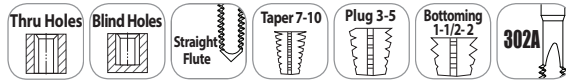




# Machine Tap for Through or Blind Holes

Style: **HTGP**

General Purpose  
Straight Flute



Machine Taps

Spiral Point Taps

Spiral Flute Taps

Thread Forming Taps

Pipe Taps

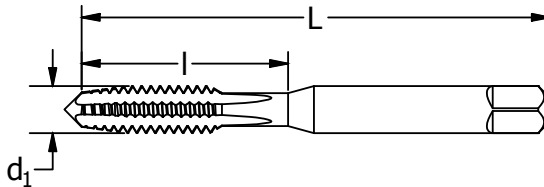
Dies

Technical Info

Sets

Index

**Note**  
Tapping speeds - see page 39-41.  
Set consists of one each taper, plug, bottoming chamfer.  
\* #0 - #3 and 7/8" and larger: 302 blank style.  
Sets available - see page 14.



order number

diameter & pitch	thrd form	d <sub>1</sub> in	no. flts	H-limit	L in	l in	taper		plug				bottoming		set	
							Bright	TiN	Bright	Oxide	TiN	TiCN	Bright	TiN	Bright	TiN
*0-80	UNF	.0600	2	H1	1.625	0.313	330004	—	330016	—	—	—	330066	—	—	—
*0-80	UNF	.0600	2	H2	1.625	0.313	—	—	300041	—	300047	—	300058	300054	—	—
*1-64	UNC	.0730	2	H1	1.688	0.375	330005	—	330017	—	—	—	330067	—	—	—
*1-72	UNF	.0730	2	H1	1.688	0.375	330006	—	300165	—	—	—	330068	—	—	—
*2-56	UNC	.0860	2	H2	1.750	0.438	—	—	330018	—	—	—	330069	—	—	—
*2-56	UNC	.0860	3	H1	1.750	0.438	330007	—	330019	—	—	—	300264	—	—	—
*2-56	UNC	.0860	3	H2	1.750	0.438	300272	300278	300280	—	300286	330035	300299	300294	341573	174511
*2-64	UNF	.0860	3	H2	1.750	0.438	330008	—	330020	—	—	—	330070	—	—	—
*3-48	UNC	.0990	3	H2	1.813	0.500	300512	339044	300520	—	300526	—	300538	339045	341599	355802
*3-56	UNF	.0990	3	H2	1.813	0.500	300637	339046	300645	—	339047	—	300652	339048	341607	355803
4-40	UNC	.1120	2	H1	1.875	0.563	—	—	330021	—	—	—	—	—	—	—
4-40	UNC	.1120	2	H2	1.875	0.563	—	—	300769	—	—	—	300778	—	—	—
4-40	UNC	.1120	3	H2	1.875	0.563	300819	300815	300827	—	300823	330036	300835	300831	341623	174530
4-48	UNF	.1120	3	H2	1.875	0.563	300934	300930	300942	—	300948	—	300959	300955	341649	174531
5-40	UNC	.1250	2	H2	1.938	0.625	—	—	301007	—	—	—	301015	—	—	—
5-40	UNC	.1250	3	H2	1.938	0.625	301056	301052	301064	—	301060	—	301072	301078	341664	174536
5-44	UNF	.1250	3	H2	1.938	0.625	301171	301177	301189	—	—	—	301197	301193	341672	174537
6-32	UNC	.1380	2	H2	2.000	0.688	—	—	301247	—	—	—	301254	—	—	—
6-32	UNC	.1380	2	H3	2.000	0.688	—	—	301270	—	—	—	301288	—	—	—
6-32	UNC	.1380	3	H2	2.000	0.688	301320	—	301338	—	330062	—	301346	—	341698	—
6-32	UNC	.1380	3	H3	2.000	0.688	301353	301359	301361	330037	301367	330038	301379	301375	341706	174538
6-40	UNF	.1380	3	H2	2.000	0.688	301478	301474	301486	—	301482	—	301494	301490	341714	174539
8-32	UNC	.1640	2	H1	2.125	0.750	—	—	330022	—	—	—	—	—	—	—
8-32	UNC	.1640	2	H2	2.125	0.750	—	—	301544	—	—	—	301551	—	—	—
8-32	UNC	.1640	2	H3	2.125	0.750	—	—	301577	—	—	—	301585	—	—	—
8-32	UNC	.1640	3	H2	2.125	0.750	—	—	301635	—	—	—	301643	—	—	—
8-32	UNC	.1640	3	H3	2.125	0.750	—	—	301668	—	—	—	301676	—	—	—
8-32	UNC	.1640	4	H2	2.125	0.750	301718	—	301726	—	330063	—	301734	—	341730	—
8-32	UNC	.1640	4	H3	2.125	0.750	301742	301748	301759	330039	301755	330040	301767	301763	341748	174544
8-36	UNF	.1640	4	H2	2.125	0.750	301924	301920	301933	—	301938	—	301940	301946	341755	174545

continued on next page

**General Purpose  
Straight Flute**

**Machine Tap for Through or Blind Holes**

**Style: HTGP (continued)**



Machine  
Taps

Spiral Point  
Taps

Spiral Flute  
Taps

Thread Forming  
Taps

Pipe Taps

Dies

Technical Info

Sets

Index

diameter & pitch	thrd form	d <sub>1</sub> in	no. flts	H- limit	L in	I in	order number									
							taper		plug				bottoming		set	
							Bright	TiN	Bright	Oxide	TiN	TiCN	Bright	TiN	Bright	TiN
10-24	UNC	.1900	2	H2	2.375	0.875	—	—	301999	—	—	—	—	—	—	—
10-24	UNC	.1900	2	H3	2.375	0.875	—	—	302021	—	—	—	302039	—	—	—
10-24	UNC	.1900	3	H3	2.375	0.875	—	—	302112	—	—	—	302120	—	—	—
10-24	UNC	.1900	4	H2	2.375	0.875	302161	—	302179	—	—	—	302187	—	341771	—
10-24	UNC	.1900	4	H3	2.375	0.875	302195	302191	302203	330041	302209	330042	302211	302217	341789	174508
10-32	UNF	.1900	2	H2	2.375	0.875	—	—	302260	—	—	—	302278	—	—	—
10-32	UNF	.1900	2	H3	2.375	0.875	—	—	302294	—	—	—	302302	—	—	—
10-32	UNF	.1900	3	H3	2.375	0.875	—	—	302385	—	330045	—	302393	—	—	—
10-32	UNF	.1900	4	H2	2.375	0.875	302435	—	302443	—	—	—	302450	—	341805	—
10-32	UNF	.1900	4	H3	2.375	0.875	302468	302464	302476	330043	302472	330044	302484	302480	341813	174509
12-24	UNC	.2160	4	H3	2.375	0.938	302526	302522	302534	—	302530	—	302542	302548	341821	174510
12-28	UNF	.2160	4	H3	2.375	0.938	302583	—	302591	—	330046	—	302609	330079	341839	—
1/4-20	UNC	.2500	2	H3	2.500	1.000	—	—	326004	—	—	—	326012	—	—	—
1/4-20	UNC	.2500	3	H2	2.500	1.000	—	—	330024	—	—	—	—	—	—	—
1/4-20	UNC	.2500	3	H3	2.500	1.000	—	—	326160	—	—	—	326178	—	—	—
1/4-20	UNC	.2500	3	H5	2.500	1.000	—	—	330025	—	—	—	—	—	—	—
1/4-20	UNC	.2500	4	H1	2.500	1.000	305008	—	305016	—	—	—	305024	—	330080	—
1/4-20	UNC	.2500	4	H2	2.500	1.000	305033	—	305040	—	—	—	305057	—	342514	—
1/4-20	UNC	.2500	4	H3	2.500	1.000	305065	305061	305073	330047	305079	330048	305081	305087	342522	174506
1/4-20	UNC	.2500	4	H5	2.500	1.000	—	—	305107	—	305103	—	305115	305111	—	—
1/4-20	UNC	.2500	4	H11	2.500	1.000	—	—	330026	—	—	—	—	—	—	—
1/4-28	UNF	.2500	2	H3	2.500	1.000	—	—	326087	—	—	—	326095	—	—	—
1/4-28	UNF	.2500	3	H3	2.500	1.000	—	—	326244	—	326240	—	326251	—	—	—
1/4-28	UNF	.2500	4	H2	2.500	1.000	—	—	305198	—	—	—	305206	305209	—	—
1/4-28	UNF	.2500	4	H3	2.500	1.000	305214	305210	305222	330049	305228	330051	305230	305236	342530	174507
5/16-18	UNC	.3125	2	H3	2.719	1.125	—	—	326285	—	—	—	326293	—	—	—
5/16-18	UNC	.3125	3	H3	2.719	1.125	—	—	326368	—	—	—	326376	—	—	—
5/16-18	UNC	.3125	4	H2	2.719	1.125	—	—	305370	—	—	—	305388	—	—	—
5/16-18	UNC	.3125	4	H3	2.719	1.125	305396	305392	305404	330052	305403	330053	305412	305418	342555	174532
5/16-18	UNC	.3125	4	H5	2.719	1.125	—	—	305438	—	—	—	305446	—	—	—
5/16-18	UNC	.3125	4	H11	2.719	1.125	—	—	330027	—	—	—	—	—	—	—
5/16-24	UNF	.3125	3	H3	2.719	1.125	—	—	326442	—	—	—	326459	—	—	—
5/16-24	UNF	.3125	4	H3	2.719	1.125	305511	305517	305529	—	305525	—	305537	305533	342563	174533
5/16-24	UNF	.3125	4	H4	2.719	1.125	—	—	305552	—	—	—	305560	—	—	—
3/8-16	UNC	.3750	3	H3	2.938	1.250	—	—	326525	—	326521	—	326533	326539	—	—
3/8-16	UNC	.3750	4	H2	2.938	1.250	—	—	305677	—	—	—	305685	—	—	—
3/8-16	UNC	.3750	4	H3	2.938	1.250	305693	305699	305701	330055	305707	330057	305719	305715	342589	174528
3/8-16	UNC	.3750	4	H5	2.938	1.250	—	—	305735	—	305731	—	305743	305749	—	—
3/8-24	UNF	.3750	3	H3	2.938	1.250	—	—	326608	—	—	—	326616	—	—	—
3/8-24	UNF	.3750	4	H3	2.938	1.250	305818	305814	305826	330058	305822	—	305834	305830	342597	174529
7/16-14	UNC	.4375	4	H3	3.156	1.438	305990	305996	306006	—	306002	—	306014	306010	342605	174540
7/16-14	UNC	.4375	4	H5	3.156	1.438	—	—	306030	—	306036	—	306048	306044	—	—
7/16-20	UNF	.4375	4	H3	3.156	1.438	306113	306119	306121	—	306127	—	306139	306135	342613	174541
7/16-20	UNF	.4375	4	H5	3.156	1.438	—	—	306154	—	306157	—	306162	306165	—	—
1/2-13	UNC	.5000	3	H3	3.375	1.656	—	—	326681	—	—	—	326699	—	—	—
1/2-13	UNC	.5000	4	H1	3.375	1.656	—	—	306246	—	—	—	—	—	—	—
1/2-13	UNC	.5000	4	H3	3.375	1.656	306295	306291	306303	330059	306309	330060	306311	306317	342621	174504
1/2-13	UNC	.5000	4	H5	3.375	1.656	—	—	306337	—	—	—	306345	306341	—	—
1/2-20	UNF	.5000	3	H3	3.375	1.656	—	—	326707	—	—	—	—	—	—	—
1/2-20	UNF	.5000	4	H3	3.375	1.656	306444	306440	306451	—	306457	—	306469	306465	342639	174505
1/2-20	UNF	.5000	4	H5	3.375	1.656	—	—	306485	—	—	—	—	—	—	—
9/16-12	UNC	.5625	4	H3	3.594	1.656	306626	306622	306634	—	306630	—	306642	306648	342647	174546
9/16-18	UNF	.5625	4	H3	3.594	1.656	306741	—	306758	—	306754	—	306766	306762	342654	—

continued on next page



Machine Tap for Through or Blind Holes

Style: **HTGP** (continued)

General Purpose  
Straight Flute

diameter & pitch	thrd form	d <sub>1</sub> in	no. flts	H-limit	L in	I in	order number									
							taper		plug		bottoming		set			
							Bright	TiN	Bright	Oxide	TiN	TiCN	Bright	TiN	Bright	TiN
5/8-11	UNC	.6250	4	H3	3.813	1.813	306923	306929	306931	330061	306937	—	306949	306945	342662	174534
5/8-11	UNC	.6250	4	H5	3.813	1.813	—	—	306964	—	—	—	306972	306978	—	—
5/8-18	UNF	.6250	4	H3	3.813	1.813	307046	307042	307053	—	307059	—	307061	307067	342670	174535
11/16-11	UNS	.6875	4	H3	4.031	1.813	307160	—	307178	—	—	—	307186	—	342688	—
11/16-16	UNS	.6875	4	H3	4.031	1.813	307194	—	307202	—	—	—	307210	—	342696	—
3/4-10	UNC	.7500	4	H3	4.250	2.000	307343	307349	307350	—	307356	—	307368	307364	342704	174513
3/4-16	UNF	.7500	4	H3	4.250	2.000	307467	307463	307475	—	307471	—	307483	307489	342712	174514
*7/8-9	UNC	.8750	4	H4	4.468	2.219	307707	307703	307715	—	307711	—	307723	307729	342720	174543
*7/8-14	UNF	.8750	4	H4	4.468	2.219	307822	307828	307830	—	307836	—	307848	307844	342738	174542
*1-8	UNC	1.0000	4	H4	5.125	2.500	308069	308065	308077	—	308073	—	308085	308081	342746	174503
*1-12	UNF	1.0000	4	H4	5.125	2.500	308184	—	308192	—	330065	—	308200	—	—	—
*1-14	UNS	1.0000	4	H4	5.125	2.500	308275	—	308283	—	—	—	308291	—	342761	—
*1-1/8-7	UNC	1.1250	4	H4	5.438	2.563	308424	—	308432	—	—	—	308440	—	—	—
*1-1/8-12	UNF	1.1250	4	H4	5.438	2.563	308457	—	308465	—	—	—	308473	—	—	—
*1-1/4-7	UNC	1.2500	4	H4	5.750	2.563	308549	—	308556	—	—	—	308564	—	—	—
*1-1/4-12	UNF	1.2500	6	H4	5.750	2.563	308572	—	308580	—	—	—	308598	—	—	—
*1-3/8-6	UNC	1.3750	4	H4	6.063	3.000	—	—	308671	—	—	—	—	—	—	—
*1-3/8-12	UNF	1.3750	6	H4	6.063	3.000	—	—	308705	—	—	—	308713	—	—	—
*1-1/2-6	UNC	1.5000	4	H4	6.375	3.000	308788	—	308796	—	—	—	308804	—	—	—
*1-1/2-12	UNF	1.5000	6	H4	6.375	3.000	308812	—	308820	—	—	—	308838	—	—	—

Style: **HTGP**

Metric - General Purpose  
Straight Flute

diameter & pitch	d <sub>1</sub> mm	no. flts	D-limit	L in	I in	order number							
						taper		plug		bottoming		set	
						Bright	TiN	Bright	TiN	Bright	TiN	Bright	TiN
M1.6 x 0.35	1.60	2	D3	1.625	.313	—	—	328018	—	330071	—	—	—
M2 x 0.4	2.00	3	D3	1.750	.438	328067	328684	328075	328685	328083	328686	174516	343502
M2.5 x 0.45	2.50	3	D3	1.813	.500	328158	328688	328166	328689	328174	328690	174559	343503
M3 x 0.5	3.00	3	D3	1.938	.625	328182	328691	328190	328188	328208	328205	174519	343504
M3.5 x 0.6	3.50	3	D4	2.000	.688	328240	—	328257	328693	328265	—	174560	—
M4 x 0.7	4.00	4	D4	2.125	.750	328273	328695	328281	328287	328299	328295	174520	343506
M4.5 x 0.75	4.50	4	D4	2.375	.875	328331	—	328349	328697	328356	—	174561	—
M5 x 0.8	5.00	4	D4	2.375	.875	328364	328698	328372	328378	328380	328386	174521	343508
M6 x 1.0	6.00	4	D5	2.500	1.000	328422	328699	328430	328436	328448	328444	174522	343509
M7 x 1.0	7.00	4	D5	2.719	1.125	330009	—	328497	—	330072	—	—	—
M8 x 1.0	8.00	4	D5	2.719	1.125	330010	—	330028	—	330073	—	—	—
M8 x 1.25	8.00	4	D5	2.719	1.125	328547	328703	328554	328550	328562	328568	174524	343511
M10 x 1.25	10.00	4	D5	2.938	1.250	330011	—	330029	—	330074	—	—	—
M10 x 1.5	10.00	4	D6	2.938	1.250	328604	328704	328612	328618	328620	328626	174548	343512
M12 x 1.25	12.00	4	D5	3.375	1.656	330012	—	330030	—	330075	—	—	—
M12 x 1.75	12.00	4	D6	3.375	1.656	328661	328705	328679	328675	328687	328683	174549	343513
M14 x 1.5	14.00	4	D6	3.594	1.656	330013	—	330031	—	330076	—	—	—
M14 x 2.0	14.00	4	D7	3.594	1.656	328752	328706	328760	328707	328778	328708	174550	343514
M16 x 1.5	16.00	4	D6	3.813	1.813	330014	—	330032	—	330077	—	—	—
M16 x 2.0	16.00	4	D7	3.813	1.813	328810	328709	328828	328710	328836	328711	174551	343515
M18 x 1.5	18.00	4	D6	4.031	1.813	330015	—	330033	—	—	—	—	—
M18 x 2.5	18.00	4	D7	4.031	1.813	328877	—	328885	—	328893	—	174552	—
M20 x 1.5	20.00	4	D6	4.469	2.000	—	—	330034	—	330078	—	—	—
M20 x 2.5	20.00	4	D7	4.469	2.000	328935	—	328943	328716	328950	328717	174553	—
M24 x 3.0	24.00	4	D8	4.906	2.219	329057	—	329065	328719	329073	328720	—	—
M30 x 3.5	30.00	4	D9	5.438	2.563	—	—	329180	—	—	—	—	—