

## METRIC - STRAIGHT FLUTE HAND TAPS

### Straight Flute Hand Taps - Gold Oxide Ground Thread - High Speed Steel

#### Type 31-UB, 31-UBN, 31-Taper, Type 32-UB, 32-UBN, 32-Plug Type 33-UB, 33-UBN, 33-Bottoming

- The most common style of tap.
- Can be used by hand or for tapping under power.
- Versatile taps for use in general machine tapping or CNC tapping applications.
- Use for through hole or blind hole tapping.



**Type 31-UB - Taper**

Gold Oxide - low temperature stress relief that enhances lubricity, reduces friction and increases tap toughness.



**Type 32-UBN - Plug**

Titanium nitride - increases wear resistance by producing a higher surface hardness and exceptional lubricity resulting in longer tool life.



**Type 33 - Bottoming**  
Bright Finish

31-UB Taper Part #	32-UB Plug Part #	33-UB Bottoming Part #	31-UBN Taper Part #	32-UBN Plug Part #	33-UBN Bottoming Part #	31 Taper Part #	32 Plug Part #	33 Bottoming Part #	Size	# of Flutes	PD Limit	QTY. per/pack
60329	61569	61561	37661	37662	37663	54691	54692	54693	1.6-0.35	2	D3	3
60339	61579	61571	37691	37692	37693	54701	54702	54703	1.8-0.35	2	D3	3
60349	61589	61581	37711	37712	37713	54711	54712	54713	2.0-0.40	3	D3	3
60359	61599	61591	37701	37702	37703	54721	54722	54723	2.2-0.45	3	D3	3
60379	61629	61681	37731	37732	37733	54731	54732	54733	2.5-0.45	3	D3	3
60389	61631	61682	37741	37742	37743	54741	54742	54743	3.0-0.50	3	D3	3
60519	61632	61683	37751	37752	37753	54751	54752	54753	3.5-0.60	3	D4	3
60529	61633	61684	37761	37762	37763	54761	54762	54763	4.0-0.70	4	D4	3
60369	61634	61689	37771	37772	37773	54771	54772	54773	4.5-0.75	4	D4	3
60539	61639	61691	37781	37782	37783	54781	54782	54783	5.0-0.80	4	D4	3
60549	61641	61692	37791	37792	37793	54791	54792	54793	6.0-1.00	4	D5	3
60559	61642	61693	37801	37802	37803	54801	54802	54803	7.0-1.00	4	D5	3
60569	61643	61694	37811	37812	37813	54811	54812	54813	8.0-1.00	4	D5	3
60579	61644	61699	37821	37822	37823	54821	54822	54823	8.0-1.25	4	D5	3
60589	61649	61701	37831	37832	37833	54831	54832	54833	10.0-1.25	4	D5	3
60611	61651	61702	37841	37842	37843	54841	54842	54843	10.0-1.50	4	D6	3
61601	61652	61703	37851	37852	37853	54851	54852	54853	12.0-1.25	4	D5	3
61901	61911	61921	38451	38452	38453	55201	55202	55203	12.0-1.50	4	D6	3
61602	61653	61704	37861	37862	37863	54861	54862	54863	12.0-1.75	4	D6	3
61603	61654	61709	37871	37872	37873	54871	54872	54873	14.0-1.50	4	D6	1
61604	61659	61711	37881	37882	37883	54881	54882	54883	14.0-2.00	4	D7	1
61609	61661	61712	37891	37892	37893	54891	54892	54893	16.0-1.50	4	D6	1
61611	61662	61713	37901	37902	37903	54901	54902	54903	16.0-2.00	4	D7	1
61281	61282	61283	38491	38492	38493	54911	54912	54913	18.0-1.50	4	D6	1
61612	61663	61714	37911	37912	37913	54921	54922	54923	18.0-2.50	4	D7	1
66361	66362	66363	38501	38502	38503	55251	55252	55253	20.0-1.50	4	D6	1
61613	61664	61719	37921	37922	37923	54931	54932	54933	20.0-2.50	4	D7	1
66371	66372	66373	38521	38522	38523	55261	55262	55263	22.0-1.50	4	D6	1
66381	66382	66383	38531	38532	38533	55271	55272	55273	22.0-2.50	4	D7	1
66391	66392	66393	38541	38542	38543	55281	55282	55283	24.0-2.00	4	D7	1
61614	61669	61721	37931	37932	37933	54941	54942	54943	24.0-3.00	4	D8	1
66401	66402	66403	-----	-----	-----	55291	55292	55293	27.0-2.00	4	D7	1
61619	61671	61722	-----	-----	-----	54951	54952	54953	27.0-3.00	4	D8	1
66411	66412	66413	-----	-----	-----	55301	55302	55303	30.0-2.00	4	D7	1
61621	61672	61723	-----	-----	-----	54961	54962	54963	30.0-3.50	4	D9	1
66421	66422	66423	-----	-----	-----	55311	55312	55313	33.0-2.00	6	D7	1
61622	61673	61724	-----	-----	-----	54971	54972	54973	33.0-3.50	4	D9	1
66431	66432	66433	-----	-----	-----	55321	55322	55323	36.0-3.00	4	D8	1
61623	61674	61729	-----	-----	-----	54981	54982	54983	36.0-4.00	4	D9	1
66441	66442	66443	-----	-----	-----	55331	55332	55333	39.0-3.00	6	D8	1
61624	61679	61731	-----	-----	-----	54991	54992	54993	39.0-4.00	6	D9	1

## PRODUCT TIPS

### Tap Wrenches:

They come in two sizes, large & small. Make sure tap is securely locked in place by turning the hex head as tightly as possible with your fingers. Do not use a wrench to tighten.



**Taper Tap**

This section cuts full-size thread



**Plug Tap**

This section cuts full-size thread



**Bottoming Tap**

This section cuts full-size thread

