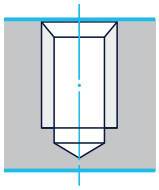
# UNF - Unified Fine Thread ANSI B1.1

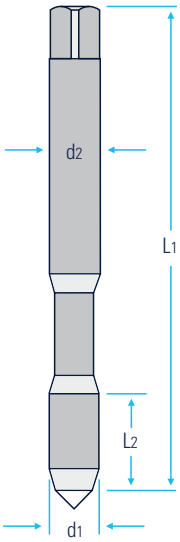
## Machine Taps

DIN 371 HSS-E
straight flutes
for general construction steel

Group 360
for blind holes



2xd1



| | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|
| Art.-No. | | | | | | | 360 | | | |
| 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 | | | |
| Ød1 | P tpi | L1 | L2 | d2 | □ | | | | | |
| Nr. 5 | 44 | 56 | 10 | 3,5 | 2,7 | 2,7 | ● | | | |
| Nr. 6 | 40 | 56 | 10 | 4 | 3 | 3,0 | ● | | | |
| Nr. 8 | 36 | 63 | 12 | 4,5 | 3,4 | 3,5 | ● | | | |
| Nr. 10 | 32 | 70 | 14 | 6 | 4,9 | 4,1 | ● | | | |
| Nr. 12 | 28 | 80 | 16 | 6 | 4,9 | 4,7 | ● | | | |
| 1/4" | 28 | 80 | 16 | 7 | 5,5 | 5,5 | ● | | | |
| 5/16" | 24 | 90 | 18 | 8 | 6,2 | 6,9 | ● | | | |
| 3/8" | 24 | 100 | 20 | 10 | 8 | 8,5 | ● | | | |



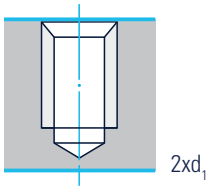
○ available – intermediate size on request

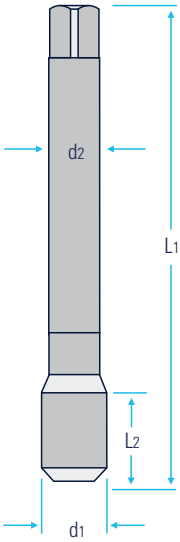
# UNF - Unified Fine Thread ANSI B1.1

## Machine Taps

DIN 374 HSS-E
straight flutes
for general construction steel

Group 460
for blind holes



| | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|
| Art.-No. | | | | | | | 460 | | | |
| 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 | | | |
| Ød1 | P tpi | L1 | L2 | d2 | □ | | | | | |
| 7/16" | 20 | 100 | 20 | 8 | 6,2 | 9,9 | ● | | | |
| 1/2" | 20 | 100 | 20 | 9 | 7 | 11,5 | ● | | | |
| 9/16" | 18 | 100 | 22 | 11 | 9 | 12,9 | ● | | | |
| 5/8" | 18 | 100 | 22 | 12 | 9 | 14,5 | ● | | | |
| 3/4" | 16 | 110 | 25 | 14 | 11 | 17,5 | ● | | | |
| 7/8" | 14 | 140 | 25 | 18 | 14,5 | 20,4 | ● | | | |
| 1" | 12 | 140 | 28 | 20 | 16 | 23,3 | ● | | | |



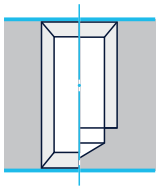
○ available – intermediate size on request

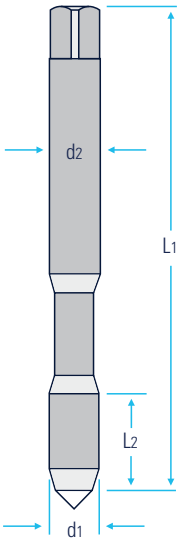
# UNF - Unified Fine Thread ANSI B1.1

## Machine Taps
## White Ring

DIN 371 HSS-E
straight flutes
for cast iron

Group 363
for blind and through holes



| | | | |
|---|---|---|---|
| Art.-No. | | | 363 |
| 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 |

| Ød1 | P tpi | L1 | L2 | d2 | □ | | |
|---|---|---|---|---|---|---|---|
| Nr. 5 | 44 | 56 | 10 | 3,5 | 2,7 | 2,7 | |
| Nr. 6 | 40 | 56 | 10 | 4 | 3 | 3,0 | |
| Nr. 8 | 36 | 63 | 12 | 4,5 | 3,4 | 3,5 | |
| Nr. 10 | 32 | 70 | 14 | 6 | 4,9 | 4,1 | ● |
| Nr. 12 | 28 | 80 | 16 | 6 | 4,9 | 4,7 | |
| 1/4" | 28 | 80 | 16 | 7 | 5,5 | 5,5 | ● |
| 5/16" | 24 | 90 | 18 | 8 | 6,2 | 6,9 | ● |
| 3/8" | 24 | 100 | 20 | 10 | 8 | 8,5 | ● |



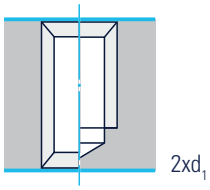
○ available – intermediate size on request

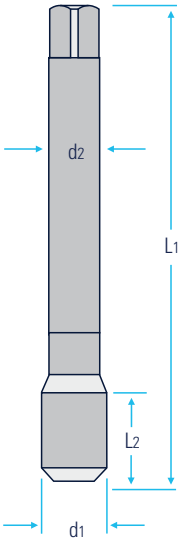
# UNF - Unified Fine Thread ANSI B1.1

## Machine Taps
## White Ring

DIN 374 HSS-E
straight flutes
for cast iron

Group 463
for blind and through holes



| | | | |
|---|---|---|---|
| Art.-No. | | | 463 |
| 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 |

| Ød1 | P tpi | L1 | L2 | d2 | □ | | |
|---|---|---|---|---|---|---|---|
| 7/16" | 20 | 100 | 20 | 8 | 6,2 | 9,9 | |
| 1/2" | 20 | 100 | 20 | 9 | 7 | 11,5 | ● |
| 9/16" | 18 | 100 | 22 | 11 | 9 | 12,9 | |
| 5/8" | 18 | 100 | 22 | 12 | 9 | 14,5 | ● |
| 3/4" | 16 | 110 | 25 | 14 | 11 | 17,5 | ● |
| 7/8" | 14 | 140 | 25 | 18 | 14,5 | 20,4 | ● |
| 1" | 12 | 140 | 28 | 20 | 16 | 23,3 | ● |



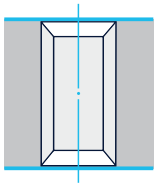
○ available – intermediate size on request

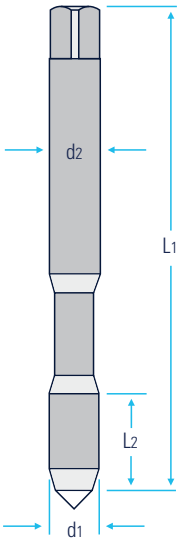
# UNF - Unified Fine Thread ANSI B1.1

## Machine Taps

DIN 371 HSS-E
spiral point
for general construction steel

Group 365
for through holes



| | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|
| Art.-No. | | | | | | | 365 | 365/25 | |
| Technology | Page 7.1 | | | | | | | | |
| 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 | |
| Ød1 | P tpi | L1 | L2 | d2 | □ | | | | |
| Nr. 5 | 44 | 56 | 10 | 3,5 | 2,7 | 2,7 | ● | ● | |
| Nr. 6 | 40 | 56 | 10 | 4 | 3 | 3,0 | ● | ● | |
| Nr. 8 | 36 | 63 | 12 | 4,5 | 3,4 | 3,5 | ● | ● | |
| Nr. 10 | 32 | 70 | 14 | 6 | 4,9 | 4,1 | ● | ● | |
| Nr. 12 | 28 | 80 | 16 | 6 | 4,9 | 4,7 | ● | | |
| 1/4" | 28 | 80 | 16 | 7 | 5,5 | 5,5 | ● | ● | |
| 5/16" | 24 | 90 | 18 | 8 | 6,2 | 6,9 | ● | ● | |
| 3/8" | 24 | 100 | 20 | 10 | 8 | 8,5 | ● | ● | |



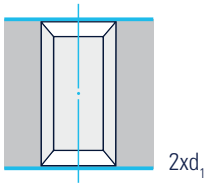
○ available – intermediate size on request

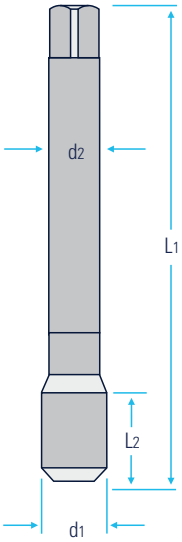
# UNF - Unified Fine Thread ANSI B1.1

## Machine Taps

DIN 374 HSS-E
spiral point
for general construction steel

Group 465
for through holes



| | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|
| Art.-No. | | | | | | 465 | 465/25 | | |
| Technology | Page 7.1 | | | | | | | | |
| 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 | | |
| Ød1 | P tpi | L1 | L2 | d2 | □ | | | | |
| 7/16" | 20 | 100 | 20 | 8 | 6,2 | 9,9 | ● | | |
| 1/2" | 20 | 100 | 20 | 9 | 7 | 11,5 | ● | ● | |
| 9/16" | 18 | 100 | 22 | 11 | 9 | 12,9 | ● | | |
| 5/8" | 18 | 100 | 22 | 12 | 9 | 14,5 | ● | ● | |
| 3/4" | 16 | 110 | 25 | 14 | 11 | 17,5 | ● | ● | |
| 7/8" | 14 | 140 | 25 | 18 | 14,5 | 20,4 | ● | ● | |
| 1" | 12 | 140 | 28 | 20 | 16 | 23,3 | ● | ● | |



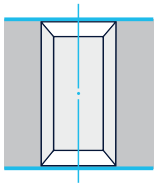
○ available – intermediate size on request

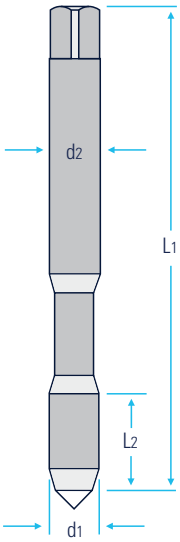
# UNF - Unified Fine Thread ANSI B1.1

## Machine Taps
## Blue Ring

DIN 371 HSS-E
spiral point
for chemical resistant steel

Group 366
for through holes



| | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|
| Art.-No. | | | | | | | 366 | 366/25 | |
| 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 |
| Ød1 | P tpi | L1 | L2 | d2 | □ | | | | |
| Nr. 5 | 44 | 56 | 10 | 3,5 | 2,7 | 2,7 | ● | ● | |
| Nr. 6 | 40 | 56 | 10 | 4 | 3 | 3,0 | ● | ● | |
| Nr. 8 | 36 | 63 | 12 | 4,5 | 3,4 | 3,5 | ● | ● | |
| Nr. 10 | 32 | 70 | 14 | 6 | 4,9 | 4,1 | ● | ● | |
| Nr. 12 | 28 | 80 | 16 | 6 | 4,9 | 4,7 | | | |
| 1/4" | 28 | 80 | 16 | 7 | 5,5 | 5,5 | ● | ● | |
| 5/16" | 24 | 90 | 18 | 8 | 6,2 | 6,9 | ● | ● | |
| 3/8" | 24 | 100 | 20 | 10 | 8 | 8,5 | ● | ● | |



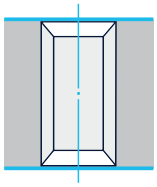
○ available – intermediate size on request

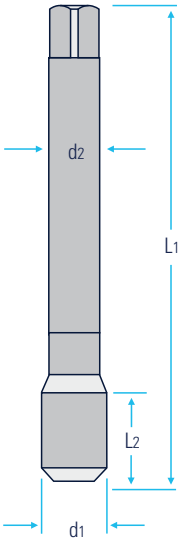
# UNF - Unified Fine Thread ANSI B1.1

## Machine Taps
## Blue Ring

DIN 374 HSS-E
spiral point
for chemical resistant steel

Group 466
for through holes



| | | | | | |
|---|---|---|---|---|---|
| Art.-No. | | | 466 | 466/25 | |
| 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 |

| Ød1 | P tpi | L1 | L2 | d2 | □ | |
|---|---|---|---|---|---|---|
| 7/16" | 20 | 100 | 20 | 8 | 6,2 | 9,9 |
| 1/2" | 20 | 100 | 20 | 9 | 7 | 11,5 |
| 9/16" | 18 | 100 | 22 | 11 | 9 | 12,9 |
| 5/8" | 18 | 100 | 22 | 12 | 9 | 14,5 |
| 3/4" | 16 | 110 | 25 | 14 | 11 | 7,5 |
| 7/8" | 14 | 140 | 25 | 18 | 14,5 | 20,4 |
| 1" | 12 | 140 | 28 | 20 | 16 | 23,3 |

| Ød1 | 466 | 466/25 |
|---|---|---|
| 7/16" | | |
| 1/2" | ● | ● |
| 9/16" | | |
| 5/8" | ● | ● |
| 3/4" | ● | ● |
| 7/8" | ● | ● |
| 1" | ● | ● |



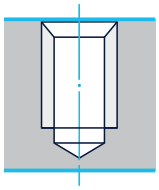
○ available – intermediate size on request

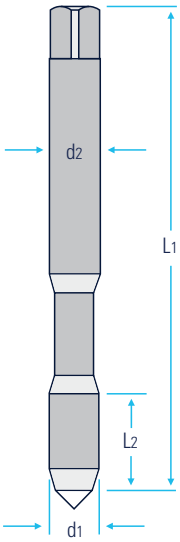
# UNF - Unified Fine Thread ANSI B1.1

## Machine Taps
## Red Ring

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

Group 368
for blind holes



| | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|
| Art.-No. | | | | | | 368 | | | |
| 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 | |
| Ød1 | P tpi | L1 | L2 | d2 | □ | | | | |
| Nr. 5 | 44 | 56 | 10 | 3,5 | 2,7 | 2,7 | | | |
| Nr. 6 | 40 | 56 | 10 | 4 | 3 | 3,0 | | | |
| Nr. 8 | 36 | 63 | 12 | 4,5 | 3,4 | 3,5 | ● | | |
| Nr. 10 | 32 | 70 | 14 | 6 | 4,9 | 4,1 | ● | | |
| Nr. 12 | 28 | 80 | 16 | 6 | 4,9 | 4,7 | | | |
| 1/4" | 28 | 80 | 16 | 7 | 5,5 | 5,5 | ● | | |
| 5/16" | 24 | 90 | 18 | 8 | 6,2 | 6,9 | ● | | |
| 3/8" | 24 | 100 | 20 | 10 | 8 | 8,5 | ● | | |



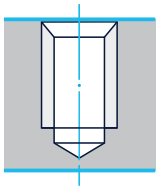
○ available – intermediate size on request

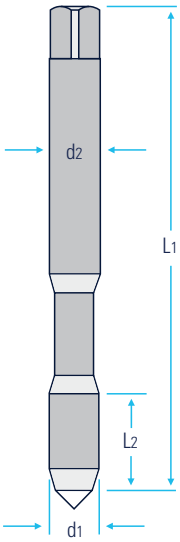
# UNF - Unified Fine Thread ANSI B1.1

## Machine Taps

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

Group 372
for blind holes



| Art.-No. | | | 372 | 372/25 | | |
|---|---|---|---|---|---|---|
| Technology | Page 7.1 | | | | | |
| 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 □ | | | | |
| Nr. 5 | 44 | 56 10 3,5 2,7 2,7 | ● | ● | | |
| Nr. 6 | 40 | 56 10 4 3 3,0 | ● | ● | | |
| Nr. 8 | 36 | 63 12 4,5 3,4 3,5 | ● | ● | | |
| Nr. 10 | 32 | 70 14 6 4,9 4,1 | ● | ● | | |
| Nr. 12 | 28 | 80 16 6 4,9 4,7 | ● | | | |
| 1/4" | 28 | 80 16 7 5,5 5,5 | ● | ● | | |
| 5/16" | 24 | 90 18 8 6,2 6,9 | ● | ● | | |
| 3/8" | 24 | 100 20 10 8 8,5 | ● | ● | | |



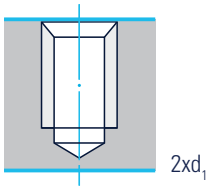
○ available – intermediate size on request

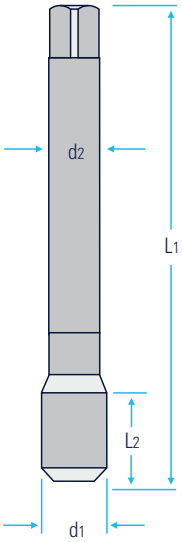
# UNF - Unified Fine Thread ANSI B1.1

## Machine Taps

DIN 374 HSS-E
RH spiral flutes 40°
for general construction steel

Group 472
for blind holes



| Art.-No. | | | 472 | 472/25 | | |
|---|---|---|---|---|---|---|
| Technology | Page 7.1 | | | | | |
| 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" | 20 | 100 | 20 | 8 | 6,2 | 9,9 | ● | | | |
| 1/2" | 20 | 100 | 20 | 9 | 7 | 11,5 | ● | ● | | |
| 9/16" | 18 | 100 | 22 | 11 | 9 | 12,9 | ● | | | |
| 5/8" | 18 | 100 | 22 | 12 | 9 | 14,5 | ● | ● | | |
| 3/4" | 16 | 110 | 25 | 14 | 11 | 17,5 | ● | ● | | |
| 7/8" | 14 | 140 | 25 | 18 | 14,5 | 20,4 | ● | ● | | |
| 1" | 12 | 140 | 28 | 20 | 16 | 23,3 | ● | ● | | |



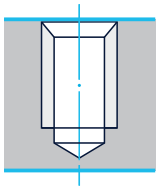
○ available – intermediate size on request

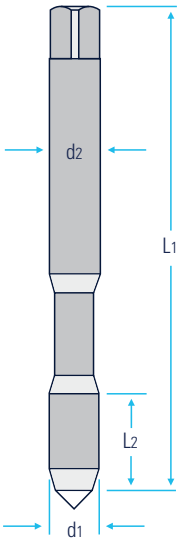
# UNF - Unified Fine Thread ANSI B1.1

## Machine Taps
## Blue Ring

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

Group 373
for blind holes



| | | | | | | | | |
|---|---|---|---|---|---|---|---|---|
| Art.-No. | | | | | | 373 | 373/25 | |
| 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 |
| Ød1 | P tpi | L1 | L2 | d2 | □ | | | |
| Nr. 5 | 44 | 56 | 10 | 3,5 | 2,7 | 2,7 | ● | ● |
| Nr. 6 | 40 | 56 | 10 | 4 | 3 | 3,0 | ● | ● |
| Nr. 8 | 36 | 63 | 12 | 4,5 | 3,4 | 3,5 | ● | ● |
| Nr. 10 | 32 | 70 | 14 | 6 | 4,9 | 4,1 | ● | ● |
| Nr. 12 | 28 | 80 | 16 | 6 | 4,9 | 4,7 | | |
| 1/4" | 28 | 80 | 16 | 7 | 5,5 | 5,5 | ● | ● |
| 5/16" | 24 | 90 | 18 | 8 | 6,2 | 6,9 | ● | ● |
| 3/8" | 24 | 100 | 20 | 10 | 8 | 8,5 | ● | ● |



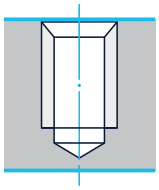
○ available – intermediate size on request

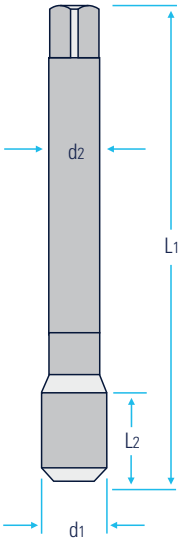
# UNF - Unified Fine Thread ANSI B1.1

## Machine Taps
## Blue Ring

DIN 374 HSS-E
RH spiral flutes 40°
for chemical resistant steel

Group 473
for blind holes



| | | | | | | | | |
|---|---|---|---|---|---|---|---|---|
| Art.-No. | | | | | | 473 | 473/25 | |
| 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 |
| Ød1 | P tpi | L1 | L2 | d2 | □ | | | |
| 7/16" | 20 | 100 | 20 | 8 | 6,2 | 9,9 | | |
| 1/2" | 20 | 100 | 20 | 9 | 7 | 11,5 | ● | ● |
| 9/16" | 18 | 100 | 22 | 11 | 9 | 12,9 | | |
| 5/8" | 18 | 100 | 22 | 12 | 9 | 14,5 | ● | ● |
| 3/4" | 16 | 110 | 25 | 14 | 11 | 17,5 | ● | ● |
| 7/8" | 14 | 140 | 25 | 18 | 14,5 | 20,4 | ● | ● |
| 1" | 12 | 140 | 28 | 20 | 16 | 23,3 | ● | ● |



○ available – intermediate size on request