

Screwing taps —

Part 1: Specification of general dimensions

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Committees responsible for this British Standard

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- British Electrical Systems Association (BEAMA Ltd.)
- Federation of British Engineers' Tool Manufacturers
- Screw Thread Tool Manufacturers' Association

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Foreword

The revision of this Part of BS 949 has been prepared under the direction of the Machine, Engineers and Hand Tools Standards Policy Committee. It supersedes BS 949-1:1976 which is withdrawn and those clauses and tables relating to the general dimensions of taps in BS 949-2:1979¹⁾.

In 1989 the European Committee for Standardization (CEN) endorsed ISO 2857 and ISO 5967, published by the International Organization for Standardization (ISO) as EN 22857:1989 and EN 25967:1989 respectively. Both were given the status of national standards without modification with the publication of BS 949-4 (identical to EN 22857) and BS 949-5 (identical to EN 25967) which fulfils the United Kingdom obligations as a member of CEN in this respect.

BS 949-1:1976 has been revised to withdraw any conflicting requirements with EN 22857 and EN 25967 and is technically equivalent to Parts of ISO 529¹⁾ and ISO 2283 with amendment 01:1977, both of which were not adopted by CEN.

When the revisions are complete, BS 949 will consist of the following Parts.

- *Part 1: Specification of general dimensions;*
- *Part 2: Specification of unified thread taps — manufacturing tolerances¹⁾;*
- *Part 3: Specification for pipe thread taps¹⁾;*
- *Part 4: Specification for metric thread taps — manufacturing tolerances (identical to EN 22857);*
- *Part 5: Nomenclature and terminology (identical to EN 25967).*

A British Standard does not purport to include all the necessary provisions of a contract. Users of British Standards are responsible for their correct application.

Compliance with a British Standard does not of itself confer immunity from legal obligations.

Summary of pages

This document comprises a front cover, an inside front cover, pages i and ii, pages 1 to 10, an inside back cover and a back cover.

This standard has been updated (see copyright date) and may have had amendments incorporated. This will be indicated in the amendment table on the inside front cover.

¹⁾ Revision in preparation.

Section 1. General

0 Introduction

0.1 Types of tap

Two types of tap are specified in this Part of BS 949, namely short machine or hand taps (see **0.2**) and long shank machine taps (see **0.3**).

0.2 Short machine or hand taps

The short machine or hand taps are specified in three patterns which differ in the shank of the tap, not in the threaded portion. The three patterns are:

- a) taps in the size range over 0.9 mm and up to 2.8 mm which have a full diameter shank and a tapered connecting portion between the threaded portion and the shank (see Figure 1);
- b) taps in the size range over 2.8 mm and up to 10.0 mm which have a full diameter shank and a neck between the threaded portion and the shank (see Figure 2);
- c) taps in the size range over 10.0 mm and up to 101.6 mm which have a reduced diameter shank (see Figure 3).

0.3 Long shank machine taps

The long shank machine tap (size range over 2.8 mm and up to 26.5 mm) is a tap with a reduced diameter shank (see Figure 4) but, for a given size of tap, the shank length is greater than that of the short tap.

1 Scope

1.1 This Part of this British Standard specifies the general dimensions and tolerances for screwing taps for the following threads:

- a) ISO metric coarse pitch series threads complying with BS 3643;
- b) ISO metric fine pitch series threads complying with BS 3643;
- c) Unified (ISO inch) general-purpose screw threads, coarse thread series (UNC), from No. 1 to No. 12 and from $\frac{1}{4}$ in to 4 in diameter complying with BS 1580-1, BS 1580-2 and BS 1580-3;
- d) Unified (ISO inch) general-purpose screw threads, fine thread series (UNF), from No. 0 to No. 12 and from $\frac{1}{4}$ in to $1\frac{1}{2}$ in diameter complying with BS 1580-1, BS 1580-2 and BS 1580-3;
- e) British Standard Whitworth (BSW) threads from $\frac{1}{8}$ in to 4 in diameter and British Standard Fine (BSF) threads from $\frac{3}{16}$ in to 3 in diameter complying with BS 84;
- f) British Association (BA) threads from No. 14 to No. 0 complying with BS 93.

1.2 The sizes of taps specified include those suitable for the tapped holes for sparkings plugs and those suitable for the tapped holes for fittings for steel conduit specified in BS 4568.

NOTE The titles of the publications referred to in this standard are listed on the inside back cover.