YG TAP STEEL

TD174 SERIES

UNC

Unified coarse threads

- Unified Grobgewinde
- UNC
- Unificato passo grosso

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.

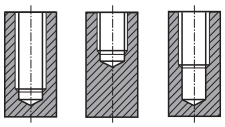
DIN 371

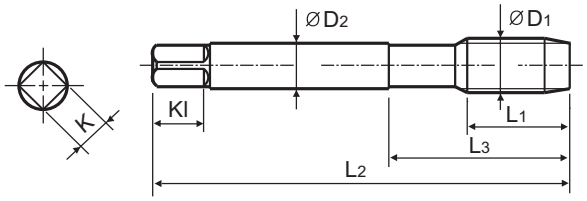


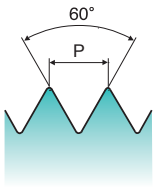
DIN 376

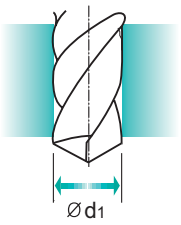


Hole type
2.5×D









Material groups **VG** | HSS-E | DIN 371/376 | 2B | 60° | C | R40 | TiN

p.B159

Recommended ToolHolder
Plain Shank
TAPPING ER CHUCK
TAPPING CHUCK
ONE STEP TAPPING CHUCK

Unit : mm

SIZE ØD1	TPI	EDP No. TiN	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	TD174162	6	56	18	3.5	2.7	6	3	2.3
#5	- 40UNC	TD174202	7	56	18	3.5	2.7	6	3	2.6
#6	- 32UNC	TD174242	7	56	20	4	3	6	3	2.85
#8	- 32UNC	TD174282	8	63	21	4.5	3.4	6	3	3.5
#10	- 24UNC	TD174322	10	70	25	6	4.9	8	3	3.9
#12	- 24UNC	TD174362	10	80	30	6	4.9	8	3	4.5
1/4	- 20UNC	TD174402	13	80	30	7	5.5	8	3	5.2
5/16	- 18UNC	TD174442	14	90	35	8	6.2	9	3	6.6
3/8	- 16UNC	TD174482	16	100	39	9	7	10	3	8
7/16	- 14UNC	TD174522	17	100	40	8	6.2	9	3	9.4
1/2	- 13UNC	TD174562	20	110	44	9	7	10	3	10.75
9/16	- 12UNC	TD174602	20	110	44	11	9	12	3	12.25
5/8	- 11UNC	TD174642	22	110	44	12	9	12	3	13.5
3/4	- 10UNC	TD174702	25	125	50	14	11	14	4	16.5
7/8	- 9UNC	TD174742	27	140	54	18	14.5	17	4	19.5
1	- 8UNC	TD174782	30	160	60	20	16	19	4	22.25
1-1/8	- 7UNC	TD174822	35	180	65	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											○					○					