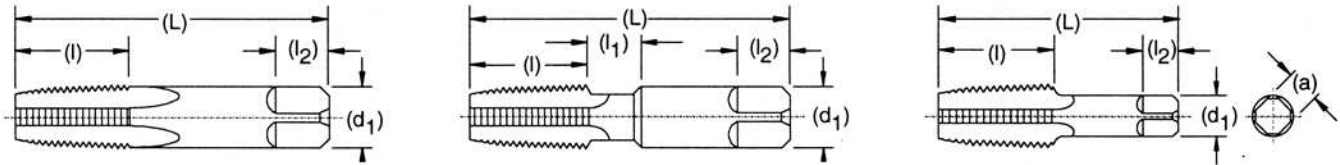


STANDARD PIPE TAP / STRAIGHT & TAPER

Ground Thread

(Ref. USCTI Table 311)



Tap Dimensions - Inches

Nominal Size Inches	Overall Length L	Thread Length l	Square Length l ₂	Shank Dia. d ₁	Size of Square a	Optional Neck Length l ₁
1/16	2.13	0.69	0.38	0.3125	0.2340	0.3750
1/8*	2.13	0.75	0.38	0.3125	0.2340	-
1/8	2.13	0.75	0.38	0.4375	0.3280	0.3750
1/4	2.44	1.06	0.44	0.5625	0.4210	0.3750
3/8	2.56	1.06	0.50	0.7000	0.5310	0.3750
1/2	3.13	1.38	0.63	0.6875	0.5150	-
3/4	3.25	1.38	0.69	0.9063	0.6790	-
1	3.75	1.75	0.81	1.1250	0.8430	-
1-1/4	4.00	1.75	0.94	1.3125	0.9840	-
1-1/2	4.25	1.75	1.00	1.5000	1.1250	-
2	4.50	1.75	1.13	1.8750	1.4060	-
2-1/2	5.50	2.56	1.25	2.2500	1.6870	-
3	6.00	2.63	1.38	2.6250	1.9680	-
3-1/2	6.50	2.69	1.50	2.8125	2.1080	-
4	6.75	2.75	1.56	3.0000	2.2500	-

* Small Shank

Tolerances

Element	Size Range	Direction	Tolerance
Overall Length - L	1/16 to 3/4 inc.	Plus or Minus	0.0310
	1 to 4 inc.	Plus or Minus	0.0630
Thread Length - l	1/16 to 3/4 inc.	Plus or Minus	0.0630
	1 to 1-1/4 inc.	Plus or Minus	0.0940
	1-1/2 to 4	Plus or Minus	0.1250
Square Length - l ₂	1/16 to 3/4 inc.	Plus or Minus	0.0310
	1 to 4 inc.	Plus or Minus	0.0630
Shank Diameter - d ₁	1/16 to 1/8	Minus	0.0015
	1/4 to 1 inc.	Minus	0.0020
	1-1/4 to 4 inc.	Minus	0.0030
Size of Square - a	1/16 to 1/8	Minus	0.0040
	1/4 to 3/4 inc.	Minus	0.0060
	1 to 4 inc.	Minus	0.0080

NOTE: For thread limits and tolerances see USCTI Tables 335, 335A and 338. For eccentricity tolerances of taps see Table 317.

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