

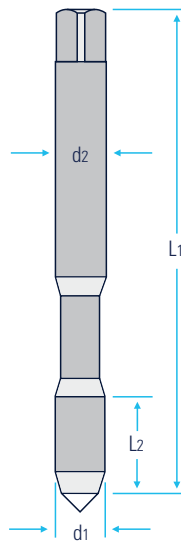
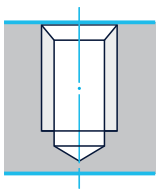


UNC - Unified Coarse Thread ANSI B1.1

Machine Taps

DIN 371 HSS-E
straight flutes
for general construction steel

Group 340
for blind holes



Art.-No.		340		
Technology	Page 7.1			
Chamfer Length	Page 7.4	C / 2-3 x P		
Surface	Page 7.5	bright		
Tolerance	Page 7.6	2 B		
Material Groups	Page 7.7	1a. general construction steel		

Ød ₁	P _{tpi}	L ₁	L ₂	d ₂	□				
Nr. 4	40	56	10	3,5	2,7	2,3	●		
Nr. 5	40	56	10	3,5	2,7	2,6	●		
Nr. 6	32	56	10	4	3	2,8	●		
Nr. 8	32	63	12	4,5	3,4	3,5	●		
Nr. 10	24	70	14	6	4,9	3,9	●		
Nr. 12	24	80	16	6	4,9	4,5	●		
1/4"	20	80	16	7	5,5	5,2	●		
5/16"	18	90	18	8	6,2	6,6	●		
3/8"	16	100	20	10	8	8,0	●		

UNC / UNF

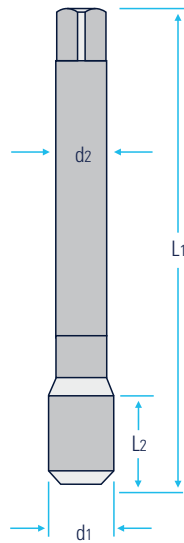
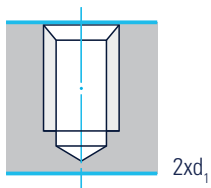


UNC - Unified Coarse Thread ANSI B1.1

Machine Taps

DIN 376 HSS-E
straight flutes
for general construction steel

Group 440
for blind holes



Art.-No.		440			
Technology	Page 7.1				
Chamfer Length	Page 7.4	C / 2-3 x P			
Surface	Page 7.5		bright		
Tolerance	Page 7.6		2 B		
Material Groups	Page 7.7	1a. general construction steel			

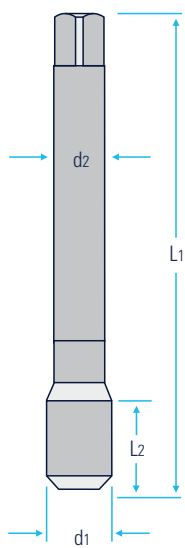
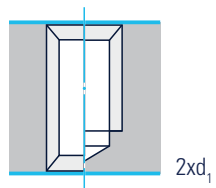
$\varnothing d_1$	P tpi	L ₁	L ₂	d ₂	\square					
7/16"	14	100	20	8	6,2	9,4	●			
1/2"	13	110	22	9	7	10,8	●			
9/16"	12	110	24	11	9	12,2	●			
5/8"	11	110	26	12	9	13,6	●			
3/4"	10	140	32	16	12	16,5	●			
7/8"	9	160	36	18	14,5	19,5	●			
1"	8	160	36	18	14,5	22,3	●			






UNC - Unified Coarse Thread ANSI B1.1


Machine Taps
White Ring

DIN 376 HSS-E
 straight flutes
 for cast iron

Group 443
 for blind and through holes



Art.-No.		443		
Technology	 Page 7.1	White Ring		
Chamfer Length	 Page 7.4	C / 2-3 x P		
Surface	 Page 7.5	nitrided		
Tolerance	 Page 7.6	2 B		
Material Groups	 Page 7.7	3a. grey cast iron 8b. duroplastics		

Ød ₁	P _{tpi}	L ₁	L ₂	d ₂	□				
7/16"	14	100	20	8	6,2	9,4			
1/2"	13	110	22	9	7	10,8	●		
9/16"	12	110	24	11	9	12,2			
5/8"	11	110	26	12	9	13,6	●		
3/4"	10	140	32	16	12	16,5	●		
7/8"	9	160	36	18	14,5	19,5	●		
1"	8	160	36	18	14,5	22,3	●		

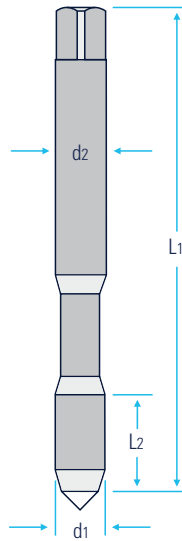
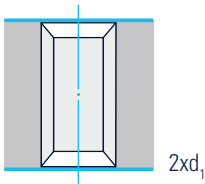


UNC - Unified Coarse Thread ANSI B1.1

Machine Taps

DIN 371 HSS-E
spiral point
for general construction steel

Group 345
for through holes



Art.-No.		345	345/25		
Technology	Page 7.1	High Volume [®] <small>by Schumacher</small>	High Volume [®] <small>by Schumacher</small>		
Chamfer Length	Page 7.4	B / 3,5-5 x P			
Surface	Page 7.5	bright	TiN		
Tolerance	Page 7.6	2 B	2 B		
Material Groups	Page 7.7	1a. general construction steel		3b. spheroidal and malleable cast iron	

Ød ₁	P tpi	L ₁	L ₂	d ₂	□	⌀				
Nr. 4	40	56	10	3,5	2,7	2,3	●			
Nr. 5	40	56	10	3,5	2,7	2,6	●	●		
Nr. 6	32	56	10	4	3	2,8	●	●		
Nr. 8	32	63	12	4,5	3,4	3,5	●	●		
Nr. 10	24	70	14	6	4,9	3,9	●	●		
Nr. 12	24	80	16	6	4,9	4,5	●			
1/4"	20	80	16	7	5,5	5,2	●	●		
5/16"	18	90	18	8	6,2	6,6	●	●		
3/8"	16	100	20	10	8	8,0	●	●		

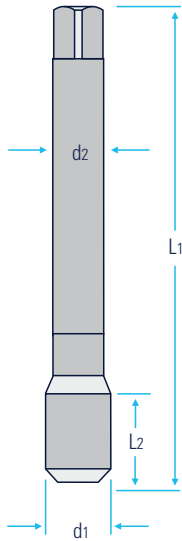
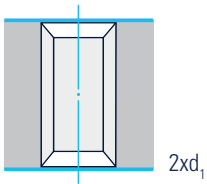


UNC - Unified Coarse Thread ANSI B1.1

Machine Taps

DIN 376 HSS-E
spiral point
for general construction steel

Group 445
for through holes



Art.-No.		445	445/25	
Technology	Page 7.1	High Volume <small>by Schumacher</small>	High Volume <small>by Schumacher</small>	
Chamfer Length	Page 7.4	B / 3,5-5 x P		
Surface	Page 7.5	bright	TiN	
Tolerance	Page 7.6	2 B	2 B	
Material Groups	Page 7.7	1a. general construction steel 3b. spheroidal and malleable cast iron		

$\varnothing d_1$	P tpi	L ₁	L ₂	d ₂	\square	$\frac{1}{2}$			
7/16"	14	100	20	8	6,2	9,4		●	
1/2"	13	110	22	9	7	10,8		●	●
9/16"	12	110	24	11	9	12,2		●	
5/8"	11	110	26	12	9	13,6		●	●
3/4"	10	140	32	16	12	16,5		●	●
7/8"	9	160	36	18	14,5	19,5		●	●
1"	8	160	36	18	14,5	22,3		●	●

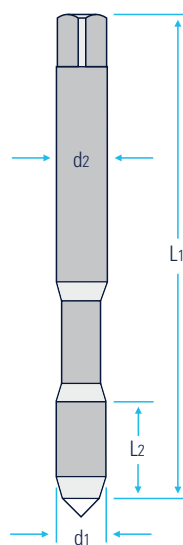
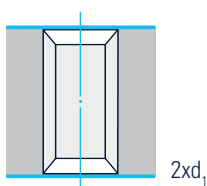


UNC - Unified Coarse Thread ANSI B1.1

Machine Taps
Blue Ring

DIN 371 HSS-E
spiral point
for chemical resistant steel

Group 346
for through holes



Art.-No.		346	346/25		
Technology	Page 7.1	Blue Ring	Blue Ring		
Chamfer Length	Page 7.4	B / 3,5-5 x P			
Surface	Page 7.5	bright	TiN		
Tolerance	Page 7.6	2 B	2 B		
Material Groups	Page 7.7	1b. high strength steel 2. chemical resistant steel 4. titanium alloys			

ϕd_1	P_{tpi}	L ₁	L ₂	d ₂	\square				
Nr. 4	40	56	10	3,5	2,7	2,3			
Nr. 5	40	56	10	3,5	2,7	2,6	●	●	
Nr. 6	32	56	10	4	3	2,8	●	●	
Nr. 8	32	63	12	4,5	3,4	3,5	●	●	
Nr. 10	24	70	14	6	4,9	3,9	●	●	
Nr. 12	24	80	16	6	4,9	4,5			
1/4"	20	80	16	7	5,5	5,2	●	●	
5/16"	18	90	18	8	6,2	6,6	●	●	
3/8"	16	100	20	10	8	8,0	●	●	

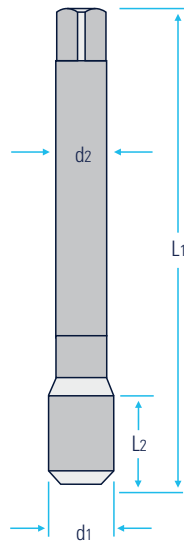
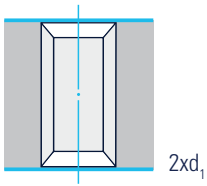


UNC - Unified Coarse Thread ANSI B1.1

Machine Taps
Blue Ring

DIN 376 HSS-E
spiral point
for chemical resistant steel

Group 446
for through holes



Art.-No.		446	446/25		
Technology	Page 7.1	Blue Ring	Blue Ring		
Chamfer Length	Page 7.4	B / 3,5-5 x P			
Surface	Page 7.5	bright	TiN		
Tolerance	Page 7.6	2 B	2 B		
Material Groups	Page 7.7	1b. high strength steel 2. chemical resistant steel 4. titanium alloys			

$\varnothing d_1$	P _{tpi}	L ₁	L ₂	d ₂	□				
7/16"	14	100	20	8	6,2	9,4			
1/2"	13	110	22	9	7	10,8	●	●	
9/16"	12	110	24	11	9	12,2			
5/8"	11	110	26	12	9	13,6	●	●	
3/4"	10	140	32	16	12	16,5	●	●	
7/8"	9	160	36	18	14,5	19,5	●	●	
1"	8	160	36	18	14,5	22,3	●	●	

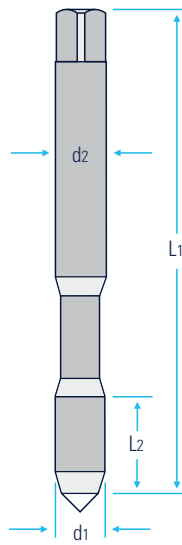
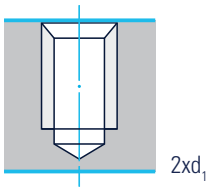


UNC - Unified Coarse Thread ANSI B1.1

Machine Taps
Red Ring

DIN 371 HSS-E PM
RH spiral flutes 20°
for nickel alloys

Group 348
for blind holes



Art.-No.		348		
Technology	Page 7.1	PM-Line by Schumacher		
Chamfer Length	Page 7.4	3-4 x P		
Surface	Page 7.5	bright		
Tolerance	Page 7.6	2 B		
Material Groups	Page 7.7	1b. high strength steel 4. titanium alloys 5. nickel alloys		

Ød ₁	P tpi	L ₁	L ₂	d ₂	□	⌀
Nr. 4	40	56	10	3,5	2,7	2,3
Nr. 5	40	56	10	3,5	2,7	2,6
Nr. 6	32	56	10	4	3	2,8
Nr. 8	32	63	12	4,5	3,4	3,5
Nr. 10	24	70	14	6	4,9	3,9
Nr. 12	24	80	16	6	4,9	4,5
1/4"	20	80	16	7	5,5	5,2
5/16"	18	90	18	8	6,2	6,6
3/8"	16	100	20	10	8	8,0

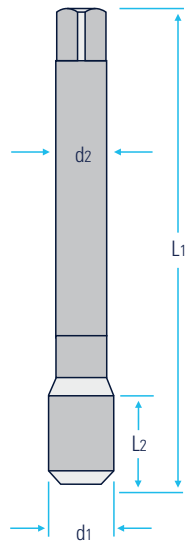
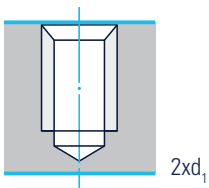


UNC - Unified Coarse Thread ANSI B1.1

Machine Taps Red Ring

DIN 376 HSS-E PM
RH spiral flutes 20°
for nickel alloys

Group 448
for blind holes



Art.-No.		448			
Technology	Page 7.1	PM-Line by Schumacher Red Ring			
Chamfer Length	Page 7.4	3-4 x P			
Surface	Page 7.5	bright			
Tolerance	Page 7.6	2 B			
Material Groups	Page 7.7	1b. high strength steel 4. titanium alloys 5. nickel alloys			

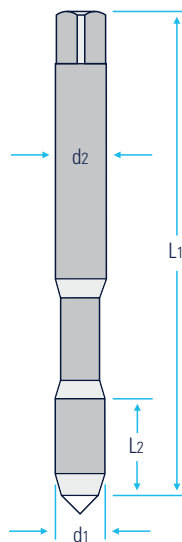
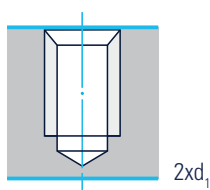
Ød ₁	P _{tpi}	L ₁	L ₂	d ₂	□	🌀				
7/16"	14	100	20	8	6,2	9,4				
1/2"	13	110	22	9	7	10,8	●			
9/16"	12	110	24	11	9	12,2				
5/8"	11	110	26	12	9	13,6	●			
3/4"	10	140	32	16	12	16,5	●			
7/8"	9	160	36	18	14,5	19,5				
1"	8	160	36	18	14,5	22,3				

UNC - Unified Coarse Thread ANSI B1.1


Machine Taps

DIN 371 HSS-E
RH spiral flutes 40°
for general construction steel

Group 352
for blind holes



Art.-No.		352	352/25		
Technology	Page 7.1	High Volume <small>by Schumacher</small>	High Volume <small>by Schumacher</small>		
Chamfer Length	Page 7.4	C / 2-3 x P			
Surface	Page 7.5	bright	TiN		
Tolerance	Page 7.6	2 B	2 B		
Material Groups	Page 7.7	1a. general construction steel 3b. spheroidal and malleable cast iron			

Ød ₁	P tpi	L ₁	L ₂	d ₂	□			
Nr. 4	40	56	10	3,5	2,7	2,3	●	
Nr. 5	40	56	10	3,5	2,7	2,6	●	●
Nr. 6	32	56	10	4	3	2,8	●	●
Nr. 8	32	63	12	4,5	3,4	3,5	●	●
Nr. 10	24	70	14	6	4,9	3,9	●	●
Nr. 12	24	80	16	6	4,9	4,5	●	
1/4"	20	80	16	7	5,5	5,2	●	●
5/16"	18	90	18	8	6,2	6,6	●	●
3/8"	16	100	20	10	8	8,0	●	●

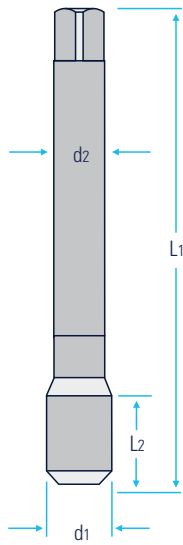
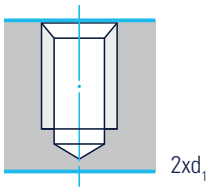


UNC - Unified Coarse Thread ANSI B1.1

Machine Taps

DIN 376 HSS-E
RH spiral flutes 40°
for general construction steel

Group 452
for blind holes



Art.-No.		452	452/25	
Technology	Page 7.1	High Volume	High Volume	
Chamfer Length	Page 7.4	C / 2-3 x P		
Surface	Page 7.5	bright	TiN	
Tolerance	Page 7.6	2 B	2 B	
Material Groups	Page 7.7	1a. general construction steel 3b. spheroidal and malleable cast iron		

Ød1	P tpi	L1	L2	d2	□				
7/16"	14	100	20	8	6,2	9,4	●		
1/2"	13	110	22	9	7	10,8	●	●	
9/16"	12	110	24	11	9	12,2	●		
5/8"	11	110	26	12	9	13,6	●	●	
3/4"	10	140	32	16	12	16,5	●	●	
7/8"	9	160	36	18	14,5	19,5	●	●	
1"	8	160	36	18	14,5	22,3	●	●	

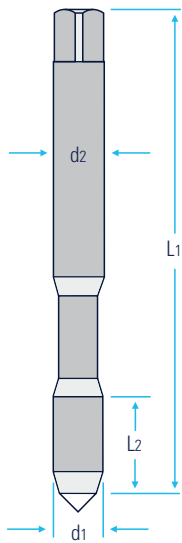
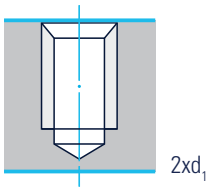


UNC - Unified Coarse Thread ANSI B1.1

Machine Taps
Blue Ring

DIN 371 HSS-E
RH spiral flutes 40°
for chemical resistant steel

Group 353
for blind holes



Art.-No.		353	353/25	
Technology	Page 7.1	Blue Ring	Blue Ring	
Chamfer Length	Page 7.4	C / 2-3 x P		
Surface	Page 7.5	bright	TiN	
Tolerance	Page 7.6	2 B	2 B	
Material Groups	Page 7.7	1b. high strength steel 2. chemical resistant steel 4. titanium alloys		

Ød ₁	P _{tpi}	L ₁	L ₂	d ₂	□	
Nr. 4	40	56	10	3,5	2,7	2,3
Nr. 5	40	56	10	3,5	2,7	2,6
Nr. 6	32	56	10	4	3	2,8
Nr. 8	32	63	12	4,5	3,4	3,5
Nr. 10	24	70	14	6	4,9	3,9
Nr. 12	24	80	16	6	4,9	4,5
1/4"	20	80	16	7	5,5	5,2
5/16"	18	90	18	8	6,2	6,6
3/8"	16	100	20	10	8	8,0

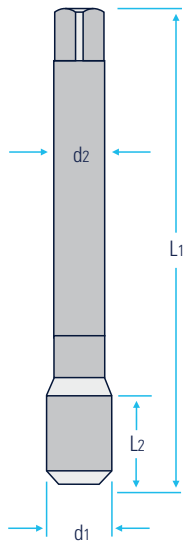
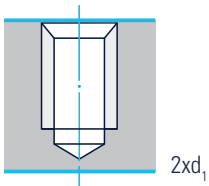


UNC - Unified Coarse Thread ANSI B1.1

Machine Taps
Blue Ring

DIN 376 HSS-E
RH spiral flutes 40°
for chemical resistant steel

Group 453
for blind holes



Art.-No.		453	453/25	
Technology	i Page 7.1	Blue Ring	Blue Ring	
Chamfer Length	i Page 7.4	C / 2-3 x P		
Surface	i Page 7.5	bright	TiN	
Tolerance	i Page 7.6	2 B	2 B	
Material Groups	i Page 7.7	1b. high strength steel	2. chemical resistant steel	4. titanium alloys

$\varnothing d_1$	P tpi	L ₁	L ₂	d ₂	\square				
7/16"	14	100	20	8	6,2	9,4			
1/2"	13	110	22	9	7	10,8	●	●	
9/16"	12	110	24	11	9	12,2			
5/8"	11	110	26	12	9	13,6	●	●	
3/4"	10	140	32	16	12	16,5	●	●	
7/8"	9	160	36	18	14,5	19,5	●	●	
1"	8	160	36	18	14,5	22,3	●	●	

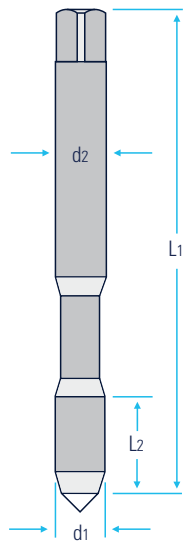
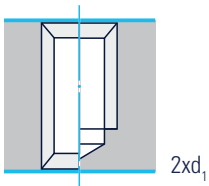


UNC - Unified Coarse Thread ANSI B1.1


Forming Taps

DIN 371 HSS-E
straight oil grooves
for steel, non-ferrous steel
and heat treatable steel

Group 356
for blind and through holes



Art.-No.		356/53	356/2553	
Technology	Page 7.1	High Volume <small>by Schumacher</small>	High Volume <small>by Schumacher</small>	
Chamfer Length	Page 7.4	C / 2-3 x P		
Surface	Page 7.5	bright	TiN	
Tolerance	Page 7.6	2 BX	2 BX	
Material Groups	Page 7.7	1a. general construction steel 1b. high strength steel 6. copper alloys		

$\varnothing d_1$	P tpi	L ₁	L ₂	d ₂	\square			
Nr. 4	40	56	10	3,5	2,7	2,55	●	●
Nr. 5	40	56	10	3,5	2,7	2,9	●	●
Nr. 6	32	56	10	4	3	3,15	●	●
Nr. 8	32	63	12	4,5	3,4	3,8	●	●
Nr. 10	24	70	14	6	4,9	4,35	●	●
Nr. 12	24	80	16	6	4,9	4,95		
1/4"	20	80	16	7	5,5	5,8	●	●
5/16"	18	90	18	8	6,2	7,3	●	●
3/8"	16	100	20	10	8	8,8	●	●