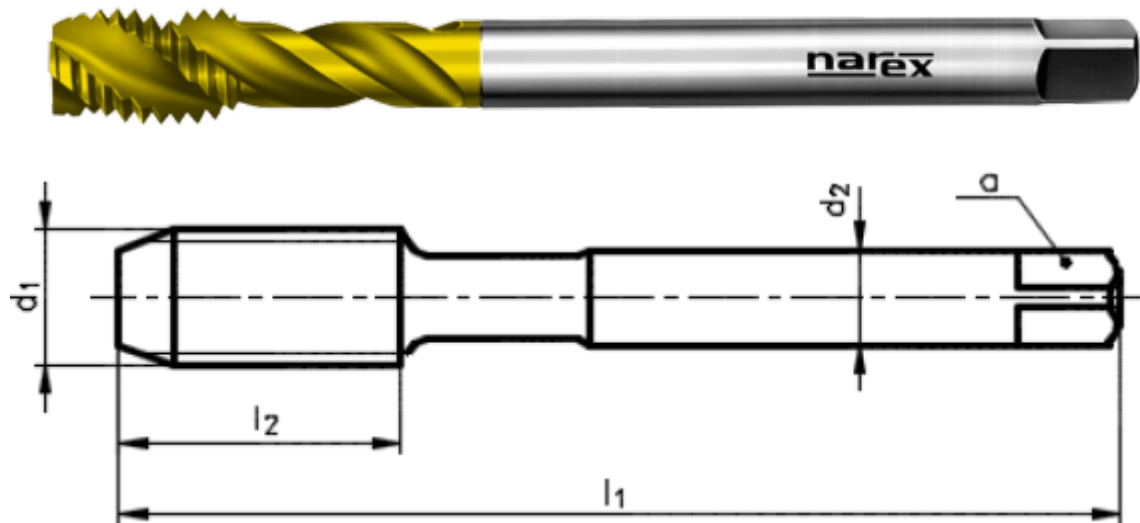


Machine tap with right-hand spiral flutes 35°

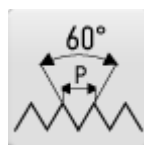


CATALOGUE NUMBER: 4065

Machine tap with spiral flutes, unified national fine thread, DIN 374, TiN coated, suitable for structural steels, cast steels, free cutting steels, spheroidal and malleable cast iron, aluminium alloys and long chipping copper alloys.



THREAD UNF
Unified fine thread



PROFILE SKETCH
60°



TYPE N
Tap for steels up to 800 N/mm²



TAP MATERIAL
Super high speed steel



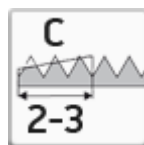
COATING
Titanium nitride coating



TAP STANDARD
~ DIN 374



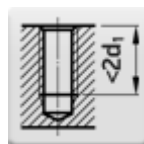
THREAD TOLERANCE
2B



CHAMFER C
Length 2-3 pitch



SPIRAL FLUTE ANGLE
35°



HOLE TYPE
Blind hole (thread length < 2 d₁)

Select product model

ID	D1	P	Tolerance	I1	I2	d2	a	Price excl. VAT	Price incl. VAT
041535930102000	UNF5	44	2B	56	5	2,2	-	15.50 EUR	18.76 EUR
041535930103000	UNF6	40	2B	56	7	2,5	2,1	15.80 EUR	19.12 EUR
041535930104000	UNF8	36	2B	63	7	2,8	2,1	15.80 EUR	19.12 EUR
041535930105000	UNF10	32	2B	70	8	3,5	2,7	16.70 EUR	20.21 EUR
041535930106000	UNF12	28	2B	80	10	4	3	19.15 EUR	23.17 EUR
041535930107000	UNF1/4	28	2B	80	10	4,5	3,4	18.35 EUR	22.20 EUR
041535930109000	UNF5/16	24	2B	90	13	6	4,9	19.20 EUR	23.23 EUR
041535930111000	UNF3/8	24	2B	90	15	7	5,5	20.60 EUR	24.93 EUR
041535930112000	UNF7/16	20	2B	100	15	8	6,2	26.75 EUR	32.37 EUR
041535930113000	UNF1/2	20	2B	100	14	9	7	26.85 EUR	32.49 EUR
041535930114000	UNF9/16	18	2B	100	16	11	9	42.40 EUR	51.30 EUR
041535930115000	UNF5/8	18	2B	100	16	12	9	35.85 EUR	43.38 EUR
041535930117000	UNF3/4	16	2B	110	20	14	11	47.00 EUR	56.87 EUR
041535930119000	UNF7/8	14	2B	125	20	18	14,5	57.10 EUR	69.09 EUR
041535930121000	UNF1	12	2B	140	22	18	14,5	79.00 EUR	95.59 EUR

Use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	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 $L < 1,5d1$)	15-30	Emulsion	Recommended use
Aluminium alloys si content < 10%	blind hole (thread length $L < 2xd1$)	15-30	Emulsion	Recommended use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	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 $L < 2xd1$)	10-15	Cutting Oil	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
Plain cast steels up to 800 N/mm2	blind hole (thread length $L < 2xd1$)	12-15	Cutting Oil/Emulsion	Recommended use
Plain cast steels up to 800 N/mm2	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/mm2	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/mm2	blind hole (thread length $L < 2xd1$)	12-15	Cutting Oil/Emulsion	Recommended use
Structural steels and heat-treated steels up to 800 N/mm2	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/mm2	blind hole (thread length $L < 1,5xd1$)	12-15	Cutting Oil/Emulsion	Recommended use