

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

TAPS & DIES

HIGH CARBON STEEL TAPS

HANSON® Pipe Taper Taps (HCS)



1903

- 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)
- Ideal for pipe fittings
- Tapered at a rate of 3/4" per foot

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

HANSON 6-pc Pipe Taper Tap Set (HCS)



1921

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

HANSON Spark Plug Taps (HCS)



2459

- Available in standard and metric threads
- Ideal for threading or re-threading spark plug holes

Description	No. of Flutes	Bulk Stock #
14 mm - 1.25	4	2449
18 mm - 1.50	4	2459

HANSON Tap (HCS) & Drill Bit (HSS)



80238

- High speed steel drill bits ensure fast, precise drilling
- High carbon steel plug taps are ideal for general purpose threading

Description	Plug Carded Stock #
4 - 40 NC Tap + No. 43 Drill Bit	80209
6 - 32 NC Tap + 7/64" Drill Bit	80213
8 - 32 NC Tap + No. 29 Drill Bit	80217
10 - 24 NC Tap + No. 25 Drill Bit	80220
10 - 32 NF Tap + No. 21 Drill Bit	80221
12 - 24 NC Tap + No. 16 Drill Bit	80222
1/4" - 20 NC Tap + 13/64" Drill Bit	80230
1/4" - 28 NF Tap + No. 3 Drill Bit	80232
5/16" - 18 NC Tap + Letter G Drill Bit	80235
3/8" - 16 NC Tap + Letter O Drill Bit	80238
1/2" - 13 NC Tap + 27/64" Drill Bit	80242
1/4" - 18 NPT Tap + 7/16" Drill Bit	80260
6 mm - 1.00 Tap + 5mm Drill Bit	80327
8 mm - 1.25 Tap + 17/64" Drill Bit	80334
10 mm - 1.50 Tap + 8.5 Drill Bit	80340