# YG TAP STEEL

**TC184 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.

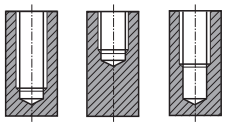
DIN 371

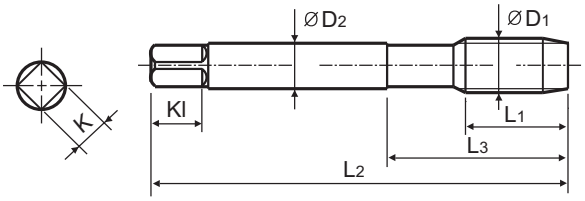


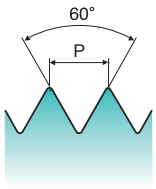
DIN 374

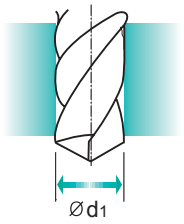


**Hole type**
2.5×D






Material groups **VG** | HSS-E | DIN 371/374 | 2B | 60° | C | R40 | Bright

p.B159

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 |
|---|---|---|---|---|---|---|---|---|---|---|
| #4 | - 48UNF | TC184182 | 6 | 56 | 18 | 3.5 | 2.7 | 6 | 3 | 2.4 |
| #5 | - 44UNF | TC184222 | 7 | 56 | 18 | 3.5 | 2.7 | 6 | 3 | 2.7 |
| #6 | - 40UNF | TC184262 | 7 | 56 | 20 | 4 | 3 | 6 | 3 | 3 |
| #8 | - 36UNF | TC184302 | 8 | 63 | 21 | 4.5 | 3.4 | 6 | 3 | 3.5 |
| #10 | - 32UNF | TC184342 | 10 | 70 | 25 | 6 | 4.9 | 8 | 3 | 4.1 |
| #12 | - 28UNF | TC184382 | 10 | 80 | 30 | 6 | 4.9 | 8 | 3 | 4.7 |
| 1/4 | - 28UNF | TC184422 | 10 | 80 | 30 | 7 | 5.5 | 8 | 3 | 5.5 |
| 5/16 | - 24UNF | TC184462 | 10 | 90 | 35 | 8 | 6.2 | 9 | 3 | 6.9 |
| 3/8 | - 24UNF | TC184502 | 10 | 100 | 39 | 9 | 7 | 10 | 3 | 8.5 |
| 7/16 | - 20UNF | TC184542 | 13 | 100 | 40 | 8 | 6.2 | 9 | 3 | 9.9 |
| 1/2 | - 20UNF | TC184582 | 13 | 100 | 40 | 9 | 7 | 10 | 3 | 11.5 |
| 9/16 | - 18UNF | TC184622 | 15 | 100 | 40 | 11 | 9 | 12 | 3 | 12.9 |
| 5/8 | - 18UNF | TC184662 | 15 | 100 | 40 | 12 | 9 | 12 | 3 | 14.5 |
| 3/4 | - 16UNF | TC184722 | 17 | 110 | 44 | 14 | 11 | 14 | 4 | 17.5 |
| 7/8 | - 14UNF | TC184762 | 17 | 125 | 50 | 18 | 14.5 | 17 | 4 | 20.5 |
| 1 | - 12UNF | TC184802 | 20 | 140 | 54 | 18 | 14.5 | 17 | 4 | 23.25 |
| 1-1/8 | - 12UNF | TC184842 | 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 | | | | | | | | | | | ○ | | | | | ○ | | | | | |