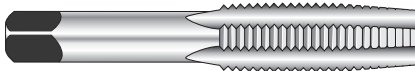


# HIGH SPEED STEEL LEFT HAND TAPS

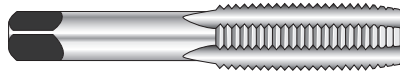
ICS USA

SPECIAL PURPOSE

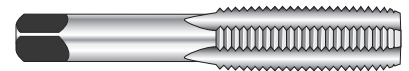
GROUND THREAD



**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 Left Hand Taps with straight flutes are designed to cut threads with a left hand rotation and are commonly used in applications where left hand studs and fasteners are needed. They can be used by hand or in production machines where ground thread accuracy and performance are required. They are suitable for tapping most materials in through or blind holes.

THREADS PER INCH							
SIZE	NC UNC	NF UNF	NS	NO. OF FLUTES	LIMIT NO.	HSS SHTL	3PC HSS SET SHTLS
6	32	-	-	3	H3	7.42	22.26
8	32	-	-	4	H3	7.42	22.26
10	24	32	-	4	H3	7.42	22.26
1/4	20	28	-	4	H3	7.70	23.10
5/16	18	24	-	4	H3	8.62	25.86
3/8	16	24	-	4	H3	10.38	31.14
7/16	14	20	-	4	H3	15.36	46.08
1/2	13	20	-	4	H3	18.06	54.18
9/16	12	18	-	4	H3	23.46	70.38

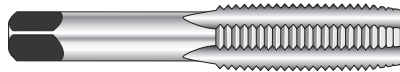
THREADS PER INCH							
SIZE	NC UNC	NF UNF	NS	NO. OF FLUTES	LIMIT NO.	HSS SHTL	3PC HSS SET SHTLS
5/8	11	18	-	4	H3	29.06	87.18
3/4	10	16	-	4	H3	40.70	122.10
7/8	9	14	12	4	H4	55.80	167.40
1	8	12	14	4	H4	76.52	229.56
1-1/8	7	12	8	4	H4	111.50	-
1-1/4	7	12	8	4-6	H4	149.30	-
1-3/8	6	12	8	4-6	H4	184.94	-
1-1/2	6	12	8	4-6	H4	219.68	-
1-3/4	-	-	8	6	H4	239.86	-

# HIGH SPEED STEEL +.005 OVERSIZE HAND TAPS

ICS USA

SPECIAL PURPOSE

GROUND THREAD



**PLUG CHAMFER**

High Speed Steel +.005 Oversize Hand Taps are designed to be used where a part will be plated or heat treated after tapping or where a loss of size is expected. They produce threads with a pitch diameter that is .005 larger than the basic pitch diameter. They are suitable for most materials in through or blind holes, especially plastics and synthetic resins. They are also referred to as Pre-Plate Taps.

THREADS PER INCH					PRICE
SIZE	NC UNC	NF UNF	NS	NO. OF FLUTES	HSS SHTO
6	32	40	-	3	7.34
8	32	36	-	4	7.34
10	24	32	-	4	7.34
1/4	20	28	-	4	7.34
5/16	18	24	-	4	8.62
3/8	16	24	-	4	10.44
7/16	14	20	-	4	17.40
1/2	13	20	-	4	18.08

THREADS PER INCH					PRICE
SIZE	NC UNC	NF UNF	NS	NO. OF FLUTES	HSS SHTO
5/8	11	18	-	4	35.46
3/4	10	16	-	4	49.66
7/8	9	14	-	4	58.94
1	8	12	14	4	78.54
1-1/8	7	12	-	4-6	101.40
1-1/4	7	12	-	4-6	128.84
1-3/8	6	12	-	4-6	158.40
1-1/2	6	12	-	4-6	186.04

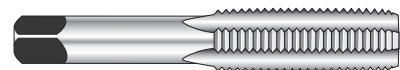
# HIGH SPEED STEEL SPECIAL OVERSIZE HAND TAPS

ICS USA

SPECIAL PURPOSE

GROUND THREAD

**STEAM HOMO  
THREAD PROTECTION**



**SPECIAL BOTTOM  
CHAMFER**

Special Oversize Hand Taps are used for tough dirty jobs. Profiled (flame cut) parts, with scale, and punched holes with burrs. The parts are subsequently shot-blasted and hot dip galvanized. The amount of oversize is to allow for heavy zinc deposition in the threads. They are also referred to as Pre-Plate Taps.

SIZE	THREADS PER INCH	NO. OF FLUTES	DECIMAL OVERSIZE	HSS
1/4	20	4	+.015	OHT016
5/16	18	4	+.015	OHT020
3/8	16	4	+.015	OHT024
1/2	13	4	+.020	OHT032
5/8	11	4	+.020	OHT040
3/4	10	4	+.020	OHT048

SIZE	THREADS PER INCH	NO. OF FLUTES	DECIMAL OVERSIZE	HSS
1	8	4	+.020	OHT100
1-1/8	7	4	+.030	OHT108
1-1/4	7	4	+.030	OHT116
1-3/8	6	6	+.030	OHT124
1-1/2	6	6	+.030	OHT132

\* Inquire for special oversize hand taps not listed.

\* Price quoted upon request.