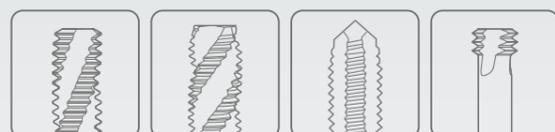




Leading Through Innovation



Global Cutting Tool Leader **YG-1**



SOLID CARBIDE & HSS-E

THREADING

YG TAP CAST IRON
YG TAP CAST IRON

- For Cast Iron or Similar Work Materials
- Für Gusseisen oder ähnliche Werkstoffe



SOLID CARBIDE & HSS-E YG TAP CAST IRON

For Cast Iron or Similar Work Materials

HOLE TYPE		Max. 2.0xD Blind / Through Hole				
TOOL MATERIAL		CARBIDE		HSS-E		
CHAMFER LEAD ACC. TO DIN2197		C	C	C	C	C
FLUTE TYPE		Straight Flute	Straight Flute	Straight Flute	Straight Flute	Straight Flute
SPIRAL FLUTE ANGLE		-	-	-	-	-
M	DIN371/376	T0993 (P.229)	TE821 (P.230)	TD821 (P.231)	TI821 (P.232)	TY821 (P.233)
	DIN352					
MF	DIN357/LONG					
	DIN374		TE403 (P.234)			
UNC	DIN2181					
	DIN371/376		TE434 (P.235)			
UNF	DIN351					
	DIN371/374		TE454 (P.236)			
BSW	DIN2182/2183					
	DIN351					
G(BSP)	DIN5156/5157					
EG-M	DIN371/376					
EG-UNC	DIN371/376					
EG-UNF	DIN371/374					

SURFACE TREATMENT		Bright	NI	TIN	TICN	TiAIN
MODEL						

Please visit globalyg1.com/mat for material search
 ◎ : Excellent ○ : Good
 Recommended cutting conditions : P.237

ISO	VDI 3323	Material Description	Composition / Structure / Heat Treatment	HB	HRc	Bright	NI	TIN	TICN	TiAIN	
P	1	Non-alloy steel	About 0.15% C	Annealed	125						
	2		About 0.45% C	Annealed	190						
	3		About 0.45% C	Quenched & Tempered	250						
	4		About 0.75% C	Annealed	270						
	5	About 0.75% C	Quenched & Tempered	300							
	6	Low alloy steel	Annealed	180	10						
	7		Quenched & Tempered	275	29						
	8		Quenched & Tempered	300	32						
	9		Quenched & Tempered	350	38						
	10		High alloyed steel, and tool steel	Annealed	200	15					
	11	Quenched & Tempered	325	35							
M	12	Stainless steel	Ferritic / Martensitic	Annealed	200	15					
	13		Martensitic	Quenched & Tempered	240	23					
	14	Austenitic	180	10							
K	15	Grey cast iron	Pearlitic / ferritic	180	10	◎	◎	◎	◎	◎	
	16		Pearlitic (Martensitic)	260	26	◎	◎	◎	◎	◎	
	17	Nodular cast iron	Ferritic	160	3	◎	◎	◎	◎	◎	
	18		Pearlitic	250	25	◎	◎	◎	◎	◎	
	19		Ferritic	130	25	○	○	○	○	○	
20	Malleable cast iron	Pearlitic	230	21	○	○	○	○	○		
N	21	Aluminum-wrought alloy	Not Curable	60							
	22		Curable	Hardened	100						
	23	Aluminum-cast, alloyed	≤ 12% Si, Not Curable	75		◎					
	24		≤ 12% Si, Curable	Hardened	90						
	25		> 12% Si, Not Curable	130		◎					
	26	Copper and Copper Alloys (Bronze / Brass)	Cutting Alloys, PB>1%	110							
	27		CuZn, CuSnZn (Brass)	90							
	28		CuSn, lead-free copper and electrolytic copper	100				○	◎	◎	◎
	29		Non Metallic Materials	Duroplastic, Fiber Reinforced Plastic							
	30	Rubber, Wood, etc.									
S	31	Heat Resistant Super Alloys	Fe Based	Annealed	200	15					
	32		Cured	280	30						
	33		Annealed	250	25						
	34	Titanium Alloys	Ni or Co Based	Cured	350	38					
	35		Cast	320	34						
36	Pure Titanium	400 Rm									
37	Alpha + Beta Alloys	Hardened	1050 Rm								
H	38	Hardened steel	Hardened	550	55						
	39		Hardened	630	60						
	40	Chilled Cast Iron	Cast	400	42	◎					
41	Hardened Cast Iron	Hardened	550	55							

YG TAP CAST IRON

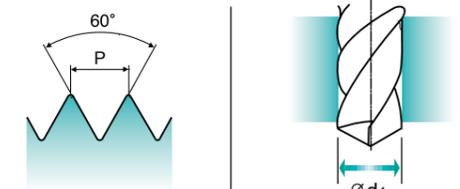
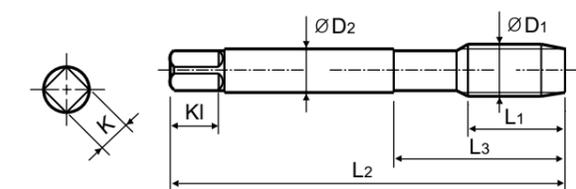
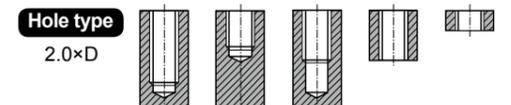
T0993 SERIES

ISO metric coarse threads DIN 13

- Metrisches ISO-Gewinde DIN 13
- ISO MÉTRIQUE DIN13
- ISO Metrico passo grosso DIN 13

Carbide tap can increase tool life longer than HSS taps due to higher hardness. Suitable for cast iron and high silicon aluminiums.

Der VHM-Gewindebohrer kann die Lebensdauer gegenüber HSS-Gewindebohrern erhöhen dank der größeren Härte. Geeignet für Guss und Aluminium mit hohem Siliziumanteil



Material groups: **GG** CARBIDE DIN 371/376 6HX 60° C Bright

Machine taps Maschinengewindebohrer

Recommended Cutting Page : P.237 Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1	P	Bright	L1	L2	L3	ØD2	K	KI	Z	Ød1
M3 × 0.5		T0993206	11	56	18	3.5	2.7	6	3	2.5
M3.5 × 0.6		T0993226	12	56	20	4	3	6	3	2.9
M4 × 0.7		T0993246	13	63	21	4.5	3.4	6	3	3.3
M5 × 0.8		T0993286	15	70	25	6	4.9	8	4	4.2
M6 × 1		T0993316	17	80	30	6	4.9	8	4	5
M8 × 1.25		T0993366	20	90	35	8	6.2	9	4	6.8
M10 × 1.5		T0993426	22	100	39	10	8	11	4	8.5
M12 × 1.75		T0993506	24	110	44	9	7	10	4	10.2
M14 × 2		T0993546	26	110	44	11	9	12	4	12
M16 × 2		T0993606	27	110	44	12	9	12	4	14
M18 × 2.5		T0993656	30	125	50	14	11	14	4	15.5
M20 × 2.5		T0993706	32	140	54	16	12	15	4	17.5

►DIN 371(M2~M10) and DIN 376(M11~M20)

◎ : Excellent ○ : Good

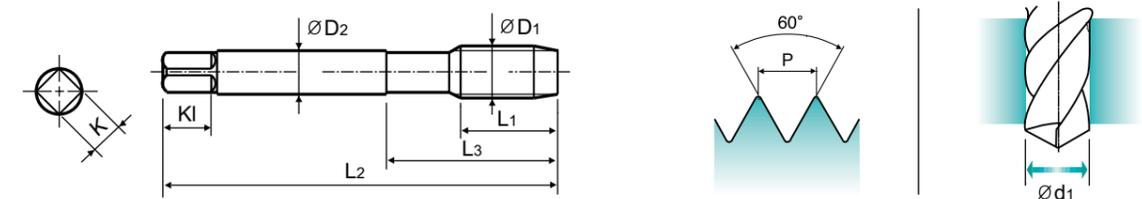
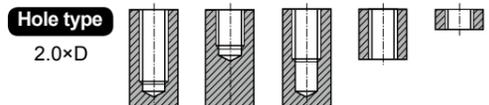
ISO	P										M				K							
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel		Stainless steel		Grey cast iron		Nodular cast iron		Malleable cast iron			
Material Description	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20		
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20		
HRc	125	13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25	21			
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230		
Recommended															◎	◎	◎	◎	○	○		
ISO	N									S						H						
	Aluminum-wrought alloy			Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials			Heat Resistant Super Alloys			Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron		
Material Description	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	
HRc	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550	
HB																						
Recommended			◎		◎																◎	

M ISO metric coarse threads DIN 13

- Metrisches ISO-Gewinde DIN 13
- ISO MÉTRIQUE DIN13
- ISO Metrico passo grosso DIN 13

► Suitable for tapping cast iron or similar work materials.

► Geeignet zum Gewindeschneiden von Guss oder ähnlichen Werkstoffen



Material groups **GG** **HSS-E** **DIN 371/376** **6HX** **60°** **C** **NI** **Machine taps Maschinengewindebohrer**

Recommended Cutting Page : P.237 Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1	P	NI	L1	L2	L3	ØD2	K	KI	Z	Ød1
M2 × 0.4		TE821136	8	45	13	2.8	2.1	5	3	1.6
M2.2 × 0.45		TE821156	8	45	13	2.8	2.1	5	3	1.75
*M2.3 × 0.4		TE821196	8	45	13	2.8	2.1	5	3	1.9
M2.5 × 0.45		TE821176	9	50	15	2.8	2.1	5	3	2.05
*M2.6 × 0.45		TE821496	9	50	15	2.8	2.1	5	3	2.1
M3 × 0.5		TE821206	11	56	18	3.5	2.7	6	3	2.5
M3.5 × 0.6		TE821226	12	56	20	4	3	6	3	2.9
M4 × 0.7		TE821246	13	63	21	4.5	3.4	6	3	3.3
M4.5 × 0.75		TE821266	14	70	25	6	4.9	8	3	3.7
M5 × 0.8		TE821286	15	70	25	6	4.9	8	4	4.2
M6 × 1		TE821316	17	80	30	6	4.9	8	4	5
M7 × 1		TE821346	17	80	30	7	5.5	8	4	6
M8 × 1.25		TE821366	20	90	35	8	6.2	9	4	6.8
M9 × 1.25		TE821396	20	90	35	9	7	10	4	7.8
M10 × 1.5		TE821426	22	100	39	10	8	11	4	8.5
M11 × 1.5		TE821466	22	100	40	8	6.2	9	4	9.5
M12 × 1.75		TE821506	24	110	44	9	7	10	4	10.2
M14 × 2		TE821546	26	110	44	11	9	12	4	12
M16 × 2		TE821606	27	110	44	12	9	12	4	14
M18 × 2.5		TE821656	30	125	50	14	11	14	4	15.5
M20 × 2.5		TE821706	32	140	54	16	12	15	4	17.5
M22 × 2.5		TE821746	32	140	54	18	14.5	17	4	19.5
M24 × 3		TE821786	34	160	60	18	14.5	17	4	21
M27 × 3		TE821866	36	160	60	20	16	19	4	24
M30 × 3.5		TE821946	40	180	70	22	18	21	4	26.5

► DIN 371(M2~M10) and DIN 376(M11~M30)

► * DIN profile not ISO

◎ : Excellent ○ : Good

ISO Material Description	P										M				K					
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel		Stainless steel		Grey cast iron	Nodular cast iron	Malleable cast iron			
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc	13	25	28	32	30	10	29	32	38	15	35	15	23	10	10	26	3	25	21	21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended															◎	◎	◎	◎	○	○

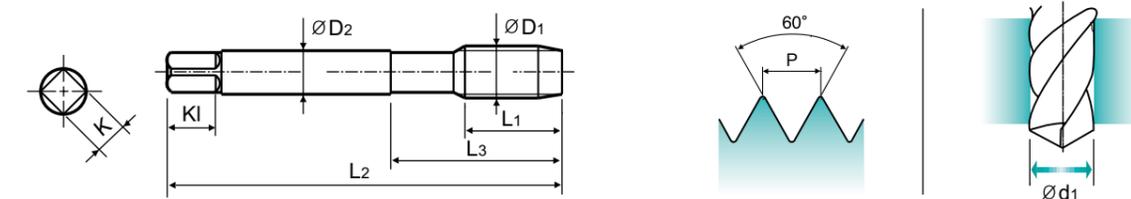
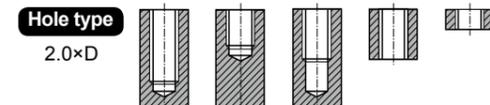
ISO Material Description	N					S					H										
	Aluminum-wrought alloy		Aluminum-cast, alloyed		Copper and Copper Alloys (Bronze / Brass)	Non Metallic Materials		Heat Resistant Super Alloys			Titanium Alloys	Hardened steel	Chilled Cast Iron	Hardened Cast Iron							
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc	21	22	23	24	25	26	27	28	29	30	15	30	25	38	34	55	60	42	42	55	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550
Recommended																					○

M ISO metric coarse threads DIN 13

- Metrisches ISO-Gewinde DIN 13
- ISO MÉTRIQUE DIN13
- ISO Metrico passo grosso DIN 13

► Suitable for tapping cast iron or similar work materials.

► Geeignet zum Gewindeschneiden von Guss oder ähnlichen Werkstoffen



Material groups **GG** **HSS-E** **DIN 371/376** **6HX** **60°** **C** **TiN** **Machine taps Maschinengewindebohrer**

Recommended Cutting Page : P.237 Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1	P	TiN	L1	L2	L3	ØD2	K	KI	Z	Ød1
M2 × 0.4		TD821136	8	45	13	2.8	2.1	5	3	1.6
M2.2 × 0.45		TD821156	8	45	13	2.8	2.1	5	3	1.75
*M2.3 × 0.4		TD821196	8	45	13	2.8	2.1	5	3	1.9
M2.5 × 0.45		TD821176	9	50	15	2.8	2.1	5	3	2.05
*M2.6 × 0.45		TD821496	9	50	15	2.8	2.1	5	3	2.1
M3 × 0.5		TD821206	11	56	18	3.5	2.7	6	3	2.5
M3.5 × 0.6		TD821226	12	56	20	4	3	6	3	2.9
M4 × 0.7		TD821246	13	63	21	4.5	3.4	6	3	3.3
M4.5 × 0.75		TD821266	14	70	25	6	4.9	8	3	3.7
M5 × 0.8		TD821286	15	70	25	6	4.9	8	4	4.2
M6 × 1		TD821316	17	80	30	6	4.9	8	4	5
M7 × 1		TD821346	17	80	30	7	5.5	8	4	6
M8 × 1.25		TD821366	20	90	35	8	6.2	9	4	6.8
M9 × 1.25		TD821396	20	90	35	9	7	10	4	7.8
M10 × 1.5		TD821426	22	100	39	10	8	11	4	8.5
M11 × 1.5		TD821466	22	100	40	8	6.2	9	4	9.5
M12 × 1.75		TD821506	24	110	44	9	7	10	4	10.2
M14 × 2		TD821546	26	110	44	11	9	12	4	12
M16 × 2		TD821606	27	110	44	12	9	12	4	14
M18 × 2.5		TD821656	30	125	50	14	11	14	4	15.5
M20 × 2.5		TD821706	32	140	54	16	12	15	4	17.5
M22 × 2.5		TD821746	32	140	54	18	14.5	17	4	19.5
M24 × 3		TD821786	34	160	60	18	14.5	17	4	21
M27 × 3		TD821866	36	160	60	20	16	19	4	24
M30 × 3.5		TD821946	40	180	70	22	18	21	4	26.5

► DIN 371(M2~M10) and DIN 376(M11~M30)

► * DIN profile not ISO

◎ : Excellent ○ : Good

ISO Material Description	P										M				K					
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel		Stainless steel		Grey cast iron	Nodular cast iron	Malleable cast iron			
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc	13	25	28	32	30	10	29	32	38	15	35	15	23	10	10	26	3	25	21	21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended															◎	◎	◎	◎	○	○

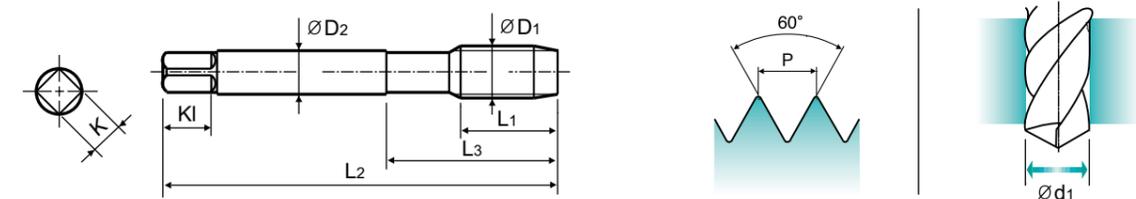
ISO Material Description	N					S					H										
	Aluminum-wrought alloy		Aluminum-cast, alloyed		Copper and Copper Alloys (Bronze / Brass)	Non Metallic Materials		Heat Resistant Super Alloys			Titanium Alloys	Hardened steel	Chilled Cast Iron	Hardened Cast Iron							
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc	21	22	23	24	25	26	27	28	29	30	15	30	25	38	34	55	60	42	42	55	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550
Recommended																					◎

M ISO metric coarse threads DIN 13

- Metrisches ISO-Gewinde DIN 13
- ISO MÉTRIQUE DIN13
- ISO Metrico passo grosso DIN 13

► Suitable for tapping cast iron or similar work materials.

► Geeignet zum Gewindeschneiden von Guss oder ähnlichen Werkstoffen



GG HSS-E DIN 371/376 6HX 60° C TICN Machine taps Maschinengewindebohrer

Recommended Cutting Page : P.237 Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1	P	TiCN	L1	L2	L3	ØD2	K	KI	Z	Ød1
M2 × 0.4		TI821136	8	45	13	2.8	2.1	5	3	1.6
M2.2 × 0.45		TI821156	8	45	13	2.8	2.1	5	3	1.75
*M2.3 × 0.4		TI821196	8	45	13	2.8	2.1	5	3	1.9
M2.5 × 0.45		TI821176	9	50	15	2.8	2.1	5	3	2.05
*M2.6 × 0.45		TI821496	9	50	15	2.8	2.1	5	3	2.1
M3 × 0.5		TI821206	11	56	18	3.5	2.7	6	3	2.5
M3.5 × 0.6		TI821226	12	56	20	4	3	6	3	2.9
M4 × 0.7		TI821246	13	63	21	4.5	3.4	6	3	3.3
M4.5 × 0.75		TI821266	14	70	25	6	4.9	8	3	3.7
M5 × 0.8		TI821286	15	70	25	6	4.9	8	4	4.2
M6 × 1		TI821316	17	80	30	6	4.9	8	4	5
M7 × 1		TI821346	17	80	30	7	5.5	8	4	6
M8 × 1.25		TI821366	20	90	35	8	6.2	9	4	6.8
M9 × 1.25		TI821396	20	90	35	9	7	10	4	7.8
M10 × 1.5		TI821426	22	100	39	10	8	11	4	8.5
M11 × 1.5		TI821466	22	100	40	8	6.2	9	4	9.5
M12 × 1.75		TI821506	24	110	44	9	7	10	4	10.2
M14 × 2		TI821546	26	110	44	11	9	12	4	12
M16 × 2		TI821606	27	110	44	12	9	12	4	14
M18 × 2.5		TI821656	30	125	50	14	11	14	4	15.5
M20 × 2.5		TI821706	32	140	54	16	12	15	4	17.5
M22 × 2.5		TI821746	32	140	54	18	14.5	17	4	19.5
M24 × 3		TI821786	34	160	60	18	14.5	17	4	21
M27 × 3		TI821866	36	160	60	20	16	19	4	24
M30 × 3.5		TI821946	40	180	70	22	18	21	4	26.5

► DIN 371(M2~M10) and DIN 376(M11~M30)

► * DIN profile not ISO

◎ : Excellent ○ : Good

ISO Material Description	P										M				K					
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel		Stainless steel		Grey cast iron	Nodular cast iron		Malleable cast iron		
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc	13	25	28	32	30	10	29	32	38	15	35	15	23	10	10	26	3	25	21	
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended															◎	◎	◎	◎	○	○

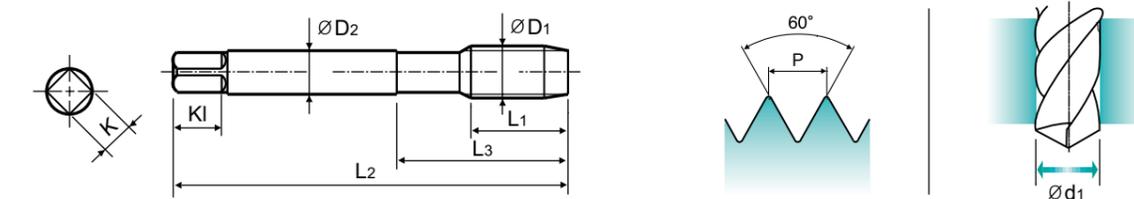
ISO Material Description	N					S					H										
	Aluminum-wrought alloy		Aluminum-cast, alloyed		Copper and Copper Alloys (Bronze / Brass)	Non Metallic Materials		Heat Resistant Super Alloys			Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron						
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc	21	22	23	24	25	26	27	28	29	30	15	30	25	38	34	55	60	42	42	55	
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550
Recommended																					◎

M ISO metric coarse threads DIN 13

- Metrisches ISO-Gewinde DIN 13
- ISO MÉTRIQUE DIN13
- ISO Metrico passo grosso DIN 13

► Suitable for tapping cast iron or similar work materials.

► Geeignet zum Gewindeschneiden von Guss oder ähnlichen Werkstoffen



GG HSS-E DIN 371/376 6HX 60° C TiAlN Machine taps Maschinengewindebohrer

Recommended Cutting Page : P.237 Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1	P	TiAlN	L1	L2	L3	ØD2	K	KI	Z	Ød1
M2 × 0.4		TY821136	8	45	13	2.8	2.1	5	3	1.6
M2.2 × 0.45		TY821156	8	45	13	2.8	2.1	5	3	1.75
*M2.3 × 0.4		TY821196	8	45	13	2.8	2.1	5	3	1.9
M2.5 × 0.45		TY821176	9	50	15	2.8	2.1	5	3	2.05
*M2.6 × 0.45		TY821496	9	50	15	2.8	2.1	5	3	2.1
M3 × 0.5		TY821206	11	56	18	3.5	2.7	6	3	2.5
M3.5 × 0.6		TY821226	12	56	20	4	3	6	3	2.9
M4 × 0.7		TY821246	13	63	21	4.5	3.4	6	3	3.3
M4.5 × 0.75		TY821266	14	70	25	6	4.9	8	3	3.7
M5 × 0.8		TY821286	15	70	25	6	4.9	8	4	4.2
M6 × 1		TY821316	17	80	30	6	4.9	8	4	5
M7 × 1		TY821346	17	80	30	7	5.5	8	4	6
M8 × 1.25		TY821366	20	90	35	8	6.2	9	4	6.8
M9 × 1.25		TY821396	20	90	35	9	7	10	4	7.8
M10 × 1.5		TY821426	22	100	39	10	8	11	4	8.5
M11 × 1.5		TY821466	22	100	40	8	6.2	9	4	9.5
M12 × 1.75		TY821506	24	110	44	9	7	10	4	10.2
M14 × 2		TY821546	26	110	44	11	9	12	4	12
M16 × 2		TY821606	27	110	44	12	9	12	4	14
M18 × 2.5		TY821656	30	125	50	14	11	14	4	15.5
M20 × 2.5		TY821706	32	140	54	16	12	15	4	17.5
M22 × 2.5		TY821746	32	140	54	18	14.5	17	4	19.5
M24 × 3		TY821786	34	160	60	18	14.5	17	4	21
M27 × 3		TY821866	36	160	60	20	16	19	4	24
M30 × 3.5		TY821946	40	180	70	22	18	21	4	26.5

► DIN 371(M2~M10) and DIN 376(M11~M30)

► * DIN profile not ISO

◎ : Excellent ○ : Good

ISO Material Description	P										M				K					
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel		Stainless steel		Grey cast iron	Nodular cast iron		Malleable cast iron		
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc	13	25	28	32	30	10	29	32	38	15	35	15	23	10	10	26	3	25	21	
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended															◎	◎	◎	◎	○	○

ISO Material Description	N					S					H										
	Aluminum-wrought alloy		Aluminum-cast, alloyed		Copper and Copper Alloys (Bronze / Brass)	Non Metallic Materials		Heat Resistant Super Alloys			Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron						
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc	21	22	23	24	25	26	27	28	29	30	15	30	25	38	34	55	60	42	42	55	
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550
Recommended																					◎

YG TAP CAST IRON

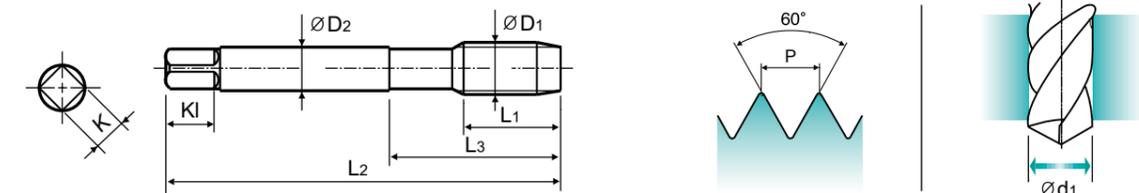
TE403 SERIES

MF ISO metric fine threads DIN 13

● Metrisches ISO-Feingewinde DIN 13
● ISO MÉTRIQUE PAS FINS DIN13
● ISO Metrico passo fine DIN 13

► Suitable for tapping cast iron or similar work materials due to nitriding.

► Geeignet zum Gewindeschneiden von Guss oder ähnlichen Werkstoffen dank der Nitrierung



Material groups: **GG** HSS-E DIN 374 6HX 60° C NI

Machine taps
Maschinengewindebohrer

Recommended Cutting Page : P.237 Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1	P	Ni	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M4	× 0.5	TE403256	10	63	21	2.8	2.1	5	3	3.5
M5	× 0.5	TE403296	11	70	25	3.5	2.7	6	4	4.5
M6	× 0.75	TE403326	13	80	30	4.5	3.4	6	4	5.2
M6	× 0.5	TE403336	13	80	30	4.5	3.4	6	4	5.5
M7	× 0.75	TE403356	14	80	30	5.5	4.3	7	4	6.2
M8	× 1	TE403376	17	90	36	6	4.9	8	4	7
M8	× 0.75	TE403386	14	80	30	6	4.9	8	4	7.2
M10	× 1.25	TE403436	22	100	40	7	5.5	8	4	8.8
M10	× 1	TE403446	18	90	36	7	5.5	8	4	9
M10	× 0.75	TE403456	18	90	36	7	5.5	8	4	9.2
M12	× 1.5	TE403516	22	100	40	9	7	10	4	10.5
M12	× 1.25	TE403526	22	100	40	9	7	10	4	10.8
M12	× 1	TE403536	18	100	40	9	7	10	4	11
M14	× 1.5	TE403556	22	100	40	11	9	12	4	12.5
M14	× 1.25	TE403566	22	100	40	11	9	12	4	12.8
M16	× 1.5	TE403616	22	100	40	12	9	12	4	14.5
M18	× 1.5	TE403676	25	110	44	14	11	14	4	16.5
M20	× 1.5	TE403726	25	125	50	16	12	15	4	18.5
M22	× 1.5	TE403766	25	125	50	18	14.5	17	4	20.5
M24	× 1.5	TE403806	27	140	54	18	14.5	17	4	22.5

◎ : Excellent ○ : Good

ISO Material Description	P					M				K										
	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel		Grey cast iron	Nodular cast iron		Malleable cast iron			
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc	13	25	28	32	30	10	29	32	38	15	35	15	23	10	10	26	3	25	21	21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended															◎	◎	◎	◎	○	○

ISO Material Description	N					S					H											
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)		Non Metallic Materials			Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron		
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	
HRc											15	30	25	38	34			55	60	42	55	
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550	
Recommended																						○

YG TAP CAST IRON

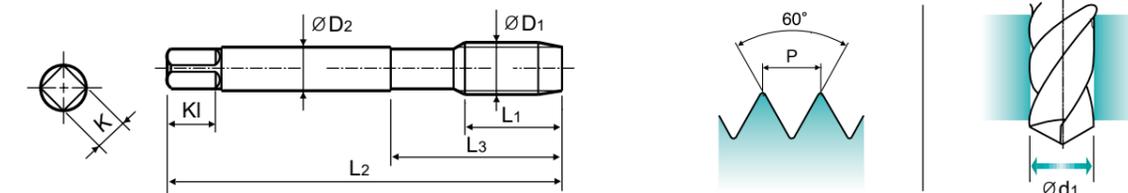
TE434 SERIES

UNC Unified coarse threads

● Unified Grobgewinde
● UNC
● Unificato passo grosso

► Suitable for tapping cast iron or similar work materials due to nitriding.

► Geeignet zum Gewindeschneiden von Guss oder ähnlichen Werkstoffen dank der Nitrierung



Material groups: **GG** HSS-E DIN 371/376 2BX 60° C NI

Machine taps
Maschinengewindebohrer

Recommended Cutting Page : P.237 Unit : mm

SIZE	TPI	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1		Ni	L1	L2	L3	ØD2	K	Kl	Z	Ød1
#4	- 40UNC	TE434162	11	56	18	3.5	2.7	6	3	2.3
#5	- 40UNC	TE434202	11	56	18	3.5	2.7	6	3	2.6
#6	- 32UNC	TE434242	12	56	20	4	3	6	3	2.85
#8	- 32UNC	TE434282	13	63	21	4.5	3.4	6	3	3.5
#10	- 24UNC	TE434322	15	70	25	6	4.9	8	3	3.9
#12	- 24UNC	TE434362	16	80	30	6	4.9	8	3	4.5
1/4	- 20UNC	TE434402	17	80	30	7	5.5	8	4	5.2
5/16	- 18UNC	TE434442	20	90	35	8	6.2	9	4	6.6
3/8	- 16UNC	TE434482	22	100	39	9	7	10	4	8
7/16	- 14UNC	TE434522	22	100	40	8	6.2	9	4	9.4
1/2	- 13UNC	TE434562	25	110	44	9	7	10	4	10.75
9/16	- 12UNC	TE434602	26	110	44	11	9	12	4	12.25
5/8	- 11UNC	TE434642	27	110	44	12	9	12	4	13.5
3/4	- 10UNC	TE434702	30	125	50	14	11	14	4	16.5
7/8	- 9UNC	TE434742	32	140	54	18	14.5	17	4	19.5
1	- 8UNC	TE434782	36	160	60	20	16	17	4	22.25
1-1/8	- 7UNC	TE434822	40	180	70	22	18	21	4	25

►DIN 371(#4~3/8) and DIN 376(7/16~1-1/8)

◎ : Excellent ○ : Good

ISO Material Description	P					M				K										
	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel		Grey cast iron	Nodular cast iron		Malleable cast iron			
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc	13	25	28	32	30	10	29	32	38	15	35	15	23	10	10	26	3	25	21	21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended															◎	◎	◎	◎	○	○

ISO Material Description	N					S					H											
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)		Non Metallic Materials			Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron		
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	
HRc											15	30	25	38	34			55	60	42	55	
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550	
Recommended																						○

YG TAP CAST IRON

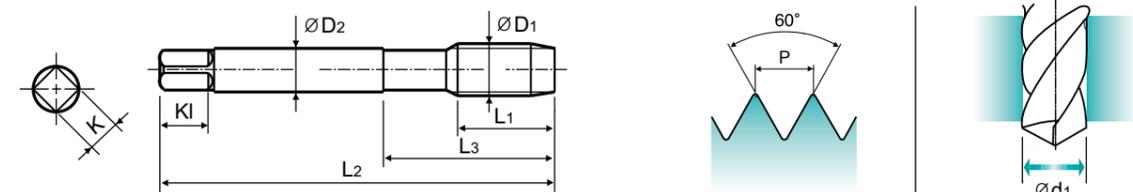
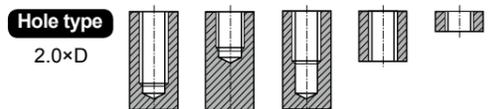
TE454 SERIES

UNF Unified fine threads

● Unified Feingewinde
○ UNF
○ Unificato passo fine

► Suitable for tapping cast iron or similar work materials due to nitriding.

► Geeignet zum Gewindeschneiden von Guss oder ähnlichen Werkstoffen dank der Nitrierung



Material groups: **GG** **HSS-E** **DIN 371/374** **2BX** **60°** **C** **NI**

Machine taps
Maschinengewindebohrer

Recommended Cutting Page : P.237

Unit : mm

SIZE	TPI	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1		Ni	L1	L2	L3	ØD2	K	Kl	Z	Ød1
#4 - 48UNF		TE454182	11	56	18	3.5	2.7	6	3	2.4
#5 - 44UNF		TE454222	11	56	18	3.5	2.7	6	3	2.7
#6 - 40UNF		TE454262	12	56	20	4	3	6	3	3
#8 - 36UNF		TE454302	13	63	21	4.5	3.4	6	3	3.5
#10 - 32UNF		TE454342	15	70	25	6	4.9	8	3	4.1
#12 - 28UNF		TE454382	16	80	30	6	4.9	8	4	4.7
1/4 - 28UNF		TE454422	17	80	30	7	5.5	8	4	5.5
5/16 - 24UNF		TE454462	17	90	35	8	6.2	9	4	6.9
3/8 - 24UNF		TE454502	18	100	39	9	7	10	4	8.5
7/16 - 20UNF		TE454542	22	100	40	8	6.2	9	4	9.9
1/2 - 20UNF		TE454582	22	100	40	9	7	10	4	11.5
9/16 - 18UNF		TE454622	22	100	40	11	9	12	4	12.9
5/8 - 18UNF		TE454662	22	100	40	12	9	12	4	14.5
3/4 - 16UNF		TE454722	25	110	44	14	11	14	4	17.5
7/8 - 14UNF		TE454762	26	125	50	18	14.5	17	4	20.5
1 - 12UNF		TE454802	28	140	54	18	14.5	17	4	23.25
1-1/8 - 12UNF		TE454842	30	150	60	22	18	21	4	26.5

► DIN 371(#4~3/8) and DIN 374(7/16~1-1/8)

◎ : Excellent ○ : Good

ISO	P										M				K					
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel		Stainless steel		Grey cast iron	Nodular cast iron		Malleable cast iron		
Material Description	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc	13	25	28	32	30	10	29	32	38	15	35	15	23	10	10	26	3	25	130	21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended															◎	◎	◎	◎	○	○

ISO	N										S						H				
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)		Non Metallic Materials			Heat Resistant Super Alloys			Titanium Alloys			Hardened steel	Chilled Cast Iron	Hardened Cast Iron		
Material Description	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc	15	30	25	38	34	15	30	25	38	34	15	30	25	38	34	55	60	55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550
Recommended																					

YG TAP CAST IRON

RECOMMENDED CUTTING CONDITIONS EMPFOHLENE SCHNEIDKONDITIONEN

ISO	VDI 3323	Material Description	HB	HRc	T0993	TE821 TE403 TE434 TE454	TD821	TI821	TY821
					Vc (m/min)				
P	1	Non-alloy steel	125						
	2		190	13					
	3		250	25					
	4		270	28					
	5		300	32					
	6	Low alloy steel	180	10					
	7		275	29					
	8		300	32					
	9		350	38					
	10		High alloyed steel, and tool steel	200	15				
	11	325		35					
M	12	Stainless steel	200	15					
	13		240	23					
	14		180	10					
K	15	Grey cast iron	180	10	10-15	10-15	15-20	15-20	15-20
	16		260	26	5-8	5-8	8-11	8-11	8-11
	17	Nodular cast iron	160	3	10-15	10-15	15-20	15-20	15-20
	18		250	25	5-8	5-8	8-11	8-11	8-11
	19		Malleable cast iron	130		10-15	10-15	15-20	15-20
20	230	21		5-8	5-8	8-11	8-11	8-11	
N	21	Aluminum-wrought alloy	60						
	22		100						
	23	Aluminum-cast, alloyed	75		15-20				
	24		90						
	25		130		10-15				
	26		110						
	27	Copper and Copper Alloys (Bronze / Brass)	90			8-12	12-16	12-16	12-16
	28		100						
	29		Non Metallic Materials						
	30								
S	31	Heat Resistant Super Alloys	200	15					
	32		280	30					
	33		250	25					
	34		350	38					
	35		320	34					
	36	Titanium Alloys	400 Rm						
	37		1050 Rm						
H	38	Hardened steel	550	55					
	39		630	60					
	40	Chilled Cast Iron	400	42	3-5				
	41	Hardened Cast Iron	550	55					