



**ADVANCES**  
**MASTER CATALOG 2015** | Tapping Preview

## WIDIA-GTD™ Lightning™ Service

Rely on the WIDIA™ Lightning Service program to deliver the special taps you need, when and where you need them. Within minutes, we can quote, process, and release your order to the factory.



# Lightning Service

### Features and Benefits

- Non-standard tap sizes, pitches, PDs, coatings, etc.
- Special taps can be used for tapping steel, cast iron, aluminum, or brass.
- Custom-ordered taps can be designed to thread INCONEL®, titanium, and high-temp alloys.
- Always accurate thread pitch diameters and gage fits.
- Select products available for shipping within 24 hours.

LIGHTNING SERVICE  
**24** HOUR  
SHIPPING

## How to Order Special Taps

WIDIA™ leads the industry in quoting technology. Experienced quotation specialists and product engineers use in-house designed software to generate a quote from a customer inquiry and design cutting tools with the requested features, modifications, options, and surface treatments.

### Use the following outline when selecting a tap:

1. Determine the tap that meets your cutting tool needs. For assistance, consult the Tap Selection Guide on pages A2–A9.
2. If the style, size, and/or quantity is not listed, consult customer service for a factory quote. WIDIA is fully equipped and ready to design your tool to your unique specifications.

### Please use the following guidelines when placing an order:

1. Tap style and required quantity.
2. Catalog number (if available).
3. Size and pitch (nominal diameter and threads per inch or mm pitch).
4. Number of flutes (if spiral flute, state right or left hand and helix angle desired).
5. Chamfer (taper, plug, modified bottoming, or bottoming).
6. Surface treatments.
7. Right- or left-hand thread (right hand is default).
8. Additional features or options.

NOTE: If you do not specify the pitch, number of flutes, and/or chamfer, standard specifications will be applied and shipped uncoated.

Any additional information, such as material to be tapped, type of hole, and any general dimensions, such as overall length and shank diameter, will ensure a correct tap for your application.

## Delivery Matrix

### ■ Surface Treatments

treatment	lead time	price
TiN — Titanium Nitride	24 hours	consult customer service
Steam Oxide	24 hours	N/C
Nitride	24 hours	N/C
Steam Oxide/Nitride	48 hours	N/C
TiCN — Titanium Carbonitride	1 week	consult customer service
TiAlN — Titanium Aluminum Nitride	2 weeks	consult customer service
CrN — Chromium Nitride	2 weeks	consult customer service
TiN+Cr/C — Titanium Nitride + Chromium Nitride	2 weeks	consult customer service

NOTE: Add to lead time designated for special taps.

### ■ Common Special Taps and Special Taps from Blanks

sizes	max quantity	lead time
up to 13/16", M20	72 pcs.	24 hours
7/8–1", M22–M25	24 pcs.	24 hours
1-1/16–2", M27–M48	12 pcs.	24 hours
2-1/8–2-1/2", M56	6 pcs.	24 hours
larger than 2-1/2"	2 pcs.	24 hours
Rp (BSPP), Rc (BSPT), G (BSPF)	47 pcs.	72 hours

NOTE: For orders greater than specified maximum quantity, consult customer service.

### ■ Additional Features and Options

feature/option	lead time
controlled root (minor diameter ±.001")	no additional time
double lead (except form taps)	24 hours
triple lead,	24 hours
interrupted threads, taper or straight flute	24 hours
external centers removed	no additional time
special marking	no additional time
special K-series taps	5 days
STI taps	24 hours

NOTE: Add to lead time designated for special taps.

### ■ Coating Recommendation Chart

Material Group	oxide	nitride	TiN	TiCN	TiAlN	CrN	TiN+CrCC
P	○		○	●	○		○
M	○		○	○	○	○	●
K	○	○	○	●	○		
N		○	○	○			●
S		○	○	○	●	○	
H							
speed (SFM) increase	0%	0%	50%	50%	100%	0%	50%

● first choice

○ alternate choice

# ADVANCES MASTER CATALOG 2015

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