YG TAP CAST IRON

TE454 SERIES

UNF

Unified fine threads

Unified Feingewinde
UNF
Unificato passo fine

Machine taps
Maschinengewindebohrer

▶ Suitable for tapping cast iron or similar work materials due to nitriding.

▶ Geeignet zum Gewindeschneiden von Guss oder ähnlichen Werkstoffen dank der Nitrierung

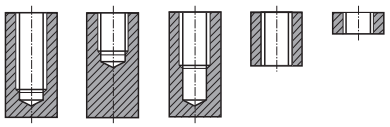
DIN 371

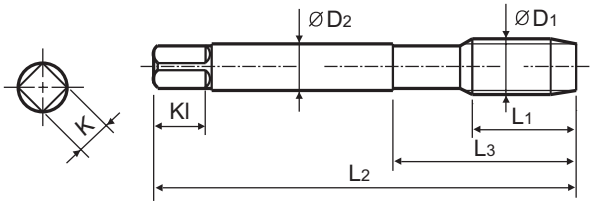


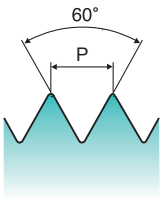
DIN 374

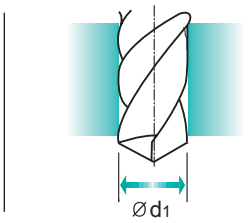


Hole type
2.0×D









Material groups **GG** | HSS-E | DIN 371/374 | 2BX | 60° | C | Nitride

p.B205

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

Unit : mm

SIZE ØD1	TPI	EDP No. Ni	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	TE454182	11	56	18	3.5	2.7	6	3	2.4
#5	- 44UNF	TE454222	11	56	18	3.5	2.7	6	3	2.7
#6	- 40UNF	TE454262	12	56	20	4	3	6	3	3
#8	- 36UNF	TE454302	13	63	21	4.5	3.4	6	3	3.5
#10	- 32UNF	TE454342	15	70	25	6	4.9	8	3	4.1
#12	- 28UNF	TE454382	16	80	30	6	4.9	8	4	4.7
1/4	- 28UNF	TE454422	17	80	30	7	5.5	8	4	5.5
5/16	- 24UNF	TE454462	17	90	35	8	6.2	9	4	6.9
3/8	- 24UNF	TE454502	18	100	39	9	7	10	4	8.5
7/16	- 20UNF	TE454542	22	100	40	8	6.2	9	4	9.9
1/2	- 20UNF	TE454582	22	100	40	9	7	10	4	11.5
9/16	- 18UNF	TE454622	22	100	40	11	9	12	4	12.9
5/8	- 18UNF	TE454662	22	100	40	12	9	12	4	14.5
3/4	- 16UNF	TE454722	25	110	44	14	11	14	4	17.5
7/8	- 14UNF	TE454762	26	125	50	18	14.5	17	4	20.5
1	- 12UNF	TE454802	28	140	54	18	14.5	17	4	23.25
1-1/8	- 12UNF	TE454842	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							○														

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