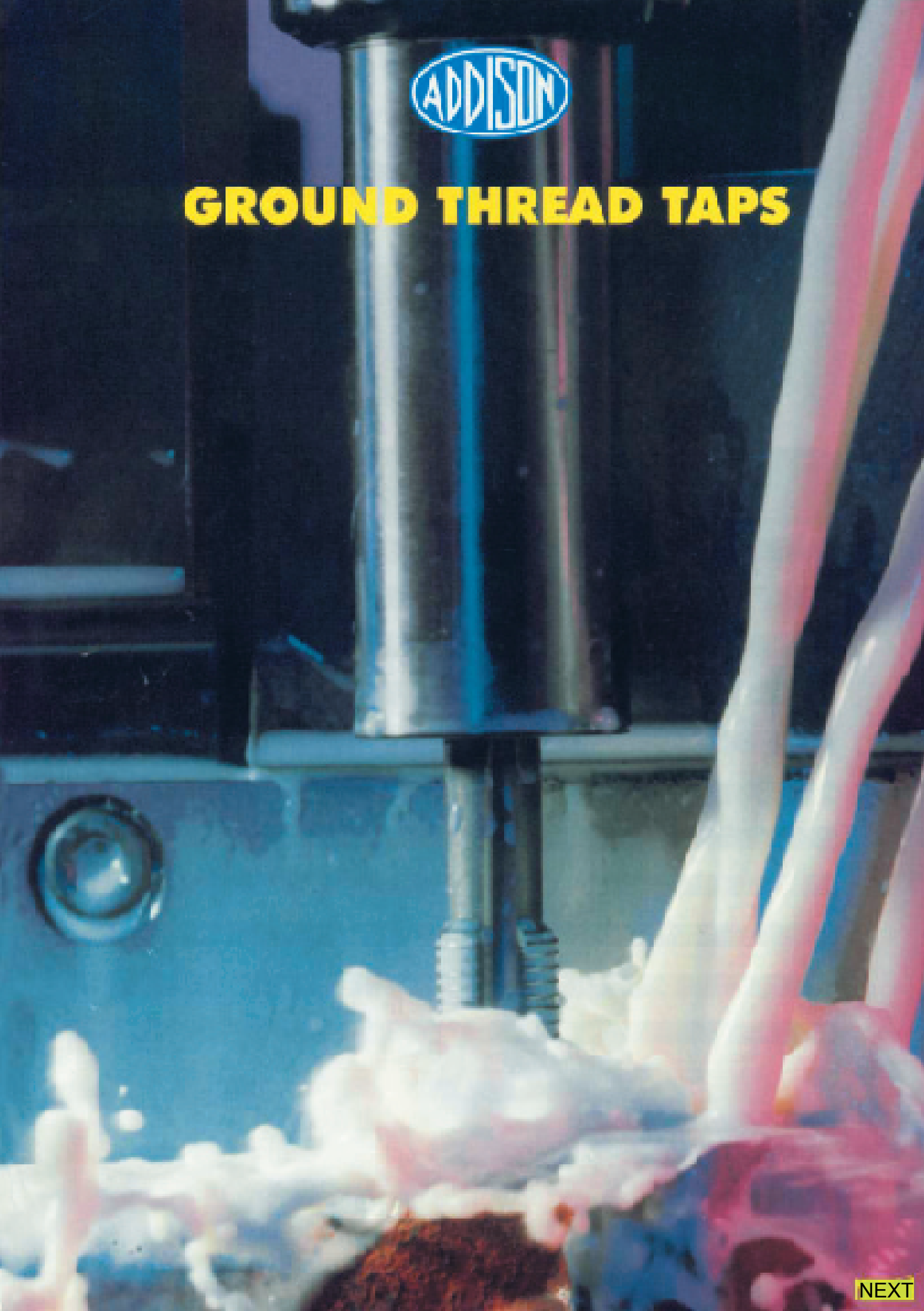




GROUND THREAD TAPS



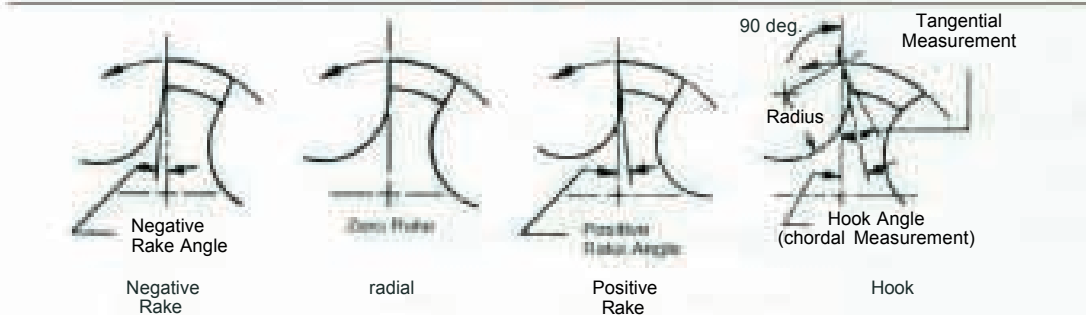
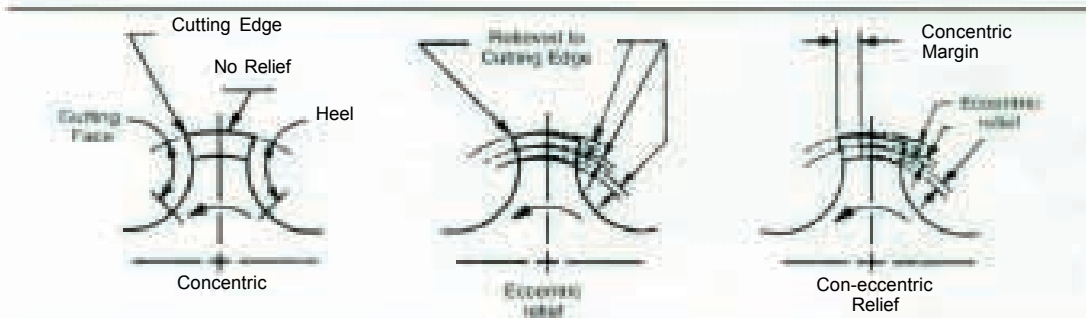
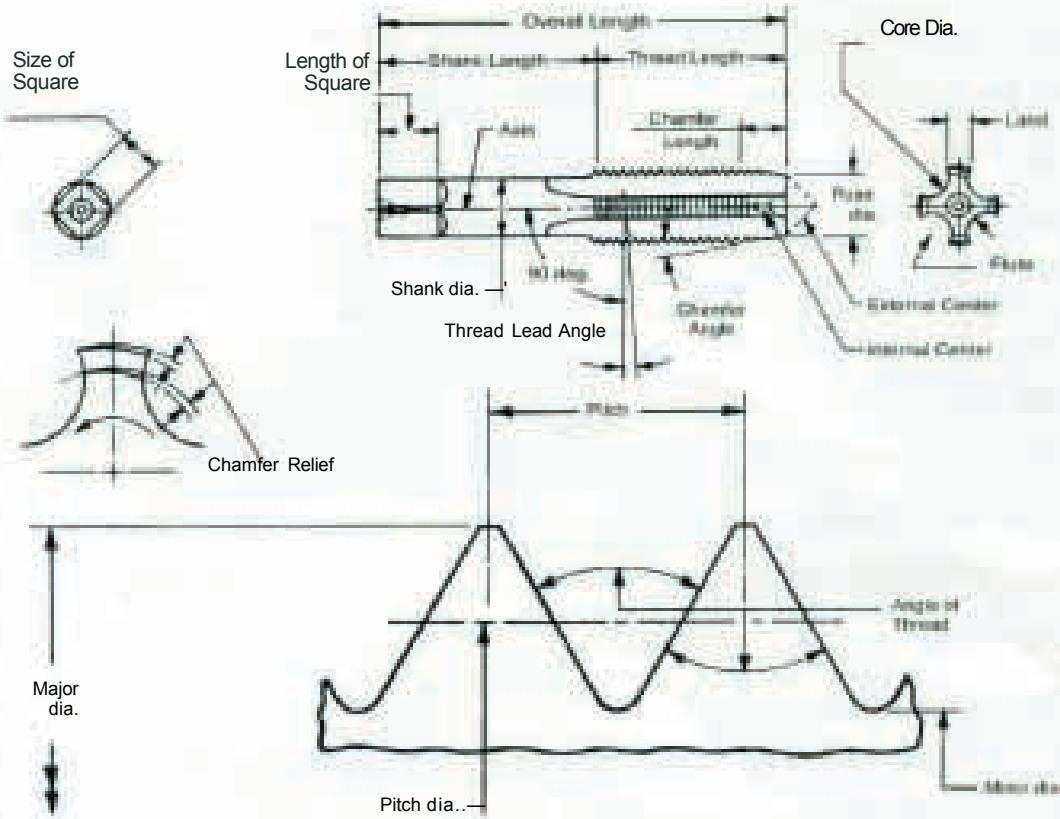
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SCREWING TAPS - NOMENCLATURE





High Speed Steel GROUND THREAD HAND AND SHORT MACHINE SCREWING TAPS For ISO Metric Screw Threads

Specifications conform to
IS 6175 : Part 2 : 1992

Dimensions in mm

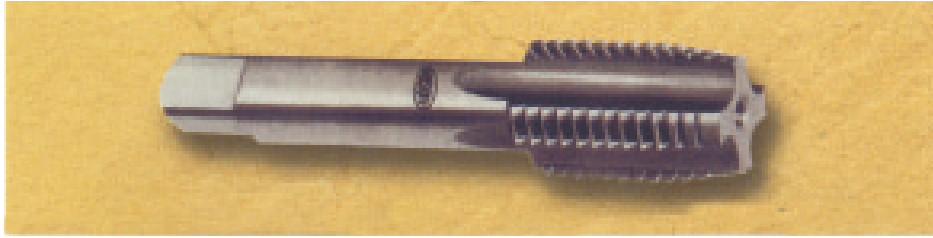


TABLE I : ISO Metric Screw Threads Coarse Pitch

Nominal Diameter	Pitch	Thread Length	Overall Length	Shank Dia	Square Size
3.0	0.50	11	48	3.15	2.50
4.0	0.70	13	53	4.00	3.15
4.5	0.75	13	53	4.50	3.55
5.0	0.80	16	58	5.00	4.00
6.0	1.00	19	66	6.30	5.00
7.0	1.00	19	66	7.10	5.60
8.0	1.25	22	72	8.00	6.30
9.0	1.25	22	72	9.00	7.10
10.0	1.50	24	80	10.00	8.00

TABLE II : ISO Metric Screw Threads Fine Pitch

Nominal Diameter	Pitch	Thread Length	Overall Length	Shank Dia	Square Size
4.0	0.50	13	53	4.0	3.15
4.5	0.50	13	53	4.5	3.55
5.0	0.50	16	58	5.0	4.00
5.5	0.50	17	62	5.6	4.50
6.0	0.75	19	66	6.3	5.00
7.0	0.75	19	66	7.1	5.60
8.0	0.75	16	66	8.0	6.30
8.0	1.00	19	69	8.0	6.30
9.0	0.75	16	66	9.0	7.10
9.0	1.00	19	69	9.0	7.10
10.0	0.75	17	73	10.0	8.00
10.0	1.00	20	76	10.0	8.00
10.0	1.25	20	76	10.0	8.00

Manufactured with straight flutes and a shank with square for driving,

- 1) Unless otherwise specified, the Screwing taps shall be supplied with tolerance class '6H', non-serial and with Straight flutes.
- 2) Usually supplied in sets consisting of three taps, viz. Taper, Second and Bottoming for Coarse Pitch and Taper and Bottoming for Fine Pitch



High Speed Steel GROUND THREAD HAND AND SHORT MACHINE SCREWING TAPS For ISO Metric Coarse Pitch Threads

Specifications conform to
IS 6175 : Part 3 : 1992

Dimensions in mm



Nominal Diameter	Pitch	Thread Length	Overall Length	Shank Dia	Square Size
11	1.50	25	85	8.0	6.3
12	1.75	29	89	9.0	7.1
14	2.00	30	95	11.2	9.0
16	2.00	32	102	12.5	10.0
18	2.50	37	112	14.0	11.2
20	2.50	37	112	14.0	11.2
22	2.50	38	118	16.0	12.5
24	3.00	45	130	18.0	14.0
27	3.00	45	135	20.0	16.0
30	3.50	48	138	20.0	16.0
33	3.50	51	151	22.4	18.0

Nominal Diameter	Pitch	Thread Length	Overall Length	Shank Dia	Square Size
36	4.00	57	162	25.0	20.0
39	4.00	60	170	28.0	22.4
42	4.50	60	170	28.0	22.4
45	4.50	67	187	31.5	25.0
48	5.00	67	187	31.5	25.0
52	5.00	70	200	35.5	28.0
56	5.50	70	200	35.5	28.0
60	5.50	76	221	40.0	31.5
64	6.00	79	224	40.0	31.5
68	6.00	79	234	45.0	35.5

- 1) Unless otherwise specified, the Screwing taps shall be supplied with tolerance class '6H', Non-Serial and with Straight flutes.
- 2) Usually supplied in sets consisting of three taps viz, Taper, Second and Bottoming.



High Speed Steel GROUND THREAD HAND AND SHORT MACHINE SCREWING TAPS For ISO Metric Fine Pitch Threads

Specifications conform to
IS 6175 : Part 3 : 1992

Dimensions in mm



Nominal Diameter	Pitch	Thread Length	Overall Length	Shank Dia	Square Size
11	0.75	20	80	8.0	6.3
11	1.00	20	80	8.0	6.3
12	1.00	20	80	9.0	7.1
12	1.25	24	84	9.0	7.1
12	1.50	29	89	9.0	7.1
14	1.00	22	87	11.2	9.0
14	1.25	25	90	11.2	9.0
14	1.50	30	95	11.2	9.0
15	1.00	22	87	11.2	9.0
15	1.50	30	95	11.2	9.0
16	1.00	22	92	12.5	10.0
16	1.50	32	102	12.5	10.0
17	1.00	22	92	12.5	10.0
17	1.50	32	102	12.5	10.0
18	1.00	22	97	14.0	11.2
18	1.50	29	104	14.0	11.2
18	2.00	37	112	14.0	11.2
20	1.00	27	102	14.0	11.2
20	1.50	29	104	14.0	11.2
20	2.00	37	112	14.0	11.2
22	1.00	29	109	16.0	12.5
22	1.50	33	113	16.0	12.5

Nominal Diameter	Pitch	Thread Length	Overall Length	Shank Dia	Square Size
22	2.00	38	118	16.0	12.5
24	1.00	29	114	18.0	14.0
24	1.50	35	120	18.0	14.0
24	2.00	35	120	18.0	14.0
25	1.00	29	114	18.0	14.0
25	1.50	35	120	18.0	14.0
25	2.00	35	120	18.0	14.0
26	1.50	35	120	18.0	14.0
27	1.00	30	120	20.0	16.0
27	1.50	37	127	20.0	16.0
27	2.00	37	127	20.0	16.0
28	1.00	30	120	20.0	16.0
28	1.50	37	127	20.0	16.0
28	2.00	37	127	20.0	16.0
30	1.00	30	120	20.0	16.0
30	1.50	37	127	20.0	16.0
30	2.00	37	127	20.0	16.0
30	3.00	48	138	20.0	16.0
32	1.50	37	137	22.4	18.0
32	2.00	37	137	22.4	18.0
33	1.50	37	137	22.4	18.0
33	2.00	37	137	22.4	18.0

Manufactured with straight flutes and a shank with square for driving.



High Speed Steel GROUND THREAD HAND AND SHORT MACHINE SCREWING TAPS For ISO Metric Fine Pitch Threads

Specifications conform to
IS 6175 : Part 3 : 1992

Dimensions in mm



Nominal Diameter	Pitch	Thread Length	Overall Length	Shank Dia	Square Size
33	3.0	51	151	22.4	18.0
35	1.5	39	144	25.0	20.0
36	1.5	39	144	25.0	20.0
36	2.0	39	144	25.0	20.0
36	3.0	57	162	25.0	20.0
38	1.5	39	149	28.0	22.4
39	1.5	39	149	28.0	22.4
39	2.0	39	149	28.0	22.4
39	3.0	60	170	28.0	22.4
40	1.5	39	149	28.0	22.4
40	2.0	39	149	28.0	22.4
40	3.0	60	170	28.0	22.4
42	1.5	39	149	28.0	22.4
42	2.0	39	149	28.0	22.4
42	3.0	60	170	28.0	22.4
42	4.0	60	170	28.0	22.4
45	1.5	45	165	31.5	25.0
45	2.0	45	165	31.5	25.0
45	3.0	67	187	31.5	25.0
45	4.0	67	187	31.5	25.0
48	1.5	45	165	31.5	25.0
48	2.0	45	165	31.5	25.0
48	3.0	67	187	31.5	25.0
48	4.0	67	187	31.5	25.0
50	1.5	45	165	31.5	25.0
50	2.0	45	165	31.5	25.0
50	3.0	67	187	31.5	25.0
52	1.5	45	175	35.5	28.0
52	2.0	45	175	35.5	28.0
52	3.0	70	200	35.5	28.0
52	4.0	70	200	35.5	28.0
55	1.5	45	175	35.5	28.0

Nominal Diameter	Pitch	Thread Length	Overall Length	Shank Dia	Square Size
55	2.0	45	175	35.5	28.0
55	3.0	70	200	35.5	28.0
55	4.0	70	200	35.5	28.0
56	1.5	45	175	35.5	28.0
56	2.0	45	175	35.5	28.0
56	3.0	70	200	35.5	28.0
56	4.0	70	200	35.5	28.0
58	1.5	48	193	40.0	31.5
58	2.0	48	193	40.0	31.5
58	3.0	64	209	40.0	31.5
58	4.0	64	209	40.0	31.5
60	1.5	48	193	40.0	31.5
60	2.0	48	193	40.0	31.5
60	3.0	64	209	40.0	31.5
60	4.0	64	209	40.0	31.5
62	1.5	48	193	40.0	31.5
62	2.0	48	193	40.0	31.5
62	3.0	64	209	40.0	31.5
62	4.0	64	209	40.0	31.5
64	1.5	48	193	40.0	31.5
64	2.0	48	193	40.0	31.5
64	3.0	64	209	40.0	31.5
64	4.0	64	209	40.0	31.5
65	1.5	48	193	40.0	31.5
65	2.0	48	193	40.0	31.5
65	3.0	64	209	40.0	31.5
65	4.0	64	209	40.0	31.5
68	1.5	48	203	45.0	35.5
68	2.0	48	203	45.0	35.5
68	3.0	64	219	45.0	35.5
68	4.0	64	219	45.0	35.5
70	1.5	48	203	45.0	35.5



High Speed Steel GROUND THREAD HAND AND SHORT MACHINE SCREWING TAPS For ISO Metric Fine Pitch Threads

Specifications conform to
IS 6175 : Part 3 : 1992

Dimensions in mm



Nominal Diameter	Pitch	Thread Length	Overall Length	Shank Dia	Square Size
70	2.0	48	203	45	35.5
70	3.0	64	219	45	35.5
70	4.0	64	219	45	35.5
70	6.0	79	234	45	35.5
72	1.5	48	203	45	35.5
72	2.0	48	203	45	35.5
72	3.0	64	219	45	35.5
72	4.0	64	219	45	35.5
72	6.0	79	234	45	35.5
75	1.5	48	203	45	35.5
75	2.0	48	203	45	35.5
75	3.0	64	219	45	35.5
75	4.0	64	219	45	35.5
76	1.5	51	226	50	40.0
76	2.0	51	226	50	40.0
76	3.0	67	242	50	40.0
76	4.0	67	242	50	40.0
76	6.0	83	258	50	40.0
78	2.0	51	226	50	40.0
80	1.5	51	226	50	40.0
80	2.0	51	226	50	40.0

Nominal Diameter	Pitch	Thread Length	Overall Length	Shank Dia	Square Size
80	3.0	67	242	50	40.0
80	4.0	67	242	50	40.0
80	6.0	83	258	50	40.0
82	2.0	51	226	50	40.0
85	2.0	51	226	50	40.0
85	3.0	67	242	50	40.0
85	4.0	67	242	50	40.0
85	6.0	86	261	50	40.0
90	2.0	51	226	50	40.0
90	3.0	67	242	50	40.0
90	4.0	67	242	50	40.0
90	6.0	86	261	50	40.0
95	2.0	54	244	56	45.0
95	3.0	70	260	56	45.0
95	4.0	70	260	56	45.0
95	6.0	89	279	56	45.0
100	2.0	54	244	56	45.0
100	3.0	70	260	56	45.0
100	4.0	70	260	56	45.0
100	6.0	89	279	56	45.0

- 1) Unless otherwise specified, the Screwing taps shall be supplied with tolerance class '6H', Non-Serial and with Straight flutes.
- 2) Usually supplied in sets consisting of two taps viz. Taper and Bottoming.



High Speed Steel GROUND THREAD HAND TAPS BSW Form

Specifications conform to
BS 949 : Part 2 : 1979
(Class 2, Corresponds to Zone 3)

Dimensions in inch / mm



Nominal Diameter Inch	Thread per Inch	Thread Length mm	Overall Length mm	Shank Dia mm	Square Size mm
3/16	24	16	58	5.00	4.00
1/4	20	19	66	6.30	5.00
5/16	18	22	72	8.00	6.30
3/8	16	24	80	10.00	8.00
7/16	14	25	85	8.00	6.30
1/2	12	29	89	9.00	7.10
9/16	12	30	95	11.20	9.00
5/8	11	32	102	12.50	10.00
11/16	11	37	112	14.00	11.20
3/4	10	37	112	14.00	11.20
7/8	9	38	118	16.00	12.50

Nominal Diameter Inch	Thread per Inch	Thread Length mm	Overall Length mm	Shank Dia mm	Square Size mm
1	8	45	130	18.0	14.0
1.1/8	7	48	138	20.0	16.0
1.1/4	7	51	151	22.4	18.0
1.3/8	6	57	162	25.0	20.0
1.1/2	6	60	170	28.0	22.4
1.3/4	5	67	187	31.5	25.0
2	4.1/2	70	200	35.5	28.0
2.1/4	4	76	221	40.0	31.5
2.1/2	4	79	224	40.0	31.5
2.3/4	3.1/2	79	234	45.0	35.5
3	3.1/2	83	258	50.0	40.0

Taps upto and including 3/8" dia. are supplied with full diameter shank and a neck between threaded portion and shank

Manufactured with straight flutes and a shank with square for driving.

Usually supplied in sets consisting of three taps, viz. Taper, Second and Bottoming.



High Speed Steel GROUND THREAD HAND TAPS BSF Form

Specifications conform to
BS 949 : Part 2 : 1979
(Class 2, Corresponds to Zone 3)

Dimensions in inch / mm



Nominal Diameter Inch	Thread per Inch	Thread Length mm	Overall Length mm	Shank Dia mm	Square Size mm
3/16	32	16	58	5.00	4.00
1/4	26	19	66	6.30	5.00
5/16	22	22	72	8.00	6.30
3/8	20	24	80	10.00	8.00
7/16	18	25	85	8.00	6.30
1/2	16	29	89	9.00	7.10
9/16	16	30	95	11.20	9.00
5/8	14	32	102	12.50	10.00
11/16	14	37	112	14.00	11.20
3/4	12	37	112	14.00	11.20
7/8	11	38	118	16.00	12.50
1	10	45	130	18.00	14.00

Nominal Diameter Inch	Thread per Inch	Thread Length mm	Overall Length mm	Shank Dia mm	Square Size mm
1.1/8	9	48	138	20.0	16.0
1.1/4	9	51	151	22.4	18.0
1.3/8	8	57	162	25.0	20.0
1.1/2	8	60	170	28.0	22.4
1.5/8	8	60	170	28.0	22.4
1.3/4	7	67	187	31.5	25.0
2	7	70	200	35.5	28.0
2.1/4	6	76	221	40.0	31.5
2.1/2	6	79	224	40.0	31.5
2.3/4	6	79	234	45.0	35.5
3	5	83	258	50.0	40.0

Taps upto and including 3/8" dia. are supplied with full diameter shank and a neck between threaded portion and shank

Manufactured with straight flutes and a shank with square for driving

Usually supplied in sets consisting of three taps viz., Taper, Second and Bottoming.



High Speed Steel GROUND THREAD HAND TAPS UNC Form

Specifications conform to
BS 949 : Part 2 : 1979
(Class 2, Corresponds to Zone 3)

Dimensions in inch / mm



Nominal Diameter Inch	Thread per Inch	Thread Length mm	Overall Length mm	Shank Dia mm	Square Size mm
1/4	20	19	66	6,3	5.0
5/16	18	22	72	8.0	6.3
3/8	16	24	80	10.0	8.0
7/16	14	25	85	8.0	6.3
1/2	13	29	89	9.0	7.1
9/16	12	30	95	11.2	9.0
5/8	11	32	102	12.5	10.0
3/4	10	37	112	14.0	11.2
7/8	9	38	118	16.0	12.5
1	8	45	130	18.0	14.0

Nominal Diameter Inch	Thread per Inch	Thread Length mm	Overall Length mm	Shank Dia mm	Square Size mm
1.1/8	7	48	138	20.0	16.0
1.1/4	7	51	151	22.4	18.0
1.3/8	6	57	162	25.0	20.0
1.1/2	6	60	170	28.0	22.4
1.3/4	5	67	187	31.5	25.0
2	4.1/2	70	200	35.5	28.0
2.1/4	4.1/2	76	221	40.0	31.5
2.1/2	4	79	224	40.0	31.5
2.3/4	4	79	234	45.0	35.5
3	4	83	258	50.0	40.0

Taps upto and including 3/8" dia. are supplied with full diameter shank and a neck between threaded portion and shank

Manufactured with straight flutes and a shank with square for driving

Usually supplied in sets consisting of three taps viz., Taper, Second and Bottoming.



High Speed Steel GROUND THREAD HAND TAPS UNF Form

Specifications conform to
BS 949 : Part 2 : 1979
(Class 2, Corresponds to Zone 3)

Dimensions in inch / mm



Nominal Diameter Inch	Thread per Inch	Thread Length mm	Overall Length mm	Shank Dia mm	Square Size mm
1/4	28	19	66	6.3	5.0
5/16	24	19	69	8.0	6.3
3/8	24	20	76	10.0	8.0
7/16	20	22	82	8.0	6.3
1/2	20	24	84	9.0	7.1
9/16	18	25	90	11.2	9.0
5/8	18	25	95	12.5	10.0

Nominal Diameter Inch	Thread per Inch	Thread Length mm	Overall Length mm	Shank Dia mm	Square Size mm
3/4	16	29	104	14.0	11.2
7/8	14	33	113	16.0	12.5
1	12	35	120	18.0	14.0
1.1/8	12	37	127	20.0	16.0
1.1/4	12	37	137	22.4	18.0
1.3/8	12	39	144	25.0	20.0
1.1/2	12	39	149	28.0	22.4

Taps upto and including 3/8" dia. are supplied with full diameter shank and a neck between threaded portion and shank

Manufactured with straight flutes and a shank with square for driving

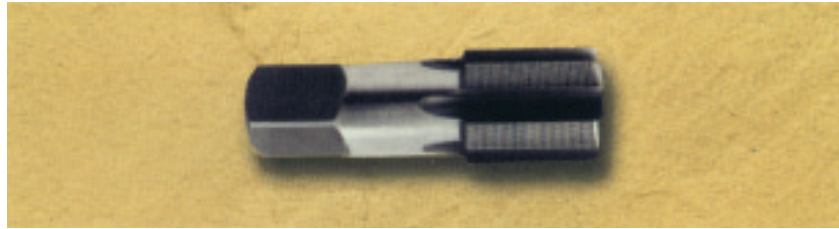
Usually supplied in sets consisting of three taps viz., Taper, Second and Bottoming.



High Speed Steel GROUND THREAD HAND TAPS BSCY Form

Specifications conform to
BS 949 : 1951
(Zone 3)

Dimensions in Inches



Nominal Diameter	Threads per Inch	Thread Length	Overall Length	Shank Dia	Square Size
1/4	26	1	2.1/2	0.253	0.197
5/16	26	1.1/8	2.3/4	0.315	0.242
3/8	26	1.1/4	2.15/16	0.377	0.294
7/16	26	1.1/4	3	0.323	0.242
1/2	26	1.1/4	3	0.367	0.275
9/16	26	1.1/4	3	0.429	0.322
5/8	26	1.1/4	3	0.480	0.360
11/16	26	1.1/4	3	0.542	0.406
3/4	26	1.1/2	3.1/4	0.590	0.442

Nominal Diameter	Threads per Inch	Thread Length	Overall Length	Shank Dia	Square Size
7/8	24	1.1/2	3.1/4	0.697	0.523
1	24	1.1/2	3.1/4	0.800	0.600
1.1/8	26	1.1/2	4	0.896	0.672
1.290	24	1.1/2	4	1.021	0.766
1.370	24	1.1/2	4	1.108	0.831
1.450	26	1.1/2	4	1.233	0.925
1.9/16	24	2	5	1.305	0.979
1.5/8	24	2	5	1.305	0.979

Manufactured with straight flutes and a shank with square for driving

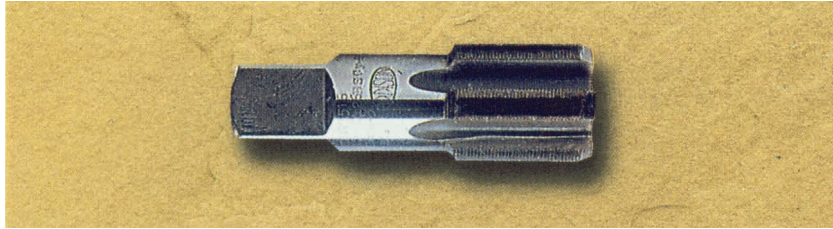
Usually supplied in sets consisting of three taps viz., Taper, Second and Bottoming.



High Speed Steel GROUND THREAD HAND TAPS BS Conduit Form

Specifications conform to
BS 949 :1951
(Zone 3)

Dimensions in Inches



Nominal Diameter	Threads per Inch	Thread Length	Overall Length	Shank Dia	Square Size
1/2	18	1.1/4	3	0.367	0.275
5/8	18	1.1/4	3	0.480	0.360
3/4	16	1.1/2	3.1/4	0.590	0.442
1	16	1.1/2	3.1/4	0.800	0.600

Nominal Diameter	Threads per Inch	Thread Length	Overall Length	Shank Dia	Square Size
1.1/4	16	1.1/2	4	1.021	0.766
1.1/2	14	1.1/2	4	1.233	0.925
2	14	2	5	1.644	1.233
2.1/2	14	2	5.1/4	2.100	1.575

Manufactured with whit worth thread form with straight flutes and a shank with square for driving

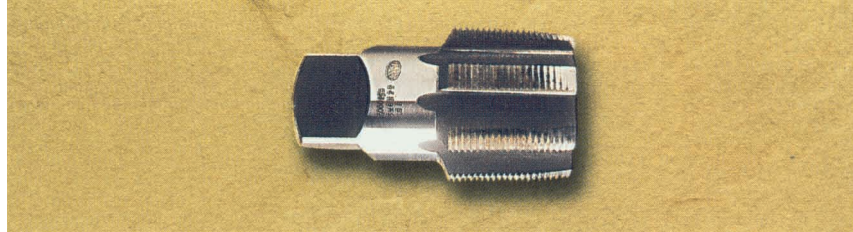
Usually supplied in sets consisting of three taps viz., Taper, Second and Bottoming.



High Speed Steel GROUND THREAD HAND TAPS BS (Parallel)

Specifications conform to
BS 949 :1951
(Zone 3)

Dimensions in Inches



Nominal Size	Threads per Inch	Thread Length	Overall Length	Shank Dia	Square Size
1/8	28	3/4	2.1/8	0.318	0.238
1/4	19	1.1/16	2.7/16	0.429	0.322
3/8	19	1.1/16	2.9/16	0.542	0.406
1/2	14	1.3/8	3.1/8	0.687	0.515
5/8	14	1.3/8	3.3/16	0.800	0.600
3/4	14	1.3/8	3.1/4	0.906	0.679
7/8	14	1.9/16	3.1/2	1.093	0.812
1	11	1.3/4	3.3/4	1.125	0.843
1.1/4	11	1.3/4	4	1.312	0.984

Nominal Size	Threads per Inch	Thread Length	Overall Length	Shank Dia	Square Size
1.1/2	11	1.3/4	4.1/4	1.500	1.125
1.3/4	11	1.3/4	4.3/8	1.625	1.218
2	11	1.3/4	4.1/2	1.875	1.406
2.1/4	11	2.1/8	5	2.000	1.500
2.1/2	11	2.9/16	5.1/2	2.250	1.687
2.3/4	11	2.9/16	5.3/4	2.375	1.781
3	11	2.5/8	6	2.625	1.968
3.1/2	11	2.11/16	6.1/2	2.812	2.108
4	11	2.3/4	6.3/4	3.000	2.250

Manufactured with whit worth thread form with straight flutes and a shank with square for driving

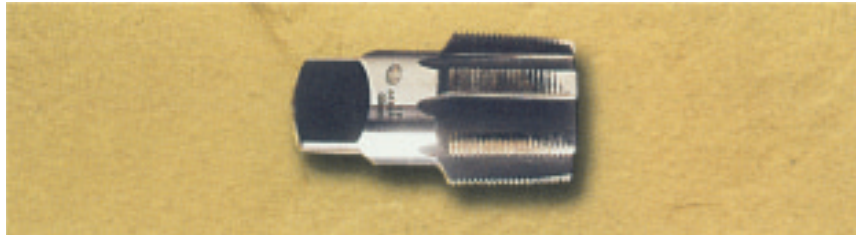
Usually supplied in sets consisting of two taps viz., Taper and Bottoming.



High Speed Steel GROUND THREAD HAND TAPS BSP (Parallel) 'G' Series

Specifications conform to
BS 949 :Part3 : 1982

Dimensions in inch / mm



Nominal Diameter inch	Threads per inch	Thread Length mm	Overall Length mm	Shank Dia mm	Square Size mm
1/8	28	15	59	8.0	6.3
1/4	19	19	67	10.0	8.0
3/8	19	21	75	12.5	10.0
1/2	14	26	87	16.0	12.5
5/8	14	26	91	18.0	14.0
3/4	14	28	96	20.0	16.0
7/8	14	29	102	22.4	18.0
1	11	33	109	25.0	20.0
1.18	11	34	115	28.0	22.4
1.14	11	36	119	31.5	25.0

Nominal Diameter inch	Threads per Inch	Thread Length mm	Overall Length mm	Shank Dia mm	Square Size mm
1.1/2	11	37	125	35.5	28.0
1.3/4	11	39	132	35.5	28.0
2	11	41	140	40.0	31.5
2.1/4	11	42	142	40.0	31.5
2.1/2	11	45	153	45.0	35.5
2.3/4	11	46	160	50.0	40.0
3	11	48	164	50.0	40.0
3.1/2	11	50	173	63.0	50.0
4	11	53	185	71.0	56.0

Manufactured with whit worth thread form with straight flutes and a shank with square for driving

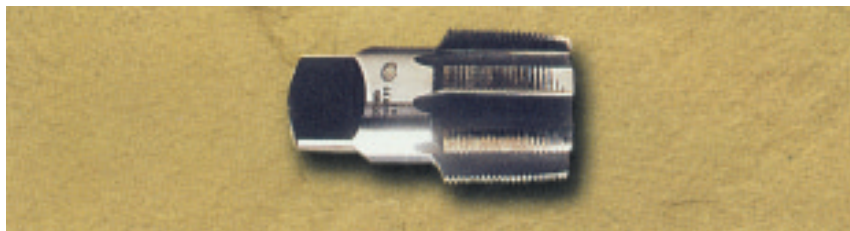
Usually supplied in sets consisting of two taps viz., Taper and Bottoming.



High Speed Steel GROUND THREAD HAND TAPS BSP (Taper) Rc Series

Specifications conform to
BS 949 : Part 3 : 1982

Dimensions in inch / mm



Nominal Diameter Inch	Threads per Inch	Thread Length mm	Overall Length mm	Shank Dia mm	Square Size mm
1/8	28	15	59	8.0	6.3
1/4	19	19	67	10.0	8.0
3/8	19	21	75	12.5	10.0
1/2	14	26	87	16.0	12.5
3/4	14	28	96	20.0	16.0
1	11	33	109	25.0	20.0

Nominal Diameter Inch	Threads per Inch	Thread Length mm	Overall Length mm	Shank Dia mm	Square Size mm
1.1/4	11	36	119	31.5	25.0
1.1/2	11	37	125	35.5	28.0
2	11	41	140	40.0	31.5
2.1/2	11	45	153	45.0	35.5
3	11	48	164	50.0	40.0
4	11	53	185	71.0	56.0

Manufactured with straight flutes and a shank with square for driving

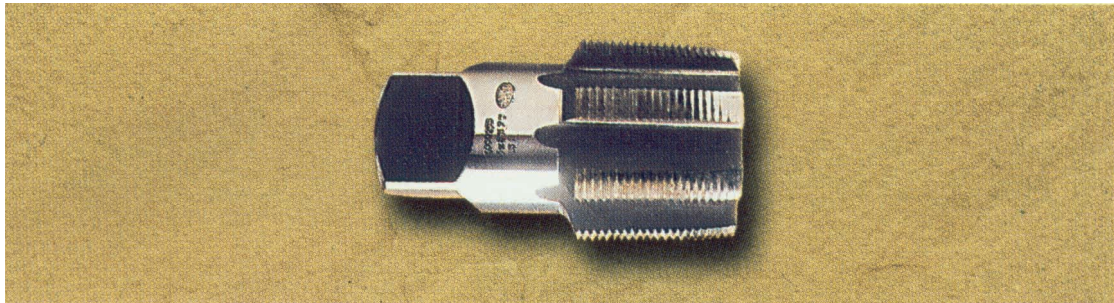
Usually supplied in sets consisting of two taps viz., Taper and Bottoming,



High Speed Steel
GROUND THREAD HAND TAPS
American National Taper Pipe Taps (NPT)

Specifications conform to
BS 949 : 1969

Dimensions in inches



Nominal Size	Threads per Inch	Thread Length	Overall Length	Shank Dia	Square Size
1/8	27	3/4	2.1/8	0.318	0.238
1/4	18	1.1/16	2.7/16	0.429	0.322
3/8	18	1.1/16	2.9/16	0.542	0.406
1/2	14	1.3/8	3.1/8	0.687	0.515
3/4	14	1.3/8	3.1/4	0.906	0.679
1	11.1/2	1.3/4	3.3/4	1.125	0.843
1.1/4	11.1/2	1.3/4	4	1.312	0.984

Nominal Size	Threads per Inch	Thread Length	Overall Length	Shank Dia	Square Size
1.1/2	11.1/2	1.3/4	4.1/4	1.500	1.125
2	11.1/2	1.3/4	4.1/2	1.875	1.406
2.1/2	8	2.9/16	5.1/2	2.250	1.687
3	8	2.5/8	6	2.625	1.968
3.1/2	8	2.11/16	6.1/2	2.812	2.108
4	8	2.3/4	6.3/4	3.000	2.250

Manufactured with straight flutes and shank with square for driving

Usually supplied in sets consisting of two taps viz., Taper and Bottoming.



**High Speed Steel
GROUND THREAD LONG SHANK
MACHINE SCREWING TAPS
For ISO Metric Coarse Pitch Threads**

Specifications conform to
IS 6175 : Part 4 : 1991

Dimensions in mm



Nominal Diameter	Pitch	Thread Length	Overall Length	Shank Dia	Square Size
6	1.00	19	89.0	4.5	3.55
7	1.00	19	89.0	5.6	4.50
8	1.25	22	97.0	6.3	5.00
9	1.25	22	97.0	7.1	5.60
10	1.50	24	108.0	8.0	6.30
11	1.50	25	115.0	8.0	6.30
12	1.75	29	119.0	9.0	7.10
14	2.00	30	127.0	11.2	9.00
16	2.00	32	137.0	12.5	10.00
18	2.50	37	149.0	14.0	11.20
20	2.50	37	149.0	14.0	11.20
22	2.50	38	158.0	16.0	12.50
24	3.00	45	172.0	18.0	14.00

Nominal Diameter	Pitch	Thread Length	Overall Length	Shank Dia	Square Size
27	3.00	45	180.0	20.0	16.0
30	3.50	48	183.0	20.0	16.0
33	3.50	51	201.0	22.4	18.0
36	4.00	57	214.5	25.0	20.0
39	4.00	60	225.0	28.0	22.4
42	4.50	60	225.0	28.0	22.4
45	4.50	67	247.0	31.5	25.0
48	5.00	67	247.0	31.5	25.0
52	5.00	70	265.0	35.5	28.0
56	5.50	70	265.0	35.5	28.0
60	5.50	76	293.5	40.0	31.5
64	6.00	79	296.5	40.0	31.5
68	6.00	79	311.5	45.0	35.5

Manufactured with straight flutes and a long shank with a driving square for machine tapping.

Type 'A' - 5 Deg. Taper Angle with Long Taper Lead
 Type 'B' - 10 Deg, Taper Angle with Spiral point
 Type 'C' - 20 Deg. Taper Angle with Shorter Taper Lead
 Type 'D' - 10 Deg, Taper Angle without Spiral point

Unless otherwise specified the Screwing Taps shall be supplied with tolerance class 6H.



High Speed Steel
**GROUND THREAD LONG SHANK
 MACHINE SCREWING TAPS**
 For ISO Metric Fine Pitch Threads

Specifications conform to
 IS 6175 : Part 4 : 1991

Dimensions in mm



Nominal Diameter	Pitch	Thread Length	Overall Length	Shank Dia	Square Size
6	0.75	19	89	4.5	3.55
7	0.75	19	89	5.6	4.50
8	0.75	16	91	6.3	5.00
8	1.00	19	97	6.3	5.00
9	0.75	16	94	7.1	5.60
9	1.00	19	97	7.1	5.60
10	0.75	17	104	8.0	6.30
10	1.00	20	108	8.0	6.30
10	1.25	20	108	8.0	6.30
11	0.75	20	110	8.0	6.30
11	1.00	20	110	8.0	6.30
12	1.00	20	110	9.0	7.10
12	1.25	24	119	9.0	7.10
12	1.50	29	119	9.0	7.10
14	1.00	22	124	11.2	9.00
14	1.25	25	127	11.2	9.00
14	1.50	30	127	11.2	9.00
15	1.00	22	124	11.2	9.00
15	1.50	30	127	11.2	9.00
16	1.00	22	127	12.5	10.00
16	1.50	32	137	12.5	10.00
17	1.00	22	127	12.5	10.00

Nominal Diameter	Pitch	Thread Length	Overall Length	Shank Dia	Square Size
17	1.50	32	137	12.5	10.0
18	1.00	22	135	14.0	11.2
18	1.50	29	142	14.0	11.2
18	2.00	37	149	14.0	11.2
20	1.00	27	140	14.0	11.2
20	1.50	29	142	14.0	11.2
20	2.00	37	149	14.0	11.2
22	1.00	29	149	16.0	12.5
22	1.50	33	153	16.0	12.5
22	2.00	38	158	16.0	12.5
24	1.00	29	157	18.0	14.0
24	1.50	35	172	18.0	14.0
24	2.00	35	172	18.0	14.0
25	1.00	29	157	18.0	14.0
25	1.50	35	163	18.0	14.0
25	2.00	35	163	18.0	14.0
26	1.50	35	163	18.0	14.0
26	2.00	35	163	18.0	14.0
27	1.00	30	165	20.0	16.0
27	1.50	37	172	20.0	16.0
27	2.00	37	172	20.0	16.0
28	1.00	30	165	20.0	16.0



High Speed Steel GROUND THREAD LONG SHANK MACHINE SCREWING TAPS For ISO Metric Fine Pitch Threads

Specifications conform to
IS 6175 : Part 4 : 1991

Dimensions in mm



Nominal Diameter	Pitch	Thread Length	Overall Length	Shank Dia	Square Size
28	1.5	37	1720	20.0	16.0
28	2.0	37	1720	20.0	16.0
30	1.0	30	1650	20.0	16.0
30	1.5	37	1720	20.0	16.0
30	2.0	37	1720	20.0	16.0
30	3.0	48	1830	20.0	16.0
32	1.5	37	1870	22.4	18.0
32	2.0	37	1870	22.4	18.0
33	1.5	37	1870	22.4	18.0
33	2.0	37	1870	22.4	18.0
33	3.0	51	2010	22.4	18.0
35	1.5	39	1965	25.0	20.0
36	1.5	39	1965	25.0	20.0
36	2.0	39	1965	25.0	20.0
36	3.0	57	2145	25.0	20.0
38	1.5	39	2040	28.0	22.4
39	1.5	39	2040	28.0	22.4
39	2.0	39	2040	28.0	22.4
39	3.0	60	2250	28.0	22.4
40	1.5	39	2040	28.0	22.4
40	2.0	39	2040	28.0	22.4

Nominal Diameter	Pitch	Thread Length	Overall Length	Shank Dia	Square Size
40	3.0	60	2250	28.0	22.4
42	1.5	39	2040	28.0	22.4
42	2.0	39	2040	28.0	22.4
42	3.0	60	2250	28.0	22.4
42	4.0	60	2250	28.0	22.4
45	1.5	45	2250	31.5	25.0
45	2.0	45	2250	31.5	25.0
45	3.0	67	2470	31.5	25.0
45	4.0	67	2470	31.5	25.0
48	1.5	45	2250	31.5	25.0
48	2.0	45	2250	31.5	25.0
48	3.0	67	2470	31.5	25.0
48	4.0	67	2470	31.5	25.0
50	1.5	45	2250	31.5	25.0
50	2.0	45	2250	31.5	25.0
50	3.0	67	2470	31.5	25.0
52	1.5	45	2400	35.5	28.0
52	2.0	45	2400	35.5	28.0
52	3.0	70	2650	35.5	28.0
52	4.0	70	2650	35.5	28.0

Type 'A' - 5 Deg. Taper Angle with Long Taper Lead
 Type 'B' - 10 Deg. Taper Angle with Spiral point
 Type 'C' - 20 Deg. Taper Angle with Shorter Taper Lead
 Type 'D' - 10 Deg. Taper Angle without Spiral point.

Unless otherwise specified the Screwing Taps shall be supplied with tolerance class 6H.



High Speed Steel

GROUND THREAD NUT SCREWING TAPS

For ISO Metric Coarse Pitch Threads

Specifications conform to
IS 6175 : Part 5 : 1991

Dimensions in mm



Nominal Diameter	Pitch	Thread Length	Overall Length	Shank Dia	Square Size
6	1.00	32	110	4.5	3.55
7	1.00	36	110	5.6	4.50
8	1.25	40	125	6.3	5.00
9	1.25	40	140	7.1	5.60
10	1.50	45	140	8.0	6.30
11	1.50	45	160	8.0	6.30
12	1.75	50	180	9.0	7.10
14	2.00	56	200	11.2	9.00
16	2.00	63	200	12.5	10.00
18	2.50	63	220	14.0	11.20
20	2.50	70	250	14.0	11.20

Nominal Diameter	Pitch	Thread Length	Overall Length	Shank Dia	Square Size
22	2.50	80	280	16.0	12.5
24	3.00	80	280	18.0	14.0
27	3.00	90	315	20.0	16.0
30	3.50	100	315	20.0	16.0
33	3.50	110	355	22.4	18.0
36	4.00	110	400	25.0	20.0
39	4.00	125	400	28.0	22.4
42	4.50	125	450	28.0	22.4
45	4.50	140	500	31.5	25.0
48	5.00	140	500	31.5	25.0

Manufactured with straight flutes and a long shank with a square for machine tapping of nuts.

Unless otherwise specified the screwing taps shall be supplied with Tolerance class 6H



High Speed Steel GROUND THREAD NUT TAPS BSW Form

Specifications conform to
BS 949-1969(Zone 3)

Dimensions in inch / mm



Nominal Diameter Inch	Threads per Inch	Thread Length mm	Overall Length mm	Shank Dia mm	Square Size mm
1/4	20	38	110	4.50	3.55
5/16	18	42	120	6.00	4.50
3/8	16	48	140	7.00	5.60
7/16	14	55	160	8.00	6.30
1/2	12	64	180	9.50	7.50
9/16	12	64	200	11.20	9.00
5/8	11	70	200	12.50	10.00
3/4	10	76	250	14.00	11.20

Nominal Diameter Inch	Threads per Inch	Thread Length mm	Overall Length mm	Shank Dia mm	Square Size mm
7/8	9	85	280	16.0	12.5
1	8	95	280	18.0	14.0
1.1/8	7	109	315	20.0	16.0
1.1/4	7	109	355	22.4	18.0
1.1/2	6	127	400	28.0	22.4
1.3/4	5	153	500	31.5	25.0
2	4.1/2	170	560	35.5	28.0

Manufactured with straight flutes and a long shank with a square for machine tapping of nuts.



High Speed Steel GROUND THREAD NUT TAPS BSF Form

Specifications conform to
BS 949-1969(Zone 3)

Dimensions in inch / mm



Nominal Diameter Inch	Threads per Inch	Thread Length mm	Overall Length mm	Shank Dia mm	Square Size mm
1/4	26	30	110	4.50	3.55
5/16	22	35	120	6.00	4.50
3/8	20	38	140	7.00	5.60
7/16	18	43	160	8.00	6.30
1/2	16	48	180	9.50	7.50
9/16	16	48	200	11.20	9.00
5/8	14	55	200	12.50	10.00
3/4	12	64	250	14.00	11.20
7/8	11	70	280	16.00	12.50

Nominal Diameter Inch	Threads per Inch	Thread Length mm	Overall Length mm	Shank Dia mm	Square Size mm
1	10	76	280	18.0	14.0
1.1/8	9	85	315	20.0	16.0
1.1/4	9	85	355	22.4	18.0
1.3/8	8	95	400	25.0	20.0
1.1/2	8	95	400	28.0	22.4
1.5/8	8	95	450	28.0	22.4
1.3/4	7	109	500	31.5	25.0
2	7	109	560	35.5	28.0

Manufactured with straight flutes and a long shank with a square for machine tapping of nuts.



High Speed Steel GROUND THREAD NUT TAPS UNC Form

Specifications conform to
BS 949-1969(Zone 3)

Dimensions in inch / mm



Nominal Diameter Inch	Threads per Inch	Thread Length mm	Overall Length mm	Shank Dia mm	Square Size mm
1/4	20	38	110	4.5	3.55
5/16	18	43	125	6.0	4.50
3/8	16	48	140	7.0	5.60
7/16	14	55	160	8.0	6.30
1/2	13	59	180	9.5	7.50
9/16	12	64	200	11.2	9.00
5/8	11	70	200	12.5	10.00
3/4	10	76	250	14.0	11.20

Nominal Diameter Inch	Threads per Inch	Thread Length mm	Overall Length mm	Shank Dia mm	Square Size mm
7/8	9	85	280	16.0	12.5
1	8	95	280	18.0	14.0
1.1/8	7	109	315	20.0	16.0
1.1/4	7	109	355	22.4	18.0
1.3/8	6	127	400	25.0	20.0
1.1/2	6	127	400	28.0	22.4
1.3/4	5	153	500	31.5	25.0
2	4.1/2	170	560	35.5	28.0

Manufactured with straight flutes and a long shank with a square for machine tapping of nuts.



High Speed Steel GROUND THREAD NUT TAPS UNF Form

Specifications conform to
BS 949-1969(Zone 3)

Dimensions in inch / mm



Nominal Diameter Inch	Threads per Inch	Thread Length mm	Overall Length mm	Shank Dia mm	Square Size mm
1/4	28	28	110	4.5	3.55
5/16	24	32	125	6.0	4.50
3/8	24	32	140	7.0	5.60
7/16	20	38	160	8.0	6.30
1/2	20	38	180	9.5	7.50
9/16	18	43	200	11.2	9.00
5/8	18	43	200	12.5	10.00

Nominal Diameter Inch	Threads per Inch	Thread Length mm	Overall Length mm	Shank Dia mm	Square Size mm
3/4	16	48	250	14.0	11.2
7/8	14	55	280	16.0	12.5
1	12	64	280	18.0	14.0
1.1/8	12	64	315	20.0	16.0
1.1/4	12	64	355	22.4	18.0
1.3/8	12	64	400	25.0	20.0
1.1/2	12	64	400	28.0	22.4

Manufactured with straight flutes and a long shank with a square for machine tapping of nuts.



High Speed Steel GROUND THREAD HAND TAPS For ISO Metric Coarse Pitch Threads

Specifications conform to
DIN 352 - 1981

Dimensions in mm



Nominal Diameter	Pitch	Thread Length	Overall Length	Shank Dia	Square Size
3.0	0.5	11	40	3.5	2.7
3.5	0.6	13	45	4.0	3.0
4.0	0.7	13	45	4.5	3.4
4.5	0.75	16	50	6.0	4.9
5.0	0.8	16	50	6.0	4.9
6.0	1.0	19	50	6.0	4.9
7.0	1.0	19	50	6.0	4.9
8.0	1.25	22	56	6.0	4.9
9.0	1.25	22	63	7.0	5.5
10.0	1.5	24	70	7.0	5.5
11.0	1.5	24	70	8.0	6.2
12.0	1.75	29	75	9.0	7.0
14.0	2.0	30	80	11.0	9.0
16.0	2.0	32	80	12.0	9.0
18.0	2.5	40	95	14.0	11.0
20.0	2.5	40	95	16.0	12.0

Nominal Diameter	Pitch	Thread Length	Overall Length	Shank Dia	Square Size
22	2.5	40	100	18.0	14.5
24	3.0	50	110	18.0	14.5
27	3.0	50	110	20.0	16.0
30	3.5	56	125	22.0	18.0
33	3.5	56	125	25.0	20.0
36	4.0	63	150	28.0	22.0
39	4.0	63	150	32.0	24.0
42	4.5	63	150	32.0	24.0
45	4.5	70	160	36.0	29.0
48	5.0	75	180	36.0	29.0
52	5.0	75	180	40.0	32.0
56	5.5	85	200	45.0	35.0
60	5.5	85	200	45.0	35.0
64	6.0	90	220	50.0	39.0
68	6.0	90	220	50.0	39.0

Manufactured with straight flutes and a shank with square for driving .

Usually supplied in sets consisting of Three serial Hand taps viz, Rougher, Intermediate and Finisher tap
Unless otherwise Specified , the screwing taps shall be supplied with tolerance class '6H'



High Speed Steel GROUND THREAD HAND TAPS For ISO Metric Fine Pitch Threads

Specifications conform to
DIN 2181 - 1981

Dimensions in mm



Nominal Diameter	Pitch	Thread Length	Overall Length	Shank Dia	Square Size
4.0	0.5	10	45	4.5	3.4
5.0	0.5	12	50	6.0	4.9
5.5	0.5	12	50	6.0	4.9
6.0	0.75	14	50	6.0	4.9
7.0	0.75	14	50	6.0	4.9
8.0	0.75	19	50	6.0	4.9
8.0	1.0	22	56	6.0	4.9
9.0	0.75	19	56	7.0	5.5
9.0	1.0	22	63	7.0	5.5
10.0	0.75	20	63	7.0	5.5
10.0	1.0	20	63	7.0	5.5
10.0	1.25	24	70	7.0	5.5
11.0	0.75	20	63	8.0	6.2
11.0	1.0	20	63	8.0	6.2
12.0	1.0	22	70	9.0	7.0
12.0	1.25	22	70	9.0	7.0

Nominal Diameter	Pitch	Thread Length	Overall Length	Shank Dia	Square Size
12	1.5	22	70	9.0	7.0
14	1.0	22	70	11.0	9.0
14	1.25	22	70	11.0	9.0
14	1.5	22	70	11.0	9.0
15	1.0	22	70	12.0	9.0
15	1.5	22	70	12.0	9.0
16	1.0	22	70	12.0	9.0
16	1.5	22	70	12.0	9.0
18	1.0	22	80	14.0	11.0
18	1.5	22	80	14.0	11.0
20	1.0	22	80	16.0	12.0
20	1.5	22	80	16.0	12.0
22	1.0	22	80	18.0	14.5
22	1.5	22	80	18.0	14.5
24	1.0	22	90	18.0	14.5
24	1.5	22	90	18.0	14.5

Manufactured with straight flutes and a shank with square for driving.

Usually supplied in sets consisting of Two serial Hand taps viz., Rougher and Finisher tap
Unless otherwise Specified, the screwing taps shall be supplied with tolerance class '6H'



High Speed Steel
GROUND THREAD HAND TAPS
For ISO Metric Fine Pitch Threads

Specifications conform to
DIN 2181 - 1981

Dimensions in mm



Nominal Diameter	Pitch	Thread Length	Overall Length	Shank Dia	Square Size
24	2.0	22	90	18	14.5
25	1.5	22	90	18	14.5
25	2.0	22	90	18	14.5
27	1.5	22	90	20	16.0
27	2.0	22	90	20	16.0
28	1.5	22	90	20	16.0
28	2.0	22	90	20	16.0
30	1.5	22	90	22	18.0
30	2.0	22	90	22	18.0
32	1.5	22	90	22	18.0
32	2.0	22	90	22	18.0
33	1.5	25	100	25	20.0
33	2.0	25	100	25	20.0
36	1.5	25	100	28	22.0
36	2.0	40	125	28	22.0
36	3.0	40	125	28	22.0
39	1.5	25	110	32	24.0
39	2.0	40	125	32	24.0
39	3.0	40	125	32	24.0

Nominal Diameter	Pitch	Thread Length	Overall Length	Shank Dia	Square Size
40	1.5	25	110	32	24.0
40	2.0	40	125	32	24.0
40	3.0	40	125	32	24.0
42	1.5	25	110	32	24.0
42	2.0	40	125	32	24.0
42	3.0	40	125	32	24.0
45	1.5	25	110	36	29.0
45	2.0	40	125	36	29.0
45	3.0	40	125	36	29.0
48	1.5	40	140	36	29.0
48	2.0	40	140	36	29.0
48	3.0	40	140	36	29.0
50	1.5	40	140	36	29.0
50	2.0	40	140	36	29.0
50	3.0	40	140	36	29.0
52	1.5	40	140	40	32.0
52	2.0	40	140	40	32.0
52	3.0	40	140	40	32.0