

General-Purpose Taps

Straight Pipe Taps

Styles 963B, 967B • NPS/NPSF Straight Pipe Taps

DRILLING

FEATURES

USCTI 311	HSS SUBSTRATE
GENERAL PURPOSE	BRIGHT
NPS	MOD 3-5
NPSF DRYSEAL	
GROUND THREAD	

APPLICATIONS

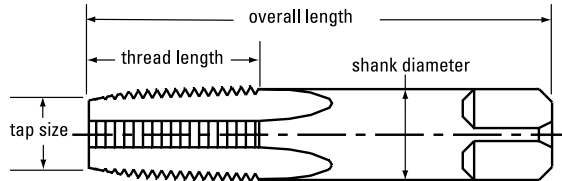
ALLOY-TOOL STEEL
CARBON STEEL



Style 963B NPS Bright



Style 967B NPSF Bright



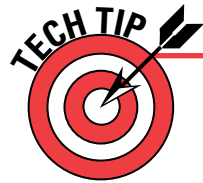
Tapping speeds are listed on page 131.

HOLE FINISHING

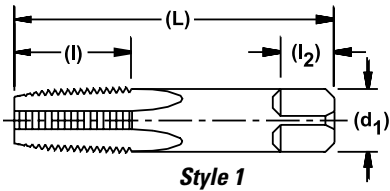
Tap Size and Pitch	Decimal Equiv.	Metric Equiv.	Number of Flutes	Shank Diameter		Overall Length		Thread Length		Order Number	
				in	mm	in	mm	in	mm	NPS 963B	NPSF 967B
1/8-27*	.1250	3.18	4	.3125	7.94	2.125	53.98	.750	19.05	–	C64129
1/8-27	.1250	3.18	4	.4375	11.11	2.125	53.98	.750	19.05	C64116	C64130
1/4-18	.2500	6.35	4	.5625	14.29	2.438	61.91	1.063	26.99	C64117	C64131
3/8-18	.3750	9.53	4	.7000	17.78	2.563	65.09	1.063	26.99	C64118	C64132
1/2-14	.5000	12.70	4	.6875	17.46	3.125	79.38	1.375	34.93	C64119	C64133

*small shank

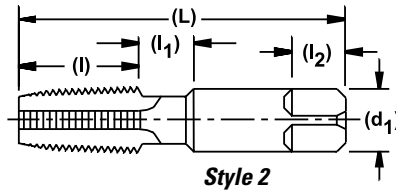
THREADING



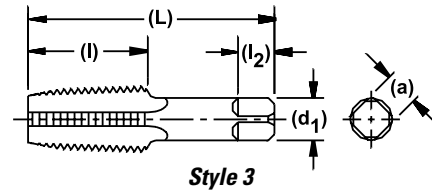
USCTI Table 311 • Standard Pipe Tap Dimensions, Straight and Taper, Ground Thread



Style 1



Style 2



Style 3

MILLING

General Dimensions (all measurements in inches)

Nominal Size	Tap Style	Overall Length L	Thread Length l	Square Length l2	Shank Diameter d1	Square Size a	Optional Neck l1
1/16	1	2.13	.69	.38	.3125	.234	.375
1/8	1	2.13	.75	.38	.3125	.234	–
1/8	1	2.13	.75	.38	.4375	.328	.375
1/4	1	2.44	1.06	.44	.5625	.421	.375
3/8	1	2.56	1.06	.50	.7000	.531	.375
1/2	3	3.13	1.38	.63	.6875	.515	–
3/4	3	3.25	1.38	.69	.9063	.679	–
1	3	3.75	1.75	.81	1.1250	.843	–
1-1/4	3	4.00	1.75	.94	1.3125	.984	–
1-1/2	3	4.25	1.75	1.00	1.5000	1.125	–
2	3	4.50	1.75	1.13	1.8750	1.406	–
2-1/2	3	5.50	2.56	1.25	2.2500	1.687	–
3	3	6.00	2.63	1.38	2.6250	1.968	–
3-1/2	3	6.50	2.69	1.50	2.8125	2.108	–
4	3	6.75	2.75	1.56	3.0000	2.250	–

Tolerances (all measurements in inches)

Element	Range	Direction	Tolerance
Length Overall - L	1/16" to 3/4" inc.	+/-	.031
	1" to 4" inc.	+/-	.063
Length of Thread - l	1/16" to 3/4" inc.	+/-	.063
	1" to 1-1/4" inc.	+/-	.094
	1-1/2" to 4" inc.	+/-	.125
Length of Square - l2	1/16" to 3/4" inc.	+/-	.031
	1" to 4" inc.	+/-	.063
Diameter of Shank - d1	1/16" to 1/8"	–	.0015
	1/4" to 1" inc.	–	.0020
	1-1/4" to 4" inc.	–	.0030
Size of Square - a	1/16" to 1/8"	–	.004
	1/4" to 3/4" inc.	–	.006
	1" to 4" inc.	–	.008

OTHER TOOLS