



For Stainless Steels, Alloy Steels and Ductile Irons

Spiral Pointed Taps for Stainless Steels For Unified Threads

ZELX SS Spiral Pointed Taps are designed for difficult jobs including the stainless steel family of materials as well as alloy steels, high carbon steel and ductile irons. Our unique design ZELX SS taps increase productivity through longer tool life. The unique spiral point chamfer makes them ideally suited for the through hole of difficult to machine materials.

ZELX SS



ZELX SS have an Oxide Surface Treatment
Custom Blend High Vanadium HSS

ZELX SS taps are suitable for UNJ Aerospace internal threading applications.

Plug Style (3 to 5 threads chamfered) List 3218 Machine Screw sizes with oxide surface treatment
Fractional sizes with oxide surface treatment

TPI Nominal NC Size	NF UNC	NF UNF	No. of Flutes	Pitch Diameter Limit/ EDP Numbers						Dimensions		
				H2	H3	H4	H5	H6	H7	Length of Thread	Neck Length	Length Overall
2	56	—	2	382623	382624	—	—	—	—	.256	.181	1- 3/4
3	48	—	2	382600	—	—	—	—	—	.295	.205	1- 13/16
4	40	—	2	382601	382602	382612	382634	—	—	.335	.227	1- 7/8
4	—	48	2	382683	—	—	—	—	—	.335	.227	1- 7/8
5	—	40	3	382603	—	—	—	—	—	.374	.251	1- 15/16
6	32	—	3	382604	382605	382608	382635	382659	382665	.413	.274	2
6	—	40	3	382684	382642	—	—	—	—	.413	.274	2
8	32	—	3	382606	382607	382629	382637	382660	382667	.453	.297	2- 1/8
8	—	36	3	382686	—	—	—	—	—	.453	.297	2- 1/8
10	24	—	3	—	382609	—	382639	382690	382669	.531	.344	2- 3/8
10	—	32	3	382611	382610	382630	382640	382661	382670	.531	.344	2- 3/8
12	24	—	3	—	382688	—	—	—	—	.571	.366	2- 3/8
12	—	28	3	—	382689	—	—	—	—	.571	.366	2- 3/8
1/4	20	—	3	—	382613	—	382643	382590	382673	.591	.409	2- 1/2
1/4	—	28	3	—	382614	382631	382644	382662	382674	.591	.409	2- 1/2
5/16	18	—	3	—	382615	—	382645	—	382675	.669	.456	2- 23/32
5/16	—	24	3	—	382616	382632	382646	382663	382676	.669	.456	2- 23/32
3/8	16	—	3	—	382617	—	382647	—	382668	.748	.502	2- 15/16
3/8	—	24	3	—	382618	382633	382648	382664	382678	.748	.502	2- 15/16
7/16	14	—	3	—	382619	—	382649	—	—	.866	—	3- 5/32
7/16	—	20	3	—	382620	—	382650	382691	382680	.866	—	3- 5/32
1/2	13	—	3	—	382621	—	382651	—	382681	.984	—	3- 3/8
1/2	—	20	3	—	382622	—	382652	382692	382682	.984	—	3- 3/8
9/16	12	—	3	—	382653	—	—	—	—	.984	—	3- 19/32
9/16	—	18	3	—	382654	—	—	—	—	.984	—	3- 19/32
5/8	11	—	3	—	382625	—	382655	—	—	1.083	—	3- 13/16
5/8	—	18	3	—	382626	382636	382656	382694	382591	1.083	—	3- 13/16
3/4	10	—	3	—	382627	—	382657	—	—	1.201	—	4- 1/4
3/4	—	16	3	—	382628	—	382658	—	382592	1.201	—	4- 1/4

Necked design enhances flow of cutting fluid to cutting teeth and reduces surface contact between the tool and work-piece for more efficient threading.

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