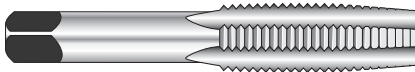


HIGH SPEED STEEL - TITANIUM NITRIDE COATED
STANDARD HAND TAPS

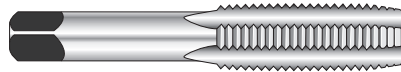
ICS WIS

GENERAL PURPOSE

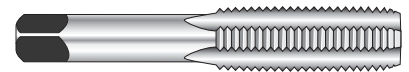
GROUND THREAD



TAPER TAP
 7-10 Thread Chamfer
 at 5 degrees per side



PLUG TAP
 3-5 Thread Chamfer
 at 8 degrees per side



BOTTOMING TAP
 1-2 Thread Chamfer
 at 18 degrees per side

High Speed Steel Hand Taps with straight flutes are designed for general purpose hand tapping or in production machines where ground thread accuracy and performance are required. They are suitable for tapping most materials in through or blind holes. Hand taps retain chips in the flutes during use and work best on materials that produce chips and the swarf breaks easily. They are also known as Straight Flute Taps.

SIZE	THREADS PER INCH			NO. OF FLUTES	LIMIT NO.	HSS	TiN COAT	3PC HSS SET	TAP DRILL SIZE APPROXIMATELY 75% THREAD		
	NC UNC	NF UNF	NS						SHT*	SHTT*	SHTS*
0	-	80	-	2	H1	11.60	13.94	34.78	-	3/64	-
1	64	72	-	2	H1	10.78	13.12	32.32	53	53	-
2	56	64	-	3	H2	8.82	11.18	26.46	50	50	-
3	48	56	-	3	H2	7.18	9.54	21.56	47	45	-
4	40	48	36	3	H2	5.66	8.00	18.90	43	44	42
5	40	44	-	3	H2	5.66	8.00	16.96	38	37	-
6	32	40	-	3	H3	4.24	6.48	12.74	36	33	-
8	32	36	-	4	H3	4.58	8.68	13.74	29	29	-
10	24	32	-	4	H3	4.58	8.68	13.74	25	21	-
12	24	28	-	4	H3	6.14	10.36	18.40	16	14	-
1/4	20	28	-	4	H3	4.80	9.02	14.36	7	3	-
5/16	18	24	-	4	H3	6.30	12.08	18.90	"F"	"I"	-
3/8	16	24	-	4	H3	8.20	13.76	24.60	5/16	"Q"	-
7/16	14	20	-	4	H3	12.28	18.74	36.84	"U"	25/64	-
1/2	13	20	-	4	H3	12.78	19.68	38.30	27/64	29/64	-
9/16	12	18	-	4	H3	15.76	27.24	47.26	31/64	33/64	-
5/8	11	18	-	4	H3	19.70	30.84	59.10	17/32	37/64	-
11/16	-	-	11	4	H3	23.10	33.60	69.30	-	-	19/32
11/16	-	-	16	4	H3	23.10	33.60	69.30	-	-	5/8
3/4	10	16	-	4	H3	26.72	39.66	80.14	21/32	11/16	-
7/8	9	14	-	4	H4	36.94	55.04	110.82	49/64	13/16	-
1	8	12	14	4	H4	56.46	83.40	169.34	7/8	15/16	59/64
1-1/8	7	12	-	4	H4	84.28	138.04	252.82	63/64	1-3/64	-
1-1/4	7	12	-	4-6	H4	106.92	160.66	320.72	1-7/64	1-11/64	-
1-3/8	6	12	-	4-6	H4	134.42	188.16	403.26	1-7/32	1-19/64	-
1-1/2	6	12	-	4-6	H4	169.12	222.86	507.34	1-11/32	1-27/64	-
1-3/4	5	-	-	6	H4	-	-	-	1-9/16	-	-
2	4-1/2	-	-	6	H4	-	-	-	1-25/32	-	-
2-1/4	4-1/2	-	-	6	H6	-	-	-	2-1/32	-	-
2-1/2	4	-	-	6	H6	-	-	-	2-1/4	-	-
3	4	-	-	6	H10	-	-	-	2-3/4	-	-
3-1/2	4	-	-	6	H10	-	-	-	3-1/4	-	-

* **SHT & SHTT** - Please specify Threads Per Inch & Taper (T), Plug (P) or Bottoming (B) chamfer.

Examples: SHT#06-32T, SHT#06-32P, SHT#06-32B.

SHTS - Please specify Threads Per Inch. 3 piece sets contain 1 each of Taper, Plug, and Bottom chamfer taps.

PITCH DIAMETER LIMIT SYMBOLS
H: (High) Pitch Dia. is above basic. The number following "H" is the number of .0005" steps above the basic pitch diameter. Taps larger than 1" dia. have .0010" steps.
LIMITS FOR TAPS TO 1" DIAMETER
H1 = Basic to Basic + .0005"
H2 = Basic + .0005" to basic + .0010"
H3 = Basic + .0010" to basic + .0015"
H4 = Basic + .0015" to basic + .0020"
LIMITS FOR TAPS TO 1" DIAMETER
H4 = Basic + .001" to basic .002"

PACKAGING

#6 to 1/2 - 12 taps/box
 9/16 to 1 - 3 taps/box
 1-1/8 to 1-3/4 - 1 tap/tube

THREAD FORM SYMBOLS
NC American National Coarse Thread Series
UNC Unified Coarse Thread Series
NF American National Fine Thread Series
UNF Unified Fine Thread Series
NS American National Thread - Special