**UNJ Thread Taps**

**for Nickel and Titanium Alloys**

**SPECIAL TOOLING SOLUTIONS**

**MOdULAr TOOLING SySTEMS**

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**REAMING PCd/PCBNTAPPING/THrEAd- MILLING/FLUTELESS TAPPING**

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**SFM recommendations for cut taps**

<table>
<thead>
<tr>
<th>Material</th>
<th>Approximate Hardness</th>
<th>HSS-E_PM, Hard Coated</th>
</tr>
</thead>
<tbody>
<tr>
<td>Titanium Alloys</td>
<td>140 - 275 Brinnel</td>
<td>20 - 30 sfm</td>
</tr>
<tr>
<td></td>
<td>300 - 340 Brinnel</td>
<td>10 - 20 sfm</td>
</tr>
<tr>
<td>Nickel Alloys</td>
<td>200 - 300 Brinnel</td>
<td>10 - 20 sfm</td>
</tr>
<tr>
<td></td>
<td>&gt; 300 Brinnel</td>
<td>6 - 12 sfm</td>
</tr>
</tbody>
</table>

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**External UNJ threads must be produced with a prescribed root radius; therefore, standard Unified Screw Thread (UN) tooling may not be used.**

**Internal UNJ threads are not required to have a root radius; therefore, ground thread taps designed to produce Unified Screw Threads of the proper class of fit may be used. The letter “J” need not be marked on the tap. The larger product minor diameter of the UNJ internal thread requires the use of a larger tap drill than is used when producing Unified Screw Threads.**

**UNJ INTERNAL THREAD**

Root to clear 0.125P width-flat or rounded. Assemblies with all UN external threads.

**UNJ classes 3B and 3BG No radius required on internal threads.**

**UNJ EXTERNAL THREAD**

Assemblies only with UNJ Internal.

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The new GÜHROSync tapping chuck

Synchro and hydraulic clamping technology intelligently combined.

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