

Y/G SCREW THREAD INSERT TAPS

TC934 SERIES

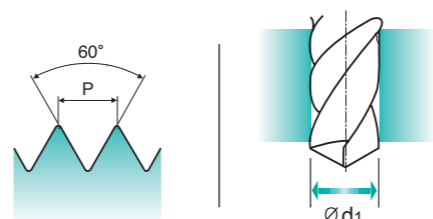
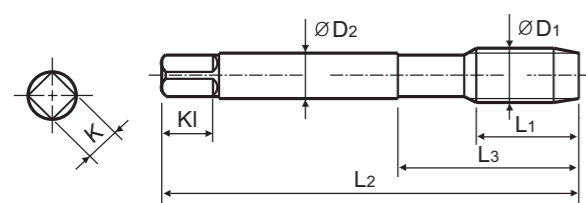
EG-UNC

Unified coarse threads for Screw Thread insert

- Unified Regelgew.f.Gew.Drahteins
 - UNC POUR FILETS RAPPORTÉS
 - ISO Metrico passo grosso per Helicoil
- Machine taps
Maschinengewindebohrer

▶ Wire insert threads are used for increasing fastening strength in soft materials.

▶ Gewinde mit Drahteinsätzen werden verwendet um größere Drehmomente in weichen Werkstoffen zu erreichen.



Material groups: AI, HSS-E, DIN 371/376, 2B, 60°, B, Bright, p.B306

Recommended ToolHolder: Plain Shank, TAPPING ER CHUCK, ONE STEP TAPPING CHUCK

Page: D215-220, D221-228, D211-213

Recommended Cutting Page : P.298

Unit : mm

SIZE	TPI	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1		Bright	L1	L2	L3	ØD2	K	Kl	Z	Ød1
#4 - 40 UNC		TC934162	13	63	21	4.5	3.4	6	3	3.1
#5 - 40 UNC		TC934202	13	63	21	4.5	3.4	6	3	3.4
#6 - 32 UNC		TC934242	14	70	25	6	4.9	8	3	3.8
#8 - 32 UNC		TC934282	13	80	25	6	4.9	8	3	4.4
#10 - 24 UNC		TC934322	17	80	30	7	5.5	8	3	5.2
#12 - 24 UNC		TC934362	17	80	30	7	5.5	8	3	5.8
1/4 - 20 UNC		TC934402	20	90	35	8	6.2	9	3	6.7
5/16 - 18 UNC		TC934442	22	100	39	10	8	11	3	8.4
3/8 - 16 UNC		TC934482	21	110	39	12	9	12	3	10
7/16 - 14 UNC		TC934522	26	110	44	11	9	12	3	11.6
1/2 - 13 UNC		TC934562	27	110	44	12	9	12	3	13.3
9/16 - 12 UNC		TC934602	30	125	50	14	11	14	3	15
5/8 - 11 UNC		TC934642	30	125	50	14	11	14	4	16.5
3/4 - 10 UNC		TC934702	32	140	54	18	14.5	17	4	19.75

▶DIN 371(#4~3/8) and DIN 376(7/16~3/4)

◎ : Excellent ○ : Good

ISO	P										M				K					
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel		Stainless steel		Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc	13	25	28	32	38	10	29	32	38	15	35	15	23	10	10	26	3	25	21	21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	○	○	○																	

ISO	N					S					H											
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron	
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	
HRc											15	30	25	38	34			55	60	42	55	
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550	
Recommended	◎	◎	◎	◎																		

Y/G SCREW THREAD INSERT TAPS

TC954 SERIES

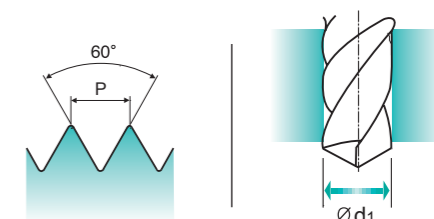
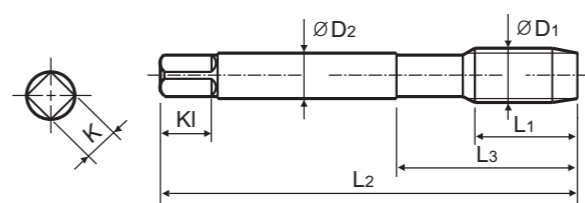
EG-UNF

Unified fine threads for Screw Thread insert

- Unified Feingew.f.Gew.Drahteins
 - UNC POUR FILETS RAPPORTÉS
 - ISO Metrico passo grosso per Helicoil
- Machine taps
Maschinengewindebohrer

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ØD1		Bright	L1	L2	L3	ØD2	K	Kl	Z	Ød1
#4 - 48 UNF		TC954182	12	56	20	4	3	6	3	3.1
#6 - 40 UNF		TC954262	14	70	25	6	4.9	8	3	3.7
#8 - 36 UNF		TC954302	13	70	25	6	4.9	8	3	4.4
#10 - 32 UNF		TC954342	13	80	25	6	4.9	8	3	5.1
1/4 - 28 UNF		TC954422	17	90	35	8	6.2	9	3	6.6
5/16 - 24 UNF		TC954462	18	100	39	10	8	11	3	8.25
3/8 - 24 UNF		TC954502	18	110	39	12	9	12	3	9.8
7/16 - 20 UNF		TC954542	22	100	40	9	7	10	3	11.5
1/2 - 20 UNF		TC954582	22	100	40	11	9	12	3	13.1
9/16 - 18 UNF		TC954622	22	100	40	12	9	12	3	14.75
5/8 - 18 UNF		TC954662	25	110	44	14	11	14	4	16.25
3/4 - 16 UNF		TC954722	25	125	50	16	12	15	4	19.5

▶DIN 371(#4~3/8) and DIN 374(7/16~3/4)

◎ : Excellent ○ : Good

ISO	P										M				K					
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel		Stainless steel		Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc	13	25	28	32	38	10	29	32	38	15	35	15	23	10	10	26	3	25	21	21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	○	○	○																	

ISO	N					S					H											
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron	
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	
HRc											15	30	25	38	34			55	60	42	55	
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550	
Recommended	◎	◎	◎	◎																		