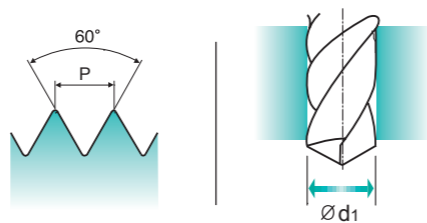
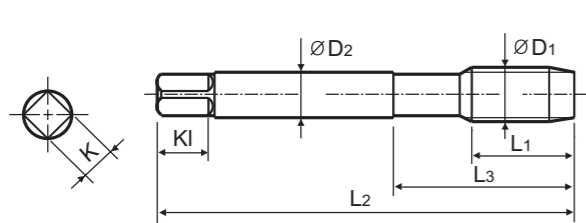
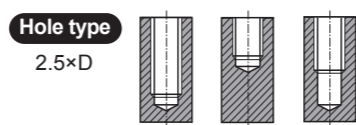


UNC Unified coarse threads
 ● Unified Grobgewinde
 ○ UNC
 ○ Unificato passo grosso

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: **GS** HSS-E DIN 371/376 2B 60° C R40 Bright p.B169

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		Bright	L1	L2	L3	ØD2	K	Kl	Z	Ød1
#4	-40UNC	TC144162	6	56	18	3.5	2.7	6	3	2.3
#5	-40UNC	TC144202	7	56	18	3.5	2.7	6	3	2.6
#6	-32UNC	TC144242	7	56	20	4	3	6	3	2.85
#8	-32UNC	TC144282	8	63	21	4.5	3.4	6	3	3.5
#10	-24UNC	TC144322	10	70	25	6	4.9	8	3	3.9
#12	-24UNC	TC144362	10	80	30	6	4.9	8	3	4.5
1/4	-20UNC	TC144402	13	80	30	7	5.5	8	3	5.2
5/16	-18UNC	TC144442	14	90	35	8	6.2	9	3	6.6
3/8	-16UNC	TC144482	16	100	39	9	7	10	3	8
7/16	-14UNC	TC144522	17	100	40	8	6.2	9	3	9.4
1/2	-13UNC	TC144562	20	110	44	9	7	10	3	10.75
9/16	-12UNC	TC144602	20	110	44	11	9	12	3	12.25
5/8	-11UNC	TC144642	22	110	44	12	9	12	3	13.5
3/4	-10UNC	TC144702	25	125	50	14	11	14	4	16.5
7/8	-9UNC	TC144742	27	140	54	18	14.5	17	4	19.5
1	-8UNC	TC144782	30	160	60	20	16	19	4	22.25
1-1/8	-7UNC	TC144822	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	21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	○	◎	◎	◎	◎	◎	◎	○	○	○	○	○	○	○	○	○	◎	◎	○	○

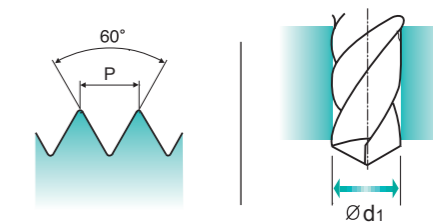
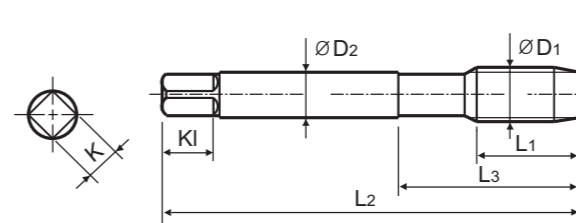
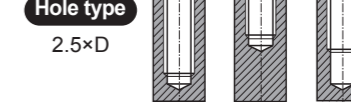
ISO	N					S					H											
	Aluminum-wrought alloy		Aluminum-cast, alloyed		Copper and Copper Alloys (Bronze / Brass)	Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron							
Material Description	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	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	○	○	○	◎	◎	○	○	◎			○	○	○	○	○	○	○	○	○	○	○	○

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: **GS** HSS-E DIN 371/374 2B 60° C R40 Bright p.B169

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		Bright	L1	L2	L3	ØD2	K	Kl	Z	Ød1
#4	-48UNF	TC124182	6	56	18	3.5	2.7	6	3	2.4
#5	-44UNF	TC124222	7	56	18	3.5	2.7	6	3	2.7
#6	-40UNF	TC124262	7	56	20	4	3	6	3	3
#8	-36UNF	TC124302	8	63	21	4.5	3.4	6	3	3.5
#10	-32UNF	TC124342	10	70	25	6	4.9	8	3	4.1
#12	-28UNF	TC124382	10	80	30	6	4.9	8	3	4.7
1/4	-28UNF	TC124422	10	80	30	7	5.5	8	3	5.5
5/16	-24UNF	TC124462	10	90	35	8	6.2	9	3	6.9
3/8	-24UNF	TC124502	10	100	39	9	7	10	3	8.5
7/16	-20UNF	TC124542	13	100	40	8	6.2	9	3	9.9
1/2	-20UNF	TC124582	13	100	40	9	7	10	3	11.5
9/16	-18UNF	TC124622	15	100	40	11	9	12	3	12.9
5/8	-18UNF	TC124662	15	100	40	12	9	12	3	14.5
3/4	-16UNF	TC124722	17	110	44	14	11	14	4	17.5
7/8	-14UNF	TC124762	17	125	50	18	14.5	17	4	20.5
1	-12UNF	TC124802	20	140	54	18	14.5	17	4	23.25
1-1/8	-12UNF	TC124842	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	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		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	○	○	○	◎	◎	○	○	◎			○	○	○	○	○	○	○	○	○	○	○	○