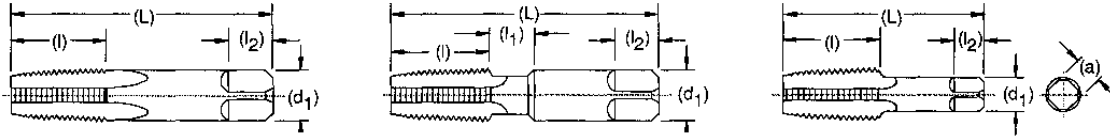


STANDARD PIPE TAP DIMENSIONS

STRAIGHT AND TAPER, GROUND THREAD

(Ref. USCTI Table 311)



General Dimensions

Dimensions - Inches						
Nominal Size Inches	Overall Length L	Thread Length l	Square Length l ₂	Shank Diameter d ₁	Size of Square a	Length Optional Neck
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	Size Range	Direction	Tolerance
Overall Length - L	1/16 to 3/4 inc.	Plus or Minus	.031
	1" to 4" inc.	Plus or Minus	.063
Thread Length - l	1/16 to 3/4 inc.	Plus or Minus	.063
	1" to 1-1/4" inc.	Plus or Minus	.094
Square Length - l ₂	1-1/2 to 4"	Plus or Minus	.125
	1/16 to 3/4 inc.	Plus or Minus	.031
	1" to 4" inc.	Minus	.063
Shank Diameter - d ₁	1/16 to 1/8 inc.	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 inc.	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