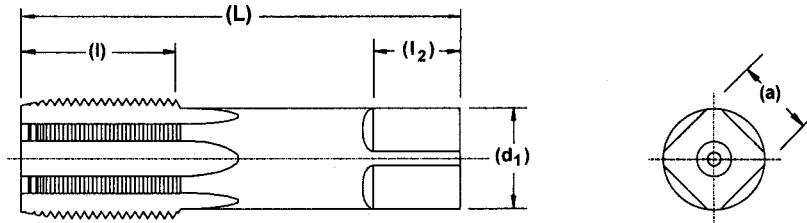


**SPECIAL TAPS**  
**ENGINEERING DATA**

**SPECIAL FINE PITCH TAPS, SHORT SERIES, GROUND THREAD**

(Ref. USCTI Table 303)



Unless otherwise specified, special taps 1.010" to 1.510" diameter inclusive, having 14 or more threads per inch or 1.75 millimeter pitch and finer, and sizes over 1.510" diameter with 10 or more threads per inch, or 2.5 millimeter pitch and finer, will be made to the general dimensions shown below:

**General Dimensions**

Nominal Diameter Range - Inches		Nominal Fractional Diameter Inches	Nominal Metric Diameter Millimeters	Tap Dimensions - Inches				
Over	To (Incl.)			Overall Length L	Thread Length l	Square Length l <sub>2</sub>	Shank Diameter d <sub>1</sub>	Size of Square a
1.010	1.073	1 1/16	M27	4.00	1.50	.88	.8960	.672
1.073	1.135	1 1/8		4.00	1.50	.88	.8960	.672
1.135	1.198	1 3/16	M30	4.00	1.50	1.00	1.0210	.766
1.198	1.260	1 1/4		4.00	1.50	1.00	1.0210	.766
1.260	1.323	1 5/16	M33	4.00	1.50	1.00	1.1080	.831
1.323	1.385	1 3/8		4.00	1.50	1.00	1.1080	.831
1.385	1.448	1 7/16	M36	4.00	1.50	1.00	1.2330	.925
1.448	1.510	1 1/2		4.00	1.50	1.00	1.2330	.925
1.510	1.635	1 5/8	M39	5.00	2.00	1.13	1.3050	.979
1.635	1.760	1 3/4	M42	5.00	2.00	1.25	1.4300	1.072
1.760	1.885	1 7/8		5.00	2.00	1.25	1.5190	1.139
1.885	2.010	2	M48	5.00	2.00	1.38	1.6440	1.233
2.010	2.135	2 1/8		5.25	2.00	1.38	1.7690	1.327
2.135	2.260	2 1/4	M56	5.25	2.00	1.44	1.8940	1.420
2.260	2.385	2 3/8		5.25	2.00	1.44	2.0190	1.514
2.385	2.510	2 1/2		5.25	2.00	1.50	2.1000	1.575
2.510	2.635	2 5/8	M64	5.50	2.00	1.50	2.1000	1.575
2.635	2.760	2 3/4		5.50	2.00	1.50	2.1000	1.575
2.760	2.885	2 7/8	M72	5.50	2.00	1.50	2.1000	1.575
2.885	3.010	3		5.50	2.00	1.50	2.1000	1.575
3.010	3.135	3 1/8		5.75	2.00	1.50	2.1000	1.575
3.135	3.260	3 1/4	M80	5.75	2.00	1.50	2.1000	1.575
3.260	3.385	3 3/8		5.75	2.00	1.50	2.1000	1.575
3.385	3.510	3 1/2		5.75	2.00	1.50	2.1000	1.575
3.510	3.635	3 5/8	M90	6.00	2.00	1.75	2.1000	1.575
3.635	3.760	3 3/8		6.00	2.00	1.75	2.1000	1.575
3.760	3.885	3 7/8		6.00	2.00	1.75	2.1000	1.575
3.885	4.010	4	M100	6.00	2.00	1.75	2.1000	1.575

**Notes**

For tolerances see Table 302.

For standard thread limits and tolerances for Unified Inch Screw Threads see Tables 327A.

For standard thread limits and tolerances for Metric Threads see Tables 337 and 341.

For eccentricity tolerances of tap elements see Table 317.