

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 |