



EXTENSION TAPS



Extension Hand Taps

- Large, Standard, and Small Shanks
- Bottom and Plug Chamfers
- 4", 6", & 8" Lengths

Extension Spiral Point Plug Taps

- Standard and Small Shanks
- 4", 6", & 8" Lengths

Extension NPT Pipe Taps

- Standard Shanks
- 4" & 6" Lengths



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Extension Hand Taps

Straight Flute Extension Hand Taps are used for tapping by hand or tapping by machine in blind holes or through holes in a wide variety of materials.



**Metric Extension
Hand Taps
Back Cover**

**List No. 2040 - Fractional and Machine Screw -
High Speed Steel**

4" Extension Hand Taps

Size	TPI UNC	TPI UNF	Pitch Dia. Limit	No. of Flutes	Thread Length	Shank Style	Shank Dia.	EDP No.	
								Plug	Bottom
1/4	20		H3	4	1	Small	0.185	31600	—
5/16	18		H3	4	1-1/8	Small	0.240	31601	—
3/8	16		H3	4	1-1/4	Small	0.275	31602	—
1/2	13		H3	4	1-21/32	Std	0.367	31603	—

6" Extension Hand Taps

6	32		H3	3	11/16	Small	0.097	31614	—
6	32		H3	3	11/16	Std	0.141	31615	31616
8	32		H3	4	3/4	Small	0.123	31617	—
8	32		H3	4	3/4	Std	0.168	31618	31619
10	24		H3	4	7/8	Small	0.136	31620	—
10	24		H3	4	7/8	Std	0.194	31621	31622
10		32	H3	4	7/8	Small	0.136	31623	—
10		32	H3	4	7/8	Std	0.194	31624	31625
1/4	20		H3	4	1	Small	0.185	31626	—
1/4	20		H3	4	1	Std	0.255	31627	31628
1/4		28	H3	4	1	Small	0.185	31629	—
1/4		28	H3	4	1	Std	0.255	31630	31631
5/16	18		H3	4	1-1/8	Small	0.240	31632	—
5/16	18		H3	4	1-1/8	Std	0.318	31633	31634
5/16		24	H3	4	1-1/8	Small	0.240	31635	—
5/16		24	H3	4	1-1/8	Std	0.318	31636	31637
3/8	16		H3	4	1-1/4	Small	0.275	31638	31639
3/8	16		H3	4	1-1/4	Std	0.381	31640	31641
3/8		24	H3	4	1-1/4	Small	0.275	31642	—
3/8		24	H3	4	1-1/4	Std	0.381	31643	31644
7/16	14		H3	4	1-7/16	Std	0.323	31645	31646
7/16		20	H3	4	1-7/16	Std	0.323	31647	31648
1/2	13		H3	4	1-21/32	Std	0.367	31649	31651
1/2	13		H3	4	1-21/32	Large	0.507	31650	—
1/2		20	H3	4	1-21/32	Std	0.367	31652	—
9/16	12		H3	4	1-21/32	Std	0.429	31653	31654
9/16		18	H3	4	1-21/32	Std	0.429	31655	31656
5/8	11		H3	4	1-13/16	Std	0.480	31657	—
5/8		18	H3	4	1-13/16	Std	0.480	31658	31659
3/4	10		H3	4	2	Std	0.590	31660	31661
3/4		16	H3	4	2	Std	0.590	31662	—
7/8	9		H4	4	2-7/32	Std	0.697	31663	—
1	8		H4	4	2-1/2	Std	0.800	31664	—

8" Extension Hand Taps

1/4	20		H3	4	1	Std	0.255	31685	—
5/16	18		H3	4	1-1/8	Std	0.318	31686	—
3/8	16		H3	4	1-1/4	Small	0.275	31687	—
3/8	16		H3	4	1-1/4	Std	0.381	31688	—
7/16	14		H3	4	1-7/16	Std	0.323	31689	—
1/2	13		H3	4	1-21/32	Std	0.367	31690	—
1/2	13		H3	4	1-21/32	Large	0.507	31691	—
5/8	11		H3	4	1-13/16	Std	0.480	31692	—
3/4	10		H3	4	2	Std	0.590	31693	—
7/8	9		H4	4	2-7/32	Std	0.697	31694	—
1	8		H4	4	2-1/2	Std	0.800	31695	31696

Spiral Point Extension Taps

Spiral Point Extension Taps are used for tapping through holes by machine in a wide variety of materials. Chips are ejected ahead of the tap eliminating problems associated with chips remaining in the hole.



**Metric Spiral Point
Extension Taps
Back Cover**

**List No. 2041 - Fractional and Machine Screw -
High Speed Steel**

4" Extension Spiral Point Plug Taps

Size	TPI UNC	TPI UNF	Pitch Dia. Limit	No. of Flutes	Thread Length	Shank Style	Shank Dia.	EDPNo.
6	32		H3	2	11/16	Small	0.097	31710
6	32		H3	2	11/16	Std	0.141	31711
8	32		H3	2	3/4	Small	0.123	31712
8	32		H3	2	3/4	Std	0.168	31713
10	24		H3	2	7/8	Small	0.136	31714
10	24		H3	2	7/8	Std	0.194	31715
10		32	H3	2	7/8	Small	0.136	31716
10		32	H3	2	7/8	Std	0.194	31717
1/4	20		H3	2	1	Small	0.185	31718
1/4		28	H3	2	1	Small	0.185	31719
5/16	18		H3	2	1-1/8	Small	0.240	31720
5/16		24	H3	2	1-1/8	Small	0.240	31721
3/8	16		H3	3	1-1/4	Small	0.275	31722
3/8		24	H3	3	1-1/4	Small	0.275	31723
1/2	13		H3	3	1-21/32	Std	0.367	31724

6" Extension Spiral Point Plug Taps

6	32		H3	2	11/16	Small	0.097	31735
6	32		H3	2	11/16	Std	0.141	31736
8	32		H3	2	3/4	Small	0.123	31737
8	32		H3	2	3/4	Std	0.168	31738
10	24		H3	2	7/8	Small	0.136	31739
10	24		H3	2	7/8	Std	0.194	31740
10		32	H3	2	7/8	Small	0.136	31741
10		32	H3	2	7/8	Std	0.194	31742
1/4	20		H3	2	1	Small	0.185	31743
1/4	20		H3	2	1	Std	0.255	31744
1/4		28	H3	2	1	Small	0.185	31745
1/4		28	H3	2	1	Std	0.255	31746
5/16	18		H3	2	1-1/8	Small	0.240	31747
5/16	18		H3	2	1-1/8	Std	0.318	31748
5/16		24	H3	2	1-1/8	Small	0.240	31749
5/16		24	H3	2	1-1/8	Std	0.318	31750
3/8	16		H3	3	1-1/4	Small	0.275	31751
3/8	16		H3	3	1-1/4	Std	0.381	31752
3/8		24	H3	3	1-1/4	Small	0.275	31753
3/8		24	H3	3	1-1/4	Std	0.381	31754
7/16	14		H3	3	1-7/16	Std	0.323	31755
7/16		20	H3	3	1-7/16	Std	0.323	31756
1/2	13		H3	3	1-21/32	Std	0.367	31757
1/2		20	H3	3	1-21/32	Std	0.367	31758
5/8	11		H3	3	1-13/16	Std	0.480	31759
5/8		18	H3	3	1-13/16	Std	0.480	31760
3/4	10		H3	3	2	Std	0.590	31761
3/4		16	H3	3	2	Std	0.590	31762

8" Extension Spiral Point Plug Taps

3/8	16		H3	3	1-1/4	Small	0.275	31780
1/2	13		H3	3	1-21/32	Std	0.367	31781
5/8	11		H3	3	1-13/16	Std	0.480	31782
3/4	10		H3	3	2	Std	0.590	31783

Extension Straight Flute Taper Pipe Taps

Extension Straight Flute Taper Pipe Taps are used for tapping by hand or by machine in blind or through holes in a wide variety of materials.



List No. 2042 NPT - High Speed Steel

4" Extension Straight Flute Taper Pipe Taps

Size	TPI UNC	Chamfer	No. of Flutes	Thread Length	Shank Dia.	EDP No.
1/16	27	Plug	4	11/16	0.312	31790
1/8	27	Plug	4	3/4	0.438	31791
1/4	18	Plug	4	1-1/16	0.563	31792

6" Extension Straight Flute Taper Pipe Taps

1/16	27	Plug	4	11/16	0.312	31800
1/8	27	Plug	4	3/4	0.438	31801
1/4	18	Plug	4	1-1/16	0.563	31802
3/8	18	Plug	4	1-1/16	0.700	31803
1/2	14	Plug	4	1-3/8	0.688	31804
3/4	14	Plug	4	1-3/8	0.906	31805
1	11.5	Plug	4	1-3/4	1.125	31806

Metric Extension Hand Taps



List No. 2040M - High Speed Steel

Metric 6" Extension Hand Taps

Size	Pitch	Pitch Dia. Limit	No. of Flutes	Thread Length	Shank Style	Shank Dia.	EDP No.	
							Plug	Bottom
M4.5	0.75	D4	4	7/8	Std	0.194	31820	31821
M6	1.00	D5	4	1	Std	0.255	31822	31823
M8	1.25	D5	4	1-1/8	Std	0.318	31824	31825
M10	1.50	D6	4	1-1/4	Small	0.323	31826	31827
M12	1.75	D6	4	1-21/32	Std	0.367	31828	31829
M14	2.00	D7	4	1-21/32	Large	0.570	31830	—
M16	2.00	D7	4	1-13/16	Large	0.633	31831	—
M20	2.50	D7	4	2	Std	0.652	31832	—

Metric Spiral Point Extension Taps



List No. 2041M - High Speed Steel

Metric 6" Extension Spiral Point Plug Taps

Size	Pitch	Pitch Dia. Limit	No. of Flutes	Thread Length	Shank Style	Shank Dia.	EDP No.
M4	0.70	D4	2	3/4	Std	0.168	31833
M5	0.80	D4	2	7/8	Std	0.194	31834
M6	1.00	D5	2	1	Std	0.255	31835
M8	1.25	D5	2	1-1/8	Std	0.318	31836
M10	1.50	D6	3	1-1/4	Std	0.381	31837
M12	1.75	D6	3	1-21/32	Std	0.367	31838