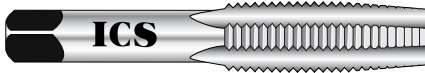


HIGH SPEED STEEL - TITANIUM NITRIDE COATED STANDARD HAND TAPS

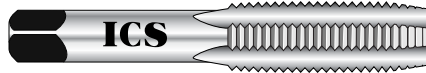
ICS **WIS**

GENERAL PURPOSE

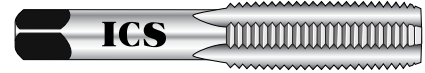
GROUND THREAD



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 HIGH SPEED STEEL		PRICE EACH TIN COATED	TAP DRILL SIZE APPROX. 75% THREAD			
	NC UNC	NF UNF	NS			TAPER, PLUG BOTTOMING	TAPER, PLUG BOTTOMING 3 PC SET		TAPER, PLUG BOTTOMING	NC	NF	NS
						SHT	SHTS		SHTT			
0	-	80	-	2	H1	11.04	33.08	13.28	-	3/64	-	
1	64	72	-	2	H1	10.26	30.78	12.50	53	53	-	
2	56	64	-	3	H2	8.40	25.20	10.64	50	50	-	
3	48	56	-	3	H2	6.84	20.50	9.08	47	45	-	
4	40	48	36	3	H2	5.38	16.14	7.62	43	44	42	
5	40	44	-	3	H2	5.38	16.14	7.62	38	37	-	
6	32	40	-	3	H3	3.92	11.76	6.16	36	33	-	
8	32	36	-	4	H3	4.22	12.64	8.26	29	29	-	
10	24	32	-	4	H3	4.22	12.64	8.26	25	21	-	
12	24	28	-	4	H3	5.84	17.48	9.86	16	14	-	
1/4	20	28	-	4	H3	4.56	13.66	8.58	7	3	-	
5/16	18	24	-	4	H3	5.34	16.00	11.50	"F"	"I"	-	
3/8	16	24	-	4	H3	6.16	18.48	12.32	5/16	"Q"	-	
7/16	14	20	-	4	H3	10.62	31.86	16.78	"U"	25/64	-	
1/2	13	20	-	4	H3	11.32	33.94	17.48	27/64	29/64	-	
9/16	12	18	-	4	H3	14.74	44.02	25.94	31/64	33/64	-	
5/8	11	18	-	4	H3	18.16	54.44	29.36	17/32	37/64	-	
11/16	-	-	11	4	H3	19.68	59.02	32.00	-	-	19/32	
11/16	-	-	16	4	H3	19.68	59.02	32.00	-	-	5/8	
3/4	10	16	-	4	H3	25.44	76.28	37.76	21/32	11/16	-	
7/8	9	14	-	4	H4	35.18	105.52	52.42	49/64	13/16	-	
1	8	12	14	4	H4	53.76	161.28	79.42	7/8	15/16	59/64	
1-1/8	7	12	-	4	H4	80.26	240.78	131.46	63/64	1-3/64	-	
1-1/4	7	12	-	4-6	H4	101.82	305.44	153.00	1-7/64	1-11/64	-	
1-3/8	6	12	-	4-6	H4	128.02	384.06	179.20	1-7/32	1-19/64	-	
1-1/2	6	12	-	4-6	H4	161.06	483.18	212.24	1-11/32	1-27/64	-	
1-3/4	5	-	-	6	H4	179.42	-	251.54	1-9/16	-	-	
2	4-1/2	-	-	6	H4	230.94	-	349.88	1-25/32	-	-	
2-1/4	4-1/2	-	-	6	H6	292.32	-	411.28	2-1/32	-	-	
2-1/2	4	-	-	6	H6	347.76	-	592.76	2-1/4	-	-	
3	4	-	-	6	H10	509.04	-	-	2-3/4	-	-	
3-1/2	4	-	-	6	H10	757.68	-	-	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 OVER 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

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