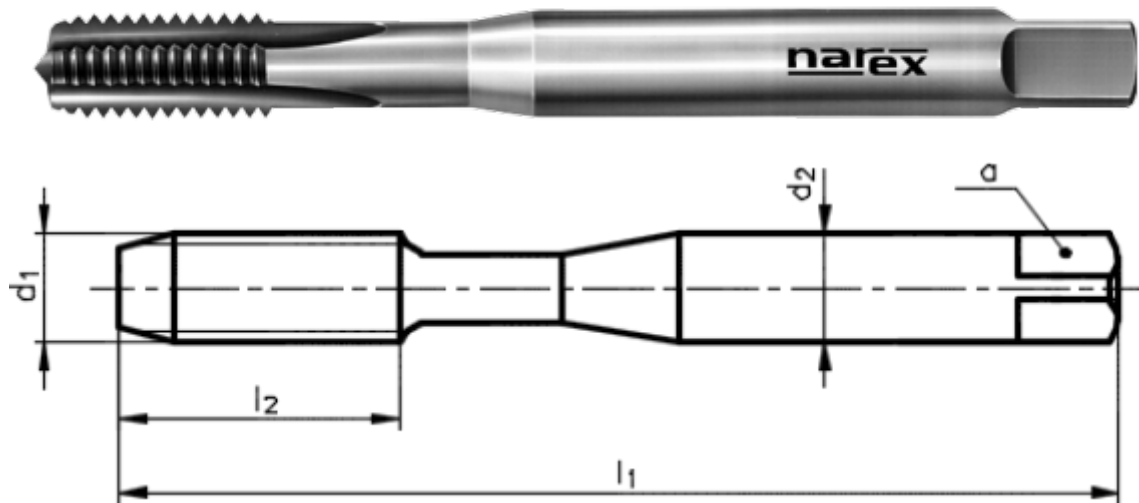


Machine tap with straight flutes

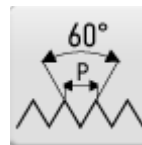


CATALOGUE NUMBER: 1004

Machine tap with straight flutes, unified national coarse thread, DIN 371, suitable for structural steels, free cutting steels, short chipping copper alloys, grey cast iron, aluminium alloys with Si>10%.



THREAD UNC
Unified coarse thread



PROFILE SKETCH
60°



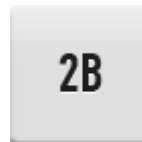
TYPE N
Tap for steels up to 800 N/mm²



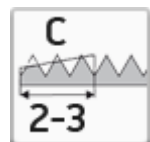
TAP MATERIAL
Super high speed steel



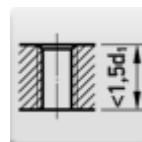
TAP STANDARD
~ DIN 371



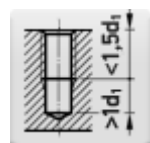
THREAD TOLERANCE
2B



CHAMFER C
Length 2-3 pitch



HOLE TYPE
Through hole (thread length $L < 1,5d_1$)



HOLE TYPE
Blind hole (thread length $< 1,5 d_1$, pilot drilling depth $\geq L+d_1$)

Select product model

ID	D1	P	Tolerance	l1	l2	d2	a	Price excl. VAT	Price incl. VAT
041531810002000	UNC5	40	2B	56	9	3,5	2,7	9.80 EUR	11.86 EUR
041531810003000	UNC6	32	2B	56	11	4	3	9.20 EUR	11.13 EUR
041531810004000	UNC8	32	2B	63	12	4,5	3,4	9.20 EUR	11.13 EUR
041531810005000	UNC10	24	2B	70	13	6	4,9	9.80 EUR	11.86 EUR
041531810006000	UNC12	24	2B	80	15	6	4,9	11.00 EUR	13.31 EUR
041531810007000	UNC1/4	20	2B	80	15	7	5,2	10.55 EUR	12.77 EUR
041531810009000	UNC5/16	18	2B	90	18	8	6,2	11.70 EUR	14.16 EUR
041531810011000	UNC3/8	16	2B	90	20	9	7	13.00 EUR	15.73 EUR

Use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Aluminium alloys si content > 10%	through hole (thread length $L < 1,5d1$)	12-15	Emulsion	Possible use
Copper alloys (short chipping)	blind hole (thread length $< 1,5 d1$, pilot drilling depth $\geq L+d1$)	10-15	Cutting Oil/Emulsion	Recommended use
Copper alloys (short chipping)	through hole (thread length $L < 1,5d1$)	10-15	Cutting Oil/Emulsion	Recommended use
Free cutting steels up to 800 N/mm2	blind hole (thread length $< 1,5 d1$, pilot drilling depth $\geq L+d1$)	8-10	Cutting Oil/Emulsion	Possible use
Free cutting steels up to 800 N/mm2	through hole (thread length $L < 1,5d1$)	8-10	Cutting Oil/Emulsion	Possible use
Grey cast iron	through hole (thread length $L < 1,5d1$)	7-10	Emulsion	Possible use
Grey cast iron	blind hole (thread length $L < 2xd1$)	7-10	Emulsion	Possible use
Grey cast iron	blind hole (thread length $< 1,5 d1$, pilot drilling depth $\geq L+d1$)	7-10	Emulsion	Possible use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Grey cast iron	blind hole (thread length $L < 2,5d_1$)	7-10	Emulsion	Possible use
Grey cast iron	through hole (thread length $L > 1,5d_1$)	7-10	Emulsion	Possible use
Grey cast iron	blind hole (thread length $L < 1,5d_1$)	7-10	Emulsion	Possible use
Structural steels up to 500 N/mm ²	through hole (thread length $L < 1,5d_1$)	4-6	Cutting Oil/Emulsion	Possible use
Structural steels up to 500 N/mm ²	blind hole (thread length $< 1,5 d_1$, pilot drilling depth $\geq L+d_1$)	4-6	Cutting Oil/Emulsion	Possible use

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