
Hand Taps--High Speed Steel Machine Screw Sizes

Machine screw taps are basically the same as hand taps and can be used wherever hand taps are applicable. The major difference between the two is the method of designation. Machine screw taps are identified by size using numbers #0 through #12 instead of fractions. Each number starting with #0 increases the nominal diameter 0.013 inches to the next consecutive size. The term "hand tap" is typically used to denote a fractional tap size. Although the name implies a hand operation, it is found in common use on all production machines. Taps with a taper chamfer are useful in starting a tapped thread square with the part. The plug chamfered tap, however, is the most widely used tap in both hand and production tapping.



Tap Description	Plug	Bottom	Taper
0-80 H1 2FL	116520	116531	116543
0-80 H2 2FL	116567	116579	-----
1-64 H1 2FL	116646	116658	116660
1-64 H2 2FL	116683	-----	-----
1-72 H1 2FL	116750	116762	116774
1-72 H2 2FL	116786	116798	-----
2-56 H1 2FL	116877	116889	-----
2-56 H2 2FL	116890	116907	-----
2-56 H1 3FL	116932	116944	116956
2-56 H2 3FL	116970	116981	116993
2-64 H2 3FL	117080	117092	117109
3-48 H2 2FL	117195	117201	-----
3-48 H1 3FL	117237	-----	-----
3-48 H2 3FL	117250	117262	117274
3-56 H1 3FL	117353	-----	-----
3-56 H2 3FL	117377	117389	117390
4-40 H1 2FL	117560	-----	-----
4-40 H2 2FL	117572	117584	-----
4-40 H3 2FL	117596	117602	-----
4-40 H1 3FL	117638	117640	117651
4-40 H2 3FL	117675	117687	117699
4-48 H1 3FL	117845	-----	-----
4-48 H2 3FL	117857	117869	117870
5-40 H2 2FL	117950	117961	-----
5-40 H1 3FL	117997	118000	118011
5-40 H2 3FL	118035	118047	118059
5-44 H2 3FL	118230	118242	118254
6-32 H1 2FL	118310	-----	-----
6-32 H2 2FL	118321	118333	-----
6-32 H3 2FL	118345	118357	-----
6-32 H1 3FL	118382	118394	118400
6-32 H2 3FL	118424	118436	118448
6-32 H3 3FL	118461	118473	118485

Hand Taps--High Speed Steel Machine Screw Sizes



Tap Description	Plug	Bottom	Taper
6-40 H2 2FL	118710	-----	-----
6-40 H1 3FL	118734	-----	-----
6-40 H2 3FL	118746	118758	118760
8-32 H1 2FL	118850	-----	-----
8-32 H2 2FL	118862	118874	-----
8-32 H3 2FL	118886	118898	-----
8-32 H2 3FL	118941	118953	-----
8-32 H3 3FL	118965	118977	-----
8-32 H7 3FL	118989	118990	-----
8-32 H1 4FL	119015	119027	119039
8-32 H2 4FL	119052	119064	119076
8-32 H3 4FL	119090	119106	119118
8-32 H7 4FL	119131	119143	-----
8-36 H1 4FL	119386	-----	-----
8-36 H2 4FL	119398	119404	119416
10-24 H2 2FL	119490	119507	-----
10-24 H3 2FL	119519	119520	-----
10-24 H2 3FL	119556	-----	-----
10-24 H3 3FL	119568	119570	-----
10-24 H7 3FL	119581	119593	-----
10-24 H1 4FL	119623	119635	119647
10-24 H2 4FL	119660	119672	119684
10-24 H3 4FL	119702	119714	119726
10-24 H7 4FL	119740	119751	-----
10-32 H1 2FL	119970	119982	-----
10-32 H2 2FL	119994	120005	-----
10-32 H3 2FL	120017	120029	-----
10-32 H2 3FL	120078	120080	-----
10-32 H3 3FL	120091	120108	-----
10-32 H7 3FL	120110	120121	-----
10-32 H1 4FL	120157	120169	120170
10-32 H2 4FL	120194	120200	120212
10-32 H3 4FL	120236	120248	120250
10-32 H7 4FL	120273	120285	-----
12-24 H3 4FL	120522	120534	120546
12-28 H1 4FL	120674	-----	-----
12-28 H3 4FL	120704	120716	120728

Hand Taps--High Speed Steel Hand Taps (Fractional Sizes)



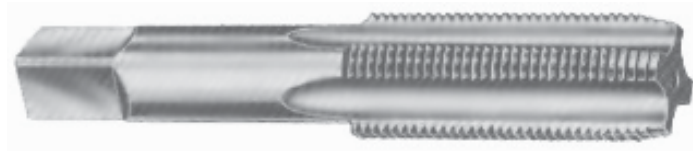
Tap Description	Plug	Bottom	Taper
1/4-20 H2 2FL	120789	120790	_____
1/4-20 H3 2FL	120807	120819	_____
1/4-20 H1 3FL	120820	_____	_____
1/4-20 H2 3FL	120832	_____	_____
1/4-20 H3 3FL	120844	120856	_____
1/4-20 H5 3FL	120881	120893	_____
1/4-20 H1 4FL	120935	120947	120959
1/4-20 H2 4FL	120972	120984	120996
1/4-20 H3 4FL	121022	121034	121046
1/4-20 H5 4FL	121095	121101	_____
1/4-28 H2 2FL	121356	_____	_____
1/4-28 H3 2FL	121370	121381	_____
1/4-28 H1 3FL	121393	121400	_____
1/4-28 H3 3FL	121435	121447	_____
1/4-28 H1 4FL	121496	121502	121484
1/4-28 H2 4FL	121514	121526	121538
1/4-28 H3 4FL	121551	121563	121575
1/4-28 H4 4FL	121599	121605	_____
5/16-18 H3 2FL	121850	121861	_____
5/16-18 H3 3FL	121897	121903	_____
5/16-18 H5 3FL	121939	121940	_____
5/16-18 H1 4FL	121976	121988	_____
5/16-18 H2 4FL	122026	122038	122040
5/16-18 H3 4FL	122051	122063	122075
5/16-18 H5 4FL	122117	122129	_____
5/16-24 H3 3FL	122385	122397	_____
5/16-24 H1 4FL	122440	122452	122446
5/16-24 H2 4FL	122464	122476	122488
5/16-24 H3 4FL	122506	122518	122520
5/16-24 H4 4FL	122543	122555	_____
3/8-16 H1 3FL	122737	_____	_____
3/8-16 H2 3FL	122749	_____	_____
3/8-16 H3 3FL	122762	122774	_____
3/8-16 H5 3FL	122816	122828	_____
3/8-16 H1 4FL	122853	122865	_____
3/8-16 H2 4FL	122890	122907	122919
3/8-16 H3 4FL	122932	122944	122956
3/8-16 H5 4FL	123006	123018	_____
3/8-24 H3 3FL	123201	123213	_____
3/8-24 H1 4FL	123262	123274	_____
3/8-24 H2 4FL	123286	123298	_____
3/8-24 H3 4FL	123328	123330	123341
3/8-24 H4 4FL	123365	123377	_____

Hand Taps--High Speed Steel Hand Taps (Fractional Sizes)



Tap Description	Plug	Bottom	Taper
7/16-14 H3 3FL	123572	123584	_____
7/16-14 H1 4FL	123614	123626	_____
7/16-14 H2 4FL	123651	123663	_____
7/16-14 H3 4FL	123675	123687	123699
7/16-14 H5 4FL	123730	123742	_____
7/16-20 H3 3FL	123936	_____	_____
7/16-20 H1 4FL	123950	_____	123923
7/16-20 H3 4FL	124000	124011	124023
7/16-20 H5 4FL	124047	124059	_____
1/2-13 H2 3FL	124205	_____	_____
1/2-13 H3 3FL	124229	124230	_____
1/2-13 H1 4FL	124278	124280	_____
1/2-13 H2 4FL	124310	124321	_____
1/2-13 H3 4FL	124333	124345	124357
1/2-13 H5 4FL	124394	124412	_____
1/2-20 H3 3FL	124606	_____	_____
1/2-20 H1 4FL	124618	124620	124625
1/2-20 H2 4FL	124631	124643	_____
1/2-20 H3 4FL	124655	124667	124679
1/2-20 H5 4FL	124710	124722	_____
9/16-12 H3 4FL	124916	124928	124930
9/16-12 H5 4FL	124941	124953	_____
9/16-18 H2 4FL	124989	_____	_____
9/16-18 H3 4FL	125003	125015	125027
9/16-18 H5 4FL	125052	125064	_____
5/8-11 H2 4FL	125106	125107	_____
5/8-11 H3 4FL	125118	125120	125131
5/8-11 H5 4FL	125167	125179	_____
5/8-18 H2 4FL	125246	125247	_____
5/8-18 H3 4FL	125258	125260	125271
5/8-18 H5 4FL	125283	125295	_____
11/16-11 H3 4FL	125325	125337	125349
11/16-16 H3 4FL	125362	125374	125386
3/4-10 H1 4FL	125404	_____	_____
3/4-10 H2 4FL	125416	_____	_____
3/4-10 H3 4FL	125428	125430	125441
3/4-10 H5 4FL	125465	125477	_____

Hand Taps--High Speed Steel Hand Taps (Fractional Sizes)



Tap Description	Plug	Bottom	Taper
3/4-16 H1 4FL	125520	_____	_____
3/4-16 H2 4FL	125532	125533	_____
3/4-16 H3 4FL	125544	125556	125568
3/4-16 H4 4FL	125581	_____	_____
3/4-16 H5 4FL	125600	125611	_____
7/8-9 H2 4FL	125660	_____	_____
7/8-9 H4 4FL	125684	125696	125702
7/8-9 H6 4FL	125726	_____	_____
7/8-14 H2 4FL	125751	_____	_____
7/8-14 H4 4FL	125763	125775	125787
7/8-14 H6 4FL	125805	_____	_____
1-8 H4 4FL	125878	125880	125891
1-8 H6 4FL	125910	_____	_____
1-12 H4 4FL	125969	125970	125982
1-14 H2 4FL	126044	_____	_____
1-14 H4 4FL	126056	126068	126070
1 1/8-7 H4 4FL	126100	126111	126123
1 1/8-12 H4 4FL	126147	126159	126160
1 1/4-7 H4 4FL	126184	126196	126202
1 1/4-12 H4 6FL	126226	126238	126240
1 3/8-6 H4 4FL	126275	126287	126299
1 3/8-12 H4 6FL	126317	126329	126330
1 1/2-6 H4 4FL	126354	126366	126378
1 1/2-12 H4 6FL	126391	126408	126410