

# Taper Pipe Reamers

High Speed Steel - Left Hand Helical Flute  
Right Hand Cut

3/4" Taper per foot. For reaming holes to be tapped with American Standard taper pipe taps.

Fraise à tuyau

Rima de tubería



List No. 2116

STANDARD PACKAGE All sizes — 1 each

FOR THREAD SIZE	DIAMETER LARGE END	DIAMETER SMALL END	FLUTE LENGTH	OAL	EDP NO.
1/8	.362	.316	3/4	2 1/8	36081
1/4	.472	.406	1 1/16	2 7/16	36082
3/8	.606	.540	1 1/16	2 9/16	36083
1/2	.751	.665	1 3/8	3 1/8	36084
3/4	.962	.876	1 3/8	3 1/4	36085
1	1.212	1.103	1 3/4	3 3/4	36086
1 1/4	1.553	1.444	1 3/4	4	36087
1 1/2	1.793	1.684	1 3/4	4 1/4	36088
2	2.268	2.159	1 3/4	4 1/2	36089

Tool Coatings Also Available

# Taper Pipe Taps

Ground Thread — High Speed Steel  
NPT/ANPT—NPTF

Chamfer - 2-3 1/2 threads

**Regular Thread NPT** taper pipe taps are commonly used for tapping pipe fittings and couplings in a wide variety of materials. Assembly requires the use of a thread sealant to ensure a tight seal.

**NPTF Dryseal** taper pipe taps produce threads where a tight seal is achieved during assembly by metal-to-metal contact. Used for applications requiring a tight seal without the use of thread sealants.

**Interrupted Thread** taper pipe taps reduce friction, increase chip capacity and enhance coolant flow to the cutting teeth for reduced chance of torn threads and improved thread quality. Recommended for a wide variety of materials, especially soft ductile materials and materials producing long continuous chips.

Taraud au pas du gaz

Machuelo de roscar para tuberías



List No. 2113 Interrupted Thread



List No. 2119 Regular Thread

STANDARD PACKAGE 1/16" thru 1/4" — 6 each  
3/8" thru 2" — 1 each

SIZE	THREAD LENGTH	OAL	NO. OF FLUTES.		INTERRUPTED THREAD LIST NO. 2113 EDP NO.		REGULAR THREAD LIST NO. 2119 EDP NO.	
			LIST NO. 2113	LIST NO. 2119	NPT/ANPT	NPTF	NPT/ANPT	NPTF
1/16-27	1 1/16	2 1/8	5	4	—	—	36121	36141
1/8-27* (Sm. Sk.)	3/4	2 1/8	5	4	36001	36021	36122	36142
1/8-27* (Lg. Sk.)	3/4	2 1/8	5	4	36002	36022	36123	36143
1/4-18	1 1/16	2 7/16	5	4	36003	36023	36124	36144
3/8-18	1 1/16	2 9/16	5	4	36004	36024	36125	36145
1/2-14	1 3/8	3 1/8	5	4	36005	36025	36126	36146
3/4-14	1 3/8	3 1/4	5	5	36006	36026	36127	36147
1-1 1/2	1 3/4	3 3/4	5	5	36007	36027	36128	36148
1 1/4-1 1/2	1 3/4	4	5	5	36008	—	36129	36149
1 1/2-1 1/2	1 3/4	4 1/4	7	7	36009	—	36130	36150
2-1 1/2	1 3/4	4 1/2	7	7	36010	—	36131	36151

\*Large shank furnished unless otherwise specified.

# Straight Pipe Taps

## Ground Thread — High Speed Steel

### NPS/NPSF

**NPS** straight pipe taps produce straight pipe threads for low pressure applications in a wide variety of materials. Can be assembled with taper pipe threads, straight pipe threads or fittings. Assembly requires the use of a thread sealant to ensure a tight seal.

**NPSF Dryseal** straight pipe taps produce threads where a tight seal is achieved during assembly by metal-to-metal contact when assembled with dryseal taper pipe threads. Used for applications requiring a tight seal without the use of thread sealants.

SIZE	NUMBER OF FLUTES	THREAD LENGTH	OAL	EDP NO.	
				NPS	NPSF
1/8-27* (Sm. Sk.)	4	3/4	2 1/8	36161	36181
1/8-27* (Lg. Sk.)	4	3/4	2 1/8	36162	36182
1/4-18	4	1 1/16	2 7/16	36163	36183
3/8-18	4	1 1/16	2 9/16	36164	36184
1/2-14	4	1 3/8	3 1/8	36165	36185
3/4-14	5	1 3/8	3 1/4	36166	36186
1-1 1/2	5	1 3/4	3 3/4	36167	—

\*Large shank furnished unless otherwise specified.

Taraud au pas du gaz

Machuelo de roscar para tuberías



### List No. 2123

**STANDARD** 1/8" thru 1/4" — 6 each

**PACKAGE** 3/8" thru 1" — 1 each

Furnished in Plug style chamfer only. NPS also suitable for NPSC or NPSM work.

# Taper Pipe Taps For Cast Iron

## Ground Thread — High Speed Steel

### NPT

Taper pipe 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. Assembly requires the use of a thread sealant to ensure a tight seal.

Furnished with 2-3 1/2 thread chamfer in NPT thread form 1°-3° Rake.

Taraud au pas du gaz

Machuelo de roscar para tuberías



### List No. 2133 Surface Treated

**STANDARD** 1/8" thru 1/4" — 6 each

**PACKAGE** 3/8" thru 2" — 1 each

SIZE	THREAD LENGTH	OAL	NO. OF FLUTES	NPT EDP NO.
1/8-27 (Lg. Sk.)	3/4	2 1/8	4	36202
1/4-18	1 1/16	2 7/16	4	36203
3/8-18	1 1/16	2 9/16	4	36204
1/2-14	1 3/8	3 1/8	4	36205
3/4-14	1 3/8	3 1/4	5	36206

SIZE	THREAD LENGTH	OAL	NO. OF FLUTES	NPT EDP NO.
1-1 1/2	1 3/4	3 3/4	5	36207
1 1/4-1 1/2	1 3/4	4	5	36208
1 1/2-1 1/2	1 3/4	4 1/4	7	36209
2-1 1/2	1 3/4	4 1/2	7	36210

# High Hook Taper Pipe Taps

Ground Thread — High Speed Steel  
NPT/NPTF

High Hook taper pipe taps feature specific geometry for tapping ductile materials and soft gummy materials including aluminum, mild steels, free machining stainless steels, leaded steels and other materials. **NPT** threads require the use of a thread sealant to ensure a tight seal. **NPTF** threads are used for applications requiring a tight seal without the use of thread sealants.

SIZE	THREAD LENGTH	OAL	NO. OF FLUTES	EDP NO.	
				NPT	NPTF
1/8-27 (Lg. Sk.)	3/4	2 1/8	4	36188	36194
1/4-18	1 1/16	2 7/16	4	36189	36195
3/8-18	1 1/16	2 9/16	4	36190	36196
1/2-14	1 3/8	3 1/8	4	36191	36197
3/4-14	1 3/8	3 1/4	5	36192	36198
1-1 1/2	1 3/4	3 3/4	5	36193	36199

Taraud au pas du gaz

Machuelo de roscar para tuberías



List No. 2120

Taper — 3/4" per foot  
Chamfer — 2 - 3-1/2 threads

STANDARD PACKAGE 1/8" thru 1/4" — 6 each  
3/8" thru 1" — 1 each

# Spiral Flute Taper Pipe Taps

Ground Thread — High Speed Steel  
NPT/NPTF — 30° Spiral Flute

Spiral Flute taper pipe taps are recommended for tapping stringy and ductile materials that produce long stringy chips. The **spiral flute** lifts the chips out of the hole to eliminate chip packing in the flutes. **NPT** threads require the use of a thread sealant to ensure a tight seal. **NPTF** threads are used for applications requiring a tight seal without the use of thread sealants.

Tool Coatings Also Available

SIZE	THREAD LENGTH	OAL	NO. OF FLUTES	EDP NO.	
				NPT	NPTF
1/8-27 (Lg. Sk.)	3/4	2 1/8	4	36168	36173
1/4-18	1 1/16	2 7/16	4	36169	36174
3/8-18	1 1/16	2 9/16	4	36170	36175
1/2-14	1 3/8	3 1/8	4	36171	36176
3/4-14	1 3/8	3 1/4	5	36172	36177

Taraud au pas du gaz

Machuelo de roscar para tuberías



List No. 2121

Chamfer — 2 - 3-1/2 threads

STANDARD PACKAGE 1/8" thru 1/4" — 6 each  
3/8" thru 3/4" — 1 each

# Cut Thread Taper Pipe Taps

High Speed Steel — NPT

Cut Thread taps are general purpose taps that are ideal for maintenance, repair and rethreading applications. Because they are not precision ground, they are used in applications that do not require high accuracy, close tolerance threads.

SIZE	THREAD LENGTH	OAL	NO. OF FLUTES	EDP NO.
1/8-27* (Sm.Sk.)	3/4	2 1/8	4	36061
1/8-27* (Lg.Sk.)	3/4	2 1/8	4	36062
1/4-18	1 1/16	2 7/16	4	36063
3/8-18	1 1/16	2 9/16	4	36064
1/2-14	1 3/8	3 1/8	4	36065

\*Large shank furnished unless otherwise specified.

Taraud au pas du gaz

Machuelo de roscar para tuberías



List No. 2115

STANDARD PACKAGE 1/8" thru 1/4" — 6 each  
3/8" thru 2" — 1 each

SIZE	THREAD LENGTH	OAL	NO. OF FLUTES	EDP NO.
3/4-14	1 3/8	3 1/4	5	36066
1-1 1/2	1 3/4	3 3/4	5	36067
1 1/4-1 1/2	1 3/4	4	5	36068
1 1/2-1 1/2	1 3/4	4 1/4	7	36069
2-1 1/2	1 3/4	4 1/2	7	36070