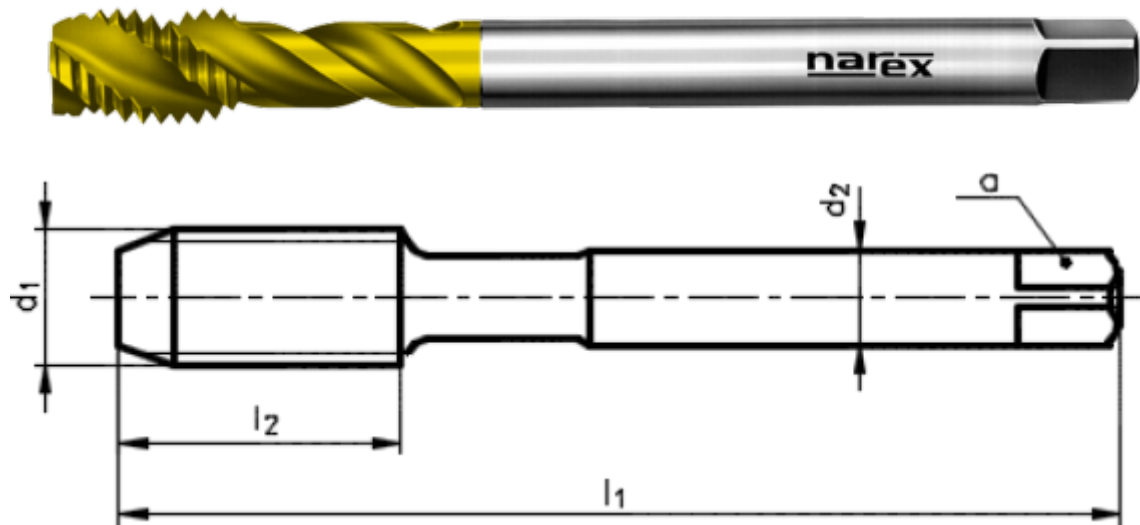


# Machine tap with right-hand spiral flutes 35°

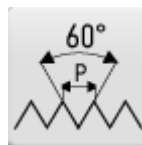


## CATALOGUE NUMBER: 4064

Machine tap with spiral flutes, unified national coarse thread, DIN 376, TiN coated, suitable for structural steels, cast steels, free cutting steels, spheroidal and malleable cast iron, aluminium alloys 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



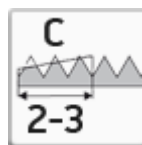
**COATING**  
Titanium nitride coating



**TAP STANDARD**  
~ DIN 376



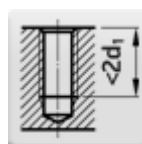
**THREAD TOLERANCE**  
2B



**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
041535930012000	UNC7/16	14	2B	100	18	8	6,2	26.15 EUR	31.64 EUR
041535930013000	UNC1/2	13	2B	110	20	9	7	26.30 EUR	31.82 EUR
041535930014000	UNC9/16	12	2B	110	20	11	9	37.45 EUR	45.31 EUR
041535930015000	UNC5/8	11	2B	110	20	12	9	35.30 EUR	42.71 EUR
041535930017000	UNC3/4	10	2B	125	25	14	11	44.15 EUR	53.42 EUR
041535930019000	UNC7/8	9	2B	140	25	18	14,5	54.05 EUR	65.40 EUR
041535930021000	UNC1	8	2B	160	30	18	14,5	73.25 EUR	88.63 EUR

## Use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Aluminium alloys si content < 10%	blind hole (thread length $L < 1,5d1$ )	15-30	Emulsion	Recommended use
Aluminium alloys si content < 10%	blind hole (thread length $L < 2xd1$ )	15-30	Emulsion	Recommended use
Aluminium alloys si content < 10%	blind hole (thread length $< 1,5 d1$ , pilot drilling depth $\geq L+d1$ )	15-30	Emulsion	Recommended use
Aluminium alloys si content > 10%	blind hole (thread length $< 1,5 d1$ , pilot drilling depth $\geq L+d1$ )	14-20	Emulsion	Possible use
Aluminium alloys si content > 10%	blind hole (thread length $L < 1,5xd1$ )	14-20	Emulsion	Possible use
Aluminium alloys si content > 10%	blind hole (thread length $L < 2xd1$ )	14-20	Emulsion	Possible use
Copper alloys (long chipping)	blind hole (thread length $< 1,5 d1$ , pilot drilling depth $\geq L+d1$ )	10-15	Cutting Oil	Possible use
Copper alloys (long chipping)	blind hole (thread length $L < 1,5xd1$ )	10-15	Cutting Oil	Possible use

<b>MACHINED MATERIAL</b>	<b>HOLE TYPE</b>	<b>CUTTING SPEED</b>	<b>LUBRICATION</b>	<b>USE</b>
Copper alloys (long chipping)	blind hole (thread length $L < 2xd1$ )	10-15	Cutting Oil	Possible use
Plain cast steels up to 800 N/mm <sup>2</sup>	blind hole (thread length $L < 2xd1$ )	12-15	Cutting Oil/Emulsion	Recommended use
Plain cast steels up to 800 N/mm <sup>2</sup>	blind hole (thread length $< 1,5 d1$ , pilot drilling depth $\geq L+d1$ )	12-15	Cutting Oil/Emulsion	Recommended use
Plain cast steels up to 800 N/mm <sup>2</sup>	blind hole (thread length $L < 1,5xd1$ )	12-15	Cutting Oil/Emulsion	Recommended use
Spheroidal graphite cast iron and malleable cast iron	blind hole (thread length $L < 2xd1$ )	6-8	Emulsion	Possible use
Spheroidal graphite cast iron and malleable cast iron	blind hole (thread length $< 1,5 d1$ , pilot drilling depth $\geq L+d1$ )	6-8	Emulsion	Possible use
Spheroidal graphite cast iron and malleable cast iron	blind hole (thread length $L < 2,5xd1$ )	6-8	Emulsion	Possible use
Spheroidal graphite cast iron and malleable cast iron	blind hole (thread length $L < 1,5xd1$ )	6-8	Emulsion	Possible use
Structural steels and heat-treated steels up to 800 N/mm <sup>2</sup>	blind hole (thread length $< 1,5 d1$ , pilot drilling depth $\geq L+d1$ )	12-15	Cutting Oil/Emulsion	Recommended use
Structural steels and heat-treated steels up to 800 N/mm <sup>2</sup>	blind hole (thread length $L < 1,5xd1$ )	12-15	Cutting Oil/Emulsion	Recommended use
Structural steels and heat-treated steels up to 800 N/mm <sup>2</sup>	blind hole (thread length $L < 2xd1$ )	12-15	Cutting Oil/Emulsion	Recommended use