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# Spiral Fluted Taps for Stainless Steels

For Unified Threads

For Stainless Steels, Alloy Steels and Ductile Irons

## ZELX SS



ZELX SS have an Oxide Surface Treatment  
Custom Blend High Vanadium HSS

ZELX SS Spiral Flute Taps are designed for difficult jobs including the stainless steel family of materials as well as alloy steels, high carbon steel and ductile irons. Our unique design ZELX SS taps increase productivity through longer tool life. The modified bottom chamfer makes them ideally suited to blind hole tapping.

ZELX Spiral Fluted Taps are oxide surface treated or Titanium Nitride (TiN) coated to reduce loading and galling of product material, improving tap wear life and thread quality.

ZELX SS taps are suitable for UNJ Aerospace internal threading applications.

- List 3218 Machine Screw sizes with oxide surface treatment
- 3228 Fractional sizes with oxide surface treatment
- 3218T Machine Screw sizes with TiN (Titanium Nitride)
- 3228T Fractional sizes with TiN (Titanium Nitride)

Modified Bottoming Style  
(2- 1/2 to 3- 1/2 threads chamfered)

Nominal Size	TPI NC UNC	NF UNF	No. of Flutes	Pitch Diameter Limit/ EDP Numbers									Dimensions			
				H2	H2 TIN	H3	H3 TIN	H4	H5	H5 TIN	H6	H7	Length of Thread	Neck Length	Length Overall	
2	56	—	2	384623	—	—	—	—	—	—	—	—	—	.157	.280	1- 3/4
3	48	—	2	384600	—	—	—	—	—	—	—	—	—	.197	.303	1- 13/16
4	40	—	2	384601	384901	384602	—	384629	384634	—	—	—	—	.236	.326	1- 7/8
4	—	48	2	384683	—	—	—	—	—	—	—	—	—	.236	.326	1- 7/8
5	—	40	3	384603	384903	—	—	—	—	—	—	—	—	.236	.389	1- 15/16
6	32	—	3	384604	—	384605	384905	384636	384635	—	—	384659	384665	.276	.411	2
6	—	40	3	384684	—	384685	—	—	—	—	—	—	—	.276	.411	2
8	32	—	3	384606	—	384607	384907	384638	384637	—	—	384660	384667	.276	.474	2- 1/8
8	—	36	3	—	—	384687	—	—	—	—	—	—	—	.276	.474	2- 1/8
10	24	—	3	384624	—	384609	384909	—	384639	—	—	384690	384669	.354	.521	2- 3/8
10	—	32	3	384611	—	384610	384910	384630	384640	384640TIN	384662	384670	—	.276	.599	2- 3/8
12	24	—	3	—	—	384688	—	—	—	—	—	—	—	.354	.583	2- 3/8
12	—	28	3	—	—	384689	—	—	—	—	—	—	—	.276	.661	2- 3/8
1/4	20	—	3	—	—	384613	384913	—	384643	384643TIN	—	384673	—	.433	.567	2- 1/2
1/4	—	28	3	—	—	384614	384914	384631	384644	384644TIN	384664	384674	—	.354	.646	2- 1/2
5/16	18	—	3	—	—	384615	384915	—	384645	384645TIN	—	384675	—	.472	.653	2- 23/32
5/16	—	24	3	—	—	384616	384916	384632	384646	—	—	384676	—	.394	.731	2- 23/32
3/8	16	—	3	—	—	384617	384917	—	384647	384647TIN	—	384677	—	.551	.699	2- 15/16
3/8	—	24	3	—	—	384618	384918	384633	384648	—	—	384678	—	.394	.856	2- 15/16
7/16	14	—	3	—	—	384619	384919	—	384649	—	—	384679	—	.591	—	3- 5/32
7/16	—	20	3	—	—	384620	384920	—	384650	—	—	384691	384680	.472	—	3- 5/32
1/2	13	—	3	—	—	384621	384921	—	384651	384651TIN	—	384681	—	.630	—	3- 3/8
1/2	—	20	3	—	—	384622	384922	—	384652	—	—	384692	384682	.472	—	3- 3/8
9/16	12	—	3	—	—	384653	384953	—	—	—	—	—	—	.709	—	3- 19/32
9/16	—	18	3	—	—	384654	384954	—	384698	—	—	—	—	.512	—	3- 19/32
5/8	11	—	3	—	—	384625	384925	—	384655	—	—	—	—	.748	—	3- 13/16
5/8	—	18	3	—	—	384626	384926	—	384656	—	—	384672	—	.512	—	3- 13/16
3/4	10	—	3	—	—	384627	384927	—	384657	—	—	—	—	.827	—	4- 1/4
3/4	—	16	3	—	—	384628	384928	—	384658	—	—	384686	—	.591	—	4- 1/4

Necked design enhances flow of cutting fluid to cutting teeth and reduces surface contact between the tool and work-piece for more efficient threading.

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