

# SPECIAL THREAD HAND TAPS

- PRECISION GROUND THREAD
- RIGHT HAND, HIGH SPEED STEEL



SIZE	H LIMITS	TAPER	PLUG	BOTTOM
1-56	H1	3290-337	3290-336	3290-335
4-32	H2	3290-617	3290-616	3290-615
6-48	H2	3290-942	3290-941	3290-940
8-24	H3	3291-150	3291-149	3291-148
8-40	H2	3291-177	3291-176	3291-175
10-28	H3	3291-437	3291-436	3291-435
10-30	H3	3291-452	3291-451	3291-450
10-36	H2	3291-467	3291-466	3291-465
10-40	H2	3291-482	3291-481	3291-480
10-48	H2	3291-498	3291-497	3291-496
10-56	H2	3291-507	3291-506	3291-505
10-64	H2	3291-537	3291-536	3291-535
12-32	H3	3291-712	3291-711	3291-710
12-36	H2	3291-725	3291-724	3291-723
5/32-32	H3	3293-827	3293-826	3293-825
3/16-24	H3	3294-008	3294-007	3294-006
7/32-32	H3	3294-242	3294-241	3294-240
1/4-24	H3	3294-477	3294-476	3294-475
1/4-27	H3	3294-487	3294-486	3294-485
1/4-32	H2	3294-492	3294-491	3294-490
1/4-36	H2	3294-508	3294-507	3294-506
1/4-40	H2	3294-522	3294-521	3294-520
1/4-48	H2	3294-537	3294-536	3294-535
1/4-56	H2	3294-552	3294-551	3294-550
1/4-64	H2	3294-582	3294-581	3294-580
1/4-80	H2	3294-622	3294-621	3294-620
9/32-32	H3	3294-882	3294-881	3294-880
5/16-20	H3	3295-073	3295-072	3295-071
5/16-27	H3	3295-092	3295-091	3295-090
5/16-28	H3	3295-111	3295-110	3295-109
5/16-32	H3	3295-122	3295-121	3295-120
5/16-40	H2	3295-152	3295-151	3295-150
11/32-32	H3	3295-472	3295-471	3295-470
3/8-18	H3	3295-727	3295-726	3295-725
3/8-20	H3	3295-743	3295-742	3295-741
3/8-27	H3	3295-762	3295-761	3295-760
3/8-32	H3	3295-779	3295-778	3295-777
3/8-40	H2	3295-830	3295-829	3295-828
3/8-48	H2	3295-854	3295-853	3295-852
13/32-32	H3	3296-118	3296-117	3296-116
7/16-16	H3	3296-302	3296-301	3296-300
7/16-18	H3	3296-314	3296-313	3296-312
7/16-24	H3	3296-326	3296-325	3296-324
7/16-27	H3	3296-338	3296-337	3296-336
7/16-28	H3	3296-350	3296-349	3296-348
7/16-32	H3	3296-368	3296-367	3296-366
7/16-40	H2	3296-417	3296-416	3296-415
15/32-32	H3	3296-662	3296-661	3296-660
1/2-12	H3	3296-817	3296-816	3296-815
1/2-14	H3	3296-822	3296-821	3296-820
1/2-16	H3	3296-832	3296-831	3296-830
1/2-18	H3	3296-852	3296-851	3296-850
1/2-24	H3	3296-867	3296-866	3296-865
1/2-27	H3	3296-882	3296-881	3296-880
1/2-28	H3	3296-897	3296-896	3296-895
1/2-32	H3	3296-927	3296-926	3296-925
1/2-40	H2	3296-942	3296-941	3296-940
9/16-16	H3	3297-393	3297-392	3297-391
9/16-20	H3	3297-405	3297-404	3297-403
9/16-24	H3	3297-423	3297-422	3297-421

SIZE	H LIMITS	TAPER	PLUG	BOTTOM
9/16-27	H3	3297-444	3297-443	3297-442
9/16-32	H3	3297-474	3297-473	3297-472
5/8-10	H3	3297-903	3297-902	3297-901
5/8-12	H3	3297-917	3297-916	3297-915
5/8-16	H3	3297-947	3297-946	3297-945
5/8-20	H3	3297-959	3297-958	3297-957
5/8-24	H3	3297-971	3297-970	3297-969
5/8-27	H3	3297-989	3297-988	3297-987
5/8-28	H3	3298-002	3298-001	3298-000
5/8-32	H3	3298-013	3298-012	3298-011
11/16-18	H3	3298-432	3298-431	3298-430
11/16-20	H3	3298-444	3298-443	3298-442
11/16-24	H3	3298-447	3298-446	3298-445
11/16-28	H3	3298-484	3298-483	3298-482
11/16-32	H3	3298-499	3298-498	3298-497
3/4-12	H4	3298-900	3298-899	3298-898
3/4-14	H4	3298-923	3298-922	3298-921
3/4-18	H3	3298-917	3298-916	3298-915
3/4-20	H3	3298-932	3298-931	3298-930
3/4-24	H3	3298-947	3298-946	3298-945
3/4-27	H3	3298-968	3298-967	3298-966
3/4-32	H3	3298-998	3298-997	3298-996
3/4-40	H3	3299-028	3299-027	3299-026
13/16-10	H4	3299-502	3299-501	3299-500
13/16-12	H4	3299-514	3299-513	3299-512
13/16-16	H3	3299-527	3299-526	3299-525
13/16-18	H3	3299-542	3299-541	3299-540
13/16-20	H3	3299-557	3299-556	3299-555
13/16-24	H3	3299-578	3299-577	3299-576
7/8-10	H4	3300-022	3300-021	3300-020
7/8-12	H4	3300-032	3300-031	3300-030
7/8-16	H4	3300-045	3300-044	3300-043
7/8-18	H4	3300-057	3300-056	3300-055
7/8-20	H4	3300-072	3300-071	3300-070
7/8-24	H4	3300-093	3300-092	3300-091
7/8-27	H4	3300-108	3300-107	3300-106
7/8-32	H4	3300-138	3300-137	3300-136
15/16-12	H4	3300-538	3300-537	3300-536
15/16-14	H4	3300-553	3300-552	3300-551
15/16-16	H3	3300-568	3300-567	3300-566
15/16-18	H3	3300-583	3300-582	3300-581
15/16-20	H3	3300-598	3300-597	3300-596
15/16-32	H3	3300-664	3300-663	3300-662
1-10	H4	3301-036	3301-035	3301-034
1-16	H4	3301-049	3301-048	3301-047
1-18	H3	3301-062	3301-061	3301-060
1-20	H3	3301-074	3301-073	3301-072
1-24	H3	3301-092	3301-091	3301-090
1-27	H3	3301-104	3301-103	3301-102
1-32	H3	3301-116	3301-115	3301-114
1-40	H3	3301-140	3301-139	3301-138
1 1/16-8	H5	3301-450	3301-449	3301-448
1 1/16-12	H5	3301-464	3301-463	3301-462
1 1/16-14	H5	3301-476	3301-475	3301-474
1 1/16-16	H4	3301-488	3301-487	3301-486
1 1/16-18	H4	3301-500	3301-499	3301-498
1 1/16-20	H4	3301-518	3301-517	3301-516
1 1/16-24	H4	3301-530	3301-529	3301-528
1 1/8-10	H5	3301-752	3301-751	3301-750
1 1/8-14	H5	3301-774	3301-773	3301-772

**Special Hand Taps** are right hand, ground thread general purpose, high speed steel taps that are for hand use or under power. Manufactured to Table 302, 303 & 304 dimensions. They may be used in through holes or blind holes. Performance may be improved for selected materials with a surface treatment. They are available in three chamfers: Taper, Plug and Bottom.

**Taper** taps (7-10 threads chamfered) sometimes called a starter tap. Long chamfer reduces torque by having more teeth in contact with the material.

**Plug** taps (3-5 threads chamfered) used in either blind or through holes.

**Bottom** taps (1-2 threads chamfered) allow for tapping close to the bottom of a blind hole.

### Pitch Diameter Limits

- H1 Limit= Basic to basic plus .0005"
- H2 Limit= Basic plus .0005" to basic plus .001"
- H3 Limit= Basic plus .001" to basic plus .0015"
- H4 Limit= Basic plus .0015" to basic plus .002"
- H5 Limit= Basic plus .002" to basic plus .0025"
- H6 Limit= Basic plus .0025" to basic plus .003"
- H7 Limit= Basic plus .003" to basic plus .0035"
- H8 Limit= Basic plus .0035" to basic plus .004"
- H11 Limit= Basic plus .005" to basic plus .0055"



Taper



Plug



Bottoming