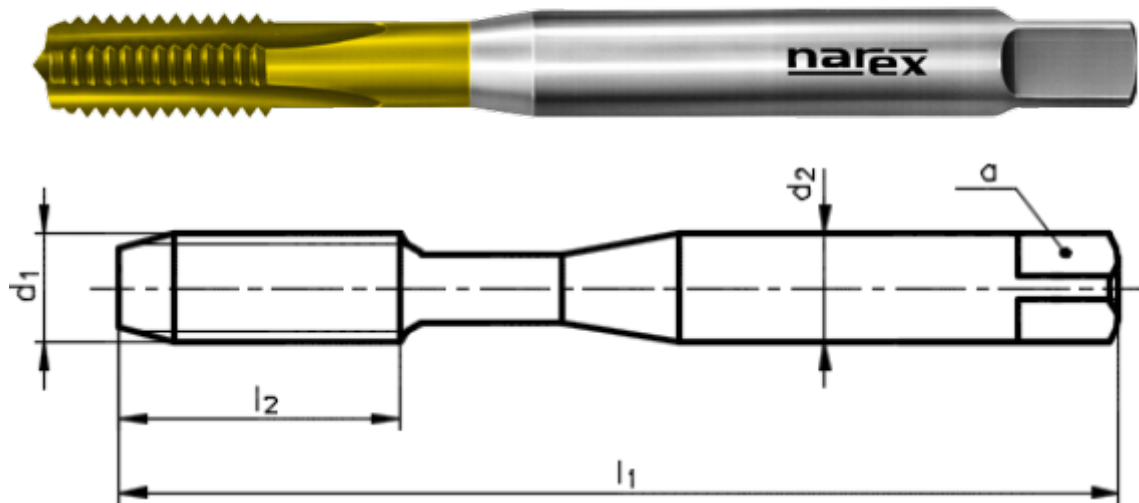


Machine tap with straight flutes

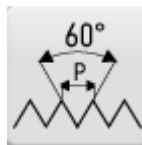


CATALOGUE NUMBER: 1014

Machine tap with straight flutes, unified national coarse thread, DIN 371, TiN coated, 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



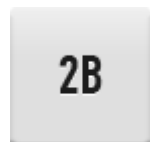
TAP MATERIAL
Super high speed steel



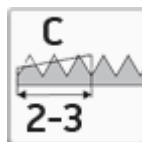
COATING
Titanium nitride coating



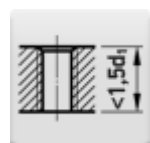
TAP STANDARD
~ DIN 371



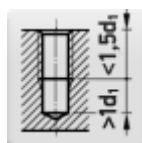
THREAD TOLERANCE
2B



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
041535810002000	UNC5	40	2B	56	9	3,5	2,7	12.80 EUR	15.49 EUR
041535810003000	UNC6	32	2B	56	11	4	3	12.00 EUR	14.52 EUR
041535810004000	UNC8	32	2B	63	12	4,5	3,4	12.00 EUR	14.52 EUR
041535810005000	UNC10	24	2B	70	13	6	4,9	12.80 EUR	15.49 EUR
041535810006000	UNC12	24	2B	80	15	6	4,9	14.25 EUR	17.24 EUR
041535810007000	UNC1/4	20	2B	80	15	7	5,2	13.80 EUR	16.70 EUR
041535810009000	UNC5/16	18	2B	90	18	8	6,2	15.30 EUR	18.51 EUR
041535810011000	UNC3/8	16	2B	90	20	9	7	16.95 EUR	20.51 EUR

Use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Aluminium alloys si content > 10%	through hole (thread length $L < 1,5d1$)	14-20	Emulsion	Recommended use
Copper alloys (short chipping)	through hole (thread length $L < 1,5d1$)	15-25	Cutting Oil/Emulsion	Recommended use
Copper alloys (short chipping)	blind hole (thread length $< 1,5 d1$, pilot drilling depth $\geq L+d1$)	15-25	Cutting Oil/Emulsion	Recommended use
Free cutting steels up to 800 N/mm2	through hole (thread length $L < 1,5d1$)	10-14	Cutting Oil/Emulsion	Possible use
Free cutting steels up to 800 N/mm2	blind hole (thread length $< 1,5 d1$, pilot drilling depth $\geq L+d1$)	10-14	Cutting Oil/Emulsion	Possible use
Grey cast iron	through hole (thread length $L > 1,5d1$)	8-12	Emulsion	Possible use
Grey cast iron	blind hole (thread length $L < 1,5d1$)	8-12	Emulsion	Possible use
Grey cast iron	through hole (thread length $L < 1,5d1$)	8-12	Emulsion	Possible use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Grey cast iron	blind hole (thread length $L < 2 \times d_1$)	8-12	Emulsion	Possible use
Grey cast iron	blind hole (thread length $< 1,5 d_1$, pilot drilling depth $\geq L + d_1$)	8-12	Emulsion	Possible use
Grey cast iron	blind hole (thread length $L < 2,5 \times d_1$)	8-12	Emulsion	Possible use
Structural steels up to 500 N/mm ²	blind hole (thread length $< 1,5 d_1$, pilot drilling depth $\geq L + d_1$)	5-8	Cutting Oil/Emulsion	Possible use
Structural steels up to 500 N/mm ²	through hole (thread length $L < 1,5 \times d_1$)	5-8	Cutting Oil/Emulsion	Possible use

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