



Machine tap, uncoated, UNC: 1-8



Order data

Order number	137862 1-8
GTIN	4045197595010
Item class	12H

Description

Version:

Sturdy design, with right-hand chip flutes. HSS-E

Application:

For UNC uniform coarse threads ASME – B1.1.

Thread type: UNC

Tool material: HSS E

Standard: DIN 376

Threads per inch: 8

Thread Ø: 25.4 mm

Overall length L: 160 mm

Shank Ø D_s: 18 mm

Shank square □: 14.5 mm

Tapping hole Ø: 22.25 mm

Technical description

Tapping hole Ø	22.25 mm
Number of clamping slots	4
Number of cutting edges Z	4
Thread pitch	3.175 mm
Thread Ø	25.4 mm
Threads per inch	8
Standard	DIN 376

Tool material	HSS E
Shank $\varnothing D_s$	18 mm
Overall length L	160 mm
Shank square \square	14.5 mm
Thread depth	50.8 mm
Thread type	UNC
Thread size	1-8 UNC
Coating	uncoated
Flank angle	60°
Tolerance class	2B
Taper lead form	C
Helix angle	15°
Shank	Plain shank with h9
Through-coolant	no
Application for type of drilling	up to 2xD for blind holes
Cutting direction	right-hand
Type of threading tool	Machine tap for conventional machining
Colour ring	without
Type of product	Tap

User data

	Suitability	V_c	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	13 m/min	N
Steel < 500 N/mm ²	suitable	15 m/min	P
Steel < 750 N/mm ²	suitable	15 m/min	P
Oil	suitable		
wet maximum	suitable only under restricted conditions		

