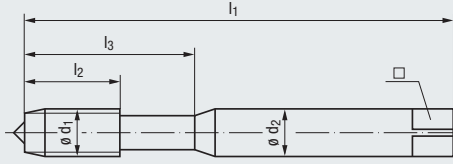


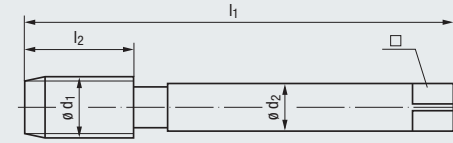
- Product Finder
- V_c
- UNC
- UNF
- M
- MF
- G
- STI
- SELF-LOCK
- Tech. Info

DIN Length - ANSI Shank

Overall length acc. to DIN 2174



Reinforced Shank
(No.1 - 3/8)



Reduced Shank
(7/16 - 1)

UNC

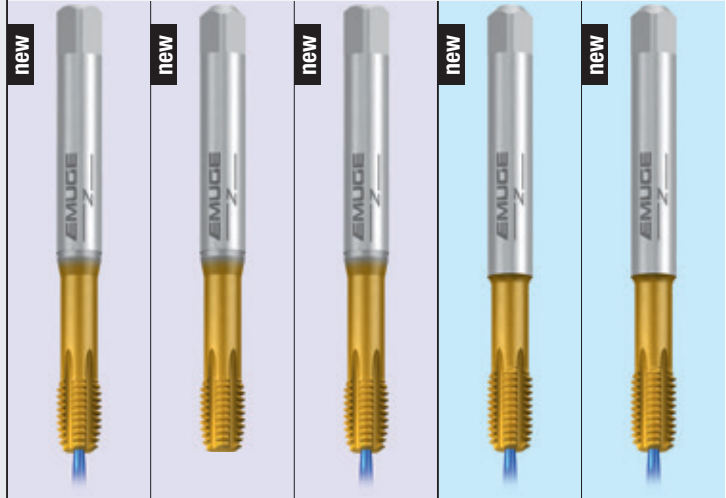
Unified Coarse Thread
ASME B1.1

Class of Fit: 2BX
Coating: TIN-80
Cutting Material: **HSSE-PM**
Technical Characteristics: C / 2-3, E / 0

Thread Depth and Hole Shape

Applications - Material

Z
CNC-Controlled
Machines



2BX	2BX	2BX	2BX	2BX
TIN-80	TIN-80	TIN-80	TIN-80	TIN-80
HSSE-PM	HSSE-PM	HSSE-PM	Carbide	Carbide
C / 2-3	E / 1.5-2	E / 1.5-2	C / 2-3	E / 1.5-2
E / 0	E / 0 / P	E / 0	E / 0	E / 0



P 1.1-5.1	P 1.1-5.1	P 1.1-5.1	P 2.1-5.1	P 2.1-5.1
M 1.1-3.1 2)	M 1.1-3.1 2)	M 1.1-3.1 2)	N 1.4-5, 2.4-5	N 1.4-5, 2.4-5
K 2.1	K 2.1	K 2.1		
N 2.1-2, 2.4-5	N 2.1-2, 2.4-5	N 2.1-2, 2.4-5		
S 1.1-2.2 2)	S 1.1-2.2 2)	S 1.1-2.2 2)		
S 2.4 2)	S 2.4 2)	S 2.4 2)		

Reinforced Shank

Nominal Size ø d ₁	T.P.I.	l ₁	l ₂	inch			□	Tool Identification		BU38Z700	BU39Z700	BU44Z700	BU38Z800	BU44Z800
				l ₃	ø d ₂	□		Dimens. ID	InnoForm 1-Z-SN-IKZ PM-TIN-80					
No. 1	64	1.772	0.157	0.472	0.141	0.110	0.0669	.5000						
No. 2	56	1.772	0.177	0.472	0.141	0.110	0.0787	.5001						
No. 3	48	1.969	0.197	0.551	0.141	0.110	0.0906	.5002						
No. 4	40	2.205	0.236	0.709	0.141	0.110	0.1004	.5003						
No. 5	40	2.205	0.276	0.709	0.141	0.110	0.1142	.5004						
No. 6	32	2.205	0.276	0.787	0.141	0.110	0.1240	.5005						
No. 8	32	2.480	0.315	0.827	0.168	0.131	0.1496	.5006						
No.10	24	2.756	0.394	0.984	0.194	0.152	0.1713	.5007						
No.12	24	3.150	0.394	1.142	0.220	0.165	0.1969	.5008						
1/4	20	3.150	0.512	1.181	0.255	0.191	0.2264	.5009						
5/16	18	3.543	0.551	1.378	0.318	0.238	0.2874	.5010						
3/8	16	3.937	0.630	1.535	0.381	0.286	0.3465	.5011						

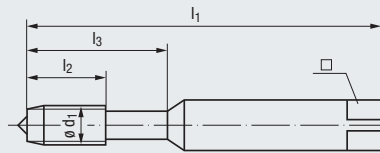
Reduced Shank

Nominal Size ø d ₁	T.P.I.	l ₁	l ₂	inch			□	Tool Identification		CU38Z700	CU39Z700	CU44Z700		
				l ₃	ø d ₂	□		Dimens. ID	InnoForm 2-Z-SN-IKZ PM-TIN-80					
7/16	14	3.937	0.709	—	0.323	0.242	0.4035	.5012						
1/2	13	4.331	0.787	—	0.367	0.275	0.4646	.5013						
9/16	12	4.331	0.787	—	0.429	0.322	0.5236	.5014						
5/8	11	4.331	0.866	—	0.480	0.360	0.5827	.5015						
3/4	10	4.921	0.984	—	0.590	0.442	0.7028	.5016						
7/8	9	5.512	1.063	—	0.697	0.523	0.8228	.5017						
1	8	6.299	1.181	—	0.800	0.600	0.9409	.5018						

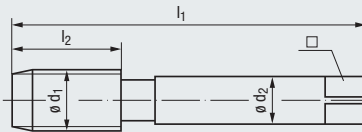
We recommend a smaller preparatory diameter by 0.002 in for difficult to form materials (such as aluminum cast alloys) for P = 24 T.P.I. and coarser threads. For further information regarding the recommended preparatory diameters, see page 208 - 209.

ANSI Length • ANSI Shank

STEEL
Steel
Materials

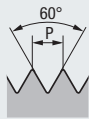


Reinforced Shank
(No.4 - 3/8)



Reduced Shank
(7/16 - 3/4)

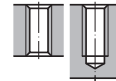
UNC



**Unified Coarse Thread
ASME B1.1**

Class of Fit: 2BX
Coating: TIN
Cutting Material: HSS Extra
Technical Characteristics: C / 2-3, E / O / P

Thread Depth and Hole Shape: max. 3 x d₁



Applications – Material

- P 1.1-3.1
- M 1.1-2.1²⁾
- N 1.4-5, 2.1-2

Tool Identification

AU921400

**Druck
STEEL-SN
TIN**

Nominal Size ø d ₁	T.P.I.	inch							□	Dimens. ID	Druck STEEL-SN TIN
		l ₁	l ₂	l ₃	ø d ₂	□	□	□			
No. 4	40	1 7/8	1.88	0.433	0.709	0.141	0.110	0.1004	.5003	●	
No. 5	40	1 15/16	1.94	0.433	0.709	0.141	0.110	0.1142	.5004	●	
No. 6	32	2	2.00	0.472	0.748	0.141	0.110	0.1240	.5005	●	
No. 8	32	2 1/8	2.13	0.512	0.827	0.168	0.131	0.1496	.5006	●	
No. 10	24	2 3/8	2.38	0.591	0.945	0.194	0.152	0.1713	.5007	●	
1/4	20	2 1/2	2.50	0.669	1.142	0.255	0.191	0.2264	.5009	●	
5/16	18	2 23/32	2.72	0.787	1.299	0.318	0.238	0.2874	.5010	●	
3/8	16	2 15/16	2.94	0.866	1.378	0.381	0.286	0.3465	.5011	●	
7/16	14	3 5/32	3.16	0.866	—	0.323	0.242	0.4035	.5012	●	
1/2	13	3 3/8	3.38	0.984	—	0.367	0.275	0.4646	.5013	●	
9/16	12	3 19/32	3.59	1.024	—	0.429	0.322	0.5236	.5014	●	
5/8	11	3 13/16	3.81	1.063	—	0.480	0.360	0.5827	.5015	●	
3/4	10	4 1/4	4.25	1.181	—	0.590	0.442	0.7028	.5016	●	

2) Restricted application possibilities with emulsion

We recommend a smaller preparatory diameter by 0.002 in for difficult to form materials (such as aluminum cast alloys) for P = 24 T.P.I. and coarser threads. For further information regarding the recommended preparatory diameters, see page 208 - 209.

DIN Length • ANSI Shank



All ANSI Length • ANSI Shank taps are available in the popular DIN Length • ANSI Shank style.

The DIN Length • ANSI Shank configuration allows for added reach capabilities and greater chip clearance.

Product Finder

V_c

UNC

UNF

M

MF

G

ST

SELF-LOCK

Tech. Info

