



# Thread Forming Taps for Non-Ferrous Materials

For Unified Threads

## N-RS



N-RS have a Nitride Surface Toughening Treatment  
Custom Blend High Vanadium HSS

For Aluminums, Brass, Copper Alloys  
(Non-Ferrous Materials).

Improved performance, new tap design.

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

List 3550 Machine Screw Sizes  
3552 Fractional Sizes

Nominal Size	TPI		No. of Lobe Grooves	Pitch Diameter Limit/ EDP Numbers						Dimensions		
	UNC UNJC	UNF UNJF		H2	H3	H4	H5	H6	H7	Length of Thread	Neck Length	Length Overall
0	—	80	0	388410	—	—	—	—	—	.315	—	1.575
1	64	—	0	388411	—	—	—	—	—	.315	—	1.575
1	—	72	0	388412	—	—	—	—	—	.315	—	1.575
2	56	—	0	388413	388414	—	—	—	—	.354	—	1.772
2	—	64	0	388415	388416	—	—	—	—	.354	—	1.772
3	48	—	0	388417	388418	—	—	—	—	.276	.217	1.969
3	—	56	0	388419	388420	—	—	—	—	.276	.217	1.969
4	40	—	0	—	388421	—	388422	—	—	.433	.276	2.205
4	—	48	0	—	388425	—	388426	—	—	.433	.276	2.205
5	40	—	1	—	388429	—	388430	—	—	.433	.276	2.205
5	—	44	1	—	388433	—	388434	—	—	.433	.276	2.205
6	32	—	1	—	388437	—	388438	—	—	.512	.276	2.205
6	—	40	1	—	388442	—	388443	—	—	.512	.276	2.205
8	32	—	1	—	388446	—	388447	—	—	.512	.315	2.480
8	—	36	1	—	388450	—	388451	—	—	.512	.315	2.480
10	24	—	1	—	—	388454	—	388455	—	.630	.354	2.756
10	—	32	1	—	—	388458	—	388459	—	.630	.354	2.756
12	24	—	1	—	—	388462	—	388463	—	.630	.354	3.150
12	—	28	1	—	—	388466	—	388467	—	.630	.354	3.150
1/4	20	—	1	—	—	388470	—	388471	—	.748	.433	3.150
1/4	—	28	1	—	—	388474	—	388475	—	.748	.433	3.150
5/16	18	—	1	—	—	—	388478	—	388479	.866	.512	3.543
5/16	—	24	1	—	—	—	388482	—	388483	.866	.512	3.543
3/8	16	—	1	—	—	—	388486	—	388487	.945	.591	3.937
3/8	—	24	1	—	—	—	388490	—	388491	.787	.748	3.543
7/16	14	—	1	—	—	—	388494	—	388495	.945	—	3.937
7/16	—	20	1	—	—	—	388498	—	388499	.945	—	3.937
1/2	13	—	1	—	—	—	388504	—	388505	1.142	—	4.331
1/2	—	20	1	—	—	—	388508	—	388509	.866	—	3.937

N-RS Roll taps can be run 1.5 times faster than the tapping speeds recommended for thread cutting taps