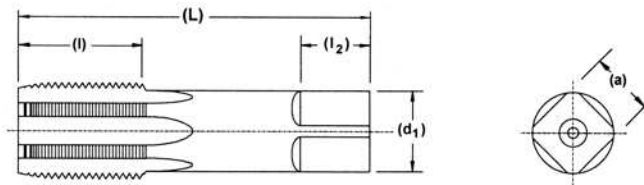


**SPECIAL FINE PITCH TAPS / SHORT SERIES**

Tap Dimensions, Ground Thread  
(Ref. USCTI Table 303)



Unless otherwise specified, special taps 1.010" to 1.510" diameter inclusive, having 14 or more threads per inch or 1.75mm pitch and finer, and sizes over 1.510" diameter with 10 or more threads per inch, or 2.5mm pitch and finer, will be made to the general dimensions shown below:

Nominal Diameter Range - Inches		Nominal Fractional Diameter Inches	Nominal Metric Diameter Millimeters, (in)	Tap Dimensions - Inches				
Over	To (Inc.)			Overall Length L	Thread Length l	Square Length l <sub>2</sub>	Shank Dia. d <sub>1</sub>	Size of Square a
1.010	1.073	1 1/16	M27	4.00	1.50	0.88	0.8960	0.6720
1.073	1.135	1 1/8	-	4.00	1.50	0.88	0.8960	0.6720
1.135	1.198	1 3/16	M30	4.00	1.50	1.00	1.0210	0.7660
1.198	1.260	1 1/4	-	4.00	1.50	1.00	1.0210	0.7660
1.260	1.323	1 5/16	M33	4.00	1.50	1.00	1.1080	0.8310
1.323	1.385	1 3/8	-	4.00	1.50	1.00	1.1080	0.8310
1.385	1.448	1 7/16	M36	4.00	1.50	1.00	1.2330	0.9250
1.448	1.510	1 1/2	-	4.00	1.50	1.00	1.2330	0.9250
1.510	1.635	1 5/8	M39	5.00	2.00	1.13	1.3050	0.9790
1.635	1.760	1 3/4	M42	5.00	2.00	1.25	1.4300	1.0720
1.760	1.885	1 7/8	-	5.00	2.00	1.25	1.5190	1.1390
1.885	2.010	2	M48	5.00	2.00	1.38	1.6440	1.2330
2.010	2.135	2 1/8	-	5.25	2.00	1.38	1.7690	1.3270
2.135	2.260	2 1/4	M56	5.25	2.00	1.44	1.8940	1.4200
2.260	2.385	2 3/8	-	5.25	2.00	1.44	2.0190	1.5140
2.385	2.510	2 1/2	-	5.25	2.00	1.50	2.1000	1.5750
2.510	2.635	2 5/8	M64	5.50	2.00	1.50	2.1000	1.5750
2.635	2.760	2 3/4	-	5.50	2.00	1.50	2.1000	1.5750
2.760	2.885	2 7/8	M72	5.50	2.00	1.50	2.1000	1.5750
2.885	3.010	3	-	5.50	2.00	1.50	2.1000	1.5750
3.010	3.135	3 1/8	-	5.75	2.00	1.50	2.1000	1.5750
3.135	3.260	3 1/4	M80	5.75	2.00	1.50	2.1000	1.5750
3.260	3.385	3 3/8	-	5.75	2.00	1.50	2.1000	1.5750
3.385	3.510	3 1/2	-	5.75	2.00	1.50	2.1000	1.5750
3.510	3.635	3 5/8	M90	6.00	2.00	1.75	2.1000	1.5750
3.635	3.760	3 3/4	-	6.00	2.00	1.75	2.1000	1.5750
3.760	3.885	3 7/8	-	6.00	2.00	1.75	2.1000	1.5750
3.885	4.010	4	M100	6.00	2.00	1.75	2.1000	1.5750

**NOTES**

- For tolerances see Table 302.
- For standard thread limits and tolerances for Unified Inch Screw Threads see Table 327A.
- For standard thread limits and tolerances for Metric Threads see Tables 337 and 341.
- For eccentricity tolerances of tap elements see Table 317.