

# Straight Flute

## Hand Taps

### Ground Thread — High Speed Steel

**Straight Flute** hand taps are used for hand tapping and machine tapping in through holes or blind holes in a wide variety of materials.

Available in sets, taper (8-10 thread chamfer), plug (3-5 thread chamfer) or bottoming (1-2 thread chamfer).

Taraud à main

Machuelo de roscar manual



### List No. 2068 — Machine Screw

**STANDARD PACKAGE** All sizes — 12 each  
Sets (Taper Plug Bottom)

Bold type indicates standard H limit.

Tool Coating Also Available

SIZE	TPI		NO. OF FLUTES	PITCH DIA. LIMIT	THREAD LENGTH	OAL	EDP NO.			
	UNC	UNF					SETS	TAPER	PLUG	BOTTOM
0	—	80	2	H1	5/16	1 5/8	<b>33901</b>	<b>33601</b>	<b>33701</b>	<b>33801</b>
	—	80	2	<b>H2</b>	5/16	1 5/8	—	—	<b>33702</b>	<b>33802</b>
1	64	—	2	H1	3/8	1 11/16	<b>33902</b>	<b>33602</b>	<b>33703</b>	<b>33803</b>
	64	—	2	<b>H2</b>	3/8	1 11/16	—	—	<b>33704</b>	—
	—	72	2	H1	3/8	1 11/16	<b>33903</b>	<b>33603</b>	<b>33705</b>	<b>33804</b>
	—	72	2	<b>H2</b>	3/8	1 11/16	—	—	<b>33706</b>	<b>33805</b>
2	56	—	3	H1	7/16	1 3/4	<b>33904</b>	<b>33604</b>	<b>33707</b>	<b>33806</b>
	56	—	3	<b>H2</b>	7/16	1 3/4	—	<b>33605</b>	<b>33708</b>	<b>33807</b>
	—	64	3	<b>H2</b>	7/16	1 3/4	<b>33905</b>	<b>33606</b>	<b>33710</b>	<b>33809</b>
3	48	—	3	H1	1/2	1 13/16	—	—	<b>33711</b>	—
	48	—	3	<b>H2</b>	1/2	1 13/16	<b>33906</b>	<b>33607</b>	<b>33712</b>	<b>33810</b>
	—	56	3	<b>H2</b>	1/2	1 13/16	<b>33907</b>	<b>33608</b>	<b>33714</b>	<b>33812</b>
4	40	—	3	<b>H2</b>	9/16	1 7/8	<b>33909</b>	<b>33610</b>	<b>33716</b>	<b>33814</b>
	—	48	3	<b>H2</b>	9/16	1 7/8	<b>33910</b>	<b>33611</b>	<b>33719</b>	<b>33816</b>
	—	*36	3	<b>H2</b>	9/16	1 7/8	<b>33911</b>	<b>33612</b>	<b>33720</b>	<b>33817</b>
5	40	—	3	H1	5/8	1 15/16	—	—	<b>33721</b>	—
	40	—	3	<b>H2</b>	5/8	1 15/16	<b>33912</b>	<b>33613</b>	<b>33722</b>	<b>33818</b>
	—	44	3	<b>H2</b>	5/8	1 15/16	<b>33913</b>	<b>33614</b>	<b>33724</b>	<b>33820</b>
6	32	—	3	H1	1 1/16	2	<b>33914</b>	<b>33615</b>	<b>33726</b>	<b>33821</b>
	32	—	3	H2	1 1/16	2	<b>33915</b>	<b>33616</b>	<b>33727</b>	<b>33822</b>
	32	—	3	<b>H3</b>	1 1/16	2	<b>33916</b>	<b>33617</b>	<b>33728</b>	<b>33823</b>
	—	40	3	H1	1 1/16	2	—	—	<b>33731</b>	—
	—	40	3	<b>H2</b>	1 1/16	2	<b>33917</b>	<b>33618</b>	<b>33732</b>	<b>33826</b>
8	32	—	4	H1	3/4	2 1/8	<b>33918</b>	<b>33619</b>	<b>33734</b>	<b>33827</b>
	32	—	4	H2	3/4	2 1/8	<b>33919</b>	<b>33620</b>	<b>33735</b>	<b>33828</b>
	32	—	4	<b>H3</b>	3/4	2 1/8	<b>33920</b>	<b>33621</b>	<b>33736</b>	<b>33829</b>
	—	36	4	<b>H2</b>	3/4	2 1/8	<b>33921</b>	<b>33622</b>	<b>33742</b>	<b>33835</b>
10	24	—	4	H1	7/8	2 3/8	<b>33922</b>	<b>33623</b>	<b>33743</b>	<b>33836</b>
	24	—	4	H2	7/8	2 3/8	<b>33923</b>	<b>33624</b>	<b>33744</b>	<b>33837</b>
	24	—	4	<b>H3</b>	7/8	2 3/8	<b>33924</b>	<b>33625</b>	<b>33745</b>	<b>33838</b>
	—	32	4	H1	7/8	2 3/8	<b>33925</b>	<b>33626</b>	<b>33751</b>	<b>33842</b>
	—	32	4	H2	7/8	2 3/8	<b>33926</b>	<b>33627</b>	<b>33752</b>	<b>33843</b>
	—	32	4	<b>H3</b>	7/8	2 3/8	<b>33927</b>	<b>33628</b>	<b>33753</b>	<b>33844</b>
12	24	—	4	<b>H3</b>	1 5/16	2 3/8	<b>33928</b>	<b>33629</b>	<b>33758</b>	<b>33849</b>
	—	28	4	<b>H3</b>	1 5/16	2 3/8	<b>33929</b>	<b>33630</b>	<b>33759</b>	<b>33850</b>

\*UNS

# Optional Flutes Straight Flute Hand Taps

Taraud à main

Machuelo de roscar manual



## Ground Thread — High Speed Steel

**Straight Flute** hand taps are used for hand tapping and machine tapping in through holes or blind holes in a wide variety of materials.

**Optional Flutes** taps feature fewer flutes than standard taps for added chip capacity in deeper hole tapping.

## List No. 2068 — Machine Screw

**STANDARD PACKAGE** All sizes — 12 each

Available in plug (3-5 thread chamfer), or bottoming (1-2 thread chamfer).

Bold type indicates standard H limit.

SIZE	UNC	TPI		NO. OF FLUTES	PITCH DIA. LIMIT	THREAD LENGTH	OAL	EDP NUMBER	
		UNC	UNF					PLUG	BOTTOM
2	56	—	—	2	<b>H2</b>	7/16	1 3/4	<b>33709</b>	<b>33808</b>
4	40	—	—	2	<b>H2</b>	9/16	1 7/8	<b>33717</b>	<b>33815</b>
5	40	—	—	2	<b>H2</b>	5/8	1 15/16	<b>33723</b>	<b>33819</b>
6	32	—	—	2	H2	1 1/16	2	<b>33729</b>	<b>33824</b>
	32	—	—	2	<b>H3</b>	1 1/16	2	<b>33730</b>	<b>33825</b>
	—	40	—	2	<b>H2</b>	1 1/16	2	<b>33733</b>	—
8	32	—	—	2	H2	3/4	2 1/8	<b>33740</b>	<b>33833</b>
	32	—	—	2	<b>H3</b>	3/4	2 1/8	<b>33741</b>	<b>33834</b>
	32	—	—	3	H2	3/4	2 1/8	<b>33738</b>	—
	32	—	—	3	<b>H3</b>	3/4	2 1/8	<b>33739</b>	<b>33832</b>
10	24	—	—	2	H2	7/8	2 3/8	<b>33749</b>	<b>33840</b>
	24	—	—	2	<b>H3</b>	7/8	2 3/8	<b>33750</b>	<b>33841</b>
	24	—	—	3	H2	7/8	2 3/8	<b>33747</b>	—
	24	—	—	3	<b>H3</b>	7/8	2 3/8	<b>33748</b>	<b>33839</b>
	—	32	—	2	H2	7/8	2 3/8	<b>33756</b>	<b>33847</b>
	—	32	—	2	<b>H3</b>	7/8	2 3/8	<b>33757</b>	<b>33848</b>
	—	32	—	3	H2	7/8	2 3/8	<b>33754</b>	<b>33845</b>
	—	32	—	3	<b>H3</b>	7/8	2 3/8	<b>33755</b>	<b>33846</b>

# Surface Treated Straight Flute Hand Taps

Taraud à main

Machuelo de roscar manual



## Ground Thread — High Speed Steel

**Straight Flute** hand taps are used for hand tapping and machine tapping in through holes or blind holes in a wide variety of materials.

**Steam Oxide Surface Treatment** increases wear resistance, reduces friction, acts as a lubricant, reduces galling and chip welding, improves chip flow and increases tap lubricant retention. **NOT RECOMMENDED FOR NON-FERROUS MATERIALS.**

## List No. 2068X Machine Screw Steam Oxide Treated

**STANDARD PACKAGE** All sizes — 12 each

Available in plug (3-5 thread chamfer), or bottoming (1-2 thread chamfer)

SIZE	UNC	TPI		NO. OF FLUTES	PITCH DIA. LIMIT	THREAD LENGTH	OAL	EDP NUMBER	
		UNC	UNF					PLUG	BOTTOM
6	32	—	—	3	H3	1 1/16	2	<b>32558</b>	<b>32573</b>
	—	40	—	3	H2	1 1/16	2	<b>32559</b>	<b>32574</b>
8	32	—	—	4	H3	3/4	2 1/8	<b>32560</b>	<b>32575</b>
	—	36	—	4	H2	3/4	2 1/8	<b>32561</b>	<b>32576</b>
10	24	—	—	4	H3	7/8	2 3/8	<b>32562</b>	<b>32577</b>
	—	32	—	4	H3	7/8	2 3/8	<b>32563</b>	<b>32578</b>

# Titanium Nitride (TiN) Coated Straight Flute Hand Taps

Taraud à main

Machuelo de roscar manual



## Ground Thread — High Speed Steel

**Straight Flute** hand taps are used for hand tapping and machine tapping in through holes or blind holes in a wide variety of materials.

**Titanium Nitride (TiN) Coating** results in an extremely hard surface with high lubricity for increased tool life, improved thread quality, reduced torque and increased tapping speeds for greater productivity.

## List No. 2068G — Machine Screw

**STANDARD PACKAGE** All sizes — 12 each

Available in plug (3-5 thread chamfer), or bottoming (1-2 thread chamfer).

SIZE	TPI		NO. OF FLUTES	PITCH DIA. LIMIT	THREAD LENGTH	OAL	EDP NUMBER	
	UNC	UNF					PLUG	BOTTOM.
0	—	80	2	H1	5/16	1 5/8	92460	92480
1	64	—	2	H1	3/8	1 11/16	92461	92481
	—	72	2	H1	3/8	1 11/16	92462	92482
2	56	—	3	H2	7/16	1 3/4	92463	92483
	—	64	3	H2	7/16	1 3/4	92464	92484
3	48	—	3	H2	1/2	1 13/16	92465	92485
	—	56	3	H2	1/2	1 13/16	92466	92486
4	40	—	3	H2	9/16	1 7/8	92467	92487
	—	48	3	H2	9/16	1 7/8	92468	92488
	—	36*	3	H2	9/16	1 7/8	92469	92489
5	40	—	3	H2	5/8	1 15/16	92470	92490
	—	44	3	H2	5/8	1 15/16	92471	92491
6	32	—	3	H3	11/16	2	92472	92492
	—	40	3	H2	11/16	2	92473	92493
8	32	—	4	H3	3/4	2 1/8	92474	92494
	—	36	4	H2	3/4	2 1/8	92475	92495
10	24	—	4	H3	7/8	2 3/8	92476	92496
	—	32	4	H3	7/8	2 3/8	92477	92497
12	24	—	4	H3	15/16	2 3/8	92478	92498
	—	28	4	H3	15/16	2 3/8	92479	92499

\*UNS

## SPECIAL TAPS FAST QUOTE SERVICE

Call Morse Cutting Tools for all of your special tap needs.  
To expedite your quote please provide the following information:

TAP SIZE \_\_\_\_\_ CLASS of FIT or H LIMIT \_\_\_\_\_ # of FLUTES \_\_\_\_\_

TYPE of TAP \_\_\_\_\_ SURFACE TREATMENT \_\_\_\_\_

MATERIAL to be THREADED \_\_\_\_\_ HARDNESS \_\_\_\_\_

BLIND or THROUGH HOLE \_\_\_\_\_ LENGTH of THREAD \_\_\_\_\_

# of HOLES to TAP \_\_\_\_\_ TAPPING EQUIPMENT USED \_\_\_\_\_

CURRENT TAP USED \_\_\_\_\_ TAPPING PROBLEM \_\_\_\_\_

# Straight Flute Hand Taps

## Ground Thread — High Speed Steel

**Straight Flute** hand taps are used for hand tapping and machine tapping in through holes or blind holes in a wide variety of materials.

Available in sets or taper (8-10 thread chamfer), plug (3-5 thread chamfer), or bottoming (1-2 thread chamfer)

**Tool Coatings Also Available**

Taraud à main

Machuelo de roscar manual



### List No. 2046 Fractional

**STANDARD PACKAGE** 1/4" thru 1/2" — 12 each  
 9/16" thru 3/4" — 3 each  
 7/8" thru 1 1/2" — 1 each  
 Sets (Taper Plug Bottom)

Bold type indicates standard H limit.

SIZE	TPI		NO. OF FLUTES	PITCH DIA. LIMIT	THREAD LENGTH	OAL	EDP NUMBER			
	UNC	UNF					SETS EDP NO.	TAPER	PLUG	BOTTOM
1/4	20	—	4	H1	1	2 1/2	—	<b>32301</b>	<b>32402</b>	<b>32601</b>
	20	—	4	H2	1	2 1/2	—	<b>32302</b>	<b>32404</b>	<b>32602</b>
	20	—	4	<b>H3</b>	1	2 1/2	<b>32701</b>	<b>32303</b>	<b>32407</b>	<b>32605</b>
	20	—	4	H5	1	2 1/2	—	—	<b>32409</b>	—
	—	28	4	H1	1	2 1/2	—	—	<b>32410</b>	<b>32607</b>
	—	28	4	H2	1	2 1/2	—	—	<b>32411</b>	<b>32608</b>
	—	28	4	<b>H3</b>	1	2 1/2	<b>32702</b>	<b>32304</b>	<b>32414</b>	<b>32611</b>
	—	28	4	H4	1	2 1/2	—	—	<b>32415</b>	<b>32612</b>
5/16	18	—	4	H2	1 1/8	2 23/32	—	—	<b>32418</b>	<b>32614</b>
	18	—	4	<b>H3</b>	1 1/8	2 23/32	<b>32703</b>	<b>32305</b>	<b>32421</b>	<b>32617</b>
	18	—	4	H5	1 1/8	2 23/32	—	—	<b>32422</b>	<b>32618</b>
	—	24	4	H2	1 1/8	2 23/32	—	—	<b>32424</b>	—
	—	24	4	<b>H3</b>	1 1/8	2 23/32	<b>32704</b>	<b>32306</b>	<b>32426</b>	<b>32621</b>
	—	24	4	H4	1 1/8	2 23/32	—	—	<b>32427</b>	<b>32622*</b>
3/8	16	—	4	H1	1 1/4	2 15/16	—	—	<b>32429</b>	—
	16	—	4	H2	1 1/4	2 15/16	—	—	<b>32430</b>	<b>32624</b>
	16	—	4	<b>H3</b>	1 1/4	2 15/16	<b>32705</b>	<b>32307</b>	<b>32432</b>	<b>32626</b>
	16	—	4	H5	1 1/4	2 15/16	—	—	<b>32434</b>	<b>32627</b>
	—	24	4	H1	1 1/4	2 15/16	—	—	<b>32435</b>	—
	—	24	4	H2	1 1/4	2 15/16	—	—	<b>32436</b>	<b>32629</b>
	—	24	4	<b>H3</b>	1 1/4	2 15/16	<b>32706</b>	<b>32308</b>	<b>32438</b>	<b>32631</b>
	—	24	4	H4	1 1/4	2 15/16	—	—	<b>32439</b>	—
7/16	14	—	4	<b>H3</b>	1 7/16	3 5/32	<b>32707</b>	<b>32309</b>	<b>32441</b>	<b>32633</b>
	14	—	4	H5	1 7/16	3 5/32	—	—	<b>32442</b>	<b>32634</b>
	—	20	4	<b>H3</b>	1 7/16	3 5/32	<b>32708</b>	<b>32310</b>	<b>32444</b>	<b>32635</b>
	—	20	4	H5	1 7/16	3 5/32	—	—	<b>32445</b>	<b>32636</b>
1/2	13	—	4	H1	1 21/32	3 3/8	—	—	<b>32446</b>	—
	13	—	4	<b>H3</b>	1 21/32	3 3/8	<b>32709</b>	<b>32311</b>	<b>32449</b>	<b>32640</b>
	13	—	4	H5	1 21/32	3 3/8	—	—	<b>32450</b>	<b>32641</b>
	—	20	4	H1	1 21/32	3 3/8	—	—	<b>32451</b>	<b>32642</b>
	—	20	4	<b>H3</b>	1 21/32	3 3/8	<b>32710</b>	<b>32312</b>	<b>32453</b>	<b>32643</b>
	—	20	4	H5	1 21/32	3 3/8	—	—	<b>32454</b>	—
9/16	12	—	4	<b>H3</b>	1 21/32	3 19/32	<b>32711</b>	<b>32313</b>	<b>32455</b>	<b>32644</b>
	12	—	4	H5	1 21/32	3 19/32	—	—	<b>32456</b>	—
	—	18	4	H2	1 21/32	3 19/32	—	—	<b>32457</b>	—
	—	18	4	<b>H3</b>	1 21/32	3 19/32	<b>32712</b>	<b>32314</b>	<b>32458</b>	<b>32645</b>
	—	18	4	H5	1 21/32	3 19/32	—	—	<b>32459</b>	—
5/8	11	—	4	H2	1 13/16	3 13/16	—	—	<b>32460</b>	—
	11	—	4	<b>H3</b>	1 13/16	3 13/16	<b>32713</b>	<b>32315</b>	<b>32461</b>	<b>32647</b>
	11	—	4	H5	1 13/16	3 13/16	—	—	<b>32462</b>	<b>32648</b>
	—	18	4	H2	1 13/16	3 13/16	—	—	<b>32463</b>	—
	—	18	4	<b>H3</b>	1 13/16	3 13/16	<b>32714</b>	<b>32316</b>	<b>32464</b>	<b>32649</b>
	—	18	4	H5	1 13/16	3 13/16	—	—	<b>32465</b>	<b>32650</b>

\*Available While Supplies Last

(continued)

# Straight Flute Hand Taps (continued)

List No. 2046 Fractional

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SIZE	UNC	TPI		NO. OF FLUTES	PITCH DIA. LIMIT	THREAD LENGTH	OAL	EDP NUMBER			
		UNF	UNS					SETS EDP NO.	TAPER	PLUG	BOTTOM
1 <sup>1</sup> / <sub>16</sub>	—	—	11	4	H3	1 <sup>13</sup> / <sub>16</sub>	4 <sup>1</sup> / <sub>32</sub>	32715	32317	32466	32651
	—	—	16	4	H3	1 <sup>13</sup> / <sub>16</sub>	4 <sup>1</sup> / <sub>32</sub>	32716	32318	32467	32652
3 <sup>4</sup> / <sub>4</sub>	10	—	—	4	H3	2	4 <sup>1</sup> / <sub>4</sub>	32717	32319	32469	32653
	10	—	—	4	H5	2	4 <sup>1</sup> / <sub>4</sub>	—	—	32470	32654
	—	16	—	4	H1	2	4 <sup>1</sup> / <sub>4</sub>	—	—	32471	—
	—	16	—	4	H2	2	4 <sup>1</sup> / <sub>4</sub>	—	—	32472	—
	—	16	—	4	H3	2	4 <sup>1</sup> / <sub>4</sub>	32718	32320	32473	32655
	—	16	—	4	H5	2	4 <sup>1</sup> / <sub>4</sub>	—	—	32474	32656
7 <sup>6</sup> / <sub>8</sub>	9	—	—	4	H4	2 <sup>7</sup> / <sub>32</sub>	4 <sup>1</sup> / <sub>16</sub>	32719	32321	32475	32657
	9	—	—	4	H6	2 <sup>7</sup> / <sub>32</sub>	4 <sup>1</sup> / <sub>16</sub>	—	—	32476	—
	—	14	—	4	H2	2 <sup>7</sup> / <sub>32</sub>	4 <sup>1</sup> / <sub>16</sub>	—	—	32477	—
	—	14	—	4	H4	2 <sup>7</sup> / <sub>32</sub>	4 <sup>1</sup> / <sub>16</sub>	32720	32322	32478	32658
1	8	—	—	4	H4	2 <sup>1</sup> / <sub>2</sub>	5 <sup>1</sup> / <sub>8</sub>	32721	32323	32480	32659
	8	—	—	4	H6	2 <sup>1</sup> / <sub>2</sub>	5 <sup>1</sup> / <sub>8</sub>	—	—	32481	—
	—	12	—	4	H4	2 <sup>1</sup> / <sub>2</sub>	5 <sup>1</sup> / <sub>8</sub>	32722	32324	32482	32660
	—	—	14	4	H4	2 <sup>1</sup> / <sub>2</sub>	5 <sup>1</sup> / <sub>8</sub>	32723	32325	32484	32661
1 <sup>1</sup> / <sub>8</sub>	7	—	—	4	H4	2 <sup>9</sup> / <sub>16</sub>	5 <sup>7</sup> / <sub>16</sub>	32724	32326	32485	32662
	—	12	—	4	H4	2 <sup>9</sup> / <sub>16</sub>	5 <sup>7</sup> / <sub>16</sub>	32725	32327	32486	32663
1 <sup>1</sup> / <sub>4</sub>	7	—	—	4	H4	2 <sup>9</sup> / <sub>16</sub>	5 <sup>3</sup> / <sub>4</sub>	32726	32328	32487	32664
	—	12	—	6	H4	2 <sup>9</sup> / <sub>16</sub>	5 <sup>3</sup> / <sub>4</sub>	32727	32329	32488	32665
1 <sup>3</sup> / <sub>8</sub>	6	—	—	4	H4	3	6 <sup>1</sup> / <sub>16</sub>	32728	32330	32489	32666
	—	12	—	6	H4	3	6 <sup>1</sup> / <sub>16</sub>	32729	32331	32490	32667
1 <sup>1</sup> / <sub>2</sub>	6	—	—	4	H4	3	6 <sup>3</sup> / <sub>8</sub>	32730	32332	32491	32668
	—	12	—	6	H4	3	6 <sup>3</sup> / <sub>8</sub>	32731	32333	32492	32669

## Optional Flutes Straight Flute Hand Taps

**Straight Flute** hand taps are used for hand tapping and machine tapping in through holes or blind holes in a wide variety of materials.

**Optional Flutes** taps feature fewer flutes than standard taps for added chip capacity in deeper hole tapping.

Taraud à main

Machuelo de roscar manual



List No. 2046 — Fractional

STANDARD PACKAGE All sizes — 12 each

Ground Thread—High Speed Steel

SIZE	UNC	TPI		NO. OF FLUTES	PITCH DIA. LIMIT	THREAD LENGTH	OAL	EDP NUMBER	
		UNF	UNS					PLUG	BOTTOM
1 <sup>4</sup> / <sub>4</sub>	20	—	—	2	H3	1	2 <sup>1</sup> / <sub>2</sub>	32405	32603
	20	—	—	3	H3	1	2 <sup>1</sup> / <sub>2</sub>	32406	32604
	20	—	—	3	H5	1	2 <sup>1</sup> / <sub>2</sub>	32408	32606
	—	28	—	2	H3	1	2 <sup>1</sup> / <sub>2</sub>	32412	32609
	—	28	—	3	H3	1	2 <sup>1</sup> / <sub>2</sub>	32413	32610
5 <sup>6</sup> / <sub>16</sub>	18	—	—	2	H3	1 <sup>1</sup> / <sub>8</sub>	2 <sup>23</sup> / <sub>32</sub>	—	32615
	18	—	—	3	H3	1 <sup>1</sup> / <sub>8</sub>	2 <sup>23</sup> / <sub>32</sub>	32420	32616
	—	24	—	3	H3	1 <sup>1</sup> / <sub>8</sub>	2 <sup>23</sup> / <sub>32</sub>	32425	32620
3 <sup>6</sup> / <sub>8</sub>	16	—	—	3	H3	1 <sup>1</sup> / <sub>4</sub>	2 <sup>15</sup> / <sub>16</sub>	32431	32625
	—	24	—	3	H3	1 <sup>1</sup> / <sub>4</sub>	2 <sup>15</sup> / <sub>16</sub>	32437	32630
7 <sup>6</sup> / <sub>16</sub>	14	—	—	3	H3	1 <sup>7</sup> / <sub>16</sub>	3 <sup>5</sup> / <sub>32</sub>	32440	—
	—	20	—	3	H3	1 <sup>7</sup> / <sub>16</sub>	3 <sup>5</sup> / <sub>32</sub>	32443	—
1 <sup>2</sup> / <sub>2</sub>	13	—	—	3	H3	1 <sup>21</sup> / <sub>32</sub>	3 <sup>3</sup> / <sub>8</sub>	32448	32639
	—	20	—	3	H3	1 <sup>21</sup> / <sub>32</sub>	3 <sup>3</sup> / <sub>8</sub>	32452	—

# Titanium Nitride (TiN) Coated Straight Flute Hand Taps

**Straight Flute** hand taps are used for hand tapping and machine tapping in through holes or blind holes in a wide variety of materials.

**Titanium Nitride (TiN) Coating** results in an extremely hard surface with high lubricity for increased tool life, improved thread quality, reduced torque and increased tapping speeds for greater productivity.

SIZE	PITCH DIA. LIMIT	THREAD LENGTH	OAL	NO. OF FLUTES	EDP NO.	
					PLUG	BOTTOM
1/4 - 20	H3	1	2 1/2	4	92400	92430
1/4 - 28	H3	1	2 1/2	4	92401	92431
5/16 - 18	H3	1 1/8	2 23/32	4	92402	92432
5/16 - 24	H3	1 1/8	2 23/32	4	92403	92433
3/8 - 16	H3	1 1/4	2 15/16	4	92404	92434
3/8 - 24	H3	1 1/4	2 15/16	4	92405	92435
7/16 - 14	H3	1 7/16	3 5/32	4	92406	92436
7/16 - 20	H3	1 7/16	3 5/32	4	92407	92437
1/2 - 13	H3	1 21/32	3 3/8	4	92408	92438
1/2 - 20	H3	1 21/32	3 3/8	4	92409	92439
9/16 - 12	H3	1 21/32	3 19/32	4	92410	92440
9/16 - 18	H3	1 21/32	3 19/32	4	92411	92441
5/8 - 11	H3	1 13/16	3 13/16	4	92412	92442
5/8 - 18	H3	1 13/16	3 13/16	4	92413	92443
1 1/16 - 11	H3	2	4 1/4	4	92414	92444
1 1/16 - 16	H3	2	4 1/4	4	92415	92445
3/4 - 10	H3	2	4 1/4	4	92416	92446
3/4 - 16	H3	2	4 1/4	4	92417	92447
7/8 - 9	H4	2 7/32	4 11/16	4	92418	92448
7/8 - 14	H4	2 7/32	4 11/16	4	92419	92449
1 - 8	H4	2 1/2	5 1/8	4	92420	92450
1 - 14	H4	2 1/2	5 1/8	4	92421	92451

Taraud à main

Machuelo de roscar manual



## List No. 2046G Fractional

**STANDARD** 1/4 - 1/2 — 12 each  
**PACKAGE** 9/16 - 3/4 — 3 each  
 7/8 - 1 — 1 each

**Ground Thread - High Speed Steel**

# +.005" Oversize Straight Flute Hand Taps

**Straight Flute** hand taps are used for hand tapping and machine tapping in through holes or blind holes in a wide variety of materials.

**+.005" Oversize (H11)** taps are mainly used for parts that will be plated or heat treated after tapping. Also used in materials that tend to shrink after tapping.

Taraud surdimensionné

Machuelo de roscar extra grande



## List No. 2014 Machine Screw & Fractional

**STANDARD** Machine screw sizes: 12 each  
**PACKAGE** Fractional sizes: 1/4" thru 1/2" — 12 each  
 5/8" — 3 each

**Ground Thread — High Speed Steel — Plug Style**

PITCH DIA. LIMIT	AMOUNT LARGER THAN BASIC PITCH DIA.
H11	.0050"-.0055"

## List No. 2014 Machine Screw

SIZE	TPI		PITCH DIA. LIMIT	THREAD LENGTH	OAL	NO. OF FLUTES	EDP NO. PLUG
	UNC	UNF					
6	32	—	H11	1 1/16	2	3	34222
8	32	—	H11	3/4	2 1/8	4	34223
10	24	—	H11	7/8	2 3/8	4	34225
10	—	32	H11	7/8	2 3/8	4	34226

## List No. 2014 Fractional

SIZE	TPI		PITCH DIA. LIMIT	THREAD LENGTH	OAL	NO. OF FLUTES	EDP NO. PLUG
	UNC	UNF					
1/4	20	—	H11	1	2 1/2	4	34301
5/16	18	—	H11	1 1/8	2 23/32	4	34303
3/8	16	—	H11	1 1/4	2 15/16	4	34305
1/2	13	—	H11	1 21/32	3 3/8	4	34309
5/8	11	—	H11	1 13/16	3 13/16	4	34313

# Eight Pitch Straight Flute Hand Taps

## Ground Thread — High Speed Steel

**Straight Flute** hand taps are used for hand tapping and machine tapping in through holes or blind holes in a wide variety of materials.

**Eight Pitch** taps are often required for applications in the power generation industry and general construction.

SIZE	TPI	NO. OF FLUTES	PITCH DIA. LIMIT	THREAD LENGTH	OAL	EDP NO.		
						TAPER	PLUG	BOTTOM
1	8	4	H4	2½	5⅞	32323	32480	32659
1⅛	8	4	H5	2⅞	5⅞	32334	32508	32501
1¼	8	4	H5	2⅞	5¾	32336	32509	32502
1⅜	8	4	H5	3	6⅞	32338	32510	32503
1½	8	6	H5	3	6⅞	32340	32511	32504
1⅝	8	6	H6	3⅞	6⅞	—	32512	32505
1¾	8	6	H6	3⅞	7	32344	32513	32506
1⅞	8	6	H6	3⅞	7⅞	—	32514	32507
2	8	6	H6	3⅞	7⅞	32348	32515	32516
2⅛	8	6	H6	3⅞	8	34919	34925	34933
2¼	8	6	H6	3⅞	8¼	34920	34926	34934
2⅜	8	6	H6	4	8½	34921	34927	34935
2½	8	6	H6	4	8¾	34922	34928	34936
2⅝	8	6	H8	4	8¾	—	34929	34937
2¾	8	6	H8	4	9¼	34923	34930	34938
2⅞	8	6	H8	4	9¼	—	34931	34939
3	8	6	H8	4⅞	9¾	34924	34932	34940

Taraud à main

Machuelo de roscar manual



### List No. 2046 Fractional

**STANDARD PACKAGE** All sizes — 1 each

Available in taper (8-10 thread chamfer), plug (3-5 thread chamfer), or bottoming (1-2 thread chamfer)

# Surface Treated Straight Flute Hand Taps

## Ground Thread — High Speed Steel

**Straight Flute** hand taps are used for hand tapping and machine tapping in through holes or blind holes in a wide variety of materials.

**Steam Oxide Surface Treatment** increases wear resistance, reduces friction, acts as a lubricant, reduces galling and chip welding, improves chip flow and increases tap lubricant retention. **NOT RECOMMENDED FOR NON-FERROUS MATERIALS.**

SIZE	TPI		NO. OF FLUTES	PITCH DIA. LIMIT	THREAD LENGTH	OAL	EDP NO.	
	UNC	UNF					PLUG	BOTTOMING
¼	20	—	4	H3	1	2½	32520	32535
	—	28	4	H3	1	2½	32521	32536
⅕	18	—	4	H3	1⅛	2 <sup>23</sup> / <sub>32</sub>	32522	32537
	—	24	4	H3	1⅛	2 <sup>23</sup> / <sub>32</sub>	32523	32538
⅜	16	—	4	H3	1¼	2 <sup>15</sup> / <sub>16</sub>	32524	32539
	—	24	4	H3	1¼	2 <sup>15</sup> / <sub>16</sub>	32525	32540
½	13	—	4	H3	1 <sup>21</sup> / <sub>32</sub>	3⅞	32526	32541
	—	20	4	H3	1 <sup>21</sup> / <sub>32</sub>	3⅞	32527	32542
⅝	12	—	4	H3	1 <sup>21</sup> / <sub>32</sub>	3 <sup>19</sup> / <sub>32</sub>	32532	32547
	—	18	4	H3	1 <sup>21</sup> / <sub>32</sub>	3 <sup>19</sup> / <sub>32</sub>	32533	32548
⅞	11	—	4	H3	1 <sup>13</sup> / <sub>16</sub>	3 <sup>13</sup> / <sub>16</sub>	32528	32543
	—	18	4	H3	1 <sup>13</sup> / <sub>16</sub>	3 <sup>13</sup> / <sub>16</sub>	32529	32544
¾	10	—	4	H3	2	4¼	32530	32545
	—	16	4	H3	2	4¼	32531	32546

Taraud à main

Machuelo de roscar manual



### List No. 2046X — Fractional Steam Oxide Treated

**STANDARD PACKAGE** 1/4" thru 1/2" — 12 each  
5/8" thru 3/4" — 3 each

Available in plug (3-5 thread chamfer), or bottoming (1-2 thread chamfer)

# Straight Flute Hand Taps For Cast Iron

Taraud à main

Machuelo de roscar manual



**Ground Thread — High Speed Steel  
Steam Oxide Over Nitride**

Taps for Cast Iron feature specific geometry and a wear resistant surface finish for tapping materials that produce small or powdery chips. Recommended for cast iron, cast brass and other brass materials and non-metals that produce small or powdery chips.

**List No. 2021 — Machine Screw & Fractional  
List No. 2021M — Metric**

**Straight Flute** hand taps are used for hand tapping and machine tapping in through holes or blind holes.

Available in plug (3-5 chamfer) and bottoming (1-2 thread chamfer)

## List No. 2021 Machine Screw & Fractional

SIZE	THREAD TYPE	PITCH DIA. LIMIT	NO. OF FLUTES	THREAD LENGTH	OAL	EDP NO. PLUG	EDP NO. BOTTOM
10-24	NC	H3	4	7/8	2-3/8	34870	34890
10-32	NF	H3	4	7/8	2-3/8	34871	34891
1/4-20	NC	H3	4	1	2-1/2	34872	34892
1/4-28	NF	H3	4	1	2-1/2	34873	34893
5/16-18	NC	H3	4	1-1/8	2-23/32	34874	34894
5/16-24	NF	H3	4	1-1/8	2-23/32	34875	34895
3/8-16	NC	H3	4	1-1/4	2-15/16	34876	34896
3/8-24	NF	H3	4	1-1/4	2-15/16	34877	34897
7/16-14	NC	H3	4	1-7/16	3-5/32	34878	34898
7/16-20	NF	H3	4	1-7/16	3-5/32	34879	34899
1/2-13	NC	H3	4	1-21/32	3-3/8	34880	34900
1/2-20	NF	H3	4	1-21/32	3-3/8	34881	34901
9/16-12	NC	H3	4	1-21/32	3-19/32	34882	34902
9/16-18	NF	H3	4	1-21/32	3-19/32	34883	34903
5/8-11	NC	H3	4	1-13/16	3-13/16	34884	34904
5/8-18	NF	H3	4	1-13/16	3-13/16	34885	34905
3/4-10	NC	H3	4	2	4-1/4	34886	34906
3/4-16	NF	H3	4	2	4-1/4	34887	34907

## List No. 2021M Metric

SIZE	PITCH	PITCH DIA. LIMIT	NO. OF FLUTES	THREAD LENGTH	OAL	EDP NO. PLUG	EDP NO. BOTTOM
M6	1	D5	4	1	2-1/2	34910	34915
M8	1.25	D5	4	1-1/8	2-23/32	34911	34916
M10	1.5	D6	4	1-1/4	2-15/16	34912	34917
M12	1.75	D6	4	1-21/32	3-3/8	34913	34918

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# Metric Straight Flute Hand Taps

## Ground Thread — High Speed Steel

**Straight Flute** hand taps are used for hand tapping and machine tapping in through holes or blind holes in a wide variety of materials.

Available in sets or taper (8-10 thread chamfer), plug (3-5 thread chamfer), or bottoming (1-2 thread chamfer).

Taraud à main

Machuelo de roscar manual



### List No. 7500

**STANDARD PACKAGE** M1.6 thru M12 — 12 each  
M14 thru M16 — 3 each  
M18 thru M39 — 1 each  
Sets (Taper, Plug, Bottom)

SIZE	PITCH DIA. LIMIT	NO. OF FLUTES	THREAD LENGTH	OAL	SETS		EDP NO.	
					EDP NO.	TAPER	PLUG	BOTTOM
M1.6 × 0.35	D3	2	5/16	1 5/8	38200	38141	38016	38116
M1.8 × 0.35	D3	2	3/8	1 11/16	38201	38142	38017	38117
M2 × 0.4	D3	3	7/16	1 3/4	38203	38143	38018	38118
M2.2 × 0.45	D3	3	7/16	1 3/4	38204	38144	38019	38119
M2.5 × 0.45	D3	3	1/2	1 13/16	38205	38145	38001	38101
M3 × 0.5	D3	3	5/8	1 15/16	38206	38146	38002	38102
M3.5 × 0.6	D4	3	1 1/16	2	38207	38147	38003	38103
M4 × 0.7	D4	4	3/4	2 1/8	38208	38148	38004	38104
M4.5 × 0.75	D4	4	7/8	2 3/8	38209	38149	38005	38105
M5 × 0.8	D4	4	7/8	2 3/8	38210	38150	38006	38106
M6 × 1	D5	4	1	2 1/2	38211	38151	38007	38107
M7 × 1	D5	4	1 1/8	2 23/32	38212	38152	38008	38108
M8 × 1	D5	4	1 1/8	2 23/32	38213	38153	38020	38120
*M8 × 1.25	D5	4	1 1/8	2 23/32	38214	38154	38009	38109
M10 × 1.25	D5	4	1 1/4	2 15/16	38215	38155	38021	38121
*M10 × 1.5	D6	4	1 1/4	2 15/16	38216	38156	38010	38110
M12 × 1.25	D5	4	1 21/32	3 3/8	38217	38157	38022	38122
*M12 × 1.75	D6	4	1 21/32	3 3/8	38218	38158	38011	38111
M14 × 1.5	D6	4	1 21/32	3 19/32	38219	38159	38023	38123
*M14 × 2	D7	4	1 21/32	3 19/32	38220	38160	38012	38112
M16 × 1.5	D6	4	1 13/16	3 13/16	38221	38161	38024	38124
*M16 × 2	D7	4	1 13/16	3 13/16	38222	38162	38013	38113
M18 × 1.5	D6	4	1 13/16	4 1/32	38223	38163	38025	38125
*M18 × 2.5	D7	4	1 13/16	4 1/32	38224	38164	38014	38114
M20 × 1.5	D6	4	2	4 15/32	38225	38165	38026	38126
*M20 × 2.5	D7	4	2	4 15/32	38226	38166	38015	38115
M22 × 1.5	D6	4	2 7/32	4 11/16	38227	38167	38027	38127
*M22 × 2.5	D7	4	2 7/32	4 11/16	38228	38168	38028	38128
M24 × 2	D7	4	2 7/32	4 29/32	38229	38169	38029	38129
*M24 × 3	D8	4	2 7/32	4 29/32	38230	38170	38030	38130
M27 × 2	D7	4	2 1/2	5 1/8	38231	38171	38031	38131
*M27 × 3	D8	4	2 1/2	5 1/8	38232	38172	38032	38132
M30 × 2	D7	4	2 9/16	5 7/16	38233	38173	38033	38133
*M30 × 3.5	D9	4	2 9/16	5 7/16	38234	38174	38034	38134
M33 × 2	D7	6	2 9/16	5 3/4	38238	38178	38038	38138
*M33 × 3.5	D9	4	2 9/16	5 3/4	—	38175**	38035	—
M36 × 3	D8	4	3	6 1/16	38236	38176	38036	38136
*M36 × 4	D9	4	3	6 1/16	38237	38177	38037	38137
M39 × 3	D8	6	3 3/16	6 11/16	38239**	38179**	—	—
*M39 × 4	D9	6	3 3/16	6 11/16	—	38180**	38040**	38140**

Pitch diameters are those recommended for 6H class of thread.

\*Designates course pitch  
\*\*Available while supplies last