



Spiral Fluted Taps for Non-Ferrous Materials

For Unified Threads

ZELX ALS



*ZELX ALS have a Nitride Surface Toughening Treatment
Custom Blend High Vanadium HSS

For Silicon Die Cast Aluminum Alloys, Soft
Plastics and Copper Alloys.

25° Spiral Fluted Taps

Modified Bottoming (2- 1/2 to 3 threads chamfered)
DIN lengths with ANSI shank dimensions.

List 3804 Machine Screw Sizes
3834 Fractional Sizes

TPI Nominal Size	NC UNC	NF UNF	No. of Flutes	Pitch Diameter Limit/ EDP Numbers				Dimensions		
				H2	H3	H4	H5	Length of Thread	Neck Length	Length Overall
2	56	—	2	386400	—	—	—	.276	.196	1.772
4	40	—	2	386401	—	—	—	.433	.276	2.205
5	40	—	3	386402	—	—	—	.433	.276	2.205
6	32	—	3	—	386403	—	—	.512	.275	2.205
8	32	—	3	—	386404	—	—	.512	.315	2.480
10	24	—	3	—	386405	—	—	.630	.354	2.756
10	—	32	3	—	386406	—	—	.630	.354	2.756
1/4	20	—	3	—	386407	—	386408	.748	.433	3.150
1/4	—	28	3	—	386409	386411	—	.748	.433	3.150
5/16	18	—	3	—	386412	—	386413	.866	.512	3.543
5/16	—	24	3	—	386414	386415	—	.866	.512	3.543
3/8	16	—	3	—	386416	—	386417	.945	.590	3.937
3/8	—	24	3	—	386418	386419	—	.787	.748	3.543
7/16	14	—	3	—	386420	—	386421	.945	—	3.937
7/16	—	20	3	—	386422	—	386423	.945	—	3.937
1/2	13	—	3	—	386424	—	386425	1.142	—	4.331
1/2	—	20	3	—	386426	—	386427	.866	—	3.937

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

Spiral Fluted Taps for Non-Ferrous Materials

For Metric Threads

ZELX ALS

Modified Bottoming (2- 1/2 to 3 threads chamfered)
DIN lengths with ANSI shank dimensions.

List 3874 Metric Sizes

Nominal Size	No. of Flutes	Pitch Diameter Limit/ EDP Numbers				Dimensions		
		D3	D4	D5	D6	Length of Thread	Neck Length	Length Overall
M3 X 0.5	3	386428	—	—	—	.433	.276	2.205
M3.5 X 0.6	3	—	386429	—	—	.512	.275	2.205
M4 X 0.7	3	—	386430	—	—	.512	.315	2.480
M5 X 0.8	3	—	386431	—	—	.630	.354	2.756
M6 X 1	3	—	—	386432	—	.748	.433	3.150
M7 X 1	3	—	—	386433	—	.748	.433	3.150
M8 X 1	3	—	—	386434	—	.866	.512	3.543
M8 X 1.25	3	—	—	386435	—	.866	.512	3.543
M10 X 1.25	3	—	—	386436	—	.945	.590	3.937
M10 X 1.5	3	—	—	—	386437	.945	.590	3.937
M12 X 1.25	3	—	—	386438	—	.866	—	3.937
M12 X 1.5	3	—	—	386439	—	.866	—	3.937
M12 X 1.75	3	—	—	—	386440	1.142	—	4.331

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