



High Speed Steel
GROUND THREAD HAND AND
SHORT MACHINE SCREWING TAPS
For ISO Metric Screw Threads

Specifications Conform to :
IS 6175 : Part 2 : 1992
Dimensions in mm



TABLE I : ISO Metric Screw Threads Coarse Pitch

Nominal Diameter	Pitch	Thread Length	Overall Length	Shank Dia	Square Size
3.0	0.50	11	48	3.15	2.50
4.0	0.70	13	53	4.00	3.15
4.5	0.75	13	53	4.50	3.55
5.0	0.80	16	58	5.00	4.00
6.0	1.00	19	66	6.30	5.00
7.0	1.00	19	66	7.10	5.60
8.0	1.25	22	72	8.00	6.30
9.0	1.25	22	72	9.00	7.10
10.0	1.50	24	80	10.00	8.00

TABLE II : ISO Metric Screw Threads Fine Pitch

Nominal Diameter	Pitch	Thread Length	Overall Length	Shank Dia	Square Size
4.0	0.50	13	53	4.00	3.15
4.5	0.50	13	53	4.50	3.55
5.0	0.50	16	58	5.00	4.00
5.5	0.50	17	62	5.60	4.50
6.0	0.75	19	66	6.30	5.00
7.0	0.75	19	66	7.10	5.60
8.0	0.75	16	66	8.0	6.30
8.0	1.00	19	69	8.0	6.30
9.0	0.75	16	66	9.0	7.10
9.0	1.00	19	69	9.0	7.10
10.0	0.75	17	73	10.0	8.00
10.0	1.00	20	76	10.0	8.00
10.0	1.25	20	76	10.0	8.00

Manufactured with straight flutes and a shank with square for driving.

- 1) Unless otherwise specified, the Screwing taps shall be supplied with tolerance class '6H', non - serial and with Straight flutes.
- 2) Usually supplied in sets consisting of three taps, viz. Taper , Second , Bottoming , for Coarse Pitch and Taper and Bottoming for Fine Pitch.



High Speed Steel
GROUND THREAD HAND AND
SHORT MACHINE SCREWING TAPS
For ISO Metric Coarse Pitch Threads

Specifications Conform to :
IS 6175 : Part 3 : 1992
Dimensions in mm



Nominal Diameter	Pitch	Thread Length	Overall Length	Shank Dia	Square Size
11	1.50	25	85	8.0	6.30
12	1.75	29	89	9.0	7.10
14	2.00	30	95	11.20	9.00
16	2.00	32	102	12.50	10.00
18	2.50	37	112	14.00	11.20
20	2.50	37	112	14.00	11.20
22	2.50	38	118	16.00	12.50
24	3.00	45	130	18.00	14.00
27	3.00	45	135	20.00	16.00
30	3.50	48	138	20.00	16.00
33	3.50	51	151	22.40	18.00

Nominal Diameter	Pitch	Thread Length	Overall Length	Shank Dia	Square Size
36	4.00	57	162	25.00	20.00
39	4.00	60	170	28.00	22.40
42	4.50	60	170	28.00	22.40
45	4.50	67	187	31.50	25.00
48	5.00	67	187	31.50	25.00
52	5.00	70	200	35.50	28.00
56	5.50	70	200	35.50	28.00
60	5.50	76	221	40.00	31.50
64	6.00	79	224	40.00	31.50
68	6.00	79	234	45.00	35.50

- 1) Unless otherwise specified, the Screwing taps shall be supplied with tolerance class '6H',non - serial and with Straight flutes.
- 2) Usually supplied in sets consisting of three taps, viz. Taper, Second, Bottoming.



High Speed Steel
GROUND THREAD HAND AND
SHORT MACHINE SCREWING TAPS
 For ISO Metric Fine Pitch Threads

Specifications Conform to :
 IS 6175 : Part 3 : 1992
 Dimensions in mm



Nominal Diameter	Pitch	Thread Length	Overall Length	Shank Dia	Square Size
11	0.75	20	80	8.00	6.30
11	1.00	20	80	8.00	6.30
12	1.00	20	80	9.00	7.10
12	1.25	24	84	9.00	7.10
12	1.50	29	89	9.00	7.10
14	1.00	22	87	11.20	9.00
14	1.25	25	90	11.20	9.00
14	1.50	30	95	11.20	9.00
15	1.00	22	87	11.20	9.00
15	1.50	30	95	11.20	9.00
16	1.00	22	92	12.50	10.00
16	1.50	32	102	12.50	10.00
17	1.00	22	92	12.50	10.00
17	1.50	32	102	12.50	10.00
18	1.00	22	97	14.00	11.20
18	1.50	29	104	14.00	11.20
18	2.00	37	112	14.00	11.20
20	1.00	27	102	14.00	11.20
20	1.50	29	104	14.00	11.20
20	2.00	37	112	14.00	11.20
22	1.00	29	109	16.00	12.50
22	1.50	33	113	16.00	12.50

Nominal Diameter	Pitch	Thread Length	Overall Length	Shank Dia	Square Size
22	2.00	38	118	16.00	12.50
24	1.00	29	114	18.00	14.00
24	1.50	35	120	18.00	14.00
24	2.00	35	120	18.00	14.00
25	1.00	29	114	18.00	14.00
25	1.50	35	120	18.00	14.00
25	2.00	35	120	18.00	14.00
26	1.50	35	120	18.00	14.00
27	1.00	30	120	20.00	16.00
27	1.50	37	127	20.00	16.00
27	2.00	37	127	20.00	16.00
28	1.00	30	120	20.00	16.00
28	1.50	37	127	20.00	16.00
28	2.00	37	127	20.00	16.00
30	1.00	30	120	20.00	16.00
30	1.50	37	127	20.00	16.00
30	2.00	37	127	20.00	16.00
30	3.00	48	138	20.00	16.00
32	1.50	37	137	22.40	18.00
32	2.00	37	137	22.40	18.00
33	1.50	37	137	22.40	18.00
33	2.00	37	137	22.40	18.00

Manufactured with straight flutes and a shank with square for driving.



High Speed Steel
GROUND THREAD HAND AND
SHORT MACHINE SCREWING TAPS
 For ISO Metric Fine Pitch Threads

Specifications Conform to :
 IS 6175 : Part 3 : 1992
 Dimensions in mm



Nominal Diameter	Pitch	Thread Length	Overall Length	Shank Dia	Square Size
33	3.0	51	151	22.4	18.0
35	1.5	39	144	25.0	20.0
36	1.5	39	144	25.0	20.0
36	2.0	39	144	25.0	20.0
36	3.0	57	162	25.0	20.0
38	1.5	39	149	28.0	22.4
39	1.5	39	149	28.0	22.4
39	2.0	39	149	28.0	22.4
39	3.0	60	170	28.0	22.4
40	1.5	39	149	28.0	22.4
40	2.0	39	149	28.0	22.4
40	3.0	60	170	28.0	22.4
42	1.5	39	149	28.0	22.4
42	2.0	39	149	28.0	22.4
42	3.0	60	170	28.0	22.4
42	4.0	60	170	28.0	22.4
45	1.5	45	165	31.5	25.0
45	2.0	45	165	31.5	25.0
45	3.0	67	187	31.5	25.0
45	4.0	67	187	31.5	25.0
48	1.5	45	165	31.5	25.0
48	2.0	45	165	31.5	25.0
48	3.0	67	187	31.5	25.0
48	4.0	67	187	31.5	25.0
50	1.5	45	165	31.5	25.0
50	2.0	45	165	31.5	25.0
50	3.0	67	187	31.5	25.0
52	1.5	45	175	35.5	28.0
52	2.0	45	175	35.5	28.0
52	3.0	70	200	35.5	28.0
52	4.0	70	200	35.5	28.0
55	1.5	45	175	35.5	28.0

Nominal Diameter	Pitch	Thread Length	Overall Length	Shank Dia	Square Size
55	2.0	45	175	35.5	28.0
55	3.0	70	200	35.5	28.0
55	4.0	70	200	35.5	28.0
56	1.5	45	175	35.5	28.0
56	2.0	45	175	35.5	28.0
56	3.0	70	200	35.5	28.0
56	4.0	70	200	35.5	28.0
58	1.5	48	193	40.0	31.5
58	2.0	48	193	40.0	31.5
58	3.0	64	209	40.0	31.5
58	4.0	64	209	40.0	31.5
60	1.5	48	193	40.0	31.5
60	2.0	48	193	40.0	31.5
60	3.0	64	209	40.0	31.5
60	4.0	64	209	40.0	31.5
62	1.5	48	193	40.0	31.5
62	2.0	48	193	40.0	31.5
62	3.0	64	209	40.0	31.5
62	4.0	64	209	40.0	31.5
64	1.5	48	193	40.0	31.5
64	2.0	48	193	40.0	31.5
64	3.0	64	209	40.0	31.5
64	4.0	64	209	40.0	31.5
65	1.5	48	193	40.0	31.5
65	2.0	48	193	40.0	31.5
65	3.0	64	209	40.0	31.5
65	4.0	64	209	40.0	31.5
68	1.5	48	203	45.0	35.5
68	2.0	48	203	45.0	35.5
68	3.0	64	219	45.0	35.5
68	4.0	64	219	45.0	35.5
70	1.5	48	203	45.0	35.5



**High Speed Steel
GROUND THREAD HAND AND
SHORT MACHINE SCREWING TAPS
For ISO Metric Fine Pitch Threads**

Specifications Conform to :
IS 6175 : Part 3 : 1992
Dimensions in mm



Nominal Diameter	Pitch	Thread Length	Overall Length	Shank Dia	Square Size
70	2.0	48	203	45	35.5
70	3.0	64	219	45	35.5
70	4.0	64	219	45	35.5
70	6.0	79	234	45	35.5
72	1.5	48	203	45	35.5
72	2.0	48	203	45	35.5
72	3.0	64	219	45	35.5
72	4.0	64	219	45	35.5
72	6.0	79	234	45	35.5
75	1.5	48	203	45	35.5
75	2.0	48	203	45	35.5
75	3.0	64	219	45	35.5
75	4.0	64	219	45	35.5
76	1.5	51	226	50	40.0
76	2.0	51	226	50	40.0
76	3.0	67	242	50	40.0
76	4.0	67	242	50	40.0
76	6.0	83	258	50	40.0
78	2.0	51	226	50	40.0
80	1.5	51	226	50	40.0
80	2.0	51	226	50	40.0

Nominal Diameter	Pitch	Thread Length	Overall Length	Shank Dia	Square Size
80	3.0	67	242	50	40.0
80	4.0	67	242	50	40.0
80	6.0	83	258	50	40.0
82	2.0	51	226	50	40.0
85	2.0	51	226	50	40.0
85	3.0	67	242	50	40.0
85	4.0	67	242	50	40.0
85	6.0	86	261	50	40.0
90	2.0	51	226	50	40.0
90	3.0	67	242	50	40.0
90	4.0	67	242	50	40.0
90	6.0	86	261	50	40.0
95	2.0	54	244	56	45.0
95	3.0	70	260	56	45.0
95	4.0	70	260	56	45.0
95	6.0	89	279	56	45.0
100	2.0	54	244	56	45.0
100	3.0	70	260	56	45.0
100	4.0	70	260	56	45.0
100	6.0	89	279	56	45.0

- 1) Unless otherwise specified, the Screwing taps shall be supplied with tolerance class '6H'. non - serial and with Straight flutes.
2) Usually supplied in sets consisting of two taps viz. Taper and Bottoming.



**High Speed Steel
GROUND THREAD HAND TAPS
BSW Form**

Specifications Conform to:
BS 949: Part 2 : 1979
(Class 2, Corresponds to Zone 3)
Dimensions in Inch / mm



Nominal Diameter Inch	Thread per Inch	Thread Length mm	Overall Length mm	Shank Dia mm	Square Size mm
3/16	24	16	58	5.00	4.00
1/4	20	19	66	6.30	5.00
5/16	18	22	72	8.00	6.30
3/8	16	24	80	10.00	8.00
7/16	14	25	85	8.00	6.30
1/2	12	29	89	9.00	7.10
9/16	12	30	95	11.20	9.00
5/8	11	32	102	12.50	10.00
11/16	11	37	112	14.00	11.20
3/4	10	37	112	14.00	11.20
7/8	9	38	118	16.00	12.50

Nominal Diameter Inch	Thread per Inch	Thread Length mm	Overall Length mm	Shank Dia mm	Square Size mm
1	8	45	130	18.0	14.0
1.1/8	7	48	138	20.0	16.0
1.1/4	7	51	151	22.4	18.0
1.3/8	6	57	162	25.0	20.0
1.1/2	6	60	170	28.0	22.4
1.3/4	5	67	187	31.5	25.0
2	4.1/2	70	200	35.5	28.0
2.1/4	4	76	221	40.0	31.5
2.1/2	4	79	224	40.0	31.5
2.3/4	3.1/2	79	234	45.0	35.5
3	3.1/2	83	258	50.0	40.0

Taps upto and including 3/8" dia, are supplied with full diameter shank and a neck between threaded portion and shank.

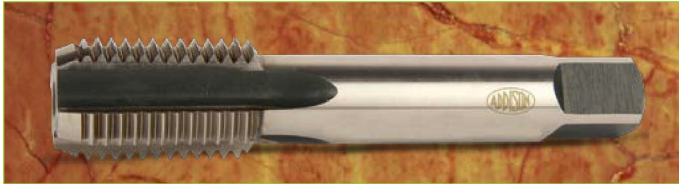
Manufactured with Straight flutes and a shank with square for driving.

Usually supplied in sets consisting of three taps, viz. Taper, Second and Bottoming.



High Speed Steel
GROUND THREAD HAND TAPS
BSF Form

Specifications Conform to
BS 949: Part 2 : 1979
(Class 2, Corresponds to Zone 3)
Dimensions in Inch / mm



Nominal Diameter Inch	Thread per Inch	Thread Length mm	Overall Length mm	Shank Dia mm	Square Size mm
3/16	32	16	58	5.00	4.00
1/4	26	19	66	6.30	5.00
5/16	22	22	72	8.00	6.30
3/8	20	24	80	10.00	8.00
7/16	18	25	85	8.00	6.30
1/2	16	29	89	9.00	7.10
9/16	16	30	95	11.20	9.00
5/8	14	32	102	12.50	10.00
11/16	14	37	112	14.00	11.20
3/4	12	37	112	14.00	11.20
7/8	11	38	118	16.00	12.50
1	10	45	130	18.00	14.00

Taps upto and including 3/8" dia, are supplied with full diameter shank and a neck between threaded portion and shank.

Manufactured with Straight flutes and a shank with square for driving.

Usually supplied in sets consisting of three taps , viz. Taper, Second and Bottoming.



High Speed Steel
GROUND THREAD HAND TAPS
UNC Form

Specifications Conform to:
BS 949:Part 2 : 1979
(Class 2, Corresponds to Zone 3)
Dimensions in Inch / mm



Nominal Diameter Inch	Thread per Inch	Thread Length mm	Overall Length mm	Shank Dia mm	Square Size mm
1/4	20	19	66	6.30	5.00
5/16	18	22	72	8.00	6.30
3/8	16	24	80	10.00	8.00
7/16	14	25	85	8.00	6.30
1/2	13	29	89	9.00	7.10
9/16	12	30	95	11.20	9.00
5/8	11	32	102	12.50	10.00
3/4	10	37	112	14.00	11.20
7/8	9	38	118	16.00	12.50
1	8	45	130	18.00	14.00

Taps upto and including 3/8" dia, are supplied with full diameter shank and a neck between threaded portion and shank.

Manufactured with Straight flutes and a shank with square for driving.

Usually supplied in sets consisting of three taps , viz. Taper, Second and Bottoming.



High Speed Steel
GROUND THREAD HAND TAPS
UNF Form

Specifications Conform to :
BS 949: Part 2 : 1979
(Class 2, Corresponds to Zone 3)
Dimensions in Inch / mm



Nominal Diameter Inch	Thread per Inch	Thread Length mm	Overall Length mm	Shank Dia mm	Square Size mm
1/4	28	19	66	6.30	5.00
5/16	24	19	69	8.0	6.30
3/8	24	20	76	10.00	8.00
7/16	20	22	82	8.00	6.30
1/2	20	24	84	9.00	7.10
9/16	18	25	90	11.20	9.00
5/8	18	25	95	12.50	10.00

Nominal Diameter Inch	Thread per Inch	Thread Length mm	Overall Length mm	Shank Dia mm	Square Size mm
3/4	16	29	104	14	11.2
7/8	14	33	113	16	12.50
1	12	35	120	18	14.0
1.1/8	12	37	127	20.0	16.0
1.1/4	12	37	137	22.4	18.0
1.3/8	12	39	144	25.0	20.0
1.1/2	12	39	149	28.0	22.4

Taps upto and including 3/8" dia, are supplied with full diameter shank and a neck between threaded portion and shank.

Manufactured with Straight flutes and a shank with square for driving.

Usually supplied in sets consisting of three taps , viz. Taper, Second and Bottoming.



High Speed Steel
GROUND THREAD HAND TAPS
BSCY Form

Specifications Conform to :
BS 949:1951 | (Zone 3)
Dimensions in Inches



Nominal Diameter Inch	Thread per Inch	Thread Length	Overall Length	Shank Dia	Square Size
1/4	26	1	2.1/2	0.253	0.197
5/16	26	1.1/8	2.3/4	0.315	0.242
3/8	26	1.1/4	2.15/16	0.377	0.294
7/16	26	1.1/4	3	0.323	0.242
1/2	26	1.1/4	3	0.367	0.275
9/16	26	1.1/4	3	0.429	0.322
5/8	26	1.1/4	3	0.480	0.360
11/16	26	1.1/4	3	0.542	0.406
3/4	26	1.1/2	3.1/4	0.590	0.442

Nominal Diameter Inch	Thread per Inch	Thread Length	Overall Length	Shank Dia	Square Size
7/8	24	1.1/2	3.1/4	0.697	0.523
1	24	1.1/2	3.1/4	0.800	0.600
1.1/8	26	1.1/2	4	0.896	0.672
1.290	24	1.1/2	4	1.021	0.766
1.370	24	1.1/2	4	1.108	0.831
1.450	26	1.1/2	4	1.233	0.925
1.9/16	24	2	5	1.305	0.979
1.5/8	24	2	5	1.305	0.979

Manufactured with Straight flutes and a shank with square for driving.

Usually supplied in sets consisting of three taps, viz. Taper, Second and Bottoming.



High Speed Steel
GROUND THREAD HAND TAPS
BS Conduit Form

Specifications Conform to :
BS 949: 1951 | (Zone 3)
Dimensions in Inches



Nominal Diameter Inch	Thread per Inch	Thread Length	Overall Length	Shank Dia	Square Size
1/2	18	1.1/4	3	0.367	0.275
5/8	18	1.1/4	3	0.480	0.360
3/4	16	1.1/2	3.1/4	0.590	0.442
1	16	1.1/2	3.1/4	0.800	0.600

Nominal Diameter Inch	Thread per Inch	Thread Length	Overall Length	Shank Dia	Square Size
1.1/4	16	1.1/2	4	1.021	0.766
1.1/2	14	1.1/2	4	1.233	0.925
2	14	2	5	1.644	1.233
2.1/2	14	2	5.1/4	2.100	1.575

Manufactured with whitworth thread form with Straight flutes and a shank with square for driving.

Usually supplied in sets consisting of three taps, viz. Taper, Second and Bottoming.



High Speed Steel
GROUND THREAD HAND TAPS
BSP (Parallel)

Specifications Conform to :
BS 949:1951 | (Zone 3)
Dimensions in Inches



Nominal Diameter Inch	Thread per Inch	Thread Length	Overall Length	Shank Dia	Square Size
1/8	28	3/4	2.1/8	0.318	0.238
1/4	19	1.1/16	2.7/16	0.429	0.322
3/8	19	1.1/16	2.9/16	0.542	0.406
1/2	14	1.3/8	3.1/8	0.687	0.515
5/8	14	1.3/8	3.3/16	0.800	0.600
3/4	14	1.3/8	3.1/4	0.906	0.679
7/8	14	1.9/16	3.1/2	1.093	0.812
1	11	1.3/4	3.3/4	1.125	0.843
1.1/4	11	1.3/4	4	1.312	0.984

Nominal Diameter Inch	Thread per Inch	Thread Length	Overall Length	Shank Dia	Square Size
1.1/2	11	1.3/4	4.1/4	1.500	1.125
1.3/4	11	1.3/4	4.3/8	1.625	1.218
2	11	1.3/4	4.1/2	1.875	1.406
2.1/4	11	2.1/8	5	2.000	1.500
2.1/2	11	2.9/16	5.1/2	2.250	1.687
2.3/4	11	2.9/16	5.3/4	2.375	1.781
3	11	2.5/8	6	2.625	1.968
3.1/2	11	2.11/16	6.1/2	2.812	2.108
4	11	2.3/4	6.3/4	3.000	2.250

Manufactured with whitworth thread form with Straight flutes and a shank with square for driving.

Usually supplied in sets consisting of two taps, viz. Taper and Bottoming.



High Speed Steel
GROUND THREAD HAND TAPS
BSP (Parallel) 'G' Series

Specifications Conform to :
BS 949: Part 3 :1982
Dimensions in Inch / mm



Nominal Diameter Inch	Thread per Inch	Thread Length mm	Overall Length mm	Shank Dia mm	Square Size mm
1/8	28	15	59	8.0	6.3
1/4	19	19	67	10.0	8.0
3/8	19	21	75	12.5	10.0
1/2	14	26	87	16.0	12.5
5/8	14	26	91	18.0	14.0
3/4	14	28	96	20.0	16.0
7/8	14	29	102	22.4	18.0
1	11	33	109	25.0	20.0
1.1/8	11	34	115	28.0	22.40
1.1/4	11	36	119	31.5	25.0

Nominal Diameter Inch	Thread per Inch	Thread Length mm	Overall Length mm	Shank Dia mm	Square Size mm
1.1/2	11	37	125	35.5	28.0
1.3/4	11	39	132	35.5	28.0
2	11	41	140	40.0	31.5
2.1/4	11	42	142	40.0	31.5
2.1/2	11	45	153	45.0	35.5
2.3/4	11	46	160	50.0	40.0
3	11	48	164	50.0	40.0
3.1/2	11	50	173	63.0	50.0
4	11	53	185	71.0	56.0

Manufactured with whitworth thread form with Straight flutes and a shank with square for driving.

Usually supplied in sets consisting of two taps, viz. Taper and Bottoming.



High Speed Steel
GROUND THREAD HAND TAPS
BSP (Taper) 'Rc' Series

Specifications Conform to :
BS 949: Part 3 :1982
Dimensions in Inch / mm



Nominal Diameter Inch	Thread per Inch	Thread Length mm	Overall Length mm	Shank Dia mm	Square Size mm
1/8	28	15	59	8.0	6.3
1/4	19	19	67	10.0	8.0
3/8	19	21	75	12.5	10.0
1/2	14	26	87	16.0	12.5
3/4	14	28	96	20.0	16.0
1	11	33	109	25.0	20.0

Nominal Diameter Inch	Thread per Inch	Thread Length mm	Overall Length mm	Shank Dia mm	Square Size mm
1.1/4	11	36	119	31.5	25.0
1.1/2	11	37	125	35.5	28.0
2	11	41	140	40.0	31.5
2.1/2	11	45	153	45.0	35.5
3	11	48	164	50.0	40.0
4	11	53	185	71.0	56.0

Manufactured with Straight flutes and a shank with square for driving.

Usually supplied in sets consisting of two taps, viz. Taper and Bottoming.



High Speed Steel
GROUND THREAD HAND TAPS
 American National Taper Pipe Taps (NPT)

Specifications Conform to :
 BS 949: 1969
 Dimensions in inches



Nominal Diameter Inch	Thread per Inch	Thread Length	Overall Length	Shank Dia	Square Size
1/8	27	3/4	2.1/8	0.318	0.238
1/4	18	1.1/16	2.7/16	0.429	0.322
3/8	18	1.1/16	2.9/16	0.542	0.406
1/2	14	1.3/8	3.1/8	0.687	0.515
3/4	14	1.3/8	3.1/4	0.906	0.679
1	11.1/2	1.3/4	3.3/4	1.125	0.843
1.1/4	11.1/2	1.3/4	4	1.312	0.984

Nominal Diameter Inch	Thread per Inch	Thread Length	Overall Length	Shank Dia	Square Size
1.1/2	11.1/2	1.3/4	4.1/4	1.500	1.125
2	11.1/2	1.3/4	4.1/2	1.875	1.406
2.1/2	8	2.9/16	5.1/2	2.250	1.687
3	8	2.5/8	6	2.625	1.968
3.1/2	8	2.11/16	6.1/2	2.812	2.108
4	8	2.3/4	6.3/4	3.000	2.250

Manufactured with Straight flutes and a shank with square for driving.

Usually supplied in sets consisting of two taps , viz. Taper and Bottoming.