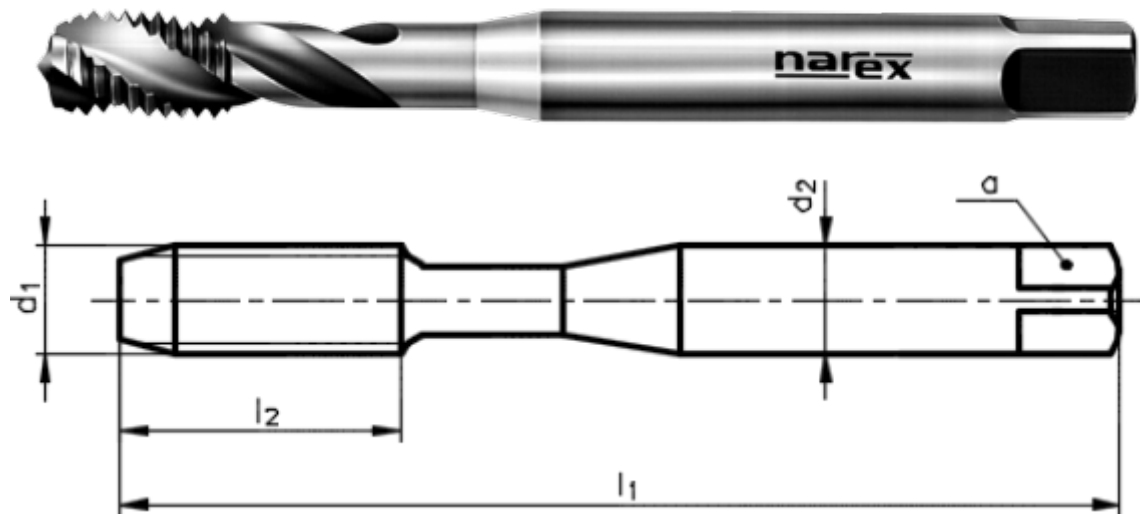


# Machine tap with right-hand spiral flutes 35°

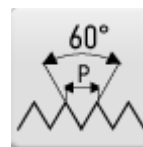


## CATALOGUE NUMBER: 2054

Machine tap with spiral flutes, unified national coarse thread, DIN 371, suitable for structural steels, cast steels, free cutting steels, spheroidal and malleable cast iron, aluminium alloys Si<10 % and long chipping copper alloys.



**THREAD UNC**  
Unified coarse thread



**PROFILE SKETCH**  
60°



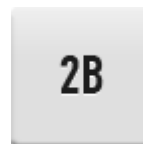
**TYPE N**  
Tap for steels up to 800 N/mm2



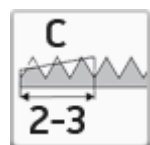
**TAP MATERIAL**  
Super high speed steel



**TAP STANDARD**  
~ DIN 371



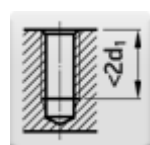
**THREAD TOLERANCE**  
2B



**CHAMFER C**  
Length 2-3 pitch



**SPIRAL FLUTE ANGLE**  
35°



**HOLE TYPE**  
Blind hole (thread length <math>< 2 d\_1</math>)

# Select product model

ID	D1	P	Tolerance	l1	l2	d2	a	Price excl. VAT	Price incl. VAT
041531830002000	UNC5	40	2B	56	5	3,5	2,7	11.05 EUR	13.37 EUR
041531830003000	UNC6	32	2B	56	7	4	3	10.45 EUR	12.64 EUR
041531830004000	UNC8	32	2B	63	7	4,5	3,4	10.50 EUR	12.71 EUR
041531830005000	UNC10	24	2B	70	8	6	4,9	11.20 EUR	13.55 EUR
041531830006000	UNC12	24	2B	80	10	6	4,9	13.00 EUR	15.73 EUR
041531830007000	UNC1/4	20	2B	80	10	7	5,2	12.55 EUR	15.19 EUR
041531830009000	UNC5/16	18	2B	90	13	8	6,2	13.10 EUR	15.85 EUR
041531830011000	UNC3/8	16	2B	90	15	9	7	15.05 EUR	18.21 EUR

## Use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Aluminium alloys si content < 10%	blind hole (thread length $L < 2xd1$ )	14-20	Emulsion	Recommended use
Aluminium alloys si content < 10%	blind hole (thread length $L < 1,5xd1$ )	14-20	Emulsion	Recommended use
Aluminium alloys si content < 10%	blind hole (thread length $< 1,5 d1$ , pilot drilling depth $\geq L+d1$ )	14-20	Emulsion	Recommended use
Copper alloys (long chipping)	blind hole (thread length $L < 2xd1$ )	6-10	Cutting Oil	Possible use
Copper alloys (long chipping)	blind hole (thread length $< 1,5 d1$ , pilot drilling depth $\geq L+d1$ )	6-10	Cutting Oil	Possible use
Copper alloys (long chipping)	blind hole (thread length $L < 1,5xd1$ )	6-10	Cutting Oil	Possible use
Plain cast steels up to 800 N/mm2	blind hole (thread length $L < 1,5xd1$ )	10-14	Cutting Oil/Emulsion	Recommended use
Plain cast steels up to 800 N/mm2	blind hole (thread length $L < 2xd1$ )	10-14	Cutting Oil/Emulsion	Recommended use

<b>MACHINED MATERIAL</b>	<b>HOLE TYPE</b>	<b>CUTTING SPEED</b>	<b>LUBRICATION</b>	<b>USE</b>
Plain cast steels up to 800 N/mm <sup>2</sup>	blind hole (thread length < 1,5 d <sub>1</sub> , pilot drilling depth ≥ L+d <sub>1</sub> )	10-14	Cutting Oil/Emulsion	Recommended use
Spheroidal graphite cast iron and malleable cast iron	blind hole (thread length < 1,5 d <sub>1</sub> , pilot drilling depth ≥ L+d <sub>1</sub> )	4-7	Emulsion	Possible use
Spheroidal graphite cast iron and malleable cast iron	blind hole (thread length L < 2,5d <sub>1</sub> )	4-7	Emulsion	Possible use
Spheroidal graphite cast iron and malleable cast iron	blind hole (thread length L < 1,5d <sub>1</sub> )	4-7	Emulsion	Possible use
Spheroidal graphite cast iron and malleable cast iron	blind hole (thread length L < 2xd <sub>1</sub> )	4-7	Emulsion	Possible use
Structural steels and heat-treated steels up to 800 N/mm <sup>2</sup>	blind hole (thread length L < 2xd <sub>1</sub> )	10-14	Cutting Oil/Emulsion	Recommended use
Structural steels and heat-treated steels up to 800 N/mm <sup>2</sup>	blind hole (thread length < 1,5 d <sub>1</sub> , pilot drilling depth ≥ L+d <sub>1</sub> )	10-14	Cutting Oil/Emulsion	Recommended use
Structural steels and heat-treated steels up to 800 N/mm <sup>2</sup>	blind hole (thread length L < 1,5d <sub>1</sub> )	10-14	Cutting Oil/Emulsion	Recommended use

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