

## TAP RECOMMENDATIONS FOR CLASSES OF THREAD

*Unified and American National Screw Threads*

Nominal Size	T.P.I. NC UNC	T.P.I. NF UNF	RECOMMENDED TAP FOR CLASS OF THREAD				PITCH DIAMETER LIMITS FOR CLASS OF THREAD				
			Class 2	Class 3	Class 2B	Class 3B	Min. All Classes (Basic)	Max. Class 2	Max. Class 3	Max. Class 2B	Max. Class 3B
0	-	80	GH1	GH1	GH2	GH1	.0519	.0536	.0532	.0542	.0536
1	64	-	GH1	GH1	GH2	GH1	.0629	.0648	.0643	.0655	.0648
1	-	72	GH1	GH1	GH2	GH1	.0640	.0658	.0653	.0665	.0659
2	56	-	GH1	GH1	GH2	GH1	.0744	.0764	.0759	.0772	.0765
2	-	64	GH1	GH1	GH2	GH1	.0759	.0778	.0773	.0786	.0779
3	48	-	GH1	GH1	GH2	GH1	.0855	.0877	.0871	.0885	.0877
3	-	56	GH1	GH1	GH2	GH1	.0874	.0894	.0889	.0902	.0895
4	40	-	GH2	GH1	GH2	GH2	.0958	.0982	.0975	.0991	.0982
4	-	48	GH1	GH1	GH2	GH1	.0985	.1007	.1001	.1016	.1008
5	40	-	GH2	GH1	GH2	GH2	.1088	.1112	.1105	.1121	.1113
5	-	44	GH1	GH1	GH2	GH1	.1102	.1125	.1118	.1134	.1126
6	32	-	GH2	GH1	GH3	GH2	.1177	.1204	.1196	.1214	.1204
6	-	40	GH2	GH1	GH2	GH2	.1218	.1242	.1235	.1252	.1243
8	32	-	GH2	GH1	GH3	GH2	.1437	.1464	.1456	.1475	.1465
8	-	36	GH2	GH1	GH2	GH2	.1460	.1485	.1478	.1496	.1487
10	24	-	GH3	GH1	GH3	GH3	.1629	.1662	.1653	.1672	.1661
10	-	32	GH2	GH1	GH3	GH2	.1697	.1724	.1716	.1736	.1726
12	24	-	GH3	GH1	GH3	GH3	.1889	.1922	.1913	.1933	.1922
12	-	28	GH3	GH1	GH3	GH3	.1928	.1959	.1950	.1970	.1959
1/4	20	-	GH3	GH2	GH5	GH3	.2175	.2211	.2201	.2224	.2211
1/4	-	28	GH3	GH1	GH4	GH3	.2268	.2299	.2290	.2311	.2300
5/16	18	-	GH3	GH2	GH5	GH3	.2764	.2805	.2794	.2817	.2803
5/16	-	24	GH3	GH1	GH4	GH3	.2854	.2887	.2878	.2902	.2890
3/8	16	-	GH3	GH2	GH5	GH3	.3344	.3389	.3376	.3401	.3387
3/8	-	24	GH3	GH1	GH4	GH3	.3479	.3512	.3503	.3528	.3516
7/16	14	-	GH5	GH3	GH5	GH3	.3911	.3960	.3947	.3972	.3957
7/16	-	20	GH3	GH1	GH5	GH3	.4050	.4086	.4076	.4104	.4091
1/2	13	-	GH5	GH3	GH5	GH3	.4500	.4552	.4537	.4565	.4548
1/2	-	20	GH3	GH1	GH5	GH3	.4675	.4711	.4701	.4731	.4717
9/16	12	-	GH5	GH3	GH5	GH3	.5084	.5140	.5124	.5152	.5135
9/16	-	18	GH3	GH2	GH5	GH3	.5264	.5305	.5294	.5323	.5308
5/8	11	-	GH5	GH3	GH5	GH3	.5660	.5719	.5702	.5732	.5714
5/8	-	18	GH3	GH2	GH5	GH3	.5889	.5930	.5919	.5949	.5934
3/4	10	-	GH5	GH3	GH5	GH5	.6850	.6914	.6895	.6927	.6907
3/4	-	16	GH3	GH2	GH5	GH3	.7094	.7139	.7126	.7159	.7143
7/8	9	-	GH6	GH4	GH6	GH4	.8028	.8098	.8077	.8110	.8089
7/8	-	14	GH4	GH2	GH6	GH4	.8286	.8335	.8322	.8356	.8339
1	8	-	GH6	GH4	GH6	GH4	.9188	.9264	.9242	.9276	.9254
1	-	12	GH4	GH2	GH6	GH4	.9459	.9515	.9499	.9535	.9516
1	-	14*	GH4	GH2	GH6	GH4	.9536	.9585	.9572	.9609	.9590
1 1/8	7	-	GH8	GH4	GH8	GH4	1.0322	1.0407	1.0381	1.0416	1.0393
1 1/8	-	12	GH4	GH4	GH6	GH4	1.0709	1.0765	1.0749	1.0787	1.0768
1 1/4	7	-	GH8	GH4	GH8	GH4	1.1572	1.1657	1.1631	1.1668	1.1644
1 1/4	-	12	GH4	GH4	GH6	GH4	1.1959	1.2015	1.1999	1.2039	1.2019
1 3/8	6	-	GH8	GH4	GH8	GH4	1.2667	1.2768	1.2738	1.2771	1.2745
1 3/8	-	12	GH4	GH4	GH6	GH4	1.3209	1.3265	1.3249	1.3291	1.3270
1 1/2	6	-	GH8	GH4	GH8	GH4	1.3917	1.4018	1.3988	1.4022	1.3996
1 1/2	-	12	GH4	GH4	GH6	GH4	1.4459	1.4515	1.4499	1.4542	1.4522

\*UNS

These are general tap recommendations to produce the Class of Thread indicated in average materials when used with reasonable care. However, if the tap specified does not give a satisfactory gauge fit in the work, please consult the factory.