

Styles 1001, 1001-TN 1002, 1002-TN, 1003, 1003-TN, 1004 • Hand Taps

FEATURES

USCT1 302	HSS SUBSTRATE
GENERAL PURPOSE	BRIGHT
BLIND HOLES	STEAM OXIDE
THRU HOLES	TiN
GROUND THREAD	TiCN
TAPER 7-10	
PLUG 3-5	
BOTTOMING 1 1/2-2	

APPLICATIONS

ALLOY STEEL
CARBON STEEL
FREE-MACH STAINLESS
ALUMINUM



Style 1001 Taper Chamfer Bright



Style 1001 Taper Chamfer TiN-Coated



Style 1002 Plug Chamfer Bright



Style 1002 Plug Chamfer TiCN-Coated



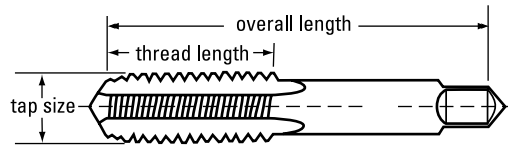
Style 1003 Bottoming Chamfer Bright



Style 1003 Bottoming Chamfer TiN-Coated

Tapping speeds are listed on page 131.

Set consists of one each taper, plug, and bottoming chamfers.



Tap Size-Pitch and Thd Form	Dec. Equiv.	MM Equiv.	# Flt	H-Limit	Overall Length		Thrd Length		Order Number								
					in	mm	in	mm	Taper 1001 Bright	TiN	Plug 1002 Bright Oxide	TiN	TiCN	Bottoming 1003 Bright	TiN	1004/Set Bright	
0-80 UNF	.0600	1.52	2	H1	1.625	41.28	.313	7.94	C54025		C54026				C54027		
0-80 UNF	.0600	1.52	2	H2	1.625	41.28	.313	7.94			C54029		C55156		C54030		
1-64 UNC	.0730	1.85	2	H1	1.688	42.86	.375	9.53	C54055		C54056				C54057		
1-72 UNC	.0730	1.85	2	H1	1.688	42.88	.375	9.53	C54060		C54061				C54062		
2-56 UNC	.0860	2.18	3	H1	1.750	44.45	.375	9.53	C54083		C54084				C54085		
2-56 UNC	.0860	2.18	2	H2	1.750	44.45	.375	9.53			C54087				C54088		
2-56 UNC	.0860	2.18	3	H2	1.750	44.45	.375	9.53	C54089		C54090		C55158	C56050	C54091		C54092
2-64 UNF	.0860	2.18	3	H2	1.750	44.45	.438	11.11	C54093		C54094				C54095		
3-48 UNC	.0990	2.51	3	H2	1.813	46.04	.500	12.70	C54115		C54116				C54117		C54118
3-56 UNF	.0990	2.51	3	H2	1.813	46.04	.500	12.70	C54120		C54121				C54122		C54123
4-40 UNC	.1120	2.84	2	H1	1.875	47.63	.563	14.29			C54142				C54148		
4-40 UNC	.1120	2.84	2	H2	1.875	47.63	.563	14.29			C54147				C54149		
4-40 UNC	.1120	2.84	3	H2	1.875	47.63	.563	14.29	C54149		C54150		C55160	C56052	C54151		C54152
4-48 UNF	.1120	2.84	3	H2	1.875	47.63	.563	14.29	C54153		C54154				C54155		C54156
5-40 UNC	.1250	3.18	2	H2	1.938	49.21	.625	15.88			C54186				C54187		
5-40 UNC	.1250	3.18	3	H2	1.938	49.21	.625	15.88	C54188		C54189		C55162		C54190		C54191
5-44 UNF	.1250	3.18	3	H2	1.938	49.21	.625	15.88	C54192		C54193				C54194		C54195
6-32 UNC	.1380	3.51	2	H2	2.000	50.80	.688	17.46			C54215				C54216		
6-32 UNC	.1380	3.51	3	H2	2.000	50.80	.688	17.46	C54217		C54218		C55164		C54219		C54220
6-32 UNC	.1380	3.51	2	H3	2.000	50.80	.688	17.46			C54221				C54222		
6-32 UNC	.1380	3.51	3	H3	2.000	50.80	.688	17.46	C54223		C54224	C56000	C55100	C56054	C54225	C55200	C54226
6-40 UNF	.1380	3.51	3	H2	2.000	50.80	.688	17.46	C54232		C54233		C55102		C54234	C55202	C54235
8-32 UNC	.1640	4.17	2	H1	2.125	53.98	.750	19.05			C54256				C54257		
8-32 UNC	.1640	4.17	2	H2	2.125	53.98	.750	19.05			C54264				C54265		
8-32 UNC	.1640	4.17	3	H2	2.125	53.98	.750	19.05			C54267				C54268		
8-32 UNC	.1640	4.17	4	H2	2.125	53.98	.750	19.05	C54269		C54270		C55166		C54271		C54272
8-32 UNC	.1640	4.17	2	H3	2.125	53.98	.750	19.05			C54273				C54274		
8-32 UNC	.1640	4.17	3	H3	2.125	53.98	.750	19.05			C54275				C54276		
8-32 UNC	.1640	4.17	4	H3	2.125	53.98	.750	19.05	C54277	C54307	C54278	C56002	C55104	C56056	C54279	C55204	C54280
8-36 UNF	.1640	4.17	4	H2	2.125	53.98	.750	19.05	C54289		C54290		C55106		C54291		C54292

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DRILLING
HOLE FINISHING
THREADING
MILLING
OTHER TOOLS

General-Purpose Taps

Hand Taps

Styles 1001, 1001-TN 1002, 1002-TN, 1003, 1003-TN, 1004 • Hand Taps (continued)

DRILLING

HOLE FINISHING

THREADING

MILLING

OTHER TOOLS

Tap Size-Pitch and Thd Form	Dec. Equiv.	MM Equiv.	# Flt	H- Limit	Overall Length in mm	Thrd Length in mm	Order Number													
							Taper 1001 Bright TiN		Plug 1002 Bright Oxide TiN TiCN			Bottoming 1003 Bright TiN		1004/Set Bright						
10-24 UNC .1900 4.83 2 H2 2.375 60.33 .875 22.23																				
10-24 UNC .1900 4.83 4 H2 2.375 60.33 .875 22.23							C54321													C54324
10-24 UNC .1900 4.83 2 H3 2.375 60.33 .875 22.23																				C54326
10-24 UNC .1900 4.83 3 H3 2.375 60.33 .875 22.23																				C54328
10-24 UNC .1900 4.83 4 H3 2.375 60.33 .875 22.23							C54329													C54332
10-32 UNF .1900 4.83 2 H2 2.375 60.33 .875 22.23																				
10-32 UNF .1900 4.83 4 H2 2.375 60.33 .875 22.23							C54348													C54351
10-32 UNF .1900 4.83 2 H3 2.375 60.33 .875 22.23																				C54353
10-32 UNF .1900 4.83 3 H3 2.375 60.33 .875 22.23																				C54355
10-32 UNF .1900 4.83 4 H3 2.375 60.33 .875 22.23							C54356	C54309												C54359
12-24 UNC .2160 5.49 4 H3 2.375 60.33 .938 23.81							C54385													C54388
12-28 UNF .2160 5.49 4 H3 2.375 60.33 .938 23.81							C54389													C54392
1/4-20 UNC .2500 6.35 4 H1 2.500 63.50 1.000 25.40							C54443													C54447
1/4-20 UNC .2500 6.35 3 H2 2.500 63.50 1.000 25.40																				
1/4-20 UNC .2500 6.35 4 H2 2.500 63.50 1.000 25.40							C54448													C54452
1/4-20 UNC .2500 6.35 2 H3 2.500 63.50 1.000 25.40																				
1/4-20 UNC .2500 6.35 3 H3 2.500 63.50 1.000 25.40																				C54457
1/4-20 UNC .2500 6.35 4 H3 2.500 63.50 1.000 25.40																				C54459
1/4-20 UNC .2500 6.35 4 H3 2.500 63.50 1.000 25.40							C54453													C54460
1/4-20 UNC .2500 6.35 3 H5 2.500 63.50 1.000 25.40																				
1/4-20 UNC .2500 6.35 4 H5 2.500 63.50 1.000 25.40																				C54462
1/4-20 UNC .2500 6.35 4 H11 2.500 63.50 1.000 25.40																				C54464
1/4-28 UNF .2500 6.35 4 H2 2.500 63.50 1.000 25.40																				C54468
1/4-28 UNF .2500 6.35 2 H3 2.500 63.50 1.000 25.40																				C54473
1/4-28 UNF .2500 6.35 3 H3 2.500 63.50 1.000 25.40																				C54475
1/4-28 UNF .2500 6.35 4 H3 2.500 63.50 1.000 25.40							C54469													C54476
5/16-18 UNC .3125 7.94 4 H2 2.719 69.06 1.125 28.58																				C54503
5/16-18 UNC .3125 7.94 2 H3 2.719 69.06 1.125 28.58																				C54508
5/16-18 UNC .3125 7.94 3 H3 2.719 69.06 1.125 28.58																				C54510
5/16-18 UNC .3125 7.94 4 H3 2.719 69.06 1.125 28.58							C54504													C54511
5/16-18 UNC .3125 7.94 4 H5 2.719 69.06 1.125 28.58																				C54513
5/16-18 UNC .3125 7.94 4 H11 2.719 69.06 1.125 28.58																				
5/16-24 UNF .3125 7.94 3 H3 2.719 69.06 1.125 28.58																				C54522
5/16-24 UNF .3125 7.94 4 H3 2.719 69.06 1.125 28.58							C54518													C54523
5/16-24 UNF .3125 7.94 4 H4 2.719 69.06 1.125 28.58																				C54525
3/8-16 UNC .3750 9.53 4 H2 2.938 74.61 1.250 31.75																				C54581
3/8-16 UNC .3750 9.53 3 H3 2.938 74.61 1.250 31.75																				C54586
3/8-16 UNC .3750 9.53 4 H3 2.938 74.61 1.250 31.75							C54582													C54587
3/8-16 UNC .3750 9.53 4 H5 2.938 74.61 1.250 31.75																				C54589
3/8-24 UNF .3750 9.53 3 H3 2.938 74.61 1.250 31.75																				C54599
3/8-24 UNF .3750 9.53 4 H3 2.938 74.61 1.250 31.75							C54595													C54600
7/16-14 UNC .4375 11.11 4 H3 3.156 80.17 1.438 36.51							C54652													C54656
7/16-14 UNC .4375 11.11 4 H5 3.156 80.17 1.438 36.51																				C54659
7/16-20 UNF .4375 11.11 4 H3 3.156 80.17 1.438 36.51							C54661													C54665
7/16-20 UNF .4375 11.11 4 H5 3.156 80.17 1.438 36.51																				C54667
1/2-13 UNC .5000 12.70 4 H1 3.375 85.73 1.656 42.06																				
1/2-13 UNC .5000 12.70 3 H3 3.375 85.73 1.656 42.06																				C54730
1/2-13 UNC .5000 12.70 4 H3 3.375 85.73 1.656 42.06							C54726													C54731
1/2-13 UNC .5000 12.70 4 H5 3.375 85.73 1.656 42.06																				C54733
1/2-20 UNF .5000 12.70 3 H3 3.375 85.73 1.656 42.06																				
1/2-20 UNF .5000 12.70 4 H3 3.375 85.73 1.656 42.06							C54737													C54741
1/2-20 UNF .5000 12.70 4 H5 3.375 85.73 1.656 42.06																				
9/16-12 UNC .5625 14.29 4 H3 3.594 91.28 1.656 42.07							C54759													C54762
9/16-18 UNC .5625 14.29 4 H3 3.594 91.28 1.656 42.07							C54765													C54768
5/8-11 UNC .6250 15.88 4 H3 3.813 96.84 1.813 46.04							C54779													C54782
5/8-11 UNC .6250 15.88 4 H5 3.813 96.84 1.813 46.04																				C54784
5/8-18 UNF .6250 15.88 4 H3 3.813 96.84 1.813 46.04							C54787													C54790

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