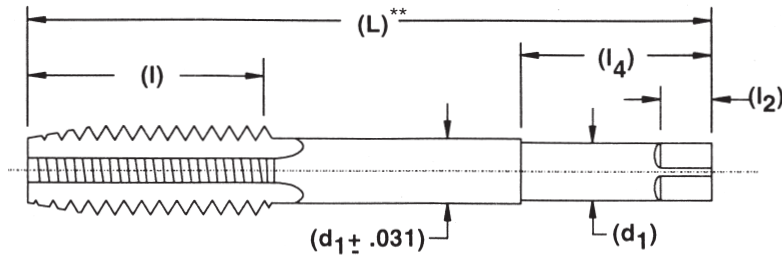


SPECIAL EXTENSION TAPS, GROUND THREAD

(Ref. USCTI Table 303-A)



Unless otherwise specified, special extension taps will be furnished with dimensions and tolerances as shown for Machine Screw and Fractional taps in Tables 302 and 303, and for Pipe taps in Table 311.

Exceptions:

1. Types of centers are optional with manufacturer.
2. Tolerances on shank diameter d_1 for l_4 length as shown in the following table.
3. Shank eccentricity tolerance in Table 317 applies only to the l_4 length shown in the following table.
4. Length of Close Tolerance Shank, (l_4) is minimum.

Nominal Tap Size		l Thread Length	d_1 Shank Diameter	l_2 Square Length	Square Size	"l ₄ " Ground Shank Length
Fractional	Machine Screw					
	6	.688	.141	.188	.110	1.13
	8	.750	.168	.250	.131	1.25
	10 - 12	.875	.194	.250	.152	1.38
1/4	14	1.00	.255	.313	.191	1.50
1/4*		1.00	.185	.250	.138	Full Length
5/16		1.13	.318	.375	.238	1.56
5/16*		1.13	.240	.281	.180	Full Length
3/8		1.25	.381	.438	.286	1.63
3/8*		1.25	.275	.375	.206	Full Length
7/16		1.44	.323	.406	.242	1.69
1/2		1.66	.367	.438	.275	1.69
9/16		1.66	.429	.500	.322	1.88
5/8		1.81	.480	.563	.360	2.00
3/4		2.00	.590	.688	.442	2.25
7/8		2.22	.697	.750	.523	2.50
1"		2.50	.800	.813	.600	2.63
1-1/8		2.56	.896	.875	.672	2.75
1-1/4		2.56	1.021	1.00	.766	2.88
1-3/8		3.00	1.108	1.063	.831	3.00
1-1/2		3.00	1.233	1.125	.925	3.00

* Denotes small shank.

** NOTE: The overall length ('L' Dimension) is determined by customer requirements. Stocked sizes are 4", 6", 8" 10" and 12" OAL depending on diameter.

Tolerances

For Shank Diameter, d_1 and l_4 length

Size Range		Direction	Tolerance
Fractional	Machine Screw		
1/4 to 5/8 incl.	0 - 14 incl.	Minus	.003
11/16 to 1-1/2 incl.		Minus	.004