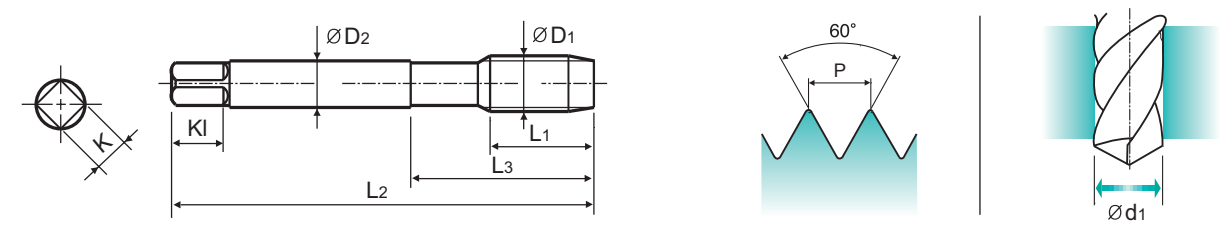
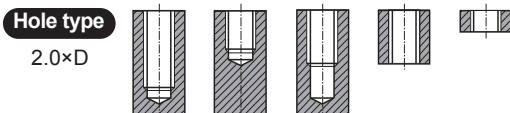


UNF Unified fine threads
 Unified Feingewinde
 UNF
 Unificato passo fine

Machine taps
 Maschinengewindebohrer

► Suitable for tapping cast iron or similar work materials due to nitriding.

► Geeignet zum Gewindeschneiden von Guss oder ähnlichen Werkstoffen dank der Nitrierung



Material groups: **GG** HSS-E DIN 371/374 2BX 60° C Nitride p.B245

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

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		Ni	L1	L2	L3	ØD2	K	Kl	Z	Ød1
#4	- 48UNF	TE454182	11	56	18	3.5	2.7	6	3	2.4
#5	- 44UNF	TE454222	11	56	18	3.5	2.7	6	3	2.7
#6	- 40UNF	TE454262	12	56	20	4	3	6	3	3
#8	- 36UNF	TE454302	13	63	21	4.5	3.4	6	3	3.5
#10	- 32UNF	TE454342	15	70	25	6	4.9	8	3	4.1
#12	- 28UNF	TE454382	16	80	30	6	4.9	8	4	4.7
1/4	- 28UNF	TE454422	17	80	30	7	5.5	8	4	5.5
5/16	- 24UNF	TE454462	17	90	35	8	6.2	9	4	6.9
3/8	- 24UNF	TE454502	18	100	39	9	7	10	4	8.5
7/16	- 20UNF	TE454542	22	100	40	8	6.2	9	4	9.9
1/2	- 20UNF	TE454582	22	100	40	9	7	10	4	11.5
9/16	- 18UNF	TE454622	22	100	40	11	9	12	4	12.9
5/8	- 18UNF	TE454662	22	100	40	12	9	12	4	14.5
3/4	- 16UNF	TE454722	25	110	44	14	11	14	4	17.5
7/8	- 14UNF	TE454762	26	125	50	18	14.5	17	4	20.5
1	- 12UNF	TE454802	28	140	54	18	14.5	17	4	23.25
1-1/8	- 12UNF	TE454842	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					
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel		Stainless steel		Grey cast iron		Nodular cast iron		Malleable cast iron	
Material Description	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
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	10	29	32	38	15	35	15	23	10	10	26	3	25	130	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
Material Description	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41		
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41		
HRc	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41		
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550		
Recommended																							

ISO	VDI 3323	Material Description	HB	HRc	T0993	TE821 TE403 TE434 TE454	TD821	TI821	TY821
					Vc (m/min)				
K	15	Grey cast iron	180	10	10-15	10-15	15-20	15-20	15-20
	16		260	26	5-8	5-8	8-11	8-11	8-11
	17	Nodular cast iron	160	3	10-15	10-15	15-20	15-20	15-20
	18		250	25	5-8	5-8	8-11	8-11	8-11
	19		Malleable cast iron	130		10-15	10-15	15-20	15-20
20	230	21		5-8	5-8	8-11	8-11	8-11	
N	23	Aluminum-cast, alloyed	75		15-20				
	25		130		10-15				
	27	Copper and Copper Alloys (Bronze / Brass)	90			8-12	12-16	12-16	12-16
H	40	Chilled Cast Iron	400	42	3-5				