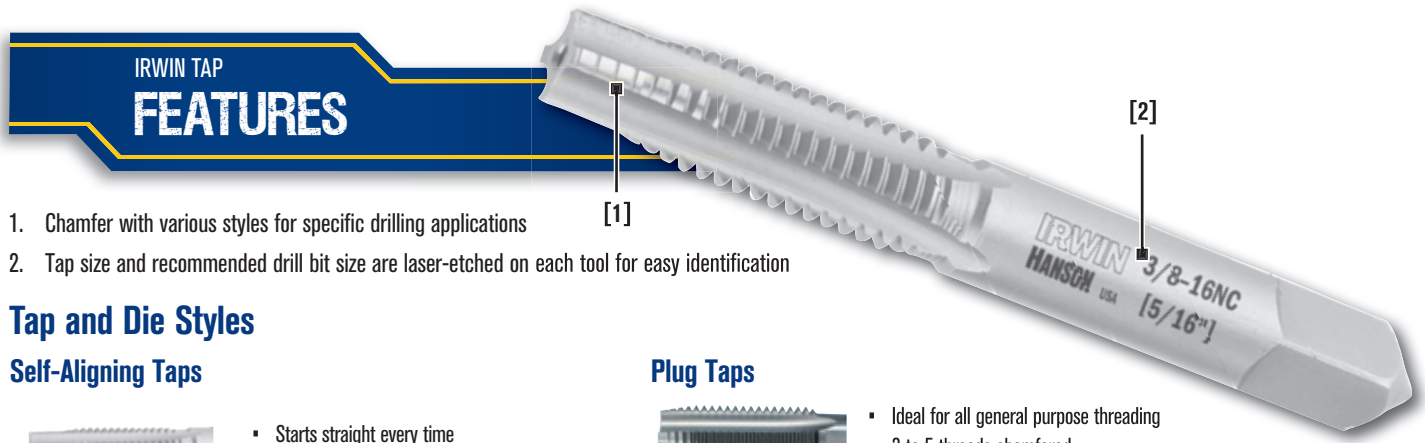


IRWIN HANSON

IRWIN® HANSON® has been manufacturing High Carbon Steel threading tools for over 100 years, and has proven itself to be a brand you can trust. Performance, thread quality, durability, and ease of use – proven for over a century.

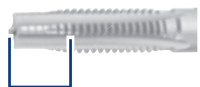


IRWIN TAP FEATURES

1. Chamfer with various styles for specific drilling applications
2. Tap size and recommended drill bit size are laser-etched on each tool for easy identification

Tap and Die Styles

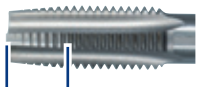
Self-Aligning Taps



8-10 threads

- Starts straight every time
- Ideal for through holes and irregular surfaces

Taper Taps



8-10 threads

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

Plug Taps



3-5 threads

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

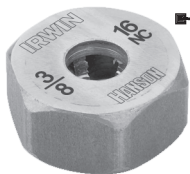
Bottom Taps



1-2 threads

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

Self-Aligning Dies



1" Across Hex Flats

- Starts straight every time
- More steel at critical points for extra strength
- Recommended for use with PTS die stock

Hexagon Dies



5/8", 1", 1-7/16" and 1-13/16" Across Hex Flats

- Best suited for maintenance and repair work
- Recommended for use with hexagonal die stock handles
- In area with limited space, die can be used with a wrench or socket

Solid Round Dies



1" and 1-1/2" Overall Diameter

- Ideal for general purpose threading
- Fits into adjustable guide or plain die stock handles

Adjustable Round Dies



1", 1-1/2", 2" and 3" Overall Diameter

- Ideal for a precision threading with the adjustment of die made by set screw
- Adjustable dies allow the user to under or over cut their threads
- Fits into adjustable guide or plain die stock handles
- Meets Federal Specifications GGG-D-296

Tap & Die Description Guide

10-24 NC

Fastener Diameter

10 - Machine screw size
5/8" - Fractional
8 mm - Metric

Thread Pitch

Threads per inch (machine & fractional)
Distance between threads (metric)

Thread Type

NC = National Coarse (USS)
NF = National Fine (SAE)
NS = National Special
NEF = National Extra Fine
NPT = National Pipe Taper
BSP = British Standard Pipe
(no thread symbol required for metric fasteners)

Applications

General purpose machines and appliances
Automotive parts requiring extreme pressures
Special threads – either diameter or threads per inch
For optical or thin wall parts
For all pipe threads
For all pipe threads

HANSON Metric Taps (HCS)



1859

- Ideal for auto repair and machinery where metric threads are specified
- Straight flutes are ground to provide rapid chip removal for efficient threading
- Designed for hand threading work in a variety of materials
- Taps produce a class 2B thread

Description	No. of Flutes	Plug Carded Item #	Plug Bulk Item #	Bottom Bulk Item #	Self Aligning Bulk Item #
3 mm - 0.50	3	8312	1712ZR	1812ZR	4935238
3 mm - 0.60	3	—	1713ZR	—	—
4 mm - 0.70	4	8317	1717ZR	1817ZR	4935239
4 mm - 0.75	4	8318	1718ZR	1818ZR	4935240
5 mm - 0.80	4	8322ZR	1722ZR	1822ZR	4935241
5 mm - 0.90	4	8323ZR	1723ZR	1823ZR	4935242
6 mm - 1.00	4	8327	1727	1827ZR	4935243
6.3 mm - 1.00	4	—	1729ZR	1829	—
7 mm - 1.00	4	8331	1731ZR	1831ZR	4935244
8 mm - 1.00	4	8333	1733ZR	1833ZR	4935245
8 mm - 1.25	4	8334	1734ZR	1834ZR	4935246
9 mm - 0.75	4	8335	1735	—	—
9 mm - 1.00	4	8336	1736	—	4935247
9 mm - 1.25	4	8337	1737	1837ZR	4935248
10 mm - 1.00	4	8338	1738	1838ZR	—
10 mm - 1.25	4	8339	1739	1839	4935249
10 mm - 1.50	4	8340	1740ZR	1840	4935250
11 mm - 1.50	4	8341	1741ZR	—	4935251
12 mm - 1.25	4	8342ZR	1742ZR	1842ZR	4935252
12 mm - 1.50	4	8343ZR	1743ZR	—	—
12 mm - 1.75	4	8344	1744ZR	1844	4935253
14 mm - 1.25	4	—	1749ZR	1849ZR	—
14 mm - 1.50	4	—	1750	—	—
14 mm - 2.00	4	—	1752ZR	1852	—
16 mm - 1.00	4	—	1754ZR	—	—
16 mm - 1.50	4	—	1755ZR	1855	—
16 mm - 2.00	4	—	1756ZR	1856	—
18 mm - 1.50	4	—	1759ZR	1859ZR	—
18 mm - 2.50	4	—	1761ZR	1861ZR	—
20 mm - 2.50	4	—	1764ZR	1864ZR	—
22 mm - 1.50	4	—	1765ZR	1865ZR	—
24 mm - 2.00	4	—	1768ZR	1868ZR	—
24 mm - 3.00	4	—	1769ZR	1869ZR	—

HANSON Pipe Taper Taps (HCS)



1903

- Ideal for pipe fittings
- Cuts internal threads in pipes
- Nominal size of the tap is that of the pipe fitting being tapped
- Available in National Pipe Taper (NPT) and British Standard Pipe Taper (BSP)
- Tapered at a rate of 3/4" per foot

Description	No. of Flutes	Plug Carded Item #	Taper Pouched Item #	Taper Bulk Item #
1/8" - 27 NPT	4	8202	—	1902ZR
1/4" - 18 NPT	4	8203	—	1903ZR
3/8" - 18 NPT	4	—	1904P	1904ZR
1/2" - 14 NPT	4	—	1905P	1905ZR
3/4" - 14 NPT	5	—	1906P	1906ZR
1" - 11-1/2 NPT	5	—	—	1907ZR
1-1/4" - 11-1/2 NPT	5	—	—	1908ZR
1-1/2" - 11-1/2 NPT	6	—	—	1909ZR
2" - 11-1/2 NPT	6	—	—	1910ZR
1/8" - 28 BSP	4	—	—	1911ZR
1/4" - 19 BSP	4	—	—	1912ZR

HANSON 6-piece Pipe Taper Tap Set (HCS)



1921

Set Contents	Item # 1921
1/8" - 27 NPT	1902ZR
1/4" - 18 NPT	1903ZR
3/8" - 18 NPT	1904ZR
1/2" - 14 NPT	1905ZR
3/4" - 14 NPT	1906ZR
1" - 11-1/2 NPT	1907ZR

Taps & Dies

High Carbon Steel Combination Sets

HANSON® 66-piece Metric Tap & Hex Die Set



97312

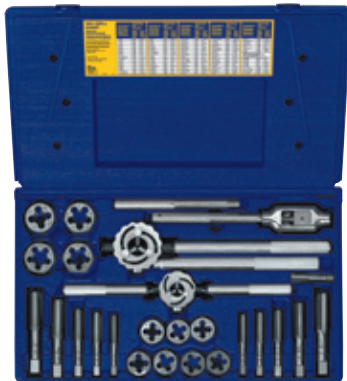
TAPS & DIES

Set Contents		Item # 97312
Thread Size Metric	Tap Item # Plug Style	Die Item # 5/8" Hexagon
3 mm - 0.50	1712ZR	6312
4 mm - 0.70	1717ZR	6317
4 mm - 0.75	1718ZR	6318
5 mm - 0.80	1722ZR	6322
5 mm - 0.90	1723ZR	6323ZR
6 mm - 1.00	1727	6327
		1" Hexagon
7 mm - 1.00	1731ZR	6631
8 mm - 1.00	1733ZR	6633
8 mm - 1.25	1734ZR	6634
9 mm - 1.00	1736	6636
9 mm - 1.25	1737	6637
10 mm - 1.25	1739	6639
10 mm - 1.50	1740ZR	6640
11 mm - 1.50	1741ZR	6641
12 mm - 1.50	1743ZR	6643
12 mm - 1.75	1744ZR	6644
		1-7/16" Hexagon
14 mm - 1.25	2449	6949ZR
14 mm - 1.50	1750	6950ZR
14 mm - 2.00	1752ZR	6952
16 mm - 1.50	1755ZR	6955ZR
16 mm - 2.00	1756ZR	6956
18 mm - 1.50	1759ZR	6959
18 mm - 2.50	1761ZR	6961ZR
		1-13/16" Hexagon
20 mm - 2.50	1764ZR	8564ZR
22 mm - 1.50	1765ZR	8565ZR
24 mm - 2.00	1768ZR	8568
24 mm - 3.00	1769ZR	8569
Pipe		1" Hexagon
1/8" - 28 BSP	1911ZR	6711
Threading Tools		Item #
Plain Die Stock - 5/8" Hexagon Dies		12457
Adj. Die Stock - 1" Dies		11026
Adj. Die Stock - 1-7/16" Hexagon Dies		12436
Adj. Die Stock - 1-13/16" Hexagon Dies		12446
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

High Carbon Steel Combination Sets

HANSON 25-piece Metric Tap & Hex Die Set



97311

HANSON 12-piece Machine Screw/ Fractional Tap & Hex Die Set



1765542

HANSON 12-piece Machine Screw/ Fractional Tap & Hex Die Set



24605

HANSON 12-piece Metric Tap & Hex Die Set



1765541

Set Contents		Item # 97311
Thread Size Metric	Tap Item # Plug Style	Die Item # 1-7/16" Hexagon
14 mm - 1.25	2449	6949ZR
14 mm - 1.50	1750	6950ZR
14 mm - 2.00	1752ZR	6952
16 mm - 1.50	1755ZR	6955ZR
16 mm - 2.00	1756ZR	6956
18 mm - 1.50	1759ZR	6959
18 mm - 2.50	1761ZR	6961ZR
		1-13/16" Hexagon
20 mm - 2.50	1764ZR	8564ZR
22 mm - 1.50	1765ZR	8565ZR
24 mm - 2.00	1768ZR	8568
24 mm - 3.00	1769ZR	8569
Threading Tools		Item #
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

Set Contents		Item # 1765542
Thread Size Fractional	Tap Item # Self-Alignmning	Die Item # Self-Aligning
1/4" - 20 NC	4935228	4935024
5/16" - 18 NC	4935230	4935026
3/8" - 16 NC	4935232	4935028
1/2" - 13 NC	4935236	4935032
Threading Tools		Item #
PTS Die Stock - 1"		4935054
PTS Die Spacer		1775311
PTS Adj Tap Socket - Medium 1/4" to 1/2" (6mm - 12mm)		4935053
T-Bar for Adj Tap Socket		1775312

Set Contents		Item # 24605
Thread Size Machine Screw	Tap Item # Plug Style	Die Item # 5/8" Hexagon
6 - 32 NC	1118	6118
8 - 32 NC	1124	6124
10 - 24 NC	1128ZR	6128
10 - 32 NF	1131	6131
Fractional		
1/4" - 20 NC	1420	6220
Threading Tools		Item #
Plain Die Stock - 5/8" Hexagon Dies		12457
T-Handle Tap Wrench - Taps No. 0 to 1/4"		12401

Set Contents		Item # 1765541
Thread Size Metric	Tap Item # Plug Style	Die Item # 5/8" Hexagon
3mm - 0.50	1712ZR	6312
4mm - 0.70	1717ZR	6317
5mm - 0.80	1722ZR	6322
6mm - 1.00	1727	6327
7mm - 1.00	1731ZR	6631
Threading Tools		Item #
Plain Die Stock - 5/8" Hexagon Dies		12457
T-Handle Tap Wrench - Taps No. 0 to 1/4"		12401

TAPS & DIES