

Taps, High-Speed Steel



1. Scope

This standard covers the requirements for high-speed steel (HSS) taps.
This standard applies to the Seattle City Light (SCL) stock numbers listed in Section 8.

2. Application

Taps are used for tapping (creating holes with internal threading, into ferrous and nonferrous materials). Tap holes can be mated with compatible fasteners.

3. Industry Standards

Taps shall meet the applicable requirements of the latest revision of the following industry standards:

ANSI/ASME B1.1; Unified Inch Screw Thread, (UN and UNR Thread Form)

ANSI/ASME B1.7; Screw Threads: Nomenclature, Definitions, and Letter Symbols

ANSI/ASME B1.20.1; Pipe Threads, General Purpose, Inch

ANSI/ASME B94.9; Taps: Ground Thread with Cut Thread Appendix (Inch and Metric Sizes)

4. Requirements

Product requirements shall be as described below and defined in Section 8:

- High-speed steel (HSS)
- Straight flute
- Right hand thread
- Square shank driver
- Right hand spiral cut rotation



5. Marking

Each tap shall be marked on its shank with:

- Nominal size
- Thread form symbol
- Tap material
- Pitch diameter limit

6. Packaging

Product shall be packaged to prevent damage during shipping, handling, and storage.

Individual packages shall be legibly marked with:

- Manufacturer name
- Manufacturer catalog number
- Product description
- Seattle City Light stock number

Shipping containers shall be legibly marked with:

- Seattle City Light purchase order number

7. Issuance

Stock Unit: EA

8. Approved Manufacturers

Table 8a. Taper, UNC Thread

Stock No.	Size (Inch or No.)	Threads per Inch	Approved Manufacturer	Part No.
765505	2	56	OSG USA, Inc.	1010900
765507	4	40	OSG USA, Inc.	1012100
765508	6	32	Fastcut Tool	10124
765509	8	32	Fastcut Tool	10172
"	"	"	Morse Cutting Tools	33621
765510	10	24	Cleveland Tool Division	C54321
765512	12	24	Morse Cutting Tools	33629
765601	1/4	20	Cleveland Tool Division	C54453
765602	5/16	18	Cleveland Tool Division	C54504
765603	3/8	16	Morse Cutting Tools	32307
765604	7/16	14	Morse Cutting Tools	32309
765605	1/2	13	Fastcut Tool	10504
765607	5/8	11	OSG USA, Inc.	1123600
765608	3/4	10	OSG USA, Inc.	1125008

Table 8b. Plug, UNC Thread

Stock No.	Size (Inch or No.)	Threads per Inch	Approved Manufacturer	Part No.
765525	2	56	Cleveland Tool Division	C54090
765527	4	40	Cleveland Tool Division	C54150
765528	6	32	Cleveland Tool Division	C54224
765529	8	32	Fastcut Tool	11030
765530	10	24	Cleveland Tool Division	C54330
765532	12	24	Cleveland Tool Division	C54386
765621	1/4	20	Cleveland Tool Division	C54454
765622	5/16	18	Cleveland Tool Division	C54505
765623	3/8	16	Fastcut Tool	10423
765624	7/16	14	Fastcut Tool	10466
765625	1/2	13	Fastcut Tool	10505
765627	5/8	11	Fastcut Tool	10562
765628	3/4	10	Fastcut Tool	10601

Table 8c. Bottoming, UNC Thread

Stock No.	Size (Inch or No.)	Threads per Inch	Approved Manufacturer	Part No.
765547	4	40	OSG USA, Inc.	1012300
765548	6	32	OSG USA, Inc.	1023800
765549	8	32	OSG USA, Inc.	1024400
765550	10	24	Cleveland Tool Division	C54331
765552	12	24	Cleveland Tool Division	C54387
765641	1/4	20	Cleveland Tool Division	C54455
"	"	"	Morse Cutting Tools	32605
765642	5/16	18	Fastcut Tool	10377
765643	3/8	16	Cleveland Tool Division	C54584
765644	7/16	14	Cleveland Tool Division	C54654
765645	1/2	13	Cleveland Tool Division	C54728
765647	5/8	11	Cleveland Tool Division	C54781
765648	3/4	10	Morse Cutting Tools	32653

Table 8d. Taper, UNF Thread

Stock No.	Size (Inch or No.)	Threads per Inch	Approved Manufacturer	Part No.
765511	10	32	Cleveland Tool Division	C54356
765661	1/4	28	Fastcut Tool	10351
765662	5/16	24	Fastcut Tool	10399
765663	3/8	24	Fastcut Tool	10446
765664	7/16	20	Fastcut Tool	10484
765666	9/16	18	Cleveland Tool Division	C54765

Table 8e. Plug, UNF Thread

Stock No.	Size (Inch or No.)	Threads per Inch	Approved Manufacturer	Part No.
765681	1/4	28	Cleveland Tool Division	C54470
765682	5/16	24	Cleveland Tool Division	C54519
765683	3/8	24	Cleveland Tool Division	C54596
765684	7/16	20	Cleveland Tool Division	C54662
765685	1/2	20	Cleveland Tool Division	C54738
765686	9/16	18	Cleveland Tool Division	C54766
765531	10	32	Cleveland Tool Division	C54357

Table 8f. Bottoming, UNF Thread

Stock No.	Size (Inch or No.)	Threads per Inch	Approved Manufacturer	Part No.
765551	10	32	Cleveland Tool Division	C54358
765701	1/4	28	Cleveland Tool Division	C54471
765702	5/16	24	Cleveland Tool Division	C54520
765703	3/8	24	Cleveland Tool Division	C54597
765704	7/16	20	Cleveland Tool Division	C54663

Table 8g. Pipe, Taper, NPT Thread

Stock No.	Size (in)	Threads per Inch	Approved Manufacturer	Part No.
765720	1/8	27	Cleveland Tool Division	C64038
765721	1/4	18	Cleveland Tool Division	C64039
765722	3/8	18	Cleveland Tool Division	C64040
765723	1/2	14	Cleveland Tool Division	C64041
765724	3/4	14	Cleveland Tool Division	C64042
765725	1	11-1/2	Cleveland Tool Division	C64043

9. Sources

Neuansourinh, Ponet; SCL Standards Engineer and originator of 7637.80
ponet.neuansourinh@seattle.gov)

SCL Stock Catalog page 76-30; June 29, 1998

www.asme.org

www.gfii.com (Cleveland Tool Division)

www.heritagecutter.com/BrubakerWeldon/PublicStore (Fastcut Tool)

www.morsecuttingtools.com

www.osgtool.com