

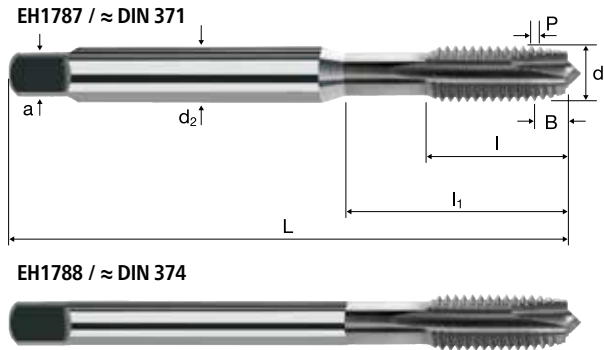
Taps



UNF **2B**

HSS PM/F

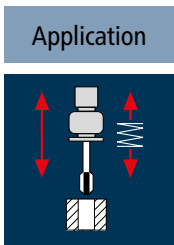
Form B



Rm < 850	Rm 850-1100	Rm 1100-1300								
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Example: Order-N°.		Article-N°.		a-Code							TiCN
Order-N°.		EH1787		756							EH1787
Ø Code	d	P(TPI)	d (mm)	L	l	l ₁	d ₂	a			
756	Nr.6	-40.0	3.505	56	12.00	20.0	4.0	3.0	3	2.95	●
757	Nr.8	-36.0	4.166	63	13.00	21.0	4.5	3.4	3	3.50	●
758	Nr.10	-32.0	4.826	70	15.00	25.0	6.0	4.9	3	4.10	●
759	Nr.12	-28.0	5.486	80	17.00	30.0	6.0	4.9	3	4.60	●
760	1/4	-28.0	6.350	80	17.00	30.0	7.0	5.5	3	5.50	●
761	5/16	-24.0	7.938	90	20.00	35.0	8.0	6.2	3	6.90	●
762	3/8	-24.0	9.525	100	22.00	39.0	10.0	8.0	3	8.50	●

Example: Order-N°.		Article-N°.		a-Code							TiCN
Order-N°.		EH1788		763							EH1788
Ø Code	d	P(TPI)	d (mm)	L	l	l ₁	d ₂	a			
763	7/16	-20.0	11.113	100	22.00	39.0	8.0	6.2	3	9.90	●
764	1/2	-20.0	12.700	100	22.00	39.0	9.0	7.0	3	11.50	●
765	9/16	-18.0	14.288	100	22.00	39.0	11.0	9.0	3	12.90	●
766	5/8	-18.0	15.875	100	22.00	39.0	12.0	9.0	3	14.50	●
767	3/4	-16.0	19.050	110	25.00	45.0	14.0	11.0	4	17.50	●
768	7/8	-14.0	22.225	125	26.00	50.0	18.0	14.5	4	20.40	●



Application

Material

Steel
500 - 850 N/mm²



Steel
500 - 850 N/mm²



Steel
850 - 1100 N/mm²



Steel
850 - 1100 N/mm²



Steel
1100 - 1300 N/mm²



Steel
1100 - 1300 N/mm²



UNF	P(TPI)	d [mm]	P [mm]	V _c 1.5 x d			V _c 2.0 x d			V _c 3.0 x d		
				n [min ⁻¹]	v _f [100%]		n [min ⁻¹]	v _f [100%]		n [min ⁻¹]	v _f [100%]	
Nr.6	-40.0	3.505	0.635	25	2270	1442	20	1815	1153	15	1360	864
Nr.8	-36.0	4.166	0.706	25	1910	1348	20	1530	1079	15	1145	808
Nr.10	-32.0	4.826	0.794	25	1650	1310	20	1320	1048	15	990	786
Nr.12	-28.0	5.486	0.907	25	1450	1315	20	1160	1052	15	870	789
1/4	-28.0	6.350	0.907	25	1255	1138	20	1005	912	15	750	680
5/16	-24.0	7.938	1.058	25	1000	1058	20	800	847	15	600	635
3/8	-24.0	9.525	1.058	25	835	884	20	670	709	15	500	529
7/16	-20.0	11.113	1.270	25	715	908	20	575	730	15	430	546
1/2	-20.0	12.700	1.270	25	625	794	20	500	635	15	375	476
9/16	-18.0	14.288	1.411	25	555	783	20	445	628	15	335	473
5/8	-18.0	15.875	1.411	25	500	706	20	400	564	15	300	423
3/4	-16.0	19.050	1.588	25	420	667	20	335	532	15	250	397
7/8	-14.0	22.225	1.814	25	360	653	20	285	517	15	215	390
Nr.6	-40.0	3.505	0.635	20	1815	1153	15	1360	864	12	1090	692
Nr.8	-36.0	4.166	0.706	20	1530	1079	15	1145	808	12	915	646
Nr.10	-32.0	4.826	0.794	20	1320	1048	15	990	786	12	790	627
Nr.12	-28.0	5.486	0.907	20	1160	1052	15	870	789	12	695	630
1/4	-28.0	6.350	0.907	20	1005	912	15	750	680	12	600	544
5/16	-24.0	7.938	1.058	20	800	847	15	600	635	12	480	508
3/8	-24.0	9.525	1.058	20	670	709	15	500	529	12	400	423
7/16	-20.0	11.113	1.270	20	575	730	15	430	546	12	345	438
1/2	-20.0	12.700	1.270	20	500	635	15	375	476	12	300	381
9/16	-18.0	14.288	1.411	20	445	628	15	335	473	12	265	374
5/8	-18.0	15.875	1.411	20	400	564	15	300	423	12	240	339
3/4	-16.0	19.050	1.588	20	335	532	15	250	397	12	200	318
7/8	-14.0	22.225	1.814	20	285	517	15	215	390	12	170	308
Nr.6	-40.0	3.505	0.635	7	635	403	4	365	232	-	-	-
Nr.8	-36.0	4.166	0.706	7	535	377	4	305	215	-	-	-
Nr.10	-32.0	4.826	0.794	7	460	365	4	265	210	-	-	-
Nr.12	-28.0	5.486	0.907	7	405	367	4	230	209	-	-	-
1/4	-28.0	6.350	0.907	7	350	318	4	200	181	-	-	-
5/16	-24.0	7.938	1.058	7	280	296	4	160	169	-	-	-
3/8	-24.0	9.525	1.058	7	235	249	4	135	143	-	-	-
7/16	-20.0	11.113	1.270	7	200	254	4	115	146	-	-	-
1/2	-20.0	12.700	1.270	7	175	222	4	100	127	-	-	-
9/16	-18.0	14.288	1.411	7	155	219	4	90	127	-	-	-
5/8	-18.0	15.875	1.411	7	140	198	4	80	113	-	-	-
3/4	-16.0	19.050	1.588	7	115	183	4	65	103	-	-	-
7/8	-14.0	22.225	1.814	7	100	181	4	55	100	-	-	-