YG TAP INOX

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.

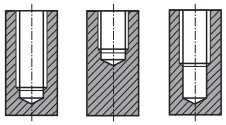
DIN 371

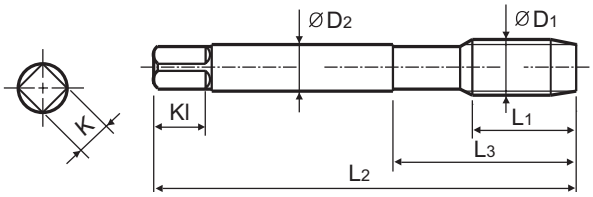


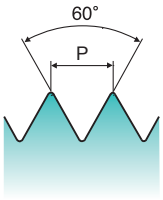
DIN 376

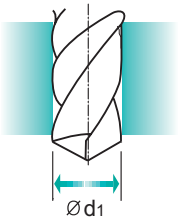


Hole type
2.5×D









Material groups VA NW | HSS-E | DIN 371/376 | 2B | 60° | C | R40 | Vap

p.B193

Recommended ToolHolder
Plain Shank
TAPPING ER CHUCK
TAPPING CHUCK
ONE STEP TAPPING CHUCK

Unit : mm

SIZE ØD1	TPI	EDP No. Vap	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
#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					
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	400 Rm	1050 Rm	550	630	400	550
Recommended											○					○					

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