UNC Unified coarse threads

Unified Grobgewinde
UNC
Unificato passo grosso

Sets of taps
Gewindebohrer-Satz

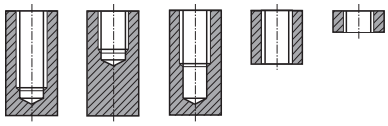
▶ This tap is a serial hand tap in set, First, Second and Bottoming.
▶ Bottoming tap of set has final internal thread dimensions only.

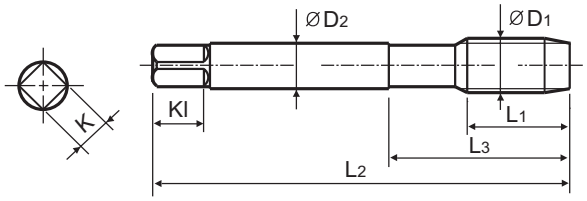
▶ Dies ist ein Handgewindebohrer im Satz mit Vor-, Mittel- und Fertigschneider.
▶ Nur der Fertigschneider kann das gewünschte Gewinde schneiden.

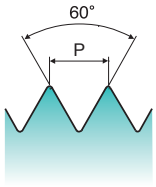
First
Second
Bottoming

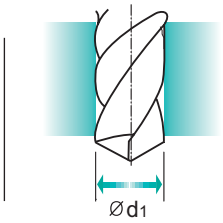


Hole type
2.0×D









Material groups **GS** | HSS | DIN 351 | 2B | 60° | I/II/III | Bright

p.B309

Recommended ToolHolder: Plain Shank — TAPPING ER CHUCK / TAPPING CHUCK / ONE STEP TAPPING CHUCK

Unit : mm

SIZE ØD1	TPI	EDP No. Bright	Thread Length L1	Overall Length L2	Neck Length L3	Shank Diameter ØD2	Square Size K	Square Length Kl	No. of Flute Z	Tapping Drill Diameter Ød1
#2	56UNC	T7363089	9	36	13	2.8	2.1	5	3	1.8
#3	48UNC	T7363129	10	40	15	2.8	2.1	5	3	2.1
#4	40UNC	T7363169	10	42	18	3.5	2.7	6	3	2.3
#5	40UNC	T7363209	10	42	18	3.5	2.7	6	3	2.6
#6	32UNC	T7363249	11	45	18	4	3	6	3	2.85
#8	32UNC	T7363289	12	48	23	4.5	3.4	6	3	3.5
#10	24UNC	T7363329	14	52	26	6	4.9	6	3	3.9
#12	24UNC	T7363369	16	56	27	6	4.9	8	3	4.5
1/4	20UNC	T7363409	16	56	27	6	4.9	8	3	5.2
5/16	18UNC	T7363449	20	63	34	6	4.9	8	3	6.6
3/8	16UNC	T7363489	22	70	38	7	5.5	8	4	8
7/16	14UNC	T7363529	22	70	38	8	6.2	9	4	9.4
1/2	13UNC	T7363569	25	80	45	9	7	10	4	10.75
9/16	12UNC	T7363609	26	80	45	11	9	12	4	12.25
5/8	11UNC	T7363649	27	90	55	12	9	12	4	13.5
3/4	10UNC	T7363709	32	105	65	14	11	14	4	16.5
7/8	9UNC	T7363749	32	110	69	18	14.5	17	4	19.5
1	8UNC	T7363789	36	110	69	20	16	19	4	22.25
1-1/8	7UNC	T7363829	40	125	77	22	18	21	4	25
1-1/4	7UNC	T7363869	40	125	77	25	20	23	4	28.25
1-1/8	6UNC	T7363909	50	150	88	28	22	25	4	30.75
1-1/2	6UNC	T7363949	50	150	88	32	24	27	4	34
1-3/4	5UNC	T7363B89	58	160	93	36	29	32	4	39.5
2	4½UNC	T7363D29	65	180	102	40	32	35	4	45.25

◎ : 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	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			
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			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					○	○	○														