

TECHNICAL DATA

TAP THREAD LIMIT STANDARDS AND DIMENSIONS

Taper Pipe Taps

Table 338

Nominal Size Inches	Threads Per Inch	*Gage Measurement — Inches Tolerance Plus or Minus			Taper Per Foot — Inches			
		Projection	Cut Thread	Ground Thread	Cut Thread		Ground Thread	
					Min.	Max.	Min.	Max.
1/16	27	.312	1/16	1/16	23/32	27/32	23/32	25/32
1/8	27	.312	1/16	1/16	23/32	27/32	23/32	25/32
1/4	18	.459	1/16	1/16	23/32	27/32	23/32	25/32
3/8	18	.454	1/16	1/16	23/32	27/32	23/32	25/32
1/2	14	.579	1/16	1/16	23/32	13/16	23/32	25/32
3/4	14	.565	1/16	1/16	23/32	13/16	23/32	25/32
1	11 1/2	.678	3/32	3/32	23/32	13/16	23/32	25/32
1 1/4	11 1/2	.686	3/32	3/32	23/32	13/16	23/32	25/32
1 1/2	11 1/2	.699	3/32	3/32	23/32	13/16	23/32	25/32
2	11 1/2	.667	3/32	3/32	23/32	13/16	23/32	25/32
2 1/2	8	.925	3/32	3/32	47/64	51/64	47/64	25/32
3	8	.925	3/32	3/32	47/64	51/64	47/64	25/32
3 1/2	8	.938	1/8	1/8	47/64	51/64	47/64	25/32
4	8	.950	1/8	1/8	47/64	51/64	47/64	25/32

*Distance small end of tap projects through (L.) Taper Ring Gage

Straight Pipe Taps

Table 335

Nominal Size Inches	Threads Per Inch NPS	Major Diameter			Pitch Diameter		
		Plug at Gaging Notch E	Minimum G	Maximum H	Plug at Gaging Notch E	Minimum K	Maximum L
1/8	27	.3983	.4022	.4032	.3736	.3746	.3751
1/4	18	.5286	.5340	.5350	.4916	.4926	.4931
3/8	18	.6640	.6694	.6704	.6270	.6280	.6285
1/2	14	.8260	.8335	.8345	.7784	.7794	.7799
3/4	14	1.0364	1.0440	1.0450	.9889	.9899	.9904
1	11 1/2	1.2966	1.3057	1.3072	1.2386	1.2397	1.2407
1 1/4	11 1/2	1.6413	1.6505	1.6520	1.5834	1.5845	1.5855
1 1/2	11 1/2	1.8803	1.8894	1.8909	1.8223	1.8234	1.8244
2	11 1/2	2.3542	2.3634	2.3649	2.2963	2.2974	2.2984
2 1/2	8	2.8454	2.8597	2.8612	2.7622	2.7633	2.7646
3	8	3.4718	3.4860	3.4875	3.3885	3.3896	3.3909
3 1/2	8	3.9721	3.9863	3.9878	3.8888	3.8899	3.8912
4	8	4.4704	4.4846	4.4861	4.3871	4.3882	4.3895

Straight Pipe Taps — Dryseal

Table 335-A

Nominal Size Inches	Threads Per Inch NPS	Major Diameter		Plug at Gaging Notch E	Pitch Diameter		Minor* Diameter Flat Maximum
		Minimum G	Maximum H		Minimum K	Maximum L	
1/16	27	.3008	.3018	.2812	.2772	.2777	.004
1/8	27	.3932	.3942	.3736	.3696	.3701	.004
1/4	18	.5239	.5249	.4916	.4859	.4864	.005
3/8	18	.6593	.6603	.6270	.6213	.6218	.005
1/2	14	.8230	.8240	.7784	.7712	.7717	.005
3/4	14	1.0335	1.0345	.9889	.9817	.9822	.005
1	11 1/2	1.2933	1.2943	1.2386	1.2295	1.2305	.006

*As specified or sharper.

