



## High Performance Thread Forming Taps For Unified Threads

# ZELX HP-RZ



HP-RZ have a TiCN Surface Treatment  
PM High Speed Steel

For Stainless Steels, Low, Medium, High Carbon  
Steels <35HRC.

HP-RZ Roll taps can be run 2 times faster than the tapping  
speeds recommended for thread cutting taps. Taps have a  
TiCN coating for tapping with coolant.

Plug Style (3 to 5 threads chamfered)  
DIN lengths with ANSI shank dimensions.

List 3502 Machine Screw Sizes  
3512 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
6	32	—	2	—	386810	—	386811	—	—	.512	.276	2.205
8	32	—	2	—	386814	—	386815	—	—	.512	.375	2.480
10	24	—	2	—	—	386818	—	386819	—	.630	.354	2.756
10	—	32	2	—	—	386822	—	386823	—	.630	.354	2.756
1/4	20	—	2	—	—	386826	—	386827	—	.748	.433	3.150
1/4	—	28	2	—	—	386830	—	386831	—	.748	.433	3.150
5/16	18	—	3	—	—	—	386834	—	386835	.866	.512	3.543
5/16	—	24	3	—	—	—	386838	—	386839	.866	.512	3.543
3/8	16	—	3	—	—	—	386842	—	386843	.945	.591	3.937
3/8	—	24	3	—	—	—	386846	—	386847	.787	.748	3.543
7/16	14	—	4	—	—	—	386850	—	386851	.945	—	3.937
7/16	—	20	4	—	—	—	386854	—	386855	.945	—	3.937
1/2	13	—	4	—	—	—	386858	—	386859	1.142	—	4.331
1/2	—	20	4	—	—	—	386862	—	386863	.866	—	3.937