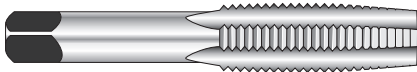


HIGH SPEED STEEL - TITANIUM NITRIDE COATED  
**STANDARD HAND TAPS**

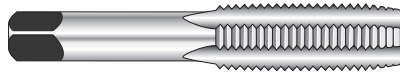
ICS WIS

GENERAL PURPOSE

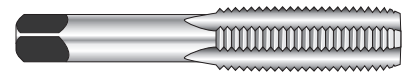
GROUND THREAD



**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.	PRICE EACH			TAP DRILL SIZE APPROXIMATELY 75% THREAD		
	NC UNC	NF UNF	NS	OF	HIGH SPEED STEEL			TIN COATED					
					TAPER, PLUG or BOTTOMING			TAPER, PLUG & BOTTOMING (3 PC SET)	TAPER, PLUG or BOTTOMING				
					SHT			SHTS	SHTT				
0	-	80	-	2	H1	11.60	34.78	13.94	-	3/64	-		
1	64	72	-	2	H1	10.78	32.32	13.12	53	53	-		
2	56	64	-	3	H2	8.82	26.46	11.18	50	50	-		
3	48	56	-	3	H2	7.18	21.56	9.54	47	45	-		
4	40	48	36	3	H2	5.66	18.90	8.00	43	44	42		
5	40	44	-	3	H2	5.66	16.96	8.00	38	37	-		
6	32	40	-	3	H3	4.24	12.74	6.48	36	33	-		
8	32	36	-	4	H3	4.58	13.74	8.68	29	29	-		
10	24	32	-	4	H3	4.58	13.74	8.68	25	21	-		
12	24	28	-	4	H3	6.14	18.40	10.36	16	14	-		
1/4	20	28	-	4	H3	4.80	14.36	9.02	7	3	-		
5/16	18	24	-	4	H3	6.30	18.90	12.08	"F"	"I"	-		
3/8	16	24	-	4	H3	7.36	22.06	12.94	5/16	"Q"	-		
7/16	14	20	-	4	H3	11.16	33.46	17.62	"U"	25/64	-		
1/2	13	20	-	4	H3	12.78	38.30	19.68	27/64	29/64	-		
9/16	12	18	-	4	H3	15.76	47.26	27.24	31/64	33/64	-		
5/8	11	18	-	4	H3	19.70	59.10	30.84	17/32	37/64	-		
11/16	-	-	11	4	H3	23.10	69.30	33.60	-	-	19/32		
11/16	-	-	16	4	H3	23.10	69.30	33.60	-	-	5/8		
3/4	10	16	-	4	H3	26.72	80.14	39.66	21/32	11/16	-		
7/8	9	14	-	4	H4	36.94	110.82	55.04	49/64	13/16	-		
1	8	12	14	4	H4	56.46	169.34	83.40	7/8	15/16	59/64		
1-1/8	7	12	-	4	H4	84.28	252.82	138.04	63/64	1-3/64	-		
1-1/4	7	12	-	4-6	H4	106.92	320.72	160.66	1-7/64	1-11/64	-		
1-3/8	6	12	-	4-6	H4	134.42	403.26	188.16	1-7/32	1-19/64	-		
1-1/2	6	12	-	4-6	H4	169.12	507.34	222.86	1-11/32	1-27/64	-		
1-3/4	5	-	-	6	H4				1-9/16	-	-		
2	4-1/2	-	-	6	H4	CALL	CALL	CALL	1-25/32	-	-		
2-1/4	4-1/2	-	-	6	H6	FOR	FOR	FOR	2-1/32	-	-		
2-1/2	4	-	-	6	H6	PRICE	PRICE	PRICE	2-1/4	-	-		
3	4	-	-	6	H10				2-3/4	-	-		
3-1/2	4	-	-	6	H10				3-1/4	-	-		

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
<b>NC</b> American National Coarse Thread Series
<b>UNC</b> Unified Coarse Thread Series
<b>NF</b> American National Fine Thread Series
<b>UNF</b> Unified Fine Thread Series
<b>NS</b> American National Thread - Special

• Please specify Taper (T), Plug (P) or Bottoming (B) chamfer. Examples: SHT#06-32T, SHT#06-32P, SHT#06-32B.