 - (b) In the event that Buyer is unable to accept delivery of the goods at time of shipment, Seller shall invoice Buyer for the full purchase price as if shipment had been made and (i) if Seller is able to store such goods in its own facilities, Buyer will pay Seller the reasonable handling and storage charges for the period of such storage, and (ii) if Seller is unable to store such goods in its own facilities, Seller reserves the right to arrange handling and storage in a suitable bonded warehouse for the Buyer at Buyer's expense. In cases where handling and storage become necessary, it shall be Buyer's responsibility to notify Seller when shipment is to be made. Seller will make necessary arrangements for shipment at Buyer's expense.
- 7. **RETURNED GOODS.** Goods may not be returned. If Seller consents in writing to the return of goods for any reason, however, Buyer assumes all risk of loss of such returned goods until actual receipt by Seller.
- 8. **INSPECTION.** Buyer shall inspect the goods immediately upon the receipt thereof.
- 9. **WARRANTY.** Seller warrants to original equipment manufacturers, distributors and industrial and commercial users ("Buyer") of its products that each new product manufactured or supplied by Seller shall be commercially free from defects in material and workmanship at the time of shipment of the goods. All claims for allegedly defective goods must be made within 10 days after Buyer learns of such alleged defects limited to a maximum period of one year from the date of sale by Seller. All claims not made in writing and received by Seller within such 10-day period shall be deemed waived. Seller's sole obligation under this warranty is limited to furnishing without additional charge a replacement, or at its option, repairing or issuing credit for any product which shall be returned freight prepaid to the plant designated by a Seller representative and which upon inspection is determined by Seller to be defective in material or workmanship. Complete information as to operating conditions, machine setup, and application of cutting fluid should accompany any product returned for inspection. The provisions of this Warranty shall not apply to any Seller product which has been subjected to misuse, abuse, improper operating conditions (machine setup or application of cutting fluid), or which has been repaired or altered if such repair or alteration in the judgment of Seller would adversely affect performance of the product. THIS WARRANTY IS EXCLUSIVE AND IS IN LIEU OF ALL OTHER WARRANTIES, EXPRESSED OR IMPLIED, INCLUDING ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. Seller's sole liability on any claim of any kind, whether in contract, tort or otherwise, for any loss or damage arising out of, connected with, or resulting from the manufacture, sale, delivery or use of the products sold hereunder shall in no case exceed the cost of replacement or repair as provided herein. EVEN IF THE REPAIR OR REPLACEMENT REMEDY SHALL BE DEEMED TO HAVE FAILED OF ITS ESSENTIAL PURPOSE UNDER SECTION 2-719 OF THE UNIFORM COMMERCIAL CODE, SELLER SHALL HAVE NO LIABILITY TO BUYER FOR CONSEQUENTIAL OR INCIDENTAL DAMAGES, SUCH AS LOST PROFITS, LOST REVENUE, DAMAGE TO OTHER EQUIPMENT OR LIABILITY OR INJURY TO A THIRD PARTY. IN NO EVENT SHALL SELLER BE LIABLE FOR ANY SPECIAL, INCIDENTAL OR CONSEQUENTIAL DAMAGES. There are no other warranties, expressed or implied, made by Seller except the warranty against defects in material and workmanship set forth above. Unless authorized in writing by a corporate officer or vice president, no agent, employee or representative of Seller has any authority to bind Seller to any affirmation, representation or warranty concerning the goods sold under the sales contract and such affirmation, representation or warranty has not formed a part of the basis of the bargain and shall be unenforceable.
- 10. **REMEDIES AND LIMITATION OF LIABILITY.** In the event Buyer claims Seller has breached any of its obligations under the Sales Contract, whether of warranty or otherwise, Seller may request the return of goods and tender to Buyer, at Seller's option, a replacement shipment of goods or the purchase price theretofore paid by Buyer. If Seller so requests the return of the goods, the goods will be redelivered to Seller in accordance with Seller's instructions and at Buyer's expense. If Seller so determines, a refund of the purchase price paid by Buyer shall be made only upon actual receipt of the goods by Seller. Except as herein provided, Seller shall have no further obligation under the Sales Contract. The remedies contained in this paragraph and paragraph 9 hereof shall constitute the sole recourse of Buyer against Seller for breach of any of Seller's obligations under the Sales Contract, whether of warranty or otherwise. In no event shall Seller be liable for incidental, consequential or special damages, nor shall Seller's liability on any claim for damages arising out of or connected with the Sales Contract or the manufacture, sale, delivery or use of the goods exceed the purchase price of the goods.
- 11. **TECHNICAL ADVICE.** Any technical advice furnished, or recommendation made by Seller or any representative of Seller concerning any use or application of any of the goods is believed to be reliable, but Seller makes no warranty, express or implied, on results to be obtained. Buyer assumes all responsibility for loss or damage resulting from the handling or use of any of the goods.
- 12. **FORCE MAJEURE.** Seller shall not be liable for failure to perform its obligations under the Sales Contract in whole or in part caused by the occurrence of any contingencies beyond the control either of Seller or of suppliers to Seller, including but not limited to acts of God; acts of Buyer; acts of any government or agency thereof or civil or military authority, fires, accidents, explosions, strikes or other labor disputes, earthquakes, storms, judicial action, floods, war (whether an actual declaration thereof is made or not), sabotage, riot, delays in transportation, lack of or inability to obtain raw materials, components, labor, fuel or supplies, technical failure, or other circumstances beyond Seller's reasonable control, whether similar or dissimilar to the foregoing. If any such contingency occurs, Seller may allocate goods and deliveries among Seller's customers.
- 13. **ASSIGNMENT AND DELEGATION.** No right or interest in the Sales Contract shall be assigned by Buyer without Seller's prior written consent, and no delegation of any obligation owed, or of the performance of any obligation by Buyer shall be made without Seller's prior written consent. Any attempted assignment or delegation shall be wholly void and totally ineffective for all purposes unless made in conformity with this paragraph.
- 14. **CHANGES.** Seller may, at any time without notice, make changes (whether in design, materials, improvements or otherwise) in any catalog goods, and may discontinue the manufacture of any catalog goods, all in its sole discretion, without incurring any obligations of any kind as a result thereof, whether for failure to fill an order of Buyer or otherwise.
- 15. **SEVERABILITY.** If any term, clause or provision contained in the Sales Contract is declared or held invalid by a court of competent jurisdiction, such declaration or holding shall not affect the validity of any other term, clause or provision contained herein.
- 16. **GOVERNING LAW AND LIMITATION.**
 - (a) The formation and performance of the Sales Contract shall be governed by the Uniform Commercial Code as adopted in the State of Illinois. Whenever a term defined by said Uniform Commercial Code is used in the Sales Contract, the definition contained in said Uniform Commercial Code controls. Any action for breach of the Sales Contract must be commenced within one year after the cause of action accrued, and all such claims shall be barred thereafter notwithstanding any statutory period of limitations to the contrary.
 - (b) The Sales Contract shall be deemed to have been made at Roscoe, Illinois, and shall be interpreted and the rights and liabilities of the parties hereto determined in accordance with the laws of Illinois. Seller represents that the goods will be produced in compliance with the Fair Labor Standards Act of 1938, as amended. Buyer hereby agrees to the jurisdiction of any state or federal court located within Winnebago County, Illinois. Buyer waives any objection based on forum non conveniens and any objection to venue of any action instituted hereunder, and consents to the granting of such legal or equitable relief as is deemed appropriate by a court of competent jurisdiction. The rights and obligations of Seller and Buyer shall not be governed by the provisions of the United Nations Convention on Contracts for the International Sales of Goods; and
 - (c) BUYER AGREES TO PAY ALL OF SELLER'S COSTS AND EXPENSES OF COLLECTION AND LITIGATION, INCLUDING BUT NOT LIMITED TO ATTORNEYS' FEES AND COSTS.

REGAL CUTTING TOOLS



WARRANTY

Regal Cutting Tools ("Seller") warrants to original equipment manufacturers, distributors and industrial and commercial users ("Buyer") of its products that each new product manufactured or supplied by Seller shall be commercially free from defects in material and workmanship at the time of shipment of the goods. All claims for allegedly defective goods must be made within 10 days after Buyer learns of such alleged defects limited to a maximum period of one year from the date of sale by Seller. All claims not made in writing and received by Seller within such 10-day period shall be deemed waived. Seller's sole obligation under this warranty is limited to furnishing without additional charge a replacement, or at its option, repairing or issuing credit for any product which shall be returned freight prepaid to the plant designated by a Seller representative and which upon inspection is determined by Seller to be defective in material or workmanship. Complete information as to operating conditions, machine setup, and application of cutting fluid should accompany any product returned for inspection. The provisions of this Warranty shall not apply to any Seller product which has been subjected to misuse, abuse, improper operating conditions (machine setup or application of cutting fluid), or which has been repaired or altered if such repair or alteration in the judgment of Seller would adversely affect performance of the product. THIS WARRANTY IS EXCLUSIVE AND IS IN LIEU OF ALL OTHER WARRANTIES, EXPRESSED OR IMPLIED, INCLUDING ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. Seller's sole liability on any claim of any kind, whether in contract, tort or otherwise, for any loss or damage arising out of, connected with, or resulting from the manufacture, sale, delivery or use of the products sold hereunder shall in no case exceed the cost of replacement or repair as provided herein. IN NO EVENT SHALL SELLER BE LIABLE FOR ANY SPECIAL, INCIDENTAL OR CONSEQUENTIAL DAMAGES. There are no other warranties, expressed or implied, made by Seller except the warranty against defects in material and workmanship set forth above. Unless authorized in writing by a corporate officer or vice president, no agent, employee or representative of Seller has any authority to bind Seller to any affirmation, representation or warranty concerning the goods sold under the sales contract and such affirmation, representation or warranty has not formed a part of the basis of the bargain and shall be unenforceable.



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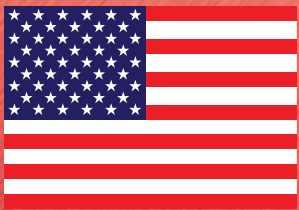
Be prepared with this information:

- Nominal size
- Threads per inch
- Right hand or left hand thread
- Class of fit (if not to commercial standards)
- Tapping depth
- Material to be tapped
- Diameter of the hole before tapping
- Will tap be backed out of hole?
- Type of tapping machine used
- Are taps to be used for sizing only of rough chased threads?
- Will fixture used affect length of tap?



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