

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	Hardened steel
Machine or manual	Machine
Hole type	Through bore
Surface treatment	Steam
Materials to be machined	4140, 4340, H13
Other	D2, P20
Hardness	Up to 35 HRC
Tap length	Standard



EDP Cromson	Cromson Description	Diam. Thread	Nb Thread	Nb Flutes	Thread Limit	OAL	Tap length
76001005	CRPS - 2-56 - SP	2	56	2	H2	1.3/4	0.433
76001010	CRPS - 3-48 - SP	3	48	2	H2	1.13/16	0.512
76001015	CRPS - 4-40 - SP	4	40	2	H3	1.7/8	0.433
76001020	CRPS - 4-40 - SP	4	40	2	H2	1.7/8	0.433
76001025	CRPS - 6-32 - SP	6	32	3	H3	2	0.512
76001030	CRPS - 6-40 - SP	6	40	3	H3	2	0.512
76001035	CRPS - 8-32 - SP	8	32	3	H3	2.1/8	0.512
76001040	CRPS - 10-24 - SP	10	24	3	H3	2.3/8	0.512
76001045	CRPS - 10-32 - SP	10	32	3	H3	2.3/8	0.512
76001050	CRPS - 12-24 - SP	12	24	3	H3	2.3/8	0.512
76001055	CRPS - 1/4-20 - SP	1/4	20	3	H3	2.1/2	0.630
76001060	CRPS - 1/4-28 - SP	1/4	28	3	H3	2.1/2	0.630
76001065	CRPS - 5/16-18 - SP	5/16	18	3	H3	2.23/32	0.748
76001070	CRPS - 5/16-24 - SP	5/16	24	3	H3	2.23/32	0.748
76001075	CRPS - 3/8-16 - SP	3/8	16	3	H3	2.15/16	0.748
76001080	CRPS - 3/8-24 - SP	3/8	24	3	H3	2.15/16	0.748
76001085	CRPS - 7/16-20 - SP	7/16	20	3	H3	3.5/32	0.866
76001090	CRPS - 1/2-13 - SP	1/2	13	3	H3	3 3/8	0.945
76001095	CRPS - 1/2-20 - SP	1/2	20	3	H3	3.3/8	0.945
76001100	CRPS - 5/8-11 - SP	5/8	11	3	H3	3.13/16	1.102
76001105	CRPS - 5/8-18 - SP	5/8	18	3	H3	3.13/16	1.102
76001110	CRPS - 3/4-10 - SP	3/4	10	3	H3	4.1/4	1.220
76001115	CRPS - 3/4-16 - SP	3/4	16	3	H3	4.1/4	1.220
76001120	CRPS - M2-0.4 - SP	M2	0.4	2	D3	1.3/4	0.433
76001125	CRPS - M2.5-0.45 - SP	M2.5	0.45	2	D3	1.13/16	0.512
76001130	CRPS - M3-0.5 - SP	M3	0.5	3	D3	1.15/16	0.433
76001135	CRPS - M3.5-0.6 - SP	M3.5	0.6	3	D4	2	0.512
76001140	CRPS - M4-0.7 - SP	M4	0.7	3	D4	2.1/8	0.512
76001145	CRPS - M4.5-0.75 - SP	M4.5	0.75	3	D4	2.3/8	0.512
76001150	CRPS - M5-0.8 - SP	M5	0.8	3	D4	2.3/8	0.512
76001155	CRPS - M6-1 - SP	M6	1	3	D5	2.1/2	0.630
76001160	CRPS - M7-1 - SP	M7	1	3	D5	2.23/32	0.630
76001165	CRPS - M8-1 - SP	M8	1	3	D5	2.23/32	0.748
76001170	CRPS - M8-1.25 - SP	M8	1.25	3	D5	2.23/32	0.748

EDP Cromson	Cromson Description	Diam. Thread	Nb Thread	Nb Flutes	Thread Limit	OAL	Tap length
76001175	CRPS - M10-1.5 - SP	M10	1.5	3	D6	2.15/16	0.748
76001180	CRPS - M10-1.25 - SP	M10	1.25	3	D5	2.15/16	0.748
76001185	CRPS - M12-1.75 - SP	M12	1.75	3	D6	3.3/8	0.945
76001190	CRPS - M12-1.25 - SP	M12	1.25	3	D5	3.3/8	0.945
76001195	CRPS - M14-1.5 - SP	M14	1.5	3	D7	3.19/32	0.984
76001200	CRPS - M14-2 - SP	M14	2	3	D6	3.19/32	0.984
76001205	CRPS - M16-2 - SP	M16	2	3	D7	3.13/16	1.102
76001210	CRPS - M16-1.5 - SP	M16	1.5	3	D6	3.13/16	1.102
76001215	CRPS - M18-1.5 - SP	M18	1.5	4	D6	4.1/32	1.102
76001220	CRPS - M18-2.5 - SP	M18	2.5	4	D7	4.1/32	1.102
76001225	CRPS - M20-1.5 - SP	M20	1.5	4	D5	4.15/32	1.220
76001230	CRPS - M20-2.5 - SP	M20	2.5	4	D6	4.15/32	1.220
76001235	CRPS - M22-1.5 - SP	M22	1.5	4	D6	4.11/16	1.339
76001240	CRPS - M22-2.5 - SP	M22	2.5	4	D6	4.11/16	1.339
76001245	CRPS - M24-1.5 - SP	M24	1.5	4	D5	4.29/32	1.339
76001250	CRPS - M24-3 - SP	M24	3	4	D7	4.29/32	1.339
76001255	CRPS - M27-1.5 - SP	M27	1.5	4	D7	5.1/8	1.181
76001260	CRPS - M27-3 - SP	M27	3	4	D7	5.1/8	1.181
76001265	CRPS - M30-1.5 - SP	M30	1.5	4	D7	5.7/16	1.378
76001270	CRPS - M30-3.5 - SP	M30	3.5	4	D7	5.7/16	1.378

HSSE SPIRAL FLUTE TAPS - CRPS

TECHNICAL DETAILS

General application	Hardened steel
Machine or manual	Machine
Hole type	Blind hole
Surface treatment	Steam
Materials to be machined	4140, 4340, H13
Other	D2, P20
Hardness	Up to 35 HRc
Tap length	Standard



EDP Cromson	Cromson Description	Diam. Thread	Nb Thread	Nb Flutes	Thread Limit	OAL	Tap length
76002005	CRPS - 2-56 - SF	2	56	2	H2	1.3/4	0.433
76002010	CRPS - 3-48 - SF	3	48	2	H2	1.13/16	0.512
76002015	CRPS - 4-40 - SF	4	40	2	H3	1.7/8	0.250
76002020	CRPS - 6-32 - SF	6	32	3	H2	2	0.313
76002025	CRPS - 8-32 - SF	8	32	3	H2	2.1/8	0.313

EDP Cromson	Cromson Description	Diam. Thread	Nb Thread	Nb Flutes	Thread Limit	OAL	Tap length
76002030	CRPS - 10-24 - SF	10	24	3	H3	2.3/8	0.417
76002035	CRPS - 10-32 - SF	10	32	3	H3	2.3/8	0.417
76002040	CRPS - 1/4-20 - SF	1/4	20	3	H3	2.1/2	0.500
76002045	CRPS - 1/4-28 - SF	1/4	28	3	H3	2.1/2	0.500
76002050	CRPS - 5/16-18 - SF	5/16	18	3	H3	2.23/32	0.556
76002055	CRPS - 5/16-24 - SF	5/16	24	3	H3	2.23/32	0.556
76002060	CRPS - 3/8-16 - SF	3/8	16	3	H3	2.15/16	0.625
76002065	CRPS - 3/8-24 - SF	3/8	24	3	H3	2.15/16	0.625
76002070	CRPS - 7/16-14 - SF	7/16	14	3	H3	3.5/32	0.714
76002075	CRPS - 7/16-20 - SF	7/16	20	3	H3	3.5/32	0.714
76002080	CRPS - 1/2-13 - SF	1/2	13	3	H3	3.3/8	0.769
76002085	CRPS - 1/2-20 - SF	1/2	20	3	H3	3.3/8	0.769
76002090	CRPS - 5/8-11 - SF	5/8	11	4	H3	3.13/16	0.909
76002095	CRPS - 5/8-18 - SF	5/8	18	4	H3	3.13/16	0.909
76002100	CRPS - 3/4-10 - SF	3/4	10	4	H3	4.1/4	1.000
76002105	CRPS - 3/4-16 - SF	3/4	16	4	H3	4.1/4	1.000
76002110	CRPS - M3-0.5 - SF	M3	0.5	3	D3	2.3/8	0.197
76002115	CRPS - M3.5-0.6 - SF	M3.5	0.6	3	D4	2.3/8	0.236
76002120	CRPS - M4-0.7 - SF	M4	0.7	3	D4	2.3/8	0.276
76002125	CRPS - M5-0.8 - SF	M5	0.8	3	D4	2.3/8	0.315
76002130	CRPS - M6-1 - SF	M6	1	3	D5	2.1/2	0.394
76002135	CRPS - M7-1 - SF	M7	1	3	D5	2.23/32	0.394
76002140	CRPS - M8-1.25 - SF	M8	1.25	3	D5	2.23/32	0.492
76002145	CRPS - M8-1 - SF	M8	1	3	D5	2.23/32	0.492
76002150	CRPS - M10-1.5 - SF	M10	1.5	3	D6	2.15/16	0.591
76002155	CRPS - M10-1.25 - SF	M10	1.25	3	D5	2.15/16	0.591
76002160	CRPS - M12-1.75 - SF	M12	1.75	3	D6	3.3/8	0.689
76002165	CRPS - M12-1.25 - SF	M12	1.25	3	D5	3.3/8	0.689
76002170	CRPS - M14-1.5 - SF	M14	1.5	3	D6	3.19/32	0.787
76002175	CRPS - M14-2 - SF	M14	2	3	D7	3.19/32	0.787
76002180	CRPS - M16-1.5 - SF	M16	1.5	3	D6	3.13/16	0.787
76002185	CRPS - M16-2 - SF	M16	2	3	D7	3.13/16	0.787
76002190	CRPS - M18-1.5 - SF	M18	1.5	4	D6	4.1/32	0.984
76002195	CRPS - M18-2.5 - SF	M18	2.5	4	D7	4.1/32	0.984
76002200	CRPS - M20-1.5 - SF	M20	1.5	4	D5	4.15/32	0.984
76002205	CRPS - M20-2.5 - SF	M20	2.5	4	D6	4.15/32	0.984
76002210	CRPS - M22-1.5 - SF	M22	1.5	4	D6	4.11/16	0.984
76002215	CRPS - M22-2.5 - SF	M22	2.5	4	D6	4.11/16	0.984
76002220	CRPS - M24-1.5 - SF	M24	1.5	4	D5	4.29/32	1.181
76002225	CRPS - M24-3 - SF	M24	3	4	D7	4.29/32	1.181
76002230	CRPS - M27-1.5 - SF	M27	1.5	4	D7	5.1/8	1.181
76002235	CRPS - M27-3 - SF	M27	3	4	D7	5.1/8	1.181
76002240	CRPS - M30-1.5 - SF	M30	1.5	4	D7	5.7/16	1.378
76002245	CRPS - M30-3.5 - SF	M30	3.5	4	D7	5.7/16	1.378

HSSE SPIRAL FLUTE TAPS - CRPS DIN LENGTH ANSI SHANK

TECHNICAL DETAILS

General application	Hardened steel
Machine or manual	Machine
Hole type	Through bore
Surface treatment	Steam
Materials to be machined	4140, 4340, H13
Other	D2, P20
Hardness	Up to 35 HRc
Tap length	Standard



EDP Cromson	Cromson Description	Diam. Thread	Nb Thread	Nb Flutes	Thread Limit	OAL	Tap length
76002300	CRPS - 1-8 - SP	1	8	4	H7	6.299	1.417
76002305	CRPS - 1-1/8-8- SP	1.1/8	8	4	H9	7.087	1.575
76002310	CRPS - 1-1/4-8- SP	1.1/4	8	4	H9	7.087	1.575
76002315	CRPS - 1-3/8-8- SP	1.3/8	8	5	H9	7.874	1.654
76002320	CRPS - 1-1/2-8- SP	1.1/2	8	5	H9	7.874	1.654
76002325	CRPS - 1-3/4-8- SP	1.3/4	8	6	H9	7.874	1.772
76002330	CRPS - 2-8- SP	2	8	6	H10	8.858	1.969

TECHNICAL DETAILS

General application Hardened steel
 Machine or manual Machine
 Hole type Through bore
 Surface treatment Steam
 Materials to be machined **4140, 4340, H13**
 Other **D2, P20**
 Hardness Up to 35 HRC
 Tap length Standard



EDP Cromson	Cromson Description	Diam. Thread	Nb Thread	Nb Flutes	Thread Limit	OAL	Tap length
76002500	CRPS - 10-24 - SP	10	24	3	H3	2.756	0.591
76002505	CRPS - 1/4-20 - SP	1/4	20	3	H3	3.150	0.669
76002510	CRPS - 5/16-18 - SP	5/16	18	3	H3	3.543	0.669
76002515	CRPS - 3/8-16 - SP	3/8	16	3	H3	3.937	0.787
76002520	CRPS - 7/16-14 - SP	7/16	14	3	H3	3.937	0.866
76002525	CRPS - 1/2-13 - SP	1/2	13	3	H3	4.331	0.984
76002530	CRPS - 5/8-11 - SP	5/8	11	3	H3	4.331	1.063
76002535	CRPS - 3/4-10 - SP	3/4	10	3	H3	4.921	1.181

HSSE SPIRAL POINT TAPS - CRPS 4" AND 6" OAL

TECHNICAL DETAILS

General application	Hardened steel
Machine or manual	Machine
Hole type	Through bore
Surface treatment	Steam
Materials to be machined	4140, 4340, H13
Other	D2, P20
Hardness	Up to 35 HRc
Tap length	Long



EDP Cromson	Cromson Description	Diam. Thread	Nb Thread	Nb Flutes	Thread Limit	OAL	Tap length
76002600	CRPS - 4-40 - SP	4	40	2	H2	4.000	0.433
76002605	CRPS - 6-32 - SP	6	32	3	H3	4.000	0.512
76002610	CRPS - 8-32 - SP	8	32	3	H3	4.000	0.512
76002615	CRPS - 10-24 - SP	10	24	3	H3	6.000	0.512
76002620	CRPS - 10-32 - SP	10	32	3	H3	6.000	0.512
76002625	CRPS - 1/4-20 - SP	1/4	20	3	H3	6.000	0.630
76002630	CRPS - 1/4-28 - SP	1/4	28	3	H3	6.000	0.630
76002635	CRPS - 5/16-18 - SP	5/16	18	3	H3	6.000	0.748
76002640	CRPS - 5/16-24 - SP	5/16	24	3	H3	6.000	0.748
76002645	CRPS - 3/8-16 - SP	3/8	16	3	H3	6.000	0.748
76002650	CRPS - 3/8-24 - SP	3/8	24	3	H3	6.000	0.748
76002655	CRPS - 7/16-14 - SP	7/16	14	3	H3	6.000	0.866
76002660	CRPS - 7/16-20 - SP	7/16	20	3	H3	6.000	0.866
76002665	CRPS - 1/2-13 - SP	1/2	13	3	H3	6.000	0.945
76002670	CRPS - 1/2-20 - SP	1/2	20	3	H3	6.000	0.945
76002675	CRPS - 5/8-11 - SP	5/8	11	3	H3	6.000	1.102
76002680	CRPS - 3/4-10 - SP	3/4	10	3	H3	6.000	1.220
76002685	CRPS - 7/8-9 - SP	7/8	9	3	H4	6.000	1.339
76002690	CRPS - 1-8 - SP	1	8	4	H4	6.000	1.496

TECHNICAL DETAILS

General application	Hardened steel
Machine or manual	Machine
Hole type	Blind hole
Surface treatment	Steam
Materials to be machined	4140, 4340, H13
Other	D2, P20
Hardness	Up to 35 HRc
Tap length	Long



EDP Cromson	Cromson Description	Diam. Thread	Nb Thread	Nb Flutes	Thread Limit	OAL	Tap length
76002800	CRPS - 4-40 - SF	4	40	2	H2	4.000	0.433
76002805	CRPS - 6-32 - SF	6	32	3	H3	4.000	0.512
76002810	CRPS - 8-32 - SF	8	32	3	H3	4.000	0.512
76002815	CRPS - 10-24 - SF	10	24	3	H3	4.000	0.512
76002820	CRPS - 10-32 - SF	10	32	3	H3	6.000	0.512
76002825	CRPS - 1/4-20 - SF	1/4	20	3	H3	6.000	0.630
76002830	CRPS - 1/4-28 - SF	1/4	28	3	H3	6.000	0.630
76002835	CRPS - 5/16-18 - SF	5/16	18	3	H3	6.000	0.748
76002840	CRPS - 5/16-24 - SF	5/16	24	3	H3	6.000	0.748
76002845	CRPS - 3/8-16 - SF	3/8	16	3	H3	6.000	0.748
76002850	CRPS - 3/8-24 - SF	3/8	24	3	H3	6.000	0.748
76002855	CRPS - 7/16-14 - SF	7/16	14	3	H3	6.000	0.866
76002860	CRPS - 7/16-20 - SF	7/16	20	3	H3	6.000	0.866
76002865	CRPS - 1/2-13 - SF	1/2	13	3	H3	6.000	0.945
76002870	CRPS - 1/2-20 - SF	1/2	20	3	H3	6.000	0.945
76002875	CRPS - 5/8-11 - SF	5/8	11	4	H3	6.000	1.102
76002880	CRPS - 3/4-10 - SF	3/4	10	4	H3	6.000	1.220
76002885	CRPS - 7/8-9 - SF	7/8	9	4	H4	6.000	1.339
76002890	CRPS - 1-8 - SF	1	8	4	H4	6.000	1.496

TECHNICAL DETAILS

General application	Hardened steel
Machine or manual	Machine
Hole type	Blind hole
Surface treatment	Steam
Materials to be machined	4140, 4340, H13
Other	D2, P20
Hardness	Up to 35 HRC
Tap length	Standard



EDP Cromson	Cromson Description	Diam. Thread	Nb Thread	Nb Flutes	Thread Limit	OAL	Tap length
76002900	CRPS - 1/16-27 - SP	1/16	27	4	-	2.1/8	0.688
76002905	CRPS - 1/8-27 - SP	1/8	27	4	-	2.1/8	0.750
76002910	CRPS - 1/4-18 - SP	1/4	18	4	-	2.7/16	1.063
76002915	CRPS - 3/8-18 - SP	3/8	18	4	-	2.9/16	1.063
76002920	CRPS - 1/2-14 - SP	1/2	14	4	-	3.1/8	1.375
76002925	CRPS - 3/4-14 - SP	3/4	14	5	-	3.1/4	1.375
76002930	CRPS - 1-11.5 - SP	1	11.5	5	-	3.3/4	1.750
76002935	CRPS - 1-1/4-11.5 - SP	1 1/4	11.5	5	-	4	1.750
76002940	CRPS - 1-1/2-11.5 - SP	1 1/2	11.5	5	-	4.1/4	1.750
76002945	CRPS - 2-11.5 - SP	2	11.5	5	-	4.1/2	1.750

For pre-tapping operation, please refer to our TAPERMILL line on page 35