

No.146

Selecting a Tap with a +0.3mm Oversize

【Consultation】



The tolerance on the drawing from the customer specifies +0.3mm. Is such an oversized tap available? "Hot dip galvanized" came up when I was doing research. Is it a product name?

【Answer】

Our HVSP ZP (Hybrid Value Spiral Fluted Tap for zinc plating), is an excellent choice for oversize tapping! HVSP ZP works great for both vertical and horizontal tapping, achieves stable tapping without chipping. For more information, please refer to "Bag Full of Wisdom when you are in trouble No. 25, Hot Dip Galvanizing and tap grade". Please refer to the following explanations for HVSP ZP.



【Explanation】



Hybrid Value Spiral Fluted Taps for Zinc Plating

Tapping Speeds depending on Materials

Low carbon steels 低炭素鋼	Medium carbon steels 中炭素鋼	High carbon steels 高炭素鋼	Alloy steels 合金鋼	Thermal treated steels 調質鋼	Stainless steels ステンレス鋼	Cast steels 鋳鋼
3-12 (m/min)	3-12 (m/min)	3-12 (m/min)	3-12 (m/min)	~5 (m/min)	~5 (m/min)	3-12 (m/min)
<small>25~35HRC</small>						

Due to a lack in our standard lineups, we have previously supplied oversized taps as special-made products for zinc plating. However we have more frequent requests and increasing demand, so we decided to develop a new product HVSP ZP as our standard product.

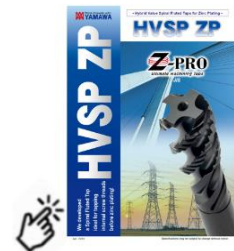
This new HVSP ZP was developed from design from HVSP, our latest technology and top-of-the-line. HVSP ZP is versatile, can be used for multiple materials and machines, and has the same design as HVSP to prevent chipping, ensuring "trouble-free and stable tapping".

-Size available from M8 to M24.

-Available in the most common oversize tolerances, +0.1mm, +0.2mm, +0.3mm.

We encourage machining within a specific tapping speed range to maximize the performance of HVSP ZP.

Please visit our website or see the flyer for more details.



【Advice on HVSP ZP bored hole diameter for your reference】

When machining threads before galvanizing, we recommend drilling larger holes to accommodate the thickness of zinc plating. Please refer to the materials on the right and confirm the final dimensions before processing.

Unit: mm

Size	Oversized bored hole size for reference		
	Oversize + 0.1mm	Oversize + 0.2mm	Oversize + 0.3mm
M8×1.25	6.95	7.05	7.15
M10×1.5	8.70	8.80	8.90
M12×1.75	10.5	10.6	10.7
M14×2	12.2	12.3	12.4
M16×2	14.2	14.3	14.4
M18×2.5	15.7	15.8	15.9
M20×2.5	17.7	17.8	17.9
M22×2.5	19.7	19.8	19.9
M24×3	21.2	21.3	21.4