UNF, tolerance 2B

N° EH1787 / EH1788

N° EH1790 / EH1791 x-tap

N° ET1750 / ET1751

N° ET1790 / ET1791 x-tap

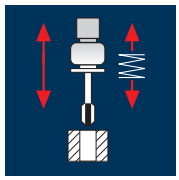
11	HSS PM/F		Rm 850-1100		321
11	HSS PM/F		Rm 850-1100		323
In	HSS PM/F		Inox Stainless		325
In	HSS PM/F		Inox Stainless		327

UNJF, tolerance 3B

N° E1799

Ni	HSS PM/F		Ni Nickel Alloy		329

Application



Material	UNF		ø [mm]	P [mm]	v_c 1.5 x d	n [min⁻¹]	v_f [100%]	v_c 2.0 x d	n [min⁻¹]	v_f [100%]	v_c 3.0 x d	n [min⁻¹]	v_f [100%]
Steel 500 - 850 N/mm²	6	-40	3.505	0.635	25	2270	1441	20	1815	1153	15	1360	864
	8	-36	4.166	0.706	25	1910	1348	20	1530	1080	15	1145	808
	10	-32	4.826	0.794	25	1650	1310	20	1320	1048	15	990	786
	12	-28	5.486	0.907	25	1450	1315	20	1160	1052	15	870	789
	1/4	-28	6.350	0.907	25	1255	1138	20	1005	912	15	750	680
	5/16	-24	7.938	1.058	25	1005	1064	20	800	847	15	600	635
	3/8	-24	9.525	1.058	25	835	883	20	670	709	15	500	529
	7/16	-20	11.113	1.270	25	715	908	20	575	730	15	430	546
	1/2	-20	12.700	1.270	25	625	794	20	500	635	15	375	476
Steel 500 - 850 N/mm²	9/16	-18	14.288	1.411	25	555	783	20	445	628	15	335	473
	5/8	-18	15.875	1.411	25	500	706	20	400	564	15	300	423
	3/4	-16	19.050	1.588	25	420	667	20	335	532	15	250	397
	7/8	-14	22.225	1.814	25	360	653	20	285	517	15	215	390
	1"	-12	25.400	2.117	25	315	667	20	250	529	15	190	402
Steel 850 - 1100 N/mm²	6	-40	3.505	0.635	20	1815	1153	15	1360	864	12	1090	692
	8	-36	4.166	0.706	20	1530	1080	15	1145	808	12	915	646
	10	-32	4.826	0.794	20	1320	1048	15	990	786	12	790	627
	12	-28	5.486	0.907	20	1160	1052	15	870	789	12	695	630
	1/4	-28	6.350	0.907	20	1005	912	15	750	680	12	600	544
	5/16	-24	7.938	1.058	20	800	847	15	600	635	12	480	508
	3/8	-24	9.525	1.058	20	670	709	15	500	529	12	400	423
	7/16	-20	11.113	1.270	20	575	730	15	430	546	12	345	438
	1/2	-20	12.700	1.270	20	500	635	15	375	476	12	300	381
Steel 850 - 1100 N/mm²	9/16	-18	14.288	1.411	20	445	628	15	335	473	12	265	374
	5/8	-18	15.875	1.411	20	400	564	15	300	423	12	240	339
	3/4	-16	19.050	1.588	20	335	532	15	250	397	12	200	318
	7/8	-14	22.225	1.814	20	285	517	15	215	390	12	170	308
	1"	-12	25.400	2.117	20	250	529	15	190	402	12	150	318

Material	UNF		ø [mm]	P [mm]	v_c 1.5 x d	n [min⁻¹]	v_f [100%]	v_c 2.0 x d	n [min⁻¹]	v_f [100%]
Steel 1100 - 1300 N/mm²	6	-40	3.505	0.635	7	635	403	4	365	232
	8	-36	4.166	0.706	7	535	377	4	305	215
	10	-32	4.826	0.794	7	460	365	4	265	210
	12	-28	5.486	0.907	7	405	367	4	230	209
	1/4	-28	6.350	0.907	7	350	317	4	200	181
	5/16	-24	7.938	1.058	7	280	296	4	160	169
	3/8	-24	9.525	1.058	7	235	249	4	135	143
	7/16	-20	11.113	1.270	7	200	254	4	115	146
	1/2	-20	12.700	1.270	7	175	222	4	100	127
Steel 1100 - 1300 N/mm²	9/16	-18	14.288	1.411	7	155	219	4	90	127
	5/8	-18	15.875	1.411	7	140	198	4	80	113
	3/4	-16	19.050	1.588	7	115	183	4	65	103
	7/8	-14	22.225	1.814	7	100	181	4	55	100
	1"	-12	25.400	2.117	7	90	191	4	50	106

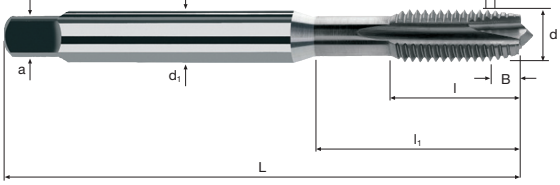
UNF | 2B

60° | HSS PM/F

=DIN 371/374

X · P
Form B

EH1787 / ≈ DIN 371



EH1788 / ≈ DIN 374

Rm < 850	Rm 850-1100	Rm 1100-1300

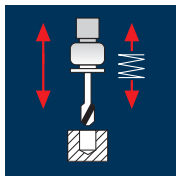
Example: Order-N°. EH1787 (Article-N°.) .756 (ø-Code)

ø Code	d	P(TPI)	d (mm)	L	l	l1	d1	a			TiCN EH1787
.756	Nr. 6	-40	3.505	56	12	20	4.0	3.0	3	2.95	●
.757	Nr. 8	-36	4.166	63	13	21	4.5	3.4	3	3.50	●
.758	Nr. 10	-32	4.826	70	15	25	6.0	4.9	3	4.10	●
.759	Nr. 12	-28	5.486	80	17	30	6.0	4.9	3	4.60	●
.760	1/4	-28	6.350	80	17	30	7.0	5.5	3	5.50	●
.761	5/16	-24	7.938	90	20	35	8.0	6.2	3	6.90	●
.762	3/8	-24	9.525	100	22	39	10.0	8.0	3	8.50	●

Example: Order-N°. EH1788 (Article-N°.) .763 (ø-Code)

ø Code	d	P(TPI)	d (mm)	L	l	l1	d1	a			TiCN EH1788
.763	7/16	-20	11.113	100	22	39	8.0	6.2	3	9.90	●
.764	1/2	-20	12.700	100	22	39	9.0	7.0	3	11.50	●
.765	9/16	-18	14.288	100	22	39	11.0	9.0	3	12.90	●
.766	5/8	-18	15.875	100	22	39	12.0	9.0	3	14.50	●
.767	3/4	-16	19.050	110	25	45	14.0	11.0	4	17.50	●
.768	7/8	-14	22.225	125	26	50	18.0	14.5	4	20.40	●
.769	1"	-12	25.400	140	32	52	18.0	14.5	5	23.30	●

Application



Material

UNF		ø [mm]	P [mm]	v_c 1.0 x d	n [min⁻¹]	v_f [100%]	v_c 1.5 x d	n [min⁻¹]	v_f [100%]	v_c 2.0 x d	n [min⁻¹]	v_f [100%]
Steel 500 - 850 N/mm²												
6	-40	3.505	0.635	32	2905	1845	28	2545	1616	22	2000	1270
8	-36	4.166	0.706	32	2445	1725	28	2140	1510	22	1680	1185
10	-32	4.826	0.794	32	2110	1675	28	1845	1465	22	1450	1151
12	-28	5.486	0.907	32	1855	1683	28	1625	1474	22	1275	1157
1/4	-28	6.350	0.907	32	1605	1456	28	1405	1274	22	1105	1002
5/16	-24	7.938	1.058	32	1285	1360	28	1125	1191	22	880	931
3/8	-24	9.525	1.058	32	1070	1132	28	935	989	22	735	778
7/16	-20	11.113	1.270	32	915	1162	28	800	1016	22	630	800
1/2	-20	12.700	1.270	32	800	1016	28	700	889	22	550	699
Steel 500 - 850 N/mm²												
9/16	-18	14.288	1.411	32	715	1009	28	625	882	22	490	691
5/8	-18	15.875	1.411	32	640	903	28	560	790	22	440	621
3/4	-16	19.050	1.588	32	535	849	28	470	746	22	370	587
7/8	-14	22.225	1.814	32	460	835	28	400	726	22	315	572
1"	-12	25.400	2.117	32	400	847	28	350	741	22	275	582
Steel 850 - 1100 N/mm²												
6	-40	3.505	0.635	20	1815	1153	16	1455	924	10	910	578
8	-36	4.166	0.706	20	1530	1080	16	1225	864	10	765	540
10	-32	4.826	0.794	20	1320	1048	16	1055	837	10	660	524
12	-28	5.486	0.907	20	1160	1052	16	930	844	10	580	526
1/4	-28	6.350	0.907	20	1005	912	16	800	726	10	500	454
5/16	-24	7.938	1.058	20	800	847	16	640	677	10	400	423
3/8	-24	9.525	1.058	20	670	709	16	535	566	10	335	354
7/16	-20	11.113	1.270	20	575	730	16	460	584	10	285	362
1/2	-20	12.700	1.270	20	500	635	16	400	508	10	250	318
Steel 850 - 1100 N/mm²												
9/16	-18	14.288	1.411	20	445	628	16	355	501	10	225	317
5/8	-18	15.875	1.411	20	400	564	16	320	452	10	200	282
3/4	-16	19.050	1.588	20	335	532	16	265	421	10	165	262
7/8	-14	22.225	1.814	20	285	517	16	230	417	10	145	263
1"	-12	25.400	2.117	20	250	529	16	200	423	10	125	265

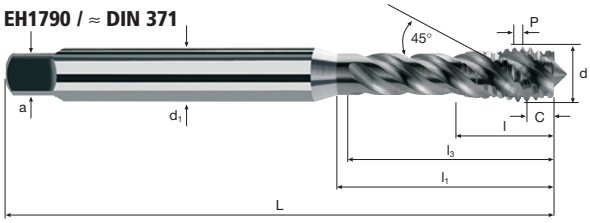
UNF | 2B

60° | HSS PM/F

=DIN 371/374

X · P
Form C

EH1790 / ≈ DIN 371



EH1791 / ≈ DIN 374

Rm < 850	Rm 850-1100

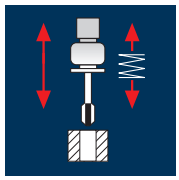
Example: Order-N°. Article-N°. **EH1790** ø-Code **.756**

ø Code	d	P(TPI)	d (mm)	L	l	l1	l3	d1	a			TiCN EH1790
.756	Nr. 6	-40	3.505	56	6	–	18	4.0	3.0	3	2.95	●
.757	Nr. 8	-36	4.166	63	7	–	19	4.5	3.4	3	3.50	●
.758	Nr. 10	-32	4.826	70	8	–	23	6.0	4.9	3	4.10	●
.759	Nr. 12	-28	5.486	80	10	–	28	6.0	4.9	3	4.60	●
.760	1/4	-28	6.350	80	10	30	28	7.0	5.5	3	5.50	●
.761	5/16	-24	7.938	90	13	35	33	8.0	6.2	3	6.90	●
.762	3/8	-24	9.525	100	15	39	37	10.0	8.0	3	8.50	●

Example: Order-N°. Article-N°. **EH1791** ø-Code **.763**

ø Code	d	P(TPI)	d (mm)	L	l	l1	l3	d1	a			TiCN EH1791
.763	7/16	-20	11.113	100	15	39	37	8.0	6.2	4	9.90	●
.764	1/2	-20	12.700	100	15	39	37	9.0	7.0	4	11.50	●
.765	9/16	-18	14.288	100	15	39	37	11.0	9.0	4	12.90	●
.766	5/8	-18	15.875	100	15	39	37	12.0	9.0	4	14.50	●
.767	3/4	-16	19.050	110	17	50	48	14.0	11.0	4	17.50	●
.768	7/8	-14	22.225	125	18	65	63	18.0	14.5	5	20.40	●
.769	1"	-12	25.400	140	24	72	70	18.0	14.5	5	23.30	●

Application



Material	UNF		ø [mm]	P [mm]	v_c 1.5 x d	n [min⁻¹]	v_f [100%]	v_c 2.0 x d	n [min⁻¹]	v_f [100%]	v_c 3.0 x d	n [min⁻¹]	v_f [100%]
Stainless steel ferritc/martensitic	6	-40	3.505	0.635	12	1090	692	10	910	578	8	725	460
	8	-36	4.166	0.706	12	915	646	10	765	540	8	610	430
	10	-32	4.826	0.794	12	790	627	10	660	524	8	530	421
	12	-28	5.486	0.907	12	695	630	10	580	526	8	465	422
	1/4	-28	6.350	0.907	12	600	544	10	500	454	8	400	363
	5/16	-24	7.938	1.058	12	480	508	10	400	423	8	320	339
	3/8	-24	9.525	1.058	12	400	423	10	335	354	8	265	280
	7/16	-20	11.113	1.270	12	345	438	10	285	362	8	230	292
	1/2	-20	12.700	1.270	12	300	381	10	250	318	8	200	254
Stainless steel ferritc/martensitic	9/16	-18	14.288	1.411	12	265	374	10	225	317	8	180	254
	5/8	-18	15.875	1.411	12	240	339	10	200	282	8	160	226
	3/4	-16	19.050	1.588	12	200	318	10	165	262	8	135	214
	7/8	-14	22.225	1.814	12	170	308	10	145	263	8	115	209
	1"	-12	25.400	2.117	12	150	318	10	125	265	8	100	212
Stainless steel [Cr-Ni/1.4301]	6	-40	3.505	0.635	7	635	403	5	455	289	4	365	232
	8	-36	4.166	0.706	7	535	377	5	380	268	4	305	215
	10	-32	4.826	0.794	7	460	365	5	330	262	4	265	210
	12	-28	5.486	0.907	7	405	367	5	290	263	4	230	209
	1/4	-28	6.350	0.907	7	350	317	5	250	227	4	200	181
	5/16	-24	7.938	1.058	7	280	296	5	200	212	4	160	169
	3/8	-24	9.525	1.058	7	235	249	5	165	175	4	135	143
	7/16	-20	11.113	1.270	7	200	254	5	145	184	4	115	146
	1/2	-20	12.700	1.270	7	175	222	5	125	159	4	100	127
Stainless steel [Cr-Ni/1.4301]	9/16	-18	14.288	1.411	7	155	219	5	110	155	4	90	127
	5/8	-18	15.875	1.411	7	140	198	5	100	141	4	80	113
	3/4	-16	19.050	1.588	7	115	183	5	85	135	4	65	103
	7/8	-14	22.225	1.814	7	100	181	5	70	127	4	55	100
	1"	-12	25.400	2.117	7	90	191	5	65	138	4	50	106

Material	UNF		ø [mm]	P [mm]	v_c 1.5 x d	n [min⁻¹]	v_f [100%]	v_c 2.0 x d	n [min⁻¹]	v_f [100%]	v_c 3.0 x d	n [min⁻¹]	v_f [100%]
Stainless steel [Cr-Ni-Mo-…/1.4571]	6	-40	3.505	0.635	8	725	460	6	545	346	5	455	289
	8	-36	4.166	0.706	8	610	430	6	460	325	5	380	268
	10	-32	4.826	0.794	8	530	421	6	395	314	5	330	262
	12	-28	5.486	0.907	8	465	422	6	350	317	5	290	263
	1/4	-28	6.350	0.907	8	400	363	6	300	272	5	250	227
	5/16	-24	7.938	1.058	8	320	339	6	240	254	5	200	212
	3/8	-24	9.525	1.058	8	265	280	6	200	212	5	165	175
	7/16	-20	11.113	1.270	8	230	292	6	170	216	5	145	184
	1/2	-20	12.700	1.270	8	200	254	6	150	191	5	125	159
Stainless steel [Cr-Ni-Mo-…/1.4571]	9/16	-18	14.288	1.411	8	180	254	6	135	190	5	110	155
	5/8	-18	15.875	1.411	8	160	226	6	120	169	5	100	141
	3/4	-16	19.050	1.588	8	135	214	6	100	159	5	85	135
	7/8	-14	22.225	1.814	8	115	209	6	85	154	5	70	127
	1"	-12	25.400	2.117	8	100	212	6	75	159	5	65	138
Heat resistant steel [17-4 PH]	6	-40	3.505	0.635	5	455	289	4	365	232	3	270	171
	8	-36	4.166	0.706	5	380	268	4	305	215	3	230	162
	10	-32	4.826	0.794	5	330	262	4	265	210	3	200	159
	12	-28	5.486	0.907	5	290	263	4	230	209	3	175	159
	1/4	-28	6.350	0.907	5	250	227	4	200	181	3	150	136
	5/16	-24	7.938	1.058	5	200	212	4	160	169	3	120	127
	3/8	-24	9.525	1.058	5	165	175	4	135	143	3	100	106
	7/16	-20	11.113	1.270	5	145	184	4	115	146	3	85	108
	1/2	-20	12.700	1.270	5	125	159	4	100	127	3	75	95
Heat resistant steel [17-4 PH]	9/16	-18	14.288	1.411	5	110	155	4	90	127	3	65	92
	5/8	-18	15.875	1.411	5	100	141	4	80	113	3	60	85
	3/4	-16	19.050	1.588	5	85	135	4	65	103	3	50	79
	7/8	-14	22.225	1.814	5	70	127	4	55	100	3	45	82
	1"	-12	25.400	2.117	5	65	138	4	50	106	3	40	85

Taps

In

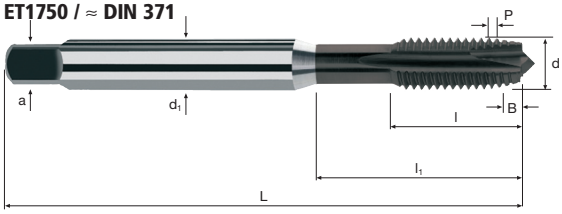
UNF | 2B

60° | HSS PM/F

=DIN 371/374

X · P
Form B

ET1750 / ≈ DIN 371



ET1751 / ≈ DIN 374

Inox
Stainless

Example:
Order-N°. Article-N°. **ET1750** ø-Code **.756**

ø Code	d	P(TPI)	d (mm)	L	l	l1	d1	a			TRIBO ET1750
.756	Nr. 6	-40	3.505	56	12	20	4.0	3.0	3	3.00	●
.757	Nr. 8	-36	4.166	63	13	21	4.5	3.4	3	3.60	●
.758	Nr. 10	-32	4.826	70	15	25	6.0	4.9	3	4.20 *	●
.759	Nr. 12	-28	5.486	80	17	30	6.0	4.9	3	4.70	●
.760	1/4	-28	6.350	80	17	30	7.0	5.5	3	5.60 *	●
.761	5/16	-24	7.938	90	20	35	8.0	6.2	3	7.00	●
.762	3/8	-24	9.525	100	22	39	10.0	8.0	3	8.60	●

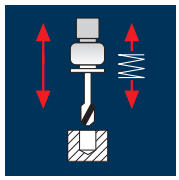
Example:
Order-N°. Article-N°. **ET1751** ø-Code **.763**

ø Code	d	P(TPI)	d (mm)	L	l	l1	d1	a			TRIBO ET1751
.763	7/16	-20	11.113	100	22	39	8.0	6.2	3	10.00	●
.764	1/2	-20	12.700	100	22	39	9.0	7.0	3	11.60	●
.765	9/16	-18	14.288	100	22	39	11.0	9.0	3	13.00	●
.766	5/8	-18	15.875	100	22	39	12.0	9.0	3	14.70 *	●
.767	3/4	-16	19.050	110	25	45	14.0	11.0	4	17.70 *	●
.768	7/8	-14	22.225	125	26	50	18.0	14.5	4	20.70 *	●
.769	1"	-12	25.400	140	32	52	18.0	14.5	4	23.50	●

* The given dimension is out of norm

UN

Application



Material	UNF		ø [mm]	P [mm]	v_c 1.0 x d	n [min⁻¹]	v_f [100%]	v_c 1.5 x d	n [min⁻¹]	v_f [100%]	v_c 2.0 x d	n [min⁻¹]	v_f [100%]
Stainless steel ferritc/martensitic	6	-40	3.505	0.635	10	910	578	8	725	460	6	545	346
	8	-36	4.166	0.706	10	765	540	8	610	430	6	460	325
	10	-32	4.826	0.794	10	660	524	8	530	421	6	395	314
	12	-28	5.486	0.907	10	580	526	8	465	422	6	350	317
	1/4	-28	6.350	0.907	10	500	454	8	400	363	6	300	272
	5/16	-24	7.938	1.058	10	400	423	8	320	339	6	240	254
	3/8	-24	9.525	1.058	10	335	354	8	265	280	6	200	212
	7/16	-20	11.113	1.270	10	285	362	8	230	292	6	170	216
	1/2	-20	12.700	1.270	10	250	318	8	200	254	6	150	191
Stainless steel ferritc/martensitic	9/16	-18	14.288	1.411	10	225	317	8	180	254	6	135	190
	5/8	-18	15.875	1.411	10	200	282	8	160	226	6	120	169
	3/4	-16	19.050	1.588	10	165	262	8	135	214	6	100	159
	7/8	-14	22.225	1.814	10	145	263	8	115	209	6	85	154
	1"	-12	25.400	2.117	10	125	265	8	100	212	6	75	159
Stainless steel [Cr-Ni/1.4301]	6	-40	3.505	0.635	5	455	289	4	365	232	3	270	171
	8	-36	4.166	0.706	5	380	268	4	305	215	3	230	162
	10	-32	4.826	0.794	5	330	262	4	265	210	3	200	159
	12	-28	5.486	0.907	5	290	263	4	230	209	3	175	159
	1/4	-28	6.350	0.907	5	250	227	4	200	181	3	150	136
	5/16	-24	7.938	1.058	5	200	212	4	160	169	3	120	127
	3/8	-24	9.525	1.058	5	165	175	4	135	143	3	100	106
	7/16	-20	11.113	1.270	5	145	184	4	115	146	3	85	108
	1/2	-20	12.700	1.270	5	125	159	4	100	127	3	75	95
Stainless steel [Cr-Ni/1.4301]	9/16	-18	14.288	1.411	5	110	155	4	90	127	3	65	92
	5/8	-18	15.875	1.411	5	100	141	4	80	113	3	60	85
	3/4	-16	19.050	1.588	5	85	135	4	65	103	3	50	79
	7/8	-14	22.225	1.814	5	70	127	4	55	100	3	45	82
	1"	-12	25.400	2.117	5	65	138	4	50	106	3	40	85

Material	UNF		ø [mm]	P [mm]	v_c 1.0 x d	n [min⁻¹]	v_f [100%]	v_c 1.5 x d	n [min⁻¹]	v_f [100%]	v_c 2.0 x d	n [min⁻¹]	v_f [100%]
Stainless steel [Cr-Ni-Mo-…/1.4571]	6	-40	3.505	0.635	6	545	346	5	455	289	4	365	232
	8	-36	4.166	0.706	6	460	325	5	380	268	4	305	215
	10	-32	4.826	0.794	6	395	314	5	330	262	4	265	210
	12	-28	5.486	0.907	6	350	317	5	290	263	4	230	209
	1/4	-28	6.350	0.907	6	300	272	5	250	227	4	200	181
	5/16	-24	7.938	1.058	6	240	254	5	200	212	4	160	169
	3/8	-24	9.525	1.058	6	200	212	5	165	175	4	135	143
	7/16	-20	11.113	1.270	6	170	216	5	145	184	4	115	146
	1/2	-20	12.700	1.270	6	150	191	5	125	159	4	100	127
Stainless steel [Cr-Ni-Mo-…/1.4571]	9/16	-18	14.288	1.411	6	135	190	5	110	155	4	90	127
	5/8	-18	15.875	1.411	6	120	169	5	100	141	4	80	113
	3/4	-16	19.050	1.588	6	100	159	5	85	135	4	65	103
	7/8	-14	22.225	1.814	6	85	154	5	70	127	4	55	100
	1"	-12	25.400	2.117	6	75	159	5	65	138	4	50	106
Heat resistant steel [17-4 PH]	6	-40	3.505	0.635	4	365	232	3	270	171			
	8	-36	4.166	0.706	4	305	215	3	230	162			
	10	-32	4.826	0.794	4	265	210	3	200	159			
	12	-28	5.486	0.907	4	230	209	3	175	159			
	1/4	-28	6.350	0.907	4	200	181	3	150	136			
	5/16	-24	7.938	1.058	4	160	169	3	120	127			
	3/8	-24	9.525	1.058	4	135	143	3	100	106			
	7/16	-20	11.113	1.270	4	115	146	3	85	108			
	1/2	-20	12.700	1.270	4	100	127	3	75	95			
Heat resistant steel [17-4 PH]	9/16	-18	14.288	1.411	4	90	127	3	65	92			
	5/8	-18	15.875	1.411	4	80	113	3	60	85			
	3/4	-16	19.050	1.588	4	65	103	3	50	79			
	7/8	-14	22.225	1.814	4	55	100	3	45	82			
	1"	-12	25.400	2.117	4	50	106	3	40	85			

Taps x-tap

In

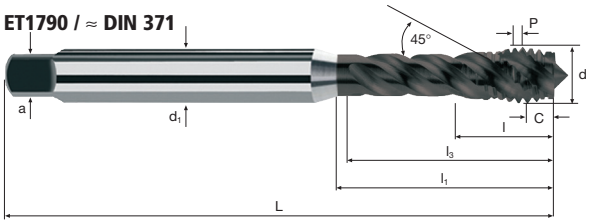
UNF | 2B

60° | HSS PM/F

≈DIN 371/374

X · P Form C

ET1790 / ≈ DIN 371



ET1791 / ≈ DIN 374

Inox Stainless

UN

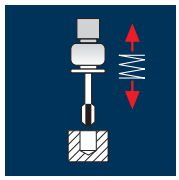
Example: **Order-N°.** Article-N°. **ET1790** ø-Code **.756**

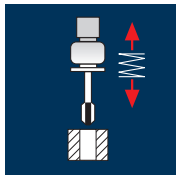
ø Code	d	P(TPI)	d (mm)	L	l	l1	l3	d1	a			TRIBO ET1790
.756	Nr. 6	-40	3.505	56	6	–	18	4.0	3.0	3	3.00	●
.757	Nr. 8	-36	4.166	63	7	–	19	4.5	3.4	3	3.60	●
.758	Nr. 10	-32	4.826	70	8	–	23	6.0	4.9	3	4.20 *	●
.759	Nr. 12	-28	5.486	80	10	–	28	6.0	4.9	3	4.70	●
.760	1/4	-28	6.350	80	10	30	28	7.0	5.5	3	5.60 *	●
.761	5/16	-24	7.938	90	13	35	33	8.0	6.2	3	7.00	●
.762	3/8	-24	9.525	100	15	39	37	10.0	8.0	3	8.60	●

Example: **Order-N°.** Article-N°. **ET1791** ø-Code **.763**

ø Code	d	P(TPI)	d (mm)	L	l	l1	l3	d1	a			TRIBO ET1791
.763	7/16	-20	11.113	100	15	39	37	8.0	6.2	4	10.00	●
.764	1/2	-20	12.700	100	15	39	37	9.0	7.0	4	11.60	●
.765	9/16	-18	14.288	100	15	39	37	11.0	9.0	4	13.00	●
.766	5/8	-18	15.875	100	15	39	37	12.0	9.0	4	14.70 *	●
.767	3/4	-16	19.050	110	17	50	48	14.0	11.0	4	17.70 *	●
.768	7/8	-14	22.225	125	18	65	63	18.0	14.5	5	20.70 *	●
.769	1"	-12	25.400	140	24	72	70	18.0	14.5	5	23.50	●

* The given dimension is out of norm

Application	Material	UNJF		ø [mm]	P [mm]	v_c 1.0 x d	n [min⁻¹]	v_f [100%]	v_c 1.5 x d	n [min⁻¹]	v_f [100%]
	Nickel base alloys not hardened	6	-40	3.505	0.635	3	270	171	2	180	114
		8	-36	4.166	0.706	3	230	162	2	155	109
		10	-32	4.826	0.794	3	200	159	2	130	103
		1/4	-28	6.350	0.907	3	150	136	2	100	91
		5/16	-24	7.938	1.058	3	120	127	2	80	85
		3/8	-24	9.525	1.058	3	100	106	2	65	69
	Nickel base alloys hardened	6	-40	3.505	0.635	2	180	114	2	180	114
		8	-36	4.166	0.706	2	155	109	2	155	109
		10	-32	4.826	0.794	2	130	103	2	130	103
		1/4	-28	6.350	0.907	2	100	91	2	100	91
		5/16	-24	7.938	1.058	2	80	85	2	80	85
		3/8	-24	9.525	1.058	2	65	69	2	65	69

Application	Material	UNJF		ø [mm]	P [mm]	v_c 1.0 x d	n [min⁻¹]	v_f [100%]	v_c 1.5 x d	n [min⁻¹]	v_f [100%]
	Nickel base alloys not hardened	6	-40	3.505	0.635	3	270	171	2	180	114
		8	-36	4.166	0.706	3	230	162	2	155	109
		10	-32	4.826	0.794	3	200	159	2	130	103
		1/4	-28	6.350	0.907	3	150	136	2	100	91
		5/16	-24	7.938	1.058	3	120	127	2	80	85
		3/8	-24	9.525	1.058	3	100	106	2	65	69
	Nickel base alloys hardened	6	-40	3.505	0.635	2	180	114	2	180	114
		8	-36	4.166	0.706	2	155	109	2	155	109
		10	-32	4.826	0.794	2	130	103	2	130	103
		1/4	-28	6.350	0.907	2	100	91	2	100	91
		5/16	-24	7.938	1.058	2	80	85	2	80	85
		3/8	-24	9.525	1.058	2	65	69	2	65	69

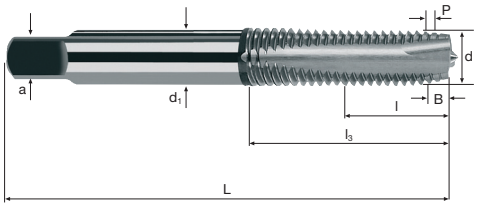
Taps

Ni

UNJF | 3B

60° | HSS PM/F

X · P | Form B



Nickel-Alloys

Example:
Order-N°. Article-N°. **E1799** ø-Code **.756**

ø Code	d	P(TPI)	d (mm)	L	l	l1	l3	d1	a			E1799
.756	Nr. 6	-40	3.505	50	12	–	18	4.0	3.0	3	3.05	●
.757	Nr. 8	-36	4.166	53	13	–	19	4.5	3.4	3	3.60	●
.758	Nr. 10	-32	4.826	58	15	–	22	6.0	4.9	3	4.20	●
.760	1/4	-28	6.350	66	17	–	28	7.0	5.5	3	5.60	●
.761	5/16	-24	7.938	72	20	–	34	8.0	6.2	3	7.10	●
.762	3/8	-24	9.525	80	22	–	37	10.0	8.0	3	8.70 *	●

* The given dimension is out of norm

UN

passion
for precision

fraisa