

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	Steel
Machine or manual	Machine and manual
Hole type	Through bore
Surface treatment	Steam
Materials to be machined	1018, 1010, 1035,
Other	1045, 1050, 1065
Hardness	Up to 25 HRc
Tap length	Standard



EDP Cromson	Cromson Description	Diam. Thread	Nb Thread	Nb Flutes	Thread Limit	OAL	Tap length
76000005	CRP3 - 4-40 - SP	4	40	2	H2	1.7/8	0.433
76000010	CRP3 - 6-32 - SP	6	32	3	H3	2	0.512
76000015	CRP3 - 6-40 - SP	6	40	3	H2	2	0.512
76000020	CRP3 - 8-32 - SP	8	32	3	H3	2.1/8	0.512
76000025	CRP3 - 10-24 - SP	10	24	2	H3	2.3/8	0.512
76000030	CRP3 - 10-24 - SP	10	24	3	H3	2.3/8	0.512
76000035	CRP3 - 10-32 - SP	10	32	2	H3	2.3/8	0.512
76000040	CRP3 - 10-32 - SP	10	32	3	H3	2.3/8	0.512
76000045	CRP3 - 12-24 - SP	12	24	3	H3	2.3/8	0.512
76000050	CRP3 - 1/4-20 - SP	1/4	20	2	H3	2.1/2	0.630
76000055	CRP3 - 1/4-20 - SP	1/4	20	3	H3	2.1/2	0.630
76000060	CRP3 - 1/4-28 - SP	1/4	28	2	H3	2.1/2	0.630
76000065	CRP3 - 1/4-28 - SP	1/4	28	3	H3	2.1/2	0.630
76000070	CRP3 - 5/16-18 - SP	5/16	18	2	H3	2.23/32	0.748
76000075	CRP3 - 5/16-18 - SP	5/16	18	3	H3	2.23/32	0.748
76000080	CRP3 - 5/16-24 - SP	5/16	24	2	H3	2.23/32	0.748
76000085	CRP3 - 5/16-24 - SP	5/16	24	3	H3	2.23/32	0.748
76000090	CRP3 - 3/8-16 - SP	3/8	16	2	H3	2.15/16	0.748
76000095	CRP3 - 3/8-16 - SP	3/8	16	3	H3	2.15/16	0.748
76000100	CRP3 - 3/8-24 - SP	3/8	24	2	H3	2.15/16	0.748
76000105	CRP3 - 3/8-24 - SP	3/8	24	3	H3	2.15/16	0.748
76000110	CRP3 - 7/16-14 - SP	7/16	14	3	H3	3.5/32	0.866
76000115	CRP3 - 7/16-20 - SP	7/16	20	3	H3	3.5/32	0.866
76000120	CRP3 - 1/2-13 - SP	1/2	13	3	H3	3.3/8	0.945
76000125	CRP3 - 1/2-20 - SP	1/2	20	3	H3	3.3/8	0.945
76000130	CRP3 - 5/8-11 - SP	5/8	11	3	H3	3.13/16	1.102
76000135	CRP3 - 5/8-18 - SP	5/8	18	3	H3	3.13/16	1.102
76000140	CRP3 - 3/4-10 - SP	3/4	10	3	H3	4.1/4	1.220
76000145	CRP3 - 3/4-16 - SP	3/4	16	3	H3	4.1/4	1.220
76000150	CRP3 - 1-8 - SP	1	8	3	H4	5.1/8	1.496
76000155	CRP3 - 1-12 - SP	1	12	3	H4	5.1/8	1.496

EDP Cromson	Cromson Description	Diam. Thread	Nb Thread	Nb Flutes	Thread Limit	OAL	Tap length
76000160	CRP3 - M2-0.4 - SP	M2	0.4	2	D3	1.3/4	0.433
76000165	CRP3 - M2.5-0.45 - SP	M2.5	0.45	2	D3	1.13/16	0.512
76000170	CRP3 - M3-0.5 - SP	M3	0.5	3	D3	1.15/16	0.433
76000175	CRP3 - M3.5-0.6 - SP	M3.5	0.6	3	D4	2	0.512
76000180	CRP3 - M4-0.7 - SP	M4	0.7	3	D4	2.1/8	0.512
76000185	CRP3 - M4.5-0.75 - SP	M4.5	0.75	3	D4	2.3/8	0.512
76000190	CRP3 - M5-0.8 - SP	M5	0.8	3	D4	2.3/8	0.512
76000195	CRP3 - M6-1 - SP	M6	1	3	D5	2.1/2	0.630
76000200	CRP3 - M7-1 - SP	M7	1	3	D5	2.23/32	0.630
76000205	CRP3 - M8-1 - SP	M8	1	3	D5	2.23/32	0.748
76000210	CRP3 - M8-1.25 - SP	M8	1.25	3	D5	2.23/32	0.748
76000215	CRP3 - M10-1.25 - SP	M10	1.25	3	D5	2.15/16	0.748
76000220	CRP3 - M10-1.5 - SP	M10	1.5	3	D6	2.15/16	0.748
76000225	CRP3 - M12-1.25 - SP	M12	1.25	3	D5	3.3/8	0.945
76000230	CRP3 - M12-1.75 - SP	M12	1.75	3	D6	3.3/8	0.945
76000235	CRP3 - M14-1.5 - SP	M14	1.5	3	D6	3.19/32	0.984
76000240	CRP3 - M14-2 - SP	M14	2	3	D7	3.19/32	0.984
76000245	CRP3 - M16-1.5 - SP	M16	1.5	3	D6	3.13/16	1.102
76000250	CRP3 - M16-2 - SP	M16	2	3	D7	3.13/16	1.102

HSSE SPIRAL FLUTE TAPS - CRP3

TECHNICAL DETAILS

General application	Steel
Machine or manual	Machine
Hole type	Blind hole
Surface treatment	Steam
Materials to be machined	1018, 1010, 1035, 1045, 1050, 1066
Other	
Hardness	Up to 25 HRc
Tap length	Standard



EDP Cromson	Cromson Description	Diam. Thread	Nb Thread	Nb Flutes	Thread Limit	OAL	Tap length
76000255	CRP3 - 4-40 - SF	4	40	2	H2	1.7/8	0.433
76000260	CRP3 - 6-32 - SF	6	32	3	H3	2	0.512
76000265	CRP3 - 8-32 - SF	8	32	3	H3	2.1/8	0.512
76000270	CRP3 - 10-24 - SF	10	24	3	H3	2.3/8	0.512
76000275	CRP3 - 10-32 - SF	10	32	3	H3	2.3/8	0.512
76000280	CRP3 - 1/4-20 - SF	1/4	20	3	H3	2.3/8	0.630
76000285	CRP3 - 1/4-28 - SF	1/4	28	3	H3	2.1/2	0.630
76000290	CRP3 - 5/16-18 - SF	5/16	18	3	H3	2.1/2	0.748

EDP Cromson	Cromson Description	Diam. Thread	Nb Thread	Nb Flutes	Thread Limit	OAL	Tap length
76000295	CRP3 - 5/16-24 - SF	5/16	24	3	H3	2.23/32	0.748
76000300	CRP3 - 3/8-16 - SF	3/8	16	3	H3	2.23/32	0.748
76000305	CRP3 - 3/8-24 - SF	3/8	24	3	H3	2.15/16	0.748
76000310	CRP3 - 7/16-14 - SF	7/16	14	3	H3	2.15/16	0.866
76000315	CRP3 - 7/16-20 - SF	7/16	20	3	H3	2.15/16	0.866
76000320	CRP3 - 1/2-13 - SF	1/2	13	3	H3	3.3/8	0.945
76000325	CRP3 - 1/2-20 - SF	1/2	20	3	H3	3.3/8	0.945
76000330	CRP3 - 5/8-11 - SF	5/8	11	4	H3	3.13/16	1.102
76000335	CRP3 - 5/8-18 - SF	5/8	18	4	H3	3.13/16	1.102
76000340	CRP3 - 3/4-10 - SF	3/4	10	4	H3	4.1/4	1.220
76000345	CRP3 - 3/4-16 - SF	3/4	16	4	H3	4.1/4	1.220
76000350	CRP3 - 7/8-9 - SF	7/8	9	4	H4	4.11/16	1.339
76000355	CRP3 - 7/8-14 - SF	7/8	14	4	H4	4.11/16	1.339
76000360	CRP3 - 1-8 - SF	1	8	4	H4	5.1/8	1.496
76000365	CRP3 - 1-12 - SF	1	12	4	H4	5.1/8	1.496
76000370	CRP3 - M3-0.5 - SF	M3	0.5	3	D3	1.15/16	0.433
76000375	CRP3 - M3.5-0.6 - SF	M3.5	0.6	3	D4	2	0.512
76000380	CRP3 - M4-0.7 - SF	M4	0.7	3	D4	2.1/8	0.512
76000385	CRP3 - M5-0.8 - SF	M5	0.8	3	D4	2.3/8	0.512
76000390	CRP3 - M6-1 - SF	M6	1	3	D5	2.1/2	0.630
76000395	CRP3 - M7-1 - SF	M7	1	3	D5	2.23/32	0.630
76000400	CRP3 - M8-1 - SF	M8	1	3	D5	2.23/32	0.748
76000405	CRP3 - M8-1.25 - SF	M8	1.25	3	D5	2.23/32	0.748
76000410	CRP3 - M10-1.25 - SF	M10	1.25	3	D5	2.15/16	0.748
76000415	CRP3 - M10-1.5 - SF	M10	1.5	3	D6	2.15/16	0.748
76000420	CRP3 - M12-1.25 - SF	M12	1.25	3	D5	3.3/8	0.945
76000425	CRP3 - M12-1.75 - SF	M12	1.75	3	D6	3.3/8	0.945
76000430	CRP3 - M14-1.5 - SF	M14	1.5	3	D6	3.19/32	0.984
76000435	CRP3 - M14-2 - SF	M14	2	3	D7	3.19/32	0.984
76000440	CRP3 - M16-1.5 - SF	M16	1.5	3	D6	3.13/16	1.102
76000445	CRP3 - M16-2 - SF	M16	2	3	D7	3.13/16	1.102
76000450	CRP3 - M18-1.5 - SF	M18	1.5	4	D6	4.1/32	1.102
76000455	CRP3 - M18-2.5 - SF	M18	2.5	4	D7	4.1/32	1.102
76000460	CRP3 - M20-1.5 - SF	M20	1.5	4	D5	4.15/32	1.220
76000465	CRP3 - M20-2.5 - SF	M20	2.5	4	D6	4.15/32	1.220