

DISCOVER OUR

TAPPING



Summary application chart-TAPPING

CROMSON High Performance Taps

Select the proper tap for your application:

CRP3 (HSSE)

General softer materials (ductile) below 25 HRc
Low carbon steel
Medium carbon steel
Brass
Copper
Aluminum
Cast iron

CRPS (HSSE)

Tough materials up to 35 HRc
High carbon steel
High alloy
Titanium
Aluminum

CRM (HSSE)


Stainless steel
Low carbon steel
Medium carbon steel
Alloyed high carbon

CRS (POWDER METAL) up to 48 HRc

High tensile materials
Tool steels
Titanium
Nickel alloys
Stainless steel

CRN (HSSE /HSS)

Aluminum including roll forming

Work material	Hardness Rockwell (HRc) Hardness Brinell (BHN) Tensile Strength (N/mm2)			material	LOW /MED CARBON STEEL	
	HRc	BHN	N/mm2	model	CRP3	
				ft. / min.	Cutting Speed SFM	
				Condition	Normalized	As Cast
Non-alloy steel, cast steel 1018, 1108, 1161, 12L14, 1522, 1572	up to 8 up to 15 over 15	up to 178 up to 205 over 205	up to 600 up to 700 over 700		20-50 20-40 20-40 	
Alloyed steel 5132, 4130, 8620, 4340, 5140, 6150 Tool Steel, 01, A2, D2, H-13, P-20.	up to 27 up to 31 over 31	up to 266 up to 297 over 297	up to 900 up to 1000 over 1000			
Stainless steel moderate 17-4PH, 15-5PH, 316L						
Stainless and acid resistant steel (Cr-Ni-Alloys) 304, 316, 17CrNi16-2						
Cast iron, grey cast iron alloys GG10-GG40, A48	up to 14 up to 24 over 24	up to 200 up to 250 over 2050	up to 680 up to 850 over 850		20-40	
Spheroidal graphite cast iron, cast iron with vermicular graphite, malleable iron GGG40, GGG80	up to 8 over 8	up to 178 over 178	up to 600 over 650			
Aluminum (Si content >10%) 6061, 2025, 208, 360						
Aluminum (Si content <10%) 413, 385, A390						
Copper, brass, bronze Beryllium copper, naval brass, AMPCO						
Titanium alloys TiAl4V						
High Temperature alloys Inconel, haynes, waspaloy, hastelloy						
Chilled cast iron	38-48				20-40	
Hardened steel 50-60 HRc	50-55 56-60 61-65					

** The machining values shown are guidelines. The optimum data for a particular machining process should be determined in trials or during machining.



Highly recommended

MED /HIGH CARBON STEEL		STAINLESS STEEL		TITANIUM. NICKEL ALLOY		ALUMINUM	
CRPS		CRM		CRS		CRN	
Cutting Speed SFM		Cutting Speed SFM		Cutting Speed SFM		Cutting Speed SFM	
Normalized	Annealed	Annealed	Hardened	Annealed/hard.	Hardened	Cutting	Roll Form
20-30		25-50					20-50
20-30 	15-25	20-30		10-20	15-20		
20-30		20-35 	15-20				
		20-35 	15-20		12-20		
						25-60	30-60
						30-80 	30-80 
		20-30				30-80	30-80
15-30				8-15 			
					5-20		

TECHNICAL DETAILS

General application	Stainless Steel
Machine or manual	Machine
Hole type	Through bore
Surface treatment	Steam
Materials to be machined	304, 316, 316L
Other	17-4PH, 15-5PH, A286
Hardness	Up to 35 HRC
Tap length	Standard



EDP Cromson	Cromson Description	Diam. Thread	Nb Thread	Nb Flutes	Thread Limit	OAL	Tap length
76003000	CRM - 2-56 - SP	2	56	2	H2	1.3/4	0.433
76003005	CRM - 3-48 - SP	3	48	2	H2	1.13/16	0.512
76003010	CRM - 4-40 - SP	4	40	2	H2	1 7/8	0.433
76003015	CRM - 6-32 - SP	6	32	3	H3	2	0.512
76003020	CRM - 8-32 - SP	8	32	3	H3	2.1/8	0.512
76003025	CRM - 10-24 - SP	10	24	3	H3	2.3/8	0.512
76003030	CRM - 10-32 - SP	10	32	3	H3	2.3/8	0.512
76003035	CRM - 1/4-20 - SP	1/4	20	3	H3	2.1/2	0.630
76003040	CRM - 1/4-28 - SP	1/4	28	3	H3	2.1/2	0.630
76003045	CRM - 5/16-18 - SP	5/16	18	3	H3	2.23/32	0.748
76003050	CRM - 5/16-24 - SP	5/16	24	3	H3	2.23/32	0.748
76003055	CRM - 3/8-16 - SP	3/8	16	3	H3	2.15/16	0.748
76003060	CRM - 3/8-24 - SP	3/8	24	3	H3	2.15/16	0.748
76003065	CRM - 7/16-14 - SP	7/16	14	3	H3	3.5/32	0.866
76003070	CRM - 7/16-20 - SP	7/16	20	3	H3	3.5/32	0.866
76003075	CRM - 1/2-13 - SP	1/2	13	3	H3	3.3/8	0.945
76003080	CRM - 1/2-20 - SP	1/2	20	3	H3	3.3/8	0.945
76003085	CRM - 5/8-11 - SP	5/8	11	3	H3	3.13/16	1.102
76003090	CRM - 5/8-18 - SP	5/8	18	3	H3	3.13/16	1.102
76003095	CRM - 3/4-10 - SP	3/4	10	3	H3	4.1/4	1.220
76003100	CRM - 3/4-16 - SP	3/4	16	3	H3	4.1/4	1.220
76003105	CRM - M3-0.5 - SP	M3	0.5	3	D3	1.15/16	0.433
76003110	CRM - M4-0.7 - SP	M4	0.7	3	D4	2.1/8	0.512
76003115	CRM - M5-0.8 - SP	M5	0.8	3	D4	2.3/8	0.512
76003120	CRM - M6-1 - SP	M6	1	3	D5	2.1/2	0.630
76003125	CRM - M8-1.25 - SP	M8	1.25	3	D5	2.23/32	0.748
76003130	CRM - M10-1.25 - SP	M10	1.25	3	D5	2.15/16	0.748
76003135	CRM - M10-1.5 - SP	M10	1.5	3	D6	2.15/16	0.748
76003140	CRM - M12-1.75 - SP	M12	1.75	3	D6	3.3/8	0.945

TECHNICAL DETAILS

General application	Stainless steel
Machine or manual	Machine
Hole type	Blind hole
Surface treatment	Steam
Materials to be machined	304, 316, 316L
Other	17-4, 15-5, A286
Hardness	Up to 35HRc
Tap length	Standard



EDP Cromson	Cromson Description	Diam. Thread	Nb Thread	Nb Flutes	Thread Limit	OAL	Tap length
76003200	CRM - 2-56 - SF	2	56	2	H2	1.3/4	0.433
76003205	CRM - 3-48 - SF	3	48	2	H2	1.13/16	0.512
76003210	CRM - 4-40 - SF	4	40	2	H2	1.7/8	0.250
76003215	CRM - 6-32 - SF	6	32	3	H2	2	0.313
76003220	CRM - 8-32 - SF	8	32	3	H2	2.1/8	0.313
76003225	CRM - 10-24 - SF	10	24	3	H3	2.3/8	0.417
76003230	CRM - 10-32 - SF	10	32	3	H3	2.3/8	0.417
76003235	CRM - 1/4-20 - SF	1/4	20	3	H3	2.1/2	0.500
76003240	CRM - 1/4-28 - SF	1/4	28	3	H3	2.1/2	0.500
76003245	CRM - 5/16-18 - SF	5/16	18	3	H3	2.23/32	0.556
76003250	CRM - 5/16-24 - SF	5/16	24	3	H3	2.23/32	0.556
76003255	CRM - 3/8-16 - SF	3/8	16	3	H3	2.15/16	0.625
76003260	CRM - 3/8-24 - SF	3/8	24	3	H3	2.15/16	0.625
76003265	CRM - 7/16-14 - SF	7/16	14	3	H3	3.5/32	0.714
76003270	CRM - 7/16-20 - SF	7/16	20	3	H3	3.5/32	0.714
76003275	CRM - 1/2-13 - SF	1/2	13	3	H3	3.3/8	0.769
76003280	CRM - 1/2-20 - SF	1/2	20	3	H3	3.3/8	0.769
76003285	CRM - 9/16-12 - SF	9/16	12	4	H3	3.19/32	0.880
76003290	CRM - 5/8-11 - SF	5/8	11	4	H3	3.13/16	0.909
76003295	CRM - 5/8-18 - SF	5/8	18	4	H3	3.13/16	0.909
76003300	CRM - 3/4-10 - SF	3/4	10	4	H3	4.1/4	1.000
76003305	CRM - 3/4-16 - SF	3/4	16	4	H3	4.1/4	1.000
76003310	CRM - M3-0.5 - SF	M3	0.5	3	D3	1.15/16	0.197
76003315	CRM - M4-0.7 - SF	M4	0.7	3	D4	2.1/8	0.276
76003320	CRM - M5-0.8 - SF	M5	0.8	3	D4	2.3/8	0.315
76003325	CRM - M6-1 - SF	M6	1	3	D5	2.1/2	0.394
76003330	CRM - M8-1.25 - SF	M8	1.25	3	D5	2.23/32	0.492
76003335	CRM - M10-1.25 - SF	M10	1.25	3	D5	2.15/16	0.591
76003340	CRM - M10-1.5 - SF	M10	1.5	3	D6	2.15/16	0.591
76003345	CRM - M12-1.75 - SF	M12	1.75	3	D6	3.3/8	0.689
76003350	CRM - M14-2 - SF	M14	2	3	D7	3.19/32	0.787
76003355	CRM - M16-2 - SF	M16	2	3	D7	3.13/16	0.787