

Straight Flute

Hand Taps

Ground Thread — High Speed Steel

Straight Flute hand taps are used for hand tapping and machine tapping in through holes or blind holes in a wide variety of materials.

Available in sets, taper (8-10 thread chamfer), plug (3-5 thread chamfer) or bottoming (1-2 thread chamfer).

Taraud à main

Machuelo de roscar manual



List No. 2068 — Machine Screw

STANDARD PACKAGE All sizes — 12 each
Sets (Taper Plug Bottom)

Bold type indicates standard H limit.

Tool Coating Also Available

SIZE	TPI		NO. OF FLUTES	PITCH DIA. LIMIT	THREAD LENGTH	OAL	EDP NO.			
	UNC	UNF					SETS	TAPER	PLUG	BOTTOM
0	—	80	2	H1	5/16	1 5/8	33901	33601	33701	33801
	—	80	2	H2	5/16	1 5/8	—	—	33702	33802
1	64	—	2	H1	3/8	1 11/16	33902	33602	33703	33803
	64	—	2	H2	3/8	1 11/16	—	—	33704	—
	—	72	2	H1	3/8	1 11/16	33903	33603	33705	33804
	—	72	2	H2	3/8	1 11/16	—	—	33706	33805
2	56	—	3	H1	7/16	1 3/4	33904	33604	33707	33806
	56	—	3	H2	7/16	1 3/4	—	33605	33708	33807
	—	64	3	H2	7/16	1 3/4	33905	33606	33710	33809
3	48	—	3	H1	1/2	1 13/16	—	—	33711	—
	48	—	3	H2	1/2	1 13/16	33906	33607	33712	33810
	—	56	3	H2	1/2	1 13/16	33907	33608	33714	33812
4	40	—	3	H2	9/16	1 7/8	33909	33610	33716	33814
	—	48	3	H2	9/16	1 7/8	33910	33611	33719	33816
	—	*36	3	H2	9/16	1 7/8	33911	33612	33720	33817
5	40	—	3	H1	5/8	1 15/16	—	—	33721	—
	40	—	3	H2	5/8	1 15/16	33912	33613	33722	33818
	—	44	3	H2	5/8	1 15/16	33913	33614	33724	33820
6	32	—	3	H1	1 1/16	2	33914	33615	33726	33821
	32	—	3	H2	1 1/16	2	33915	33616	33727	33822
	32	—	3	H3	1 1/16	2	33916	33617	33728	33823
	—	40	3	H1	1 1/16	2	—	—	33731	—
	—	40	3	H2	1 1/16	2	33917	33618	33732	33826
8	32	—	4	H1	3/4	2 1/8	33918	33619	33734	33827
	32	—	4	H2	3/4	2 1/8	33919	33620	33735	33828
	32	—	4	H3	3/4	2 1/8	33920	33621	33736	33829
	—	36	4	H2	3/4	2 1/8	33921	33622	33742	33835
10	24	—	4	H1	7/8	2 3/8	33922	33623	33743	33836
	24	—	4	H2	7/8	2 3/8	33923	33624	33744	33837
	24	—	4	H3	7/8	2 3/8	33924	33625	33745	33838
	—	32	4	H1	7/8	2 3/8	33925	33626	33751	33842
	—	32	4	H2	7/8	2 3/8	33926	33627	33752	33843
	—	32	4	H3	7/8	2 3/8	33927	33628	33753	33844
12	24	—	4	H3	1 5/16	2 3/8	33928	33629	33758	33849
	—	28	4	H3	1 5/16	2 3/8	33929	33630	33759	33850

*UNS

Optional Flutes Straight Flute Hand Taps

Ground Thread — High Speed Steel

Straight Flute hand taps are used for hand tapping and machine tapping in through holes or blind holes in a wide variety of materials.

Optional Flutes taps feature fewer flutes than standard taps for added chip capacity in deeper hole tapping.

SIZE	UNC	TPI		NO. OF FLUTES	PITCH DIA. LIMIT	THREAD LENGTH	OAL	EDP NUMBER	
		UNF	UNF					PLUG	BOTTOM
2	56	—	—	2	H2	7/16	1 3/4	33709	33808
4	40	—	—	2	H2	9/16	1 7/8	33717	33815
5	40	—	—	2	H2	5/8	1 15/16	33723	33819
6	32	—	—	2	H2	1 1/16	2	33729	33824
	32	—	—	2	H3	1 1/16	2	33730	33825
	—	40	—	2	H2	1 1/16	2	33733	—
8	32	—	—	2	H2	3/4	2 1/8	33740	33833
	32	—	—	2	H3	3/4	2 1/8	33741	33834
	32	—	—	3	H2	3/4	2 1/8	33738	—
	32	—	—	3	H3	3/4	2 1/8	33739	33832
10	24	—	—	2	H2	7/8	2 3/8	33749	33840
	24	—	—	2	H3	7/8	2 3/8	33750	33841
	24	—	—	3	H2	7/8	2 3/8	33747	—
	24	—	—	3	H3	7/8	2 3/8	33748	33839
	—	32	—	2	H2	7/8	2 3/8	33756	33847
	—	32	—	2	H3	7/8	2 3/8	33757	33848
	—	32	—	3	H2	7/8	2 3/8	33754	33845
	—	32	—	3	H3	7/8	2 3/8	33755	33846

Taraud à main

Machuelo de roscar manual



List No. 2068 — Machine Screw

STANDARD PACKAGE All sizes — 12 each

Available in plug (3-5 thread chamfer), or bottoming (1-2 thread chamfer).

Bold type indicates standard H limit.

Surface Treated Straight Flute Hand Taps

Ground Thread — High Speed Steel

Straight Flute hand taps are used for hand tapping and machine tapping in through holes or blind holes in a wide variety of materials.

Steam Oxide Surface Treatment increases wear resistance, reduces friction, acts as a lubricant, reduces galling and chip welding, improves chip flow and increases tap lubricant retention. **NOT RECOMMENDED FOR NON-FERROUS MATERIALS.**

SIZE	UNC	TPI		NO. OF FLUTES	PITCH DIA. LIMIT	THREAD LENGTH	OAL	EDP NUMBER	
		UNF	UNF					PLUG	BOTTOM
6	32	—	—	3	H3	1 1/16	2	32558	32573
	—	40	—	3	H2	1 1/16	2	32559	32574
8	32	—	—	4	H3	3/4	2 1/8	32560	32575
	—	36	—	4	H2	3/4	2 1/8	32561	32576
10	24	—	—	4	H3	7/8	2 3/8	32562	32577
	—	32	—	4	H3	7/8	2 3/8	32563	32578

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List No. 2068X Machine Screw Steam Oxide Treated

STANDARD PACKAGE All sizes — 12 each

Available in plug (3-5 thread chamfer), or bottoming (1-2 thread chamfer)

Straight Flute Hand Taps

Ground Thread — High Speed Steel

Straight Flute hand taps are used for hand tapping and machine tapping in through holes or blind holes in a wide variety of materials.

Available in sets or taper (8-10 thread chamfer), plug (3-5 thread chamfer), or bottoming (1-2 thread chamfer)

Tool Coatings Also Available

Taraud à main

Machuelo de roscar manual



List No. 2046 Fractional

STANDARD PACKAGE 1/4" thru 1/2" — 12 each
 9/16" thru 3/4" — 3 each
 7/8" thru 1 1/2" — 1 each
 Sets (Taper Plug Bottom)

Bold type indicates standard H limit.

SIZE	TPI		NO. OF FLUTES	PITCH DIA. LIMIT	THREAD LENGTH	OAL	EDP NUMBER			
	UNC	UNF					SETS EDP NO.	TAPER	PLUG	BOTTOM
1/4	20	—	4	H1	1	2 1/2	—	32301	32402	32601
	20	—	4	H2	1	2 1/2	—	32302	32404	32602
	20	—	4	H3	1	2 1/2	32701	32303	32407	32605
	20	—	4	H5	1	2 1/2	—	—	32409	—
	—	28	4	H1	1	2 1/2	—	—	32410	32607
	—	28	4	H2	1	2 1/2	—	—	32411	32608
	—	28	4	H3	1	2 1/2	32702	32304	32414	32611
	—	28	4	H4	1	2 1/2	—	—	32415	32612
5/16	18	—	4	H2	1 1/8	2 23/32	—	—	32418	32614
	18	—	4	H3	1 1/8	2 23/32	32703	32305	32421	32617
	18	—	4	H5	1 1/8	2 23/32	—	—	32422	32618
	—	24	4	H2	1 1/8	2 23/32	—	—	32424	—
	—	24	4	H3	1 1/8	2 23/32	32704	32306	32426	32621
	—	24	4	H4	1 1/8	2 23/32	—	—	32427	32622*
3/8	16	—	4	H1	1 1/4	2 15/16	—	—	32429	—
	16	—	4	H2	1 1/4	2 15/16	—	—	32430	32624
	16	—	4	H3	1 1/4	2 15/16	32705	32307	32432	32626
	16	—	4	H5	1 1/4	2 15/16	—	—	32434	32627
	—	24	4	H1	1 1/4	2 15/16	—	—	32435	—
	—	24	4	H2	1 1/4	2 15/16	—	—	32436	32629
	—	24	4	H3	1 1/4	2 15/16	32706	32308	32438	32631
	—	24	4	H4	1 1/4	2 15/16	—	—	32439	—
7/16	14	—	4	H3	1 7/16	3 5/32	32707	32309	32441	32633
	14	—	4	H5	1 7/16	3 5/32	—	—	32442	32634
	—	20	4	H3	1 7/16	3 5/32	32708	32310	32444	32635
	—	20	4	H5	1 7/16	3 5/32	—	—	32445	32636
1/2	13	—	4	H1	1 21/32	3 3/8	—	—	32446	—
	13	—	4	H3	1 21/32	3 3/8	32709	32311	32449	32640
	13	—	4	H5	1 21/32	3 3/8	—	—	32450	32641
	—	20	4	H1	1 21/32	3 3/8	—	—	32451	32642
	—	20	4	H3	1 21/32	3 3/8	32710	32312	32453	32643
	—	20	4	H5	1 21/32	3 3/8	—	—	32454	—
9/16	12	—	4	H3	1 21/32	3 19/32	32711	32313	32455	32644
	12	—	4	H5	1 21/32	3 19/32	—	—	32456	—
	—	18	4	H2	1 21/32	3 19/32	—	—	32457	—
	—	18	4	H3	1 21/32	3 19/32	32712	32314	32458	32645
	—	18	4	H5	1 21/32	3 19/32	—	—	32459	—
5/8	11	—	4	H2	1 13/16	3 13/16	—	—	32460	—
	11	—	4	H3	1 13/16	3 13/16	32713	32315	32461	32647
	11	—	4	H5	1 13/16	3 13/16	—	—	32462	32648
	—	18	4	H2	1 13/16	3 13/16	—	—	32463	—
	—	18	4	H3	1 13/16	3 13/16	32714	32316	32464	32649
	—	18	4	H5	1 13/16	3 13/16	—	—	32465	32650

*Available While Supplies Last

(continued)

Straight Flute Hand Taps (continued)

List No. 2046 Fractional

Taraud à main

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SIZE	UNC	TPI		NO. OF FLUTES	PITCH DIA. LIMIT	THREAD LENGTH	OAL	EDP NUMBER			
		UNF	UNS					SETS EDP NO.	TAPER	PLUG	BOTTOM
1 ¹ / ₁₆	—	—	11	4	H3	1 ¹³ / ₁₆	4 ¹ / ₃₂	32715	32317	32466	32651
	—	—	16	4	H3	1 ¹³ / ₁₆	4 ¹ / ₃₂	32716	32318	32467	32652
3 ⁴ / ₄	10	—	—	4	H3	2	4 ¹ / ₄	32717	32319	32469	32653
	10	—	—	4	H5	2	4 ¹ / ₄	—	—	32470	32654
	—	16	—	4	H1	2	4 ¹ / ₄	—	—	32471	—
	—	16	—	4	H2	2	4 ¹ / ₄	—	—	32472	—
	—	16	—	4	H3	2	4 ¹ / ₄	32718	32320	32473	32655
	—	16	—	4	H5	2	4 ¹ / ₄	—	—	32474	32656
7 ⁸ / ₈	9	—	—	4	H4	2 ⁷ / ₃₂	4 ¹ / ₁₆	32719	32321	32475	32657
	9	—	—	4	H6	2 ⁷ / ₃₂	4 ¹ / ₁₆	—	—	32476	—
	—	14	—	4	H2	2 ⁷ / ₃₂	4 ¹ / ₁₆	—	—	32477	—
	—	14	—	4	H4	2 ⁷ / ₃₂	4 ¹ / ₁₆	32720	32322	32478	32658
1	8	—	—	4	H4	2 ¹ / ₂	5 ¹ / ₈	32721	32323	32480	32659
	8	—	—	4	H6	2 ¹ / ₂	5 ¹ / ₈	—	—	32481	—
	—	12	—	4	H4	2 ¹ / ₂	5 ¹ / ₈	32722	32324	32482	32660
	—	—	14	4	H4	2 ¹ / ₂	5 ¹ / ₈	32723	32325	32484	32661
1 ¹ / ₈	7	—	—	4	H4	2 ⁹ / ₁₆	5 ⁷ / ₁₆	32724	32326	32485	32662
	—	12	—	4	H4	2 ⁹ / ₁₆	5 ⁷ / ₁₆	32725	32327	32486	32663
1 ¹ / ₄	7	—	—	4	H4	2 ⁹ / ₁₆	5 ³ / ₄	32726	32328	32487	32664
	—	12	—	6	H4	2 ⁹ / ₁₆	5 ³ / ₄	32727	32329	32488	32665
1 ³ / ₈	6	—	—	4	H4	3	6 ¹ / ₁₆	32728	32330	32489	32666
	—	12	—	6	H4	3	6 ¹ / ₁₆	32729	32331	32490	32667
1 ¹ / ₂	6	—	—	4	H4	3	6 ³ / ₈	32730	32332	32491	32668
	—	12	—	6	H4	3	6 ³ / ₈	32731	32333	32492	32669

Optional Flutes Straight Flute Hand Taps

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Optional Flutes taps feature fewer flutes than standard taps for added chip capacity in deeper hole tapping.

Taraud à main

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List No. 2046 — Fractional

STANDARD All sizes — 12 each
PACKAGE

Ground Thread—High Speed Steel

SIZE	UNC	TPI		NO. OF FLUTES	PITCH DIA. LIMIT	THREAD LENGTH	OAL	EDP NUMBER	
		UNF	UNS					PLUG	BOTTOM
1 ⁴ / ₄	20	—	—	2	H3	1	2 ¹ / ₂	32405	32603
	20	—	—	3	H3	1	2 ¹ / ₂	32406	32604
	20	—	—	3	H5	1	2 ¹ / ₂	32408	32606
	—	28	—	2	H3	1	2 ¹ / ₂	32412	32609
	—	28	—	3	H3	1	2 ¹ / ₂	32413	32610
5 ¹⁶ / ₁₆	18	—	—	2	H3	1 ¹ / ₈	2 ²³ / ₃₂	—	32615
	18	—	—	3	H3	1 ¹ / ₈	2 ²³ / ₃₂	32420	32616
	—	24	—	3	H3	1 ¹ / ₈	2 ²³ / ₃₂	32425	32620
3 ⁸ / ₈	16	—	—	3	H3	1 ¹ / ₄	2 ¹⁵ / ₁₆	32431	32625
	—	24	—	3	H3	1 ¹ / ₄	2 ¹⁵ / ₁₆	32437	32630
7 ¹⁶ / ₁₆	14	—	—	3	H3	1 ⁷ / ₁₆	3 ⁵ / ₃₂	32440	—
	—	20	—	3	H3	1 ⁷ / ₁₆	3 ⁵ / ₃₂	32443	—
1 ² / ₂	13	—	—	3	H3	1 ²¹ / ₃₂	3 ³ / ₈	32448	32639
	—	20	—	3	H3	1 ²¹ / ₃₂	3 ³ / ₈	32452	—