

UNF

Unified Fine Threads

 Unified Feingewinde
 UNF
 Unificato passo fine

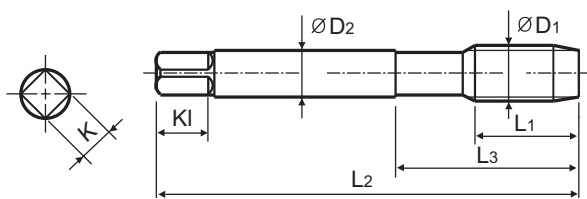
Machine taps
Maschinengewindebohrer

- ▶ High performance on various ductile materials
- ▶ Specially designed to prevent oversized threads and reduce gauging problems

- ▶ Ausgezeichnete Leistung bei verschiedenen Werkstoffen.
- ▶ Speziell entwickelt, um zu große Gewindedurchmesser zu vermeiden und Messprobleme zu reduzieren.

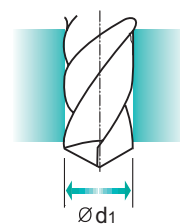
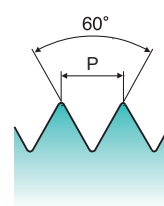
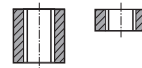
DIN 371 

DIN 374 



Hole type

3.0×D



Material groups
MU

HSS PM

DIN 371/374

2BX

60°

B

X Coating



p.B88



Plain Shank
SYNCHRO TAPPING CHUCK
TAPPING CHUCK
ONE STEP TAPPING CHUCK

Unit : mm

SIZE	TPI	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
Ø D1		X-Coating	L1	L2	L3	Ø D2	K	KI	Z	Ø d1
#4 - 48 UNF		TRJ18182GS	11.0	56.0	18.0	3.5	2.7	6.0	2	2.40
#5 - 44 UNF		TRJ18222GS	11.0	56.0	18.0	3.5	2.7	6.0	3	2.70
#6 - 40 UNF		TRJ18262GS	12.0	56.0	20.0	4.0	3.0	6.0	3	2.90
#8 - 36 UNF		TRJ18302GS	13.0	63.0	21.0	4.5	3.4	6.0	3	3.50
#10 - 32 UNF		TRJ18342GS	15.0	70.0	25.0	6.0	4.9	8.0	3	4.10
#12 - 28 UNF		TRJ18382GS	16.0	80.0	30.0	6.0	4.9	8.0	3	4.60
1/4 - 28 UNF		TRJ18422GS	17.0	80.0	30.0	7.0	5.5	8.0	3	5.50
5/16 - 24 UNF		TRJ18462GS	17.0	90.0	35.0	8.0	6.2	9.0	3	6.90
3/8 - 24 UNF		TRJ18502GS	18.0	100.0	39.0	9.0	7.0	10.0	3	8.50
7/16 - 20 UNF		TRJ18542GS	22.0	100.0	40.0	8.0	6.2	9.0	3	9.90
1/2 - 20 UNF		TRJ18582GS	22.0	100.0	40.0	9.0	7.0	10.0	3	11.50
9/16 - 18 UNF		TRJ18622GS	22.0	100.0	40.0	11.0	9.0	12.0	3	12.90
5/8 - 18 UNF		TRJ18662GS	22.0	100.0	40.0	12.0	9.0	12.0	3	14.50
3/4 - 16 UNF		TRJ18722GS	25.0	110.0	44.0	14.0	11.0	14.0	3	17.50
7/8 - 14 UNF		TRJ18762GS	26.0	125.0	50.0	18.0	14.5	17.0	3	20.50
1" - 12 UNF		TRJ18802GS	28.0	140.0	54.0	20.0	16.0	19.0	3	23.20

▶ DIN371 (#4~3/8) and DIN374 (7/16~1)

◎ : Excellent ○ : Good

ISO	P										M				K							
Material Description	Non-alloy steel					Low alloy steel					High alloyed steel and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron		
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20		
HRC		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21		
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230		
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	◎	◎	◎	◎	◎	◎	◎				
ISO	N										S						H					
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys				Titanium Alloys		Hardened steel		Chilled Cast Iron		Hardened Cast Iron	
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	
HRC											15	30	25	38	34			55	60	42	55	
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550	
Recommended	○	○	◎	◎	◎	◎	◎	◎														

CARBIDE

HSS

THREAD
MILL

SYNCHRO
TAP

PRIME
TAP

COMBO
TAP

YG TAP
STEEL

YG TAP CHIP
BREAKER

YG TAP
INOX

YG TAP
CAST IRON

YG TAP
HARDENED
STEEL

YG TAP
Ti Ni

YG TAP
ALU

YG TAP
FORMING

YG TAP
GENERAL

PIPE TAP

STI TAP

NUT TAP

TECHNICAL
DATA



RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDKONDITIONEN

					TRE30, TRE31, TRE32 TRE33, TRE34	TRJ15, TRJ16 TRJ17, TRJ18
ISO	VDI 3323	Material Description	HB	HRc	Vc (m/min.)	
P	1	Non-alloy steel	125		5-20	15-45
	2		190	13	10-50	10-55
	3		250	25	10-50	10-55
	4		270	28	15-40	15-50
	5		300	32	15-40	15-50
	6	Low alloy steel	180	10	8-30	8-30
	7		275	29	8-30	8-30
	8		300	32	8-30	8-30
	9		350	38	8-30	8-30
	10	High alloyed steel, and tool steel	200	15	8-30	8-30
	11		325	35	8-30	8-30
M	12	Stainless steel	200	15	5-15	8-20
	13		240	23	5-15	8-20
	14		180	10	5-15	8-20
K	15	Grey cast iron	180	10	15-35	15-35
	16		260	26	15-35	15-35
	17	Nodular cast iron	160	3	15-35	15-35
	18		250	25	15-35	15-35
N	21	Aluminum- wrought alloy	60		15-35	15-35
	22		100		15-35	15-35
	23	Aluminum- cast, alloyed	75		15-35	15-35
	24		90		15-35	15-35
	25		130		15-35	15-35
	26	Copper and Copper Alloys (Bronze / Brass)	110		15-35	15-35
	27		90		15-35	15-35
	28		100		15-35	15-35

