

BALAX – EDP ORDERING NUMBER SYSTEM

Balax part numbers consist of a five-digit number describing the basic tap and a three digit suffix that specifies the desired options.

1	1	2	8	5	-	2	1	4
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<p>EDP NUMBER – 11285 Found in the tables. Describes the tap type, size, and H/D number</p>	<p>THREDSHAVERS & GAGES 0 = Standard configuration.</p> <p>THREDFLOERS – 2 0 = Standard configuration. 6-32 or M3.5 and larger have one groove. Smaller taps have no grooves.</p> <p>1 = 1 Groove (for taps smaller than 6-32 or M3.5) 2 = 2 Grooves 4 = 4 Grooves 6 = 1 Groove Per Relief 7 = Burr Bit grooves 8 = 2 Grooves (HP only) 9 = 1 Groove Per Relief (HP only).</p>	<p>FRONT POINT – 1 0 = With Front point 1 = Front point removed 2 = Ettco Notch 4 = Rear and Front points removed B = Angular Outlets, Front point removed C = Angular Outlets H = Coolant-thru, Front point removed J = Coolant-thru P = Individual Packages Q = Individual Packages, Front point removed R = Radial Outlets S = Radial Outlets, Front point removed W = Individual Packages, Coolant-thru X = Individual Packages, FT PT removed, Coolant-thru</p>	<p>SURFACE TREATMENT – 4 0 = Bright Finish 1 = Nitride 2 = Steam Oxide 3 = HardChrome 4 = Balwear 5 = Balube 6 = Nitride/Steam Oxide 7 = Nitride/HardChrome A = Titanium Aluminum Nitride C = Titanium Carbonitride G = "GO" Element TiN Coated (Sets only) L = Bal-Plus N = Aluminum Chromium Nitride R = CRN S = Steam (Cut Tap) T = Titanium Nitride U = Super TiN</p>
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THREDFLOER EXAMPLE:
11285 - 2 1 4
 6-32 Bottom H5 Thredfloer with
2 grooves, front point removed,
and Balwear surface treatment.

THREDSHAVER EXAMPLE:
54715 - 0 1 C
 M8 X 1.25 BH5 Straight Flute
Threshaver with front point
removed and TiCN

THREAD GAGE EXAMPLE:
90116 - 0 0 T
 6-32 2B Gage Set with TiN.

FRONT POINTS

Standard on all tap blanks 3/8" (M10) and smaller. For some bottoming applications the front point helps center the tap in the hole and fits in the cone created by the drill at the bottom of the hole. For bottoming applications where clearance is a problem, Balax can remove front points when specified, free-of charge. Front points will be removed on all one-thread lead taps.



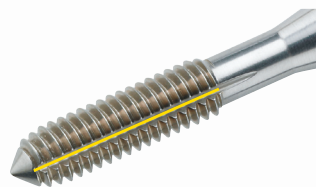
Front Point Not Removed



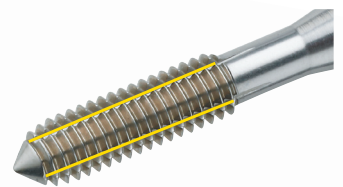
Front Point Removed

VENT GROOVES

Standard on all #6 taps (M3.5) and larger. Vent grooves provide a lubrication path, and, for holes completely filled with lubricant, the groove prevents hydraulic locking and bottom blowout of weak bottomed diecastings. For deep hole tapping, extra vent grooves help distribute and increase the flow of lubricant to the tap. HP and DIN series come with the optimal # of grooves:



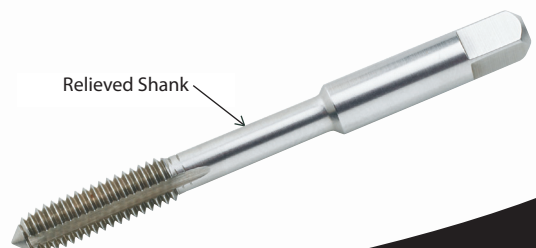
1-Groove Tap



4-Groove Tap

RELIEVED SHANK TAPS

All taps 3/8" (M10) and smaller are made with the shank diameter larger than the major diameter of the tap. These taps are unable to tap beyond the basic thread length of the tap due to the diameter of the shank. Rather than purchasing a special tap, a stock male center forming tap may be economically modified by grinding a relieved shank to increase tapping depth. Consult with a Balax "Tapplication Engineer" for further information. Multiple grooves are recommended.



Relieved Shank