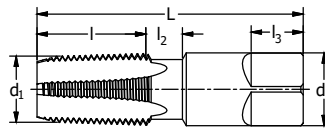
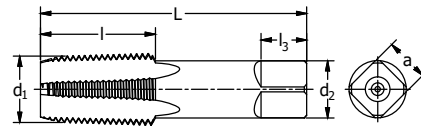


311  
Pipe Tap Blank Design 1



311  
Pipe Tap Blank Design 2  
with optional neck



311  
Pipe Tap Blank Design 3

General Dimensions (all measurements in inches)

nominal size	tap style	overall length L	thread length l	square length l <sub>3</sub>	shank dia. d <sub>2</sub>	square size a	optional neck l <sub>2</sub>
1/16	1	2.13	.69	.38	.3125	.234	.375
1/8	1	2.13	.75	.38	.3125	.234	-
1/8	1	2.13	.75	.38	.4375	.328	.375
1/4	1	2.44	1.06	.44	.5625	.421	.375
3/8	1	2.56	1.06	.50	.7000	.531	.375
1/2	3	3.13	1.38	.63	.6875	.515	-
3/4	3	3.25	1.38	.69	.9063	.679	-
1	3	3.75	1.75	.81	1.1250	.843	-
1-1/4	3	4.00	1.75	.94	1.3125	.984	-
1-1/2	3	4.25	1.75	1.00	1.5000	1.125	-
2	3	4.50	1.75	1.13	1.8750	1.406	-
2-1/2	3	5.50	2.56	1.25	2.2500	1.687	-
3	3	6.00	2.63	1.38	2.6250	1.968	-
3-1/2	3	6.50	2.69	1.50	2.8125	2.108	-
4	3	6.75	2.75	1.56	3.0000	2.250	-

Tolerances (all measurements in inches)

element	range	direction	tolerance
Length Overall	1/16" to 3/4" inc.	+ / -	.031
- L	1" to 4" inc.	+ / -	.063
Length of Thread	1/16" to 3/4" inc.	+ / -	.063
- l	1" to 1-1/4" inc.	+ / -	.094
	1-1/2" to 4"	+ / -	.125
Length of Square	1/16" to 3/4" inc.	+ / -	.031
- l <sub>3</sub>	1" to 4" inc.	+ / -	.063
Diameter of Shank	1/16" to 1/8"	-	.0015
- d <sub>2</sub>	1/4" to 1" inc.	-	.0020
	1-1/4" to 4" inc.	-	.0030
Size of Square	1/16" to 1/8"	-	.004
- a	1/4" to 3/4" inc.	-	.006
	1" to 4" inc.	-	.008

High Speed Steel TECHNICAL