

XCR-FORMING TAPS

XCR-ROLL Forming Taps Co-HSS TiN



- Excellent performance in steel, stainless steel and nonferrous materials
- "Lube grooves" for improved tool life
- Sizes ranging from 0-80 to 3/8"-24

APPLICATION

Non-Ferrous
Low Carbon Steel

INCH

RECOMMENDED USEABLE

Inch Sizes - Plug & Bottoming Style

Nominal Size	TPI		Style	Class of Fit	TiN	
	NC/UNC	NF/UNF				
0		80	B	2B	93732TI	
2	56		B	2B	93738TI	
3	48		B	2B	93742TI	
4	40		B	2B	93784TI	
6	32		P	2B	93791TI	
			B	2B	93792TI	
8	32		P	2B	93795TI	
			B	2B	93796TI	
10	24		P	2B	93829TI	
			B	2B	93830TI	
			32	P	2B	93831TI
				B	2B	93832TI
1/4	20		P	2B	93837TI	
			B	2B	93838TI	
			28	P	2B	93839TI
				B	2B	93840TI
5/16	18		P	2B	93872TI	
			B	2B	93873TI	
			24	P	2B	93874TI
				B	2B	93875TI
3/8	16		P	2B	93876TI	
			B	2B	93877TI	
			24	P	2B	93878TI
				B	2B	93879TI

TAP DRILL SIZES FOR XCR TAPS

Tap Size	Drill Size	Tap Size	Drill Size
0-80	#54	M3X.5	7/64
2-56	5/64	M4X.7	27
3-48	#43	M5X.8	4.60MM
4-40	#38	M6X1	5.50MM
6-32	1/8	M8X1.25	L
8-32	#25		
10-24	11/66	M10X1.5	9.20MM
3/8-24	T	M12X1.75	7/16
10-32	#16		
1/4-20	#1		
1/4-28	15/64		
5/16-18	L		
5/16-24	M		
3/8-16	S		

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APPLICATION

Non-Ferrous
Low Carbon Steel

METRIC

RECOMMENDED USEABLE

Metric Sizes - Plug & Bottoming Style

Nominal Size	Pitch	Style	Class of Fit	TiN
M3	0.50	B	6H	93990Ti
		P	6H	93991Ti
M4	0.70	B	6H	93992Ti
		P	6H	93993Ti
M5	0.80	B	6H	93994Ti
		P	6H	93995Ti
M6	1.00	B	6H	93996Ti
		P	6H	93997Ti
M8	1.25	B	6H	93998Ti
		P	6H	93999Ti
M10	1.50	B	6H	94000Ti
		P	6H	94001Ti
M12	1.75	B	6H	94002Ti
		P	6H	94003Ti

TAPPING SPEEDS FOR XCR TAPS

Material	Bright*
Stainless Steel	30 SFM
Low Carbon Steel	50 SFM
Medium Carbon Steel	40 SFM
Aluminum Alloys	60 SFM
Aluminum	100 SFM

* TiN coated: add 10% to above SFM

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