



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



GROUND THREAD TAPS

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.



**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





**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
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.

Nominal Diameter Inch	Thread per Inch	Thread Length mm	Overall Length mm	Shank Dia mm	Square Size mm
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	13	29	89	9.00	7.10
9/16	12	30	95	11.20	9.00
5/8	11	32	102	12.50	10.00
3/4	10	37	112	14.00	11.20
7/8	9	38	118	16.00	12.50
1	8	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	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	6.30	5.00
5/16	24	19	69	8.0	6.30
3/8	24	20	76	10.00	8.00
7/16	20	22	82	8.00	6.30
1/2	20	24	84	9.00	7.10
9/16	18	25	90	11.20	9.00
5/8	18	25	95	12.50	10.00

Nominal Diameter Inch	Thread per Inch	Thread Length mm	Overall Length mm	Shank Dia mm	Square Size mm
3/4	16	29	104	14	11.2
7/8	14	33	113	16	12.50
1	12	35	120	18	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 Inch	Thread 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 Inch	Thread 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 Inch	Thread 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 Inch	Thread 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

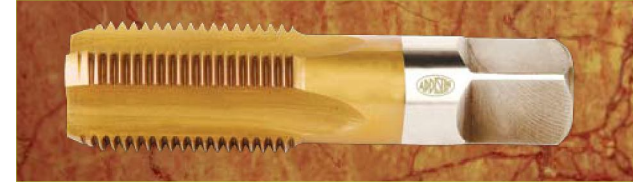
Manufactured with whitworth thread form with Straight flutes and a shank with square for driving.

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



**High Speed Steel
GROUND THREAD HAND TAPS
BSP (Parallel)**

Specifications Conform to :
BS 949:1951 | (Zone 3)
Dimensions in Inches



Nominal Diameter Inch	Thread 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 Diameter Inch	Thread 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 whitworth 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: Part 3 :1982
Dimensions in Inch / mm



Nominal Diameter Inch	Thread 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
1.1/8	11	34	115	28.0	22.40
1.1/4	11	36	119	31.5	25.0

Nominal Diameter Inch	Thread 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 whitworth 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	Thread 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	Thread 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 Diameter Inch	Thread 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 Diameter Inch	Thread 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 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 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