

# STI Spiral Pointed Taps For Nickel Base Alloys

For Unified Threads

ZELX NI Taps have been designed for extended tap life in Cobalt, Nickel, and Iron base exotic materials such as: Inconel, Hatelloy, Waspalloy and harder stainless Steels, Mold and Tool Steels >30HRC.

## ZELX NI STI



ZELX NI STI have an Oxide and Nitride Surface Toughening Treatment  
PM High Speed Steel

STI taps are oversize to the extent that the internal thread which they produce will accommodate a helical coil wire screw thread insert, which at final assembly will accept a screw thread of the nominal size and pitch.

Plug Style (3 to 5 threads chamfered)				List	3619 3629	Machine Screw Sizes Fractional Sizes				
Nominal Size	TPI NC UNC	NF UNF	No. of Flutes	Pitch Diameter Limit/ EDP Numbers				Dimensions		
				H1	H2	H3	H4	Length of Thread	Neck Length	Length Overall
2	56	—	2	—	387200	—	—	.335	.227	1- 7/8
4	40	—	3	387203	387204	—	—	.413	.274	2
6	32	—	3	—	387208	387224	—	.531	.344	2- 3/8
6	—	40	3	—	387209	—	—	.453	.297	2- 1/8
8	32	—	3	—	387210	387226	—	.571	.366	2- 3/8
10	24	—	3	—	387212	387228	—	.591	.409	2- 1/2
10	—	32	3	—	387213	387229	—	.591	.409	2- 1/2
1/4	20	—	3	—	387248	387258	—	.669	.456	2- 23/32
1/4	—	28	3	—	387249	387259	—	.669	.456	2- 23/32
5/16	18	—	3	—	—	387260	387272	.748	.502	2- 15/16
5/16	—	24	3	—	387251	387261	—	.748	.502	2- 15/16
3/8	16	—	3	—	—	387262	387270	.984	—	3- 3/8
3/8	—	24	3	—	387253	387263	—	.866	—	3- 5/32
7/16	14	—	3	—	—	387264	—	.984	—	3- 19/32
7/16	—	20	3	—	—	387265	387275	.984	—	3- 3/8
1/2	13	—	3	—	—	387266	—	1.083	—	3- 13/16
1/2	—	20	3	—	—	387267	—	.984	—	3- 19/32

### Recommended Minor Diameters and Tap Drills for Inch Size STI

Nominal Size STI	Threads per Inch		Aluminum Recommended Drill		Plastic- Steel- Magnesium Recommended Drill	
	UNC	UNF	Nominal Size	Dec. Equiv.	Nominal Size	Dec. Equiv.
2	56	—	3/32	.0938	.41	.0960
4	40	—	31	.1200	31	.1200
6	32	—	26	.1470	25	.1495
8	32	—	17	.1730	16	.1770
10	24	—	13/64	.2031	5	.2055
10	—	32	7	.2010	13/64	.2031
1/4	20	—	H	.2660	H	.2660
1/4	—	28	G	.2610	6,7mm	.2638
5/16	18	—	Q	.3320	Q	.3320
5/16	—	24	21/64	.3281	21/64	.3281
3/8	16	—	X	.3970	X	.3970
3/8	—	24	25/64	.3906	25/64	.3906
7/16	14	—	29/64	.4531	29/64	.4531
7/16	—	20	29/64	.4531	29/64	.4531
1/2	13	—	33/64	.5156	17/32	.5312
1/2	—	20	33/64	.5156	17/32	.5312