SPIRAL FLUTE TAPS

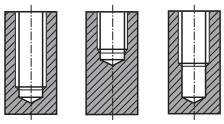
TC124 SERIES

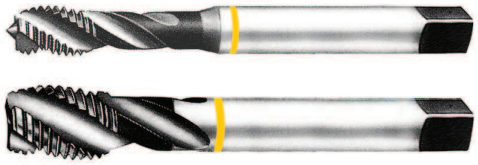
UNF Unified fine threads
Unified Feingewinde

▶ Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

▶ Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

Hole type



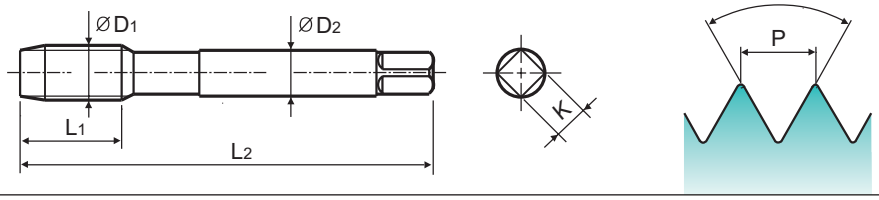


DIN 371

DIN 374

Material groups **GS** | HSS-E | DIN 371/374 | 2B | 60° | C | Bright | R40

Machine taps
Maschinengewindebohrer



Unit : mm

SIZE	TPI	EDP No.	Thread Length	Overall Length	Shank Diameter	Square Size	Tapping drill diameter
ØD1			L1	L2	ØD2	K	Ød1
#4	– 48 UNF	TC124182	6	56	3.5	2.7	2.4
#5	– 44 UNF	TC124222	7	56	3.5	2.7	2.7
#6	– 40 UNF	TC124262	7	56	4	3	3
#8	– 36 UNF	TC124302	8	63	4.5	3.4	3.5
#10	– 32 UNF	TC124342	10	70	6	4.9	4.1
#12	– 28 UNF	TC124382	10	80	6	4.9	4.7
1/4"	– 28 UNF	TC124422	10	80	7	5.5	5.5
5/16"	– 24 UNF	TC124462	10	90	8	6.2	6.9
3/8"	– 24 UNF	TC124502	10	100	9	7	8.5
7/16"	– 20 UNF	TC124542	13	100	8	6.2	9.9
1/2"	– 20 UNF	TC124582	13	100	9	7	11.5
9/16"	– 18 UNF	TC124622	15	100	11	9	12.9
5/8"	– 18 UNF	TC124662	15	100	12	9	14.5
3/4"	– 16 UNF	TC124722	17	110	14	11	17.5
7/8"	– 14 UNF	TC124762	17	125	18	14.5	20.5
1"	– 12 UNF	TC124802	20	140	20	16	23.25
1∗1/8"	– 12 UNF	TC124842	22	150	22	18	26.5

▶ DIN 371(#4~3/8") and DIN 374(7/16"~1∗1/8")

Unit : N/mm²

◎ : Excellent ○ : Good

Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
	◎	◎	◎								◎	◎	○	

Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Al Si≤10%	Al Si>10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
	○			○		◎		○	○	○	◎	○		