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**NATIONAL STANDARD OF THE
PEOPLE'S REPUBLIC OF CHINA**

GB/T 3464.1-2007

Replacing GB/T 3464.1-2007, GB/T 3464.3-2007

**Machine and hand taps-Part 1: Plain parallel shank machine and
hand taps**

机用和手用丝锥 第1部分：通用柄机用和手用丝锥

(English Translation)

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Foreword

This document complies with the provisions of GB/T 1.1-2020 "Standardization Work Guidelines Part 1: Structure and Drafting Rules of Standardization Documents".

Drafting.

This document supersedes GB/T 3464.1-2007 "Machine and hand taps - Part 1: General purpose shank machine and hand taps" and GB/T 3464.3-2007 "Machine and Hand Taps -

Part 3: Short Shank Machine and Hand Taps". This document is based on GB/T 3464.1-Based on 2007, it integrates the content of GB/T 3464.3-2007.Compared with GB/T 3464.1-2007, apart from structural adjustments and editorial changes...

Aside from the changes, the main technical changes are as follows.

- a) Increased tolerances for standard thread tap dimensions (see Tables 1-6);
- b) A unified thread tap type and size have been added (see Chapter 5);
- c) Added Whitworth thread tap types and sizes (see Chapter 6);
- d) Added "markers" (see Chapter 7);
- e) Added "Thread Profile, Basic Dimensions, and Tolerances" (see Chapter 8);
- f) Added technical specifications for unified thread taps and Whitworth thread taps (see Chapter 9);
- g) Added "Detection Methods" (see Chapter 10);
- h) The nominal cutting angle of the tap has been removed (see 3.6 of GB/T 3464.1-2007).

This document is modified to adopt ISO 529:2017 "Short taps for machine and hand use".

This document has undergone the following structural adjustments compared to ISO 529:2017.

---Chapter 4 corresponds to Chapter 4 of ISO 529:2017, where 4.2 corresponds to 4.1.3 and 4.2 of ISO 529:2017;

---Chapter 5 corresponds to Chapter 5 of ISO 529:2017, where 5.2 corresponds to 5.1.3 and 5.2 of ISO 529:2017;

Tables 1 and 2 correspond to Table 1 of ISO 529:2017, Tables 3 and 4 correspond to Table 2 of ISO 529:2017, and Table 5 corresponds to...

Tables 3 and 4, 6 and 8 of ISO 529:2017 correspond to Tables 3 and 5, 7 and 8 of ISO 529:2017.

Tables 6, 9, and 10 of ISO 529:2017 correspond to Table 7 of ISO 529:2017, and Table 11 corresponds to Table 8 of ISO 529:2017.

Tables 9 and 12 correspond to Tables 8 and 10 of ISO 529:2017, and Tables 13 and 14 correspond to Tables 8 and 10 of ISO 529:2017.

Tables 11, 15, and 16 correspond to Table 12 of ISO 529:2017;

---Chapters 7 through 11 have been added;

---Appendix D has been added.

The technical differences between this document and ISO 529:2017, and the reasons

therefor, are as follows.

---ISO 237 (see Chapter 4) has been replaced with the normatively referenced GB/T 4267 to adapt to my country's technical conditions;

---The tap type diagram has been modified (see Figures 2, 3, and 5-8) to meet domestic usage requirements;

---Added standard thread fine-pitch tap specifications (see Table 6) to meet domestic usage needs;

---The BA series thread taps (see section 6.2 of ISO 529:2017) have been removed to suit my country's technical requirements;

---The designation "5/16-18BSW" for fine-shank Whitworth threads with coarse-pitch taps has been modified to allow for a concave neck (see Table 15) to meet the requirements.

Needs for machining through holes;

---Added markers (see Chapter 7) to meet the needs of domestic production and user applications;

---Added thread profile, basic dimensions, and tolerances, and added normative references to GB/T 192, GB/T 196, and GB/T 968.

GB/T 20668, GB/T 20669, JB/T 8824.2 and JB/T 8825.2 (see Chapter 8) are used to meet the needs of domestic production and users.

Usage requirements;

---Technical requirements have been added, and normative references to GB/T 969, JB/T 8824.3, and JB/T 8825.3 have been added (see page 9).

Chapter), to meet the needs of domestic production and user use;

---The testing methods have been added, and the normative reference JB/T 10231.4 (see Chapter 10) has been added to meet the needs of domestic production and users.

Usage requirements;

---Supply conditions have been improved (see Chapter 11) to meet the needs of domestic production and user applications.

The following editorial changes have been made to this document.

---To align with existing standards, the standard name has been changed to "Machine and Hand Taps";

---Note 3 has been deleted from the range;

---Added Appendix D (Informative) "Single or Group Taps".

Please note that some content in this document may involve patents. The issuing organization of this document assumes no responsibility for identifying patents.

This document was proposed by the China Machinery Industry Federation.

This document is under the jurisdiction of the National Technical Committee on Standardization of Cutting Tools (SAC/TC91).

1 Scope

This document specifies the general dimensions, markings, thread profiles, basic dimensions and tolerances, technical specifications, and supply conditions for machine and hand taps.

The requirements are described, and the testing methods for machine-made and hand-made taps are presented.

This document applies to the manufacture of taps for machining standard threads, uniform threads, and Whitworth threads.

Note 1: For taps whose thread diameter and pitch are not listed in the table, see Table A.1 in Appendix A.

Note 2: Appendix B provides a summary of GB/T 4267 regarding the diameter of the handle and the dimensions of the drive square head.

Note 3: The relationship between the codes in this document and the symbols in ISO 13399 (all parts) is given in Appendix C.

Note 4: General dimensions are determined based on the thread diameter and pitch, including thread length (maximum value), total length, shank diameter, square head size, and shank...

The dimensions of the connection portion (neck) between the main body and the threaded portion.

2 Normative references

The contents of the following documents, through normative references within the text, constitute essential provisions of this document. Dated citations are not included.

Only the version corresponding to that date applies to this document; for undated references, the latest version (including all amendments) applies.

document.

GB/T 192 Standard thread profiles (GB/T 192-2025, ISO 68-1:2023, MOD) GB/T 196 Basic Dimensions of Ordinary Threads (GB/T 196-2025, ISO 724:2023, MOD) GB/T 968 Tolerances for Tap Threads (GB/T 968-2007, ISO 2857:1973, MOD) GB/T 969 Technical Requirements for Taps (GB/T 969-2007, ISO 8830:1991, MOD) GB/T 4267 Dimensions of