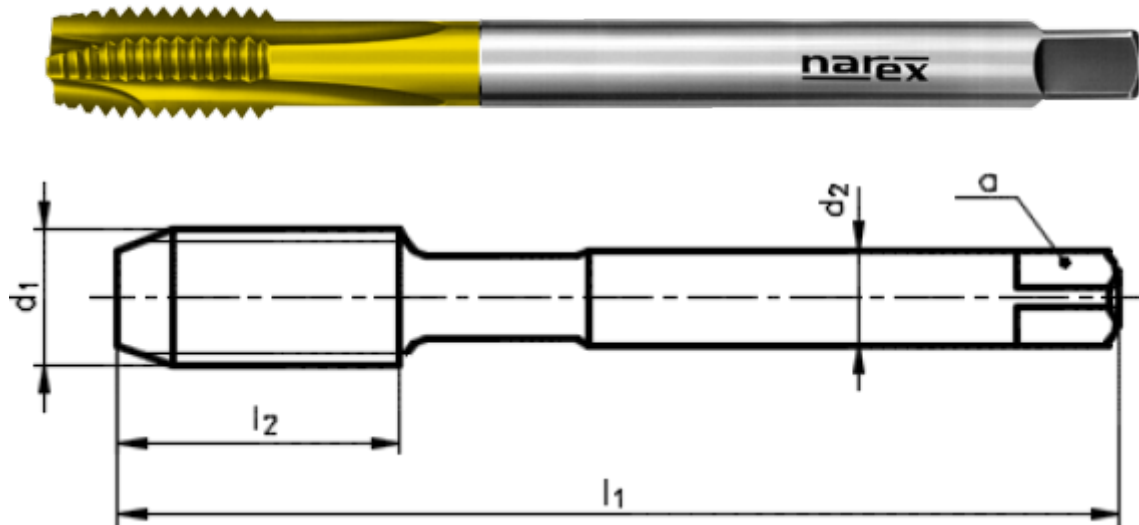


Machine tap with straight flutes and spiral point

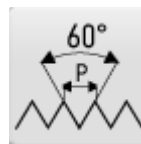


CATALOGUE NUMBER: 3514

Machine tap with straight flutes and spiral point, unified national coarse thread, DIN 376, TiN coated, suitable for structural steels, plain cast steels, free cutting steels, possible use in short chipping copper alloys, spheroidal and malleable cast iron, aluminium alloys Si<10%,



THREAD UNC
Unified coarse thread



PROFILE SKETCH
60°



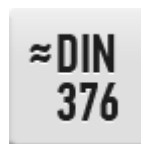
TYPE N
Tap for steels up to 800 N/mm²



TAP MATERIAL
Super high speed steel



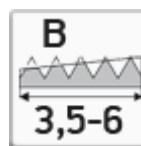
COATING
Titanium nitride coating



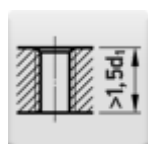
TAP STANDARD
~ DIN 376



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
041535920012000	UNC7/16	14	2B	100	20	8	6,2	22.75 EUR	27.53 EUR
041535920013000	UNC1/2	13	2B	110	23	9	7	24.55 EUR	29.71 EUR
041535920014000	UNC9/16	12	2B	110	25	11	9	36.80 EUR	44.53 EUR
041535920015000	UNC5/8	11	2B	110	25	12	9	31.20 EUR	37.75 EUR
041535920017000	UNC3/4	10	2B	125	30	14	11	42.15 EUR	51.00 EUR
041535920019000	UNC7/8	9	2B	140	30	18	14,5	51.40 EUR	62.19 EUR
041535920021000	UNC1	8	2B	160	36	18	14,5	67.05 EUR	81.13 EUR
041535920022000	UNC1 1/8	7	2B	180	40	22	18	80.50 EUR	97.41 EUR

Use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Aluminium alloys si content < 10%	through hole (thread length L > 1,5xd1)	15-30	Emulsion	Recommended use
Aluminium alloys si content < 10%	through hole (thread length L < 1,5xd1)	15-30	Emulsion	Recommended use
Aluminium alloys si content > 10%	through hole (thread length L > 1,5xd1)	14-20	Emulsion	Possible use
Aluminium alloys si content > 10%	through hole (thread length L < 1,5xd1)	14-20	Emulsion	Possible use
Copper alloys (short chipping)	through hole (thread length L < 1,5xd1)	15-25	Cutting Oil/Emulsion	Possible use
Copper alloys (short chipping)	through hole (thread length L > 1,5xd1)	15-25	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	Recommended 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	Recommended use
Plain cast steels up to 500 N/mm ²	through hole (thread length $L > 1,5d_1$)	8-12	Cutting Oil/Emulsion	Recommended use
Plain cast steels up to 500 N/mm ²	through hole (thread length $L < 1,5d_1$)	8-12	Cutting Oil/Emulsion	Recommended use
Plain cast steels up to 800 N/mm ²	through hole (thread length $L > 1,5d_1$)	12-15	Cutting Oil/Emulsion	Recommended use
Plain cast steels up to 800 N/mm ²	through hole (thread length $L < 1,5d_1$)	12-15	Cutting Oil/Emulsion	Recommended use
Spheroidal graphite cast iron and malleable cast iron	through hole (thread length $L < 1,5d_1$)	6-8	Emulsion	Recommended use
Spheroidal graphite cast iron and malleable cast iron	blind hole (thread length $< 1,5 d_1$, pilot drilling depth $\geq L+d_1$)	6-8	Emulsion	Recommended use
Spheroidal graphite cast iron and malleable cast iron	through hole (thread length $L > 1,5d_1$)	6-8	Emulsion	Recommended use
Structural steels and heat-treated steels up to 800 N/mm ²	through hole (thread length $L > 1,5d_1$)	12-15	Cutting Oil/Emulsion	Recommended use
Structural steels and heat-treated steels up to 800 N/mm ²	through hole (thread length $L < 1,5d_1$)	12-15	Cutting Oil/Emulsion	Recommended use
Structural steels up to 500 N/mm ²	through hole (thread length $L < 1,5d_1$)	6-10	Cutting Oil/Emulsion	Recommended use
Structural steels up to 500 N/mm ²	through hole (thread length $L > 1,5d_1$)	6-10	Cutting Oil/Emulsion	Recommended use

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