



TB904 SERIES

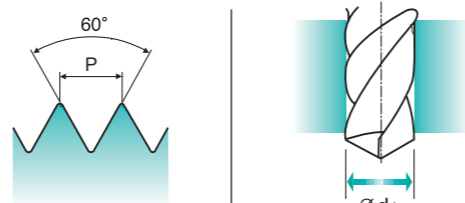
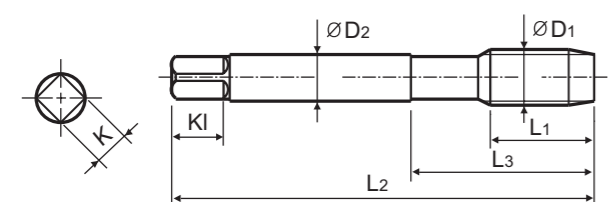
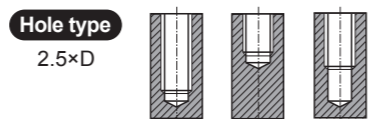
# UNC Unified coarse threads

Unified Grobgewinde  
 UNC  
 Unificato passo grosso

Machine taps  
Maschinengewindebohrer

► Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

► Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.



Material groups: **VA** **NW** **HSS-E** **DIN 371/376** **2B** **60°** **C** **R40** **Vap** **p.B233**

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		Vap	L1	L2	L3	ØD2	K	KI	Z	Ød1
#4	- 40UNC	TB904162	6	56	18	3.5	2.7	6	3	2.3
#5	- 40UNC	TB904202	7	56	18	3.5	2.7	6	3	2.6
#6	- 32UNC	TB904242	7	56	20	4	3	6	3	2.85
#8	- 32UNC	TB904282	8	63	21	4.5	3.4	6	3	3.5
#10	- 24UNC	TB904322	10	70	25	6	4.9	8	3	3.9
#12	- 24UNC	TB904362	10	80	30	6	4.9	8	3	4.5
1/4	- 20UNC	TB904402	13	80	30	7	5.5	8	3	5.2
5/16	- 18UNC	TB904442	14	90	35	8	6.2	9	3	6.6
3/8	- 16UNC	TB904482	16	100	39	9	7	10	3	8
7/16	- 14UNC	TB904522	17	100	40	8	6.2	9	3	9.4
1/2	- 13UNC	TB904562	20	110	44	9	7	10	3	10.75
9/16	- 12UNC	TB904602	20	110	44	11	9	12	3	12.25
5/8	- 11UNC	TB904642	22	110	44	12	9	12	3	13.5
3/4	- 10UNC	TB904702	25	125	50	14	11	14	4	16.5
7/8	- 9UNC	TB904742	27	140	54	18	14.5	17	4	19.5
1	- 8UNC	TB904782	30	160	60	20	16	19	4	22.25
1-1/8	- 7UNC	TB904822	35	180	65	22	18	21	4	25

► DIN 371(#4~3/8) and DIN 376(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	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)	Heat Resistant Super Alloys					Titanium Alloys										
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	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	○	○	○	○	○	○	○	○	○



TB924 SERIES

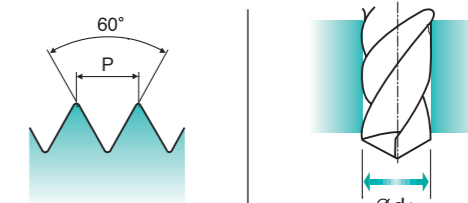
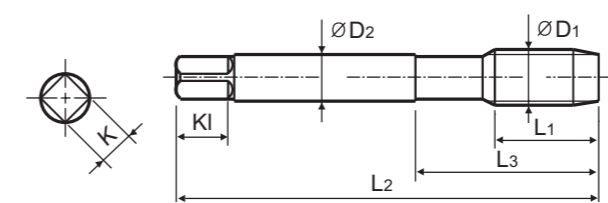
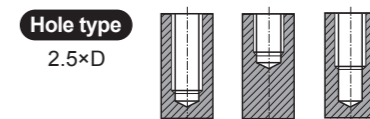
# UNF Unified fine threads

Unified Feingewinde  
 UNF  
 Unificato passo grosso

Machine taps  
Maschinengewindebohrer

► Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

► Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.



Material groups: **VA** **NW** **HSS-E** **DIN 371/374** **2B** **60°** **C** **R40** **Vap** **p.B233**

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		Vap	L1	L2	L3	ØD2	K	KI	Z	Ød1
#4	- 48UNF	TB924182	6	56	18	3.5	2.7	6	3	2.4
#5	- 44UNF	TB924222	7	56	18	3.5	2.7	6	3	2.7
#6	- 40UNF	TB924262	7	56	20	4	3	6	3	3
#8	- 36UNF	TB924302	8	63	21	4.5	3.4	6	3	3.5
#10	- 32UNF	TB924342	10	70	25	6	4.9	8	3	4.1
#12	- 28UNF	TB924382	10	80	30	6	4.9	8	3	4.7
1/4	- 28UNF	TB924422	10	80	30	7	5.5	8	3	5.5
5/16	- 24UNF	TB924462	10	90	35	8	6.2	9	3	6.9
3/8	- 24UNF	TB924502	10	100	39	9	7	10	3	8.5
7/16	- 20UNF	TB924542	13	100	40	8	6.2	9	3	9.9
1/2	- 20UNF	TB924582	13	100	40	9	7	10	3	11.5
9/16	- 18UNF	TB924622	15	100	40	11	9	12	3	12.9
5/8	- 18UNF	TB924662	15	100	40	12	9	12	3	14.5
3/4	- 16UNF	TB924722	17	110	44	14	11	14	4	17.5
7/8	- 14UNF	TB924762	17	125	50	18	14.5	17	4	20.5
1	- 12UNF	TB924802	20	140	54	18	14.5	17	4	23.25
1-1/8	- 12UNF	TB924842	22	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	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)	Heat Resistant Super Alloys					Titanium Alloys										
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	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	○	○	○	○	○	○	○	○	○