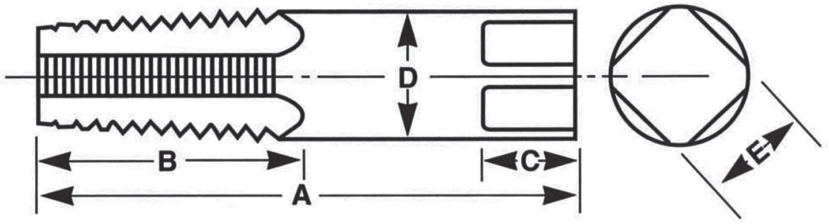
Table 311 — Pipe Taps



General Dimensions

NOMINAL SIZE INCHES	DIMENSIONS - INCHES				
	LENGTH OVERALL A	LENGTH OF THREAD B	LENGTH OF SQUARE C	DIA. OF SHANK D	SIZE OF SQUARE E
1/16	2 1/8	11/16	3/8	.3125	.234
1/8	2 1/8	3/4	3/8	.3125	.234
1/8	2 1/8	3/4	3/8	.4375	.328
1/4	2 7/16	1 1/16	7/16	.5625	.421
3/8	2 9/16	1 1/16	1/2	.7000	.531
1/2	3 1/8	1 3/8	5/8	.6875	.515
3/4	3 1/4	1 3/8	11/16	.9063	.679
1	3 3/4	1 3/4	13/16	1.1250	.843
1 1/4	4	1 3/4	15/16	1.3125	.984
1 1/2	4 1/4	1 3/4	1	1.5000	1.125
2	4 1/2	1 3/4	1 1/8	1.8750	1.406
2 1/2	5 1/2	2 9/16	1 1/4	2.2500	1.687
3	6	2 5/8	1 3/8	2.6250	1.968
3 1/2	6 1/2	2 11/16	1 1/2	2.8125	2.108
4	6 3/4	2 3/4	1 5/8	3.0000	2.250

Tolerances

ELEMENT	RANGE	DIRECTION	TOLERANCE
Length Overall — A	1/16″ to 3/4″ incl.	Plus or Minus	1/32″
	1″ to 4″ incl.	Plus or Minus	1/16″
Length of Thread — B	1/16″ to 3/4″ incl.	Plus or Minus	1/16″
	1″ to 1 1/4″ incl.	Plus or Minus	3/32″
	1 1/2″ to 4″ incl.	Plus or Minus	1/8″
Length of Square — C	1/16″ to 3/4″ incl.	Plus or Minus	1/32″
	1″ to 4″ incl.	Plus or Minus	1/16″
Diameter of Shank — D	1/16″ to 1/8″ incl.	Minus	.0015″
	1/4″ to 1/2″ incl.	Minus	.0020″
	3/4″ to 1″ incl.	Minus	.0020″
	1 1/4″ to 4″ incl.	Minus	.0030″
Size of Square — E	1/16″ to 1/8″ incl.	Minus	.0040″
	1/4″ to 3/4″ incl.	Minus	.0060″
	1″ to 4″ incl.	Minus	.0080″

USEFUL FORMULAS		
Surface Feet Per Minute = SFM Revolutions Per Minute = RPM Threads Per Inch = TPI Pitch = P Inches Per Minute = IPM	When TPI is known **P = 1 ÷ TPI**	When SFM and DIA are known: **RPM = 3.82 x SFM ÷ DIA** When RPM and P are known: **IPM = RPM x P**