



Leading Through Innovation

HSS-E

COMBO TAP

COMBO GEWINDEBOHRER

- For Multi Purpose Tapping
- Für Mehrbereichs-Gewindebohren

CARBIDE

HSS

THREAD MILL

SYNCHRO TAP

PRIME TAP

COMBO TAP

YG TAP STEEL

YG TAP CHIP BREAKER

YG TAP INOX

YG TAP CAST IRON

YG TAP HARDENED STEEL

YG TAP Ti Ni

YG TAP ALU

YG TAP FORMING

YG TAP GENERAL

PIPE TAP

STI TAP

NUT TAP

SELECTION GUIDE



HSS-E
COMBO
TAP

HSS-E TAPS for Multi-Purpose

Please visit globalyg1.com/mat for material search

© : Excellent ○ : Good

Recommended cutting conditions : p.B130

ISO	VDI 3323	Material Description	Composition / Structure / Heat Treatment		HB	HRC						
P	1	Non-alloy steel	About 0.15% C	Annealed	125		○	○	○	○	○	○
	2		About 0.45% C	Annealed	190	13	◎	◎	◎	◎	◎	◎
	3		About 0.45% C	Quenched & Tempered	250	25	◎	◎	◎	◎	◎	◎
	4		About 0.75% C	Annealed	270	28	◎	◎	◎	◎	◎	◎
	5		About 0.75% C	Quenched & Tempered	300	32	◎	◎	◎	◎	◎	◎
	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	Malleable cast iron	Ferritic		130							
	20		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		Ni or Co Based	Annealed	250	25						
	34			Cured	350	38						
	35			Cast	320	34						
	36	Titanium Alloys	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						

HSS-E												
C	C	C	C	C	C	C	C	C	C	C	E	
Spiral Flute	Spiral Flute	Spiral Flute	Spiral Flute	Spiral Flute	Spiral Flute	Spiral Flute	Spiral Flute	Spiral Flute	Spiral Flute	Spiral Flute	Spiral Flute	
R40	R40	R40	R40	R40	R40	R40	R40	R40	R40	R40	R40	
TCE06 (p.897)	TDE06 (p.897)	TBE06 (p.897)	TCE07 (p.898)	TDE07 (p.898)	TBE07 (p.898)	TCE08 (p.899)	TDE08 (p.899)	TBE08 (p.899)	TC804-IC (p.8105)		TC807 (p.8106)	M
										TC633 (p.8107)		MF
												UNC
												UNF
												BSW
												G(BSP)
												EG-M
												EG-UNC
												EG-UNF
Bright	TIN	VAP	Bright	TIN	VAP	Bright	TIN	VAP	Bright	Bright	Bright	
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	1
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	2
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	3
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	4
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◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	6
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◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	13
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◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	27
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	28
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HSS-E TAPS for Multi-Purpose

[illegible]

M

ISO Metric coarse threads DIN 13

Metrisches ISO-Gewinde DIN 13

ISO MÉTRIQUE DIN13

ISO Metrico passo grosso DIN 13

Machine taps
Maschinengewindebohrer

► 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
2.5xD

MU

HSS-E

DIN 371/376

4H

60°

C

R40

Vap Bright

TiN

p.B130

M

ISO Metric coarse threads DIN 13

Metrisches ISO-Gewinde DIN 13

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DIN 371

DIN 376

Hole type
2.5xD

MU

HSS-E

DIN 371/376

6H+0.1

60°

C

R40

Vap Bright

TiN

p.B130

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	TBE05136	TCE05136	TDE05136	8	45	13	2.8	2.1	5	3	1.6
M2.2	× 0.45	TBE05156	TCE05156	TDE05156	8	45	13	2.8	2.1	5	3	1.75
M2.3	× 0.4	TBE05196	TCE05196	TDE05196	8	45	13	2.8	2.1	5	3	1.9
M2.5	× 0.45	TBE05176	TCE05176	TDE05176	9	50	15	2.8	2.1	5	3	2.05
M2.6	× 0.45	TBE05496	TCE05496	-	9	50	15	2.8	2.1	5	3	2.1
M3	× 0.5	TBE05206	TCE05206	TDE05206	6	56	18	3.5	2.7	6	3	2.5
M3.5	× 0.6	TBE05226	TCE05226	TDE05226	7	56	20	4	3	6	3	2.9
M4	× 0.7	TBE05246	TCE05246	TDE05246	7	63	21	4.5	3.4	6	3	3.3
M4.5	× 0.75	TBE05266	TCE05266	TDE05266	8	70	25	6	4.9	8	3	3.7
M5	× 0.8	TBE05286	TCE05286	TDE05286	8	70	25	6	4.9	8	3	4.2
M6	× 1.0	TBE05316	TCE05316	TDE05316	10	80	30	6	4.9	8	3	5
M7	× 1.0	TBE05346	TCE05346	TDE05346	10	80	30	7	5.5	8	3	6
M8	× 1.25	TBE05366	TCE05366	TDE05366	13	90	35	8	6.2	9	3	6.8
M9	× 1.25	TBE05396	TCE05396	TDE05396	13	90	35	9	7	10	3	7.8
M10	× 1.5	TBE05426	TCE05426	TDE05426	15	100	39	10	8	11	3	8.5
M11	× 1.5	TBE05466	TCE05466	TDE05466	17	100	40	8	6.2	9	3	9.5
M12	× 1.75	TBE05506	TCE05506	TDE05506	18	110	44	9	7	10	3	10.2
M14	× 2.0	-	TCE05546	TDE05546	20	110	44	11	9	12	3	12
M16	× 2.0	TBE05606	TCE05606	TDE05606	20	110	44	12	9	12	3	14
M18	× 2.5	TBE05656	TCE05656	TDE05656	25	125	50	14	11	14	4	15.5
M20	× 2.5	TBE05706	TCE05706	TDE05706	25	140	54	16	12	15	4	17.5
M22	× 2.5	TBE05746	TCE05746	TDE05746	25	140	54	18	14.5	17	4	19.5
M24	× 3.0	TBE05786	TCE05786	TDE05786	30	160	60	18	14.5	17	4	21
M27	× 3.0	TBE05866	TCE05866	TDE05866	30	160	60	20	16	19	4	24
M30	× 3.5	TBE05946	TCE05946	TDE05946	35	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

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

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

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

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	TBE06136	TCE06136	TDE06136	8	45	13	2.8	2.1	5	3	1.7
M2.2	× 0.45	TBE06156	TCE06156	TDE06156	8	45	13	2.8	2.1	5	3	1.85
M2.3	× 0.4	TBE06196	TCE06196	TDE06196	8	45	13	2.8	2.1	5	3	2
M2.5	× 0.45	-	TCE06176	TDE06176	9	50	15	2.8	2.1	5	3	2.15
M2.6	× 0.45	TBE06496	TCE06496	TDE06496	9	50	15	2.8	2.1	5	3	2.2
M3	× 0.5	TBE06206	TCE06206	-	6	56	18	3.5	2.7	6	3	2.6
M3.5	× 0.6	TBE06226	TCE06226	TDE06226	7	56	20	4	3	6	3	3
M4	× 0.7	TBE06246	TCE06246	TDE06246	7	63	21	4.5	3.4	6	3	3.4
M4.5	× 0.75	TBE06266	TCE06266	TDE06266	8	70	25	6	4.9	8	3	3.8
M5	× 0.8	TBE06286	TCE06286	TDE06286	8	70	25	6	4.9	8	3	4.3
M6	× 1.0	TBE06316	TCE06316	TDE06316	10	80	30	6	4.9	8	3	5.1
M7	× 1.0	TBE06346	TCE06346	TDE06346	10	80	30	7	5.5	8	3	6.1
M8	× 1.25	TBE06366	TCE06366	TDE06366	13	90	35	8	6.2	9	3	6.9
M9	× 1.25	TBE06396	TCE06396	TDE06396	13	90	35	9	7	10	3	7.9
M10	× 1.5	TBE06426	TCE06426	TDE06426	15	100	39	10	8	11	3	8.6
M11	× 1.5	TBE06466	TCE06466	TDE06466	17	100	40	8	6.2	9	3	9.6
M12	× 1.75	TBE06506	TCE06506	TDE06506	18	110	44	9	7	10	3	10.3
M14	× 2.0	TBE06546	TCE06546	TDE06546	20	110	44	11	9	12	3	12.1
M16	× 2.0	TBE06606	TCE06606	TDE06606	20	110	44	12	9	12	3	14.1
M18	× 2.5	TBE06656	TCE06656	TDE06656	25	125	50	14	11	14	4	15.6
M20	× 2.5	TBE06706	TCE06706	TDE06706	25	140	54	16	12	15	4	17.6
M22	× 2.5	TBE06746	TCE06746	TDE06746	25	140	54	18	14.5	17	4	19.6
M24	× 3.0	-	TCE06786	TDE06786	30	160	60	18	14.5	17	4	21.1
M27	× 3.0	TBE06866	TCE06866	TDE06866	30	160	60	20	16	19	4	24.1
M30	× 3.5	TBE06946	TCE06946	TDE06946	35	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.

◎ : Excellent ○ : Good

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

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

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

M

ISO Metric coarse threads DIN 13

Metrisches ISO-Gewinde DIN 13

ISO MÉTRIQUE DIN13

ISO Metrico passo grosso DIN 13

Machine taps
Maschinengewindebohrer

► 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

MU

HSS-E

DIN 371/376

6G

60°

C

R40

Vap Bright

TiN

p.B130

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	-	-	TCE07136	-	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	3	1.75
M2.3 × 0.4	TBE07196	TCE07196	TDE07196	8	45	13	2.8	2.1	5	3	3	1.9
M2.5 × 0.45	-	-	TCE07176	-	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	3	2.1
M3 × 0.5	TBE07206	TCE07206	TDE07206	6	56	18	3.5	2.7	6	3	3	2.5
M3.5 × 0.6	-	-	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	3.3
M4.5 × 0.75	TBE07266	TCE07266	TDE07266	8	70	25	6	4.9	8	3	3	3.7
M5 × 0.8	TBE07286	TCE07286	TDE07286	8	70	25	6	4.9	8	3	3	4.2
M6 × 1.0	TBE07316	TCE07316	TDE07316	10	80	30	6	4.9	8	3	3	5
M7 × 1.0	TBE07346	TCE07346	TDE07346	10	80	30	7	5.5	8	3	3	6
M8 × 1.25	TBE07366	TCE07366	TDE07366	13	90	35	8	6.2	9	3	3	6.8
M9 × 1.25	TBE07396	TCE07396	-	13	90	35	9	7	10	3	3	7.8
M10 × 1.5	TBE07426	TCE07426	TDE07426	15	100	39	10	8	11	3	3	8.5
M11 × 1.5	TBE07466	TCE07466	TDE07466	17	100	40	8	6.2	9	3	3	9.5
M12 × 1.75	TBE07506	TCE07506	TDE07506	18	110	44	9	7	10	3	3	10.2
M14 × 2.0	TBE07546	TCE07546	-	20	110	44	11	9	12	3	3	12
M16 × 2.0	TBE07606	TCE07606	TDE07606	20	110	44	12	9	12	3	3	14
M18 × 2.5	TBE07656	TCE07656	TDE07656	25	125	50	14	11	14	4	4	15.5
M20 × 2.5	TBE07706	TCE07706	-	25	140	54	16	12	15	4	4	17.5
M22 × 2.5	TBE07746	TCE07746	TDE07746	25	140	54	18	14.5	17	4	4	19.5
M24 × 3.0	TBE07786	TCE07786	-	30	160	60	18	14.5	17	4	4	21
M27 × 3.0	TBE07866	TCE07866	TDE07866	30	160	60	20	16	19	4	4	24
M30 × 3.5	TBE07946	TCE07946	TDE07946	35	180	70	22	18	21	4	4	26.5

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

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

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				
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	○	◎	◎	◎	◎	◎	◎	◎	◎	○	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎															

	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	31	32	33	34	35	36	37	38	39	40	41																								
HB	60	100	75	90	130	110	90	100			15	30	25	38	34	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

Machine taps
Maschinengewindebohrer

► 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

MU

HSS-E

DIN 371/376

7G

60°

C

R40

Vap Bright

TiN

p.B130

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	-	TBE08136	TCE08136	TDE08136	8	45	13	2.8	2.1	5	3	1.6
M2.2 × 0.45	TBE08156	TCE08156	TDE08156	8	45	13	2.8	2.1	5	3	3	1.75
M2.3 × 0.4	TBE08196	TCE08196	TDE08196	8	45	13	2.8	2.1	5	3	3	1.9
M2.5 × 0.45	TBE08176	TCE08176	TDE08176	9	50	15	2.8	2.1	5	3	3	2.05
M2.6 × 0.45	TBE08496	-	TDE08496	9	50	15	2.8	2.1	5	3	3	2.1
M3 × 0.5	TBE08206	TCE08206	TDE08206	6	56	18	3.5	2.7	6	3	3	2.5
M3.5 × 0.6	TBE08226	TCE08226	TDE08226	7	56	20	4	3	6	3	3	2.9
M4 × 0.7	TBE08246	TCE08246	TDE08246	7	63	21	4.5	3.4	6	3	3	3.3
M4.5 × 0.75	TBE08266	TCE08266	TDE08266	8	70	25	6	4.9	8	3	3	3.7
M5 × 0.8	TBE08286	TCE08286	TDE08286	8	70	25	6	4.9	8	3	3	4.2
M6 × 1.0	TBE08316	TCE08316	TDE08316	10	80	30	6	4.9	8	3	3	5
M7 × 1.0	TBE08346	TCE08346	TDE08346	10	80	30	7	5.5	8	3	3	6
M8 × 1.25	TBE08366	TCE08366	TDE08366	13	90	35	8	6.2	9	3	3	6.8
M9 × 1.25	TBE08396	TCE08396	TDE08396	13	90	35	9	7	10	3	3	7.8
M10 × 1.5	TBE08426	TCE08426	TDE08426	15	100	39	10	8	11	3	3	8.5
M11 × 1.5	TBE08466	TCE08466	TDE08466	17	100	40	8	6.2	9	3	3	9.5
M12 × 1.75	TBE08506	TCE08506	TDE08506	18	110	44	9	7	10	3	3	10.2
M14 × 2.0	TBE08546	TCE08546	TDE08546	20	110	44	11	9	12	3	3	12
M16 × 2.0	TBE08606	TCE08606	TDE08606	20	110	44	12	9	12	3	3	14
M18 × 2.5	TBE08656	TCE08656	TDE08656	25	125	50	14	11	14	4	4	15.5
M20 × 2.5	TBE08706	TCE08706	TDE08706	25	140	54	16	12	15	4	4	17.5
M22 × 2.5	TBE08746	TCE08746	TDE08746	25	140	54	18	14.5	17	4	4	19.5
M24 × 3.0	TBE08786	TCE08786	TDE08786	30	160	60	18	14.5	17	4	4	21
M27 × 3.0	TBE08866	TCE08866	TDE08866	30	160	60	20	16	19	4	4	24
M30 × 3.5	TBE08946	TCE08946	TDE08946	35	180	70	22	18	21	4	4	26.5

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

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

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				
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	○	◎	◎	◎	◎	◎	◎	◎	◎	○	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎															

	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	31	32	33	34	35	36	37	38	39	40	41																								
HB	60	100	75	90	130	110	90	100			15	30	25	38	34	200	280	250	350	320	400Rm	1050Rm	550	630	400	550																			
Recommended			◎			◎	◎	◎																																					

B98

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B99

CARBIDE

HSS

COMBO TAP

Vap

TB844

SERIES

Bright

TC844

SERIES

TiN

TD844

SERIES

MF

ISO Metric fine threads DIN 13

Metrisches ISO-Feingewinde DIN 13

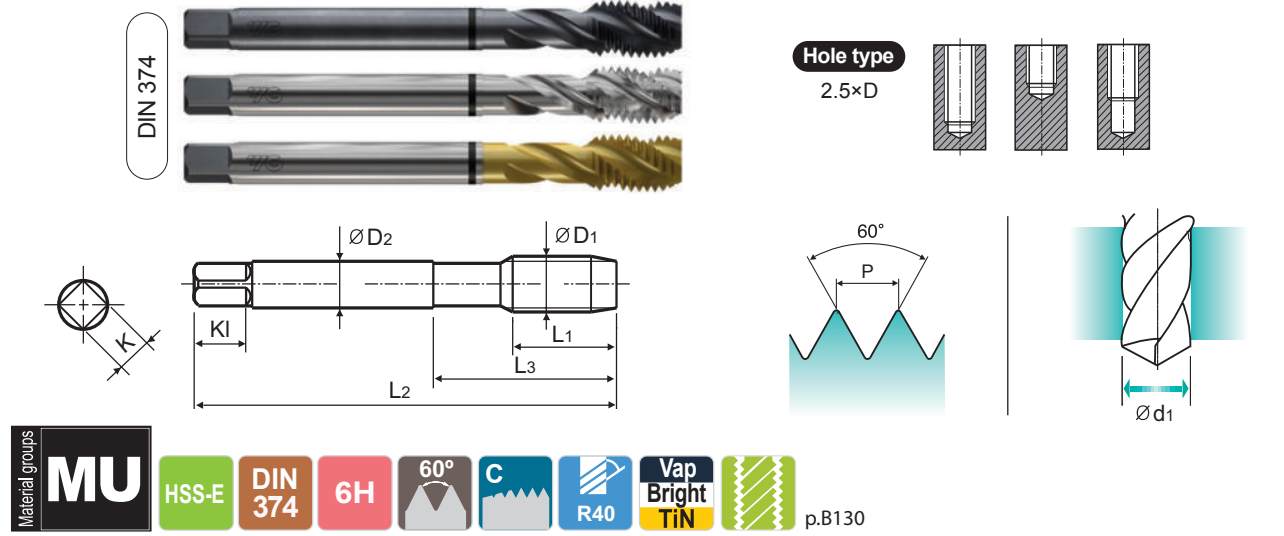
ISO MÉTRIQUE PAS FINS DIN13

ISO Metrico passo fine DIN 13

Machine taps
Maschinengewindebohrer

► 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.



CARBIDE

HSS

COMBO TAP

Vap

TB844

SERIES

Bright

TC844

SERIES

TiN

TD844

SERIES

MF

ISO Metric fine threads DIN 13

Metrisches ISO-Feingewinde DIN 13

ISO MÉTRIQUE PAS FINS DIN13

ISO Metrico passo fine DIN 13

Machine taps
Maschinengewindebohrer

► 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 374

Hole type

2.5×D

Material groups

MU

HSS-E

DIN 374

6H

60°

C

R40

Vap

Bright

TiN

p.B130

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
M48 x 3.0	-	-	TC844E56	TD844E56	36	225	90	36	29	32	4	45.0
M48 x 2.0	-	-	TC844E66	TD844E66	28	190	80	36	29	32	4	46.0
M48 x 1.5	-	-	TC844E76	TD844E76	28	190	80	36	29	32	4	46.5
M50 x 1.5	-	-	TC844F16	TD844F16	28	190	80	36	29	32	4	48.5
M52 x 3.0	-	-	TC844F56	TD844F56	36	225	90	40	32	35	4	49.0
M52 x 2.0	-	-	TC844F66	TD844F66	28	190	80	40	32	35	4	50.0
M52 x 1.5	-	-	TC844F76	TD844F76	28	190	80	40	32	35	4	50.5

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

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	15	16	17	18	19	20	17	18	19	20	21						
HRc		13	25	28	32	38	10	29	32	38	15	35	15	23	10	10	26	3	25	21	10	26	3	25	21	10	26	3	25	21	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	180	260	160	250	130	230	180	260	160	250	130	230	180	260	160	250	
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						
VDI 3323		21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	31	32	33	34	35	36	37	38	39	40	41	31	32	33	34	35
HRc		21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	15	30	25	38	34	15	30	25	38	34	15	30	25	38	34	
HB		60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550	200	280	250	350	320	400Rm	1050Rm	550	630	400	550	200	280	250	350	320
Recommended				◎			◎	◎	◎																													

B102

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YG

YG-1 CO., LTD.

CARBIDE

HSS

COMBO TAP

Bright

TCE09

SERIES

TiN

TDE09

SERIES

MF

ISO Metric fine threads DIN 13

Metrisches ISO-Feingewinde DIN 13

ISO MÉTRIQUE PAS FINS DIN13

ISO Metrico passo fine DIN 13

Machine taps
Maschinengewindebohrer

► 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 374

Hole type

2.5×D

Material groups

MU

HSS-E

DIN 374

6G

60°

C

R40

TiN

Bright

p.B130

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 x 0.5	-	TCE09256	-	5	63	21	2.8	2.1	5	3	3.5	
M5 x 0.5	-	TCE09296	TDE09296	5	70	25	3.5	2.7	6	3	4.5	
M6 x 0.5	-	TCE09336	TDE09336	5	80	30	4.5	3.4	6	3	5.5	
M7 x 0.75	-	TCE09356	TDE09356	10	80	30	5.5	4.3	7	3	6.2	
M8 x 1.0	-	-	TDE09376	10	90	36	6	4.9	8	3	7	
M8 x 0.75	-	TCE09386	-	8	80	30	6	4.9	8	3	7.2	
M10 x 1.25	-	TCE09436	TDE09436	16	100	40	7	5.5	8	3	8.8	
M10 x 1.0	-	TCE09446	TDE09446	10	90	36	7	5.5	8	3	9	
M10 x 0.75	-	TCE09456	TDE09456	10	90	36	7	5.5	8	3	9.2	
M12 x 1.5	-	TCE09516	TDE09516	15	100	40	9	7	10	3	10.5	
M12 x 1.25	-	TCE09526	TDE09526	15	100	40	9	7	10	3	10.8	
M12 x 1.0	-	-	TDE09536	11	100	40	9	7	10	3	11	
M14 x 1.5	-	TCE09556	TDE09556	15	100	40	11	9	12	3	12.5	
M14 x 1.25	-	TCE09566	-	15	100	40	11	9	12	3	12.8	
M14 x 1.0	-	TCE09576	TDE09576	11	100	40	11	9	12	3	13	
M16 x 1.5	-	TCE09616	TDE09616	15	100	40	12	9	12	3	14.5	
M16 x 1.0	-	TCE09626	TDE09626	12	100	40	12	9	12	3	15	
M18 x 1.0	-	TCE09686	TDE09686	13	110	44	14	11	14	4	17	
M20 x 1.5	-	TCE09726	-	17	125	50	16	12	15	4	18.5	
M20 x 1.0	-	TCE09736	TDE09736	14	125	50	16	12	15	4	19	
M22 x 1.5	-	TCE09766	TDE09766	17	125	50	18	14.5	17	4	20.5	
M22 x 1.0	-	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

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	15	16	17	18	19	20	17	18	19	20	21						
HRc		13	25	28	32	38	10	29	32	38	15	35	15	23	10	10	26	3	25	21	10	26	3	25	21	10	26	3	25	21	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	180	260	160	250	130	230	180	260	160	250	130	230	180	260	160	250	
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						
VDI 3323		21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	31	32	33	34	35	36	37	38	39	40	41	31	32	33	34	35
HRc		21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	15	30	25	38	34	15	30	25	38	34	15	30	25	38	34	
HB		60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550	200	280	250	350	320	400Rm	1050Rm	550	630	400	550	200	280	250	350	320
Recommended				◎			◎	◎	◎																													

YG

YG-1 CO., LTD.

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B103



Bright
TIN

TCE09 SERIES
TDE09 SERIES

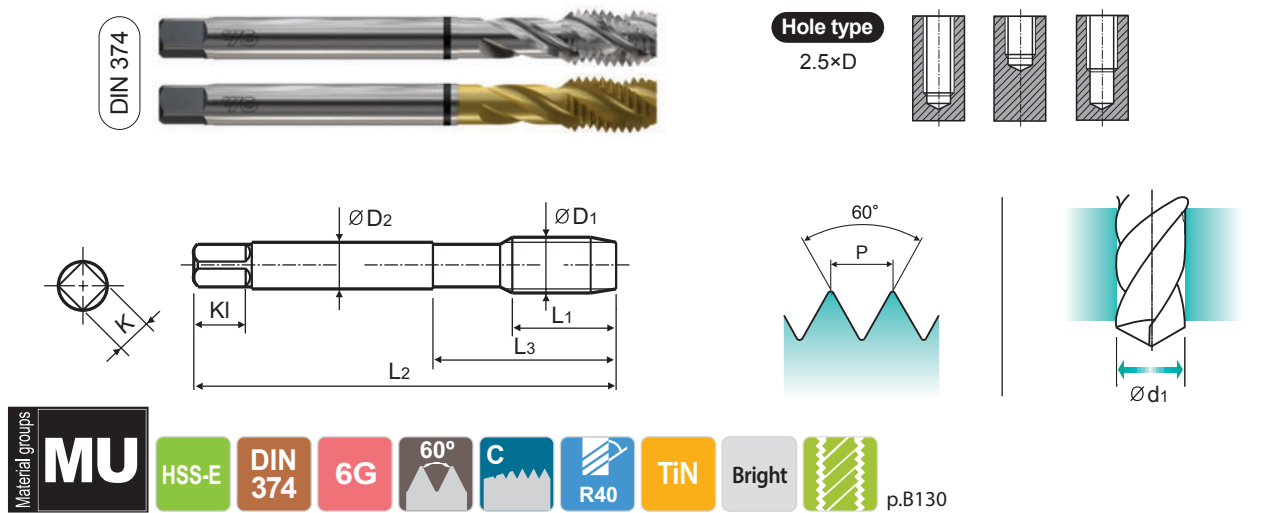
MF ISO Metric fine threads DIN 13

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

Machine taps
Maschinengewindebohrer

► 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.



Unit : mm											
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
M24 × 2.0		TCE09796	TDE09796	20	140	54	18	14.5	17	4	22
M24 × 1.5		TCE09806	TDE09806	20	140	54	18	14.5	17	4	22.5
M26 × 1.5		TCE09856	TDE09856	20	140	54	18	14.5	17	4	24.5
M27 × 2.0		TCE09876	-	20	140	54	20	16	19	4	25
M27 × 1.5		TCE09886	TDE09886	20	140	54	20	16	19	4	25.5
M28 × 1.5		TCE09916	-	20	140	54	20	16	19	4	26.5
M30 × 2.0		TCE09966	TDE09966	22	150	57	22	18	21	4	28
M30 × 1.5		TCE09976	-	22	150	57	22	18	21	4	28.5

► 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			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	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		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			◎			◎	◎	◎															



TC804-IC SERIES

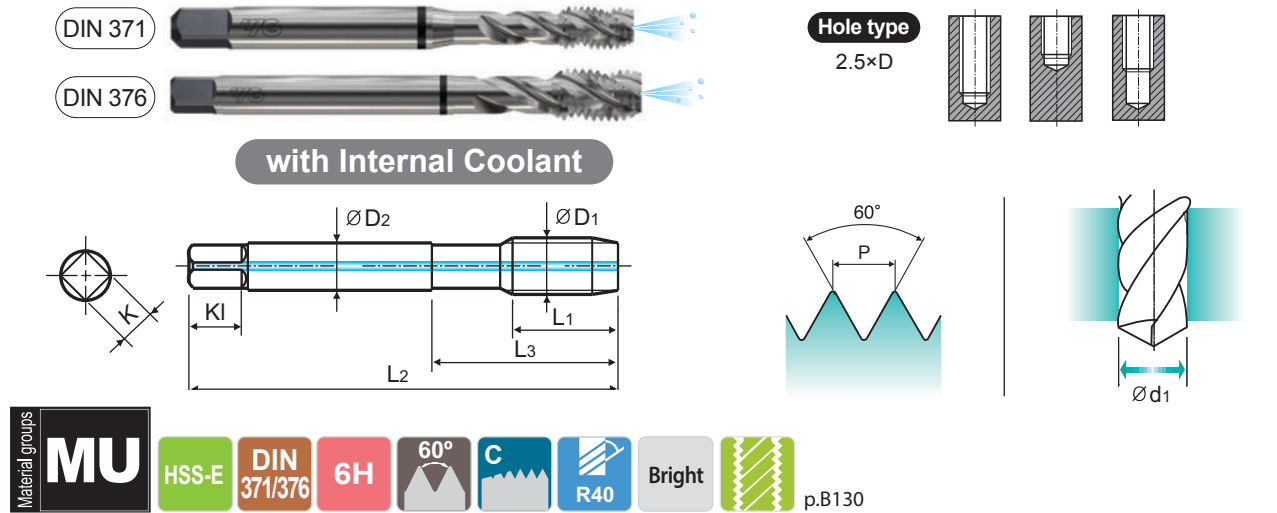
M ISO Metric coarse threads DIN 13

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

Machine taps
Maschinengewindebohrer

► 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.



Unit : mm										
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	L ₁	L ₂	L ₃	ØD ₂	K	KI	Z	Ød ₁
M6	× 1.0	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	× 2.0	TC804546IC	20	110	44	11	9	12	3	12
M16	× 2.0	TC804606IC	20	110	44	12	9	12	3	14
M18	× 2.5	TC804656IC	25	125	50	14	11	14	4	15.5

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

																				◎ : 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	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		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			◎			◎	◎	◎															



Vap

Bright

TiN

TB824 SERIES

TC824 SERIES

TD824 SERIES

UNC

Unified coarse threads

Unified Grobgewinde

UNC

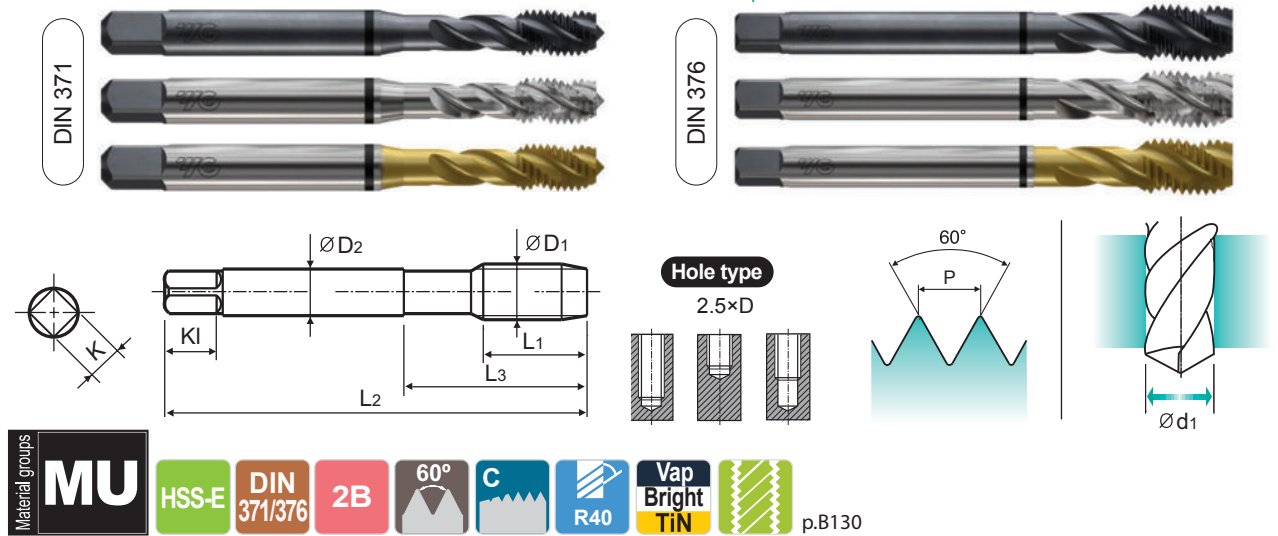
Unificato passo grosso

Machine taps

Maschinengewindebohrer

► 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.



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

► DIN 371(#4~3/8) and DIN 374(7/16~1)

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

ISO	P										M					K				
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel					Stainless steel				
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	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				
Material Description	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40
HRc	60	100	75	90	130	110	90	100			15	30	25	38	34	400Rm	1050Rm	550	630	400
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400
Recommended			○			○	○	○												



Bright

TiN

TCE01 SERIES

TDE01 SERIES

UNC

Unified coarse threads

Unified Grobgewinde

UNC

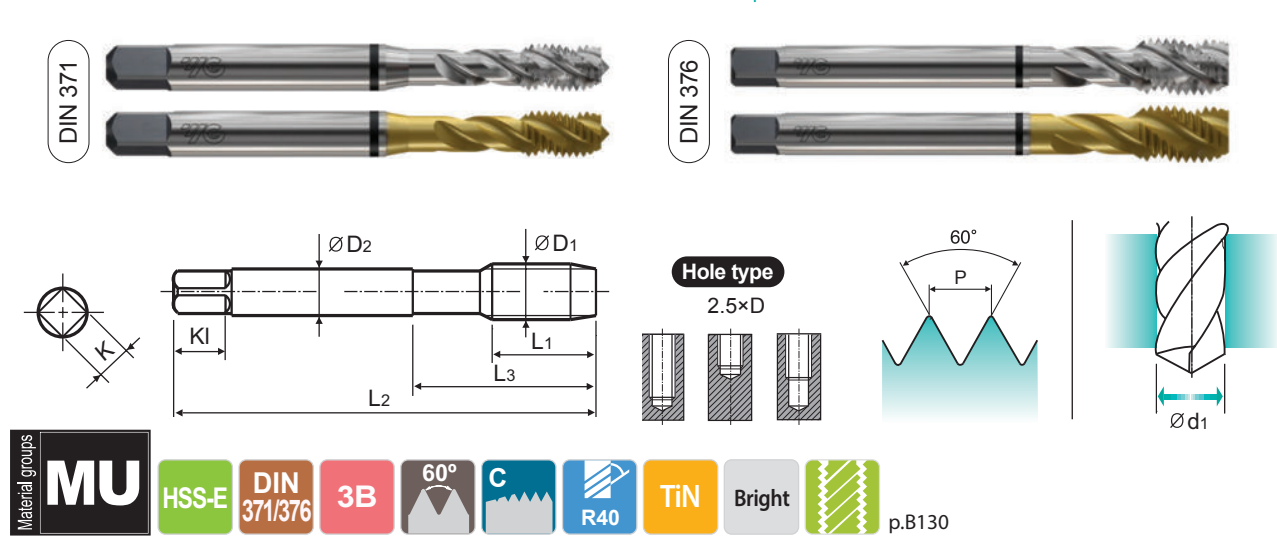
Unificato passo grosso

Machine taps

Maschinengewindebohrer

► 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.



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

ISO	P										M					K				
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel					Stainless steel				
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	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				
Material Description	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40
HRc	60	100	75	90	130	110	90	100			15	30	25	38	34	400Rm	1050Rm	550	630	400
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400
Recommended			○			○	○	○												



Vap **TB864** SERIES
Bright **TC864** SERIES
TiN **TD864** SERIES

UNF

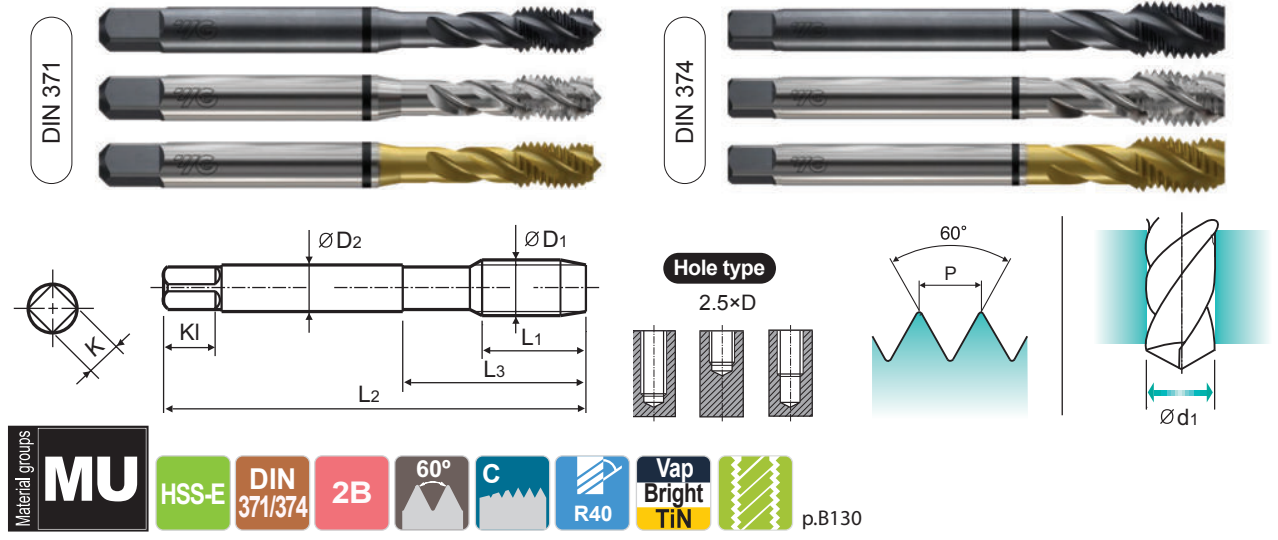
Unified fine threads

Unified Feingewinde
UNF
Unificato passo fine

Machine taps
Maschinengewindebohrer

► 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.



Unit : mm												
SIZE ØD1	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 - 48UNF		-	TC864182	-	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	-	7	56	20	4	3	6	3	3
#8 - 36UNF		-	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		-	TC864662	TD864662	15	100	40	12	9	12	3	14.5
3/4 - 16UNF		-	TC864722	TD864722	17	110	44	14	11	14	4	17.5
7/8 - 14UNF		-	TC864762	-	17	125	50	18	14.5	17	4	20.5
1 - 12UNF		-	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.

ISO Material Description	P										M					K				
	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	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				
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			○			○	○	○												



Bright **TCE02** SERIES
TiN **TDE02** SERIES

UNF

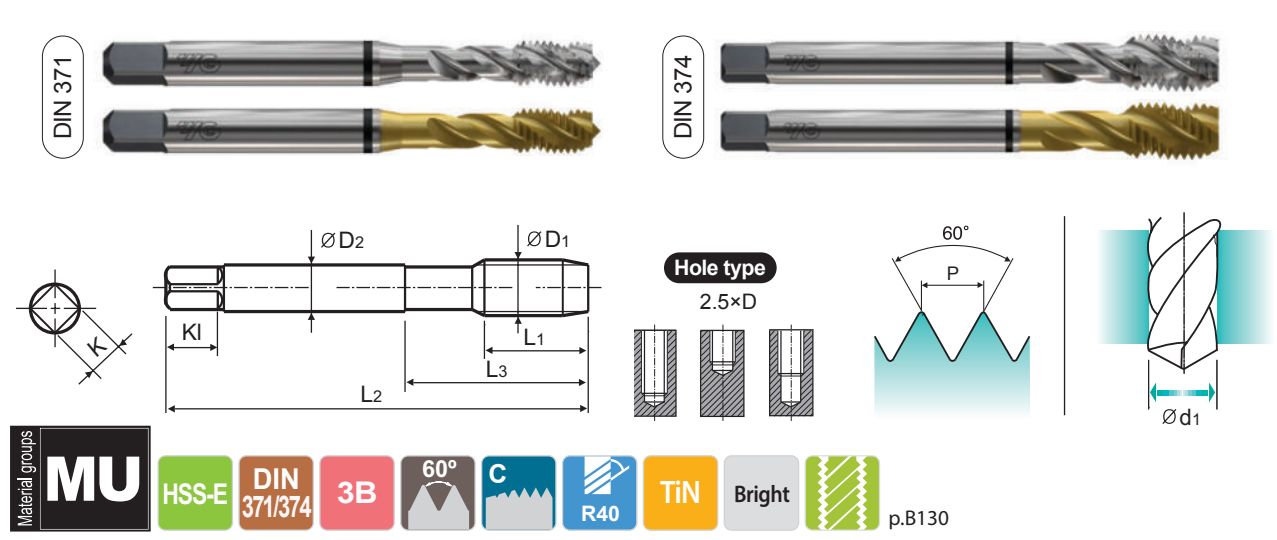
Unified fine threads

Unified Feingewinde
UNF
Unificato passo fine

Machine taps
Maschinengewindebohrer

► 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.



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 - 48UNF		TCE02182	TDE02182	6	56	18	3.5	2.7	6	3	2.4
#5 - 44UNF		TCE02222	TDE02222	7	56	18	3.5	2.7	6	3	2.7
#6 - 40UNF		TCE02262	TDE02262	7	56	20	4	3	6	3	3
#8 - 36UNF		TCE02302	TDE02302	8	63	21	4.5	3.4	6	3	3.5
#10 - 32UNF		-	TDE02342	10	70	25	6	4.9	8	3	4.1
#12 - 28UNF		TCE02382	TDE02382	10	80	30	6	4.9	8	3	4.7
1/4 - 28UNF		TCE02422	TDE02422	10	80	30	7	5.5	8	3	5.5
5/16 - 24UNF		TCE02462	TDE02462	10	90	35	8	6.2	9	3	6.9
3/8 - 24UNF		TCE02502	TDE02502	10	100	39	9	7	10	3	8.5
7/16 - 20UNF		TCE02542	TDE02542	13	100	40	8	6.2	9	3	9.9
1/2 - 20UNF		TCE02582	TDE02582	13	100	40	9	7	10	3	11.5
9/16 - 18UNF		TCE02622	TDE02622	15	100	40	11	9	12	3	12.9
5/8 - 18UNF		TCE02662	TDE02662	15	100	40	12	9	12	3	14.5
3/4 - 16UNF		TCE02722	TDE02722	17	110	44	14	11	14	4	17.5
7/8 - 14UNF		TCE02762	TDE02762	17	125	50	18	14.5	17	4	20.5
1 - 12UNF		TCE02802	TDE02802	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) or Surface Treatment(Steam Homo) is available on your request.

ISO Material Description	P										M					K				
	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	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				
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			○			○	○	○												

M

ISO Metric coarse threads DIN 13

Metrisches ISO-Gewinde DIN 13

ISO MÉTRIQUE DIN13

ISO Metrico passo grosso DIN 13

Machine taps
Maschinengewindebohrer

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

DIN 371

DIN 376

Hole type

3.0xD

MU

HSS-E

DIN 371/376

6H

60°

B

Vap Bright TiN

p.B131

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	TB814136	TC814136	TD814136	8	45	13	2.8	2.1	5	3	1.6
M2.2	× 0.45	TB814156	TC814156	TD814156	8	45	13	2.8	2.1	5	3	1.75
M2.3	× 0.4	TB814196	TC814196	TD814196	8	45	13	2.8	2.1	5	3	1.9
M2.5	× 0.45	TB814176	TC814176	TD814176	9	50	15	2.8	2.1	5	3	2.05
M2.6	× 0.45	TB814496	TC814496	TD814496	9	50	15	2.8	2.1	5	3	2.1
M3	× 0.5	TB814206	TC814206	TD814206	11	56	18	3.5	2.7	6	3	2.5
M3.5	× 0.6	TB814226	TC814226	TD814226	12	56	20	4	3	6	3	2.9
M4	× 0.7	TB814246	TC814246	TD814246	13	63	21	4.5	3.4	6	3	3.3
M4.5	× 0.75	TB814266	TC814266	TD814266	14	70	25	6	4.9	8	3	3.7
M5	× 0.8	TB814286	TC814286	TD814286	15	70	25	6	4.9	8	3	4.2
M6	× 1.0	TB814316	TC814316	TD814316	17	80	30	6	4.9	8	3	5
M7	× 1.0	TB814346	TC814346	TD814346	17	80	30	7	5.5	8	3	6
M8	× 1.25	TB814366	TC814366	TD814366	20	90	35	8	6.2	9	3	6.8
M9	× 1.25	TB814396	TC814396	TD814396	20	90	35	9	7	10	3	7.8
M10	× 1.5	TB814426	TC814426	TD814426	22	100	39	10	8	11	3	8.5
M11	× 1.5	TB814466	TC814466	-	22	100	40	8	6.2	9	3	9.5
M12	× 1.75	TB814506	TC814506	TD814506	24	110	44	9	7	10	3	10.2
M14	× 2.0	TB814546	TC814546	TD814546	26	110	44	11	9	12	3	12
M16	× 2.0	TB814606	TC814606	TD814606	27	110	44	12	9	12	3	14
M18	× 2.5	TB814656	TC814656	TD814656	30	125	50	14	11	14	4	15.5
M20	× 2.5	TB814706	TC814706	TD814706	32	140	54	16	12	15	4	17.5
M22	× 2.5	TB814746	TC814746	TD814746	32	140	54	18	14.5	17	4	19.5

► DIN 371(M2~M10) and DIN 376(M11~M52)

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

► NEXT PAGE

◎ : 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	10	29	32	38	15	35	15	23	10	15	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		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	36		55	60	42	55
HB	60	100		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

Machine taps
Maschinengewindebohrer

► 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

3.0xD

MU

HSS-E

DIN 371/376

6H

60°

B

Vap Bright TiN

p.B131

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
M24	× 3.0	-	TC814786	TD814786	34	160	60	18	14.5	17	4	21
M27	× 3.0	TB814866	TC814866	TD814866	36	160	60	20	16	19	4	24
M30	× 3.5	TB814946	TC814946	TD814946	40	180	70	22	18	21	4	26.5
M33	× 3.5	-	TC814A46	-	40	180	70	25	20	23	4	29.5
M36	× 4.0	-	TC814B36	TD814B36	50	200	80	28	22	25	4	32.0
M39	× 4.0	-	TC814C06	TD814C06	50	200	80	32	24	27	4	35.0
M42	× 4.5	-	TC814C86	TD814C86	56	200	85	32	24	27	4	37.5
M45	× 4.5	-	TC814D56	TD814D56	58	220	85	36	29	32	4	40.5
M48	× 5.0	-	TC814E26	TD814E26	65	250	90	36	29	32	4	43.0
M52	× 5.0	-	TC814F36	TD814F36	65	250	90	40	32	35	4	47.0

► DIN 371(M2~M10) and DIN 376(M11~M52)

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

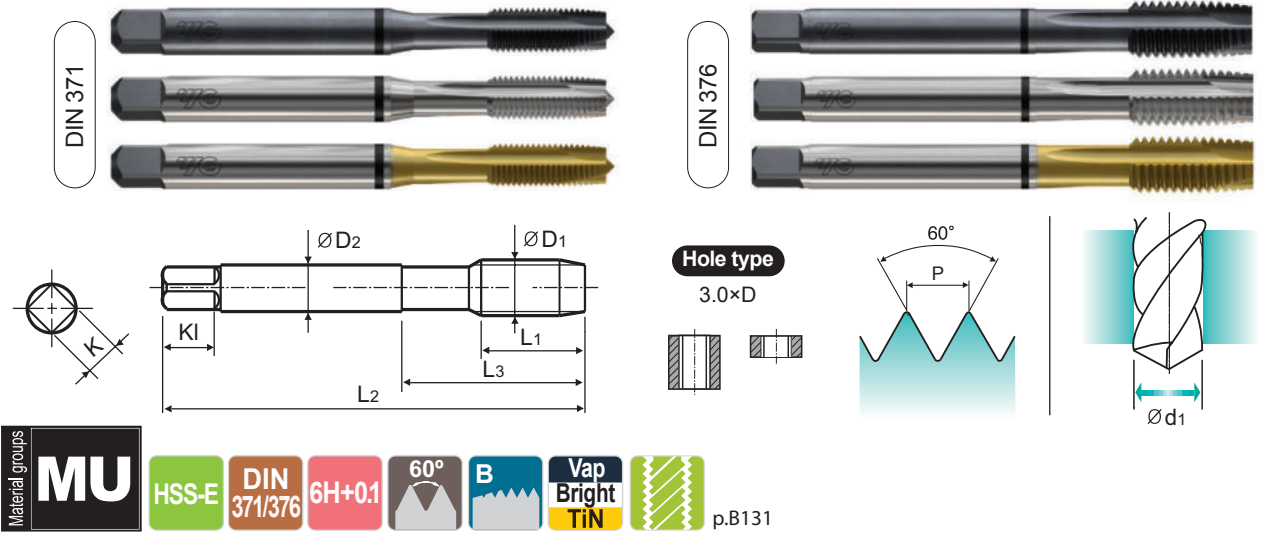
◎ : Excellent ○ : Good																							
ISO	P										M			K									
Material Description	Non-alloy steel					Low alloy steel					High alloyed steel and tool steel			Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron		
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20			
HRC		13	25	28	32	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	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			◎			◎	◎	◎															

ISO Metric coarse threads DIN 13

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

Machine taps
Maschinengewindebohrer

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



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	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	× 1.0	TBJ06316	TCJ06316	TDJ06316	17	80	30	6	4.9	8	3	5.1
M7	× 1.0	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	× 2.0	TBJ06546	TCJ06546	TDJ06546	26	110	44	11	9	12	3	12.1
M16	× 2.0	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	× 3.0	TBJ06786	TCJ06786	-	34	160	60	18	14.5	17	4	21.1
M27	× 3.0	TBJ06866	TCJ06866	TDJ06866	36	160	60	20	16	19	4	24.1
M30	× 3.5	-	TCJ06946	-	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. ◎ : Excellent ○ : Good

[illegible]



Vap

Bright

TiN

TBJ07 SERIES

TCJ07 SERIES

TDJ07 SERIES

M

ISO Metric coarse threads DIN 13

Metrisches ISO-Gewinde DIN 13

ISO MÉTRIQUE DIN13

ISO Metrico passo grosso DIN 13

Machine taps
Maschinengewindebohrer

► 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

3.0×D

Material groups

MU

HSS-E

DIN 371/376

6G

60°

B

Vap Bright TiN

p.B131

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	-	-	TCJ07136	-	8	45	13	2.8	2.1	5	3	1.6
M2.2 × 0.45	TBJ07156	TCJ07156	TDJ07156	-	8	45	13	2.8	2.1	5	3	1.75
M2.3 × 0.4	TBJ07196	TCJ07196	TDJ07196	-	8	45	13	2.8	2.1	5	3	1.9
M2.5 × 0.45	-	-	TCJ07176	TDJ07176	9	50	15	2.8	2.1	5	3	2.05
M2.6 × 0.45	TBJ07496	TCJ07496	TDJ07496	-	9	50	15	2.8	2.1	5	3	2.1
M3 × 0.5	TBJ07206	TCJ07206	TDJ07206	-	11	56	18	3.5	2.7	6	3	2.5
M3.5 × 0.6	TBJ07226	TCJ07226	TDJ07226	-	12	56	20	4	3	6	3	2.9
M4 × 0.7	TBJ07246	TCJ07246	TDJ07246	-	13	63	21	4.5	3.4	6	3	3.3
M4.5 × 0.75	TBJ07266	TCJ07266	TDJ07266	-	14	70	25	6	4.9	8	3	3.7
M5 × 0.8	TBJ07286	TCJ07286	TDJ07286	-	15	70	25	6	4.9	8	3	4.2
M6 × 1.0	TBJ07316	TCJ07316	TDJ07316	-	17	80	30	6	4.9	8	3	5
M7 × 1.0	TBJ07346	TCJ07346	TDJ07346	-	17	80	30	7	5.5	8	3	6
M8 × 1.25	TBJ07366	TCJ07366	TDJ07366	-	20	90	35	8	6.2	9	3	6.8
M9 × 1.25	TBJ07396	TCJ07396	-	-	20	90	35	9	7	10	3	7.8
M10 × 1.5	TBJ07426	TCJ07426	TDJ07426	-	22	100	39	10	8	11	3	8.5
M11 × 1.5	TBJ07466	TCJ07466	TDJ07466	-	22	100	40	8	6.2	9	3	9.5
M12 × 1.75	TBJ07506	TCJ07506	TDJ07506	-	24	110	44	9	7	10	3	10.2
M14 × 2.0	-	-	TCJ07546	TDJ07546	26	110	44	11	9	12	3	12
M16 × 2.0	TBJ07606	TCJ07606	TDJ07606	-	27	110	44	12	9	12	3	14
M18 × 2.5	TBJ07656	TCJ07656	TDJ07656	-	30	125	50	14	11	14	4	15.5
M20 × 2.5	-	-	TCJ07706	TDJ07706	32	140	54	16	12	15	4	17.5
M22 × 2.5	TBJ07746	TCJ07746	TDJ07746	-	32	140	54	18	14.5	17	4	19.5
M24 × 3.0	TBJ07786	TCJ07786	-	-	34	160	60	18	14.5	17	4	21
M27 × 3.0	TBJ07866	TCJ07866	TDJ07866	-	36	160	60	20	16	19	4	24
M30 × 3.5	TBJ07946	TCJ07946	TDJ07946	-	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

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	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									
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			15	30	25	38	34	400Rm	1050Rm	550	630	400
Recommended			◎			◎	◎	◎												



Vap

Bright

TiN

TBJ08 SERIES

TCJ08 SERIES

TDJ08 SERIES

M

ISO Metric coarse threads DIN 13

Metrisches ISO-Gewinde DIN 13

ISO MÉTRIQUE DIN13

ISO Metrico passo grosso DIN 13

Machine taps
Maschinengewindebohrer

► 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

3.0×D

Material groups

MU

HSS-E

DIN 371/376

7G

60°

B

Vap Bright TiN

p.B131

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 × 1.0	TBJ08316	TCJ08316	TDJ08316	-	17	80	30	6	4.9	8	3	5
M7 × 1.0	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 × 2.0	TBJ08546	TCJ08546	TDJ08546	-	26	110	44	11	9	12	3	12
M16 × 2.0	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 × 3.0	TBJ08786	TCJ08786	TDJ08786	-	34	160	60	18	14.5	17	4	21
M27 × 3.0	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

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	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									
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			15	30	25	38	34	400Rm	1050Rm	550	630	400
Recommended			◎			◎	◎	◎												

MF

ISO Metric fine threads DIN 13

Metrisches ISO-Feingewinde DIN 13

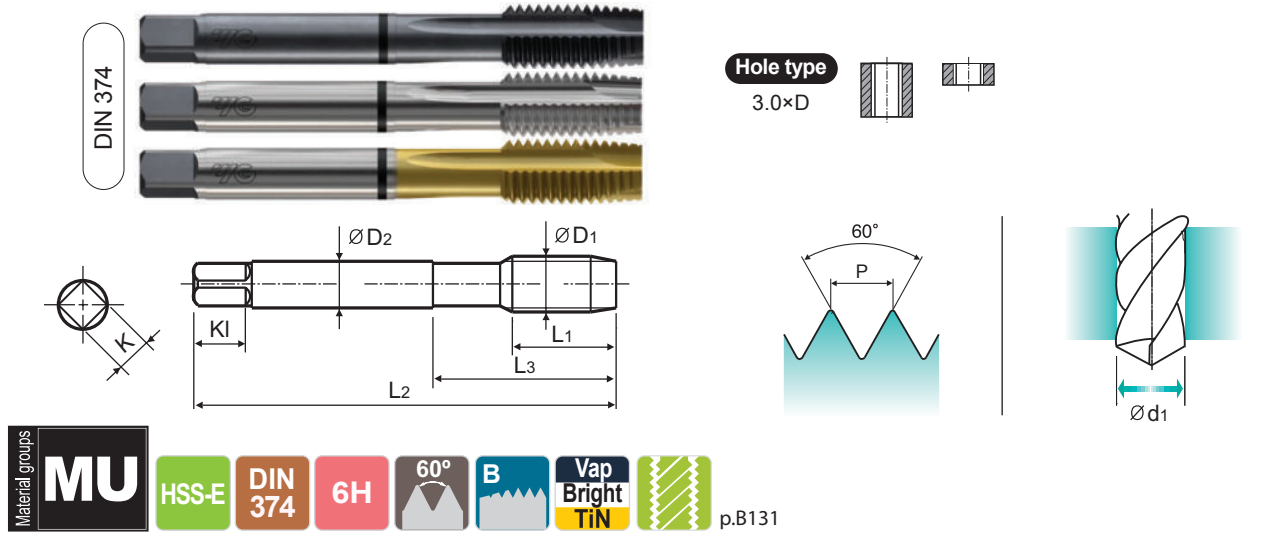
ISO MÉTRIQUE PAS FINS DIN13

ISO Metrico passo fine DIN 13

Machine taps
Maschinengewindebohrer

► 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.





Vap

Bright

TiN

TB854

SERIES

TC854

SERIES

TD854

SERIES

MF

ISO Metric fine threads DIN 13

Metrisches ISO-Feingewinde DIN 13

ISO MÉTRIQUE PAS FINS DIN13

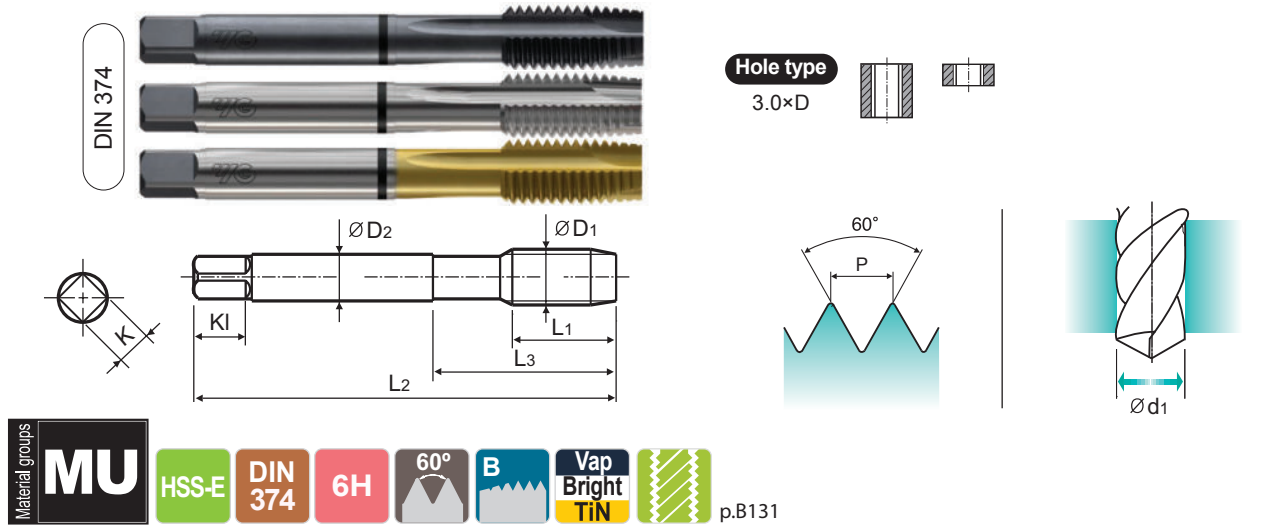
ISO Metrico passo fine DIN 13

Machine taps

Maschinengewindebohrer

► 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.



Unit : mm												
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	Vap	Bright	TiN	L ₁	L ₂	L ₃	ØD ₂	K	KI	Z	Ød ₁
M42 x 3.0	-	-	TC854D06	TD854D06	45	200	80	32	24	27	4	39.0
M42 x 2.0	-	-	TC854D16	TD854D16	33	170	70	32	24	27	4	40.0
M42 x 1.5	-	-	TC854D26	TD854D26	33	170	70	32	24	27	4	40.5
M45 x 1.5	-	-	TC854D96	TD854D96	33	180	80	36	29	32	4	43.5
M48 x 3.0	-	-	TC854E56	TD854E56	45	225	90	36	29	32	4	45.0
M48 x 2.0	-	-	TC854E66	TD854E66	36	190	80	36	29	32	4	46.0
M48 x 1.5	-	-	TC854E76	TD854E76	36	190	80	36	29	32	4	46.5
M50 x 1.5	-	-	TC854F16	TD854F16	36	190	80	36	29	32	4	48.5
M52 x 3.0	-	-	TC854F56	TD854F56	45	225	90	40	32	35	4	49.0
M52 x 2.0	-	-	TC854F66	TD854F66	36	190	80	40	32	35	4	50.0
M52 x 1.5	-	-	TC854F76	TD854F76	36	190	80	40	32	35	4	50.5

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

ISO	P										M					K				
	Non-alloy steel					Low alloy steel					Stainless steel					Grey 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	13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25	21	21
HRC	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
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				
Material Description	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40
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			15	30	25	38	34	200	280	250	350	320
Recommended			◎			◎	◎	◎								400Rm	1050Rm	550	630	400



Bright

TiN

TCJ09

SERIES

TDJ09

SERIES

MF

ISO Metric fine threads DIN 13

Metrisches ISO-Feingewinde DIN 13

ISO MÉTRIQUE PAS FINS DIN13

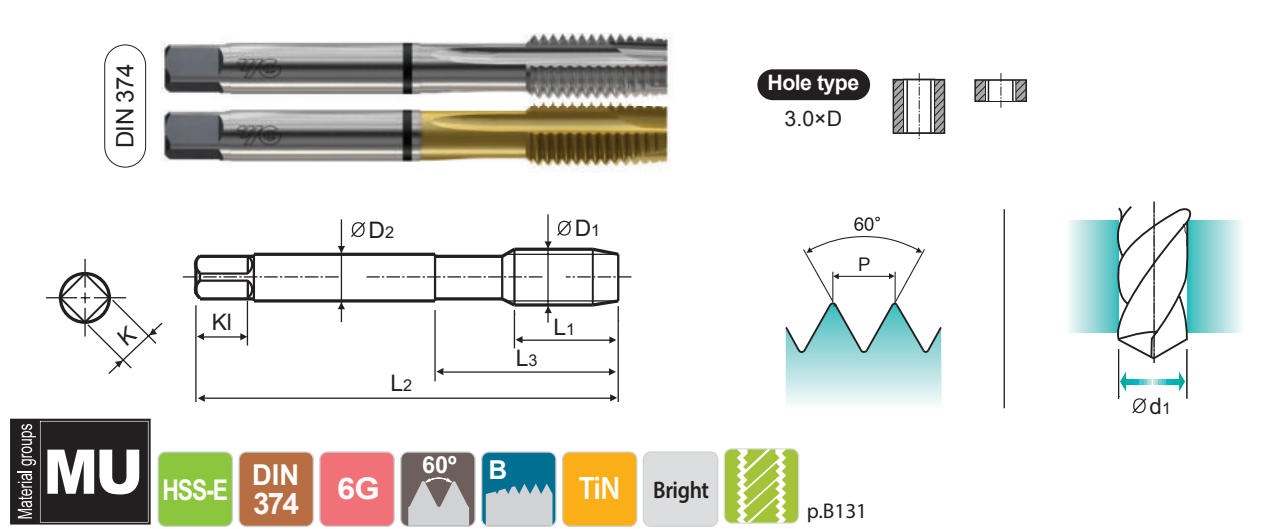
ISO Metrico passo fine DIN 13

Machine taps

Maschinengewindebohrer

► 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.



Unit : mm												
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	
M4	×	0.5	TCJ09256	TDJ09256	10	63	21	2.8	2.1	5	3	3.5
M5	×	0.5	TCJ09296	TDJ09296	11	70	25	3.5	2.7	6	3	4.5
M6	×	0.75	TCJ09326	-	13	80	30	4.5	3.4	6	3	5.2
M6	×	0.5	-	TDJ09336	13	80	30	4.5	3.4	6	3	5.5
M7	×	0.75	TCJ09356	TDJ09356	14	80	30	5.5	4.3	7	3	6.2
M8	×	1.0	TCJ09376	TDJ09376	17	90	36	6	4.9	8	3	7
M8	×	0.75	TCJ09386	TDJ09386	14	80	30	6	4.9	8	3	7.2
M10	×	1.0	TCJ09446	TDJ09446	18	90	36	7	5.5	8	3	9
M10	×	0.75	TCJ09456	TDJ09456	18	90	36	7	5.5	8	3	9.2
M12	×	1.5	TCJ09516	TDJ09516	22	100	40	9	7	10	3	10.5
M12	×	1.25	TCJ09526	TDJ09526	22	100	40	9	7	10	3	10.8
M12	×	1.0	TCJ09536	-	18	100	40	9	7	10	3	11
M14	×	1.5	TCJ09556	TDJ09556	22	100	40	11	9	12	3	12.5
M14	×	1.25	TCJ09566	TDJ09566	22	100	40	11	9	12	3	12.8
M14	×	1.0	TCJ09576	TDJ09576	22	100	40	11	9	12	3	13
M16	×	1.5	TCJ09616	TDJ09616	22	100	40	12	9	12	3	14.5
M16	×	1.0	TCJ09626	TDJ09626	18	100	40	12	9	12	3	15
M18	×	1.5	TCJ09676	TDJ09676	25	110	44	14	11	14	4	16.5
M18	×	1.0	TCJ09686	TDJ09686	20	110	44	14	11	14	4	17
M20	×	1.5	TCJ09726	TDJ09726	25	125	50	16	12	15	4	18.5
M20	×	1.0	TCJ09736	TDJ09736	20	125	50	16	12	15	4	19

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

► NEXT PAGE

ISO	P										M					K				
	Non-alloy steel					Low alloy steel					Stainless steel					Grey 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	13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25	21	21
HRC	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
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				
Material Description	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40
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			15	30	25	38	34	200	280	250	350	320
Recommended			◎			◎	◎	◎								400Rm	1050Rm	550	630	400



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 fine DIN 13

Machine taps
Maschinengewindebohrer

► 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 374

Hole type 3.0×D

60°

with Internal Coolant

Material groups MU HSS-E DIN 374 6G 60° B TIN Bright p.B131

Unit : mm											
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
M22 × 1.5		TCJ09766	TDJ09766	25	125	50	18	14.5	17	4	20.5
M22 × 1.0		TCJ09776	TDJ09776	20	125	50	18	14.5	17	4	21
M24 × 2.0		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 × 2.0		TCJ09876	TDJ09876	28	140	54	20	16	19	4	25
M27 × 1.5		-	-	28	140	54	20	16	19	4	25.5
M28 × 1.5		TCJ09916	TDJ09916	28	140	54	20	16	19	4	26.5
M30 × 2.0		TCJ09966	TDJ09966	30	150	57	22	18	21	4	28
M30 × 1.5		-	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.

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



TC814-IC SERIES

M ISO Metric coarse threads DIN 13

Metrisches ISO-Gewinde DIN 13
ISO MÉTRIQUE DIN13, AVEC ARROSAGE CENTRAL
ISO Metrico passo grosso DIN 13

Machine taps
Maschinengewindebohrer

► 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 3.0×D

60°

with Internal Coolant

Material groups MU HSS-E DIN 371/376 6H 60° B Bright p.B131

Unit : mm											
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		L ₁	L ₂	L ₃	ØD ₂	K	KI	Z	Ød ₁
M6 × 1.0		TC814316IC		17	80	30	6	4.9	8	3	5
M8 × 1.25		TC814366IC		20	90	35	8	6.2	9	3	6.8
M10 × 1.5		TC814426IC		22	100	39	10	8	11	3	8.5
M12 × 1.75		TC814506IC		24	110	44	9	7	10	3	10.2
M14 × 2.0		TC814546IC		26	110	44	11	9	12	3	12
M16 × 2.0		TC814606IC		27	110	44	12	9	12	3	14
M18 × 2.5		TC814656IC		30	125	50	14	11	14	4	15.5
M20 × 2.5		TC814706IC		32	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.

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

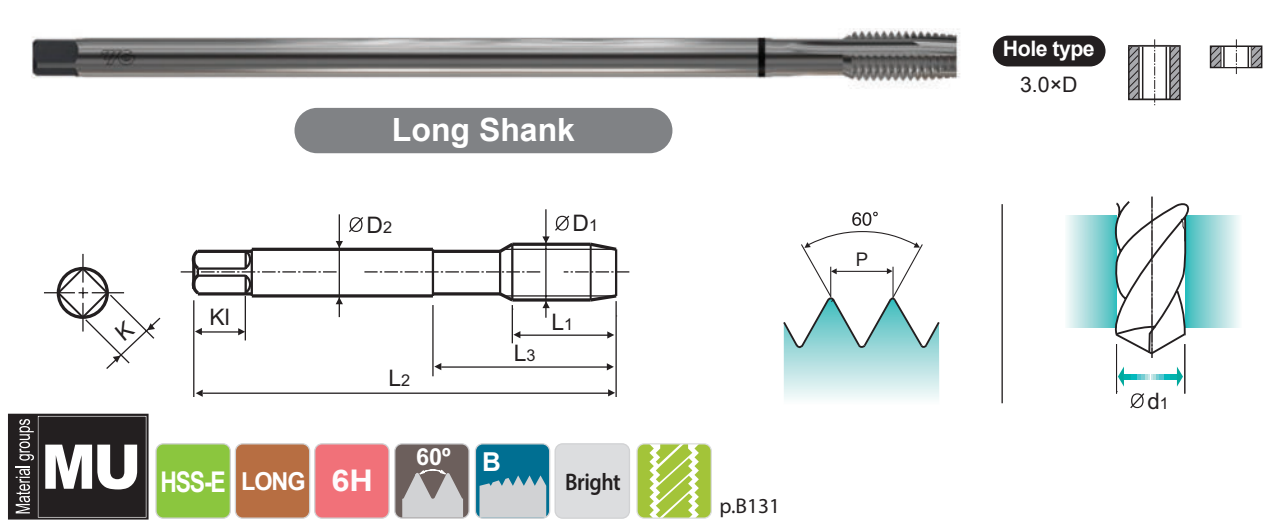
M ISO Metric coarse threads DIN 13

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

Machine taps
Maschinengewindebohrer

► 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.



Unit : mm											
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	L ₁	L ₂	L ₃	ØD ₂	K	K ₁	Z	Ød ₁	
M3	× 0.5	TC445206	11	100	18	3.5	2.7	6	3	2.5	
M4	× 0.7	TC445246	13	125	21	4.5	3.4	6	3	3.3	
M5	× 0.8	TC445286	15	140	25	6	4.9	8	3	4.2	
M6	× 1.0	TC445316	17	160	30	6	4.9	8	3	5	
M8	× 1.25	TC445366	20	180	35	6	4.9	8	3	6.8	
M10	× 1.5	TC445426	22	200	39	7	5.5	8	3	8.5	
M12	× 1.75	TC445506	24	220	44	9	7	10	3	10.2	
M14	× 2.0	TC445546	26	220	44	11	9	12	3	12	
M16	× 2.0	TC445606	27	220	44	12	9	12	3	14	
M20	× 2.5	TC445706	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			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	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	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			◎			◎	◎	◎														

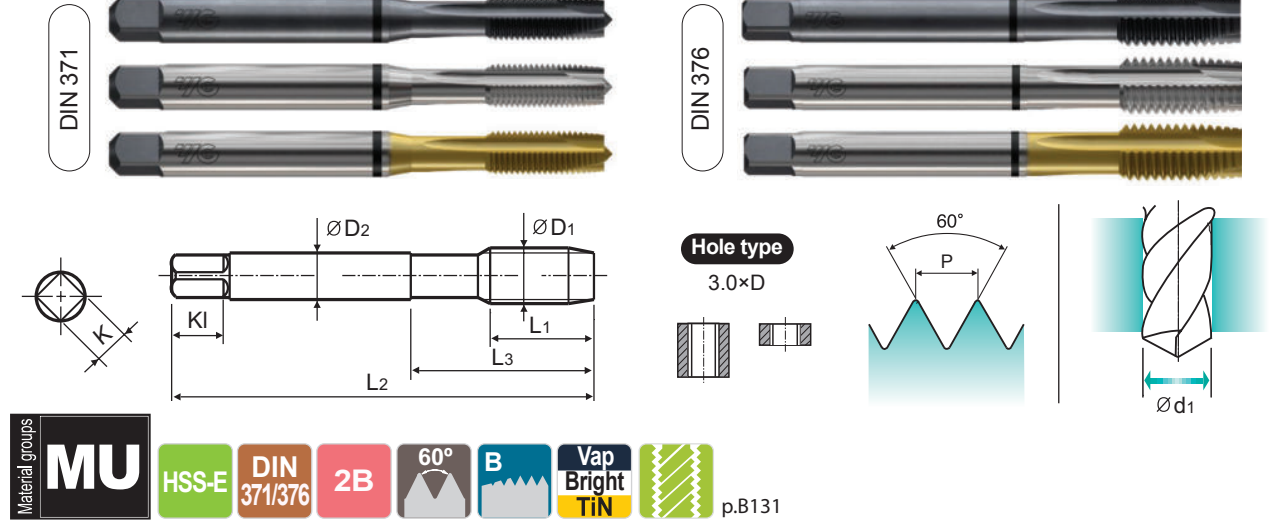
UNC Unified coarse threads

Unified Grobgewinde
UNC
Unificato passo grosso

Machine taps
Maschinengewindebohrer

► 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.



Unit : mm												
SIZE	TPI	EDP No.			Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD ₁		Vap	Bright	TiN	L ₁	L ₂	L ₃	ØD ₂	K	K ₁	Z	Ød ₁
#4 - 40 UNC		TB834162	TC834162	TD834162	11	56	18	3.5	2.7	6	3	2.3
#5 - 40 UNC		TB834202	TC834202	TD834202	11	56	18	3.5	2.7	6	3	2.6
#6 - 32 UNC		-	TC834242	TD834242	12	56	20	4	3	6	3	2.85
#8 - 32 UNC		TB834282	TC834282	TD834282	13	63	21	4.5	3.4	6	3	3.5
#10 - 24 UNC		TB834322	TC834322	TD834322	15	70	25	6	4.9	8	3	3.9
#12 - 24 UNC		TB834362	TC834362	TD834362	16	80	30	6	4.9	8	3	4.5
1/4 - 20 UNC		TB834402	TC834402	TD834402	17	80	30	7	5.5	8	3	5.2
5/16 - 18 UNC		TB834442	TC834442	TD834442	20	90	35	8	6.2	9	3	6.6
3/8 - 16 UNC		TB834482	TC834482	TD834482	22	100	39	9	7	10	3	8
7/16 - 14 UNC		TB834522	TC834522	TD834522	22	100	40	8	6.2	9	3	9.4
1/2 - 13 UNC		TB834562	TC834562	TD834562	25	110	44	9	7	10	3	10.75
9/16 - 12 UNC		-	TC834602	TD834602	26	110	44	11	9	12	3	12.25
5/8 - 11 UNC		TB834642	TC834642	TD834642	27	110	44	12	9	12	3	13.5
3/4 - 10 UNC		TB834702	TC834702	TD834702	30	125	50	14	11	14	4	16.5
7/8 - 9 UNC		TB834742	TC834742	-	32	140	54	18	14.5	17	4	19.5
1 - 8 UNC		-	TC834782	TD834782	36	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				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	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		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			◎			◎	◎	◎															

CARBIDE

HSS

COMBO TAP

Bright

TCJ01

SERIES

TIN

TDJ01

SERIES

UNC

Unified Grobgewinde

UNC

Unificato passo grosso

Machine taps

Maschinengewindebohrer

► 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

60°

P

ØD2

ØD1

L1

L2

L3

KI

K

Hole type

3.0×D

Ød1

MU

HSS-E

DIN 371/376

3B

60°

B

TiN

Bright

p.B131

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		TCJ01162	TDJ01162	11	56	18	3.5	2.7	6	3	2.3
#5 - 40 UNC		TCJ01202	TDJ01202	11	56	18	3.5	2.7	6	3	2.6
#6 - 32 UNC		TCJ01242	TDJ01242	12	56	20	4	3	6	3	2.85
#8 - 32 UNC		TCJ01282	-	13	63	21	4.5	3.4	6	3	3.5
#10 - 24 UNC		TCJ01322	TDJ01322	15	70	25	6	4.9	8	3	3.9
#12 - 24 UNC		TCJ01362	TDJ01362	16	80	30	6	4.9	8	3	4.5
1/4 - 20 UNC		TCJ01402	TDJ01402	17	80	30	7	5.5	8	3	5.2
5/16 - 18 UNC		TCJ01442	TDJ01442	20	90	35	8	6.2	9	3	6.6
3/8 - 16 UNC		TCJ01482	-	22	100	39	9	7	10	3	8
7/16 - 14 UNC		TCJ01522	TDJ01522	22	100	40	8	6.2	9	3	9.4
1/2 - 13 UNC		TCJ01562	TDJ01562	25	110	44	9	7	10	3	10.75
9/16 - 12 UNC		TCJ01602	TDJ01602	26	110	44	11	9	12	3	12.25
5/8 - 11 UNC		TCJ01642	TDJ01642	27	110	44	12	9	12	3	13.5
3/4 - 10 UNC		TCJ01702	TDJ01702	30	125	50	14	11	14	4	16.5
7/8 - 9 UNC		TCJ01742	TDJ01742	32	140	54	18	14.5	17	4	19.5
1 - 8 UNC		TCJ01782	TDJ01782	36	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.

CARBIDE

HSS

COMBO TAP

Vap

TB874

SERIES

Bright

TC874

SERIES

TIN

TD874

SERIES

UNF

Unified Feingewinde

UNF

Unificato passo fine

Machine taps

Maschinengewindebohrer

► 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 374

60°

P

ØD2

ØD1

L1

L2

L3

KI

K

Hole type

3.0×D

Ød1

MU

HSS-E

DIN 371/374

2B

60°

B

Vap Bright TiN

p.B131

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 - 48 UNF		-	TC874182	TD874182	11	56	18	3.5	2.7	6	3	2.4
#5 - 44 UNF		-	TC874222	TD874222	11	56	18	3.5	2.7	6	3	2.7
#6 - 40 UNF		-	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		-	TC874382	TD874382	16	80	30	6	4.9	8	3	4.7
1/4 - 28 UNF		-	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		-	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		-	TC874762	TD874762	26	125	50	18	14.5	17	4	20.5
1 - 12 UNF		-	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.

ISO

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	21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

◎ : Excellent ○ : Good

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			15	30	25	38	34	55	60	42	55	55	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550
Recommended			○			○	○	○													

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YG-1 CO., LTD.

CARBIDE

HSS

COMBO TAP

Vap

TB874

SERIES

Bright

TC874

SERIES

TIN

TD874

SERIES

UNF

Unified Feingewinde

UNF

Unificato passo fine

Machine taps

Maschinengewindebohrer

► 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 374

60°

P

ØD2

ØD1

L1

L2

L3

KI

K

Hole type

3.0×D

Ød1

MU

HSS-E

DIN 371/374

2B

60°

B

Vap Bright TiN

p.B131

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 - 48 UNF		-	TC874182	TD874182	11	56	18	3.5	2.7	6	3	2.4
#5 - 44 UNF		-	TC874222	TD874222	11	56	18	3.5	2.7	6	3	2.7
#6 - 40 UNF		-	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		-	TC874382	TD874382	16	80	30	6	4.9	8	3	4.7
1/4 - 28 UNF		-	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		-	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		-	TC874762	TD874762	26	125	50	18	14.5	17	4	20.5
1 - 12 UNF		-	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.

ISO

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	21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

◎ : Excellent ○ : Good

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			15	30	25	38	34	55	60	42	55	55	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550
Recommended			○			○	○	○													

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YG-1 CO., LTD.

CARBIDE												
HSS												
THREAD MILL												
SYNCHRO TAP												
PRIME TAP												
COMBO TAP												
YG TAP STEEL												
YG TAP CHIP BREAKER												
YG TAP INOX												
YG TAP CAST IRON												
YG TAP HARDENED STEEL												
YG TAP Ti Ni												
YG TAP ALU												
YG TAP FORMING												
YG TAP GENERAL												
PIPE TAP												
STI TAP												
NUT TAP												

					TC804 TC844 TC824 TC864	TD804 TD844 TD824 TD864	TB804 TB844 TB824 TB864	TCE05 TCE09 TCE01 TCE02	TDE05 TDE09 TDE01 TDE02	TBE05	TCE06	TDE06	TBE06
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	15-20
	2		190	13	15-20	20-25	15-20	15-20	20-25	15-20	15-20	20-25	15-20
	3		250	25	12-18	18-24	12-18	12-18	18-24	12-18	12-18	18-24	12-18
	4		270	28	10-15	15-20	10-15	10-15	15-20	10-15	10-15	15-20	10-15
	5		300	32	6-10	10-14	6-10	6-10	10-14	6-10	6-10	10-14	6-10
	6	Low alloy steel	180	10	10-15	15-20	10-15	10-15	15-20	10-15	10-15	15-20	10-15
	7		275	29	10-15	15-20	10-15	10-15	15-20	10-15	10-15	15-20	10-15
	8		300	32	6-10	10-14	6-10	6-10	10-14	6-10	6-10	10-14	6-10
	9		350	38	3-5	5-7	3-5	3-5	5-7	3-5	3-5	5-7	3-5
	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	3-5
M	12	Stainless steel	200	15	7-10	10-15	7-10	7-10	10-15	7-10	7-10	10-15	7-10
	13		240	23	5-8	8-11	5-8	5-8	8-11	5-8	5-8	8-11	5-8
	14		180	10	4-6	6-8	4-6	4-6	6-8	4-6	4-6	6-8	4-6
K	15	Grey cast iron	180	10	10-15	15-20	10-15	10-15	15-20	10-15	10-15	15-20	10-15
	16		260	26	5-8	8-11	5-8	5-8	8-11	5-8	5-8	8-11	5-8
	17	Nodular cast iron	160	3	10-15	15-20	10-15	10-15	15-20	10-15	10-15	15-20	10-15
	18		250	25	5-8	8-11	5-8	5-8	8-11	5-8	5-8	8-11	5-8
N	23	Aluminum-cast, alloyed	75		15-20	20-25	15-20	15-20	20-25	15-20	15-20	20-25	15-20
	26	Copper and Copper Alloys (Bronze / Brass)	110		25-35	35-40	25-35	25-35	35-40	25-35	25-35	35-40	25-35
	27		90		8-12	12-17	8-12	8-12	12-17	8-12	8-12	12-17	8-12
	28		100		15-20	20-25	15-20	15-20	20-25	15-20	15-20	20-25	15-20

					TCE07	TDE07	TBE07	TCE08	TDE08	TBE08	TC804-IC	TC633	TC807
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	15-20	15-20
	2		190	13	15-20	20-25	15-20	15-20	20-25	15-20	15-20	15-20	15-20
	3		250	25	12-18	18-24	12-18	12-18	18-24	12-18	12-18	12-18	12-18
	4		270	28	10-15	15-20	10-15	10-15	15-20	10-15	10-15	10-15	10-15
	5		300	32	6-10	10-14	6-10	6-10	10-14	6-10	6-10	6-10	6-10
	6	Low alloy steel	180	10	10-15	15-20	10-15	10-15	15-20	10-15	10-15	10-15	10-15
	7		275	29	10-15	15-20	10-15	10-15	15-20	10-15	10-15	10-15	10-15
	8		300	32	6-10	10-14	6-10	6-10	10-14	6-10	6-10	6-10	6-10
	9		350	38	3-5	5-7	3-5	3-5	5-7	3-5	3-5	3-5	3-5
	10	High alloyed steel, and tool steel	200	15	3-5	5-7	3-5	3-5	5-7	3-5	3-5	3-5	3-5
M	12	Stainless steel	200	15	7-10	10-15	7-10	7-10	10-15	7-10	7-10	7-10	7-10
	13		240	23	5-8	8-11	5-8	5-8	8-11	5-8	5-8	5-8	5-8
	14		180	10	4-6	6-8	4-6	4-6	6-8	4-6	4-6	4-6	4-6
K	15	Grey cast iron	180	10	10-15	15-20	10-15	10-15	15-20	10-15	10-15	10-15	10-15
	16		260	26	5-8	8-11	5-8	5-8	8-11	5-8	5-8	5-8	5-8
	17	Nodular cast iron	160	3	10-15	15-20	10-15	10-15	15-20	10-15	10-15	10-15	10-15
	18		250	25	5-8	8-11	5-8	5-8	8-11	5-8	5-8	5-8	5-8
N	23	Aluminum-cast, alloyed	75		15-20	20-25	15-20	15-20	20-25	15-20	15-20	15-20	15-20
	26	Copper and Copper Alloys (Bronze / Brass)	110		25-35	35-40	25-35	25-35	35-40	25-35	25-35	25-35	25-35
	27		90		8-12	12-17	8-12	8-12	12-17	8-12	8-12	8-12	8-12
	28		100		15-20	20-25	15-20	15-20	20-25	15-20	15-20	15-20	15-20

					Vc (m/min.)								
P	1	Non-alloy steel	125		15-20	20-25	15-20	15-20	20-25	15-20	15-20	15-20	15-20
	2		190	13	15-20	20-25	15-20	15-20	20-25	15-20	15-20	15-20	15-20
	3		250	25	12-18	18-24	12-18	12-18	18-24	12-18	12-18	12-18	12-18
	4		270	28	10-15	15-20	10-15	10-15	15-20	10-15	10-15	10-15	10-15
	5		300	32	6-10	10-14	6-10	6-10	10-14	6-10	6-10	6-10	6-10
	6	Low alloy steel	180	10	10-15	15-20	10-15	10-15	15-20	10-15	10-15	10-15	10-15
	7		275	29	10-15	15-20	10-15	10-15	15-20	10-15	10-15	10-15	10-15
	8		300	32	6-10	10-14	6-10	6-10	10-14	6-10	6-10	6-10	6-10
	9												

					Vc (m/min.)								
P	1	Non-alloy steel	125		15-20	20-25	15-20	15-20	20-25	15-20	15-20	15-20	15-20
	2		190	13	15-20	20-25	15-20	15-20	20-25	15-20	15-20	15-20	15-20
	3		250	25	12-18	18-24	12-18	12-18	18-24	12-18	12-18	12-18	12-18
	4		270	28	10-15	15-20	10-15	10-15	15-20	10-15	10-15	10-15	10-15
	5		300	32	6-10	10-14	6-10	6-10	10-14	6-10	6-10	6-10	6-10
	6	Low alloy steel	180	10	10-15	15-20	10-15	10-15	15-20	10-15	10-15	10-15	10-15
	7		275	29	10-15	15-20	10-15	10-15	15-20	10-15	10-15	10-15	10-15
	8		300	32	6-10	10-14	6-10	6-10	10-14	6-10	6-10	6-10	6-10
	9												

					Vc (m/min.)								
P	1	Non-alloy steel	125		15-20	20-25	15-20	15-20	20-25	15-20	15-20	15-20	15-20
	2		190	13	15-20	20-25	15-20	15-20	20-25	15-20	15-20	15-20	15-20
	3		250	25	12-18	18-24	12-18	12-18	18-24	12-18	12-18	12-18	12-18
	4		270	28	10-15	15-20	10-15	10-15	15-20	10-15	10-15	10-15	10-15
	5		300	32	6-10	10-14	6-10	6-10	10-14	6-10	6-10	6-10	6-10
	6	Low alloy steel	180	10	10-15	15-20	10-15	10-15	15-20	10-15	10-15	10-15	10-15
	7		275	29	10-15	15-20	10-15	10-15	15-20	10-15	10-15	10-15	10-15
	8		300	32	6-10	10-14	6-10	6-10	10-14	6-10	6-10	6-10	6-10
	9												

					Vc (m/min.)								
P	1	Non-alloy steel	125		15-20	20-25	15-20	15-20	20-25	15-20	15-20	15-20	15-20
	2		190	13	15-20	20-25	15-20	15-20	20-25	15-20	15-20	15-20	15-20
	3		250	25	12-18	18-24	12-18	12-18	18-24	12-18	12-18	12-18	12-18
	4		270	28	10-15	15-20	10-15	10-15	15-20	10-15	10-15	10-15	10-15
	5		300	32	6-10	10-14	6-10	6-10	10-14	6-10	6-10	6-10	6-10
	6	Low alloy steel	180	10	10-15	15-20	10-15	10-15	15-20	10-15	10-15	10-15	10-15
	7		275	29	10-15	15-20	10-15	10-15	15-20	10-15	10-15	10-15	10-15
	8		300	32	6-10	10-14	6-10	6-10	10-14	6-10	6-10	6-10	6-10
	9												

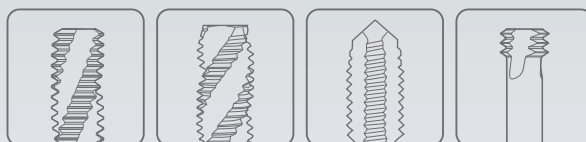
					Vc (m/min.)								
P	1	Non-alloy steel	125		15-20	20-25	15-20	15-20	20-25	15-20	15-20	15-20	15-20
	2		190	13	15-20	20-25	15-20	15-20	20-25	15-20	15-20	15-20	15-20
	3		250	25	12-18	18-24	12-18	12-18	18-24	12-18	12-18	12-18	12-18
	4		270	28	10-15	15-20	10-15	10-15	15-20	10-15	10-15	10-15	10-15
	5		300	32	6-10	10-14	6-10	6-10	10-14	6-10	6-10	6-10	6-10
	6	Low alloy steel	180	10	10-15	15-20	10-15	10-15	15-20	10-15	10-15	10-15	10-15
	7		275	29	10-15	15-20	10-15	10-15	15-20	10-15	10-15	10-15	10-15
	8		300	32	6-10	10-14	6-10	6-10	10-14	6-10	6-10	6-10	6-10
	9												

					Vc (m/min.)								
P	1	Non-alloy steel	125		15-20	20-25	15-20	15-20	20-25	15-20	15-20	15-20	15-20
	2		190	13	15-20	20-25	15-20	15-20	20-25	15-20	15-20	15-20	15-20
	3		250	25	12-18	18-24	12-18	12-18	18-24	12-18	12-18	12-18	12-18
	4		270	28	10-15	15-20	10-15	10-15	15-20	10-15	10-15	10-15	10-15
	5		300	32	6-10	10-14	6-10	6-10	10-14	6-10	6-10	6-10	6-10
	6	Low alloy steel	180	10	10-15	15-20	10-15	10-15	15-20	10-15	10-15	10-15	10-15
	7		275	29	10-15	15-20	10-15	10-15	15-20	10-15	10-15	10-15	10-15
	8		300	32	6-10	10-14	6-10	6-10	10-14	6-10	6-10	6-10	6-10
	9												

					Vc (m/min.)								
P	1	Non-alloy steel	125		15-20	20-25	15-20	15-20	20-25	15-20	15-20	15-20	15-20
	2		190	13	15-20	20-25	15-20	15-20	20-25	15-20	15-20	15-20	15-20
	3		250	25	12-18	18-24	12-18	12-18	18-24	12-18	12-18	12-18	12-18
	4		270	28	10-15	15-20	10-15	10-15	15-20	10-15	10-15	10-15	10-15
	5		300	32	6-10	10-14	6-10	6-10	10-14	6-10	6-10	6-10	6-10
	6	Low alloy steel	180	10	10-15	15-20	10-15	10-15	15-20	10-15	10-15	10-15	10-15
	7		275	29	10-15	15-20	10-15	10-15	15-20	10-15	10-15	10-15	10-15
	8		300	32	6-10	10-14	6-10	6-10	10-14				



Global Cutting Tool Leader **YG-1**



THREADING