

Fluteless Thread Forming Taps

Class of Fit Recommendations

These tap recommendations will produce the specified class of fit in most applications. Threads produced should be checked with thread plug gages to ensure that the threads meet required specifications. Threads that gage loose or tight may require experimentation with taps of lower or higher pitch diameter limit ("H" or "D" number).

Machine Screw & Fractional

| SIZE | THREADS PER INCH | | "H" LIMIT for CLASS of FIT | | |
|------|------------------|-----|----------------------------|-----|----|
| | UNC | UNF | 2 | 2B | 3B |
| 0 | 80 | — | H2 | H3 | H2 |
| 1 | 64 | — | H2 | H3 | H2 |
| | — | 72 | H2 | H3 | H2 |
| 2 | 56 | — | H2 | H3 | H2 |
| | — | 64 | H2 | H3 | H2 |
| 3 | 48 | — | H2 | H3 | H2 |
| | — | 56 | H2 | H3 | H2 |
| 4 | 40 | — | H3 | H5 | H3 |
| | — | 48 | H3 | H5 | H3 |
| 5 | 40 | — | H3 | H5 | H3 |
| | — | 44 | H3 | H5 | H3 |
| 6 | 32 | — | H3 | H5 | H3 |
| | — | 40 | H3 | H5 | H3 |
| 8 | 32 | — | H3 | H5 | H3 |
| | — | 36 | H3 | H5 | H3 |
| 10 | 24 | — | H4 | H6 | H4 |
| | — | 32 | H4 | H6 | H4 |
| 12 | 24 | — | H4 | H6 | H4 |
| | — | 28 | H4 | H6 | H4 |
| 1/4 | 20 | — | H4 | H6 | H4 |
| | — | 28 | H4 | H6 | H4 |
| 5/16 | 18 | — | H5 | H7 | H5 |
| | — | 24 | H5 | H7 | H5 |
| 3/8 | 16 | — | H5 | H7 | H5 |
| | — | 24 | H5 | H7 | H5 |
| 7/16 | 14 | — | H5 | H8 | H5 |
| | — | 20 | H5 | H8 | H5 |
| 1/2 | 13 | — | H5 | H8 | H5 |
| | — | 20 | H5 | H8 | H5 |
| 9/16 | 12 | — | H7 | H10 | H7 |
| | — | 18 | H7 | H10 | H7 |
| 5/8 | 11 | — | H7 | H10 | H7 |
| | — | 18 | H7 | H10 | H7 |
| 3/4 | 10 | — | H7 | H10 | H7 |
| | — | 16 | H7 | H10 | H7 |

Metric

| SIZE | PITCH | "D" LIMIT for CLASS of FIT | |
|------|-------|----------------------------|-----|
| | | 4H | 6H |
| M3 | 0.5 | D3 | D5 |
| M4 | 0.7 | D4 | D6 |
| M5 | 0.8 | D4 | D7 |
| M6 | 1 | D5 | D8 |
| M8 | 1.25 | D5 | D9 |
| M10 | 1.5 | D6 | D10 |
| M12 | 1.75 | D6 | D11 |
| M14 | 2 | D7 | D11 |
| M16 | 2 | D7 | D12 |
| M20 | 2.5 | D7 | D12 |