



## High Performance Thread Forming Taps for Dry Tapping For Unified Threads

### ZELX OL-RZ



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

For Stainless Steels, and Other Soft, Low and Carbon Steels

OL-RZ Roll Taps can be run 1.5 to 2 times faster than the tapping speeds recommended for thread cutting taps. Taps can be run dry or with mist coolant. Taps have TiCN coating for coolant free roll tapping.

Designed for shallow hole tapping < 1-1/2 diameters in depth

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

List 3502 Machine Screw Sizes  
3512 Fractional Sizes

TPI Nominal Size	UNC UNJC	UNF UNJF	No. of Lobe Grooves	Pitch Diameter Limit/ EDP Numbers					Dimensions			
				H2	H3	H4	H5	H6	Length of Thread	Neck Length	Length Overall	
2	56	—	0	—	386600	—	—	—	—	.354	—	1.772
4	40	—	0	—	—	—	386601	—	—	.433	.276	2.205
4	—	48	0	—	—	—	386602	—	—	.433	.276	2.205
5	40	—	0	—	—	—	386603	—	—	.433	.276	2.205
6	32	—	0	—	—	—	386604	—	—	.512	.275	2.205
8	32	—	0	—	—	—	386605	—	—	.512	.315	2.480
10	24	—	0	—	—	—	—	386606	—	.630	.354	2.756
10	—	32	0	—	—	—	—	386607	—	.630	.354	2.756
1/4	20	—	0	—	—	—	—	386608	—	.748	.433	3.150
1/4	—	28	0	—	—	—	—	386609	—	.748	.433	3.150



## High Performance Thread Forming Taps for Dry Tapping For Metric Threads

### ZELX OL-RZ



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PM High Speed Steel

For Stainless Steels, and Other Soft, Low and Carbon Steels

OL-RZ Roll Taps can be run 1.5 to 2 times faster than the tapping speeds recommended for thread cutting taps. Taps can be run dry or with mist coolant. Taps have TiCN coating for coolant free roll tapping.

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

List 3570 Metric Sizes

Nominal Size	No. of Lobe Grooves	Pitch Diameter Limit/ EDP Numbers				Dimensions		
		D5	D6	D7	D8	Length of Thread	Neck Length	Length Overall
M3 X 0.5	0	386610	—	—	—	.433	.276	2.205
M3.5 X 0.6	0	—	386611	—	—	.512	.275	2.205
M4 X 0.7	0	—	386612	—	—	.512	.315	2.480
M5 X 0.8	0	—	—	386614	—	.630	.354	2.756
M6 X 1	0	—	—	—	386615	.748	.433	3.150