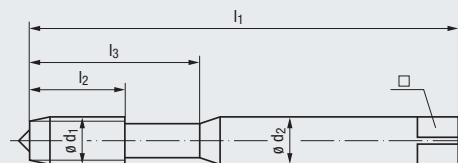
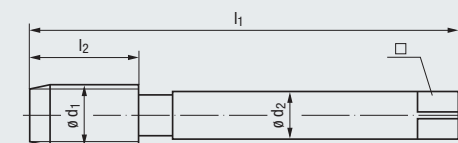


DIN Length • ANSI Shank

Overall length acc. to DIN 2174



Reinforced Shank
(No.0 - 3/8)



Reduced Shank
(7/16 - 7/8)



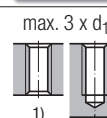
Unified Fine Thread
ASME B1.1

Class of Fit
Coating
Cutting Material
Technical Characteristics



Thread Depth
and Hole Shape

Applications – Material



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

Reinforced Shank

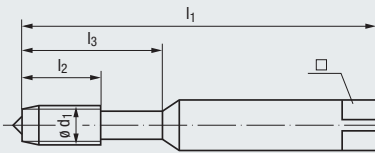
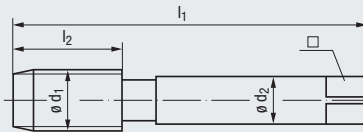
Nominal Size ø d ₁	T.P.I.	l ₁	l ₂	inch l ₃	ø d ₂	□	Tool Identification		BU44Z700	BU38Z800	BU44Z800
								Dimens. ID			
No. 0	80	1.626	0.157	0.433	0.141	0.110		.5033			
No. 1	72	1.772	0.157	0.472	0.141	0.110		.5034			
No. 2	64	1.772	0.177	0.472	0.141	0.110		.5035			
No. 3	56	1.969	0.197	0.551	0.141	0.110		.5036			
No. 4	48	2.205	0.236	0.709	0.141	0.110		.5037			
No. 5	44	2.205	0.276	0.709	0.141	0.110		.5038			
No. 6	40	2.205	0.276	0.787	0.141	0.110		.5039			
No. 8	36	2.480	0.315	0.827	0.168	0.131		.5040			
No. 10	32	2.756	0.394	0.984	0.194	0.152		.5041	●	●	●
No. 12	28	3.150	0.394	1.142	0.220	0.165		.5042	●	●	●
1/4	28	3.150	0.394	1.181	0.255	0.191		.5043	●	●	●
5/16	24	3.543	0.394	1.260	0.318	0.238		.5044	●	●	●
3/8	24	3.937	0.394	1.535	0.381	0.286		.5045	●	●	●

Reduced Shank

Nominal Size ø d ₁	T.P.I.	l ₁	l ₂	inch l ₃	ø d ₂	□	Tool Identification		CU44Z700		
								Dimens. ID			
7/16	20	3.937	0.512	—	0.323	0.242		.5046	●		
1/2	20	3.937	0.512	—	0.367	0.275		.5047	●		
9/16	18	3.937	0.591	—	0.429	0.322		.5048	●		
5/8	18	3.937	0.591	—	0.480	0.360		.5049	●		
3/4	16	4.331	0.669	—	0.590	0.442		.5050	●		
7/8	14	4.921	0.669	—	0.697	0.523		.5051	●		

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
MaterialsReinforced Shank
(No. 6 - 3/8)Reduced Shank
(7/16 - 3/4)

UNF

Unified Fine Thread
ASME B1.1Class of Fit
Coating
Cutting Material
Technical CharacteristicsThread Depth
and Hole Shape

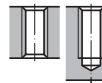
2BX

TIN

HSS Extra

C / 2-3

E / O / P

max. 3 x d₁

Applications – Material

P 1.1-3.1

M 1.1-2.1 2)

N 1.4-5, 2.1-2

Tool Identification

AU921400

Druck
STEEL-SN
TIN

Nominal Size ø d ₁	T.P.I.	l ₁		l ₂		l ₃		inch ø d ₂	□	Dimens. ID					
No. 6	40	2	2.00	0.472	0.748	0.141	0.110	0.1268		.5039	●				
No. 8	36	2 1/8	2.13	0.512	0.827	0.168	0.131	0.1516		.5040	●				
No. 10	32	2 3/8	2.38	0.591	0.945	0.194	0.152	0.1752		.5041	●				
1/4	28	2 1/2	2.50	0.669	1.142	0.255	0.191	0.2343		.5043	●				
5/16	24	2 23/32	2.72	0.669	1.299	0.318	0.238	0.2933		.5044	●				
3/8	24	2 15/16	2.94	0.709	1.378	0.381	0.286	0.3563		.5045	●				
7/16	20	3 5/32	3.16	0.866	—	0.323	0.242	0.4154		.5046	●				
1/2	20	3 3/8	3.38	0.866	—	0.367	0.275	0.4783		.5047	●				
9/16	18	3 19/32	3.59	0.866	—	0.429	0.322	0.5374		.5048	●				
5/8	18	3 13/16	3.81	0.866	—	0.480	0.360	0.6004		.5049	●				
3/4	16	4 1/4	4.25	0.984	—	0.590	0.442	0.7224		.5050	●				

1) Cold-forming in through holes is possible only with external cooling/lubrication

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.