

STANDARD TAP DIMENSIONS Table 302/303 - Over 1" Diameter

Nominal Diameter Range - Inches		Nominal Fractional Diameter (Inches)	Nominal Metric Diameter (Millimeters)	Style	Table 302 Long Length					Table 303 Short Length			
					D Shank Diameter	A Overall Length	B Thread Length	C Square Length	E Size of Square	A Overall Length	B Thread Length	C Square Length	E Size of Square
1.010	1.073	1-1/16	M27	3	.896	5-1/8	2-1/2	7/8	.672	4	1-1/2	7/8	.672
1.073	1.135	1-1/8		3	.896	5-7/16	2-9/16	7/8	.672	4	1-1/2	7/8	.672
1.135	1.198	1-3/16	M30	3	1.021	5-7/16	2-9/16	1	.766	4	1-1/2	1	.766
1.198	1.260	1-1/4		3	1.021	5-3/4	2-9/16	1	.766	4	1-1/2	1	.766
1.260	1.323	1-5/16	M33	3	1.108	5-3/4	2-9/16	1-1/16	.831	4	1-1/2	1	.831
1.323	1.385	1-3/8		3	1.108	6-1/16	3	1-1/16	.831	4	1-1/2	1	.831
1.385	1.448	1-7/16	M36	3	1.233	6-1/16	3	1-1/8	.925	4	1-1/2	1	.925
1.448	1.510	1-1/2		3	1.233	6-3/8	3	1-1/8	.925	4	1-1/2	1	.925
1.510	1.635	1-5/8	M39	3	1.305	6-11/16	3-3/16	1-1/8	.979	5	2	1-1/8	.979
1.635	1.760	1 3/4	M42	3	1.430	7	3-3/16	1-1/4	1.072	5	2	1-1/4	1.072
1.760	1.885	1-7/8		3	1.519	7-5/16	3-9/16	1-1/4	1.139	5	2	1-1/4	1.139
1.885	2.010	2	M48	3	1.644	7-5/8	3-9/16	1-3/8	1.233	5	2	1-3/8	1.233
2.010	2.135	2-1/8		3	1.769	8	3-9/16	1-3/8	1.327	5-1/4	2	1-3/8	1.327
2.135	2.260	2-1/4	M56	3	1.894	8-1/4	3-9/16	1-7/16	1.420	5-1/4	2	1-7/16	1.420
2.260	2.385	2-3/8		3	2.019	8-1/2	4	1-7/16	1.514	5-1/4	2	1-7/16	1.514
2.385	2.510	2-1/2		3	2.100	8-3/4	4	1-1/2	1.575	5-1/4	2	1-1/2	1.575
2.510	2.635	2-5/8	M64	3	2.225	8-3/4	4	1-1/2	1.669	5-1/2	2	1-1/2	1.575
2.635	2.760	2-3/4		3	2.350	9-1/4	4	1-9/16	1.762	5-1/2	2	1-1/2	1.575
2.760	2.885	2-7/8	M72	3	2.475	9-1/4	4	1	1.856	5-1/2	2	1-1/2	1.575
2.885	3.010	3		3	2.543	9-3/4	4-9/16	1-5/8	1.907	5-1/2	2	1-1/2	1.575
3.010	3.135	3-1/8		3	2.668	9-3/4	4-9/16	1-5/8	2.001	5-3/4	2	1-1/2	1.575
3.135	3.260	3-1/4	M80	3	2.793	10	4-9/16	1-3/4	2.095	5-3/4	2	1-1/2	1.575
3.260	3.385	3-3/8		3	2.883	10	4-9/16	1-3/4	2.162	5-3/4	2	1-1/2	1.575
3.385	3.510	3-1/2		3	3.008	10-1/4	4-15/16	2	2.256	5-3/4	2	1-1/2	1.575
3.510	3.635	3-5/8	M90	3	3.133	10-1/4	4-15/16	2	2.350	6	2	1-3/4	1.575
3.635	3.760	3-3/4		3	3.217	10-1/2	5-5/16	2-1/8	2.413	6	2	1-3/4	1.575
3.760	3.885	3-7/8		3	3.342	10-1/2	5-5/16	2-1/8	2.506	6	2	1-3/4	1.575
3.885	4.010	4	M100	3	3.467	10-3/4	5-5/16	2-1/4	2.600	6	2	1-3/4	1.575

Short length blanks, 2.385" diameter through 4.010", have a 2.100" shank diameter.

Note: Unless otherwise specified, special taps over 1.010" to 1.510" diameter inclusive, having 14 or more threads per inch or 1.75 millimeter pitch and finer, and sizes over 1.510" diameter with 10 or more threads per inch or 2.5 millimeter pitch and finer, are made to general dimensions, Table 303, United States Cutting Tool Institute (USCTI) standards.

Element	Nominal Diameter Range - Inches		Direction	Tolerance - Inches
	Over	To (Incl.)		
Length Overall - A	.052	1.010	Plus or Minus	1/32
	1.010	4.010	Plus or Minus	1/16
Length of Thread - B	.052	.223	Plus or Minus	3/64
	.223	.510	Plus or Minus	1/16
	.510	1.510	Plus or Minus	3/32
	1.510	4.010	Plus or Minus	1/8
Length of Square - C	.052	1.010	Plus or Minus	1/32
	1.010	4.010	Plus or Minus	1/16
Diameter of Shank - D	.052	.223	Minus	.0015
	.223	.635	Minus	.0015
	.635	1.010	Minus	.002
	1.010	1.510	Minus	.002
	1.510	2.010	Minus	.003
Size of Square - E	2.010	4.010	Minus	.003
	.052	.510	Minus	.004
	.510	1.010	Minus	.006
	1.010	2.010	Minus	.008
	2.010	4.010	Minus	.010