YG TAP FORMING

TE704 SERIES

UNC

Unified coarse threads

Unified Grobgewinde
UNC
Unificato passo grosso

Cold forming taps with oil grooves
Gewindeformer mit Schmiernuten

▶ Suitable for threading soft materials with at least 8-10% elongation.
▶ The pre-drilling holes are bigger than normal sized holes.

▶ Geeignet zum Gewindeformen weicher Werkstoffe mit mindestens 8-10% Dehnung.
▶ Die Kernlochbohrungen sind größer als normale Kernlöcher.

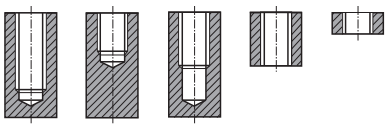
DIN 371

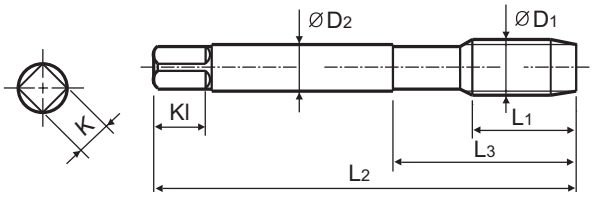


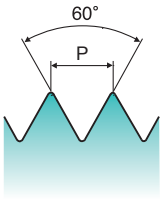
DIN 376

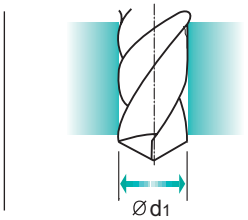


Hole type
3.0×D









Material groups **GV** | HSS-E | DIN 371/376 | 2BX | 60° | C | Nitride

p.B265

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

Unit : mm

SIZE	TPI	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	Tapping Drill Diameter
ØD1		Ni	L1	L2	L3	ØD2	K	Kl	Ød1
#5	40 UNC	TE704202	11	56	18	3.5	2.7	6	2.87
#6	32 UNC	TE704242	12	56	20	4	3	6	3.1
#8	32 UNC	TE704282	13	63	21	4.5	3.4	6	3.8
#10	24 UNC	TE704322	15	70	25	6	4.9	8	4.3
#12	24 UNC	TE704362	16	80	30	6	4.9	8	4.95
1/4	20 UNC	TE704402	17	80	30	7	5.5	8	5.75
5/16	18 UNC	TE704442	20	90	35	8	6.2	9	7.25
3/8	16 UNC	TE704482	22	100	39	9	7	10	8.75
7/16	14 UNC	TE704522	22	100	40	8	6.2	9	10.2
1/2	13 UNC	TE704562	25	110	44	9	7	10	11.7
9/16	12 UNC	TE704602	26	110	40	11	9	12	13.2
5/8	11 UNC	TE704642	27	110	44	12	9	12	14.7
3/4	10 UNC	TE704702	30	125	50	14	11	14	17.8

▶ DIN 371(#4~3/8) and DIN 376(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	◎	◎	○	○		○		○													

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