

# HAND TAPS



## **Taps** - Hand

*Reliable, precision threading*

- M, MF

- UNC, UNF, UNEF, UN, UNS

- BSW, BSF, BA, BSB

- Rc (BSPT), Rp (BSPPL), Pg Series, G (BSPF)

- NPT, NPTF, NPSF

# special taps express delivery service...

# *SUPA FAST*



Sutton Tools has a dedicated production facility for express delivery service on special taps.

With our state of the art CNC grinding equipment almost any profile can be achieved.

- Straight Flute Taps M1 to M127
- Spiral & Gun Taps M1 to M52

All Thread Forms:

Metric, MJ, UN, UNJC, UNJF, Pg, Whit, Rope forms & Acme and more!!

Surface Finishes and Treatments:

- All latest PVD coatings available

Contact our sales team for more information.



[www.sutton.com.au](http://www.sutton.com.au)

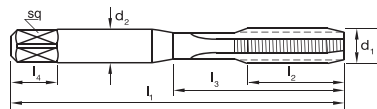




# Hand Taps Metric, Straight Flute, N



- General purpose use
- Suitable for materials up to 1000N/mm<sup>2</sup>
- Through & blind holes
- Suitable for both hand and machine operations
- Depths up to approx. 1 x d<sub>1</sub>



Catalogue Code    Size Ref.



Catalogue Code

Discount Group

Material

Surface Finish

Colour Ring & Application

Geometry

Chamfer

Limit & Nut Tolerance

Size Ref.	d <sub>1</sub>	Pitch	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	l <sub>4</sub>	z	drill Ø	T384	T385	T386	T901	
											D0702	D0702	D0702	D0702	
												HSS	HSS	HSS	HSS
												<i>Brt</i>	<i>Brt</i>	<i>Brt</i>	<i>Brt</i>
												N	N	N	N
												-	-	-	-
												Taper	Intermediate	Bottoming	Set
												Hand 2 / 6H	Hand 2 / 6H	Hand 2 / 6H	Hand 2 / 6H
												Item #	Item #	Item #	Item #
0200	M2	x 0.40	41	8	-	2.50	2.00	4	3	1.6	T384 0200	T385 0200	T386 0200	T901 0200	
0250	M2.5	x 0.45	45	10	-	2.80	2.24	5	3	2.05	T384 0250	T385 0250	T386 0250	T901 0250	
0300	M3	x 0.50	48	15	15	3.15	2.50	5	3	2.5	T384 0300	T385 0300	T386 0300	T901 0300	
0350	M3.5	x 0.60	50	17	17.5	3.55	2.80	5	3	2.9	T384 0350	T385 0350	T386 0350	T901 0350	
0400	M4	x 0.70	53	17	18	4.00	3.15	6	3	3.3	T384 0400	T385 0400	T386 0400	T901 0400	
0450	M4.5	x 0.75	53	13	19	4.50	3.55	6	3	3.7	T384 0450	T385 0450	T386 0450	T901 0450	
0500	M5	x 0.80	58	16	22	5.00	4.00	7	3	4.2	T384 0500	T385 0500	T386 0500	T901 0500	
0600	M6	x 1.00	66	19	26	6.30	5.00	8	3	5.0	T384 0600	T385 0600	T386 0600	T901 0600	
0700	M7	x 1.00	66	19	26	7.10	5.60	8	4	6.0	T384 0700	T385 0700	T386 0700	T901 0700	
0800	M8	x 1.25	72	22	30	8.00	6.30	9	4	6.8	T384 0800	T385 0800	T386 0800	T901 0800	
0900	M9	x 1.25	72	22	31	9.00	7.10	10	4	7.8	T384 0900	T385 0900	T386 0900	T901 0900	
1000	M10	x 1.50	80	24	34	10.00	8.00	11	4	8.5	T384 1000	T385 1000	T386 1000	T901 1000	
1100	M11	x 1.50	85	25	-	8.00	6.30	9	4	9.5	T384 1100	T385 1100	T386 1100	T901 1100	
1200	M12	x 1.75	89	29	-	9.00	7.10	10	4	10.2	T384 1200	T385 1200	T386 1200	T901 1200	
1400	M14	x 2.00	95	30	-	11.20	9.00	12	4	12.0	T384 1400	T385 1400	T386 1400	T901 1400	
1600	M16	x 2.00	102	32	-	12.50	10.00	13	4	14.0	T384 1600	T385 1600	T386 1600	T901 1600	
1800	M18	x 2.50	112	37	-	14.00	11.20	14	4	15.5	T384 1800	T385 1800	T386 1800	T901 1800	
2000	M20	x 2.50	112	37	-	14.00	11.20	14	4	17.5	T384 2000	T385 2000	T386 2000	T901 2000	
2200	M22	x 2.50	118	38	-	16.00	12.50	16	4	19.5	T384 2200	T385 2200	T386 2200	T901 2200	
2400	M24	x 3.00	130	45	-	18.00	14.00	18	4	21.0	T384 2400	T385 2400	T386 2400	T901 2400	
2700	M27	x 3.00	135	45	-	20.00	16.00	20	4	24.0	T384 2700	T385 2700	T386 2700	•	
3000	M30	x 3.50	138	48	-	20.00	16.00	20	4	26.5	T384 3000	T385 3000	T386 3000	•	
3300	M33	x 3.50	151	51	-	22.40	18.00	22	4	29.5	T384 3300	T385 3300	T386 3300	•	
3600	M36	x 4.00	162	57	-	25.00	20.00	24	4	32.0	T384 3600	T385 3600	T386 3600	•	
3900	M39	x 4.00	170	60	-	28.00	22.40	26	4	35.0	T384 3900	T385 3900	T386 3900	•	
4200	M42	x 4.50	170	60	-	28.00	22.40	26	4	37.5	T384 4200	T385 4200	T386 4200	•	
4500	M45	x 4.50	187	67	-	31.50	25.00	28	4	40.5	T384 4500	T385 4500	T386 4500	•	
4800	M48	x 5.00	187	67	-	31.50	25.00	28	4	43.0	T384 4800	T385 4800	T386 4800	•	
5200	M52	x 5.00	200	70	-	35.50	28.00	31	4	47.0	T384 5200	T385 5200	T386 5200	•	

### Tap & Drill Sets

0014

14 piece set (intermediate)

Taps: M3, M4, M5, M6, M8, M10, M12  
Drills: 2.5, 3.3, 4.2, 5.0, 6.8, 8.5, 10.2mm

T385 0014

SDT1

28 piece set (taper, inter, bott) (Discount Group Z0304)

Taps: M3, M4, M5, M6, M8, M10, M12  
Drills: 2.5, 3.3, 4.2, 5.0, 6.8, 8.5, 10.2mm

T901 SDT1



T385 0014



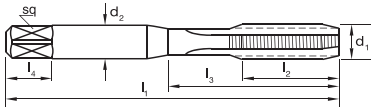
T901 SDT1

• Available on request as special manufacture. Subject to lead time.

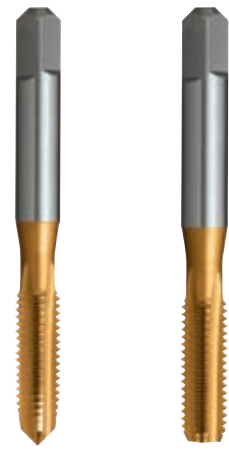
# Hand Taps Metric, Straight Flute, N



- General purpose use
- Suitable for materials up to 1000N/mm<sup>2</sup>
- Through & blind holes
- Suitable for both hand and machine operations
- Depths up to approx. 1 x d<sub>1</sub>



Catalogue Code    Size Ref.



Catalogue Code	<b>T387</b>	<b>T388</b>
Discount Group	D0706	D0706
Material	<b>HSS</b>	<b>HSS</b>
Surface Finish	<b>TiN</b>	<b>TiN</b>
Colour Ring & Application	<b>N</b>	<b>N</b>
Geometry	-	-
Chamfer	<b>Intermediate</b>	<b>Bottoming</b>
Limit & Nut Tolerance	Hand 2 / 6H	Hand 2 / 6H

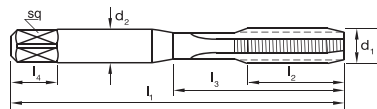
Size Ref.	d <sub>1</sub>	Pitch	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	l <sub>4</sub>	z	drill Ø	Item #	Item #
0200	M2	x 0.40	41	8	-	2.50	2.00	4	3	1.6	T387 0200	T388 0200
0250	M2.5	x 0.45	45	10	-	2.80	2.24	5	3	2.05	•	•
0300	M3	x 0.50	48	15	-	3.15	2.50	5	3	2.5	T387 0300	T388 0300
0350	M3.5	x 0.60	50	17	-	3.55	2.80	5	3	2.9	T387 0350	T388 0350
0400	M4	x 0.70	53	17	-	4.00	3.15	6	3	3.3	T387 0400	T388 0400
0450	M4.5	x 0.75	53	13	19	4.50	3.55	6	3	3.7	•	•
0500	M5	x 0.80	58	16	22	5.00	4.00	7	3	4.2	T387 0500	T388 0500
0600	M6	x 1.00	66	19	26	6.30	5.00	8	3	5.0	T387 0600	T388 0600
0700	M7	x 1.00	66	19	26	7.10	5.60	8	4	6.0	•	T388 0700
0800	M8	x 1.25	72	22	30	8.00	6.30	9	4	6.8	T387 0800	T388 0800
0900	M9	x 1.25	72	22	31	9.00	7.10	10	4	7.8	•	•
1000	M10	x 1.50	80	24	34	10.00	8.00	11	4	8.5	T387 1000	T388 1000
1100	M11	x 1.50	85	25	-	8.00	6.30	9	4	9.5	•	•
1200	M12	x 1.75	89	29	-	9.00	7.10	10	4	10.2	T387 1200	T388 1200
1400	M14	x 2.00	95	30	-	11.20	9.00	12	4	12.0	T387 1400	T388 1400
1600	M16	x 2.00	102	32	-	12.50	10.00	13	4	14.0	T387 1600	T388 1600
1800	M18	x 2.50	112	37	-	14.00	11.20	14	4	15.5	T387 1800	T388 1800
2000	M20	x 2.50	112	37	-	14.00	11.20	14	4	17.5	T387 2000	T388 2000
2200	M22	x 2.50	118	38	-	16.00	12.50	16	4	19.5	•	•
2400	M24	x 3.00	130	45	-	18.00	14.00	18	4	21.0	•	•
2700	M27	x 3.00	135	45	-	20.00	16.00	20	4	24.0	•	•
3000	M30	x 3.50	138	48	-	20.00	16.00	20	4	26.5	•	•
3300	M33	x 3.50	151	51	-	22.40	18.00	22	4	29.5	•	•
3600	M36	x 4.00	162	57	-	25.00	20.00	24	4	32.0	•	•
3900	M39	x 4.00	170	60	-	28.00	22.40	26	4	35.0	•	•
4200	M42	x 4.50	170	60	-	28.00	22.40	26	4	37.5	•	•
4500	M45	x 4.50	187	67	-	31.50	25.00	28	4	40.5	•	•
4800	M48	x 5.00	187	67	-	31.50	25.00	28	4	43.0	•	•
5200	M52	x 5.00	200	70	-	35.50	28.00	31	4	47.0	•	•

• Available on request as special manufacture. Subject to lead time.

## Hand Taps Metric, Straight Flute, N, Left Hand



- General purpose use
- Suitable for materials up to 1000N/mm<sup>2</sup>
- Through & blind holes
- Suitable for both hand and machine operations
- Depths up to approx. 1 x d<sub>1</sub>



Catalogue Code Size Ref.



Size Ref.	d <sub>1</sub>	Pitch	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	l <sub>4</sub>	z	drill Ø
0300	M3	x 0.50	48	15	15	3.15	2.50	5	3	2.5
0400	M4	x 0.70	53	17	18	4.00	3.15	6	3	3.3
0500	M5	x 0.80	58	16	22	5.00	4.00	7	3	4.2
0600	M6	x 1.00	66	19	26	6.30	5.00	8	3	5.0
0800	M8	x 1.25	72	22	30	8.00	6.30	9	4	6.8
1000	M10	x 1.50	80	24	34	10.00	8.00	11	4	8.5
1200	M12	x 1.75	89	29	-	9.00	7.10	10	4	10.2
1400	M14	x 2.00	95	30	-	11.20	9.00	12	4	12.0
1600	M16	x 2.00	102	32	-	12.50	10.00	13	4	14.0
1800	M18	x 2.50	112	37	-	14.00	11.20	14	4	15.5
2000	M20	x 2.50	112	37	-	14.00	11.20	14	4	17.5

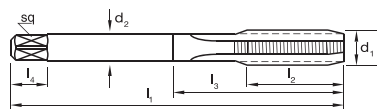


Catalogue Code	T389	T390	T391
Discount Group	D0702	D0702	D0702
Material	HSS	HSS	HSS
Surface Finish	<b>Brt</b>	<b>Brt</b>	<b>Brt</b>
Colour Ring & Application	<b>N</b>	<b>N</b>	<b>N</b>
Geometry	Left Hand	Left Hand	Left Hand
Chamfer	<b>Taper</b>	<b>Intermediate</b>	<b>Bottoming</b>
Limit & Nut Tolerance	Hand 2 / 6H LH	Hand 2 / 6H LH	Hand 2 / 6H LH
	<b>Item #</b>	<b>Item #</b>	<b>Item #</b>
	T389 0300	T390 0300	T391 0300
	T389 0400	T390 0400	T391 0400
	T389 0500	T390 0500	T391 0500
	T389 0600	T390 0600	T391 0600
	T389 0800	T390 0800	T391 0800
	T389 1000	T390 1000	T391 1000
	T389 1200	T390 1200	T391 1200
	T389 1400	T390 1400	T391 1400
	T389 1600	T390 1600	T391 1600
	T389 1800	T390 1800	T391 1800
	T389 2000	T390 2000	T391 2000

## Hand Taps Metric, Straight Flute, Oversize



- Oversize allowance to suit components for galvanize plating
- General purpose use, materials up to 1000N/mm<sup>2</sup>
- Through & blind holes
- Suitable for both hand and machine operations
- Depths up to approx 1 x d<sub>1</sub>
- Taper and inter leads available on request



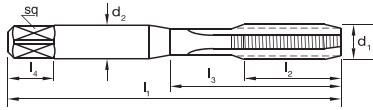
Size Ref.	d <sub>1</sub>	Pitch	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	l <sub>4</sub>	z	drill Ø	Item #
1000	M10 +0.4	x 1.5	85	25	-	8.0	6.3	9.0	4	8.9	T392 1000
1200	M12 +0.4	x 1.75	89	29	-	9.0	7.1	10.0	4	10.6	T392 1200
1600	M16 +0.4	x 2.0	112	37	-	12.5	10.0	13.0	4	14.4	T392 1600
2000	M20 +0.4	x 2.5	118	38	-	16.0	12.5	16.0	4	17.9	T392 2000
2400	M24 +0.45	x 3.0	130	45	-	18.0	14.0	18.0	4	21.5	T392 2400



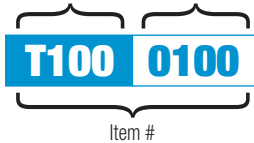
# Hand Taps Metric Fine, Straight Flute, N



- General purpose use
- Suitable for materials up to 1000N/mm<sup>2</sup>
- Through & blind holes
- Suitable for both hand and machine operations
- Depths up to approx. 1 x d<sub>1</sub>



Catalogue Code Size Ref.



Catalogue Code  
Discount Group  
Material  
Surface Finish  
Colour Ring & Application  
Geometry  
Chamfer  
Limit & Nut Tolerance



T401	T402	T403	T902
D0702	D0702	D0702	D0702
HSS	HSS	HSS	HSS
Brt	Brt	Brt	Brt
N	N	N	N
-	-	-	-
Taper	Intermediate	Bottoming	Set
Hand 2 / 6H	Hand 2 / 6H	Hand 2 / 6H	Hand 2 / 6H

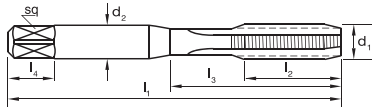
Size Ref.	d <sub>1</sub>	Pitch	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	l <sub>4</sub>	z	drill Ø	Item #	Item #	Item #	Item #
0503	MF 5	x 0.50	58	16	22	5.0	4.0	7	4	4.5	•	•	T403 0503	•
0604	MF 6	x 0.75	66	19	26	6.3	5.0	8	4	5.3	•	•	T403 0604	•
0805	MF 8	x 1.0*	72	22	30	8.0	6.3	9	4	7.0	T401 0805	T402 0805	T403 0805	T902 0805
0804	MF 8	x 0.75	72	22	30	8.0	6.3	9	4	7.3	•	•	T403 0804	•
1004	MF 10	x 0.75	80	24	34	10.0	8.0	11	4	9.3	•	•	T403 1004	•
1005	MF 10	x 1.00 <sup>†</sup>	80	24	34	10.0	8.0	11	4	9.0	T401 1005	T402 1005	T403 1005	T902 1005
1006	MF 10	x 1.25*	80	24	34	10.0	8.0	11	4	8.8	T401 1006	T402 1006	T403 1006	T902 1006
1205	MF 12	x 1.00	89	29	-	9.0	7.1	10	4	11.0	T401 1205	T402 1205	T403 1205	•
1206	MF 12	x 1.25	89	29	-	9.0	7.1	10	4	10.8	T401 1206	T402 1206	T403 1206	T902 1206
1207	MF 12	x 1.5*	89	29	-	9.0	7.1	10	4	10.5	T401 1207	T402 1207	T403 1207	T902 1207
1405	MF 14	x 1.00	95	30	-	11.2	9.0	12	4	13.0	•	•	T403 1405	•
1406	MF 14	x 1.25 <sup>†</sup>	95	30	-	11.2	9.0	12	4	12.8	T401 1406	T402 1406	T403 1406	T902 1406
1407	MF 14	x 1.5*	95	30	-	11.2	9.0	12	4	12.5	T401 1407	T402 1407	T403 1407	T902 1407
1605	MF 16	x 1.00	102	32	-	12.5	10.0	13	4	15.0	•	•	T403 1605	•
1606	MF 16	x 1.25	102	32	-	12.5	10.0	13	4	14.8	•	•	T403 1606	•
1607	MF 16	x 1.5*	102	32	-	12.5	10.0	13	4	14.5	T401 1607	T402 1607	T403 1607	T902 1607
1806	MF 18	x 1.25	112	37	-	14.0	11.2	14	4	16.8	•	•	T403 1806	•
1807	MF 18	x 1.5*	112	37	-	14.0	11.2	14	4	16.5	T401 1807	T402 1807	T403 1807	T902 1807
2006	MF 20	x 1.25	112	37	-	14.0	11.2	14	4	18.8	•	•	T403 2006	•
2007	MF 20	x 1.5**	112	37	-	14.0	11.2	14	4	18.5	T401 2007	T402 2007	T403 2007	T902 2007
2008	MF 20	x 2.0*	112	37	-	14.0	11.2	14	4	18.0	•	•	T403 2008	•
2207	MF 22	x 1.50	118	38	-	16.0	12.5	16	4	20.5	T401 2207	T402 2207	T403 2207	T902 2207
2208	MF 22	x 2.00	118	38	-	16.0	12.5	16	4	20.0	•	•	T403 2208	•
2407	MF 24	x 1.50	130	45	-	18.0	14.0	18	4	22.5	•	•	T403 2407	•
2408	MF 24	x 2.0*	130	45	-	18.0	14.0	18	4	22.0	T401 2408	T402 2408	T403 2408	T902 2408
2507	MF 25	x 1.5**	130	45	-	18.0	14.0	18	4	23.5	T401 2507	T402 2507	T403 2507	•
2708	MF 27	x 2.00	135	45	-	20.0	16.0	20	4	25.0	•	•	T403 2708	•
3007	MF 30	x 1.50	138	48	-	20.0	16.0	20	4	28.5	T401 3007	T402 3007	T403 3007	•
3008	MF 30	x 2.00	138	48	-	20.0	16.0	20	4	28.0	T401 3008	T402 3008	T403 3008	•
3207	MF 32	x 1.5**	151	51	-	22.4	18.0	22	4	30.5	T401 3207	T402 3207	T403 3207	•
4007	MF 40	x 1.5**	170	60	-	28.0	22.4	26	4	38.5	T401 4007	T402 4007	T403 4007	•
<b>Spark Plug</b>														
1005	MF 10	x 1.00	80	24	34	10.0	8.0	11	4	9.0	T401 1005	T402 1005	T403 1005	T902 1005
1206	MF 12	x 1.25	89	29	-	9.0	7.1	10	4	10.8	T401 1206	T402 1206	T403 1206	T902 1206
1406	MF 14	x 1.25	95	30	-	11.2	9.0	12	4	12.8	T401 1406	T402 1406	T403 1406	T902 1406
1807	MF 18	x 1.50	112	37	-	14.0	11.2	14	4	16.5	T401 1807	T402 1807	T403 1807	T902 1807

\* Alternative Metric Fine \*\* Conduit Metric • Available on request as special manufacture. Subject to lead time. <sup>†</sup> Limit and nut tolerance; Hand 1 / 4H

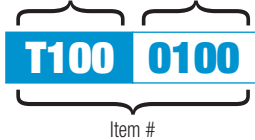
# Hand Taps Metric Fine, Straight Flute, N



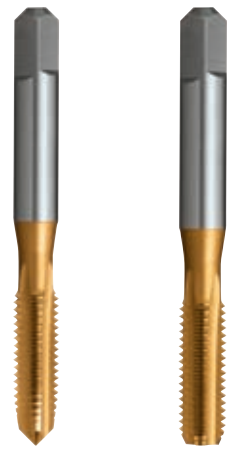
- General purpose use
- Suitable for materials up to 1000N/mm<sup>2</sup>
- Through & blind holes
- Suitable for both hand and machine operations
- Depths up to approx. 1 x d<sub>1</sub>



Catalogue Code Size Ref.



Size Ref.	d <sub>1</sub>	Pitch	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	l <sub>4</sub>	z	drill Ø	Item #	Item #
0503	MF5	x 0.50	58	16	22	5.0	4.0	7	4	4.5	•	•
0604	MF6	x 0.75	66	19	26	6.3	5.0	8	4	5.3	•	•
0804	MF8	x 0.75	72	22	30	8.0	6.3	9	4	7.3	•	•
0805	MF8	x 1.0*	72	22	30	8.0	6.3	9	4	7.0	T404 0805	T405 0805
1004	MF10	x 0.75	80	24	34	10.0	8.0	11	4	9.3	•	•
1005	MF10	x 1.00†	80	24	34	10.0	8.0	11	4	9.0	T404 1005	T405 1005
1006	MF10	x 1.25*	80	24	34	10.0	8.0	11	4	8.8	T404 1006	T405 1006
1205	MF12	x 1.00	89	29	-	9.0	7.1	10	4	11.0	•	•
1206	MF12	x 1.25	89	29	-	9.0	7.1	10	4	10.8	T404 1206	T405 1206
1207	MF12	x 1.5*	89	29	-	9.0	7.1	10	4	10.5	T404 1207	T405 1207
1405	MF14	x 1.00	95	30	-	11.2	9.0	12	4	13.0	•	•
1406	MF14	x 1.25†	95	30	-	11.2	9.0	12	4	12.8	T404 1406	T405 1406
1407	MF14	x 1.5*	95	30	-	11.2	9.0	12	4	12.5	T404 1407	T405 1407
1605	MF16	x 1.00	102	32	-	12.5	10.0	13	4	15.0	•	•
1606	MF16	x 1.25	102	32	-	12.5	10.0	13	4	14.8	•	•
1607	MF16	x 1.5*	102	32	-	12.5	10.0	13	4	14.5	•	T405 1607
1806	MF18	x 1.25	112	37	-	14.0	11.2	14	4	16.8	•	•
1807	MF18	x 1.5*	112	37	-	14.0	11.2	14	4	16.5	•	•
2006	MF20	x 1.25	112	37	-	14.0	11.2	14	4	18.8	•	•
2007	MF20	x 1.5**	112	37	-	14.0	11.2	14	4	18.5	•	•
2008	MF20	x 2.0*	112	37	-	14.0	11.2	14	4	18.0	•	•
2207	MF22	x 1.50	118	38	-	16.0	12.5	16	4	20.5	•	•
2208	MF22	x 2.00	118	38	-	16.0	12.5	16	4	20.0	•	•
2407	MF24	x 1.50	130	45	-	18.0	14.0	18	4	22.5	•	•
2408	MF24	x 2.0*	130	45	-	18.0	14.0	18	4	22.0	•	•
2507	MF25	x 1.5**	130	45	-	18.0	14.0	18	4	23.5	•	•
2708	MF27	x 2.00	135	45	-	20.0	16.0	20	4	25.0	•	•
3007	MF30	x 1.50	138	48	-	20.0	16.0	20	4	28.5	•	•
3008	MF30	x 2.00	138	48	-	20.0	16.0	20	4	28.0	•	•
3207	MF32	x 1.5**	151	51	-	22.4	18.0	22	4	30.5	•	•
4007	MF40	x 1.5**	170	60	-	28.0	22.4	26	4	38.5	•	•
<b>Spark Plug</b>												
1005	MF10	x 1.00	80	24	34	10.0	8.0	11	4	9.0	T404 1005	T405 1005
1206	MF12	x 1.25	89	29	-	9.0	7.1	10	4	10.8	T404 1206	T405 1206
1406	MF14	x 1.25	95	30	-	11.2	9.0	12	4	12.8	T404 1406	T405 1406
1807	MF18	x 1.50	112	37	-	14.0	11.2	14	4	16.5		



Catalogue Code	<b>T404</b>	<b>T405</b>
Discount Group	D0706	D0706
Material	<b>HSS</b>	<b>HSS</b>
Surface Finish	<b>TiN</b>	<b>TiN</b>
Colour Ring & Application	<b>N</b>	<b>N</b>
Geometry	-	-
Chamfer	<b>Intermediate</b>	<b>Bottoming</b>
Limit & Nut Tolerance	Hand 2 / 6H	Hand 2 / 6H

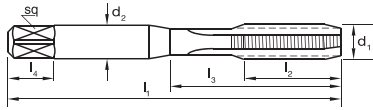
MF



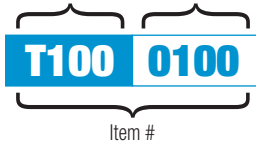
# Hand Taps UNC, Straight Flute, N



- General purpose use
- Suitable for materials up to 1000N/mm<sup>2</sup>
- Through & blind holes
- Suitable for both hand and machine operations
- Depths up to approx. 1 x d<sub>1</sub>



Catalogue Code    Size Ref.



**Catalogue Code**  
**Discount Group**  
**Material**  
**Surface Finish**  
**Colour Ring & Application**  
**Geometry**  
**Chamfer**  
**Limit & Nut Tolerance**

T414	T415	T416	T903
D0702	D0702	D0702	D0702
HSS	HSS	HSS	HSS
Br <sub>t</sub>	Br <sub>t</sub>	Br <sub>t</sub>	Br <sub>t</sub>
N	N	N	N
-	-	-	-
Taper	Intermediate	Bottoming	Set
2B	2B	2B	2B

Size Ref.	d <sub>1</sub>	TPI	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	l <sub>4</sub>	z	drill Ø	Item #	Item #	Item #	Item #
0251	#3	48	45	10	-	2.80	2.24	5	3	2.1	T414 0251	T415 0251	T416 0251	•
0284	#4	40	48	15	14.5	3.15	2.50	5	3	2.3	T414 0284	T415 0284	T416 0284	T903 0284
0318	#5	40	48	15	15	3.15	2.50	5	3	2.6	T414 0318	T415 0318	T416 0318	T903 0318
0351	#6	32	50	17	17.5	3.55	2.80	5	3	2.8	T414 0351	T415 0351	T416 0351	T903 0351
0417	#8	32	53	13	17	4.50	3.55	6	3	3.4	T414 0417	T415 0417	T416 0417	T903 0417
0483	#10	24	58	16	22	5.00	4.00	7	3	3.8	T414 0483	T415 0483	T416 0483	T903 0483
0549	#12	24	62	17	23	5.60	4.50	7	3	4.5	T414 0549	T415 0549	T416 0549	T903 0549
0476	3/16	24 (UNS)	58	16	22	5.00	4.00	7	3	3.7	T414 0476	T415 0476	T416 0476	T903 0476
0636	1/4	20	66	19	25	6.30	5.00	8	3	5.1	T414 0635	T415 0635	T416 0636	T903 0635
0635	1/4*	20	66	19	25	6.30	5.00	8	3	5.1	•	•	T416 0635	•
0795	5/16	18	72	22	30	8.00	6.30	9	4	6.6	T414 0794	T415 0794	T416 0795	T903 0794
0794	5/16*	18	72	22	30	8.00	6.30	9	4	6.6	•	•	T416 0794	•
0953	3/8	16	80	24	33	10.00	8.00	11	4	8.0	T414 0953	T415 0953	T416 0953	T903 0953
1111	7/16	14	85	25	-	8.00	6.30	9	4	9.4	T414 1111	T415 1111	T416 1111	T903 1111
1270	1/2	13	89	29	-	9.00	7.10	10	4	10.8	T414 1270	T415 1270	T416 1270	T903 1270
1429	9/16	12	95	30	-	11.20	9.00	12	4	12.2	T414 1429	T415 1429	T416 1429	T903 1429
1588	5/8	11	102	32	-	12.50	10.00	13	4	13.5	T414 1588	T415 1588	T416 1588	T903 1588
1905	3/4	10	112	37	-	14.00	11.20	14	4	16.5	T414 1905	T415 1905	T416 1905	T903 1905
2223	7/8	9	118	38	-	16.00	12.50	16	4	19.5	T414 2223	T415 2223	T416 2223	T903 2223
2540	1	8	130	45	-	18.00	14.00	18	4	22.2	T414 2540	T415 2540	T416 2540	T903 2540
2858	1-1/8	7	138	48	-	20.00	16.00	20	4	25.0	T414 2858	T415 2858	T416 2858	•
3175	1-1/4	7	151	51	-	22.40	18.00	22	4	28.0	T414 3175	T415 3175	T416 3175	T903 3175
3810	1-1/2	6	170	60	-	28.00	22.40	26	4	34.0	T414 3810	T415 3810	T416 3810	T903 3810

\* Alternative Limit    • Available on request as special manufacture. Subject to lead time.

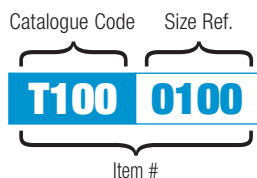
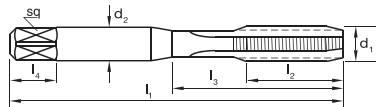




# Hand Taps UNF, Straight Flute, N



- General purpose use
- Suitable for materials up to 1000N/mm<sup>2</sup>
- Through & blind holes
- Suitable for both hand and machine operations
- Depths up to approx. 1 x d<sub>1</sub>



Catalogue Code  
Discount Group  
Material  
Surface Finish  
Colour Ring & Application  
Geometry  
Chamfer  
Limit & Nut Tolerance

T431	T432	T433	T904
D0702	D0702	D0702	D0702
HSS	HSS	HSS	HSS
<b>Br</b> t	<b>Br</b> t	<b>Br</b> t	<b>Br</b> t
N	N	N	N
-	-	-	-
Taper	Intermediate	Bottoming	Set
2B	2B	2B	2B

Size Ref.	d <sub>1</sub>	TPI	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	l <sub>4</sub>	z	drill Ø	Item #	Item #	Item #	Item #
0251	#3	56	45	10	-	2.80	2.24	5	3	2.1	T431 0251	T432 0251	T433 0251	•
0284	#4	48	48	15	14.5	3.15	2.50	5	3	2.35	T431 0284	T432 0284	T433 0284	T904 0284
0318	#5	44	48	15	15	3.15	2.50	5	3	2.65	T431 0318	T432 0318	T433 0318	T904 0318
0351	#6	40	50	17	17.5	3.55	2.80	5	3	2.9	T431 0351	T432 0351	T433 0351	T904 0351
0417	#8	36	53	13	17	4.50	3.55	6	3	3.5	T431 0417	T432 0417	T433 0417	T904 0417
0483	#10	32	58	16	22	5.00	4.00	7	3	4.1	T431 0483	T432 0483	T433 0483	T904 0483
0549	#12	28	62	17	23	5.60	4.50	7	3	4.6	T431 0549	T432 0549	T433 0549	T904 0549
0476	3/16	32 (UNS)	58	16	22	5.00	4.00	7	3	4.0	T431 0476	T432 0476	T433 0476	T904 0476
0635	1/4	28	66	19	25	6.30	5.00	8	3	5.5	T431 0635	T432 0635	T433 0635	T904 0635
0794	5/16	24	72	22	30	8.00	6.30	9	4	6.9	T431 0794	T432 0794	T433 0794	T904 0794
0953	3/8	24	80	24	33	10.00	8.00	11	4	8.5	T431 0953	T432 0953	T433 0953	T904 0953
1111	7/16	20	85	25	-	8.00	6.30	9	4	9.8	T431 1111	T432 1111	T433 1111	T904 1111
1270	1/2	20	89	29	-	9.00	7.10	10	4	11.5	T431 1270	T432 1270	T433 1270	T904 1270
1429	9/16	18	95	30	-	11.20	9.00	12	4	12.8	T431 1429	T432 1429	T433 1429	T904 1429
1588	5/8	18	102	32	-	12.50	10.00	13	4	14.5	T431 1588	T432 1588	T433 1588	T904 1588
1905	3/4	16	112	37	-	14.00	11.20	14	4	17.5	T431 1905	T432 1905	T433 1905	T904 1905
2223	7/8	14	118	38	-	16.00	12.50	16	4	20.5	T431 2223	T432 2223	T433 2223	T904 2223
2540	1	12	130	45	-	18.00	14.00	18	4	23.5	T431 2540	T432 2540	T433 2540	T904 2540
2541	1	14 (UNS)	130	45	-	18.00	14.00	18	4	24.0	T431 2541	T432 2541	T433 2541	T904 2541
2858	1-1/8	12	138	48	-	20.00	16.00	20	4	26.5	T431 2858	T432 2858	T433 2858	•
3175	1-1/4	12	151	51	-	22.40	18.00	22	4	29.5	T431 3175	T432 3175	T433 3175	•
3810	1-1/2	12	170	60	-	28.00	22.40	26	4	36.0	T431 3810	T432 3810	T433 3810	•

• Available on request as special manufacture. Subject to lead time.

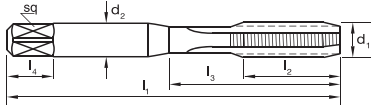




# Hand Taps UNF, Straight Flute, N, Left Hand



- General purpose use
- Suitable for materials up to 1000N/mm<sup>2</sup>
- Through & blind holes
- Suitable for both hand and machine operations
- Depths up to approx. 1 x d<sub>1</sub>



Catalogue Code    Size Ref.



Size Ref.	d <sub>1</sub>	TPI	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	l <sub>4</sub>	z	Limit	drill Ø	Item #	Item #	Item #
<b>0635</b>	1/4	28	66	19	25	6.30	5.00	8	3	GH3	5.5	T436 0635	T437 0635	T438 0635
<b>0794</b>	5/16	24	72	22	30	8.00	6.30	9	4	GH4	6.9	T436 0794	T437 0794	T438 0794
<b>0953</b>	3/8	24	80	24	33	10.00	8.00	11	4	GH4	8.5	T436 0953	T437 0953	T438 0953
<b>1111</b>	7/16	20	85	25	-	8.00	6.30	9	4	GH5	9.8	T436 1111	T437 1111	T438 1111
<b>1270</b>	1/2	20	89	29	-	9.00	7.10	10	4	GH5	11.5	T436 1270	T437 1270	T438 1270
<b>1429</b>	9/16	18	95	30	-	11.20	9.00	12	4	GH5	12.8	T436 1429	T437 1429	T438 1429
<b>1588</b>	5/8	18	102	32	-	12.50	10.00	13	4	GH5	14.5	T436 1588	T437 1588	T438 1588
<b>1905</b>	3/4	16	112	37	-	14.00	11.20	14	4	GH6	17.5	T436 1905	T437 1905	T438 1905



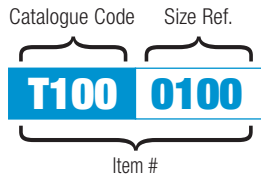
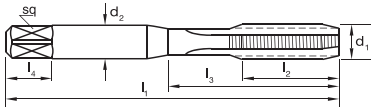
Catalogue Code	<b>T436</b>	<b>T437</b>	<b>T438</b>
Discount Group	D0702	D0702	D0702
Material	<b>HSS</b>	<b>HSS</b>	<b>HSS</b>
Surface Finish	<b>Brt</b>	<b>Brt</b>	<b>Brt</b>
Colour Ring & Application	<b>N</b>	<b>N</b>	<b>N</b>
Geometry	Left Hand	Left Hand	Left Hand
Chamfer	<b>Taper</b>	<b>Intermediate</b>	<b>Bottoming</b>
Limit & Nut Tolerance	2B LH	2B LH	2B LH

UNF

# Hand Taps UNEF, Straight Flute, N



- General purpose use
- Suitable for materials up to 1000N/mm<sup>2</sup>
- Through & blind holes
- Suitable for both hand and machine operations
- Depths up to approx. 1 x d<sub>1</sub>



Catalogue Code	<b>T445</b>	<b>T446</b>	<b>T447</b>
Discount Group	D0702	D0702	D0702
Material	<b>HSS</b>	<b>HSS</b>	<b>HSS</b>
Surface Finish	<b>Brt</b>	<b>Brt</b>	<b>Brt</b>
Colour Ring & Application	<b>N</b>	<b>N</b>	<b>N</b>
Geometry	Extra Fine	Extra Fine	Extra Fine
Chamfer	<b>Taper</b>	<b>Intermediate</b>	<b>Bottoming</b>
Limit & Nut Tolerance	2B	2B	2B

Size Ref.	d <sub>1</sub>	TPI	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	l <sub>4</sub>	z	Limit	drill Ø	Item #	Item #	Item #
<b>UNEF Series</b>														
<b>0635</b>	<b>1/4</b>	32	66	19	25	6.30	5.00	8	3	GH3/2B	5.6	T445 0635	T446 0635	T447 0635
<b>0794</b>	<b>5/16</b>	32	72	22	30	8.00	6.30	9	4	GH4/2B	7.2	T445 0794	T446 0794	T447 0794
<b>0953</b>	<b>3/8</b>	32	80	24	33	10.00	8.00	11	4	GH4/2B	8.8	T445 0953	T446 0953	T447 0953
<b>1270</b>	<b>1/2</b>	28	89	29	-	9.00	7.10	10	4	GH5/2B	11.8	T445 1270	T446 1270	T447 1270
<b>1588</b>	<b>5/8</b>	24	102	32	-	12.50	10.00	13	4	GH5/2B	14.75	T445 1588	T446 1588	T447 1588
<b>1905</b>	<b>3/4</b>	20	112	37	-	14.00	11.20	14	4	GH6/2B	18.0	T445 1905	T446 1905	T447 1905
<b>2540</b>	<b>1</b>	20	130	45	-	18.00	14.00	18	4	GH7/2B	24.2	T445 2540	T446 2540	T447 2540
<b>Tyre Valve Tap (UNS)</b>														
<b>0533</b>	<b>5V1</b>	36	62	17	23	5.60	4.50	7	3	-	4.6	•	•	<b>T489</b> T489 0533
<b>Stitching Tap</b>														
<b>0655</b>	<b>#1</b>		64	36	-	8.08	6.15	9.5	4	-	5.0	•	•	<b>T490</b> T490 0655

• Available on request as special manufacture. Subject to lead time.







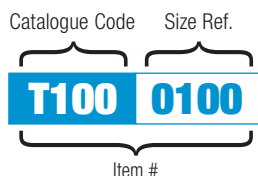
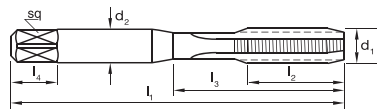




# Hand Taps BSF, BA & BSB, Straight Flute, N



- General purpose use
- Suitable for materials up to 1000N/mm<sup>2</sup>
- Through & blind holes
- Suitable for both hand and machine operations
- Depths up to approx. 1 x d<sub>1</sub>



Catalogue Code  
Discount Group  
Material  
Surface Finish  
Colour Ring & Application  
Geometry  
Chamfer  
Limit & Nut Tolerance

D0702	D0702	D0702	D0702
HSS	HSS	HSS	HSS
<i>Brt</i>	<i>Brt</i>	<i>Brt</i>	<i>Brt</i>
N	N	N	N
-	-	-	-
Taper	Intermediate	Bottoming	Set
Z3 Medium	Z3 Medium	Z3 Medium	Z3 Medium
Item #	Item #	Item #	Item #
<b>T466</b>	<b>T467</b>	<b>T468</b>	<b>T906</b>
T466 0476	T467 0476	T468 0476	T906 0476
T466 0635	T467 0635	T468 0635	T906 0635
T466 0794	T467 0794	T468 0794	T906 0794
T466 0953	T467 0953	T468 0953	T906 0953
T466 1111	T467 1111	T468 1111	T906 1111
T466 1270	T467 1270	T468 1270	T906 1270
T466 1429	T467 1429	T468 1429	•
T466 1588	T467 1588	T468 1588	•
T466 1905	T467 1905	T468 1905	•
T466 2223	T467 2223	T468 2223	•
T466 2540	T467 2540	T468 2540	•
<b>T469</b>	<b>T470</b>	<b>T471</b>	<b>T907</b>
T469 0600	T470 0600	T471 0600	•
T469 0530	T470 0530	T471 0530	T907 0530
T469 0470	T470 0470	T471 0470	T907 0470
T469 0410	T470 0410	T471 0410	T907 0410
T469 0360	T470 0360	T471 0360	T907 0360
T469 0320	T470 0320	T471 0320	T907 0320
T469 0280	T470 0280	T471 0280	T907 0280
T469 0250	T470 0250	T471 0250	T907 0250
T469 0220	T470 0220	T471 0220	T907 0220
T469 0190	T470 0190	T471 0190	T907 0190
T469 0170	T470 0170	T471 0170	T907 0170
<b>T472</b>	<b>T473</b>	<b>T474</b>	<b>T908</b>
T466 0635	T467 0635	T468 0635	T906 0635
T472 0794	T473 0794	T474 0794	T908 0794
T472 0953	T473 0953	T474 0953	T908 0953
T472 1111	T473 1111	T474 1111	T908 1111
T472 1270	T473 1270	T474 1270	T908 1270
•	•	T474 1429	•
•	•	T474 1588	•
•	•	T474 1905	•
•	•	T474 2223	•
•	•	T474 2540	•

Size Ref.	d <sub>1</sub>	TPI	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	l <sub>4</sub>	z	drill Ø
<b>BSF</b>										
<b>0476</b>	<b>3/16</b>	32	58	16	22	5.00	4.00	7	3	4.0
<b>0635</b>	<b>1/4</b>	26	66	19	25	6.30	5.00	8	3	5.3
<b>0794</b>	<b>5/16</b>	22	72	22	30	8.00	6.30	9	4	6.8
<b>0953</b>	<b>3/8</b>	20	80	24	33	10.00	8.00	11	4	8.3
<b>1111</b>	<b>7/16</b>	18	85	25	-	8.00	6.30	9	4	9.8
<b>1270</b>	<b>1/2</b>	16	89	29	-	9.00	7.10	10	4	11.0
<b>1429</b>	<b>9/16</b>	16	95	30	-	11.20	9.00	12	4	12.7
<b>1588</b>	<b>5/8</b>	14	102	32	-	12.50	10.00	13	4	14.0
<b>1905</b>	<b>3/4</b>	12	112	37	-	14.00	11.20	14	4	16.75
<b>2223</b>	<b>7/8</b>	11	118	38	-	16.00	12.50	16	4	19.75
<b>2540</b>	<b>1</b>	10	130	45	-	18.00	14.00	18	4	22.75
<b>BA</b>										
<b>0600</b>	<b>0</b>	1	66	19	26	6.30	5.00	8	3	5.1
<b>0530</b>	<b>1</b>	0.90	62	17	23	5.60	4.50	7	3	4.5
<b>0470</b>	<b>2</b>	0.81	58	16	22	5.00	4.00	7	3	4.0
<b>0410</b>	<b>3</b>	0.73	53	13	18	4.50	3.55	6	3	3.4
<b>0360</b>	<b>4</b>	0.66	50	17	-	3.55	2.80	5	3	3.0
<b>0320</b>	<b>5</b>	0.59	48	15	-	3.15	2.50	5	3	2.65
<b>0280</b>	<b>6</b>	0.53	48	15	-	3.15	2.50	5	3	2.3
<b>0250</b>	<b>7</b>	0.48	45	10	-	2.80	2.24	5	3	2.05
<b>0220</b>	<b>8</b>	0.43	45	10	-	2.80	2.24	5	3	1.8
<b>0190</b>	<b>9</b>	0.39	41	8	-	2.50	2.00	4	3	1.55
<b>0170</b>	<b>10</b>	0.35	41	8	-	2.50	2.00	4	3	1.4
<b>BSB - Brass Series</b>										
<b>0635</b>	<b>1/4</b>	26(BSF)	66	19	25	6.30	5.00	8	3	5.2
<b>0794</b>	<b>5/16*</b>	26	72	22	30	8.00	6.30	9	4	6.8
<b>0953</b>	<b>3/8*</b>	26	80	24	33	10.00	8.00	11	4	8.4
<b>1111</b>	<b>7/16*</b>	26	85	25	-	8.00	6.30	9	4	10.0
<b>1270</b>	<b>1/2*</b>	26	89	29	-	9.00	7.10	10	4	11.6
<b>1429</b>	<b>9/16*</b>	26	95	30	-	11.20	9.00	12	4	13.2
<b>1588</b>	<b>5/8*</b>	26	102	32	-	12.50	10.00	13	4	14.8
<b>1905</b>	<b>3/4*</b>	26	112	37	-	14.00	11.20	14	4	18.0
<b>2223</b>	<b>7/8*</b>	26	118	38	-	16.00	12.50	16	4	20.8
<b>2540</b>	<b>1*</b>	26	130	45	-	18.00	14.00	18	4	24.3

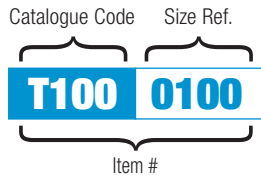
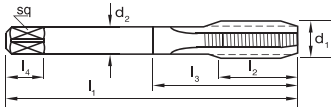
\* Available on request as special manufacture. Subject to lead time.  
\* Limit & Nut Tolerance = Z4



# Hand Taps Pipe, G (BSPF), Straight Flute



- General purpose use
- Suitable for materials up to 1000N/mm<sup>2</sup>
- Through & blind holes
- Suitable for both hand and machine operations
- Depths up to approx. 1 x d<sub>1</sub>



Catalogue Code  
Discount Group  
Material  
Surface Finish  
Colour Ring & Application  
Geometry  
Chamfer  
Limit & Nut Tolerance

T479	T480	T481	T909
D0702	D0702	D0702	D0702
HSS	HSS	HSS	HSS
Brt	Brt	Brt	Brt
N	N	N	N
-	-	-	-
Taper	Intermediate	Bottoming	Set
Z3	Z3	Z3	Z3
Item #	Item #	Item #	Item #

Size Ref.	d <sub>1</sub>	TPI	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	l <sub>4</sub>	z	drill Ø	Item #	Item #	Item #	Item #
<b>G Series (BSPF) Straight Flute Parallel, Mechanical Fastening</b>														
0973	1/8	28	59	15	-	8.0	6.3	9	4	8.8	T479 0973	T480 0973	T481 0973	T909 0973
1316	1/4	19	67	19	-	10.0	8.0	11	4	11.8	T479 1316	T480 1316	T481 1316	T909 1316
1666	3/8	19	75	21	-	12.5	10.0	13	4	15.3	T479 1666	T480 1666	T481 1666	T909 1666
2096	1/2	14	87	26	-	16.0	12.5	16	4	19.0	T479 2096	T480 2096	T481 2096	T909 2096
2291	5/8	14	91	26	-	18.0	14.0	18	4	21.0	T479 2291	T480 2291	T481 2291	T909 2291
2644	3/4	14	96	28	-	20.0	16.0	20	4	24.5	T479 2644	T480 2644	T481 2644	T909 2644
3020	7/8	14	102	29	-	22.4	18.0	22	4	28.5	T479 3020	T480 3020	T481 3020	•
3325	1	11	109	33	-	25.0	20.0	24	4	31.0	T479 3325	T480 3325	T481 3325	T909 3325
4191	1-1/4	11	119	36	-	31.5	25.0	28	4	39.5	T479 4191	T480 4191	T481 4191	•
4780	1-1/2	11	125	37	-	35.5	28.0	31	4	45.5	T479 4780	T480 4780	T481 4780	•
5375	1-3/4	11	132	39	-	35.5	28.0	31	6	51.5	T479 5375	T480 5375	T481 5375	•
5961	2	11	140	41	-	40.0	31.5	34	6	57.5	T479 5961	T480 5961	T481 5961	•

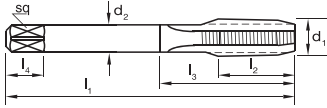
• Available on request as special manufacture. Subject to lead time.



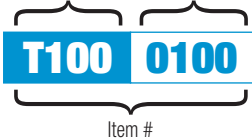
## Hand Taps Pipe, Rc (BSPT), Straight Flute



- General purpose use
- Suitable for materials up to 1000N/mm<sup>2</sup>
- Through & blind holes
- Suitable for both hand and machine operations
- Taper pipe reamer recommended prior to tapping Rc (BSPT) thread forms



Catalogue Code Size Ref.



Catalogue Code	<b>T475</b>	<b>T476</b>
Discount Group	D0702	D0706
Material	<b>HSS</b>	<b>HSS</b>
Surface Finish	<b>Brt</b>	<b>TIN</b>
Colour Ring & Application	<b>N</b>	<b>N</b>
Geometry	-	-
Chamfer	<b>Bottoming</b>	<b>Bottoming</b>
Limit & Nut Tolerance	To Suit	To Suit

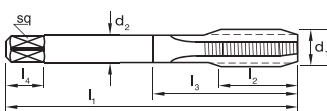
Size Ref.	d <sub>1</sub>	TPI	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	l <sub>4</sub>	z	drill Ø	Item #	Item #
<b>Rc (BSPT) 1:16 Taper Rate</b>												
<b>0973</b>	<b>1/8</b>	28	59	15	-	8.0	6.3	9	4	8.4	T475 0973	T476 0973
<b>1316</b>	<b>1/4</b>	19	67	19	-	10.0	8.0	11	4	10.8	T475 1316	T476 1316
<b>1666</b>	<b>3/8</b>	19	75	21	-	12.5	10.0	13	4	14.5	T475 1666	T476 1666
<b>2096</b>	<b>1/2</b>	14	87	26	-	16.0	12.5	16	4	18.0	T475 2096	T476 2096
<b>2644</b>	<b>3/4</b>	14	96	28	-	20.0	16.0	20	4	23.0	T475 2644	•
<b>3325</b>	<b>1</b>	11	109	33	-	25.0	20.0	24	5	29.0	T475 3325	•
<b>4191</b>	<b>1-1/4</b>	11	119	36	-	31.5	25.0	28	5	38.0	T475 4191	•
<b>4780</b>	<b>1-1/2</b>	11	125	37	-	35.5	28.0	31	7	44.0	T475 4780	•
<b>5961</b>	<b>2</b>	11	140	41	-	40.0	31.5	34	7	55.0	T475 5961	•

## Hand Taps Pipe, Rp & Pg Series, Straight Flute



- General Purpose use for materials up to approx. 1000 N/mm<sup>2</sup>
- Through & blind holes
- Suitable for both hand and machine operations

Discount Group: D0702



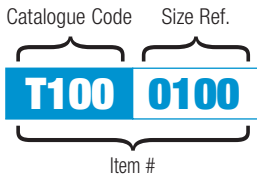
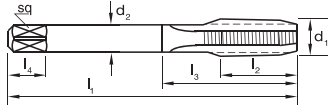
Size Ref.	d <sub>1</sub>	TPI	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	l <sub>4</sub>	z	drill Ø	Nominal OD	Item #
<b>Rp Series (BSPPL) Sealing Pipe Thread Parallel</b>												<b>T477</b>
<b>0973</b>	<b>1/8</b>	28	59	15	-	8.0	6.3	9	4	8.6	-	T477 0973
<b>1316</b>	<b>1/4</b>	19	67	19	-	10.0	8.0	11	4	11.5	-	T477 1316
<b>1666</b>	<b>3/8</b>	19	75	21	-	12.5	10.0	13	4	15.0	-	T477 1666
<b>2096</b>	<b>1/2</b>	14	87	26	-	16.0	12.5	16	4	18.5	-	T477 2096
<b>2644</b>	<b>3/4</b>	14	96	28	-	20.0	16.0	20	4	24.0	-	T477 2644
<b>3325</b>	<b>1</b>	11	109	33	-	25.0	20.0	24	4	30.2	-	T477 3325
<b>4191</b>	<b>1-1/4</b>	11	119	36	-	31.5	25.0	28	4	39.0	-	T477 4191
<b>4780</b>	<b>1-1/2</b>	11	125	37	-	35.5	28.0	31	4	45.0	-	T477 4780
<b>5961</b>	<b>2</b>	11	140	41	-	40.0	31.5	34	4	56.4	-	T477 5961
<b>Pg – Steel Conduit (Armour Pipe)</b>												<b>T478</b>
<b>1250</b>	<b>Pg 7</b>	20	89	29	-	9	7.1	10	4	11.3	12.5	T478 1250
<b>1520</b>	<b>Pg 9</b>	18	102	32	-	12.5	10	12	4	13.9	15.2	T478 1520
<b>1860</b>	<b>Pg 11</b>	18	112	37	-	14	11.2	14	4	17.3	18.6	T478 1860
<b>2040</b>	<b>Pg 13.5</b>	18	118	38	-	16	12.5	16	4	19.1	20.4	T478 2040
<b>2250</b>	<b>Pg 16</b>	18	118	38	-	16	12.5	16	4	21.2	22.5	T478 2250
<b>2830</b>	<b>Pg 21</b>	16	138	48	-	20	16	20	4	26.8	28.3	T478 2830

• Available on request as special manufacture. Subject to lead time.

# Hand Taps Pipe, National Series, Straight Flute



- General purpose use, materials up to approx. 1000 N/mm<sup>2</sup>
- Suitable for both hand and machine operations
- Taper pipe reamer recommended prior to tapping



Catalogue Code	D0702
Discount Group	HSS
Material	Colour Temp
Surface Finish	N
Colour Ring & Application	-
Geometry	Bottoming
Chamfer	Refer Limit
Limit & Nut Tolerance	Item #

Size Ref.	d <sub>1</sub>	TPI	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub>	sq	l <sub>4</sub>	z	Limit drill Ø	Item #
<b>NPSF (Dryseal Straight)</b>											<b>T486</b>
1029	1/8	27	54	19	-	11.11	8.33	9.5	4	GH3	8.6
1372	1/4	18	62	27	-	14.29	10.70	11.1	4	GH4	11.3
1715	3/8	18	65	27	-	17.78	13.49	12.7	4	GH4	14.5
2134	1/2	14	79	35	-	17.46	13.08	15.9	4	GH5	18.0
<b>NPT (National Pipe Taper) 15° Chamfer (1:16 Taper Rate)</b>											<b>T487</b>
1029	1/8	27	54	19	-	11.11	8.33	9.5	4	-	8.2
1372	1/4	18	62	27	-	14.29	10.70	11.1	4	-	10.8
1715	3/8	18	65	27	-	17.78	13.49	12.7	4	-	14.0
2134	1/2	14	79	35	-	17.46	13.08	15.9	4	-	17.5
2667	3/4	14	82	35	-	23.00	17.25	17.5	4	-	23.0
3340	1	11-1/2	95	44.5	-	28.60	21.40	20.6	5	-	28.5
4216	1-1/4	11-1/2	102	44.5	-	33.30	25.00	23.8	5	-	37.0
<b>NPTF (Dryseal Taper) 15° Chamfer (1:16 Taper Rate)</b>											<b>T488</b>
1029	1/8	27	54	19	-	11.11	8.33	9.5	4	-	8.2
1372	1/4	18	62	27	-	14.29	10.70	11.1	4	-	10.8
1715	3/8	18	65	27	-	17.78	13.49	12.7	4	-	14.0
2134	1/2	14	79	35	-	17.46	13.08	15.9	4	-	17.50

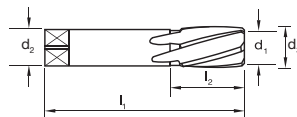
NPT

# Hand Reamers Taper Pipe



- Used prior to tapping
- For Rc (BSPT), NPT & NPTF tapered threads
- Prolongs tap life, especially in tough materials

Discount Group: B0302



Size Ref.	Size	d <sub>1</sub>	l <sub>1</sub>	l <sub>2</sub>	d <sub>3</sub>	d <sub>2</sub>	z	Item #
0803	1/8	.316	2-11/32	19/32	.353	.315	6	R108 0803
1031	1/4	.406	2-21/32	25/32	.453	.394	6	R108 1031
1372	3/8	.540	2-31/32	7/8	.592	.492	6	R108 1372
1689	1/2	.665	3-7/16	1-1/32	.729	.630	6	R108 1689
2225	3/4	.876	3-25/32	1-1/8	.945	.787	6	R108 2225
2802	1	1.103	4-5/16	1-5/16	1.184	.984	6	R108 2802
3668	1-1/4	1.444	4-11/16	1-7/16	1.529	1.240	6	R108 3668
4277	1-1/2	1.684	4-15/16	1-15/32	1.775	1.398	8	R108 4277
5484	2	2.159	5-17/32	1-5/8	2.260	1.575	8	R108 5484