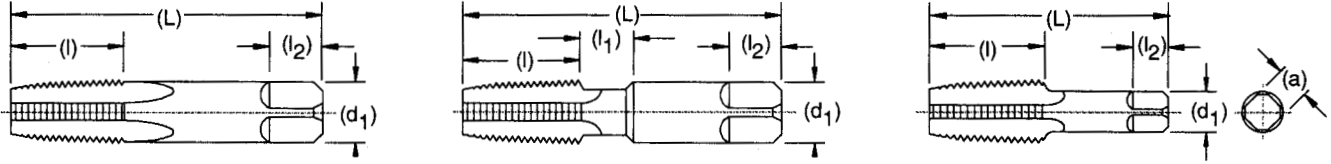


SPECIAL TAPS
ENGINEERING DATA

STANDARD PIPE TAP DIMENSIONS
STRAIGHT AND TAPER, GROUND THREAD

(Ref. USCTI Table 311)



General Dimensions

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

Tolerances

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

Note

For thread limits and tolerances see Tables 335, 335A and 338.
For eccentricity tolerances of taps see Table 317.