YG TAP GENERAL

TC424 SERIES

UNC

Unified coarse threads

Unified Grobgewinde
UNC
Unificato passo grosso

Machine taps
Maschinengewindebohrer

▶ Suitable for tapping shallow holes.

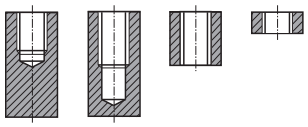
▶ Geeignet zum Gewindeschneiden flacher Sacklöcher.

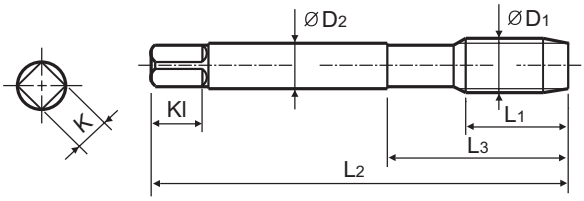
DIN 371

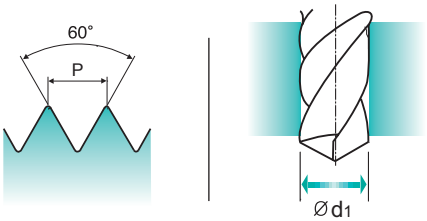
DIN 376



Hole type
2.0×D







Material groups **GS** | HSS-E | DIN 371/376 | 2B | 60° | C | 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	40UNC	TC424162	11	56	18	3.5	2.7	6	3	2.3
#5	40UNC	TC424202	11	56	18	3.5	2.7	6	3	2.6
#6	32UNC	TC424242	12	56	20	4	3	6	3	2.85
#8	32UNC	TC424282	13	63	21	4.5	3.4	6	3	3.5
#10	24UNC	TC424322	15	70	25	6	4.9	8	3	3.9
#12	24UNC	TC424362	16	80	30	6	4.9	8	3	4.5
1/4	20UNC	TC424402	17	80	30	7	5.5	8	3	5.2
5/16	18UNC	TC424442	20	90	35	8	6.2	9	3	6.6
3/8	16UNC	TC424482	22	100	39	9	7	10	3	8
7/16	14UNC	TC424522	22	100	40	8	6.2	9	3	9.4
1/2	13UNC	TC424562	25	110	44	9	7	10	3	10.75
9/16	12UNC	TC424602	26	110	44	11	9	12	3	12.25
5/8	11UNC	TC424642	27	110	44	12	9	12	3	13.5
3/4	10UNC	TC424702	30	125	50	14	11	14	4	16.5
7/8	9UNC	TC424742	32	140	54	18	14.5	17	4	19.5
1	8UNC	TC424782	36	160	60	20	16	19	4	22.25
1-1/8	7UNC	TC424822	40	180	70	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	400Rm	1050Rm	550	630	400	550
Recommended					○	○	○														

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