

History of Quality and Dependability

For over 100 years, IRWIN HANSON has been providing the highest quality threading tools in the industry. The IRWIN HANSON name signifies dependability with professionals who use our tools each and every day. By working with various tradesmen, we are able to create solutions for endless fastening challenges. Whether creating new threads or repairing damaged and worn threads, achieving a precise fit is essential. IRWIN HANSON sets the standard for delivering quality every step of the way for your threading applications.

Tap & Die Overview

Although there are hundreds of different types of fasteners, most of them have the same basic design: a spiral groove inside a hole matches the threads on the outside diameter of a screw or bolt. IRWIN HANSON taps and dies are the tools used by professionals to create threads to solve the most challenging fastener applications.

Material Types

- **High Carbon Steel (HCS)** for hand tapping applications
- **High Speed Steel (HSS)** for machine tapping where critical dimensions are required

Point Styles

- Taper, plug, and bottoming styles are available



Laser Etched

- Tap size and recommended drill bit size are laser etched on each tool for easy identification

Precision Ground Flutes



Tap Point Styles

Taper Taps



8-10 threads

- Easiest to start
- 8 to 10 threads chamfered
- Ideal for tough starting applications
- Preferred use with deep or through hole applications

Plug Taps



3-5 threads

- 3 to 5 threads chamfered
- Most common chamfer
- Ideal for for all general purpose threading

Bottom Taps



1-2 threads

- 1 to 2 threads chamfered
- Shortest and least efficient standard chamfer
- Ideal for threading close to the bottom of blind holes

HANSON® Metric Taps (HCS)



1859

- Ideal for auto repair and machinery where metric threads are specified

Description	No. of Flutes	Plug Carded Stock #	Plug Bulk Stock #	Bottom Bulk Stock #
3 mm - 0.50	3	8312	1712	1812
3 mm - 0.60	3	—	1713	—
4 mm - 0.70	4	8317	1717	1817
4 mm - 0.75	4	8318	1718	1818
5 mm - 0.80	4	8322	1722	1822
5 mm - 0.90	4	8323	1723	1823
6 mm - 1.00	4	8327	1727	1827
6.3 mm - 1.00	4	—	1729	1829
7 mm - 1.00	4	8331	1731	1831
8 mm - 1.00	4	8333	1733	1833
8 mm - 1.25	4	8334	1734	1834
9 mm - 0.75	4	8335	—	—
9 mm - 1.00	4	8336	—	—
9 mm - 1.25	4	8337	1737	1837
10 mm - 1.00	4	8338	1738	1838
10 mm - 1.25	4	8339	1739	1839
10 mm - 1.50	4	8340	1740	1840
11 mm - 1.50	4	8341	1741	—
12 mm - 1.25	4	8342	1742	1842
12 mm - 1.50	4	8343	1743	—
12 mm - 1.75	4	8344	1744	1844
14 mm - 1.25	4	—	1749	1849
14 mm - 1.50	4	—	1750	—
14 mm - 2.00	4	—	1752	1852
16 mm - 1.00	4	—	1754	—
16 mm - 1.50	4	—	1755	1855
16 mm - 2.00	4	—	1756	1856
18 mm - 1.50	4	—	1759	1859
18 mm - 2.50	4	—	1761	1861
20 mm - 2.50	4	—	1764	1864
22 mm - 1.50	4	—	1765	1865
24 mm - 2.00	4	—	1768	1868
24 mm - 3.00	4	—	1769	1869

Description	No. of Flutes	Stock #
6 - 32 NC	3	2518
8 - 32 NC	4	2524
10 - 24 NC	4	2528
10 - 32 NF	4	2531
1/8" - 40 NS	3	2606
5/32" - 32 NS	4	2610
5/32" - 36 NS	4	2611
1/4" - 20 NC	4	2620
1/4" - 28 NF	4	2623
5/16" - 18 NC	4	2627
5/16" - 24 NF	4	2629
3/8" - 16 NC	4	2634
3/8" - 24 NF	4	2636
7/16" - 14 NC	4	2639
7/16" - 20 NF	4	2640
1/2" - 13 NC	4	2644
9/16" - 12 NC	4	2648
5/8" - 11 NC	4	2652
5/8" - 18 NF	4	2654
3/4" - 10 NC	4	2658
7/8" - 9 NC	4	2661
1" - 8 NC	4	2665
3 mm - 0.50	3	2712
5 mm - 0.80	4	2722
6 mm - 1.00	4	2727
7 mm - 1.00	4	2731
8 mm - 1.00	4	2733
8 mm - 1.25	4	2734
10 mm - 1.00	4	2738
10 mm - 1.25	4	2739
10 mm - 1.50	4	2740
12 mm - 1.25	4	2742
12 mm - 1.75	4	2744
14 mm - 2.00	4	2752
16 mm - 2.00	4	2756

HANSON Tap Sets with Taper, Bottoming & Plug Point Styles



2652

- Set contains all three chamfer styles for various uses

HANSON® 66-pc Metric Tap & Hex Die Set



97312

Set Contents		Stock # 97312
Thread Size Metric	Tap Stock # Plug Style	Die Stock # 5/8" Hexagon
3 mm - 0.50	1712	6312
4 mm - 0.70	1717	6317
4 mm - 0.75	1718	6318
5 mm - 0.80	1722	6322
5 mm - 0.90	1723	6323
6 mm - 1.00	1727	6327
1" Hexagon		
7 mm - 1.00	1731	6631
8 mm - 1.00	1733	6633
8 mm - 1.25	1734	6634
9 mm - 1.00	1736	6636
9 mm - 1.25	1737	6637
10 mm - 1.25	1739	6639
10 mm - 1.50	1740	6640
11 mm - 1.50	1741	6641
12 mm - 1.50	1743	6643
12 mm - 1.75	1744	6644
1-7/16" Hexagon		
14 mm - 1.25	2449	6949
14 mm - 1.50	1750	6950
14 mm - 2.00	1752	6952
16 mm - 1.50	1755	6955
16 mm - 2.00	1756	6956
18 mm - 1.50	1759	6959
18 mm - 2.50	1761	6961
1-13/16" Hexagon		
20 mm - 2.50	1764	8564
22 mm - 1.50	1765	8565
24 mm - 2.00	1768	8568
24 mm - 3.00	1769	8569
1" Hexagon		
Pipe		
1/8" - 28 BSP	1911	6711
Threading Tools		Stock #
Adj. Die Stock - 1" Dies		11026
Adj. Die Stock - 1-7/16" Hexagon Dies		12436
Adj. Die Stock - 1-3/16" Hexagon Dies		12446
Plain Die Stock - 5/8" Hexagon Dies		12457
T-Handle Wrench - Taps No. 0 to 1/4"		12473
Adj. Handle Tap Wrench - Taps No. 0 to 1/2"		311088
Adj. Handle Tap Wrench - Taps 1/4" to 1"		12498
Two-in-One Tap Wrench - Taps 1/4" to 1/2"		12450
16 Leaf Metric Thread Pitch Gauge		11016

TAPS & DIES

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HIGH CARBON STEEL COMBINATION SETS

HANSON® 25-pc Fractional Tap & Hex Die Set



97094

Set Contents		Stock # 97094
Thread Size Fractional	Tap Stock # Plug Style	Die Stock # 1-7/16" Hexagon
9/16" - 12 NC	1448	6848
9/16" - 18 NF	1449	6849
5/8" - 11 NC	1452	6852
5/8" - 18 NF	1454	6854
3/4" - 10 NC	1458	6858
3/4" - 16 NF	1460	6860
		1-13/16" Hexagon
7/8" - 9 NC	1461	8461
7/8" - 14 NF	1463	8463
1" - 8 NC	1465	8465
1" - 14 NS	1467	8467
Pipe		1-7/16" Hexagon
1/4" - 18 NPT	1903	7003
Threading Tools		Stock #
Adj. Die Stock - 1-7/16" Hexagon Dies		12436
Adj. Die Stock - 1-13/16" Hexagon Dies		12446
Adj. Handle Tap Wrench - Taps 1/4" to 1"		12498
Empty Plastic Case		97094MT

TAPS & DIES

HANSON 25-pc Metric Tap & Hex Die Set



97311

Set Contents		Stock # 97311
Thread Size Metric	Tap Stock # Plug Style	Die Stock # 1-7/16" Hexagon
14 mm - 1.25	2449*	6949
14 mm - 1.50	1750	6950
14 mm - 2.00	1752	6952
16 mm - 1.50	1755	6955
16 mm - 2.00	1756	6956
18 mm - 1.50	1759	6959
18 mm - 2.50	1761	6961
		1-13/16" Hexagon
20 mm - 2.50	1764	8564
22 mm - 1.50	1765	8565
24 mm - 2.00	1768	8568
24 mm - 3.00	1769	8569
Threading Tools		Stock #
Adj. Die Stock - 1-7/16" Hexagon Dies		12436
Adj. Die Stock - 1-13/16" Hexagon Dies		12446
Adj. Handle Tap Wrench - Taps 1/4" to 1"		12498
Empty Plastic Case		97311MT