Hot dip zincing and the class of tap to select

【Question】
What is Hot Dip Zinking?
Any taps exclusive to Hot Dip Zinking?

【Answer】
Hot Dip Zinking is a plating method. It is available when fairly thick coating is required. When Hot Dip Zinking 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 Zinking
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 defined 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 Zinking.

<table>
<thead>
<tr>
<th>Size</th>
<th>Pitch</th>
<th>Pitch Diameter</th>
</tr>
</thead>
<tbody>
<tr>
<td>M10</td>
<td>1.5</td>
<td>+0.510 to +0.310</td>
</tr>
<tr>
<td>M12</td>
<td>1.75</td>
<td>+0.565 to +0.335</td>
</tr>
<tr>
<td>M14 M16</td>
<td>2</td>
<td>+0.632 to +0.350</td>
</tr>
<tr>
<td>M18 M20 M22</td>
<td>2.5</td>
<td>+0.754 to +0.350</td>
</tr>
<tr>
<td>M24</td>
<td>3</td>
<td>+0.950 to +0.360</td>
</tr>
</tbody>
</table>

(Defined in JISB 0290-5・1048)

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.)