



TB274 SERIES

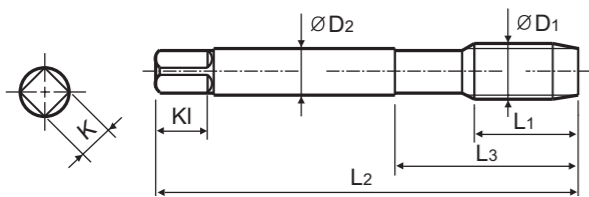
# UNF Unified fine threads

Unified Feingewinde  
 UNF  
 Unificato passo fine

Machine taps  
Maschinengewindebohrer

► Suitable for through hole in more cutting speed than other taps due to thick web.

► Geeignet für Durchgangslöcher in höherer Schnittgeschwindigkeit als bei anderen Gewindebohrern dank größerer Kerndicke.



Material groups: **VANW** HSS-E DIN 371/374 2B 60° B Vap p.B233

Recommended ToolHolder: Plain Shank TAPPING ER CHUCK D215-220 TAPPING CHUCK D221-228 ONE STEP TAPPING CHUCK D211-213

SIZE	TPI	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1		Vap	L1	L2	L3	ØD2	K	KI	Z	Ød1
#4	- 48UNF	TB274182	11	56	18	3.5	2.7	6	3	2.4
#5	- 44UNF	TB274222	11	56	18	3.5	2.7	6	3	2.7
#6	- 40UNF	TB274262	12	56	20	4	3	6	3	3
#8	- 36UNF	TB274302	13	63	21	4.5	3.4	6	3	3.5
#10	- 32UNF	TB274342	15	70	25	6	4.9	8	3	4.1
#12	- 28UNF	TB274382	16	80	30	6	4.9	8	3	4.7
1/4	- 28UNF	TB274422	17	80	30	7	5.5	8	3	5.5
5/16	- 24UNF	TB274462	17	90	35	8	6.2	9	3	6.9
3/8	- 24UNF	TB274502	18	100	39	9	7	10	3	8.5
7/16	- 20UNF	TB274542	22	100	40	8	6.2	9	3	9.9
1/2	- 20UNF	TB274582	22	100	40	9	7	10	3	11.5
9/16	- 18UNF	TB274622	22	100	40	11	9	12	3	12.9
5/8	- 18UNF	TB274662	22	100	40	12	9	12	3	14.5
3/4	- 16UNF	TB274722	25	110	44	14	11	14	4	17.5
7/8	- 14UNF	TB274762	26	125	50	18	14.5	17	4	20.5
1	- 12UNF	TB274802	28	140	54	18	14.5	17	4	23.25
1-1/8	- 12UNF	TB274842	30	150	60	22	18	21	4	26.5

► DIN 371(#4~3/8) and DIN 374(7/16~1-1/8)

◎ : Excellent ○ : Good

ISO	P										M				K					
Material Description	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	30	29	32	38	35	15	35	15	23	10	10	26	3	25	13	21
HB	125	190	250	270	300	180	275	300	350	200	240	180	180	180	260	160	250	130	230	
Recommended	◎	◎	○	○	○	○	○	○	○	○	◎	◎	◎	○	○	○	○	○	○	○

ISO	N				S						H										
Material Description	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	15	30	25	38	34	15	30	25	38	34	55	60	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	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○



## RECOMMENDED CUTTING CONDITIONS EMFOHLENE SCHNEIDKONDITIONEN

ISO	VDI 3323	Material Description	HB	HRc	Vc (m/min)																		
					TB711	TQ813	TR813	TB914	TB183	TB904	TB924	TI914	TBE15	TBE16	TBE17	TBE18	TCH14	TQ853	TR853	TB623	TB123	TB264	TB274
P	1	Non-alloy steel	125		15-20	15-20	15-20	15-20	20-25	15-20	15-20	15-20	15-20	20-25	15-20	15-20	15-20	15-20	15-20	15-20	15-20	15-20	
			190	13	15-20	15-20	15-20	15-20	20-25	15-20	15-20	15-20	15-20	20-25	15-20	15-20	15-20	15-20	15-20	15-20	15-20	15-20	15-20
			250	25		12-18	12-18	12-18	18-24	12-18	12-18	12-18	12-18	18-24	12-18	12-18	12-18	12-18	12-18	12-18	12-18	12-18	12-18
			270	28		10-15	10-15	10-15	15-20	10-15	10-15	10-15	10-15	10-15	15-20	10-15	10-15	10-15	10-15	10-15	10-15	10-15	10-15
M	12	Stainless steel	200	15	7-10	7-10	7-10	7-10	10-13	7-10	7-10	7-10	7-10	10-13	7-10	7-10	7-10	7-10	10-13	7-10	7-10	10-13	
			240	23	5-8	5-8	5-8	5-8	8-11	5-8	5-8	5-8	5-8	5-8	8-11	5-8	5-8	5-8	5-8	8-11	5-8	5-8	8-11
			180	10	4-6	4-6	4-6	4-6	6-8	4-6	4-6	4-6	4-6	4-6	6-8	4-6	4-6	4-6	4-6	6-8	4-6	4-6	6-8
N	21	Aluminum-wrought alloy	60		10-15																		
			100		15-20																		
S	31	Heat Resistant Super Alloys	200	15																			
			400Rm		10-15	10-15	10-15	15-20	10-15	10-15	10-15	10-15	15-20	10-15	10-15	10-15	10-15	10-15	10-15	10-15	10-15	10-15	15-20