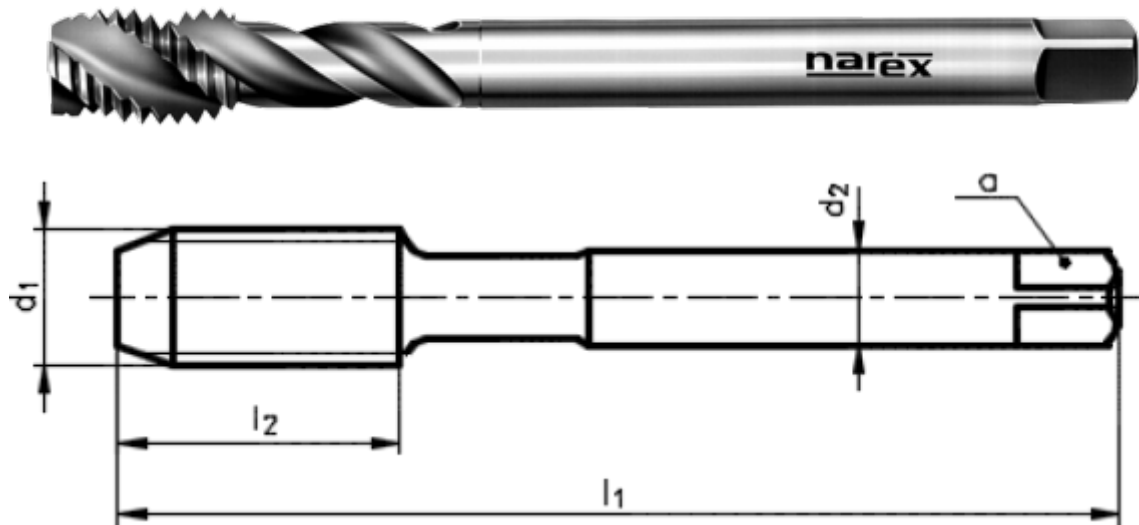


# Machine tap with right-hand spiral flutes 35°

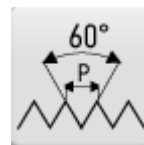


## CATALOGUE NUMBER: 4054

Machine tap with spiral flutes, unified national coarse thread, DIN 376, 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/mm<sup>2</sup>



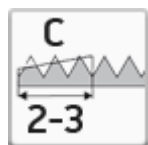
**TAP MATERIAL**  
Super high speed steel



**TAP STANDARD**  
~ DIN 376



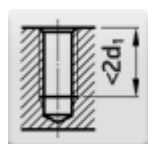
**THREAD TOLERANCE**  
2B



**CHAMFER C**  
Length 2-3 pitch



**SPIRAL FLUTE ANGLE**  
35°



**HOLE TYPE**  
Blind hole (thread length < 2 d<sub>1</sub>)

# Select product model

| ID              | D1      | P  | Tolerance | I1  | I2 | d2 | a    | Price excl. VAT | Price incl. VAT |
|-----------------|---------|----|-----------|-----|----|----|------|-----------------|-----------------|
| 041531930012000 | UNC7/16 | 14 | 2B        | 100 | 18 | 8  | 6,2  | 20.20 EUR       | 24.44 EUR       |
| 041531930013000 | UNC1/2  | 13 | 2B        | 110 | 20 | 9  | 7    | 20.40 EUR       | 24.68 EUR       |
| 041531930014000 | UNC9/16 | 12 | 2B        | 110 | 20 | 11 | 9    | 28.95 EUR       | 35.03 EUR       |
| 041531930015000 | UNC5/8  | 11 | 2B        | 110 | 20 | 12 | 9    | 27.40 EUR       | 33.15 EUR       |
| 041531930017000 | UNC3/4  | 10 | 2B        | 125 | 25 | 14 | 11   | 34.20 EUR       | 41.38 EUR       |
| 041531930019000 | UNC7/8  | 9  | 2B        | 140 | 25 | 18 | 14,5 | 41.70 EUR       | 50.46 EUR       |
| 041531930021000 | UNC1    | 8  | 2B        | 160 | 30 | 18 | 14,5 | 56.55 EUR       | 68.43 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 $< 1,5 d1$ , pilot drilling depth $\geq L+d1$ ) | 14-20         | Emulsion             | Recommended use |
| Aluminium alloys si content < 10% | blind hole (thread length $L < 1,5xd1$ )                                  | 14-20         | Emulsion             | Recommended use |
| Copper alloys (long chipping)     | blind hole (thread length $L < 1,5xd1$ )                                  | 6-10          | Cutting Oil          | Possible 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    |
| 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 < 2,5xd <sub>1</sub> )   | 4-7                  | Emulsion             | Possible use    |
| Spheroidal graphite cast iron and malleable cast iron                 | blind hole (thread length L < 1,5xd <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 < 1,5xd <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 < 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 |

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