

CHAMPION

Interrupted Thread Taper Pipe Taps

List No. 324I

NPT / Ground Thread / HSS

Description: For threading a wide variety of materials, both ferrous and non ferrous, where chip disposal is a problem.

Application: For materials which are difficult to work in, such as stainless steel, titanium and bronzes.



The first few threads are full and the balance interrupted, to reduce drag while taper pipe threading. Easier for the lubricant to reach the cutting edges. Reduces the friction and tapping torque.

EDP No. / Size	No. of Flutes	Length of Thread	Overall Length
324I-1/8-27	5	3/4	2-1/8
324I-1/4-18	5	1-1/16	2-7/16
324I-3/8-18	5	1-1/16	2-9/16
324I-1/2-14	5	1-3/8	3-1/8
324I-3/4-14	5	1-3/8	3-1/4

EDP No. / Size	No. of Flutes	Length of Thread	Overall Length
324I-1-11-1/2	5	1-3/4	3-3/4
324I-1-1/4-11-1/2	5	1-3/4	4
324I-1-1/2-11-1/2	7	1-3/4	4-1/4
324I-2-11-1/2	7	1-3/4	4-1/2

CHAMPION

Straight Pipe Taps

List No. 325

NPS / Ground Thread / HSS

Description: Identical with Taper style but have a straight thread.

Application: For tapping holes or couplings. For low pressure work to assemble with taper threaded pipe or fittings to secure a tight joint when a sealer is used.



EDP No. / Size	No. of Flutes	Length of Thread	Overall Length
325-1/8-27	4	3/4	2-1/8
325-1/4-18	4	1-1/16	2-7/16
325-3/8-18	4	1-1/16	2-9/16

EDP No. / Size	No. of Flutes	Length of Thread	Overall Length
325-1/2-14	4	1-3/8	3-1/8
325-3/4-14	5	1-3/8	3-1/4
325-1-11-1/2	5	1-3/4	3-3/4

CHAMPION

Carbon Steel Taper Pipe Taps

List No. 304

NPT / 3/4" taper/ft. / Carbon Steel

Description: Nominal size is that of the pipe fitting to be tapped.

Application: Retreading, cleaning up damaged and rusty threads.



Diameter of tap increases from the entering end of the thread portion at the rate of 3/4" per foot; the angle formed by the sides of the thread is 60°.

EDP No. / Size	No. of Flutes	Length of Thread	Overall Length
304-1/8-27	4	3/4	2-1/8
304-1/4-18	4	1-1/16	2-7/16
304-3/8-18	4	1-1/16	2-9/16
304-1/2-14	4	1-3/8	3-1/8
304-3/4-14	5	1-3/8	3-1/4

EDP No. / Size	No. of Flutes	Length of Thread	Overall Length
304-1-11-1/2	5	1-3/4	3-3/4
304-1-1/4-11-1/2	5	1-3/4	4
304-1-1/2-11-1/2	6	1-3/4	4-1/4
304-2-11-1/2	6	1-3/4	4-1/2