PRIME TAP

TRJ18 SERIES

UNF Unified Fine Threads

Unified Feingewinde
UNF
Unificato passo fine

Machine taps
Maschinengewindebohrer

- ▶ High performance on various ductile materials
- ▶ Specially designed to prevent oversized threads and reduce gauging problems

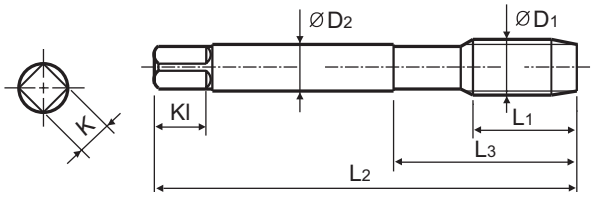
- ▶ Ausgezeichnete Leistung bei verschiedenen Werkstoffen.
- ▶ Speziell entwickelt, um zu gro ß e Gewindedurchmesser zu vermeiden und Messprobleme zu reduzieren.

DIN 371

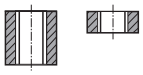


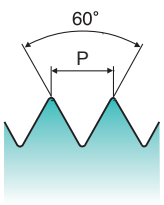
DIN 374

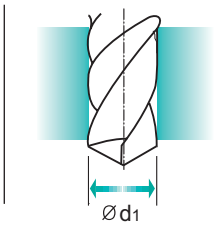




Hole type
3.0×D







Material groups **MU**

HSS PM | DIN 371/374 | 2BX | 60° | B | X Coating

p.B88

Recommended ToolHolder

Plain Shank
SYNCHRO TAPPING CHUCK
TAPPING ER CHUCK
TAPPING CHUCK
ONE STEP TAPPING CHUCK

Unit : mm

SIZE ØD1	TPI	EDP No. X-Coating	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	TRJ18182GS	11.0	56.0	18.0	3.5	2.7	6.0	2	2.40
#5	44 UNF	TRJ18222GS	11.0	56.0	18.0	3.5	2.7	6.0	3	2.70
#6	40 UNF	TRJ18262GS	12.0	56.0	20.0	4.0	3.0	6.0	3	2.90
#8	36 UNF	TRJ18302GS	13.0	63.0	21.0	4.5	3.4	6.0	3	3.50
#10	32 UNF	TRJ18342GS	15.0	70.0	25.0	6.0	4.9	8.0	3	4.10
#12	28 UNF	TRJ18382GS	16.0	80.0	30.0	6.0	4.9	8.0	3	4.60
1/4	28 UNF	TRJ18422GS	17.0	80.0	30.0	7.0	5.5	8.0	3	5.50
5/16	24 UNF	TRJ18462GS	17.0	90.0	35.0	8.0	6.2	9.0	3	6.90
3/8	24 UNF	TRJ18502GS	18.0	100.0	39.0	9.0	7.0	10.0	3	8.50
7/16	20 UNF	TRJ18542GS	22.0	100.0	40.0	8.0	6.2	9.0	3	9.90
1/2	20 UNF	TRJ18582GS	22.0	100.0	40.0	9.0	7.0	10.0	3	11.50
9/16	18 UNF	TRJ18622GS	22.0	100.0	40.0	11.0	9.0	12.0	3	12.90
5/8	18 UNF	TRJ18662GS	22.0	100.0	40.0	12.0	9.0	12.0	3	14.50
3/4	16 UNF	TRJ18722GS	25.0	110.0	44.0	14.0	11.0	14.0	3	17.50
7/8	14 UNF	TRJ18762GS	26.0	125.0	50.0	18.0	14.5	17.0	3	20.50
1"	12 UNF	TRJ18802GS	28.0	140.0	54.0	20.0	16.0	19.0	3	23.20

▶ DIN371 (#4~3/8) and DIN374 (7/16~1)

◎ : 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	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	◎	◎	○	◎	◎	◎													