



UNF

Unified fine threads

Unified Feingewinde

UNF

Unificato passo grosso

► 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

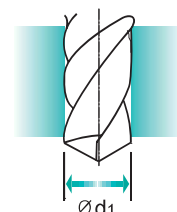
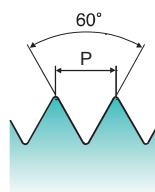
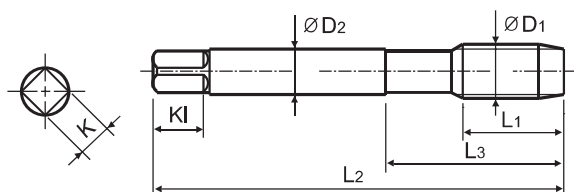
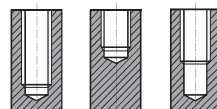


DIN 374



Hole type

2.5×D



Material groups

AI

HSS-E

DIN 371/374

2B



Bright

Machine taps
Maschinengewindebohrer

Recommended Cutting Page : P.252

Unit : mm

SIZE	TPI	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1		Bright	L1	L2	L3	ØD2	K	K1	Z	Ød1
#4	- 48UNF	TC170182	6	56	18	3.5	2.7	6	2	2.4
#5	- 44UNF	TC170222	7	56	18	3.5	2.7	6	2	2.7
#6	- 40UNF	TC170262	7	56	20	4	3	6	2	3
#8	- 36UNF	TC170302	8	63	21	4.5	3.4	6	2	3.5
#10	- 32UNF	TC170342	10	70	25	6	4.9	8	2	4.1
#12	- 28UNF	TC170382	10	80	30	6	4.9	8	2	4.7
1/4	- 28UNF	TC170422	10	80	30	7	5.5	8	2	5.5
5/16	- 24UNF	TC170462	10	90	35	8	6.2	9	2	6.9
3/8	- 24UNF	TC170502	10	100	39	9	7	10	2	8.5
7/16	- 20UNF	TC170542	13	100	40	8	6.2	9	2	9.9
1/2	- 20UNF	TC170582	13	100	40	9	7	10	2	11.5
9/16	- 18UNF	TC170622	15	100	40	11	9	12	3	12.9
5/8	- 18UNF	TC170662	15	100	40	12	9	12	3	14.5
3/4	- 16UNF	TC170722	17	110	44	14	11	14	3	17.5
7/8	- 14UNF	TC170762	17	125	50	18	14.5	17	3	20.5
1	- 12UNF	TC170802	20	140	54	18	14.5	17	3	23.25
1-1/8	- 12UNF	TC170842	22	150	60	22	18	21	3	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	◎	◎	◎	◎			○														