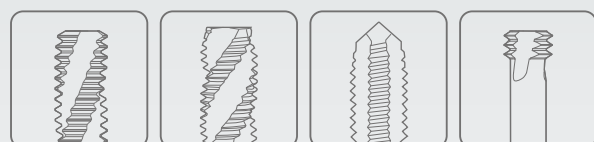




Leading Through Innovation



Global Cutting Tool Leader **YG-1**



THREADING

HSS-E & HSS-PM

COMBO TAPS

COMBO GEWINDEBOHRER

- For Multi Purpose Tapping
YG-1's Patent
- Für Mehrbereichs-Gewindebohren
YG1's Patent

CARBIDE

HSS

THREAD MILLS

SYNCHRO TAPS

COMBO TAPS

YG TAP GENERAL

YG TAP STEEL

YG TAP HARDENED

YG TAP INOX

YG TAP CAST IRON

YG TAP ALU

YG TAP Ti Ni

YG TAP FORMING

NUT TAPS

STI TAPS

PIPE TAPS

TECHNICAL DATA

SELECTION GUIDE

THREADING TOOLS

HSS-E & HSS-PM

COMBO

TAPS

For Multi Purpose Tapping

YG-1's Patent

ISO

VDI 3323

Material Description

Composition / Structure / Heat Treatment

HB

HRC

P

1

2

3

4

5

6

7

8

9

10

11

Non-alloy steel

Low alloy steel

High alloyed steel, and tool steel

About 0.15% C

About 0.45% C

About 0.45% C

About 0.75% C

About 0.75% C

Annealed

Quenched & Tempered

Quenched & Tempered

Quenched & Tempered

Quenched & Tempered

Annealed

Quenched & Tempered

125

190

250

270

300

180

275

300

350

200

325

13

25

28

32

10

29

32

38

15

35

M

12

13

14

Stainless steel

Ferritic / Martensitic

Martensitic

Austenitic

200

240

180

15

16

17

18

19

20

Grey cast iron

Nodular cast iron

Malleable cast iron

180

260

160

250

130

230

10

26

3

25

21

N

21

22

23

24

25

26

27

28

29

30

Aluminum-wrought alloy

Aluminum-cast, alloyed

Copper and Copper Alloys (Bronze / Brass)

Non Metallic Materials

Not Curable

Curable

≤ 12% Si, Not Curable

≤ 12% Si, Curable

> 12% Si, Not Curable

Cutting Alloys, PB>1%

CuZn, CuSnZn (Brass)

CuSn, lead-free copper and electrolytic copper

Duroplastic, Fiber Reinforced Plastic

Rubber, Wood, etc.

60

100

75

90

130

110

90

100

31

32

33

34

35

36

37

Heat Resistant Super Alloys

Titanium Alloys

Fe Based

Ni or Co Based

Pure Titanium

Alpha + Beta Alloys

Annealed

Cured

Annealed

Cured

Cast

Hardened

200

280

250

350

320

400 Rm

1050 Rm

38

39

40

41

Hardened steel

Chilled Cast Iron

Hardened Cast Iron

Hardened

Cast

Hardened

550

630

400

550

55

60

42

55

Max. 2.5xD Blind Hole

HSS-E

CHAMFER LEAD ACC. TO DIN2197

FLUTE TYPE

SPIRAL FLUTE ANGLE

SERIES

SURFACE TREATMENT

MODEL

<

74 phone:+82-32-526-0909, www.yg1.kr, E-mail:yg1@yg1.kr **YG-1 CO., LTD.**

YG-1 CO., LTD. phone:+82-32-526-0909, www.yg1.kr, E-mail:yg1@yg1.kr **75**

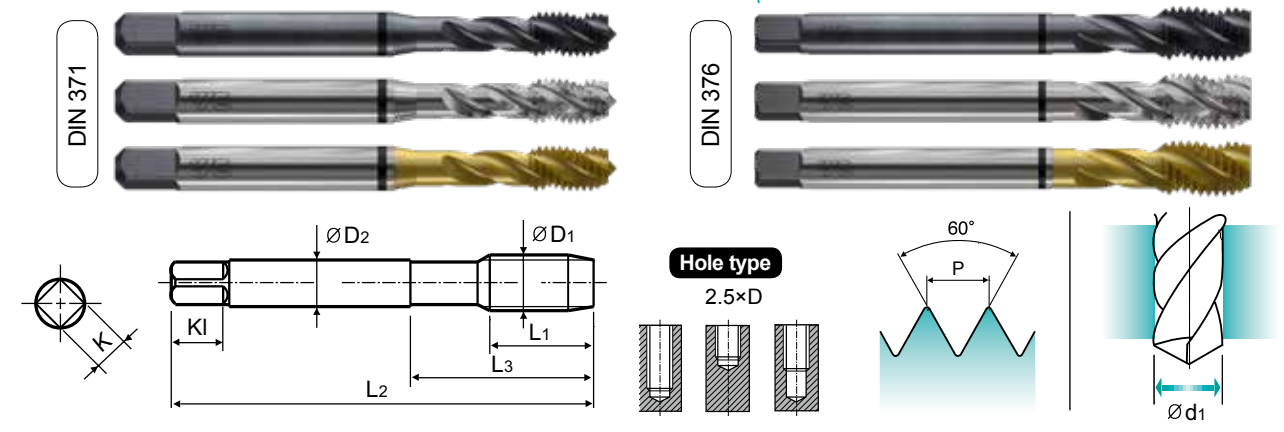
The logo for WEG COMBO TAPS is displayed on the left, featuring the WEG logo and the text "COMBO TAPS". To the right, a table lists the product series:

Vap	TBE07 SERIES
Bright	TCE07 SERIES
TiN	TDE07 SERIES

M ISO Metric coarse threads DIN 13

- 🇩🇪 Metrisches ISO-Gewinde DIN 13
- 🇫🇷 ISO MÉTRIQUE DIN13
- 🇮🇹 ISO Metrico passo grosso DIN 13

► For using multi-purpose and correct thread profiles & long tool life due to special tap geometry. YG-1 company has a patent.



Recommended Cutting Page : P.115												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	Vap	Bright	TiN	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M2	× 0.4	TBE07136	TCE07136	TDE07136	8	45	13	2.8	2.1	5	3	1.6
M2.2	× 0.45	TBE07156	TCE07156	TDE07156	8	45	13	2.8	2.1	5	3	1.75
M2.3	× 0.4	TBE07196	TCE07196	TDE07196	8	45	13	2.8	2.1	5	3	1.9
M2.5	× 0.45	TBE07176	TCE07176	TDE07176	9	50	15	2.8	2.1	5	3	2.05
M2.6	× 0.45	TBE07496	TCE07496	TDE07496	9	50	15	2.8	2.1	5	3	2.1
M3	× 0.5	TBE07206	TCE07206	TDE07206	6	56	18	3.5	2.7	6	3	2.5
M3.5	× 0.6	TBE07226	TCE07226	TDE07226	7	56	20	4	3	6	3	2.9
M4	× 0.7	TBE07246	TCE07246	TDE07246	7	63	21	4.5	3.4	6	3	3.3
M4.5	× 0.75	TBE07266	TCE07266	TDE07266	8	70	25	6	4.9	8	3	3.7
M5	× 0.8	TBE07286	TCE07286	TDE07286	8	70	25	6	4.9	8	3	4.2
M6	× 1	TBE07316	TCE07316	TDE07316	10	80	30	6	4.9	8	3	5
M7	× 1	TBE07346	TCE07346	TDE07346	10	80	30	7	5.5	8	3	6
M8	× 1.25	TBE07366	TCE07366	TDE07366	13	90	35	8	6.2	9	3	6.8
M9	× 1.25	TBE07396	TCE07396	TDE07396	13	90	35	9	7	10	3	7.8
M10	× 1.5	TBE07426	TCE07426	TDE07426	15	100	39	10	8	11	3	8.5
M11	× 1.5	TBE07466	TCE07466	TDE07466	17	100	40	8	6.2	9	3	9.5
M12	× 1.75	TBE07506	TCE07506	TDE07506	18	110	44	9	7	10	3	10.2
M14	× 2	TBE07546	TCE07546	TDE07546	20	110	44	11	9	12	3	12
M16	× 2	TBE07606	TCE07606	TDE07606	20	110	44	12	9	12	3	14
M18	× 2.5	TBE07656	TCE07656	TDE07656	25	125	50	14	11	14	4	15.5
M20	× 2.5	TBE07706	TCE07706	TDE07706	25	140	54	16	12	15	4	17.5
M22	× 2.5	TBE07746	TCE07746	TDE07746	25	140	54	18	14.5	17	4	19.5
M24	× 3	TBE07786	TCE07786	TDE07786	30	160	60	18	14.5	17	4	21
M27	× 3	TBE07866	TCE07866	TDE07866	30	160	60	20	16	19	4	24
M30	× 3.5	TBE07946	TCE07946	TDE07946	35	180	70	22	18	21	4	26.5

* The other coating (TiCN or TiAlN) is available on your request.

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COMBO TAPS

Vap **TB844** SERIES

Bright **TC844** SERIES

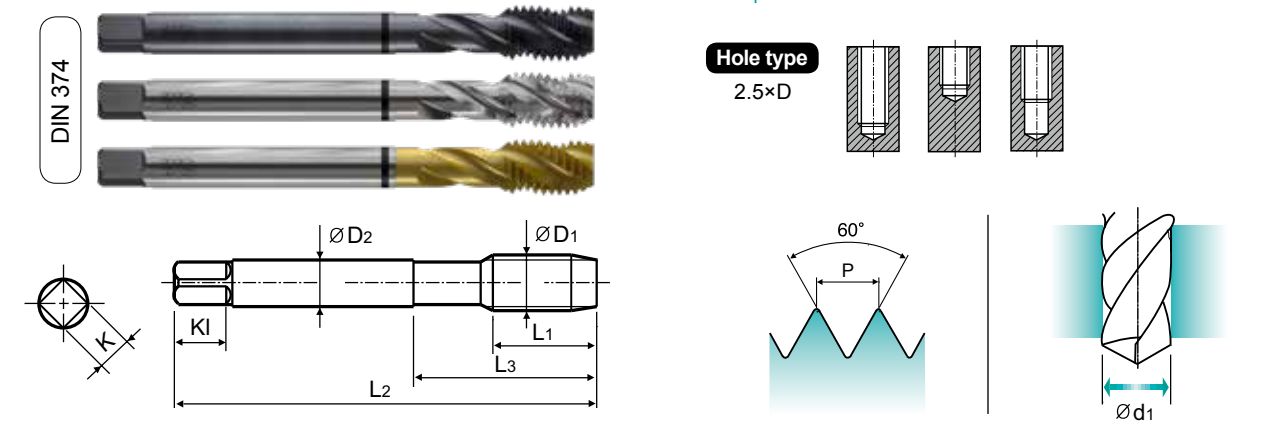
TiN **TD844** SERIES

ISO Metric fine threads DIN 13

- 🇩🇪 Metrisches ISO-Feingewinde DIN 13
- 🇫🇷 ISO MÉTRIQUE PAS FINS DIN13
- 🇮🇹 ISO Metrico passo fine DIN 13

► For using multi-purpose and correct thread profiles & long tool life due to special tap geometry. YG-1 company has a patent.

► Für vielfältigen Einsatz, genaue Gewindeprofile und lange Standzeit dank einer besonderen Schneidengeometrie. Von YG-1 patentiert.



Recommended Cutting Page : P.114

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	Vap	Bright	TiN	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M4	× 0.5	TB844256	TC844256	TD844256	5	63	21	2.8	2.1	5	3	3.5
M5	× 0.5	TB844296	TC844296	TD844296	5	70	25	3.5	2.7	6	3	4.5
M6	× 0.75	TB844326	TC844326	TD844326	8	80	30	4.5	3.4	6	3	5.2
M6	× 0.5	TB844336	TC844336	TD844336	5	80	30	4.5	3.4	6	3	5.5
M7	× 0.75	TB844356	TC844356	TD844356	10	80	30	5.5	4.3	7	3	6.2
M8	× 1	TB844376	TC844376	TD844376	10	90	36	6	4.9	8	3	7
M8	× 0.75	TB844386	TC844386	TD844386	8	80	30	6	4.9	8	3	7.2
M10	× 1.25	TB844436	TC844436	TD844436	16	100	40	7	5.5	8	3	8.8
M10	× 1	TB844446	TC844446	TD844446	10	90	36	7	5.5	8	3	9
M10	× 0.75	TB844456	TC844456	TD844456	10	90	36	7	5.5	8	3	9.2
M12	× 1.5	TB844516	TC844516	TD844516	15	100	40	9	7	10	3	10.5
M12	× 1.25	TB844526	TC844526	TD844526	15	100	40	9	7	10	3	10.8
M12	× 1	TB844536	TC844536	TD844536	11	100	40	9	7	10	3	11
M14	× 1.5	TB844556	TC844556	TD844556	15	100	40	11	9	12	3	12.5
M14	× 1.25	TB844566	TC844566	TD844566	15	100	40	11	9	12	3	12.8
M14	× 1	TB844576	TC844576	TD844576	11	100	40	11	9	12	3	13
M16	× 1.5	TB844616	TC844616	TD844616	15	100	40	12	9	12	3	14.5
M16	× 1	TB844626	TC844626	TD844626	12	100	40	12	9	12	3	15
M18	× 1.5	TB844676	TC844676	TD844676	17	110	44	14	11	14	4	16.5
M18	× 1	TB844686	TC844686	TD844686	13	110	44	14	11	14	4	17
M20	× 1.5	TB844726	TC844726	TD844726	17	125	50	16	12	15	4	18.5
M20	× 1	TB844736	TC844736	TD844736	14	125	50	16	12	15	4	19
M22	× 1.5	TB844766	TC844766	TD844766	17	125	50	18	14.5	17	4	20.5
M22	× 1	TB844776	TC844776	TD844776	14	125	50	18	14.5	17	4	21

▶ NEXT PAGE

* The other coating(TiCN or TiAlN) is available on your request.

◎: Excellent ○: Good

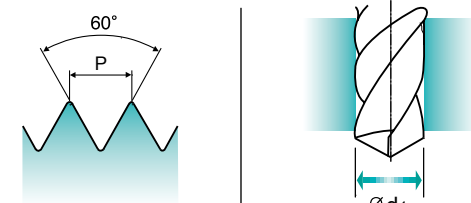
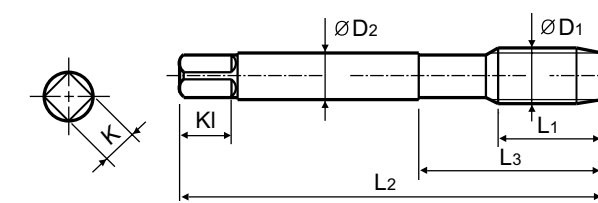
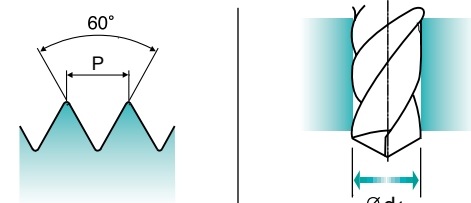
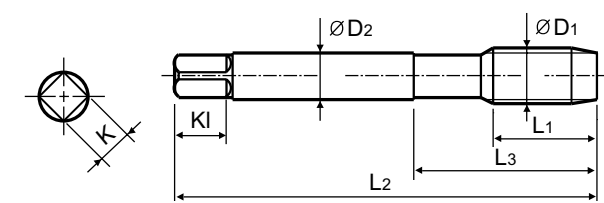
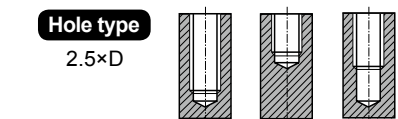
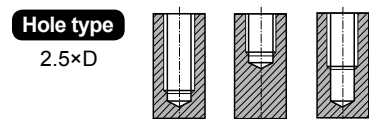
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MF **ISO Metric fine threads DIN 13**

- 🇩🇪 **Metrisches ISO-Feingewinde DIN 13**
- 🇫🇷 **ISO MÉTRIQUE PAS FINS DIN13**
- 🇮🇹 **ISO Metrico passo fine DIN 13**

► Für vielfältigen Einsatz, genaue Gewindeprofile und lange Standzeit dank einer besonderen Schneidengeometrie. Von YG-1 patentiert.

► Für vielfältigen Einsatz, genaue Gewindeprofile und lange Standzeit dank einer besonderen Schneidengeometrie. Von YG-1 patentiert.



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	Vap	Bright	TiN	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M24 × 2		TB844796	TC844796	TD844796	20	140	54	18	14.5	17	4	22
M24 × 1.5		TB844806	TC844806	TD844806	20	140	54	18	14.5	17	4	22.5
M26 × 1.5		TB844856	TC844856	TD844856	20	140	54	18	14.5	17	4	24.5
M27 × 2		TB844876	TC844876	TD844876	20	140	54	20	16	19	4	25
M27 × 1.5		TB844886	TC844886	TD844886	20	140	54	20	16	19	4	25.5
M28 × 1.5		TB844916	TC844916	TD844916	20	140	54	20	16	19	4	26.5
M30 × 2		TB844966	TC844966	TD844966	22	150	57	22	18	21	4	28
M30 × 1.5		TB844976	TC844976	TD844976	22	150	57	22	18	21	4	28.5

* The other coating(TiCN or TiAlN) is available on your request.

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	TiN	L1	L2	L3	ØD2	K	KI	Z	Ød1
M4	× 0.5	TCE09256	TDE09256	5	63	21	2.8	2.1	5	3	3.5
M5	× 0.5	TCE09296	TDE09296	5	70	25	3.5	2.7	6	3	4.5
M6	× 0.75	TCE09326	TDE09326	8	80	30	4.5	3.4	6	3	5.2
M6	× 0.5	TCE09336	TDE09336	5	80	30	4.5	3.4	6	3	5.5
M7	× 0.75	TCE09356	TDE09356	10	80	30	5.5	4.3	7	3	6.2
M8	× 1	TCE09376	TDE09376	10	90	36	6	4.9	8	3	7
M8	× 0.75	TCE09386	TDE09386	8	80	30	6	4.9	8	3	7.2
M10	× 1.25	TCE09436	TDE09436	16	100	40	7	5.5	8	3	8.8
M10	× 1	TCE09446	TDE09446	10	90	36	7	5.5	8	3	9
M10	× 0.75	TCE09456	TDE09456	10	90	36	7	5.5	8	3	9.2
M12	× 1.5	TCE09516	TDE09516	15	100	40	9	7	10	3	10.5
M12	× 1.25	TCE09526	TDE09526	15	100	40	9	7	10	3	10.8
M12	× 1	TCE09536	TDE09536	11	100	40	9	7	10	3	11
M14	× 1.5	TCE09556	TDE09556	15	100	40	11	9	12	3	12.5
M14	× 1.25	TCE09566	TDE09566	15	100	40	11	9	12	3	12.8
M14	× 1	TCE09576	TDE09576	11	100	40	11	9	12	3	13
M16	× 1.5	TCE09616	TDE09616	15	100	40	12	9	12	3	14.5
M16	× 1	TCE09626	TDE09626	12	100	40	12	9	12	3	15
M18	× 1.5	TCE09676	TDE09676	17	110	44	14	11	14	4	16.5
M18	× 1	TCE09686	TDE09686	13	110	44	14	11	14	4	17
M20	× 1.5	TCE09726	TDE09726	17	125	50	16	12	15	4	18.5
M20	× 1	TCE09736	TDE09736	14	125	50	16	12	15	4	19
M22	× 1.5	TCE09766	TDE09766	17	125	50	18	14.5	17	4	20.5
M22	× 1	TCE09776	TDE09776	14	125	50	18	14.5	17	4	21

* The other coating(TiCN or TiAlN) or Surface Treatment(Steam Homo) is available on your request.

▶ NEXT PAGE

[illegible]

																			◎ : Excellent ○ : Good			
ISO	P									M					K							
Material Description	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	6	29	32	38	15	35	15	23	10	10	26	3	25		21		
HB		125	190	250	270	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230		
Recommended	○	◎	◎	◎	◎	◎	◎	◎	◎	○		◎	◎	◎	◎	◎	◎	◎				
ISO	N									S							H					
Material Description	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			◎			◎	◎	◎														

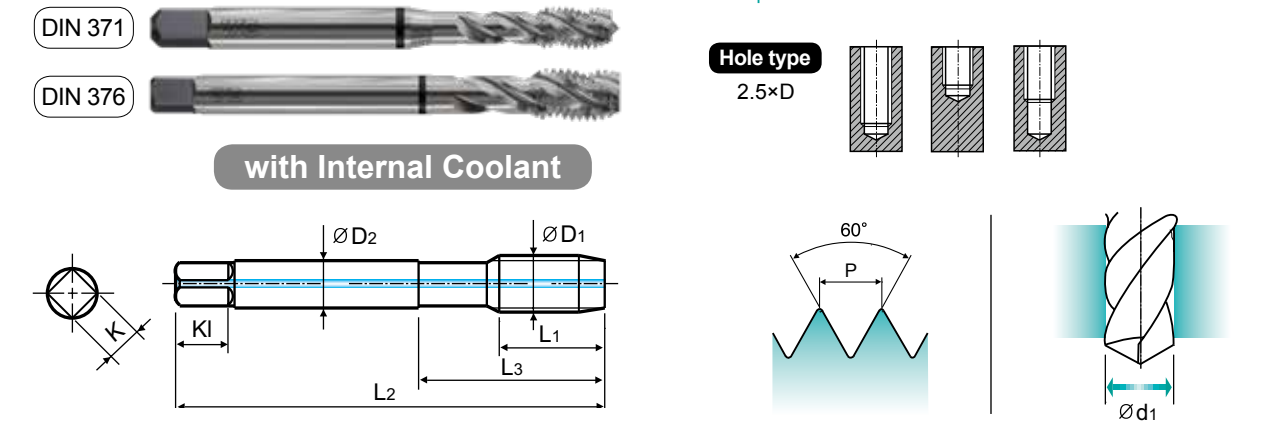

COMBO TAPS

TC804-IC
SERIES

M **ISO Metric coarse threads DIN 13**

- 🇩🇪 Metrisches ISO-Gewinde DIN 13
- 🇫🇷 ISO MÉTRIQUE DIN13
- 🇮🇹 ISO Metrico passo grosso DIN 13

► For using multi-purpose and correct thread profiles & long tool life due to special tap geometry. YG-1 company has a patent.



Recommended Cutting Page : P.115

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	Kl	Z	Ød1
M6 × 1		TC804316IC	10	80	30	6	4.9	8	3	5
M8 × 1.25		TC804366IC	13	90	35	8	6.2	9	3	6.8
M10 × 1.5		TC804426IC	15	100	39	10	8	11	3	8.5
M12 × 1.75		TC804506IC	18	110	44	9	7	10	3	10.2
M14 × 2		TC804546IC	20	110	44	11	9	12	3	12
M16 × 2		TC804606IC	20	110	44	12	9	12	3	14
M18 × 2.5		TC804656IC	25	125	50	14	11	14	4	15.5
M20 × 2.5		TC804706IC	25	140	54	16	12	15	4	17.5

►DIN 371(M6~M10) and DIN 376(M12~M20)
* Coating(TiN, TiCN or TiAlN) or Surface Treatment(Steam Homo) is available on your request.

[illegible]

CARBIDE

HSS

THREAD MILLS

SYNCHRO TAPS

COMBO TAPS

YG TAP GENERAL

YG TAP STEEL

YG TAP HARDENED

YG TAP INOX

YG TAP CAST IRON

YG TAP ALU

YG TAP Ti Ni

YG TAP FORMING

NUT TAPS

STI TAPS

PIPE TAPS

TECHNICAL DATA

COMBO TAPS

TC807

SERIES

M

ISO Metric coarse threads DIN 13

Metrisches ISO-Gewinde DIN 13

ISO MÉTRIQUE DIN13

ISO Metrico passo grosso DIN 13

► For using multi-purpose and correct thread profiles & long tool life due to special tap geometry. YG-1 company has a patent.

► Für vielfältigen Einsatz, genaue Gewindeprofile und lange Standzeitendank einer besonderen Schneidengeometrie. Von YG-1 patentiert.

DIN 371

DIN 376

Hole type

2.5×D

Short Chamfer

ØD2

ØD1

KL

L1

L2

L3

60°

P

Ød1

MU

HSS-E

DIN 371/376

6H

60°

E

Bright

R40

Machine taps
Maschinengewindebohrer

Recommended Cutting Page : P.115

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	KL	Z	Ød1
M2 × 0.4		TC807136	8	45	13	2.8	2.1	5	3	1.6
M2.2 × 0.45		TC807156	8	45	13	2.8	2.1	5	3	1.75
M2.3 × 0.4		TC807196	8	45	13	2.8	2.1	5	3	1.9
M2.5 × 0.45		TC807176	9	50	15	2.8	2.1	5	3	2.05
M2.6 × 0.45		TC807496	9	50	15	2.8	2.1	5	3	2.1
M3 × 0.5		TC807206	6	56	18	3.5	2.7	6	3	2.5
M3.5 × 0.6		TC807226	7	56	20	4	3	6	3	2.9
M4 × 0.7		TC807246	7	63	21	4.5	3.4	6	3	3.3
M4.5 × 0.75		TC807266	8	70	25	6	4.9	8	3	3.7
M5 × 0.8		TC807286	8	70	25	6	4.9	8	3	4.2
M6 × 1		TC807316	10	80	30	6	4.9	8	3	5
M7 × 1		TC807346	10	80	30	7	5.5	8	3	6
M8 × 1.25		TC807366	13	90	35	8	6.2	9	3	6.8
M9 × 1.25		TC807396	13	90	35	9	7	10	3	7.8
M10 × 1.5		TC807426	15	100	39	10	8	11	3	8.5
M11 × 1.5		TC807466	17	100	40	8	6.2	9	3	9.5
M12 × 1.75		TC807506	18	110	44	9	7	10	3	10.2
M14 × 2		TC807546	20	110	44	11	9	12	3	12
M16 × 2		TC807606	20	110	44	12	9	12	3	14
M18 × 2.5		TC807656	25	125	50	14	11	14	4	15.5
M20 × 2.5		TC807706	25	140	54	16	12	15	4	17.5
M22 × 2.5		TC807746	25	140	54	18	14.5	17	4	19.5
M24 × 3		TC807786	30	160	60	18	14.5	17	4	21
M27 × 3		TC807866	30	160	60	20	16	19	4	24
M30 × 3.5		TC807946	35	180	70	22	18	21	4	26.5

►DIN 371(M2~M10) and DIN 376(M11~M30)

* Coating(TiN, TiCN or TiAlN) or Surface Treatment(Steam Homo) is available on your request.

◎ : Excellent ○ : Good

ISO	P										M					K				
Material Description	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel					Stainless steel				
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				
Material Description	Aluminum-wrought alloy					Aluminum-cast, alloyed					Copper and Copper Alloys (Bronze / Brass)					Non Metallic Materials				
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40
HRc	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400
Recommended			◎			◎	◎	◎												

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phone:+82-32-526-0909, www.yg1.kr, E-mail:yg1@yg1.kr

YG-1 CO., LTD.

CARBIDE

HSS

THREAD MILLS

SYNCHRO TAPS

COMBO TAPS

YG TAP GENERAL

YG TAP STEEL

YG TAP HARDENED

YG TAP INOX

YG TAP CAST IRON

YG TAP ALU

YG TAP Ti Ni

YG TAP FORMING

NUT TAPS

STI TAPS

PIPE TAPS

TECHNICAL DATA

COMBO TAPS

TC633

SERIES

M

ISO Metric coarse threads DIN 13

Metrisches ISO-Gewinde DIN 13

ISO MÉTRIQUE DIN13

ISO Metrico passo grosso DIN 13

► For using multi-purpose and correct thread profiles & long tool life due to special tap geometry. YG-1 company has a patent.

► Für vielfältigen Einsatz, genaue Gewindeprofile und lange Standzeitendank einer besonderen Schneidengeometrie. Von YG-1 patentiert.

Long Shank

Hole type

2.5×D

Long Shank

ØD2

ØD1

KL

L1

L2

L3

60°

P

Ød1

MU

HSS-E

LONG

6H

60°

C

Bright

R40

Machine taps
Maschinengewindebohrer

Recommended Cutting Page : P.115

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	KL	Z	Ød1
M3 × 0.5		TC633206	11	100	18	3.5	2.7	6	3	2.5
M4 × 0.7		TC633246	13	125	21	4.5	3.4	6	3	3.3
M5 × 0.8		TC633286	15	140	25	6	4.9	8	3	4.2
M6 × 1		TC633316	17	160	30	6	4.9	8	3	5
M8 × 1.25		TC633366	20	180	35	6	4.9	8	3	6.8
M10 × 1.5		TC633426	22	200	39	7	5.5	8	3	8.5
M12 × 1.75		TC633506	24	220	44	9	7	10	3	10.2
M14 × 2		TC633546	26	220	44	11	9	12	3	12
M16 × 2		TC633606	27	220	44	12	9	12	3	14
M20 × 2.5		TC633706	32	280	54	16	12	15	4	17.5

* Coating(TiN, TiCN or TiAlN) or Surface Treatment(Steam Homo) is available on your request.

◎ : Excellent ○ : Good

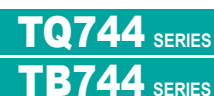
ISO	P										M					K				
Material Description	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel					Stainless steel				
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc	125	13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25	21	
HB	125	190	250	270	300	180	275	300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

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

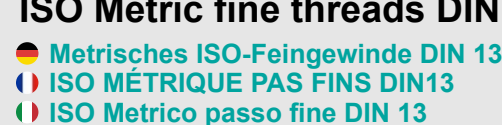
87

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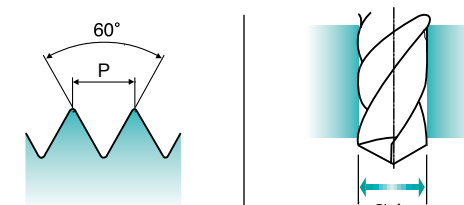
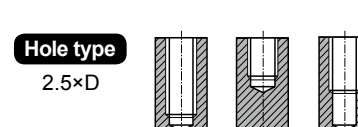
YG-1 CO., LTD.



ISO Metric fine threads DIN 13



► Für rostfreie stähle, genaue Gewindeprofile und lange Standzeitendank einer besonderen Schneidengeometrie. Von YG-1 patentiert.



Unit : mm

Recommended Cutting Page : P.116										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	Vap	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M4 × 0.5		TQ754256	5	63	21	2.8	2.1	5	3	3.5
M5 × 0.5		TQ754296	5	70	25	3.5	2.7	6	3	4.5
M6 × 0.75		TQ754326	8	80	30	4.5	3.4	6	3	5.2
M6 × 0.5		TQ754336	5	80	30	4.5	3.4	6	3	5.5
M7 × 0.75		TQ754356	10	80	30	5.5	4.3	7	3	6.2
M8 × 1		TQ754376	10	90	36	6	4.9	8	3	7
M8 × 0.75		TQ754386	8	80	30	6	4.9	8	3	7.2
M10 × 1.25		TQ754436	16	100	40	7	5.5	8	3	8.8
M10 × 1		TQ754446	10	90	36	7	5.5	8	3	9
M10 × 0.75		TQ754456	10	90	36	7	5.5	8	3	9.2
M12 × 1.5		TQ754516	15	100	40	9	7	10	3	10.5
M12 × 1.25		TQ754526	15	100	40	9	7	10	3	10.8
M12 × 1		TQ754536	11	100	40	9	7	10	3	11

* Coating(TiN, TiCN or TiAlN) is available on your request.

◎ : Excellent ○ : Good

[illegible]

YG-1 CO., LTD.

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MF

ISO Metric fine threads DIN 13

Metrisches ISO-Feingewinde DIN 13

ISO MÉTRIQUE PAS FINS DIN13

ISO Metrico passo fine DIN 13

For stainless steels and correct thread profiles & long tool life due to special tap geometry. YG-1 company has a patent.

Für rostfreie stähle, genaue Gewindeprofile und lange Standzeitendank einer besonderen Schneidengeometrie. Von YG-1 patentiert.

DIN 374

Hole type

2.5×D

VA

HSS-E

DIN 374

6H

60°

C

Vap

R45

Machine taps
Maschinengewindebohrer

Recommended Cutting Page : P.116

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	Vap	L1	L2	L3	ØD2	K	KI	Z	Ød1
M14 × 1.5		TB754556	15	100	40	11	9	12	3	12.5
M14 × 1.25		TB754566	15	100	40	11	9	12	3	12.8
M14 × 1		TB754576	11	100	40	11	9	12	3	13
M16 × 1.5		TB754616	15	100	40	12	9	12	3	14.5
M16 × 1		TB754626	12	100	40	12	9	12	3	15
M18 × 1.5		TB754676	17	110	44	14	11	14	4	16.5
M18 × 1		TB754686	13	110	44	14	11	14	4	17
M20 × 1.5		TB754726	17	125	50	16	12	15	4	18.5
M20 × 1		TB754736	14	125	50	16	12	15	4	19
M22 × 1.5		TB754766	17	125	50	18	14.5	17	4	20.5
M22 × 1		TB754776	14	125	50	18	14.5	17	4	21
M24 × 2		TB754796	20	140	54	18	14.5	17	4	22
M24 × 1.5		TB754806	20	140	54	18	14.5	17	4	22.5
M26 × 1.5		TB754856	20	140	54	18	14.5	17	4	24.5
M27 × 2		TB754876	20	140	54	20	16	19	4	25
M27 × 1.5		TB754886	20	140	54	20	16	19	4	25.5
M28 × 1.5		TB754916	20	140	54	20	16	19	4	26.5
M30 × 2		TB754966	22	150	57	22	18	21	4	28
M30 × 1.5		TB754976	22	150	57	22	18	21	4	28.5

* Coating(TiN, TiCN or TiAlN) is available on your request.

UNC

Unified coarse threads

Unified Grobgewinde

UNC

Unificato passo fine

For using multi-purpose and correct thread profiles & long tool life due to special tap geometry. YG-1 company has a patent.

Für vielfältigen Einsatz, genaue Gewindeprofile und lange Standzeitendank einer besonderen Schneidengeometrie. Von YG-1 patentiert.

DIN 371

Hole type

2.5×D

MU

HSS-E

DIN 371/376

2B

60°

C

Vap Bright TiN

R40

Machine taps
Maschinengewindebohrer

Recommended Cutting Page : P.114

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		Vap	Bright	TiN	L1	L2	L3	ØD2	K	KI	Z	Ød1
#4 - 40 UNC		TB824162	TC824162	TD824162	6	56	18	3.5	2.7	6	3	2.3
#5 - 40 UNC		TB824202	TC824202	TD824202	7	56	18	3.5	2.7	6	3	2.6
#6 - 32 UNC		TB824242	TC824242	TD824242	7	56	20	4	3	6	3	2.85
#8 - 32 UNC		TB824282	TC824282	TD824282	8	63	21	4.5	3.4	6	3	3.5
#10 - 24 UNC		TB824322	TC824322	TD824322	10	70	25	6	4.9	8	3	3.9
#12 - 24 UNC		TB824362	TC824362	TD824362	10	80	30	6	4.9	8	3	4.5
1/4 - 20 UNC		TB824402	TC824402	TD824402	13	80	30	7	5.5	8	3	5.2
5/16 - 18 UNC		TB824442	TC824442	TD824442	14	90	35	8	6.2	9	3	6.6
3/8 - 16 UNC		TB824482	TC824482	TD824482	16	100	39	9	7	10	3	8
7/16 - 14 UNC		TB824522	TC824522	TD824522	17	100	40	8	6.2	9	3	9.4
1/2 - 13 UNC		TB824562	TC824562	TD824562	20	110	44	9	7	10	3	10.75
9/16 - 12 UNC		TB824602	TC824602	TD824602	20	110	44	11	9	12	3	12.25
5/8 - 11 UNC		TB824642	TC824642	TD824642	22	110	44	12	9	12	3	13.5
3/4 - 10 UNC		TB824702	TC824702	TD824702	25	125	50	14	11	14	4	16.5
7/8 - 9 UNC		TB824742	TC824742	TD824742	27	140	54	18	14.5	17	4	19.5
1 - 8 UNC		TB824782	TC824782	TD824782	30	160	60	20	16	19	4	22.25

►DIN 371(#4~3/8) and DIN 376(7/16~1)
* The other coating(TiCN or TiAlN) is available on your request.

◎ : Excellent ○ : Good

ISO	P										M					K				
Material Description	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel					Stainless steel				
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	N										S					H				
Material Description	Aluminum-wrought alloy					Aluminum-cast, alloyed					Copper and Copper Alloys (Bronze / Brass)					Non Metallic Materials				
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40
HRc																				
HB	60	100	75	90	130	110	90	100												
Recommended																				

ISO	N										S					H				
Material Description	Aluminum-wrought alloy					Aluminum-cast, alloyed					Copper and Copper Alloys (Bronze / Brass)					Non Metallic Materials				
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40
HRc																				
HB	60	100	75	90	130	110	90	100												
Recommended																				

◎ : Excellent ○ : Good

ISO	P										M					K				
Material Description	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel					Stainless steel				
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	N										S					H				
Material Description	Aluminum-wrought alloy					Aluminum-cast, alloyed					Copper and Copper Alloys (Bronze / Brass)					Non Metallic Materials				
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40
HRc																				
HB	60	100	75	90	130	110	90	100												
Recommended																				

THREAD MILLS

SYNCHRO TAPS

COMBO TAPS

YG TAP GENERAL

YG TAP STEEL

YG TAP HARDENED

YG TAP INOX

YG TAP CAST IRON

YG TAP ALU

YG TAP Ti Ni

YG TAP FORMING

NUT TAPS

STI TAPS

PIPE TAPS

TECHNICAL DATA

UNC

Unified coarse threads

Unified Grobgewinde

UNC

Unificato passo fine

► For using multi-purpose and correct thread profiles & long tool life due to special tap geometry. YG-1 company has a patent.

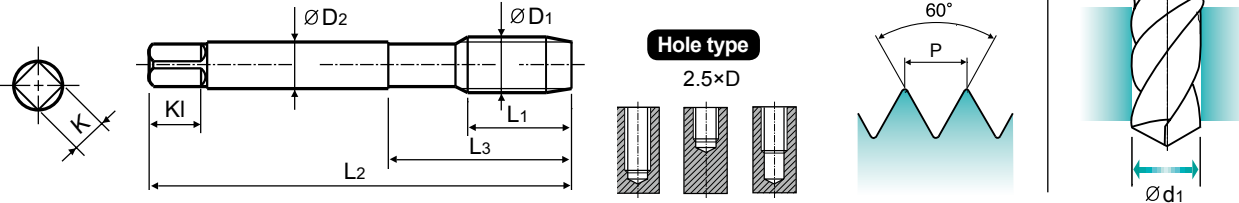
► Für vielfältigen Einsatz, genaue Gewindeprofile und lange Standzeit dank einer besonderen Schneidengeometrie. Von YG-1 patentiert.

DIN 371



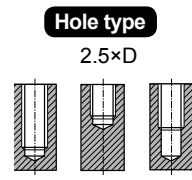
DIN 376

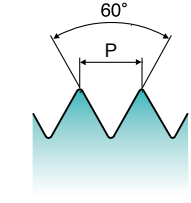


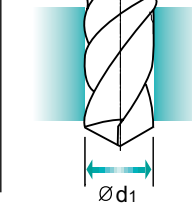


Hole type

2.5×D







MU

HSS-E

DIN 371/376

3B

60°

C

Bright TiN

R40

Machine taps
Maschinengewindebohrer

Recommended Cutting Page : P.114

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		Bright	TiN	L1	L2	L3	ØD2	K	KI	Z	Ød1
#4	- 40 UNC	TCE01162	TDE01162	6	56	18	3.5	2.7	6	3	2.3
#5	- 40 UNC	TCE01202	TDE01202	7	56	18	3.5	2.7	6	3	2.6
#6	- 32 UNC	TCE01242	TDE01242	7	56	20	4	3	6	3	2.85
#8	- 32 UNC	TCE01282	TDE01282	8	63	21	4.5	3.4	6	3	3.5
#10	- 24 UNC	TCE01322	TDE01322	10	70	25	6	4.9	8	3	3.9
#12	- 24 UNC	TCE01362	TDE01362	10	80	30	6	4.9	8	3	4.5
1/4	- 20 UNC	TCE01402	TDE01402	13	80	30	7	5.5	8	3	5.2
5/16	- 18 UNC	TCE01442	TDE01442	14	90	35	8	6.2	9	3	6.6
3/8	- 16 UNC	TCE01482	TDE01482	16	100	39	9	7	10	3	8
7/16	- 14 UNC	TCE01522	TDE01522	17	100	40	8	6.2	9	3	9.4
1/2	- 13 UNC	TCE01562	TDE01562	20	110	44	9	7	10	3	10.75
9/16	- 12 UNC	TCE01602	TDE01602	20	110	44	11	9	12	3	12.25
5/8	- 11 UNC	TCE01642	TDE01642	22	110	44	12	9	12	3	13.5
3/4	- 10 UNC	TCE01702	TDE01702	25	125	50	14	11	14	4	16.5
7/8	- 9 UNC	TCE01742	TDE01742	27	140	54	18	14.5	17	4	19.5
1	- 8 UNC	TCE01782	TDE01782	30	160	60	20	16	19	4	22.25

►DIN 371(#4~3/8) and DIN 376(7/16~1)

* The other coating(TiCN or TiAlN) or Surface Treatment(Steam Homo) is available on your request.

◎ : Excellent ○ : Good

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

THREAD MILLS

SYNCHRO TAPS

COMBO TAPS

YG TAP GENERAL

YG TAP STEEL

YG TAP HARDENED

YG TAP INOX

YG TAP CAST IRON

YG TAP ALU

YG TAP Ti Ni

YG TAP FORMING

NUT TAPS

STI TAPS

PIPE TAPS

TECHNICAL DATA

UNF

Unified fine threads

Unified Grobgewinde

UNF

Unificato passo fine

► For using multi-purpose and correct thread profiles & long tool life due to special tap geometry. YG-1 company has a patent.

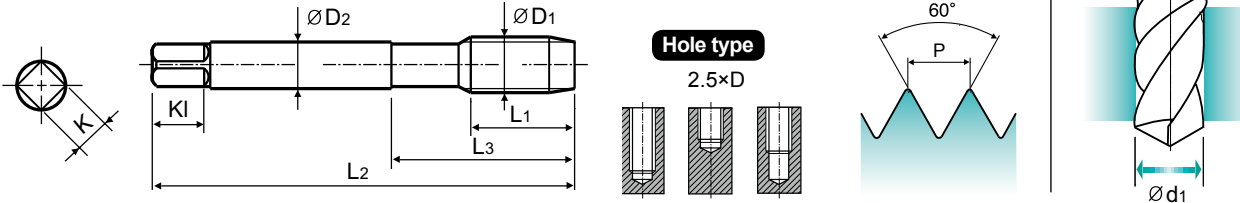
► Für vielfältigen Einsatz, genaue Gewindeprofile und lange Standzeit dank einer besonderen Schneidengeometrie. Von YG-1 patentiert.

DIN 371



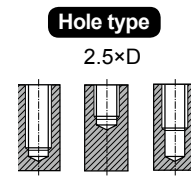
DIN 374

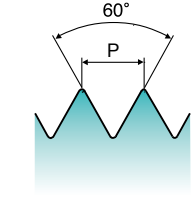


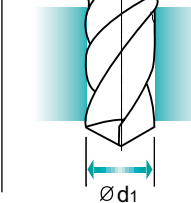


Hole type

2.5×D







MU

HSS-E

DIN 371/374

2B

60°

C

Vap Bright TiN

R40

Machine taps
Maschinengewindebohrer

Recommended Cutting Page : P.114

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		Vap	Bright	TiN	L1	L2	L3	ØD2	K	KI	Z	Ød1
#4	-48UNF	TB864182	TC864182	TD864182	6	56	18	3.5	2.7	6	3	2.4
#5	-44UNF	TB864222	TC864222	TD864222	7	56	18	3.5	2.7	6	3	2.7
#6	-40UNF	TB864262	TC864262	TD864262	7	56	20	4	3	6	3	3
#8	-36UNF	TB864302	TC864302	TD864302	8	63	21	4.5	3.4	6	3	3.5
#10	-32UNF	TB864342	TC864342	TD864342	10	70	25	6	4.9	8	3	4.1
#12	-28UNF	TB864382	TC864382	TD864382	10	80	30	6	4.9	8	3	4.7
1/4	-28UNF	TB864422	TC864422	TD864422	10	80	30	7	5.5	8	3	5.5
5/16	-24UNF	TB864462	TC864462	TD864462	10	90	35	8	6.2	9	3	6.9
3/8	-24UNF	TB864502	TC864502	TD864502	10	100	39	9	7	10	3	8.5
7/16	-20UNF	TB864542	TC864542	TD864542	13	100	40	8	6.2	9	3	9.9
1/2	-20UNF	TB864582	TC864582	TD864582	13	100	40	9	7	10	3	11.5
9/16	-18UNF	TB864622	TC864622	TD864622	15	100	40	11	9	12	3	12.9
5/8	-18UNF	TB864662	TC864662	TD864662	15	100	40	12	9	12	3	14.5
3/4	-16UNF	TB864722	TC864722	TD864722	17	110	44	14	11	14	4	17.5
7/8	-14UNF	TB864762	TC864762	TD864762	17	125	50	18	14.5	17	4	20.5
1	-12UNF	TB864802	TC864802	TD864802	20	140	54	20	16	19	4	23.25

►DIN 371(#4~3/8) and DIN 374(7/16~1)

* The other coating(TiCN or TiAlN) is available on your request.

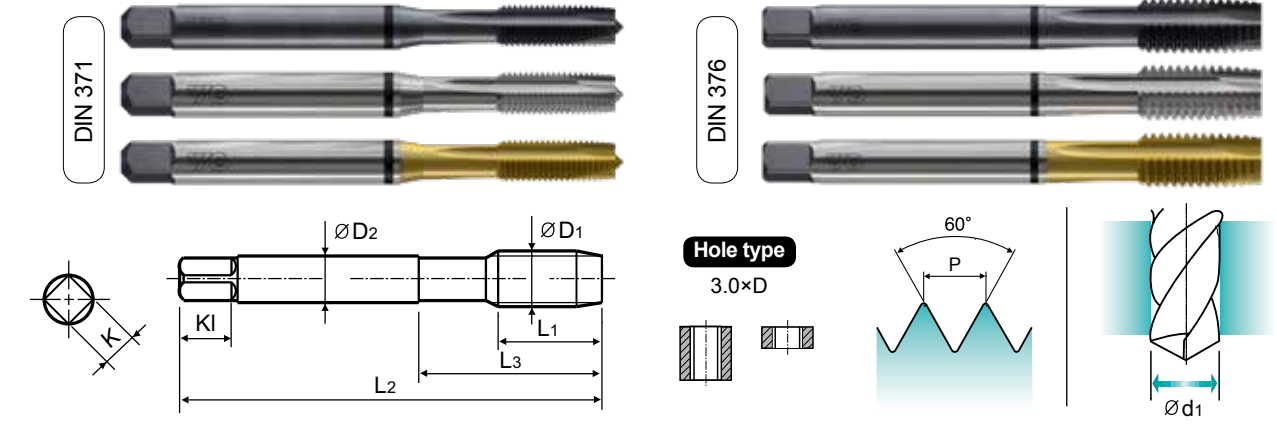
◎ : Excellent ○ : Good

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

M ISO Metric coarse threads DIN 13

► For using multi-purpose and correct thread profiles & long tool life due to special tap geometry. YG-1 company has a patent.



Recommended Cutting Page : P.116-117

Size	Pitch	EDP No.			Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1	P	Vap	Bright	TiN	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M2 × 0.4		TBJ06136	TCJ06136	TDJ06136	8	45	13	2.8	2.1	5	3	1.7
M2.2 × 0.45		TBJ06156	TCJ06156	TDJ06156	8	45	13	2.8	2.1	5	3	1.85
M2.3 × 0.4		TBJ06196	TCJ06196	TDJ06196	8	45	13	2.8	2.1	5	3	2
M2.5 × 0.45		TBJ06176	TCJ06176	TDJ06176	9	50	15	2.8	2.1	5	3	2.15
M2.6 × 0.45		TBJ06496	TCJ06496	TDJ06496	9	50	15	2.8	2.1	5	3	2.2
M3 × 0.5		TBJ06206	TCJ06206	TDJ06206	11	56	18	3.5	2.7	6	3	2.6
M3.5 × 0.6		TBJ06226	TCJ06226	TDJ06226	12	56	20	4	3	6	3	3
M4 × 0.7		TBJ06246	TCJ06246	TDJ06246	13	63	21	4.5	3.4	6	3	3.4
M4.5 × 0.75		TBJ06266	TCJ06266	TDJ06266	14	70	25	6	4.9	8	3	3.8
M5 × 0.8		TBJ06286	TCJ06286	TDJ06286	15	70	25	6	4.9	8	3	4.3
M6 × 1		TBJ06316	TCJ06316	TDJ06316	17	80	30	6	4.9	8	3	5.1
M7 × 1		TBJ06346	TCJ06346	TDJ06346	17	80	30	7	5.5	8	3	6.1
M8 × 1.25		TBJ06366	TCJ06366	TDJ06366	20	90	35	8	6.2	9	3	6.9
M9 × 1.25		TBJ06396	TCJ06396	TDJ06396	20	90	35	9	7	10	3	7.9
M10 × 1.5		TBJ06426	TCJ06426	TDJ06426	22	100	39	10	8	11	3	8.6
M11 × 1.5		TBJ06466	TCJ06466	TDJ06466	22	100	40	8	6.2	9	3	9.6
M12 × 1.75		TBJ06506	TCJ06506	TDJ06506	24	110	44	9	7	10	3	10.3
M14 × 2		TBJ06546	TCJ06546	TDJ06546	26	110	44	11	9	12	3	12.1
M16 × 2		TBJ06606	TCJ06606	TDJ06606	27	110	44	12	9	12	3	14.1
M18 × 2.5		TBJ06656	TCJ06656	TDJ06656	30	125	50	14	11	14	4	15.6
M20 × 2.5		TBJ06706	TCJ06706	TDJ06706	32	140	54	16	12	15	4	17.6
M22 × 2.5		TBJ06746	TCJ06746	TDJ06746	32	140	54	18	14.5	17	4	19.6
M24 × 3		TBJ06786	TCJ06786	TDJ06786	34	160	60	18	14.5	17	4	21.1
M27 × 3		TBJ06866	TCJ06866	TDJ06866	36	160	60	20	16	19	4	24.1
M30 × 3.5		TBJ06946	TCJ06946	TDJ06946	40	180	70	22	18	21	4	26.6

►DIN 371(M2~M10) and DIN 376(M11~M30)
* The other coating(TiCN or TiAlN) is available on your request.

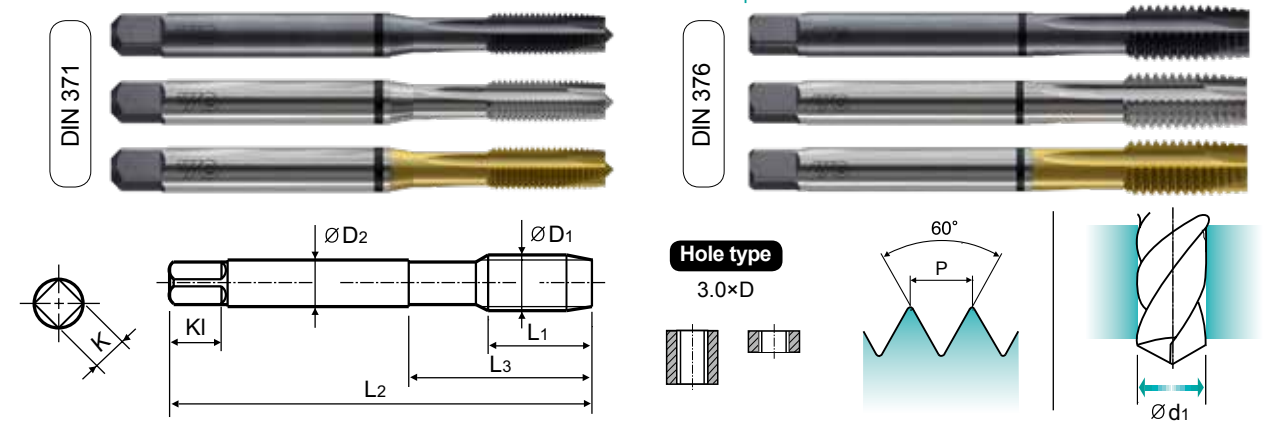
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ISO Metric coarse threads DIN 13

M

- 🇩🇪 Metrisches ISO-Gewinde DIN 13
- 🇫🇷 ISO MÉTRIQUE DIN13
- 🇮🇹 ISO Metrico passo grosso DIN 13

► Für vielfältigen Einsatz, genaue Gewindeprofile und lange Standzeit dank einer besonderen Schneidengeometrie. Von YG-1 patentiert.










Machine taps
Maschinengewindebohrer

Unit : mm

Recommended Cutting Page : P.117 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	Vap	Bright	TiN	L1	L2	L3	ØD2	K	KI	Z	Ød1
M2 × 0.4		TBJ08136	TCJ08136	TDJ08136	8	45	13	2.8	2.1	5	3	1.6
M2.2 × 0.45		TBJ08156	TCJ08156	TDJ08156	8	45	13	2.8	2.1	5	3	1.75
M2.3 × 0.4		TBJ08196	TCJ08196	TDJ08196	8	45	13	2.8	2.1	5	3	1.9
M2.5 × 0.45		TBJ08176	TCJ08176	TDJ08176	9	50	15	2.8	2.1	5	3	2.05
M2.6 × 0.45		TBJ08496	TCJ08496	TDJ08496	9	50	15	2.8	2.1	5	3	2.1
M3 × 0.5		TBJ08206	TCJ08206	TDJ08206	11	56	18	3.5	2.7	6	3	2.5
M3.5 × 0.6		TBJ08226	TCJ08226	TDJ08226	12	56	20	4	3	6	3	2.9
M4 × 0.7		TBJ08246	TCJ08246	TDJ08246	13	63	21	4.5	3.4	6	3	3.3
M4.5 × 0.75		TBJ08266	TCJ08266	TDJ08266	14	70	25	6	4.9	8	3	3.7
M5 × 0.8		TBJ08286	TCJ08286	TDJ08286	15	70	25	6	4.9	8	3	4.2
M6 × 1		TBJ08316	TCJ08316	TDJ08316	17	80	30	6	4.9	8	3	5
M7 × 1		TBJ08346	TCJ08346	TDJ08346	17	80	30	7	5.5	8	3	6
M8 × 1.25		TBJ08366	TCJ08366	TDJ08366	20	90	35	8	6.2	9	3	6.8
M9 × 1.25		TBJ08396	TCJ08396	TDJ08396	20	90	35	9	7	10	3	7.8
M10 × 1.5		TBJ08426	TCJ08426	TDJ08426	22	100	39	10	8	11	3	8.5
M11 × 1.5		TBJ08466	TCJ08466	TDJ08466	22	100	40	8	6.2	9	3	9.5
M12 × 1.75		TBJ08506	TCJ08506	TDJ08506	24	110	44	9	7	10	3	10.2
M14 × 2		TBJ08546	TCJ08546	TDJ08546	26	110	44	11	9	12	3	12
M16 × 2		TBJ08606	TCJ08606	TDJ08606	27	110	44	12	9	12	3	14
M18 × 2.5		TBJ08656	TCJ08656	TDJ08656	30	125	50	14	11	14	4	15.5
M20 × 2.5		TBJ08706	TCJ08706	TDJ08706	32	140	54	16	12	15	4	17.5
M22 × 2.5		TBJ08746	TCJ08746	TDJ08746	32	140	54	18	14.5	17	4	19.5
M24 × 3		TBJ08786	TCJ08786	TDJ08786	34	160	60	18	14.5	17	4	21
M27 × 3		TBJ08866	TCJ08866	TDJ08866	36	160	60	20	16	19	4	24
M30 × 3.5		TBJ08946	TCJ08946	TDJ08946	40	180	70	22	18	21	4	26.5

► DIN 371(M2~M10) and DIN 376(M11~M30)
* The other coating(TiCN or TiAlN) is available on your request.

◎ : Excellent ○ : Good

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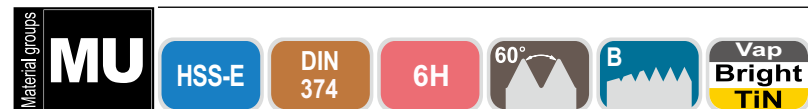
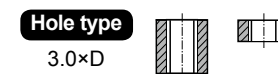
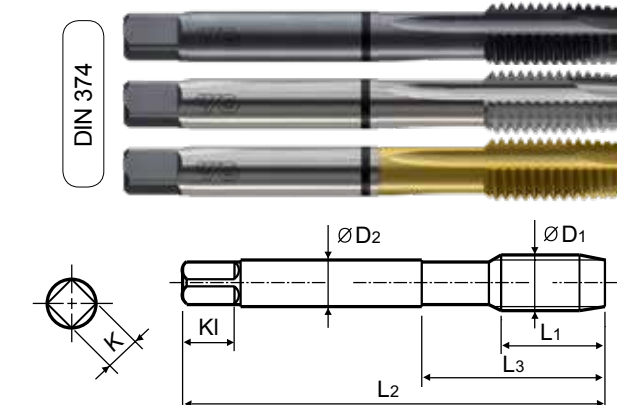
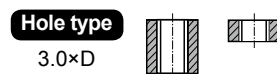
The logo for WEG COMBO TAPS is displayed on the left, featuring the WEG logo and the text "COMBO TAPS". To the right, a table lists the product series:

Vap	TB854 SERIES
Bright	TC854 SERIES
TiN	TD854 SERIES

MF **ISO Metric fine threads DIN 13**

- **Metrisches ISO-Feingewinde DIN 13**
- **ISO MÉTRIQUE PAS FINS DIN13**
- **ISO Metrico passo grosso DIN 13**

► Für vielfältigen Einsatz, genaue Gewindeprofile und lange Standzeit dank einer besonderen Schneidengeometrie. Von YG-1 patentiert.



Unit : mm

Recommended Cutting Page : P.116

SIZE	Pitch	EDP No.			Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1	P	Vap	Bright	TiN	L1	L2	L3	ØD2	K	KI	Z	Ød1
M20 × 1.5		TB854726	TC854726	TD854726	25	125	50	16	12	15	4	18.5
M20 × 1		TB854736	TC854736	TD854736	20	125	50	16	12	15	4	19
M22 × 1.5		TB854766	TC854766	TD854766	25	125	50	18	14.5	17	4	20.5
M22 × 1		TB854776	TC854776	TD854776	20	125	50	18	14.5	17	4	21
M24 × 2		TB854796	TC854796	TD854796	27	140	54	18	14.5	17	4	22
M24 × 1.5		TB854806	TC854806	TD854806	27	140	54	18	14.5	17	4	22.5
M26 × 1.5		TB854856	TC854856	TD854856	28	140	54	18	14.5	17	4	24.5
M27 × 2		TB854876	TC854876	TD854876	28	140	54	20	16	19	4	25
M27 × 1.5		TB854886	TC854886	TD854886	28	140	54	20	16	19	4	25.5
M28 × 1.5		TB854916	TC854916	TD854916	28	140	54	20	16	19	4	26.5
M30 × 2		TB854966	TC854966	TD854966	30	150	57	22	18	21	4	28
M30 × 1.5		TB854976	TC854976	TD854976	30	150	57	22	18	21	4	28.5

* The other coating(TiCN or TiAlN) is available on your request.

* The other coating(TiCN or TiAlN) is available on your request.

▶ NEXT PAGE

◎ : Excellent ○ : Good

[illegible]

100 phone:+82-32-526-0909, www.yg1.kr, E-mail:yg1@yg1.kr

YG-1 CO., LTD.

◎ : Excellent ○ : Good

[illegible]

YG-1 CO., LTD.

phone:+82-32-526-0909, www.yg1.kr, E-mail:yg1@yg1.kr



COMBO TAPS

Bright

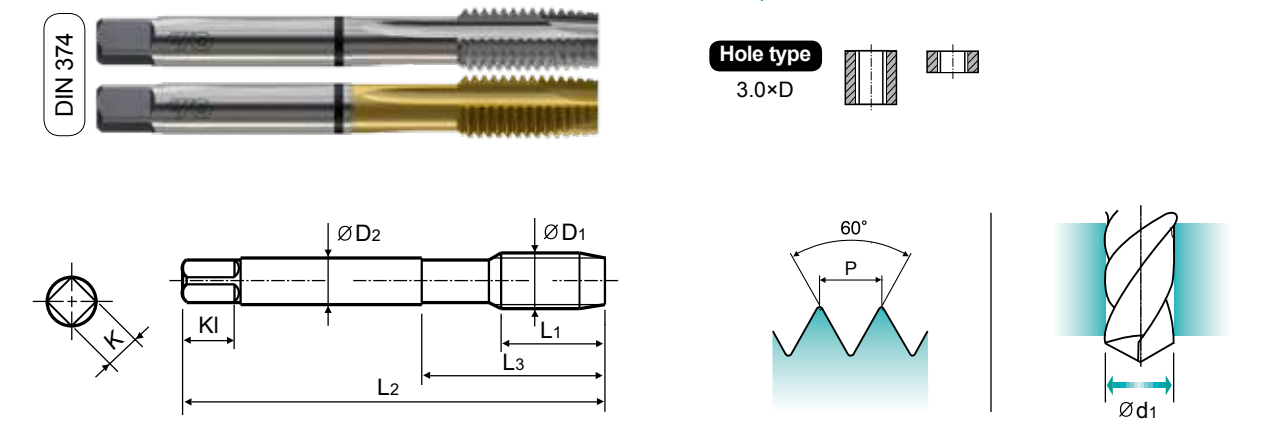
TiN

TCJ09 SERIES

TDJ09 SERIES

MF **ISO Metric fine threads DIN 13**
 🇩🇪 Metrisches ISO-Feingewinde DIN 13
 🇫🇷 ISO MÉTRIQUE PAS FINS DIN13
 🇮🇹 ISO Metrico passo grosso DIN 13

► For using multi-purpose and correct thread profiles & long tool life due to special tap geometry. YG-1 company has a patent.










Machine taps
Maschinengewindebohrer

Recommended Cutting Page : P.116

SIZE	Pitch	EDP No.		Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD ₁	P	Bright	TiN	L ₁	L ₂	L ₃	ØD ₂	K	KI	Z	Ød ₁
M20 × 1.5		TCJ09726	TDJ09726	25	125	50	16	12	15	4	18.5
M20 × 1		TCJ09736	TDJ09736	20	125	50	16	12	15	4	19
M22 × 1.5		TCJ09766	TDJ09766	25	125	50	18	14.5	17	4	20.5
M22 × 1		TCJ09776	TDJ09776	20	125	50	18	14.5	17	4	21
M24 × 2		TCJ09796	TDJ09796	27	140	54	18	14.5	17	4	22
M24 × 1.5		TCJ09806	TDJ09806	27	140	54	18	14.5	17	4	22.5
M26 × 1.5		TCJ09856	TDJ09856	28	140	54	18	14.5	17	4	24.5
M27 × 2		TCJ09876	TDJ09876	28	140	54	20	16	19	4	25
M27 × 1.5		TCJ09886	TDJ09886	28	140	54	20	16	19	4	25.5
M28 × 1.5		TCJ09916	TDJ09916	28	140	54	20	16	19	4	26.5
M30 × 2		TCJ09966	TDJ09966	30	150	57	22	18	21	4	28
M30 × 1.5		TCJ09976	TDJ09976	30	150	57	22	18	21	4	28.5

* The other coating(TiCN or TiAlN) or Surface Treatment(Steam Homo) is available on your request.

[illegible]



YG YG-1 CO., LTD. phone:+82-32-526-0909, www.yg1.kr, E-mail:yg1@yg1.kr **105**

CARBIDE

HSS

COMBO TAPS

TQ428 SERIES

TB428 SERIES

M

ISO Metric coarse threads DIN 13

Metrisches ISO-Gewinde DIN 13

ISO MÉTRIQUE DIN13

ISO Metrico passo grosso DIN 13

For stainless steels and correct thread profiles & long tool life due to special tap geometry. YG-1 company has a patent.

Für rostfreie stähle, genaue Gewindeprofile und lange Standzeitendank einer besonderen Schneidengeometrie. Von YG-1 patentiert.

DIN 371

DIN 376

Hole type

3.0×D

VA

up to M12

over M12

HSS-PM

HSS-E

DIN 371/376

6H

60°

B

Vap

Machine taps

Maschinengewindebohrer

Recommended Cutting Page : P.117

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	Vap	L1	L2	L3	ØD2	K	KI	Z	Ød1
M2 × 0.4		TQ428136	8	45	13	2.8	2.1	5	3	1.6
M2.2 × 0.45		TQ428156	8	45	13	2.8	2.1	5	3	1.75
M2.3 × 0.4		TQ428196	8	45	13	2.8	2.1	5	3	1.9
M2.5 × 0.45		TQ428176	9	50	15	2.8	2.1	5	3	2.05
M2.6 × 0.45		TQ428496	9	50	15	2.8	2.1	5	3	2.1
M3 × 0.5		TQ428206	11	56	18	3.5	2.7	6	3	2.5
M3.5 × 0.6		TQ428226	12	56	20	4	3	6	3	2.9
M4 × 0.7		TQ428246	13	63	21	4.5	3.4	6	3	3.3
M4.5 × 0.75		TQ428266	14	70	25	6	4.9	8	3	3.7
M5 × 0.8		TQ428286	15	70	25	6	4.9	8	3	4.2
M6 × 1		TQ428316	17	80	30	6	4.9	8	3	5
M7 × 1		TQ428346	17	80	30	7	5.5	8	3	6
M8 × 1.25		TQ428366	20	90	35	8	6.2	9	3	6.8
M9 × 1.25		TQ428396	20	90	35	9	7	10	3	7.8
M10 × 1.5		TQ428426	22	100	39	10	8	11	3	8.5
M11 × 1.5		TQ428466	22	100	40	8	6.2	9	3	9.5
M12 × 1.75		TQ428506	24	110	44	9	7	10	3	10.2
M14 × 2		TB428546	26	110	44	11	9	12	3	12
M16 × 2		TB428606	27	110	44	12	9	12	3	14
M18 × 2.5		TB428656	30	125	50	14	11	14	4	15.5
M20 × 2.5		TB428706	32	140	54	16	12	15	4	17.5
M22 × 2.5		TB428746	32	140	54	18	14.5	17	4	19.5
M24 × 3		TB428786	34	160	60	18	14.5	17	4	21
M27 × 3		TB428866	36	160	60	20	16	19	4	24
M30 × 3.5		TB428946	40	180	70	22	18	21	4	26.5

►DIN 371(M2~M10) and DIN 376(M11~M30)

►HSS-PM(M2~M12/TQ428) and HSS-E(M14~M30/TB428)

* Coating(TiN, TiCN or TiAlN) is available on your request.

◎ : Excellent ○ : Good

ISO	P										M					K				
Material Description	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel					Stainless steel				
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				
Material Description	Aluminum-wrought alloy					Aluminum-cast, alloyed					Copper and Copper Alloys (Bronze / Brass)					Non Metallic Materials				
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40
HRC	21										15	30	25	38	34			55	60	42
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400
Recommended																				

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YG-1 CO., LTD.

CARBIDE

HSS

COMBO TAPS

TQ438 SERIES

MF

ISO Metric fine threads DIN 13

Metrisches ISO-Feingewinde DIN 13

ISO MÉTRIQUE PAS FINS DIN13

ISO Metrico passo grosso DIN 13

For stainless steels and correct thread profiles & long tool life due to special tap geometry. YG-1 company has a patent.

Für rostfreie stähle, genaue Gewindeprofile und lange Standzeitendank einer besonderen Schneidengeometrie. Von YG-1 patentiert.

DIN 374

Hole type

3.0×D

VA

HSS-PM

DIN 374

6H

60°

B

Vap

Machine taps

Maschinengewindebohrer

Recommended Cutting Page : P.117

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	Vap	L1	L2	L3	ØD2	K	KI	Z	Ød1
M4 × 0.5		TQ438256	10	63	21	2.8	2.1	5	3	3.5
M5 × 0.5		TQ438296	11	70	25	3.5	2.7	6	3	4.5
M6 × 0.75		TQ438326	13	80	30	4.5	3.4	6	3	5.2
M6 × 0.5		TQ438336	13	80	30	4.5	3.4	6	3	5.5
M7 × 0.75		TQ438356	14	80	30	5.5	4.3	7	3	6.2
M8 × 1		TQ438376	17	90	36	6	4.9	8	3	7
M8 × 0.75		TQ438386	14	80	30	6	4.9	8	3	7.2
M10 × 1.25		TQ438436	22	100	40	7	5.5	8	3	8.8
M10 × 1		TQ438446	18	90	36	7	5.5	8	3	9
M10 × 0.75		TQ438456	18	90	36	7	5.5	8	3	9.2
M12 × 1.5		TQ438516	22	100	40	9	7	10	3	10.5
M12 × 1.25		TQ438526	22	100	40	9	7	10	3	10.8
M12 × 1		TQ438536	18	100	40	9	7	10	3	11

* Coating(TiN, TiCN or TiAlN) is available on your request.

◎ : Excellent ○ : Good

ISO	P										M					K				
Material Description	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel					Stainless steel				
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				
Material Description	Aluminum-wrought alloy					Aluminum-cast, alloyed					Copper and Copper Alloys (Bronze / Brass)					Non Metallic Materials				
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40
HRC	21										15	30	25	38	34			55	60	42
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400
Recommended																				

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YG-1 CO., LTD.

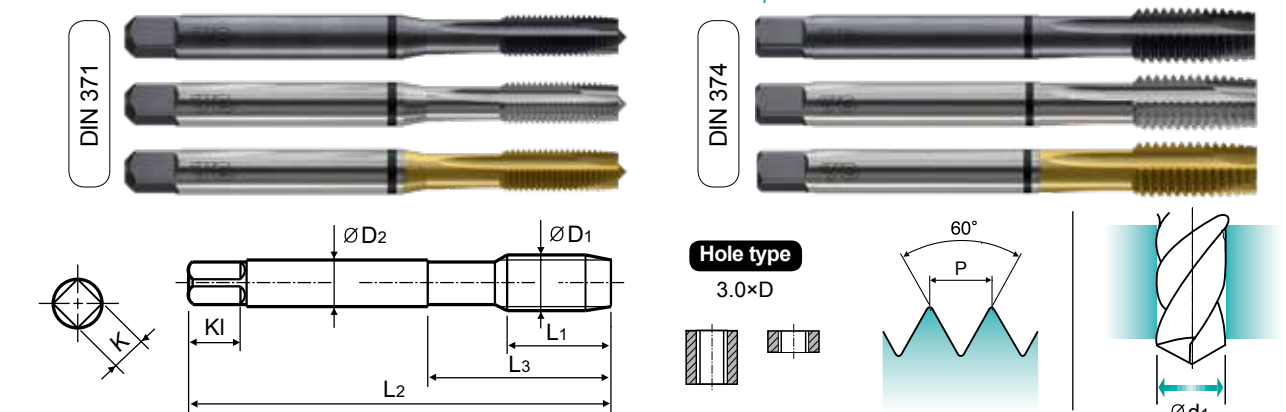
108 phone:+82-32-526-0909, www.yg1.kr, E-mail:yg1@yg1.kr **YG-1 CO., LTD.**

YG-1 CO., LTD. phone:+82-32-526-0909, www.yg1.kr, E-mail:yg1@yg1.kr **109**

UNF Unified fine threads

- 🇩🇪 Unified Feingewindea
- 🇫🇷 UNF
- 🇮🇹 Unificato passo grosso

► Für vielfältigen Einsatz, genaue Gewindeprofile und lange Standzeit dank einer besonderen Schneidengeometrie. Von YG-1 patentiert.










Machine taps
Maschinengewindebohrer

Unit : mm

Recommended Cutting Page : P.116

SIZE	TPI	EDP No.			Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
		Vap	Bright	TiN	L1	L2	L3	ØD2	K	KI	Z	Ød1
#4 - 48 UNF		TB874182	TC874182	TD874182	11	56	18	3.5	2.7	6	3	2.4
#5 - 44 UNF		TB874222	TC874222	TD874222	11	56	18	3.5	2.7	6	3	2.7
#6 - 40 UNF		TB874262	TC874262	TD874262	12	56	20	4	3	6	3	3
#8 - 36 UNF		TB874302	TC874302	TD874302	13	63	21	4.5	3.4	6	3	3.5
#10 - 32 UNF		TB874342	TC874342	TD874342	15	70	25	6	4.9	8	3	4.1
#12 - 28 UNF		TB874382	TC874382	TD874382	16	80	30	6	4.9	8	3	4.7
1/4 - 28 UNF		TB874422	TC874422	TD874422	17	80	30	7	5.5	8	3	5.5
5/16 - 24 UNF		TB874462	TC874462	TD874462	17	90	35	8	6.2	9	3	6.9
3/8 - 24 UNF		TB874502	TC874502	TD874502	18	100	39	9	7	10	3	8.5
7/16 - 20 UNF		TB874542	TC874542	TD874542	22	100	40	8	6.2	9	3	9.9
1/2 - 20 UNF		TB874582	TC874582	TD874582	22	100	40	9	7	10	3	11.5
9/16 - 18 UNF		TB874622	TC874622	TD874622	22	100	40	11	9	12	3	12.9
5/8 - 18 UNF		TB874662	TC874662	TD874662	22	100	40	12	9	12	3	14.5
3/4 - 16 UNF		TB874722	TC874722	TD874722	25	110	44	14	11	14	4	17.5
7/8 - 14 UNF		TB874762	TC874762	TD874762	26	125	50	18	14.5	17	4	20.5
1 - 12 UNF		TB874802	TC874802	TD874802	28	140	54	20	16	19	4	23.25

▶DIN 371(#4~3/8) and DIN 374(7/16~1)

* The other coating(TiCN or TiAlN) is available on your request.

◎: Excellent ○: Good

[illegible]

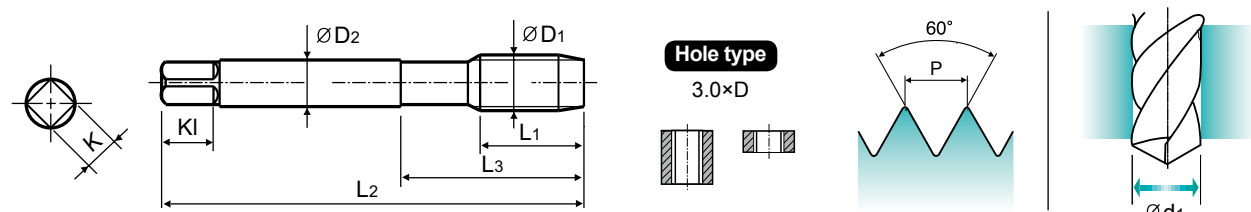
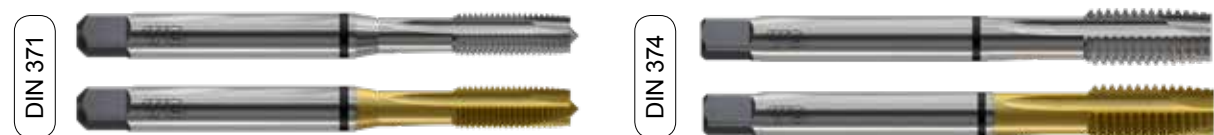

COMBO TAPS

Bright	TCJ02 SERIES
TiN	TDJ02 SERIES

UNF Unified fine threads

-  Unified Grobgewinde
-  UNF
-  Unificato passo grosso

► For using multi-purpose and correct thread profiles & long tool life due to special tap geometry. YG-1 company has a patent.



Material groups **MU** HSS-E DIN 371/374 3B 60° B Bright TiN Machine taps Maschinengewindebohrer

Recommended Cutting Page : P.116

Recommended Cutting Page : P.116 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		Bright	TiN	L1	L2	L3	ØD2	K	KI	Z	Ød1
#4 - 48 UNF		TCJ02182	TDJ02182	11	56	18	3.5	2.7	6	3	2.4
#5 - 44 UNF		TCJ02222	TDJ02222	11	56	18	3.5	2.7	6	3	2.7
#6 - 40 UNF		TCJ02262	TDJ02262	12	56	20	4	3	6	3	3
#8 - 36 UNF		TCJ02302	TDJ02302	13	63	21	4.5	3.4	6	3	3.5
#10 - 32 UNF		TCJ02342	TDJ02342	15	70	25	6	4.9	8	3	4.1
#12 - 28 UNF		TCJ02382	TDJ02382	16	80	30	6	4.9	8	3	4.7
1/4 - 28 UNF		TCJ02422	TDJ02422	17	80	30	7	5.5	8	3	5.5
5/16 - 24 UNF		TCJ02462	TDJ02462	17	90	35	8	6.2	9	3	6.9
3/8 - 24 UNF		TCJ02502	TDJ02502	18	100	39	9	7	10	3	8.5
7/16 - 20 UNF		TCJ02542	TDJ02542	22	100	40	8	6.2	9	3	9.9
1/2 - 20 UNF		TCJ02582	TDJ02582	22	100	40	9	7	10	3	11.5
9/16 - 18 UNF		TCJ02622	TDJ02622	22	100	40	11	9	12	3	12.9
5/8 - 18 UNF		TCJ02662	TDJ02662	22	100	40	12	9	12	3	14.5
3/4 - 16 UNF		TCJ02722	TDJ02722	25	110	44	14	11	14	4	17.5
7/8 - 14 UNF		TCJ02762	TDJ02762	26	125	50	18	14.5	17	4	20.5
1 - 12 UNF		TCJ02802	TDJ02802	28	140	54	20	16	19	4	23.25

* The other coating(TiCN or TiAlN) or Surface Treatment(Steam Homo) is available on your request.

[illegible]
COMBO TAPS

Combo Spiral Flute Tap Set



Set No.	Series	Surface Treatment	Size	Quantity
TB804SET5	TB804	VAP	M5, M6, M8, M10, M12	5 pcs
TC804SET7	TC804	Bright	M3, M4, M5, M6, M8, M10, M12	7 pcs

Combo Spiral Flute Tap + Gold-P Drill
(HSS-E, DIN 338, Straight Shank, 135° Split Point, Jobber Length) Set



Set No.	Series	Surface Treatment	Size							Quantity
TD804SET7-GLP195	TD804	TiN	M3	M4	M5	M6	M8	M10	M12	14pcs
	DLGP195	TiN	2.5	3.3	4.2	5	6.8	8.5	10.2	



RECOMMENDED CUTTING CONDITIONS EMPFOHLENE SCHNEIDKONDITIONEN

					TC804 TC844 TC824 TC864	TD804 TD844 TD824 TD864	TB804 TB844 TB824 TB864	TCE05 TCE09 TCE01 TCE02	TDE05 TDE09 TDE01 TDE02	TBE05	TCE06	TDE06
ISO	VDI 3323	Material Description	HB	HRc	Vc (m/min)							
P	1	Non-alloy steel	125		15-20	20-25	15-20	15-20	20-25	15-20	15-20	20-25
	2		190	13	15-20	20-25	15-20	15-20	20-25	15-20	15-20	20-25
	3		250	25	12-18	18-24	12-18	12-18	18-24	12-18	12-18	18-24
	4		270	28	10-15	15-20	10-15	10-15	15-20	10-15	10-15	15-20
	5		300	32	6-10	10-14	6-10	6-10	10-14	6-10	6-10	10-14
	6	Low alloy steel	180	10	10-15	15-20	10-15	10-15	15-20	10-15	10-15	15-20
	7		275	29	10-15	15-20	10-15	10-15	15-20	10-15	10-15	15-20
	8		300	32	6-10	10-14	6-10	6-10	10-14	6-10	6-10	10-14
	9		350	38	3-5	5-7	3-5	3-5	5-7	3-5	3-5	5-7
	10	High alloyed steel, and tool steel	200	15	3-5	5-7	3-5	3-5	5-7	3-5	3-5	5-7
	11		325	35								
M	12	Stainless steel	200	15	7-10	10-15	7-10	7-10	10-15	7-10	7-10	10-15
	13		240	23	5-8	8-11	5-8	5-8	8-11	5-8	5-8	8-11
	14		180	10	4-6	6-8	4-6	4-6	6-8	4-6	4-6	6-8
K	15	Grey cast iron	180	10	10-15	15-20	10-15	10-15	15-20	10-15	10-15	15-20
	16		260	26	5-8	8-11	5-8	5-8	8-11	5-8	5-8	8-11
	17	Nodular cast iron	160	3	10-15	15-20	10-15	10-15	15-20	10-15	10-15	15-20
	18		250	25	5-8	8-11	5-8	5-8	8-11	5-8	5-8	8-11
	19	Malleable cast iron	130									
	20		230	21								
N	21	Aluminum- wrought alloy	60									
	22		100									
	23	Aluminum- cast, alloyed	75		15-20	20-25	15-20	15-20	20-25	15-20	15-20	20-25
	24		90									
	25		130									
	26	Copper and Copper Alloys (Bronze / Brass)	110		25-35	35-40	25-35	25-35	35-40	25-35	25-35	35-40
	27		90	8-12	12-17	8-12	8-12	12-17	8-12	8-12	12-17	
	28		100	15-20	20-25	15-20	15-20	20-25	15-20	15-20	20-25	
	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								
	41	Hardened Cast Iron	550	55								



RECOMMENDED CUTTING CONDITIONS EMPFOHLENE SCHNEIDKONDITIONEN

[illegible]



RECOMMENDED CUTTING CONDITIONS EMPFOHLENE SCHNEIDKONDITIONEN

					TB744 TB754 TQ744 TQ754	TC814 TC854 TC834 TC874	TD814 TD854 TD834 TD874	TB814 TB854 TB834 TB874	TCJ05 TCJ09 TCJ01 TCJ02	TDJ05 TDJ09 TDJ01 TDJ02	TBJ05	TCJ06
					Vc (m/min)							
ISO	VDI 3323	Material Description	HB	HRc								
COMBO TAPS	1	Non-alloy steel	125			15-20	20-25	15-20	15-20	20-25	15-20	15-20
	2		190	13	15-20	15-20	20-25	15-20	15-20	20-25	15-20	15-20
3	250		25		12-18	18-24	12-18	12-18	18-24	12-18	12-18	
4	270		28	10-15	10-15	15-20	10-15	10-15	15-20	10-15	10-15	
5	300		32		6-10	10-14	6-10	6-10	10-14	6-10	6-10	
YG TAP GENERAL	6	Low alloy steel	180	10	10-15	10-15	15-20	10-15	10-15	15-20	10-15	10-15
YG TAP STEEL	7		275	29	10-15	10-15	15-20	10-15	10-15	15-20	10-15	10-15
	8		300	32		6-10	10-14	6-10	6-10	10-14	6-10	6-10
YG TAP HARDENED	9		350	38		3-5	5-7	3-5	3-5	5-7	3-5	3-5
YG TAP INOX	10		High alloyed steel, and tool steel	200	15		3-5	5-7	3-5	3-5	5-7	3-5
	11	325		35								
YG TAP CAST IRON	12	Stainless steel	200	15	7-10	7-10	10-15	7-10	7-10	10-15	7-10	7-10
	13		240	23	5-8	5-8	8-11	5-8	5-8	8-11	5-8	5-8
	14		180	10	4-6	4-6	6-8	4-6	4-6	6-8	4-6	4-6
YG TAP ALU	15	Grey cast iron	180	10		10-15	15-20	10-15	10-15	15-20	10-15	10-15
	16		260	26		5-8	8-11	5-8	5-8	8-11	5-8	5-8
YG TAP Ti Ni	17	Nodular cast iron	160	3		10-15	15-20	10-15	10-15	15-20	10-15	10-15
	18		250	25		5-8	8-11	5-8	5-8	8-11	5-8	5-8
	19	Malleable cast iron	130									
20	230		21									
YG TAP FORMING	21	Aluminum-wrought alloy	60									
NUT TAPS	22		100									
	23	Aluminum-cast, alloyed	75			15-20	20-25	15-20	15-20	20-25	15-20	15-20
	24		90									
STI TAPS	25		130									
	26		110		25-35	35-40	25-35	25-35	35-40	25-35	25-35	
PIPE TAPS	27	Copper and Copper Alloys (Bronze / Brass)	90			8-12	12-17	8-12	8-12	12-17	8-12	8-12
	28		100	15-20	15-20	20-25	15-20	15-20	20-25	15-20	15-20	
	TECHNICAL DATA	29	Non Metallic Materials									
30												
	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									
		38	Hardened steel	550	55							
39		630		60								
40		Chilled Cast Iron	400	42								
41		Hardened Cast Iron	550	55								



RECOMMENDED CUTTING CONDITIONS EMPFOHLENE SCHNEIDKONDITIONEN

[illegible]