YG TAP INOX

TB924 SERIES

UNF

Unified fine threads

Unified Feingewinde
UNF
Unificato passo fine

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.

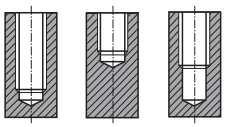
DIN 371

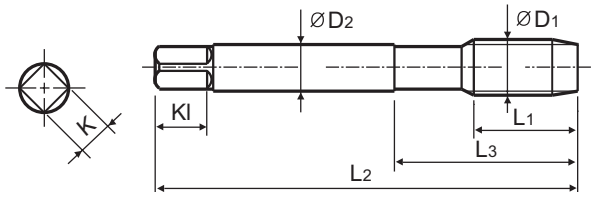


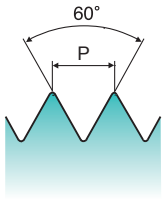
DIN 374

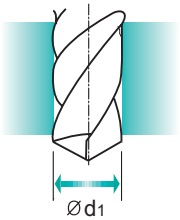


Hole type
2.5×D









Material groups **VA NW** | HSS-E | DIN 371/374 | 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	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					
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											○					○					