



BRITISH THREAD FORM: CUTTING TOOLS GROUND THREAD TAPS

BRITISH STANDARD WHITWORTH (BSW), BRITISH STANDARD FINE (BSF), BRITISH ASSOCIATION (BA),
BRITISH STANDARD PIPE PARALLEL (BSPF), BRITISH STANDARD PIPE TAPERED (BSPT)



HAND TAPS

DIAM. OF TAP INCHES	THREADS PER INCH		NUMBER OF FLUTES	LENGTH IN mm	
	BSW	BSF		THREAD	OVERALL
1/8	40	—	3	11	48
3/16	24	32	3	16	58
1/4	20	26	3	19	66
5/16	18	22	4	22	72
3/8	16	20	4	24	80
7/16	14	18	4	25	85
1/2	12	16	4	29	89
9/16	12	16	4	30	95
5/8	11	14	4	32	102
3/4	10	12	4	37	112
7/8	9	11	4	38	118
1	8	10	4	45	130
1-1/8	7	9	4	48	138
1-1/4	7	9	4	51	151
1-1/2	6	8	4	60	170
2	4-1/2	7	6	70	200

NOMINAL TAP SIZE	BA				
0	25.4	3	19	66	
1	28.2	3	17	62	
2	31.4	3	16	58	
3	34.8	3	13	53	
4	38.5	3	13	50	
5	43.0	3	11	48	
6	47.9	3	9.5	44	
7	52.9	3	9.5	44	
8	59.1	3	9.5	44	
9	65.1	3	8	41	
10	72.6	3	8	41	
12	90.7	3	8	41	



SPIRAL POINT PLUG TAPS

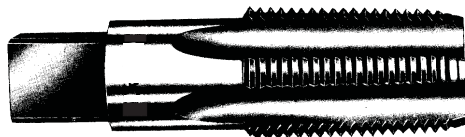
DIAM. OF TAP INCHES	THREADS PER INCH		NUMBER OF FLUTES	LENGTH IN mm	
	BSW	BSF		THREAD	OVERALL
1/8	40	—	2	11	48
3/16	24	32	2	16	58
1/4	20	26	2	19	66
5/16	18	22	3	22	72
3/8	16	20	3	24	80
7/16	14	18	3	25	85
1/2	12	16	3	29	89
9/16	12	16	3	30	95
5/8	11	14	3	32	102
3/4	10	12	3	37	112
7/8	9	11	3	38	118
1	8	10	3	45	130

NOMINAL TAP SIZE	BA				
0	25.4	2	19	66	
1	28.2	2	17	62	
2	31.4	2	16	58	
3	34.8	2	13	53	
4	38.5	2	13	50	
5	43.0	2	11	48	
6	47.9	2	9.5	44	
7	52.9	2	9.5	44	
8	59.1	2	9.5	44	
9	65.1	2	8	41	
10	72.6	2	8	41	

THE ABOVE SPIRAL POINT TAPS (ALSO KNOWN AS 'GUN' TAPS) ARE AVAILABLE IN PLUG STYLE. THEY ARE RECOMMENDED FOR USE IN THROUGH-HOLE APPLICATIONS OR IN BLIND HOLES WITH ADEQUATE CHIP ACCUMULATION SPACE.

BSW, BSF, & BA TAPS ARE AVAILABLE AS EITHER TAPER, PLUG, OR BOTTOM STYLE, OR AS A SET OF 3 TAPS.

ALL TAPS ON THIS PAGE ARE HIGH SPEED STEEL



BRITISH FORM PIPE TAPS BSPF, BSPT

BSPF PIPE TAPS ARE AVAILABLE AS EITHER TAPER, PLUG, OR BOTTOM STYLE, OR AS A SET OF 3 TAPS.
BSPT PIPE TAPS ARE AVAILABLE IN BOTTOM STYLE ONLY.

DIAM. OF TAP INCHES	THREADS PER INCH		NUMBER OF FLUTES	LENGTH IN INCHES	
	BSPF	BSPT		THREAD	OVERALL
1/8	28	28	4	3/4	2-1/8
1/4	19	19	4	1-1/16	2-7/16
3/8	19	19	4	1-1/16	2-9/16
1/2	14	14	4	1-3/8	3-1/8
5/8	14	—	4	1-3/8	3-3/16
3/4	14	14	4	1-3/8	3-1/4
7/8	14	—	4	1-9/16	3-1/2
1	11	11	6	1-3/4	3-3/4
1-1/4	11	11	6	1-3/4	4
1-1/2	11	11	6	1-3/4	4-1/4
1-3/4	11	—	6	1-3/4	4-3/8
2	11	11	6	1-3/4	4-1/2

NOTES:

BSW - BRITISH STANDARD WHITWORTH
BSF - BRITISH STANDARD FINE
BSPF - BRITISH STANDARD PIPE STRAIGHT
BSPT - BRITISH STANDARD PIPE TAPERED
BA - BRITISH ASSOCIATION

BSPF - BRITISH STANDARD PIPE STRAIGHT IS INTERCHANGEABLE WITH JAPANESE 'PF'.
BSPT - BRITISH STANDARD PIPE TAPERED IS INTERCHANGEABLE WITH JAPANESE 'PT'.
BSPF MAY ALSO BE CALLED OUT AS 'BSPP'.