

ASME B94.9-2008
(Revision of ASME B94.9-1999)

Taps: Ground Thread With Cut Thread Appendix (Inch and Metric Sizes)

AN AMERICAN NATIONAL STANDARD



**The American Society of
Mechanical Engineers**



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CONTENTS

| | |
|--|----------|
| Foreword | v |
| Committee Roster | vi |
| Correspondence With the B94 Committee | vii |
| 1 General | 1 |
| 2 Tap Categorization | 1 |
| 3 Tap Styles | 4 |
| 4 Standard System of Tap Marking | 7 |
| 5 Standard System of Tap Thread Units and Identification, Ground Thread | 7 |
| 6 Glossary of Tap Elements and Other Terms Related to Screw Threads | 8 |
| Figures | |
| 1 Illustrations of Terms Applying to Taps | 2 |
| 2 Straight Flute Style Taps | 5 |
| 3 Spiral Pointed Style Taps | 5 |
| 4 Spiral Pointed Only Style Taps | 5 |
| 5 Regular Spiral Fluted Style Taps | 5 |
| 6 Fast Spiral Fluted Style Taps | 6 |
| 7 Thread Forming Type Taps | 6 |
| 8 Pulley Type Taps | 6 |
| 9 Pipe Type Taps | 7 |
| Tables | |
| 1 Thread Series Designations | 19 |
| 2 Standard Tap Dimensions | 20 |
| 3 Optional Neck and Optional Shortened Thread Length (Tap Dimensions) | 23 |
| 4 Standard Tap Dimensions [Screw Thread Inserts (STI): Machine Screw and Fractional Size Taps] | 25 |
| 5 Standard Tap Dimension [Screw Thread Inserts (STI), Metric Size Taps] | 27 |
| 6 Straight and Taper Pipe Taps | 29 |
| 7 Tap Thread Limits and Tolerances, Formulas for Unified Inch Screw Threads (Ground Thread) | 31 |
| 8 Standard Formulas for Thread Cutting Taps | 33 |
| 9 Standard Taper Lengths for Thread Forming Taps | 34 |
| 10 Tap Thread Limits and Tolerances, Formulas for Metric Threads (Ground Thread) | 35 |
| 11 Standard Number of Flutes | 37 |
| 12 Tap Thread Limits: Machine Screw Sizes, Ground Thread (Unified and American National Thread Forms, Standard Thread Limits) | 39 |
| 13 Tap Thread Limits: Fractional Sizes, Ground Thread (Unified and American National Thread Forms, Standard Thread Limits) | 40 |
| 14 Tap Thread Limits: Metric Sizes, Ground Thread (M Profile: Standard Thread Limits in Millimeters) | 42 |
| 15 Runout of Tap Elements | 44 |
| 16 Pulley Taps, Fractional Size (High-Speed Steel, Ground Thread) | 45 |
| 17 Taper Pipe Tap Thread Limits (Ground Thread; Ground Thread for NPT, NPTE, and ANPT) | 46 |
| 18 Straight Pipe Tap Thread Limits: NPSC/NPSM, Ground Thread [American National Standard Straight Pipe Thread Form (NPSC, NPSM)] | 48 |

| | | |
|--------------------------------|--|----|
| 19 | Straight Pipe Tap Thread Limits: NPSF, Ground Thread [Dryseal American National Standard Straight Pipe Thread Form (NPSF)] | 49 |
| 20 | Tap Thread Limits [Screw Thread Inserts (STI), Ground Thread, Machine Screw, and Fractional Size] | 50 |
| 21 | Tap Thread Limits [Screw Thread Inserts (STI), Ground Thread, Metric Size (mm)] | 52 |
| Nonmandatory Appendices | | |
| A | Tap Size Recommendations | 53 |
| B | Standard System of Tap Marking Cut Thread Taps | 72 |

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FOREWORD

A subcommittee of the National Screw Thread Commission began standardizing certain dimensions of cut and ground thread taps in 1926. The subcommittee prepared a report that was finally referred to the sectional committee on Small Tools and Machine Tool Elements (B5) organized under the procedure of the American Standards Association (ASA). The original proposal passed through the regular procedure and was designated as an American Standard by ASA in April 1930.

Following the publication of the standard in 1930, Technical Committee 12 on Cut and Ground Thread Taps decided to include in the next edition additional types and sizes, a glossary of terms and definitions, and certain commercial standards issued by the tap and die manufacturers that were reproduced from their publications. Following approval from the sectional committee and the sponsors, the proposal was approved by ASA in November 1939.

In 1962 a new sectional committee, B94, was formed for the standardization of cutting tools. Technical Committee 12 on Cut and Ground Thread Taps now operates within this framework.

In 1967 the revised Standard proposed by Technical Committee 12 was approved and designated B94.9-1967.

In 1971 the revised Standard proposed by Technical Committee 12 was approved and designated B94.9-1971.

In 1979 the revised Standard proposed by Technical Committee 12 was approved and designated B94.9-1979.

In 1987 the revised Standard proposed by Technical Committee 12 was approved following all the procedures of the American National Standards Institute (ANSI) and designated ASME/ANSI B94.9-1987.

In 1999 the revised Standard proposed by Technical Committee 12 was approved and designated ASME B94.9-1999.

In 2005 the revised Standard proposed by Technical Committee 12 was approved and designated ASME B94.9-2008. The following major changes to the standard included are:

(a) ASME B94.9 is now under the P1 Standards Committee. This Standard will still have the B94.9 designation.

(b) All tables for cut thread taps have been moved to the Appendix section of this Standard.

(c) STI size taps have had blank sizes revised to be consistent with standard industry practice. The major diameter values on metric STI taps will follow established values, and pitch diameter values of metric STI taps will remain listed with "H" pitch diameter limits.

(d) The term "lead tolerance" has been changed to "cumulative pitch error," and formulas for calculating the values are included in this Standard.

(e) The practice of marking taps NPS has been changed to NPSC/NSPM.

(f) The practice of marking taps NC, NF, NEF, NS has been changed to UNC, UNF, UNEF, UNS for machine screw and fractions sizes.

(g) The inclusion of HS (high speed steel) and G (ground thread) has been made optional in the marking of taps.

(h) Nomenclature definitions for high speed steel, ground thread taps, and cut thread taps have been added.

This Standard was approved as an American National Standard on June 18, 2008.

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Screw Threads

(The following is the roster of the Committee at the time of approval of this Standard.)

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Secretary, B1 Standards Committee
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Three Park Avenue
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Proposing Revisions. Revisions are made periodically to the Standard to incorporate changes that appear necessary or desirable, as demonstrated by the experience gained from the application of the Standard. Approved revisions will be published periodically.

The Committee welcomes proposals for revisions to this Standard. Each proposal should be as specific as possible, citing the paragraph number(s), the proposed wording, and a detailed description of the reasons for the proposal, including any pertinent documentation.

Proposing a Case. Cases may be issued for the purpose of providing alternative rules when justified, to permit early implementation of an approved revision when the need is urgent, or to provide rules not covered by existing provisions. Cases are effective immediately upon ASME approval and shall be posted on the ASME Committee Web page.

Requests for Cases shall provide a Statement of Need and Background Information. The request should identify the Standard, the paragraph, figure or table number(s), and be written as a Question and Reply in the same format as existing Cases. Requests for Cases should also indicate the applicable edition(s) of the Standard to which the proposed Case applies.

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TAPS: GROUND THREAD WITH CUT THREAD APPENDIX (INCH AND METRIC SIZES)

1 GENERAL

1.1 Scope

This Standard covers various designs of standard taps, nomenclature, and definitions; the standard system of marking; and dimensions and tolerance tables for the types and styles of taps listed below. For thread series designations, refer to Table 1.

| Type | Style | Applicable Section(s) |
|---|---------------------------------------|-----------------------|
| Standard straight thread, general purpose; Tables 2, 3, and 4 | Straight fluted | 3.1 |
| | Spiral fluted | 3.4 and 3.5 |
| | Spiral point, with straight flutes | 3.2 |
| | Spiral point only, no straight flutes | 3.3 |
| Pulley; Table 6 | Straight fluted | 3.1 |
| | Straight fluted | 3.7 |
| Pipe, taper thread; Table 7 | Straight fluted | 3.8 |
| Pipe, straight thread; Table 10 | Straight fluted | 3.8 |
| Thread forming; Tables 2 and 3 | Straight lobes | 3.6 |
| | Spiral lobes | 3.6 |

1.2 Reference Standards for Screw Thread Nomenclature and Forms of Thread

The following is a list of publications referenced in this Standard.

- ASME B1.1, Unified Inch Screw Threads (UN and UNR Thread Form)
- ASME B1.7, Screw Threads: Nomenclature, Definitions, and Letter Symbols
- ASME B1.12, Class 5 Interference-Fit Thread
- ASME B1.13M, Metric Screw Threads — M Profile
- ASME B1.15, Unified Inch Screw Threads (UNJ Thread Form)
- ASME B1.20.1, Pipe Threads, General Purpose (Inch)
- ASME B1.20.3, Dryseal Pipe Threads (Inch)
- ASME B1.20.7, Hose Coupling Screw Threads (Inch)
- ASME B1.21M, Metric Screw Threads: MJ Profile
- ASME B1.30, Screw Threads — Standard Practice for Calculating and Rounding Dimensions
- ASME B18.29.1, Helical Coil Screw Thread Inserts — Free Running and Screw Locking (Inch Series)

Publisher: The American Society of Mechanical Engineers (ASME), Three Park Avenue, New York, NY 10016-5990; Order Department: 22 Law Drive, P.O. Box 2300, Fairfield, NJ 07007-2300

SAE AS-8879, Screw Threads-UNJ Profile Inch Controlled Radius Root With Increased Minor Diameter

SAE AS-71051, Pipe Threads Taper, Aeronautical National Form, Symbol ANPT-Design and Inspection Standard

Publisher: Society of Automotive Engineers (SAE), 400 Commonwealth Drive, Warrendale, PA 15096-0001

1.3 Basic Form of Thread

The basic angle of thread between the flanks of thread measured in an axial plane is 60 deg (Fig. 1).

The symmetrical height of the thread form, h , is found as follows:

$$h = 0.64951905P = \frac{0.64951905}{n}$$

The basic pitch diameter is obtained by subtracting the symmetrical single thread height, h , from the basic major diameter as follows:

$$\text{Basic pitch diameter} = D_{\text{bsc}} - h$$

where

- D_{bsc} = basic major diameter
- h = symmetrical height of thread
- n = number of threads per inch
- P = pitch of thread

1.4 Tap Pitch Diameter Size

A range of tap pitch diameter limits from which the user may select to suit local conditions is available. Tables A-1 and A-2 in Nonmandatory Appendix A list tap pitch diameter limits that produce common classes of thread when used with reasonable care in average materials. Factors beyond the tap "H" limit affect final part size.

2 TAP CATEGORIZATION

Taps included in this Standard are categorized according to type, style, size and chamfer, and blank