

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

### FEATURES

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

### APPLICATIONS

<b>ALLOY</b> STEEL
<b>CARBON</b> STEEL
<b>FREE-MACH</b> STAINLESS
<b>ALUMINUM</b>



Style 1001 Taper Chamfer Bright



Style 1001 Taper Chamfer TiN-Coated



Style 1002 Plug Chamfer Bright



Style 1002 Plug Chamfer TiCN-Coated



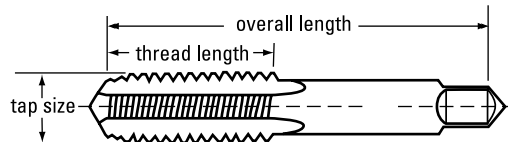
Style 1003 Bottoming Chamfer Bright



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

# Hand Taps

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

Tap Size and Pitch	Decimal Equivalent	Metric Equivalent	No of Flutes	D-Limit	Overall Length		Thread Length		Order Number			
					in	mm	in	mm	Taper 1001 Bright	Plug 1002 Bright	Bottoming 1003 Bright	Set 1004 Bright
M18 x 1.5	.7087	18.00	4	D6	4.031	102.39	1.813	46.04	C54825	C54826		
M18 x 2.5	.7087	18.00	4	D7	4.031	102.39	1.813	46.04	C54833	C54834	C54835	
M20 x 1.5	.7874	20.00	4	D6	4.469	113.51	2.000	50.80		C54857	C54858	
M20 x 2.5	.7874	20.00	4	D7	4.469	113.51	2.000	50.80	C54864	C54865	C54866	C54867
M24 x 3	.9449	24.00	4	D8	4.906	124.62	2.219	56.36	C54907	C54908	C54909	
M30 x 3.5	1.1811	30.00	4	D9	5.438	138.11	2.563	65.09		C54991		

DRILLING

HOLE FINISHING

THREADING

### Style 1002L • Left-Hand Taps

#### FEATURES

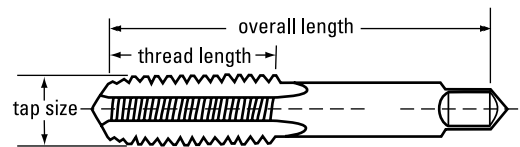
- USCTI 302
- HSS SUBSTRATE
- GENERAL PURPOSE
- BRIGHT
- THRU HOLES
- PLUG 3-5
- GROUND THREAD

#### APPLICATIONS

- ALLOY STEEL
- CARBON STEEL
- FREE-MACH STAINLESS
- ALUMINUM



Style 1002L Plug Chamfer Bright



Tapping speeds are listed on page 131.

Tap Size and Pitch	Thread Form	Decimal Equiv.	Metric Equiv.	Number of Flutes	H-Limit	Overall Length		Thread Length		Order Number
						in	mm	in	mm	Plug Bright
#10-32	UNF	.1900	4.83	4	H3	2.3750	60.33	.8750	22.23	C60732
1/4-20	UNC	.2500	6.35	4	H3	2.5000	63.50	1.0000	25.40	C60748
1/4-28	UNF	.2500	6.35	4	H3	2.5000	63.50	1.0000	25.40	C60752
5/16-18	UNC	.3125	7.94	4	H3	2.7190	69.06	1.1250	28.58	C60760
5/16-24	UNF	.3125	7.94	4	H3	2.7190	69.06	1.1250	28.58	C60764
3/8-16	UNC	.3750	9.53	4	H3	2.9380	74.63	1.2500	31.75	C60776
3/8-24	UNF	.3750	9.53	4	H3	2.9380	74.63	1.2500	31.75	C60780
7/16-20	UNF	.4375	11.11	4	H3	3.1560	80.16	1.4380	36.53	C60796
1/2-13	UNC	.5000	12.70	4	H3	3.3750	85.73	1.6560	42.06	C60808
1/2-20	UNF	.5000	12.70	4	H3	3.3750	85.73	1.6560	42.06	C60812
5/8-18	UNF	.6250	15.88	4	H3	3.8130	96.85	1.8130	46.05	C60831
3/4-10	UNC	.7500	19.05	4	H3	4.2500	107.95	2.0000	50.80	C60835
3/4-16	UNF	.7500	19.05	4	H3	4.2500	107.95	2.0000	50.80	C60866

MILLING

OTHER TOOLS

