

# "NEW" HAND Working-Taps

For Unified threads

## WT-HAND



Vanadium High Speed Steel Taps  
 YMW New WT-HAND taps are designed to thread a wide variety of materials—steels, irons, brass and plastics—in through or blind hole conditions.

Necked design enhances flow of cutting fluid to cutting teeth and reduces surface contact between the tool and workpiece for more efficient threading.

\*1 See blank type on page 97.

Overall length	Length of thread part	Length of chamfer part	Shank diameter
$L$	$l$	$l_c$	$D_s$

Unit : inch

Size	Class of fit	Chamfer	Code No.	$L$	$l$	$D_s$	Number of flutes	*1 Blank type
9/16 - 12UNC	2B	1.5P	WTT2U09S1	3.59	0.984	0.429	4	Ua
		5P	WTT2U09S5					
9/16 - 18UNF	2B	1.5P	WTT2U09O1	3.59	0.984	0.429	4	
		5P	WTT2U09O5					
5/8 - 11UNC	2B	1.5P	WTT2U10U1	3.81	1.083	0.48	4	
		5P	WTT2U10U5					
5/8 - 18UNF	2B	1.5P	WTT2U10O1	3.81	1.083	0.48	4	
		5P	WTT2U10O5					
3/4 - 10UNC	2B	1.5P	WTT2U12V1	4.25	1.201	0.59	4	
		5P	WTT2U12V5					
3/4 - 16UNF	2B	1.5P	WTT2U12P1	4.25	1.201	0.59	4	
		5P	WTT2U12P5					

Unit : inch

Size	Class of fit	Chamfer	Code No.	$L$	$l$	$D_s$	Number of flutes	*1 Blank type
No.2 - 56UNC	2B	1.5P	WTT2UN2E1	1.75	0.256	0.141	3	Uc
		5P	WTT2UN2E5					
No.4 - 40UNC	2B	1.5P	WTT2UN4H1	1.88	0.335	0.141	3	
		5P	WTT2UN4H5					
No.6 - 32UNC	2B	1.5P	WTT2UN6J1	2	0.413	0.141	3	
		5P	WTT2UN6J5					
No.8 - 32UNC	2B	1.5P	WTT2UN8J1	2.13	0.453	0.168	4	
		5P	WTT2UN8J5					
No.10 - 24UNC	2B	1.5P	WTT2UNAM1	2.38	0.531	0.194	4	
		5P	WTT2UNAM5					
No.10 - 32UNF	2B	1.5P	WTT2UNAJ1	2.38	0.531	0.194	4	
		5P	WTT2UNAJ5					
1/4 - 20UNC	2B	1.5P	WTT2U04N1	2.5	0.591	0.255	4	
		5P	WTT2U04N5					
1/4 - 28UNF	2B	1.5P	WTT2U04K1	2.5	0.591	0.255	4	
		5P	WTT2U04K5					
5/16 - 18UNC	2B	1.5P	WTT2U05O1	2.72	0.669	0.318	4	
		5P	WTT2U05O5					
5/16 - 24UNF	2B	1.5P	WTT2U05M1	2.72	0.669	0.318	4	
		5P	WTT2U05M5					
3/8 - 16UNC	2B	1.5P	WTT2U06P1	2.94	0.748	0.381	4	
		5P	WTT2U06P5					
3/8 - 24UNF	2B	1.5P	WTT2U06M1	2.94	0.748	0.381	4	
		5P	WTT2U06M5					
7/16 - 14UNC	2B	1.5P	WTT2U07Q1	3.16	0.866	0.323	4	
		5P	WTT2U07Q5					
7/16 - 20UNF	2B	1.5P	WTT2U07N1	3.16	0.866	0.323	4	
		5P	WTT2U07N5					
1/2 - 13UNC	2B	1.5P	WTT2U08R1	3.38	0.984	0.367	4	Ua
		5P	WTT2U08R5					
1/2 - 20UNF	2B	1.5P	WTT2U08N1	3.38	0.984	0.367	4	
		5P	WTT2U08N5					

U.S.A. Taps & Dies Line up

Hand Taps

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For Unified threads

**WT-HAND**



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Necked design enhances flow of cutting fluid to cutting teeth and reduces surface contact between the tool and workpiece for more efficient threading.

\*1 See blank type on page 97.

\*5 "X" of code No. stands for Oxide surface treatment.

Overall length	Length of thread part	Length of chamfer part	Shank diameter
<i>L</i>	<i>ℓ</i>	<i>ℓ<sub>C</sub></i>	<i>D<sub>s</sub></i>

Unit : inch

Size	Class of fit	Chamfer	*5 Code No.	<i>L</i>	<i>ℓ</i>	<i>D<sub>s</sub></i>	Number of flutes	*1 Blank type
9/16 - 12UNC	2B	1.5P	WTT2U09S1X	3.59	0.984	0.429	4	Ua
		5P	WTT2U09S5X					
9/16 - 18UNF	2B	1.5P	WTT2U09O1X	3.59	0.984	0.429	4	
		5P	WTT2U09O5X					
5/8 - 11UNC	2B	1.5P	WTT2U10U1X	3.81	1.083	0.48	4	
		5P	WTT2U10U5X					
5/8 - 18UNF	2B	1.5P	WTT2U10O1X	3.81	1.083	0.48	4	
		5P	WTT2U10O5X					
3/4 - 10UNC	2B	1.5P	WTT2U12V1X	4.25	1.201	0.59	4	
		5P	WTT2U12V5X					
3/4 - 16UNF	2B	1.5P	WTT2U12P1X	4.25	1.201	0.59	4	
		5P	WTT2U12P5X					

Unit : inch

Size	Class of fit	Chamfer	*5 Code No.	<i>L</i>	<i>ℓ</i>	<i>D<sub>s</sub></i>	Number of flutes	*1 Blank type
No.2 - 56UNC	2B	1.5P	WTT2UN2E1X	1.75	0.256	0.141	3	Uc
		5P	WTT2UN2E5X					
No.4 - 40UNC	2B	1.5P	WTT2UN4H1X	1.88	0.335	0.141	3	
		5P	WTT2UN4H5X					
No.6 - 32UNC	2B	1.5P	WTT2UN6J1X	2	0.413	0.141	3	
		5P	WTT2UN6J5X					
No.8 - 32UNC	2B	1.5P	WTT2UN8J1X	2.13	0.453	0.168	4	
		5P	WTT2UN8J5X					
No.10 - 24UNC	2B	1.5P	WTT2UNAM1X	2.38	0.531	0.194	4	
		5P	WTT2UNAM5X					
No.10 - 32UNF	2B	1.5P	WTT2UNA1J1X	2.38	0.531	0.194	4	
		5P	WTT2UNA1J5X					
1/4 - 20UNC	2B	1.5P	WTT2U04N1X	2.5	0.591	0.255	4	
		5P	WTT2U04N5X					
1/4 - 28UNF	2B	1.5P	WTT2U04K1X	2.5	0.591	0.255	4	
		5P	WTT2U04K5X					
5/16 - 18UNC	2B	1.5P	WTT2U05O1X	2.72	0.669	0.318	4	
		5P	WTT2U05O5X					
5/16 - 24UNF	2B	1.5P	WTT2U05M1X	2.72	0.669	0.318	4	
		5P	WTT2U05M5X					
3/8 - 16UNC	2B	1.5P	WTT2U06P1X	2.94	0.748	0.381	4	
		5P	WTT2U06P5X					
3/8 - 24UNF	2B	1.5P	WTT2U06M1X	2.94	0.748	0.381	4	
		5P	WTT2U06M5X					
7/16 - 14UNC	2B	1.5P	WTT2U07Q1X	3.16	0.866	0.323	4	
		5P	WTT2U07Q5X					
7/16 - 20UNF	2B	1.5P	WTT2U07N1X	3.16	0.866	0.323	4	
		5P	WTT2U07N5X					
1/2 - 13UNC	2B	1.5P	WTT2U08R1X	3.38	0.984	0.367	4	
		5P	WTT2U08R5X					
1/2 - 20UNF	2B	1.5P	WTT2U08N1X	3.38	0.984	0.367	4	
		5P	WTT2U08N5X					

## Hand Taps for Hard-to-Machine Materials

For Unified and Metric threads

# ZELX MOLD



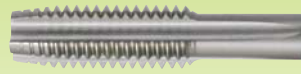
First Choice For Tapping Mold Steels  
 Ideal for tapping mold steels, tool steels and gray cast irons. (35 to 45 HRC)  
 YMW offers this series of ZELX Mold Taps made of Cobalt High Speed Steel.

\*1 See blank type on page 97.

## Industrial Quality Hand Taps for Cast Irons

For Unified and Metric threads

# HT-CI



"available while supplies last"  
 Vanadium High Speed Steel Taps  
 For Cast Irons

\*1 See blank type on page 97.

Unit : inch

Size	Class	Chamfer	Code No.	L	ℓ	D <sub>s</sub>	Number of flutes	*1 Blank type
No.4 - 40UNC	H2	5P	Y89599	1.88	0.335	0.141	3	Ub
No.5 - 40UNC	H2	5P	Y89601	1.94	0.374	0.141	3	
No.6 - 32UNC	H3	5P	Y89602	2	0.413	0.141	3	
No.8 - 32UNC	H3	5P	Y89604	2.13	0.453	0.168	3	
No.10 - 24UNC	H3	5P	Y89606	2.38	0.531	0.194	3	
No.10 - 32UNF	H3	5P	Y89607	2.38	0.531	0.194	3	
1/4 - 20UNC	H3	5P	Y89613	2.5	0.591	0.255	3	
1/4 - 28UNF	H3	5P	Y89614	2.5	0.591	0.255	3	
5/16 - 18UNC	H3	5P	Y89615	2.72	0.669	0.318	4	
5/16 - 24UNF	H3	5P	Y89616	2.72	0.669	0.318	4	
3/8 - 16UNC	H3	5P	Y89617	2.94	0.748	0.381	4	
3/8 - 24UNF	H3	5P	Y89618	2.94	0.748	0.381	4	
7/16 - 14UNC	H3	5P	Y89619	3.16	0.866	0.323	4	
7/16 - 20UNF	H3	5P	Y89620	3.16	0.866	0.323	4	
1/2 - 13UNC	H3	5P	Y89621	3.38	0.984	0.367	4	
1/2 - 20UNF	H3	5P	Y89622	3.38	0.984	0.367	4	
5/8 - 11UNC	H3	5P	Y89625	3.81	1.083	0.48	4	
5/8 - 18UNF	H3	5P	Y89626	3.81	1.083	0.48	4	
3/4 - 10UNC	H3	5P	Y89627	4.25	2	0.59	4	
3/4 - 16UNF	H3	5P	Y89628	4.25	2	0.59	4	

Unit : inch

Size	Class	Chamfer	Code No.	L	ℓ	D <sub>s</sub>	Number of flutes	*1 Blank type
1/4 - 20UNC	H3	1.5P	Y86002	2.5	1	0.255	4	Ub
		5P	Y86001					
	H5	1.5P	Y86004					
		5P	Y86003					
1/4 - 28UNF	H3	1.5P	Y86006	2.5	1	0.255	4	
		5P	Y86005					
5/16 - 18UNC	H3	1.5P	Y86008	2.72	1.13	0.318	4	
		5P	Y86007					
	H5	1.5P	Y86010					
		5P	Y86009					
5/16 - 24UNF	H3	1.5P	Y86012	2.72	1.13	0.318	4	
		5P	Y86011					
3/8 - 16UNC	H3	1.5P	Y86014	2.94	1.25	0.381	4	
		5P	Y86013					
	H5	1.5P	Y86016					
		5P	Y86015					
3/8 - 24UNF	H3	1.5P	Y86018	2.94	1.25	0.381	4	
		5P	Y86017					
7/16 - 14UNC	H3	1.5P	Y86020	3.16	1.44	0.323	4	
		5P	Y86019					
	H5	1.5P	Y86022					
		5P	Y86021					
7/16 - 20UNF	H3	1.5P	Y86024	3.16	1.44	0.323	4	
		5P	Y86023					
	H5	1.5P	Y86026					
		5P	Y86025					
1/2 - 13UNC	H3	1.5P	Y86028	3.38	1.66	0.367	4	
		5P	Y86027					
	H5	1.5P	Y86030					
		5P	Y86029					
1/2 - 20UNF	H3	1.5P	Y86032	3.38	1.66	0.367	4	
		5P	Y86031					

U.S.A. Taps & Dies Line up

Hand Taps

**HT-CI Industrial Quality Hand Taps for Cast Irons**  
For Unified and Metric threads

Unit : inch

Size	Class	Chamfer	Code No.	L	ℓ	D <sub>s</sub>	Number of flutes	*1 Blank type
1/2 - 20UNF	H5	1.5P	Y86034	3.38	1.66	0.367	4	Ub
		5P	Y86033					
9/16 - 12UNC	H3	1.5P	Y86036	3.59	1.66	0.429	4	
		5P	Y86035					
9/16 - 18UNF	H3	1.5P	Y86038	3.59	1.66	0.429	4	
		5P	Y86037					
5/8 - 11UNC	H3	1.5P	Y86040	3.81	1.81	0.48	4	
		5P	Y86039					
5/8 - 18UNF	H3	1.5P	Y86042	3.81	1.81	0.48	4	
		5P	Y86041					
3/4 - 10UNC	H3	1.5P	Y86044	4.25	2	0.59	4	
		5P	Y86043					
3/4 - 16UNF	H3	1.5P	Y86046	4.25	2	0.59	4	
		5P	Y86045					

**Industrial Quality Hand Taps**  
For Unified and Metric threads

**HT**



"available while supplies last"  
**Vanadium High Speed Steel Taps**  
For Tapping Steels, Irons, Brass and Plastics

\*1 See blank type on page 97.  
\*2 "BR" of code No. stands for Bright finish taps

Unit : inch

Size	Class	Chamfer	*2 Code No.	L	ℓ	D <sub>s</sub>	Number of flutes	*1 Blank type	
No.0 - 80UNF	H1	1.5P	Y80002	1.63	0.31	0.141	2	Ub	
			Y80002BR						
		5P	Y80001						
	Y80001BR								
	9P	Y80000							
	Y80000BR								
H2	1.5P	Y80102							
	5P	Y80101							
No.1 - 64UNC	H1	1.5P	Y80005	1.69	0.38	0.141	2		
			Y80005BR						
		5P	Y80004						
	Y80004BR								
	9P	Y80003							
	Y80003BR								
H2	5P	Y80104							
No.1 - 72UNF	H1	1.5P	Y80008	1.69	0.38	0.141	2		
			Y80008BR						
		5P	Y80007						
	Y80007BR								
	9P	Y80006							
	Y80006BR								
H2	1.5P	Y80108							
	5P	Y80107							
No.2 - 56UNC	H1	1.5P	Y80011	1.75	0.44	0.141	3		
			Y80602					2	
		5P	Y80010						3
		Y80601	2						
	9P	Y80009							
	H2	1.5P					Y80111	3	
							Y80111BR		
			Y80652				2		
Y80652BR									

Overall length	Length of thread part	Length of chamfer part	Shank diameter
<i>L</i>	<i>ℓ</i>	<i>ℓ<sub>c</sub></i>	<i>D<sub>s</sub></i>

# HT Industrial Quality Hand Taps

For Unified and Metric threads

Unit : inch

Unit : inch

Size	Class	Chamfer	*2 Code No.	<i>L</i>	<i>ℓ</i>	<i>D<sub>s</sub></i>	Number of flutes	*1 Blank type							
No.2 - 56UNC	H2	5P	Y80110	1.75	0.44	0.141	3	Ub							
			Y80110BR												
			Y80651												
			Y80651BR												
		9P	Y80109												
			Y80109BR												
No.2 - 64UNF	H1	1.5P	Y80014	1.75	0.44	0.141	3	Ub							
		5P	Y80013												
	H2	1.5P	Y80114												
			Y80114BR												
			5P						Y80113						
			Y80113BR												
		9P	Y80112												
			Y80112BR												
			No.3 - 48UNC						H1	5P	Y80016	1.81	0.5	0.141	Ub
										1.5P	Y80117				
Y80117BR															
Y80658															
Y80658BR															
H2	5P	Y80116													
		Y80116BR													
		Y80657													
		Y80657BR													
	9P	Y80115													
		Y80115BR													
No.3 - 56UNF	H1	5P	Y80019	1.81	0.5	0.141	3	Ub							
		1.5P	Y80120												
	Y80120BR														
	H2	5P	Y80119												
			Y80119BR												
			9P						Y80118						
			Y80118BR												
		No.4 - 36UNS	H2						1.5P	Y80129	1.88	0.56	0.141	3	Ub
Y80129BR															
5P	Y80128														
	Y80128BR														
	9P			Y80127											
				Y80127BR											
No.4 - 40UNC	H1	1.5P	Y80023	1.88	0.56	0.141	3	Ub							
			Y80022												
		5P	Y80613												
			Y80021												
		9P	Y80123												
			Y80123BR												
	Y80664														
	Y80664BR														

Size	Class	Chamfer	*2 Code No.	<i>L</i>	<i>ℓ</i>	<i>D<sub>s</sub></i>	Number of flutes	*1 Blank type							
No.4 - 40UNC	H2	5P	Y80122	1.88	0.56	0.141	3	Ub							
			Y80122BR												
			Y80663												
			Y80663BR												
		9P	Y80121												
			Y80121BR												
No.4 - 48UNF	H1	5P	Y80025	1.88	0.56	0.141	3	Ub							
		1.5P	Y80126												
	Y80126BR														
	H2	5P	Y80125												
			Y80125BR												
			9P						Y80124						
									Y80124BR						
		No.5 - 40UNC							H1	1.5P	Y80032	1.94	0.63	0.141	Ub
										5P	Y80031				
			1.5P							Y80132					
Y80132BR															
Y80673															
Y80673BR															
H2	5P	Y80131													
		Y80131BR													
		Y80672													
		Y80672BR													
	9P	Y80130													
		Y80130BR													
No.5 - 44UNF	H1	5P	Y80034	1.94	0.63	0.141	3	Ub							
		1.5P	Y80135												
	Y80135BR														
	H2	5P	Y80134												
			Y80134BR												
			Y80675												
			Y80675BR												
		9P	Y80133												
			Y80133BR												
			No.5 - 48UNF						H1	1.5P	Y80038	2	0.69	0.141	3
5P				Y80037											
9P	Y80036														
1.5P	Y80138														
	Y80138BR														
H2	5P	Y80679													
		Y80137													
	9P	Y80137BR													
		Y80678													
No.6 - 32UNC	H2	5P	Y80136	2	0.69	0.141	3	Ub							
			Y80136BR												
		9P	Y80136												
			Y80136BR												

U.S.A. Taps & Dies Line up

Hand Taps

**HT Industrial Quality Hand Taps**  
For Unified and Metric threads

Overall length	Length of thread part	Length of chamfer part	Shank diameter
<i>L</i>	<i>ℓ</i>	<i>ℓ<sub>C</sub></i>	<i>D<sub>s</sub></i>

Unit : inch

Unit : inch

Size	Class	Chamfer	*2 Code No.	<i>L</i>	<i>ℓ</i>	<i>D<sub>s</sub></i>	Number of flutes	*1 Blank type					
No.6 - 32UNC	H3	1.5P	Y80238	2	0.69	0.141	3	Ub					
			Y80238BR										
			Y80729										
			Y80729BR										
		5P	Y80237										
			Y80237BR										
			Y80728										
			Y80728BR										
		9P	Y80236										
			Y80236BR										
			H11						5P	Y85035	4		
									No.6 - 40UNF	H2	5P	Y80040	2
Y80141													
1.5P	Y80141BR												
	Y80140												
5P	Y80140BR												
	Y80681												
	9P	Y80139											
		Y80139BR											
No.8 - 32UNC	H1	1.5P	Y80044	2.13	0.75	0.168	4						
			Y80402										
		5P	Y80043										
			Y80401										
		9P	Y80042										
			H2					1.5P	Y80144				
									Y80452				
								Y80452BR					
	Y80685												
	5P	Y80143											
		Y80451											
	Y80684												
No.8 - 32UNC	H3	1.5P	Y80244	2.13	0.75	0.168	4						
			Y80244BR										
			Y80502										
			Y80502BR										
			Y80735										
			Y80735BR										
		5P	Y80243										
			Y80243BR										
			Y80501										
			Y80501BR										
			Y80734										
			Y80734BR										
9P	Y80242												
	Y80242BR												
	H11	5P	Y85041	4									
		No.8 - 36UNF	H2	1.5P	Y80046	2.13	0.75	0.168	4				
Y80147													
5P				Y80146									
	Y80146BR												
9P	Y80145												
	Y80145BR												
	H1			1.5P	Y80050								
					Y80049								
5P				Y80407									
				9P	Y80048								
H2				1.5P	Y80150								
					Y80149								
	5P	Y80457											
		Y80690											
	9P	Y80148											
		No.10 - 24UNC	H3	1.5P	Y80250	2.38	0.88	0.194	4				
Y80250BR													
Y80508													
Y80508BR													
5P	Y80691												
	Y80741												
	Y80741BR												
	Y80249												
9P	Y80249BR												
	Y80507												
	Y80507BR												
	Y80740												
H11	5P	Y80248											
		Y80248BR											
	H1	1.5P	Y80053										
			5P	Y80052									
No.10 - 32UNF	H2	1.5P	Y80153	2.38	0.88	0.194	4						
			Y80461										
		5P	Y80694										
			Y80152										
		9P	Y80460										
			Y80693										
			Y80151										
			H3					1.5P	Y80253				
		Y80511											
		5P						Y80511BR					
								Y80744					
		9P						Y80744BR					

U.S.A. Taps & Dies Line up

Hand Taps

# HT Industrial Quality Hand Taps

For Unified and Metric threads

Unit : inch

Unit : inch

Size	Class	Chamfer	*2 Code No.	L	ℓ	D <sub>s</sub>	Number of flutes	*1 Blank type
No.10 - 32UNF	H3	5P	Y80252	2.38	0.88	0.194	4	Ub
			Y80252BR					
			Y80510					
		Y80510BR						
		Y80743	3					
		Y80743BR						
	9P	Y80251	2					
		Y80251BR						
	H11	5P	Y85050				4	
	H1	5P	Y80055					
No.12 - 24UNC	H3	1.5P	Y80256	2.38	0.94	0.22	4	Ub
			Y80256BR					
		5P	Y80255					
	Y80255BR							
	9P	Y80254						
		Y80254BR						
No.12 - 28UNF	H1	5P	Y80058	2.38	0.94	0.22	4	Ub
	H3	1.5P	Y80259					
			Y80259BR					
	5P	Y80258						
		Y80258BR						
	9P	Y80257						
Y80257BR								
1/4 - 20UNC	H1	1.5P	Y81002	2.5	1	0.255	4	Ub
			Y81001					
		5P	Y81601					
	H2	1.5P	Y81102				3	
			Y81101					
		5P	Y81651					
	9P	Y81100	4					
		Y81202						
		Y81202BR						
	H3	1.5P	Y81702				3	
			Y81952					
			Y81952BR					
			Y81201					
		5P	Y81201BR				4	
			Y81701					
			Y81701BR					
			Y81951					
	9P	Y81951BR	2					
		Y81200						
		Y81200BR						
Y81402								
H5	1.5P	Y81802	3					
		Y81802BR						

Size	Class	Chamfer	*2 Code No.	L	ℓ	D <sub>s</sub>	Number of flutes	*1 Blank type
1/4 - 20UNC	H5	5P	Y81401	2.5	1	0.255	4	Ub
			Y81801					
	H11	5P	Y85062					
H1	1.5P	Y81005						
	5P	Y81004						
1/4 - 28UNF	H2	1.5P	Y81105	2.5	1	0.255	4	Ub
		5P	Y81104					
	H3	1.5P	Y81205				3	
			Y81205BR					
			Y81705					
			Y81955					
	5P	Y81955BR	2					
		Y81204						
		Y81204BR						
		Y81704						
	9P	Y81704BR	3					
		Y81954						
		Y81954BR						
		Y81203						
	H4	1.5P	Y81305				4	
		5P	Y81304					
H11	5P	Y85065	4					
H1	1.5P	Y81008		4				
	5P	Y81007						
H2	1.5P	Y81108	3					
	5P	Y81107						
5/16 - 18UNC	H3	1.5P	Y81208	2.72	1.13	0.318	4	Ub
			Y81208BR					
			Y81708					
			Y81708BR					
	5P	Y81958	2					
		Y81958BR						
		Y81207						
		Y81207BR						
9P	Y81707	3						
	Y81707BR							
	Y81957							
	Y81957BR							
H5	1.5P	Y81206	4					
		Y81206BR						
5P	Y81408	3						
	Y81808							
H11	5P	Y81407	4					
		Y81807						
Y85068	3							
Y81807		4						

U.S.A. Taps & Dies Line up

Hand Taps

**HT Industrial Quality Hand Taps**  
For Unified and Metric threads

Overall length	Length of thread part	Length of chamfer part	Shank diameter
<i>L</i>	<i>ℓ</i>	<i>ℓ<sub>C</sub></i>	<i>D<sub>s</sub></i>

Unit : inch

Unit : inch

Size	Class	Chamfer	*2 Code No.	<i>L</i>	<i>ℓ</i>	<i>D<sub>s</sub></i>	Number of flutes	*1 Blank type
5/16 - 24UNF	H1	1.5P	Y81011	2.72	1.13	0.318	4	Ub
		5P	Y81010					
	H2	1.5P	Y81111					
		5P	Y81110					
	H3	1.5P	Y81211					
			Y81211BR					
			Y81711					
		5P	Y81210					
			Y81210BR					
			Y81710					
			Y81710BR					
			9P					
	Y81209BR							
	H4	1.5P	Y81311					
5P		Y81310						
H11	5P	Y85071						
3/8 - 16UNC	H1	1.5P	Y81014	2.94	1.25	0.381	4	Ub
		5P	Y81013					
		Y81613						
	H2	1.5P	Y81114					
		5P	Y81113					
	H3	1.5P	Y81214					
			Y81214BR					
			Y81714					
		Y81714BR						
		5P	Y81213					
			Y81213BR					
	Y81713							
	Y81713BR							
	9P	Y81212						
		Y81212BR						
	H5	1.5P	Y81414					
			Y81814					
		5P	Y81413					
Y81813								
H11	5P	Y85074						
3/8 - 24UNF	H1	1.5P	Y81017	2.94	1.25	0.381	4	Ub
		5P	Y81016					
	H2	1.5P	Y81117					
		5P	Y81116					
	H3	1.5P	Y81217					
			Y81217BR					
			Y81717					
		Y81717BR						
		5P	Y81216					
			Y81216BR					
	Y81716							
	Y81716BR							
3/8 - 16UNC	H2	5P	Y81613	2.94	1.25	0.381	4	Ub
		5P	Y81613					
	H2	1.5P	Y81114					
		5P	Y81113					
	H3	1.5P	Y81214					
			Y81214BR					
			Y81714					
		Y81714BR						
		5P	Y81213					
			Y81213BR					
	Y81713							
	Y81713BR							
9P	Y81212							
	Y81212BR							
H5	1.5P	Y81414						
		Y81814						
	5P	Y81413						
Y81813								
H11	5P	Y85074						
3/8 - 24UNF	H1	1.5P	Y81017	2.94	1.25	0.381	4	Ub
		5P	Y81016					
	H2	1.5P	Y81117					
		5P	Y81116					
	H3	1.5P	Y81217					
			Y81217BR					
			Y81717					
		Y81717BR						
		5P	Y81216					
			Y81216BR					
	Y81716							
	Y81716BR							
7/16 - 20UNF	H2	5P	Y81613	3.16	1.44	0.323	4	Ub
		5P	Y81613					
	H2	1.5P	Y81114					
		5P	Y81113					
	H3	1.5P	Y81214					
			Y81214BR					
			Y81714					
		Y81714BR						
		5P	Y81213					
			Y81213BR					
	Y81713							
	Y81713BR							
9P	Y81212							
	Y81212BR							
H5	1.5P	Y81414						
		Y81814						
	5P	Y81413						
Y81813								
H11	5P	Y85074						
7/16 - 14UNC	H3	9P	Y81215BR	3.16	1.44	0.323	4	Ub
		9P	Y81215BR					
	H4	1.5P	Y81317					
		5P	Y81316					
	H11	5P	Y85077					
	H3	1.5P	Y81220					
			Y81220BR					
			Y81720					
		Y81720BR						
		5P	Y81219					
			Y81219BR					
	Y81719							
Y81719BR								
9P	Y81218							
	Y81218BR							
H5	1.5P	Y81420						
	5P	Y81419						
H11	5P	Y85080						
7/16 - 20UNF	H2	5P	Y81122	3.16	1.44	0.323	4	Ub
		5P	Y81122					
	H3	1.5P	Y81223					
			Y81223BR					
			Y81222					
		Y81222BR						
		5P	Y81722					
			Y81722BR					
	Y81221							
	Y81221BR							
	H5	1.5P	Y81423					
		5P	Y81422					
Y81422BR								
H11	5P	Y85083						
1/2 - 13UNC	H1	1.5P	Y81026	3.38	1.66	0.367	4	Ub
		5P	Y81025					
	H2	1.5P	Y81126					
		5P	Y81125					
	H3	1.5P	Y81226					
			Y81226BR					
			Y81726					
		Y81726BR						
		5P	Y81225					
			Y81225BR					
	Y81725							
	Y81725BR							
9P	Y81224							
	Y81224BR							
H5	1.5P	Y81426						
	5P	Y81425						
H11	5P	Y85086						

U.S.A. Taps & Dies Line up

Hand Taps

# HT Industrial Quality Hand Taps

For Unified and Metric threads

Unit : inch

Unit : inch

Size	Class	Chamfer	*2 Code No.	L	ℓ	D <sub>s</sub>	Number of flutes	*1 Blank type
1/2 - 20UNF	H1	1.5P	Y81029	3.38	1.66	0.367	4	4
		5P	Y81028					
	H3	1.5P	Y81229					
			Y81229BR					
		5P	Y81228					
			Y81228BR					
			Y81728					
			Y81227					
	9P	Y81227BR						
		1.5P	Y81429					
	H5	5P	Y81428					
H11		5P	Y85089					
9/16 - 12UNC	H3	1.5P	Y81232	3.59	1.66	0.429	4	4
			Y81232BR					
		5P	Y81231					
			Y81231BR					
	9P	Y81230						
		Y81230BR						
H5	5P	Y81431						
	9/16 - 18UNF	H2	5P	Y81134	3.59	1.66	0.429	4
H3		1.5P	Y81235					
			Y81235BR					
		5P	Y81234					
			Y81234BR					
9P		Y81233						
		Y81233BR						
H5		1.5P	Y81435					
	5P	Y81434						
5/8 - 11UNC	H1	1.5P	Y81038	3.81	1.81	0.48	4	4
			Y81038BR					
	5P	Y81037						
	H2	5P	Y81137					
		H3	1.5P					
	Y81238BR							
	5P		Y81237					
			Y81237BR					
	9P	Y81236						
		Y81236BR						
H5	1.5P	Y81438						
	5P	Y81437						
H11	5P	Y85098						
	5/8 - 18UNF	H1	5P	Y81040	3.81	1.81	0.48	4
H2			5P	Y81140				
H3		1.5P	Y81241					
			Y81241BR					
		5P	Y81240					
Y81240BR								

Size	Class	Chamfer	*2 Code No.	L	ℓ	D <sub>s</sub>	Number of flutes	*1 Blank type
5/8 - 18UNF	H3	9P	Y81239	3.81	1.81	0.48	4	4
		Y81239BR						
	H5	1.5P	Y81441					
		5P	Y81440					
11/16 - 11UNS	H3	1.5P	Y81244	4.03	1.81	0.542	4	4
			Y81244BR					
		5P	Y81243					
			Y81243BR					
		9P	Y81242					
			Y81242BR					
11/16 - 16UNS	H3	1.5P	Y81247	4.03	1.81	0.542	4	4
			Y81247BR					
		5P	Y81246					
			Y81246BR					
		9P	Y81245					
Y81245BR								
3/4 - 10UNC	H2	5P	Y81149	4.25	2	0.59	4	Ub
		1.5P	Y81250					
	Y81250BR							
	H3	5P	Y81249					
		Y81249BR						
	9P	Y81248						
		Y81248BR						
	H5	1.5P	Y81450					
5P		Y81449						
H11	5P	Y85104						
	3/4 - 16UNF	H1	5P	Y81052	4.25	2	0.59	4
H2			5P	Y81152				
H3		1.5P	Y81253					
			Y81253BR					
5P		Y81252						
		Y81252BR						
9P	Y81251							
	Y81251BR							
H5	1.5P	Y81453						
	5P	Y81452						
7/8 - 14UNF	H2	5P	Y81158	4.69	2.22	0.697	4	4
		1.5P	Y81359					
	Y81359BR							
	H4	5P	Y81358					
		Y81358BR						
	9P	Y81357						
Y81357BR								
H6	5P	Y81458						
	7/8 - 9UNC	H4	1.5P	Y81356	4.69	2.22	0.697	4
Y81356BR								
5P		Y81355						
		Y81355BR						

U.S.A. Taps & Dies Line up

Hand Taps

**HT Industrial Quality Hand Taps**  
For Unified and Metric threads

Overall length	Length of thread part	Length of chamfer part	Shank diameter
<i>L</i>	<i>ℓ</i>	<i>ℓ<sub>C</sub></i>	<i>D<sub>s</sub></i>

Unit : inch

Unit : inch

Size	Class	Chamfer	*2 Code No.	<i>L</i>	<i>ℓ</i>	<i>D<sub>s</sub></i>	Number of flutes	*1 Blank type						
7/8 - 9UNC	H4	9P	Y81354	4.69	2.22	0.697	4	Ub						
			Y81354BR											
1 - 12UNF	H4	1.5P	Y81365	5.13	2.5	0.8	4	Ub						
			Y81365BR											
		5P	Y81364											
			Y81364BR											
		9P	Y81363											
			Y81363BR											
1 - 14UNS	H2	5P	Y81167	5.13	2.5	0.8	4	Ub						
			Y81167BR											
	1.5P	Y81368												
		Y81368BR												
	5P	Y81367												
		Y81367BR												
	9P	Y81366												
		Y81366BR												
	1 - 8UNC	H2	5P						Y81161	5.13	2.5	0.8	4	Ub
									Y81362					
1.5P		Y81362BR												
		Y81361												
5P		Y81361BR												
		Y81360												
9P		Y81360BR												
		Y81461												
1"1/8 - 12UNF		H4	1.5P	Y81374	5.44	2.56	0.896	4	Ub					
				Y81374BR										
	5P		Y81373											
			Y81373BR											
	9P		Y81372											
			Y81372BR											
1"1/8 - 7UNC	H4	1.5P	Y81371	5.44	2.56	0.896	4	Ub						
			Y81371BR											
		5P	Y81370											
			Y81370BR											
		9P	Y81369											
			Y81369BR											
1"1/4 - 12UNF	H4	1.5P	Y81380	5.75	2.56	1.021	6	Ub						
			Y81380BR											
		5P	Y81379											
			Y81379BR											
		9P	Y81378											
			Y81378BR											
1"1/4 - 7UNC	H4	1.5P	Y81377	5.75	2.56	1.021	4	Ub						
			Y81377BR											
		5P	Y81376											
			Y81376BR											

Size	Class	Chamfer	*2 Code No.	<i>L</i>	<i>ℓ</i>	<i>D<sub>s</sub></i>	Number of flutes	*1 Blank type
1"1/4 - 7UNC	H4	9P	Y81375	5.75	2.56	1.021	4	Ub
			Y81375BR					
1"3/8 - 12UNF	H4	1.5P	Y81386	6.06	3	1.108	4	Ub
			Y81386BR					
		5P	Y81385					
			Y81385BR					
		9P	Y81384					
			Y81384BR					
1"3/8 - 6UNC	H4	1.5P	Y81383	6.06	3	1.108	4	Ub
			Y81383BR					
		5P	Y81382					
			Y81382BR					
9P	Y81381							
	Y81381BR							
1"1/2 - 12UNF	H4	1.5P	Y81392	6.38	3	1.233	6	Ub
			Y81392BR					
		5P	Y81391					
			Y81391BR					
9P	Y81390							
	Y81390BR							
1"1/2 - 6UNC	H4	1.5P	Y81389	6.38	3	1.233	4	Ub
			Y81389BR					
		5P	Y81388					
			Y81388BR					
9P	Y81387							
	Y81387BR							

**For Metric threads**

Size	Class	Chamfer	Code No.	<i>L</i>	<i>ℓ</i>	<i>D<sub>s</sub></i>	Number of flutes	*1 Blank type
M1.6 X 0.35	D3	1.5P	Y77996	1.63	0.31	0.141	3	Ub
		5P	Y77995				2	
M1.8 X 0.35	D3	1.5P	Y77999	1.69	0.375	0.141	3	Ub
		5P	Y77998				2	
M2 X 0.4	D3	1.5P	Y78002	1.75	0.44	0.141	3	Ub
		5P	Y78001					
M2.2 X 0.45	D3	1.5P	Y78005	1.75	0.44	0.141	3	Ub
		5P	Y78004					
M2.5 X 0.45	D3	1.5P	Y78008	1.81	0.5	0.141	3	Ub
		5P	Y78007					
M3 X 0.5	D3	1.5P	Y78011	1.94	0.63	0.141	3	Ub
		5P	Y78010					
M3.5 X 0.6	D4	1.5P	Y78014	2	0.69	0.141	3	Ub
		5P	Y78013					
M4 X 0.7	D4	1.5P	Y78017	2.13	0.75	0.168	4	Ub
		5P	Y78016					
M4.5 X 0.75	D4	1.5P	Y78020	2.38	0.88	0.194	4	Ub
		5P	Y78019					

U.S.A. Taps & Dies Line up

Hand Taps

# HT Industrial Quality Hand Taps

For Unified and Metric threads

Unit : inch

Unit : inch

Size	Class	Chamfer	Code No.	L	ℓ	D <sub>s</sub>	Number of flutes	*1 Blank type
M5 X 0.8	D4	1.5P	Y78023	2.38	0.88	0.194	4	Ub
		5P	Y78022					
M6 X 1	D5	1.5P	Y78026	2.5	1	0.255	4	Ub
		5P	Y78025					
M7 X 1	D5	1.5P	Y78029	2.72	1.13	0.318	4	Ub
		5P	Y78028					
M8 X 1	D5	1.5P	Y78032	2.72	1.13	0.318	4	Ub
		5P	Y78031					
M8 X 1.25	D5	1.5P	Y78035	2.72	1.13	0.318	4	Ub
		5P	Y78034					
M10 X 1.25	D5	1.5P	Y78038	2.94	1.25	0.381	4	Ub
		5P	Y78037					
M10 X 1.5	D6	1.5P	Y78041	2.94	1.25	0.381	4	Ub
		5P	Y78040					
M12 X 1.25	D5	1.5P	Y78044	3.38	1.66	0.367	4	Ub
		5P	Y78043					
M12 X 1.75	D6	1.5P	Y78047	3.38	1.66	0.367	4	Ub
		5P	Y78046					
M14 X 1.5	D6	1.5P	Y78050	3.59	1.66	0.429	4	Ub
		5P	Y78049					
M14 X 2	D7	1.5P	Y78053	3.59	1.66	0.429	4	Ub
		5P	Y78052					
M16 X 1.5	D6	1.5P	Y78056	3.81	1.81	0.48	4	Ub
		5P	Y78055					
M16 X 2	D7	1.5P	Y78059	3.81	1.81	0.48	4	Ub
		5P	Y78058					
M18 X 1.5	D6	1.5P	Y78062	4.03	1.81	0.542	4	Ub
		5P	Y78061					
M18 X 2.5	D7	1.5P	Y78065	4.03	1.81	0.542	4	Ub
		5P	Y78064					
M20 X 1.5	D6	1.5P	Y78068	4.47	2	0.652	4	Ub
		5P	Y78067					
M20 X 2.5	D7	1.5P	Y78071	4.47	2	0.652	4	Ub
		5P	Y78070					
M22 X 1.5	D6	1.5P	Y78074	4.69	2.22	0.697	4	Ub
		5P	Y78073					
M22 X 2.5	D7	1.5P	Y78077	4.69	2.22	0.697	4	Ub
		5P	Y78076					
M24 X 2	D7	1.5P	Y78080	4.91	2.22	0.76	4	Ub
		5P	Y78079					
M24 X 3	D8	1.5P	Y78083	4.91	2.22	0.76	4	Ub
		5P	Y78082					
M27 X 2	D7	1.5P	Y78086	5.13	2.5	0.896	4	Ub
		5P	Y78085					
M27 X 3	D8	1.5P	Y78089	5.13	2.5	0.896	4	Ub
		5P	Y78088					
M30 X 2	D7	1.5P	Y78092	5.44	2.56	1.021	4	Ub
		5P	Y78091					

Size	Class	Chamfer	Code No.	L	ℓ	D <sub>s</sub>	Number of flutes	*1 Blank type
M30 X 3.5	D9	1.5P	Y78095	5.44	2.56	1.021	4	Ub
		5P	Y78094					
M33 X 2	D7	1.5P	Y78098	5.75	2.56	1.108	4	Ub
		5P	Y78097					
M33 X 3.5	D9	1.5P	Y78101	5.75	2.56	1.108	4	Ub
		5P	Y78100					
M36 X 3	D8	1.5P	Y78104	6.06	3	1.233	4	Ub
		5P	Y78103					
M36 X 4	D9	1.5P	Y78107	6.06	3	1.233	4	Ub
		5P	Y78106					
M39 X 3	D8	1.5P	Y78110	6.69	3.19	1.305	4	Ub
		5P	Y78109					
M39 X 4	D10	1.5P	Y78113	6.69	3.19	1.305	4	Ub
		5P	Y78112					

U.S.A. Taps & Dies Line up

Hand Taps

## Industrial Quality STI Hand Taps

For Unified and Metric threads

# STI HT



"available while supplies last"  
 Vanadium High Speed Steel Taps  
 For Tapping Steels, Irons, Brass and Plastics  
 STI taps are special taps used to prepare holes for the installation of helical coil wire thread inserts.

\*1 See blank type on page 97.

## Carbide Taps for Cast Irons

For Unified and Metric threads

# ZELX CARB CI



ZELX® Performance Quality Carbide Hand Taps  
 Micro Grain Carbide  
 For Cast Irons, Hard Plastics, Fiberglass, Cast Brass, Cobalt, Chrome Alloys Steels

\*1 See blank type on page 97.

Unit : inch

Size	Class	Chamfer	Code No.	L	ℓ	D <sub>s</sub>	Number of flutes	*1 Blank type
No.2 - 56UNC	H2	1.5P	Y80781	1.88	0.563	0.141	3	Ub
		5P	Y80780					
No.4 - 40UNC	H2	1.5P	Y80785	2	0.688	0.141	3	Ub
		5P	Y80784					
No.6 - 32UNC	H3	1.5P	Y80817	2.38	0.875	0.194	3	Ub
		5P	Y80816					
No.8 - 32UNC	H3	1.5P	Y80821	2.38	0.938	0.22	3	Ub
		5P	Y80820					
No.10 - 24UNC	H2	1.5P	Y80801	2.5	1	0.255	4	Ub
		5P	Y80800					
No.10 - 32UNF	H2	1.5P	Y80803	2.5	1	0.255	3	Ub
		5P	Y80802					
	H3	1.5P	Y80827					
		5P	Y80826					
1/4 - 20UNC	H3	1.5P	Y81881	2.72	1.125	0.318	3	Ub
		5P	Y81880					
1/4 - 28UNF	H2	1.5P	Y81863	2.72	1.125	0.318	3	Ub
		5P	Y81862					
5/16 - 18UNC	H3	1.5P	Y81885	2.94	1.25	0.381	4	Ub
		5P	Y81884					
5/16 - 24UNF	H2	1.5P	Y81867	2.94	1.25	0.381	4	Ub
		5P	Y81866					
3/8 - 16UNC	H3	1.5P	Y81889	3.38	1.656	0.367	4	Ub
		5P	Y81888					
7/16 - 14UNC	H3	5P	Y81892	3.59	1.656	0.429	4	Ub
7/16 - 20UNF	H3	5P	Y81894	3.38	1.656	0.367	4	Ub
	H4	1.5P	Y81901					
1/2 - 13UNC	H3	5P	Y81896	3.81	1.81	0.48	4	Ub
1/2 - 20UNF	H3	5P	Y81898	3.59	1.656	0.429	4	Ub

Unit : inch

Size	Class	Chamfer	Code No.	L	ℓ	D <sub>s</sub>	Number of flutes	*1 Blank type
No.10 - 24UNC	H3	1.5P	Y83807	2.38	0.88	0.194	4	Ub
		5P	Y83806					
No.10 - 32UNF	H3	1.5P	Y83809	2.38	0.88	0.194	4	Ub
		5P	Y83808					
1/4 - 20UNC	H3	1.5P	Y83811	2.5	1	0.255	4	Ub
		5P	Y83810					
	H5	1.5P	Y83861					
		5P	Y83860					
1/4 - 28UNF	H3	1.5P	Y83813	2.5	1	0.255	4	Ub
		5P	Y83812					
	H5	1.5P	Y83863					
		5P	Y83862					
5/16 - 18UNC	H3	1.5P	Y83815	2.72	1.13	0.318	4	Ub
		5P	Y83814					
	H5	1.5P	Y83865					
		5P	Y83864					
5/16 - 24UNF	H3	1.5P	Y83817	2.72	1.13	0.318	4	Ub
		5P	Y83816					
	H5	1.5P	Y83867					
		5P	Y83866					
3/8 - 16UNC	H3	1.5P	Y83819	2.94	1.25	0.381	4	Ub
		5P	Y83818					
	H5	1.5P	Y83869					
		5P	Y83868					
3/8 - 24UNF	H3	1.5P	Y83821	2.94	1.25	0.381	4	Ub
		5P	Y83820					
	H5	1.5P	Y83871					
		5P	Y83870					
7/16 - 14UNC	H3	1.5P	Y83823	3.16	1.44	0.323	4	Ub
		5P	Y83822					
	H5	1.5P	Y83873					
		5P	Y83872					
7/16 - 20UNF	H3	1.5P	Y83825	3.16	1.44	0.323	4	Ub
		5P	Y83824					