

## SAE Straight Thread Port Tapping Tools

Taps are available for SAE J1926-1 female straight thread ports in sizes 2 through 32. Taps are bottoming type and made from high speed tool steel.

SAE Dash Size	Overall Length (in.)	Shank Dia. (in.)	Wrench Flat Size (in.)	Part No.
2	2 23/32	0.318	0.238	5/16X24 UNF-2B
3	2 15/16	0.381	0.286	3/8X24 UNF-2B
4	3 5/16	0.323	0.242	7/16X20 UNF-2B
5	3 3/8	0.367	0.275	1/2X20 UNF-2B
6	3 19/32	0.429	0.322	9/16X18 UNF-2B
8	4 1/4	0.590	0.442	3/4X16 UNF-2B
10	4 11/16	0.697	0.523	7/8X14 UNF-2B
12	5 1/8	0.896	0.672	1 1/16X12 UNF-2B
14	5 7/16	1.021	0.766	1 3/16X12 UNF-2B
16	5 3/4	1.108	0.831	1 5/16X12 UNF-2B
20	6 11/16	1.305	0.979	1 5/8X12 UNF-2B
24	7 5/16	1.519	1.139	1 7/8X12 UNF-2B
32	8 3/4	2.100	1.575	2 1/2X12 UNF-2B



Fig. S82 — SAE Straight Thread Port Tapping Tool

## SAE Straight Thread Port Counterboring Tools

Parker offers counterboring tools for SAE J1926-1 female straight thread ports in sizes 2 through 32. Counterbores are 4-fluted high speed tool steel.

SAE Dash Size	Shank Dia. (in.)	Shank Length (in.)	Overall Length (in.)	Recommended Pilot Drill or Bore Size (in.)	Part No.
2	1/2	1 1/2	2 1/2	0.266	Y-34730
3	1/2	1 1/2	2 1/2	0.328	Y-34731
4	1/2	1 1/2	2 41/64	0.377	Y-34732
5	1/2	1 1/2	2 41/64	0.438	Y-34733
6	3/4	1 1/2	2 47/64	0.500	Y-34734
8	3/4	1 1/2	2 53/64	0.672	Y-34735
10	1	2	3 29/64	0.797	Y-34736
12	1	2	3 19/32	0.969	Y-34737
14	1	2	3 41/64	1.095	Y-34738
16	1	2	3 41/64	1.220	Y-34739
20	1 1/2	2	3 37/64	1.530	Y-34740
24	1 1/2	2	3 37/64	1.780	Y-34741
32	1 1/2	2	3 49/64	2.405	Y-34743



Fig. S83 — SAE Straight Thread Port Counterboring Tool

\* See [Appendix](#) for recommended use of port tools.

Dimensions and pressures for reference only, subject to change.