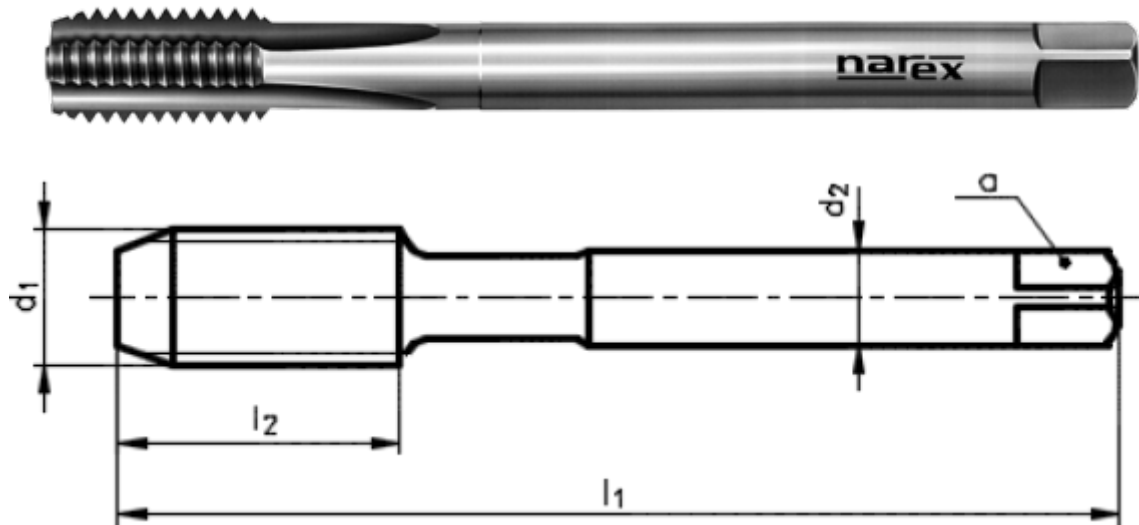


Machine tap with straight flutes

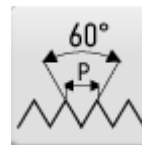


CATALOGUE NUMBER: 3004

Machine tap with straight flutes, unified national coarse thread, DIN 376, 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°



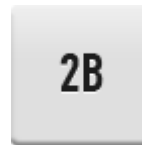
TYPE N
Tap for steels up to 800 N/mm²



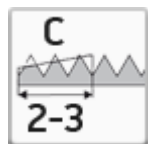
TAP MATERIAL
Super high speed steel



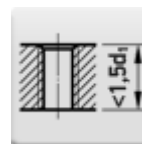
TAP STANDARD
~ DIN 376



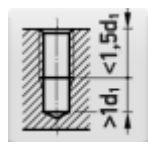
THREAD TOLERANCE
2B



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	I1	I2	d2	a	Price excl. VAT	Price incl. VAT
041531910012000	UNC7/16	14	2B	100	20	8	6,2	17.05 EUR	20.63 EUR
041531910013000	UNC1/2	13	2B	110	23	9	7	17.60 EUR	21.30 EUR
041531910014000	UNC9/16	12	2B	110	25	11	9	24.80 EUR	30.01 EUR
041531910015000	UNC5/8	11	2B	110	25	12	9	23.05 EUR	27.89 EUR
041531910017000	UNC3/4	10	2B	125	30	14	11	30.15 EUR	36.48 EUR
041531910019000	UNC7/8	9	2B	140	30	18	14,5	38.30 EUR	46.34 EUR
041531910021000	UNC1	8	2B	160	36	18	14,5	50.85 EUR	61.53 EUR
041531910022000	UNC1 1/8	7	2B	180	40	22	18	66.30 EUR	80.22 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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