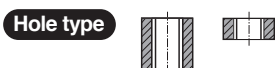


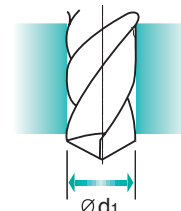
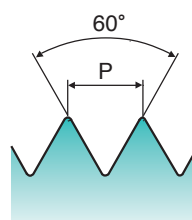
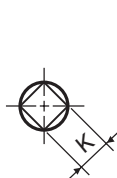
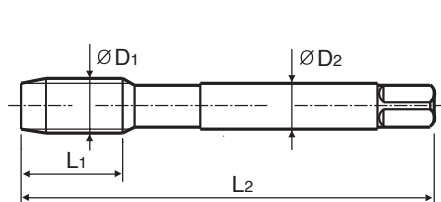
UNF Unified fine threads Unified Feingewinde

► For using multi-purpose and correct thread profiles & long tool life due to special tap geometry. YG-1 company has a patent.

► Für vielfältigen Einsatz, genaue Gewindeprofile und lange Standzeit dank einer besonderen Schneidengeometrie. Von YG-1 patentiert.



Machine taps
Maschinengewindebohrer



Unit : mm

SIZE	TPI	EDP No.		Thread Length	Overall Length	Shank Diameter	Square Size	Tapping Drill Diameter
ØD1		Bright	TiN	L1	L2	ØD2	K	Ød1
#4	- 48UNF	TC874182	TD874182	11	56	3.5	2.7	2.4
#5	- 44UNF	TC874222	TD874222	11	56	3.5	2.7	2.7
#6	- 40UNF	TC874262	TD874262	12	56	4	3	3
#8	- 36UNF	TC874302	TD874302	13	63	4.5	3.4	3.5
#10	- 32UNF	TC874342	TD874342	15	70	6	4.9	4.1
#12	- 28UNF	TC874382	TD874382	16	80	6	4.9	4.7
1/4"	- 28UNF	TC874422	TD874422	17	80	7	5.5	5.5
5/16"	- 24UNF	TC874462	TD874462	17	90	8	6.2	6.9
3/8"	- 24UNF	TC874502	TD874502	18	100	9	7	8.5
7/16"	- 20UNF	TC874542	TD874542	22	100	8	6.2	9.9
1/2"	- 20UNF	TC874582	TD874582	22	100	9	7	11.5
9/16"	- 18UNF	TC874622	TD874622	22	100	11	9	12.9
5/8"	- 18UNF	TC874662	TD874662	22	100	12	9	14.5
3/4"	- 16UNF	TC874722	TD874722	25	110	14	11	17.5
7/8"	- 14UNF	TC874762	TD874762	26	125	18	14.5	20.5
1"	- 12UNF	TC874802	TD874802	28	140	20	16	23.25

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

* The other coating(TiCN or TiAlN) or Surface Treatment(Steam Homo) is available on your request.

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
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

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CUTTING SPEED TABLE

CUTTING SPEED TABLE SCHNITTGESCHWINDIGKEITSTABELLE

Cutting Speeds m/min. into revolutions per minute

TOOL R.P.M.(rev/min)																
Tool Dia.	Cutting Speed (m/min)															
	1	2	3	4	5	6	8	10	12	15	20	25	30	40	50	60
1	318	637	955	1274	1592	1910	2548	3185	3822	4777	6396	7962	9554	12739	15924	19108
2	159	318	478	637	796	955	1274	1592	1911	2388	3185	3981	4777	6369	7962	9554
3	106	212	318	425	531	637	849	1062	1274	1592	2123	2654	3185	4246	5308	6369
4	80	159	239	318	398	478	637	796	955	1194	1592	1990	2389	3185	3981	4777
5	64	127	191	255	318	382	510	637	764	955	1274	1592	1911	2548	3185	3822
6	53	106	159	212	265	318	425	531	637	796	1062	1327	1592	2123	2653	3185
8	40	80	119	159	199	239	318	398	478	597	796	955	1194	1592	1990	2388
10	31	64	96	127	159	191	255	318	382	478	637	796	955	1274	1592	1911
12	26	53	80	106	133	159	212	265	318	398	531	663	796	1062	1327	1592
14	23	45	68	91	114	136	182	227	273	341	455	569	682	910	1137	1365
16	20	40	60	80	100	119	159	199	239	299	398	498	597	796	995	1194
18	18	35	53	71	88	106	142	177	212	265	354	442	531	708	885	1062
20	16	32	48	64	80	96	127	159	191	239	318	398	478	637	796	955
25	13	25	38	51	64	76	102	127	153	191	255	318	382	510	637	764
30	11	21	32	42	53	64	85	106	127	159	212	265	318	425	531	637
35	9	18	27	36	45	55	73	91	109	136	182	227	273	364	455	546
40	8	16	24	32	40	48	64	80	96	119	159	199	239	318	398	478

RPM = rev/min

V = m/min

D = Dia.(mm)

$$V = \frac{RPM \cdot \pi \cdot D}{1000}$$

$$RPM = \frac{1000 \cdot V}{\pi \cdot D}$$