

A-A-364
October 9, 1979

COMMERCIAL ITEM DESCRIPTION

TAP, THREAD CUTTING
(NPT AND NPS SERIES)

The General Services Administration has authorized the use of this commercial item description in lieu of Federal Specification GGG-T-581.

This commercial item description covers high speed steel taps with American Standard taper pipe threads (NPT) and American Standard straight pipe threads (NPS).

Salient characteristics:

Material. High speed steel.

Finish. Ground.

Chamfer. Threads chamfered from 2 to 3-1/2 threads on NPT taps and 3 to 5 threads on NPS taps.

Hardness. Rockwell C58 to 66.

Sizes. Shall be as follows:

<u>National Stock Number (NSN)</u>	<u>Tap size diameter - threads per inch</u>	<u>Thread series</u>	<u>Direction of rotation</u>
5136-00-189-7794	1/8 - 27	NPT	Left hand
5136-00-189-7795	1/4 - 18	NPT	Left hand
5136-00-189-7796	3/8 - 18	NPT	Left hand
5136-00-189-7797	1/2 - 14	NPT	Left hand
5136-00-189-7799	1 - 11 1/2	NPT	Left hand
5136-00-189-7800	1 1/4 - 11 1/2	NPT	Left hand
5136-00-189-7801	1 1/2 - 11 1/2	NPT	Left hand
5136-00-189-7802	2 - 11 1/2	NPT	Left hand
5136-00-189-7805	1/8 - 27	NPT	Right hand
5136-00-189-7806	1/4 - 18	NPT	Right hand
5136-00-189-7807	3/8 - 18	NPT	Right hand
5136-00-189-7808	1/2 - 14	NPT	Right hand
5136-00-237-8147	3/4 - 14	NPT	Right hand
5136-00-137-8148	1 - 11 1/2	NPT	Right hand
5136-00-237-8149	1 1/4 - 11 1/2	NPT	Right hand
5136-00-237-8153	3 - 8	NPT	Right hand
5136-00-889-5309	1/16 - 27	NPT	Right hand
5136-00-889-5312	1 1/4 - 11 1/2	NPS	Right hand
5136-00-889-5313	1 - 11 1/2	NPS	Right hand
5136-00-889-5314	3/4 - 14	NPS	Right hand
5136-00-889-5315	1/2 - 14	NPS	Right hand
5136-00-889-5316	3/8 - 18	NPS	Right hand
5136-00-889-5317	1/4 - 18	NPS	Right hand
5136-00-889-5318	1/8 - 27	NPS	Right hand
5136-00-889-5355	3/4 - 14	NPT	Left hand
5136-00-889-6967	1 1/2 - 11 1/2	NPS	Right hand
5136-00-889-6968	2 - 11 1/2	NPS	Right hand
5136-00-889-6976	1 1/2 - 11 1/2	NPT	Right hand
5136-00-889-6977	2 - 11 1/2	NPT	Right hand
5136-00-889-6978	2 1/2 - 8	NPT	Right hand

Tap marking. To be marked in a legible and permanent manner with the manufacturer's name or identifying trademark; thread size and series; "G" or "Ground" for ground finish; "HS," "HSS," or "High Speed" to indicate high speed steel; and "LH" or "Left hand" for left hand threads if applicable.

Workmanship. All taps shall be free from imperfections which may affect their appearance, serviceability, or durability.

A-A-364

Certification. The contractor shall certify that the product offered meets the salient characteristics of this description and that the product conforms to the producer's own drawings, specifications, standards, and quality assurance practices and is the same product offered for sale in the commercial marketplace. The Government reserves the right to require proof of such conformance prior to first delivery and thereafter as may be otherwise provided for under the provisions of the contract.

Recovered materials. The manufacturer shall utilize recovered materials to the maximum extent practicable.

Packaging, packing, and marking. The taps shall be packaged in accordance with normal commercial practice and packed to assure acceptance by common carrier and provide product protection against loss and damage during multiple shipments, handling, and storage. The shipping container shall be in compliance with National Motor Freight Classification and Uniform Freight Classification. Marking shall be in accordance with the contract or order.