



MORSE
CUTTING TOOLS

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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**For Tapping Applications
where
Extra Reach is Required**

Extension Straight Flute Hand Taps

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



List No. 2040
Ground Thread — High Speed Steel
Bright Finish

Small Shank Taps and Standard Shank Taps Size 7/16" and Larger have a shank diameter that is smaller than the minor diameter of the thread.

4" Overall Length

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	.185	31600	—
5/16	18		H3	4	1-1/8	Small	.240	31601	—
3/8	16		H3	4	1-1/4	Small	.275	31602	—
1/2	13		H3	4	1-21/32	Std	.367	31603	—

6" Overall Length

6	32		H3	3	11/16	Small	.097	31614	—
6	32		H3	3	11/16	Std	.141	31615	31616
8	32		H3	4	3/4	Small	.123	31617	—
8	32		H3	4	3/4	Std	.168	31618	31619
10	24		H3	4	7/8	Small	.136	31620	—
10	24		H3	4	7/8	Std	.194	31621	31622
10		32	H3	4	7/8	Small	.136	31623	—
10		32	H3	4	7/8	Std	.194	31624	31625
1/4	20		H3	4	1	Small	.185	31626	—
1/4	20		H3	4	1	Std	.255	31627	31628
1/4		28	H3	4	1	Small	.185	31629	—
1/4		28	H3	4	1	Std	.255	31630	31631
5/16	18		H3	4	1-1/8	Small	.240	31632	—
5/16	18		H3	4	1-1/8	Std	.318	31633	31634
5/16		24	H3	4	1-1/8	Small	.240	31635	—
5/16		24	H3	4	1-1/8	Std	.318	31636	31637
3/8	16		H3	4	1-1/4	Small	.275	31638	31639
3/8	16		H3	4	1-1/4	Std	.381	31640	31641
3/8		24	H3	4	1-1/4	Small	.275	31642	—
3/8		24	H3	4	1-1/4	Std	.381	31643	31644
7/16	14		H3	4	1-7/16	Std	.323	31645	31646
7/16		20	H3	4	1-7/16	Std	.323	31647	31648
1/2	13		H3	4	1-21/32	Std	.367	31649	31651
1/2	13		H3	4	1-21/32	Large	.507	31650	—
1/2		20	H3	4	1-21/32	Std	.367	31652	—
9/16	12		H3	4	1-21/32	Std	.429	31653	31654
9/16		18	H3	4	1-21/32	Std	.429	31655	31656
5/8	11		H3	4	1-13/16	Std	.480	31657	—
5/8		18	H3	4	1-13/16	Std	.480	31658	31659
3/4	10		H3	4	2	Std	.590	31660	31661
3/4		16	H3	4	2	Std	.590	31662	—
7/8	9		H4	4	2-7/32	Std	.697	31663	—
1	8		H4	4	2-1/2	Std	.800	31664	—

8" Overall Length

1/4	20		H3	4	1	Std	.255	31685	—
5/16	18		H3	4	1-1/8	Std	.318	31686	—
3/8	16		H3	4	1-1/4	Small	.275	31687	—
3/8	16		H3	4	1-1/4	Std	.381	31688	—
7/16	14		H3	4	1-7/16	Std	.323	31689	—
1/2	13		H3	4	1-21/32	Std	.367	31690	—
1/2	13		H3	4	1-21/32	Large	.507	31691	—
5/8	11		H3	4	1-13/16	Std	.480	31692	—
3/4	10		H3	4	2	Std	.590	31693	—
7/8	9		H4	4	2-7/32	Std	.697	31694	—
1	8		H4	4	2-1/2	Std	.800	31695	31696

Extension Spiral Point Plug 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.



List No. 2041
Ground Thread — High Speed Steel
Bright Finish

Small Shank Taps and Standard Shank Taps Size 7/16" and Larger have a shank diameter that is smaller than the minor diameter of the thread.

4" Overall Length

Size	TPI UNC	TPI UNF	Pitch Dia. Limit	No. of Flutes	Thread Length	Shank Style	Shank Dia.	EDP No.
6	32		H3	2	11/16	Small	.097	31710
6	32		H3	2	11/16	Std	.141	31711
8	32		H3	2	3/4	Small	.123	31712
8	32		H3	2	3/4	Std	.168	31713
10	24		H3	2	7/8	Small	.136	31714
10	24		H3	2	7/8	Std	.194	31715
10		32	H3	2	7/8	Small	.136	31716
10		32	H3	2	7/8	Std	.194	31717
1/4	20		H3	2	1	Small	.185	31718
1/4		28	H3	2	1	Small	.185	31719
5/16	18		H3	2	1-1/8	Small	.240	31720
5/16		24	H3	2	1-1/8	Small	.240	31721
3/8	16		H3	3	1-1/4	Small	.275	31722
3/8		24	H3	3	1-1/4	Small	.275	31723
1/2	13		H3	3	1-21/32	Std	.367	31724

6" Overall Length

6	32		H3	2	11/16	Small	.097	31735
6	32		H3	2	11/16	Std	.141	31736
8	32		H3	2	3/4	Small	.123	31737
8	32		H3	2	3/4	Std	.168	31738
10	24		H3	2	7/8	Small	.136	31739
10	24		H3	2	7/8	Std	.194	31740
10		32	H3	2	7/8	Small	.136	31741
10		32	H3	2	7/8	Std	.194	31742
1/4	20		H3	2	1	Small	.185	31743
1/4	20		H3	2	1	Std	.255	31744
1/4		28	H3	2	1	Small	.185	31745
1/4		28	H3	2	1	Std	.255	31746
5/16	18		H3	2	1-1/8	Small	.240	31747
5/16	18		H3	2	1-1/8	Std	.318	31748
5/16		24	H3	2	1-1/8	Small	.240	31749
5/16		24	H3	2	1-1/8	Std	.318	31750
3/8	16		H3	3	1-1/4	Small	.275	31751
3/8	16		H3	3	1-1/4	Std	.381	31752
3/8		24	H3	3	1-1/4	Small	.275	31753
3/8		24	H3	3	1-1/4	Std	.381	31754
7/16	14		H3	3	1-7/16	Std	.323	31755
7/16		20	H3	3	1-7/16	Std	.323	31756
1/2	13		H3	3	1-21/32	Std	.367	31757
1/2		20	H3	3	1-21/32	Std	.367	31758
5/8	11		H3	3	1-13/16	Std	.480	31759
5/8		18	H3	3	1-13/16	Std	.480	31760
3/4	10		H3	3	2	Std	.590	31761
3/4		16	H3	3	2	Std	.590	31762

8" Overall Length

3/8	16		H3	3	1-1/4	Small	.275	31780
1/2	13		H3	3	1-21/32	Std	.367	31781
5/8	11		H3	3	1-13/16	Std	.480	31782
3/4	10		H3	3	2	Std	.590	31783

Extension Taper Pipe Taps – NPT

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



List No. 2042
Ground Thread — High Speed Steel
Bright Finish

4" Overall Length

Size	TPI	Chamfer	No. of Flutes	Thread Length	Shank Dia.	EDP No.
1/16	27	Plug	4	11/16	.3125	31790
1/8	27	Plug	4	3/4	.4375	31791
1/4	18	Plug	4	1-1/16	.5625	31792

6" Overall Length

1/16	27	Plug	4	11/16	.3125	31800
1/8	27	Plug	4	3/4	.4375	31801
1/4	18	Plug	4	1-1/16	.5625	31802
3/8	18	Plug	4	1-1/16	.7000	31803
1/2	14	Plug	4	1-3/8	.6875	31804
3/4	14	Plug	5	1-3/8	.9063	31805
1	11.5	Plug	5	1-3/4	1.1250	31806

Extension Metric Straight Flute Hand Taps



List No. 2040M
Ground Thread — High Speed Steel
Bright Finish

Small Shank Taps and Standard Shank Taps Size M12 and Larger have a shank diameter that is smaller than the minor diameter of the thread.

6" Overall Length

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	.194	31820	31821
M6	1.00	D5	4	1	Std	.255	31822	31823
M8	1.25	D5	4	1-1/8	Std	.318	31824	31825
M10	1.50	D6	4	1-1/4	Small	.323	31826	31827
M12	1.75	D6	4	1-21/32	Std	.367	31828	31829
M14	2.00	D7	4	1-21/32	Large	.570	31830	—
M16	2.00	D7	4	1-13/16	Large	.633	31831	—
M20	2.50	D7	4	2	Std	.652	31832	—

Extension Metric Spiral Point Plug Taps



List No. 2041M
Ground Thread — High Speed Steel
Bright Finish

Small Shank Taps and Standard Shank Taps Size M12 and Larger have a shank diameter that is smaller than the minor diameter of the thread.

6" Overall Length

Size	Pitch	Pitch Dia. Limit	No. of Flutes	Thread Length	Shank Style	Shank Dia.	EDP No.
M4	0.70	D4	2	3/4	Std	.168	31833
M5	0.80	D4	2	7/8	Std	.194	31834
M6	1.00	D5	2	1	Std	.255	31835
M8	1.25	D5	2	1-1/8	Std	.318	31836
M10	1.50	D6	3	1-1/4	Std	.381	31837
M12	1.75	D6	3	1-21/32	Std	.367	31838