



OSG
Tap & Die, Inc.

HY-PRO® PIPE TAPS

NEW!

Vol. 1

Premium Design for a Wide Range of Materials



List 12053

NPT

Tap Size	Threads Per Inch	No. Of Flutes	EDP Number	List Price (Each)
1/8 (Sm.shk)	27	3	1205300108	74.57
1/8 (Lg.shk)	27	3	1205300208	74.57
1/4	18	3	1205300308	67.77
3/8	18	4	1205300408	100.16
1/2	14	5	1205300508	127.59
3/4	14	5	1205300608	194.99
1	11-1/2	5	1205300708	335.30

Packed: 1/8" = 10 pcs; 1-4" = 5 pcs; 3/8" and up = 1 pc.
Available TiCN coating only.

List 12054

NPTF

Tap Size	Threads Per Inch	No. Of Flutes	EDP Number	List Price (Each)
1/8 (Sm.shk)	27	3	1205400108	74.57
1/8 (Lg.shk)	27	3	1205400208	74.57
1/4	18	3	1205400308	67.77
3/8	18	4	1205400408	100.16
1/2	14	5	1205400508	127.59
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Work Material

Aluminum		Cast Iron	Low Carbon Steel	Med. Carbon Steel	High Carbon Steel	Alloy Steels	Die Steels	Titanium	High Nickel Alloy	Stainless Steel			Hardened Steels		
6061 7075	Casting		1010 1018	1035 1045	1065	4140 4340	20 Hrc	6AL4V (30 Hrc)	20 Hrc	300	400	17-4PH	~35 Hrc	35-45 Hrc	45-50 Hrc
		○	○	⊙	⊙	⊙	⊙			○	○	○	○	○	

⊙ best ○ good

Feature & Benefit

HSSE Material

Increased Wear Resistance

Eccentric Relief

Reduced Cutting Torque and Heat Generation

Slow Spiral

Efficient Chip Evacuation

Interrupted Thread

Reduced Cutting Torque

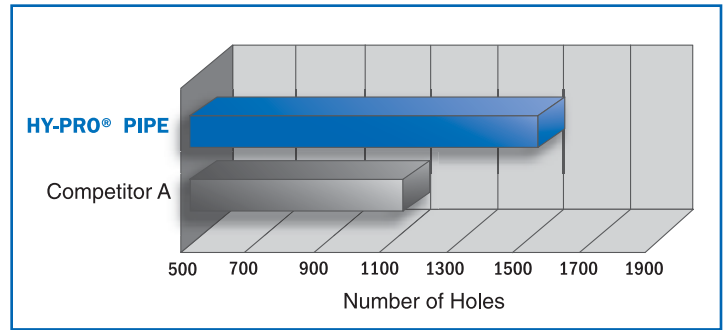
TiCN Coating

Increased Surface Hardness and Wear Resistance



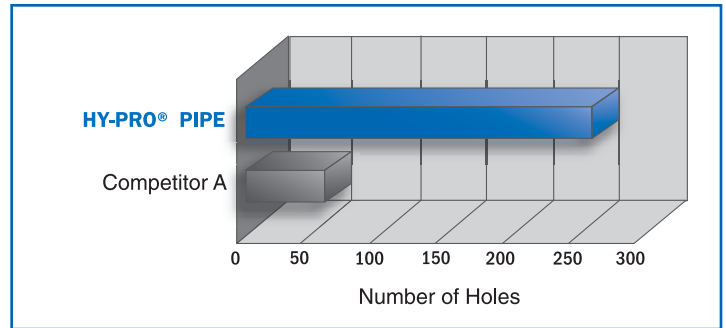
List 12053 HY-PRO® PIPE Tap Performance 1

Work Material	304 Stainless Steel
Cutting Speed	80 RPM (20 SFM)
Drilling Depth	7/8"
Cutting Fluid	Water Soluble Oil



List 12053 HY-PRO® PIPE Tap Performance 2

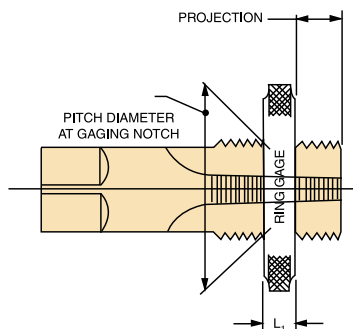
Work Material	P20 (28-32Rc)
Cutting Speed	140 RPM (25 SFM)
Drilling Depth	3/4"
Cutting Fluid	Water Soluble Oil



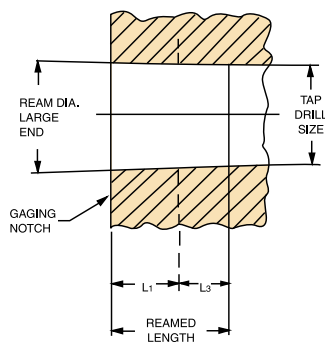
Measurement of Taper Pipe Taps, Reaming Data and Tap Drill Sizes

Size	Projection				Ream Dia. Large End	Gage Width L1	Reamed Length L1 + L3	Tap Drill for Use w/ Reaming	Tap Drill for Use w/o Reaming
	NPT & NPTF		SAE-SHORT						
	Min.	Max.	Min.	Max.					
1/16-27	0.250	0.375	0.222	0.259	0.2515	0.1600	0.2711	15/64	C
1/8-27	0.250	0.375	0.222	0.259	0.3340	0.1615	0.2726	21/64	Q
1/4-18	0.397	0.521	0.333	0.389	0.4472	0.2278	0.3945	27/64	7/16
3/8-18	0.392	0.516	0.333	0.389	0.5826	0.240	0.4067	9/16	9/16
1/2-14	0.517	0.641	0.429	0.500	0.7213	0.320	0.5343	11/16	45/64
3/4-14	0.503	0.627	0.429	0.500	0.9317	0.339	0.5533	57/64	29/32
1-11-1/2	0.584	0.772	-	-	1.1691	0.400	0.6609	1-1/8	1-9/64
1-1/4-11-1/2	0.592	0.780	-	-	1.1538	0.420	0.6809	1-15/32	1-31/64
1-1/2-11-1/2	0.606	0.792	-	-	1.7528	0.420	0.6809	1-45/64	1-23/32
2-11-1/2	0.574	0.760	-	-	2.2267	0.436	0.6969	2-3/16	2-3/16

Projection Thru Ring Gage



Reamed Hole Data



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