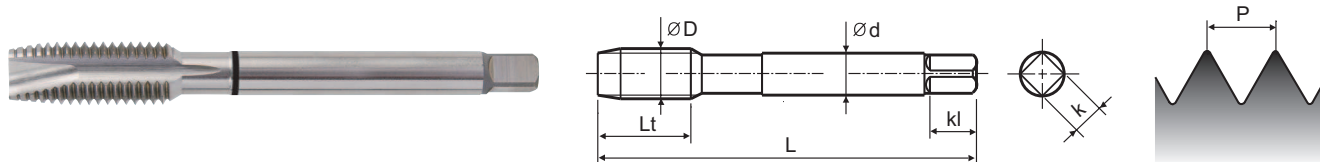


Unified coarse threads

GUN POINT TAPS for Multi Purpose



GUN POINT TAPS ◆ **TC834**



DIN371/376

Unit : mm

SIZE	TPI	Limit	EDP No.	Overall Length	Thread Length	Shank Diameter	Square Size
D				L	Lt	d	k
#4	- 40 UNC	2B	TC834162	56.0	11.0	3.5	2.7
#5	- 40 UNC	2B	TC834202	56.0	11.0	3.5	2.7
#6	- 32 UNC	2B	TC834242	56.0	12.0	4.0	3.0
#8	- 32 UNC	2B	TC834282	63.0	13.0	4.5	3.4
#10	- 24 UNC	2B	TC834322	70.0	15.0	6.0	4.9
#12	- 24 UNC	2B	TC834362	80.0	16.0	6.0	4.9
1/4	- 20 UNC	2B	TC834402	80.0	17.0	7.0	5.5
5/16	- 18 UNC	2B	TC834442	90.0	20.0	8.0	6.2
3/8	- 16 UNC	2B	TC834482	100.0	22.0	9.0	7.0
7/16	- 14 UNC	2B	TC834522	100.0	22.0	8.0	6.2
1/2	- 13 UNC	2B	TC834562	110.0	25.0	9.0	7.0
9/16	- 12 UNC	2B	TC834602	110.0	26.0	11.0	9.0
5/8	- 11 UNC	2B	TC834642	110.0	27.0	12.0	9.0
3/4	- 10 UNC	2B	TC834702	125.0	30.0	14.0	11.0
7/8	- 9 UNC	2B	TC834742	140.0	32.0	18.0	14.5
1"	- 8 UNC	2B	TC834782	160.0	36.0	20.0	16.0

▶ DIN371 (#4~3/8) and DIN376 (7/16~1")

DIN371/374

Unit : mm

SIZE	TPI	Limit	EDP No.	Overall Length	Thread Length	Shank Diameter	Square Size
D				L	Lt	d	k
#4	- 48 UNF	2B	TC834182	56.0	11.0	3.5	2.7
#5	- 44 UNF	2B	TC834222	56.0	11.0	3.5	2.7
#6	- 40 UNF	2B	TC834262	56.0	12.0	4.0	3.0
#8	- 36 UNF	2B	TC834302	63.0	13.0	4.5	3.4
#10	- 32 UNF	2B	TC834342	70.0	15.0	6.0	4.9
#12	- 28 UNF	2B	TC834382	80.0	16.0	6.0	4.9
1/4	- 28 UNF	2B	TC834422	80.0	17.0	7.0	5.5
5/16	- 24 UNF	2B	TC834462	90.0	17.0	8.0	6.2
3/8	- 24 UNF	2B	TC834502	100.0	18.0	9.0	7.0
7/16	- 20 UNF	2B	TC834542	100.0	22.0	8.0	6.2
1/2	- 20 UNF	2B	TC834582	100.0	22.0	9.0	7.0
9/16	- 18 UNF	2B	TC834622	100.0	22.0	11.0	9.0
5/8	- 18 UNF	2B	TC834662	100.0	22.0	12.0	9.0
3/4	- 16 UNF	2B	TC834722	110.0	25.0	14.0	11.0
7/8	- 14 UNF	2B	TC834762	125.0	26.0	18.0	14.5
1"	- 12 UNF	2B	TC834802	140.0	28.0	20.0	16.0

▶ DIN371 (#4~3/8) and DIN374 (7/16~1")

RECOMMENDED TAPPING SPEEDS

Work Materials		Spiral Flute	Tapping Speed	Gun point	Tapping Speed
		TC814,TC834	(m/min)	TC804,TC824	(m/min)
Steels	Structure steels	●	15 ~ 20	●	15 ~ 20
	Plain carbon steels	●	12 ~ 18	●	12 ~ 18
	Alloy steels up to 850N/mm ²	●	10 ~ 15	●	10 ~ 15
	Hardened & Tempered steels up to 1,200N/mm ²	○	6 ~ 10	○	6 ~ 10
Stainless steels	Free machining	●	7 ~ 10	●	7 ~ 10
	Austenitic	●	5 ~ 8	●	5 ~ 8
Cast iron	Grey Cast irons up to 500N/mm ²	○	10 ~ 15	○	10 ~ 15
	Malleable Cast irons up to 700N/mm ²	○	10 ~ 15	○	10 ~ 15
	Nodular graphite up to 700N/mm ²	○	10 ~ 15	○	10 ~ 15
Aluminum	Alloyed Aluminum, Si<10%	○	15 ~ 20	○	15 ~ 20
	Alloyed Aluminum, Si>10%	●	10 ~ 15	●	10 ~ 15
Titanium	Unalloyed Titanium	●	10 ~ 15	●	10 ~ 15
	Alloyed Titanium up to 900N/mm ²	○	8 ~ 12	○	8 ~ 12
Nickel	Unalloyed Nickel	●	8 ~ 12	●	8 ~ 12
	Alloyed Nickel up to 900N/mm ²	○	10 ~ 15	○	10 ~ 15
Copper	Unalloyed Copper	●	8 ~ 12	●	8 ~ 12
	Long chipping Copper	●	15 ~ 20	●	15 ~ 20
Brass	Long chipping Brass	●	15 ~ 20	●	15 ~ 20
Bronze	Long chipping Bronze	●	15 ~ 20	●	15 ~ 20

● : RECOMMENDED
○ : SUITABLE

**International
patent**

FEATURES OF COMBO TAP

1. Thread configuration with a special design. (International patent)
 - * Prevents over-feeding, thin thread and pitch diameter oversize.
2. Flute geometry with special design.
 - * Better chip evacuation.
 - * Prevents chip clogging.
 - * Improves thread quality.
3. Applicable for wide applications.
 - * Blind and through holes.
4. Excellent performance on various materials.
 - * Carbon Steels, Alloyed Steels, Tool Steel etc.