

**【Question】**

What is Hot Dip Zincing ?  
Any taps exclusive to Hot Dip Zincing ?

**【Answer】**

Hot Dip Zincing is a plating method. It is available when fairly thick coating is required.  
When Hot Dip Zincing is needed, you can use special over sized taps (normally 0.3mm to 0.6mm larger in pitch diameter) to create internal screw threads before plating.

**【Guide】**

### Hot Dip Zincing

A plating method with which to create taitanic coat on the surface by drenching steel lumber in the zinc melted at high temperatures. (Titanic coated steel lumber is rust and erosion resistant.)

#### Applications

Swimming pool, roads, bridges, civel engineering, overhead



### Guideline for selection of taps

Confirm the coating thickness is.  
Pitch diameter shall be defined larger in consideration that the diameter will decrease after plating.  
Those pitch diameters are difined by JIS standard.  
(See table on the right.)  
Normally, it is a common practice to define sizes of the taps by 0.3mm or 0.6mm over for the Class 2 screw threads exclusive to Hot Dip Zincing.

(Defined in JISB 0290-5 • 1048) (mm)

Size	Pitch	Pitch Diameter
M10	1.5	+0.510 to +0.310
M12	1.75	+0.565 to +0.335
M14 M16	2	+0.632 to +0.350
M18 M20 M22	2.5	+0.754 to +0.350
M24	3	+0.950 to +0.360

**【Recommendation】**

It is not easy to select suitable over sized taps for Hot Dip Zincing because of fluctuated coating thickness. Please select appropriate taps to meet your conditions from our lineups of M10 to M30 size range for SP II(Class 2) over sized by 0.3mm.  
(Plug gages are also available for checking internal screw threads before plating.)