SCREW THREAD INSERT TAP

TC954 SERIES

EG-UNF

Unified fine threads for Screw Thread insert

Unified Feingew.f.Gew.Drahteins
UNC POUR FILETS RAPPORTÉS
ISO Metrico passo fine per Helicoil

Machine taps
Maschinengewindebohrer

▶ Wire insert threads are used for increasing fastening strength in soft materials.

▶ Gewinde mit Drahteinsätzen werden verwendet um größere Drehmomente in weichen Werkstoffen zu erreichen.

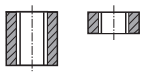
DIN 371

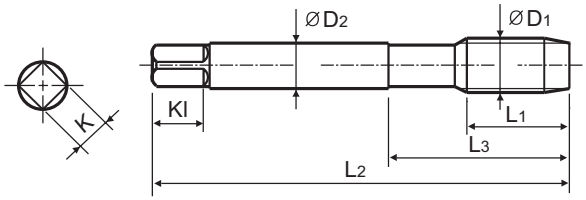


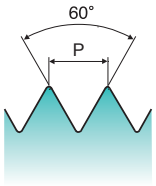
DIN 374

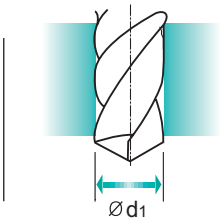


Hole type
3.0×D









Material groups **Al** | HSS-E | DIN 371/376 | 2B | 60° | B | Bright

p.B326

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	- 48 UNF	TC954182	12	56	20	4	3	6	3	3.1
#6	- 40 UNF	TC954262	14	70	25	6	4.9	8	3	3.7
#8	- 36 UNF	TC954302	13	70	25	6	4.9	8	3	4.4
#10	- 32 UNF	TC954342	13	80	25	6	4.9	8	3	5.1
1/4	- 28 UNF	TC954422	17	90	35	8	6.2	9	3	6.6
5/16	- 24 UNF	TC954462	18	100	39	10	8	11	3	8.25
3/8	- 24 UNF	TC954502	18	110	39	12	9	12	3	9.8
7/16	- 20 UNF	TC954542	22	100	40	9	7	10	3	11.5
1/2	- 20 UNF	TC954582	22	100	40	11	9	12	3	13.1
9/16	- 18 UNF	TC954622	22	100	40	12	9	12	3	14.75
5/8	- 18 UNF	TC954662	25	110	44	14	11	14	4	16.25
3/4	- 16 UNF	TC954722	25	125	50	16	12	15	4	19.5

▶ DIN 371(#4~3/8) and DIN 374(7/16~3/4)

◎ : 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	◎	◎	◎	◎			◎														