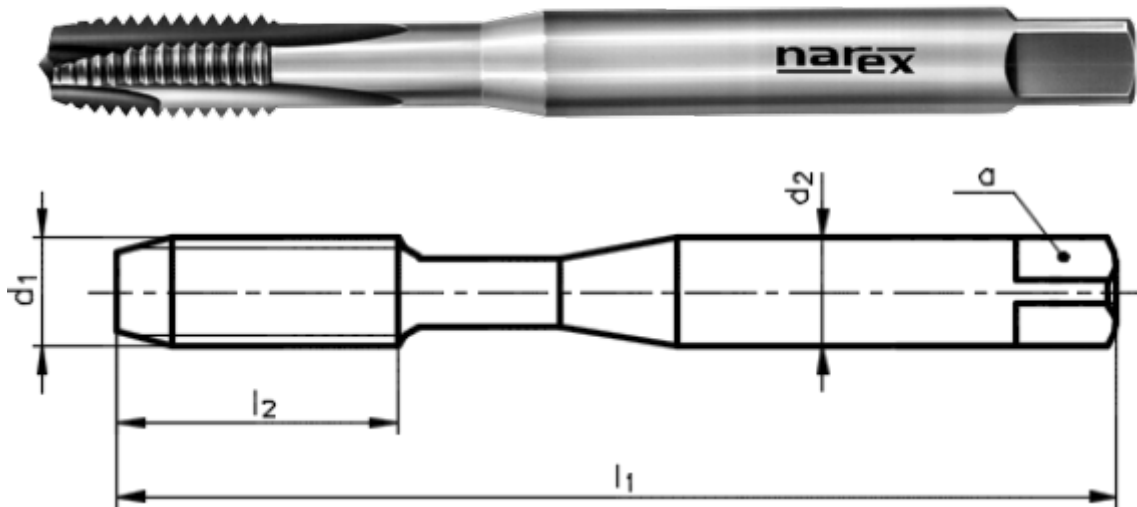


Machine tap with straight flutes and spiral point

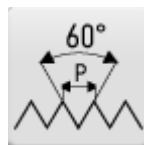


CATALOGUE NUMBER: 1504

Machine tap with straight flutes and spiral point, unified national coarse thread, DIN 371, suitable for structural steels, plain cast steels, free cutting steels, short chipping copper alloys, spheroidal and malleable 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



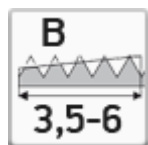
TAP MATERIAL
Super high speed steel



TAP STANDARD
~ DIN 371



THREAD TOLERANCE
2B



CHAMFER B
Length 3,5-6 pitch



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

Select product model

ID	D1	P	Tolerance	l1	l2	d2	a	Price excl. VAT	Price incl. VAT
041531820002000	UNC5	40	2B	56	9	3,5	2,7	10.30 EUR	12.46 EUR
041531820003000	UNC6	32	2B	56	11	4	3	9.90 EUR	11.98 EUR
041531820004000	UNC8	32	2B	63	12	4,5	3,4	9.75 EUR	11.80 EUR
041531820005000	UNC10	24	2B	70	13	6	4,9	10.50 EUR	12.71 EUR
041531820006000	UNC12	24	2B	80	15	6	4,9	11.75 EUR	14.22 EUR
041531820007000	UNC1/4	20	2B	80	15	7	5,2	11.30 EUR	13.67 EUR
041531820009000	UNC5/16	18	2B	90	18	8	6,2	12.80 EUR	15.49 EUR
041531820011000	UNC3/8	16	2B	90	20	9	7	14.30 EUR	17.30 EUR

Use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Aluminium alloys si content < 10%	through hole (thread length L > 1,5xd1)	14-20	Emulsion	Recommended use
Aluminium alloys si content < 10%	through hole (thread length L < 1,5xd1)	14-20	Emulsion	Recommended use
Aluminium alloys si content > 10%	through hole (thread length L > 1,5xd1)	12-15	Emulsion	Possible use
Aluminium alloys si content > 10%	through hole (thread length L < 1,5xd1)	12-15	Emulsion	Possible use
Copper alloys (short chipping)	through hole (thread length L < 1,5xd1)	12-20	Cutting Oil/Emulsion	Possible use
Copper alloys (short chipping)	through hole (thread length L > 1,5xd1)	12-20	Cutting Oil/Emulsion	Possible use
Free cutting steels up to 800 N/mm2	through hole (thread length L > 1,5xd1)	10-14	Cutting Oil/Emulsion	Possible use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Free cutting steels up to 800 N/mm ²	through hole (thread length $L < 1,5d_1$)	10-14	Cutting Oil/Emulsion	Possible use
Plain cast steels up to 500 N/mm ²	through hole (thread length $L > 1,5d_1$)	6-10	Cutting Oil/Emulsion	Recommended use
Plain cast steels up to 500 N/mm ²	through hole (thread length $L < 1,5d_1$)	6-10	Cutting Oil/Emulsion	Recommended use
Plain cast steels up to 800 N/mm ²	through hole (thread length $L > 1,5d_1$)	10-14	Cutting Oil/Emulsion	Possible use
Plain cast steels up to 800 N/mm ²	through hole (thread length $L < 1,5d_1$)	10-14	Cutting Oil/Emulsion	Possible use
Spheroidal graphite cast iron and malleable cast iron	through hole (thread length $L < 1,5d_1$)	4-7	Emulsion	Possible use
Spheroidal graphite cast iron and malleable cast iron	blind hole (thread length $< 1,5 d_1$, pilot drilling depth $\geq L+d_1$)	4-7	Emulsion	Possible use
Spheroidal graphite cast iron and malleable cast iron	through hole (thread length $L > 1,5d_1$)	4-7	Emulsion	Possible use
Structural steels and heat-treated steels up to 800 N/mm ²	through hole (thread length $L > 1,5d_1$)	10-14	Cutting Oil/Emulsion	Recommended use
Structural steels and heat-treated steels up to 800 N/mm ²	through hole (thread length $L < 1,5d_1$)	10-14	Cutting Oil/Emulsion	Recommended use
Structural steels up to 500 N/mm ²	through hole (thread length $L < 1,5d_1$)	5-8	Cutting Oil/Emulsion	Possible use
Structural steels up to 500 N/mm ²	through hole (thread length $L > 1,5d_1$)	5-8	Cutting Oil/Emulsion	Possible use

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