

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® Machine Screw Taps (HCS)



1032



1132



1232

- Ideal for routine maintenance, repair work and for rethreading where high accuracy and tolerance thread is not critical
- 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 Stock #	Plug Bulk Stock #	Taper Bulk Stock #	Bottom Bulk Stock #
0 - 80 NF	2	—	1102	1002	1202
1 - 64 NC	2	—	1104	1004	1204
1 - 72 NF	2	—	1105	1005	1205
2 - 56 NC	3	—	1106	1006	1206
2 - 64 NF	3	—	1107	1007	1207
3 - 48 NC	3	—	1108	1008	1208
3 - 56 NF	3	—	1109	1009	1209
4 - 36 NS	3	8011	1111	1011	1211
4 - 40 NC	3	8012	1112	1012	1212
4 - 48 NF	3	—	1113	1013	1213
5 - 40 NC	3	—	1116	1016	1216
5 - 44 NF	3	—	1117	1017	1217
6 - 32 NC	3	8018	1118	1018	1218
6 - 36 NS	3	—	1119	1019	1219
6 - 40 NF	3	—	1120	1020	1220
6 - 48 NS	3	—	1121	1021	1221
8 - 32 NC	4	8024	1124	1024	1224
8 - 36 NF	4	—	1125	1025	1225
8 - 40 NS	4	—	1126	1026	1226
10 - 24 NC	4	8028	1128	1028	1228
10 - 32 NF	4	8031	1131	1031	1231
12 - 24 NC	4	8032	1132	1032	1232
12 - 28 NF	4	—	1133	1033	1233
12 - 32 NEF	4	—	1134	1034	1234
14 - 20 NS	4	8035	1135	1035	1235
14 - 24 NS	4	—	1136	1036	1236

HANSON Fractional Taps (HCS)



1323



1423



1523

- Ideal for routine maintenance, repair work and for rethreading where high accuracy and tolerance thread is not critical
- 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 Stock #	Plug Bulk Stock #	Taper Bulk Stock #	Bottom Bulk Stock #
1/8" - 40 NS	3	—	—	1306	1506
3/16" - 24 NS	4	—	1412	1312	1512
3/16" - 32 NS	4	—	1413	1313	1513
1/4" - 20 NC	4	8120	1420	1320	1520
1/4" - 24 NS	4	—	1421	1321	1521
1/4" - 28 NF	4	8123	1423	1323	1523
1/4" - 32 NEF	4	—	1424	1324	1524
1/4" - 40 NS	4	—	1425	1325	1525
5/16" - 18 NC	4	8127	1427	1327	1527
5/16" - 24 NF	4	8129	1429	1329	1529
5/16" - 32 NEF	4	—	1431	1331	1531
3/8" - 16 NC	4	8134	1434	1334	1534
3/8" - 24 NF	4	8136	1436	1336	1536
7/16" - 14 NC	4	8139	1439	1339	1539
7/16" - 20 NF	4	8140	1440	1340	1540
1/2" - 13 NC	4	8144	1444	1344	1544
1/2" - 20 NF	4	8145	1445	1345	1545
1/2" - 24 NS	4	—	1446	1346	1546
9/16" - 12 NC	4	8148	1448	1348	1548
9/16" - 18 NF	4	8149	1449	1349	1549
5/8" - 11 NC	4	8152	1452	1352	1552
5/8" - 18 NF	4	8154	1454	1354	1554
11/16" - 11 NS	4	—	1456	1356	1556
11/16" - 16 NS	4	—	1457	1357	1557
3/4" - 10 NC	4	8158	1458	1358	1558
3/4" - 16 NF	4	8160	1460	1360	1560
7/8" - 9 NC	4	—	1461	1361	1561
7/8" - 14 NF	4	—	1463	1363	1563
1" - 8 NC	4	—	1465	1365	1565
1" - 12 NF	4	—	1466	1366	1566
1" - 14 NS	4	—	1467	1367	1567

TAPS & DIES

HIGH CARBON STEEL COMBINATION SETS

HANSON® 66-pc Machine Screw/Fractional Tap & Hex Die Set



97606

TAPS & DIES

Set Contents		Stock # 97606
Thread Size	Tap Stock #	Die Stock #
Machine Screw	Plug Style	5/8" Hexagon
4 - 40 NC	1112	6112
6 - 32 NC	1118	6118
8 - 32 NC	1124	6124
10 - 24 NC	1128	6128
10 - 32 NF	1131	6131
12 - 24 NC	1132	6132
Fractional		1" Hexagon
1/4" - 20 NC	1420	6520
1/4" - 28 NF	1423	6523
5/16" - 18 NC	1427	6527
5/16" - 24 NF	1429	6529
3/8" - 16 NC	1434	6534
3/8" - 24 NF	1436	6536
7/16" - 14 NC	1439	6539
7/16" - 20 NF	1440	6540
1/2" - 13 NC	1444	6544
1/2" - 20 NF	1445	6545
		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" Hexagon
1/8" - 27 NPT	1902	6702
1/4" - 18 NPT	1903	7003
Threading Tools		Stock #
Adj. Die Stock - 1" Dies		11026
Adj. Die Stock - 1-7/16" Hexagon Dies		12436
Adj. Die Stock - 1-13/16" Hexagon Dies		12446
Plain Die Stock - 5/8" Hexagon Dies		12457
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
T-Handle Wrench - Taps No. 0 to 1/4"		12473
18 Leaf Standard Thread Pitch Gauge		11018