

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	Aluminum
Machine or manual	Machine
Hole type	Blind hole
Surface treatment	Bright
Materials to be machined	Aluminum, copper, brass, bronze
Other	
Hardness	
Tap length	Standard



EDP Cromson	Cromson Description	Diam. Thread	Nb Thread	Nb Flutes	Thread Limit	OAL	Tap length	Cromson Grade
76004000	CRN - 4-40 - SF	4	40	2	H2	1.7/8	0.250	CRN
76004005	CRN - 6-32 - SF	6	32	2	H3	2	0.313	CRN
76004010	CRN - 8-32 - SF	8	32	2	H3	2.1/8	0.313	CRN
76004015	CRN - 10-24 - SF	10	24	2	H3	2.3/8	0.417	CRN
76004020	CRN - 10-32 - SF	10	32	2	H3	2.3/8	0.417	CRN
76004025	CRN - 1/4-20 - SF	1/4	20	2	H3	2.1/2	0.500	CRN
76004030	CRN - 1/4-28 - SF	1/4	28	2	H3	2.1/2	0.500	CRN
76004035	CRN - 5/16-18 - SF	5/16	18	2	H3	2.23/32	0.556	CRN
76004040	CRN - 5/16-24 - SF	5/16	24	2	H3	2.23/32	0.556	CRN
76004045	CRN - 3/8-16 - SF	3/8	16	2	H3	2.15/16	0.625	CRN
76004050	CRN - 3/8-24 - SF	3/8	24	2	H3	2.15/16	0.625	CRN
76004055	CRN - M3-0.5 - SF	M3	0.5	2	D3	1.15/16	0.197	CRN
76004060	CRN - M4-0.7 - SF	M4	0.7	2	D4	2.1/8	0.276	CRN
76004065	CRN - M5-0.8 - SF	M5	0.8	2	D5	2.3/8	0.315	CRN
76004070	CRN - M6-1 - SF	M6	1	2	D5	2.1/2	0.394	CRN
76004075	CRN - M8-1.25 - SF	M8	1.25	2	D5	2.23/32	0.492	CRN
76004080	CRN - M10-1.25 - SF	M10	1.25	2	D5	2.15/16	0.591	CRN
76004085	CRN - M10-1.5 - SF	M10	1.5	2	D6	2.15/16	0.591	CRN

TECHNICAL DETAILS

General application	Aluminum
Machine or manual	Machine
Hole type	Through bore
Surface treatment	Bright
Materials to be machined	Low carbide, aluminum
Other	Bronze, brass, copper
Hardness	Max. 20 HRc
Tap length	Standard - Roll Formed Thread



EDP Cromson	Cromson Description	Diam. Thread	Nb Thread	Nb Flutes	Thread Limit	OAL	Tap length	Cromson Grade
76004200	CRN - 4-40 - RF	4	40	-	H5	1 7/8	0.560	CRN
76004205	CRN - 6-32 - RF	6	32	-	H5	2	0.480	CRN
76004210	CRN - 8-32 - RF	8	32	-	H5	2.1/8	0.500	CRN
76004215	CRN - 10-24 - RF	10	24	-	H6	2.3/8	0.640	CRN
76004220	CRN - 10-32 - RF	10	32	-	H6	2.3/8	0.640	CRN
76004225	CRN - 1/4-20 - RF	1/4	20	-	H6	2.1/2	0.830	CRN
76004230	CRN - 1/4-28 - RF	1/4	28	-	H6	2.1/2	0.830	CRN
76004235	CRN - 5/16-18 - RF	5/16	18	-	H7	2.23/32	0.930	CRN
76004240	CRN - 5/16-24 - RF	5/16	24	-	H7	2.23/32	0.930	CRN
76004245	CRN - 3/8-16 - RF	3/8	16	-	H7	2.15/16	0.980	CRN
76004250	CRN - 3/8-24 - RF	3/8	24	-	H7	2.15/16	0.980	CRN
76004255	CRN - 1/2-13 - RF	1/2	13	-	H8	2.23/32	0.930	CRN
76004260	CRN - 1/2-20 - RF	1/2	20	-	H8	2.15/16	0.980	CRN
76004265	CRN - M3-0.5 - RF	M3	0.5	-	D5	1.15/16	0.620	CRN
76004270	CRN - M4-0.7 - RF	M4	0.7	-	D6	2.1/8	0.500	CRN
76004275	CRN - M5-0.8 - RF	M5	0.8	-	D7	2.3/8	0.640	CRN
76004280	CRN - M6-1 - RF	M6	1	-	D8	2.1/2	0.830	CRN
76004285	CRN - M8-1.25 - RF	M8	1.25	-	D9	2.23/32	0.930	CRN
76004290	CRN - M10-1.5 - RF	M10	1.5	-	D10	2.15/16	0.980	CRN

