UNF Unified fine threads

Unified Feingewinde
UNF
Unificato passo fine

Machine taps
Maschinengewindebohrer

▶ Suitable for through hole in more cutting speed than other taps due to thick web.

▶ Geeignet für Durchgangslöcher in höherer Schnittgeschwindigkeit als bei anderen Gewindebohrern dank größerer Kerndicke.

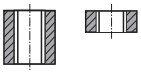
DIN 371

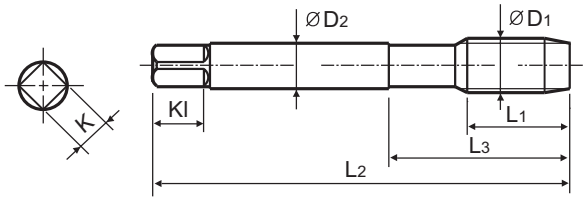


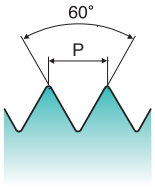
DIN 374

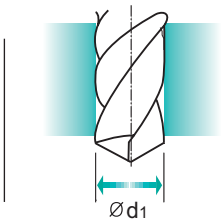


Hole type
3.0×D









Material groups **GS** | HSS-E | DIN 371/374 | 2B | 60° | B | 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
#4	48UNF	TC234182	11	56	18	3.5	2.7	6	3	2.4
#5	44UNF	TC234222	11	56	18	3.5	2.7	6	3	2.7
#6	40UNF	TC234262	12	56	20	4	3	6	3	3
#8	36UNF	TC234302	13	63	21	4.5	3.4	6	3	3.5
#10	32UNF	TC234342	15	70	25	6	4.9	8	3	4.1
#12	28UNF	TC234382	16	80	30	6	4.9	8	3	4.7
1/4	28UNF	TC234422	17	80	30	7	5.5	8	3	5.5
5/16	24UNF	TC234462	17	90	35	8	6.2	9	3	6.9
3/8	24UNF	TC234502	18	100	39	9	7	10	3	8.5
7/16	20UNF	TC234542	22	100	40	8	6.2	9	3	9.9
1/2	20UNF	TC234582	22	100	40	9	7	10	3	11.5
9/16	18UNF	TC234622	22	100	40	11	9	12	3	12.9
5/8	18UNF	TC234662	22	100	40	12	9	12	3	14.5
3/4	16UNF	TC234722	25	110	44	14	11	14	4	17.5
7/8	14UNF	TC234762	26	125	50	18	14.5	17	4	20.5
1	12UNF	TC234802	28	140	54	18	14.5	17	4	23.25
1-1/8	12UNF	TC234842	30	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	○		○	○	◎	○		◎													