Leading Through Innovation

PRIME TAP

PRIME GEWINDEBOHRER

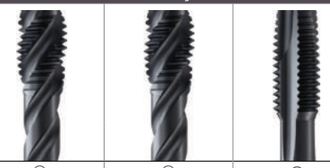
- Premium Spiral Point and Spiral Flute Taps for CNC Machines
- High and Reliable Performance on Various Ductile Materials
- Premium Gerade- und Spiralgenutete Gewindebohrer
- Ausgezeichnete und zuverlässige Leistung in verschiedenen Werkstoffen

SELECTION GUIDE

THREADING TOOLS

HSS-PM
PRIME TAP

Premium Spiral Point and Spiral Flute Taps for CNC Machines
High and Reliable Performance on Various Ductile Materials

HOLE TYPE				Max. 2.5xD Blind Hole	Max. 3.0xD Through Hole
TOOL MATERIAL				HSS-PM	
CHAMFER LEAD ACC. TO DIN2197				C	E	B
FLUTE TYPE				Spiral Flute	Spiral Flute	Spiral Point
SPIRAL FLUTE ANGLE				R45	R45	-
SERIES	M	DIN371/376		TRE30 (p.B77)	TRE34 (p.B78)	TRJ15 (p.B83)
		DIN352				
		DIN357/LONG				
	MF	DIN374		TRE31 (p.B79)		TRJ16 (p.B84)
		DIN2181				
	UNC	DIN371/376		TRE32 (p.B81)		TRJ17 (p.B86)
		DIN351				
	UNF	DIN371/374		TRE33 (p.B82)		TRJ18 (p.B87)
		DIN2181				
	BSW	DIN2182/2183				
		DIN351				
	G(BSP)	DIN5156/5157				
	EG-M	DIN371/376				
	EG-UNC	DIN371/376				
	EG-UNF	DIN371/374				
SURFACE TREATMENT				X-Coating		
MODEL						

Please visit globalyg1.com/mat for material search

◎ : Excellent ○ : Good

Recommended cutting conditions : p.B88

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			

PRIME TAP

TRE30 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

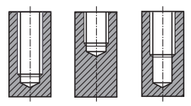
- ▶ High performance on various ductile materials
- ▶ Specially designed to prevent oversized threads and reduce gauging problems

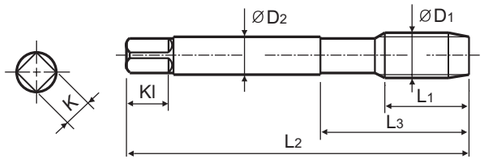
- ▶ Ausgezeichnete Leistung bei verschiedenen Werkstoffen.
- ▶ Speziell entwickelt, um zu groß e Gewindedurchmesser zu vermeiden und Messprobleme zu reduzieren.

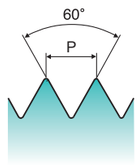
DIN 371

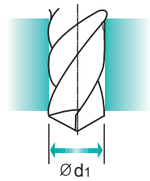
DIN 376

Hole type
2.5×D









Material groups MU | HSS PM | DIN 371/376 | 6HX | 60° | C | R45 | X Coating | p.B88

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	X-Coating	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M2 x	0.4	TRE30136GS	3.2	45.0	13.0	2.8	2.1	5.0	2	1.6
M2.5 x	0.45	TRE30176GS	3.6	50.0	15.0	2.8	2.1	5.0	2	2.1
M3 x	0.5	TRE30206GS	4.0	56.0	18.0	3.5	2.7	6.0	3	2.5
M3.5 x	0.6	TRE30226GS	4.8	56.0	20.0	4.0	3.0	6.0	3	2.9
M4 x	0.7	TRE30246GS	5.6	63.0	21.0	4.5	3.4	6.0	3	3.3
M5 x	0.8	TRE30286GS	6.4	70.0	25.0	6.0	4.9	8.0	3	4.2
M6 x	1.0	TRE30316GS	8.0	80.0	30.0	6.0	4.9	8.0	3	5.0
M7 x	1.0	TRE30346GS	10.0	80.0	30.0	7.0	5.5	8.0	3	6.0
M8 x	1.25	TRE30366GS	13.0	90.0	35.0	8.0	6.2	9.0	3	6.8
M9 x	1.25	TRE30396GS	13.0	90.0	35.0	9.0	7.0	10.0	3	7.8
M10 x	1.5	TRE30426GS	15.0	100.0	39.0	10.0	8.0	11.0	3	8.5
M12 x	1.75	TRE30506GS	18.0	110.0	44.0	9.0	7.0	10.0	3	10.3
M14 x	2.0	TRE30546GS	20.0	110.0	44.0	11.0	9.0	12.0	3	12.0
M16 x	2.0	TRE30606GS	20.0	110.0	44.0	12.0	9.0	12.0	3	14.0
M18 x	2.5	TRE30656GS	25.0	125.0	50.0	14.0	11.0	14.0	4	15.5
M20 x	2.5	TRE30706GS	25.0	140.0	54.0	16.0	12.0	15.0	4	17.5
M22 x	2.5	TRE30746GS	25.0	140.0	54.0	18.0	14.5	17.0	4	19.5
M24 x	3.0	TRE30786GS	30.0	160.0	60.0	18.0	14.5	17.0	4	21.0

▶ DIN 371(M2~M10) and DIN 376(M12~M24)

◎ : 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
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

PRIME TAP

TRE34 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

- ▶ High performance on various ductile materials
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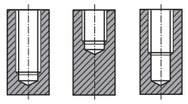
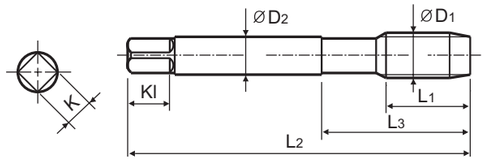
- ▶ Speziell entwickelt, um zu groβe Gewindedurchmesser zu vermeiden und Messprobleme zu reduzieren.

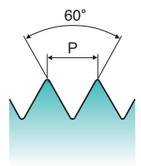
DIN 371

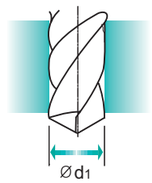
DIN 376

Hole type
2.5×D









Material groups **MU** | HSS PM | DIN 371/376 | 6HX | 60° | E | R45 | X Coating | p.B88

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	X-Coating	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M2 x	0.4	**TRE34136GS**	3.2	45.0	13.0	2.8	2.1	5.0	2	1.6
M3 x	0.5	**TRE34206GS**	4.0	56.0	18.0	3.5	2.7	6.0	3	2.5
M4 x	0.7	**TRE34246GS**	5.6	63.0	21.0	4.5	3.4	6.0	3	3.3
M5 x	0.8	**TRE34286GS**	6.4	70.0	25.0	6.0	4.9	8.0	3	4.2
M6 x	1.0	**TRE34316GS**	8.0	80.0	30.0	6.0	4.9	8.0	3	5.0
M8 x	1.25	**TRE34366GS**	13.0	90.0	35.0	8.0	6.2	9.0	3	6.8
M10 x	1.5	**TRE34426GS**	15.0	100.0	39.0	10.0	8.0	11.0	3	8.5
M12 x	1.75	**TRE34506GS**	18.0	110.0	44.0	9.0	7.0	10.0	3	10.3
M14 x	2.0	**TRE34546GS**	20.0	110.0	44.0	11.0	9.0	12.0	3	12.0
M16 x	2.0	**TRE34606GS**	20.0	110.0	44.0	12.0	9.0	12.0	3	14.0
M20 x	2.5	**TRE34706GS**	25.0	140.0	54.0	16.0	12.0	15.0	4	17.5

▶ DIN 371(M2~M10) and DIN 376(M12~M20)

◎ : 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	○	○	◎	◎	○	◎	◎	◎													

PRIME TAP

TRE31 SERIES

MF ISO Metric Fine Threads DIN 13

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

Machine taps
Maschinengewindebohrer

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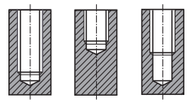
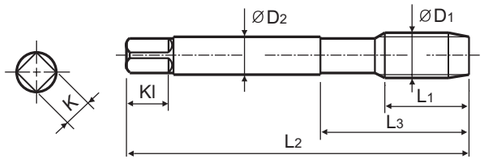
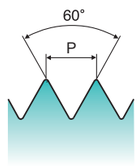
- ▶ Speziell entwickelt, um zu groβe Gewindedurchmesser zu vermeiden und Messprobleme zu reduzieren.

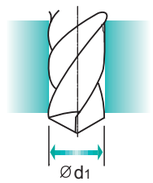
DIN 374

Hole type
2.5×D









Material groups **MU** | HSS PM | DIN 374 | 6HX | 60° | C | R45 | X Coating | p.B88

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	X-Coating	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M4 x	0.5	**TRE31256GS**	5.6	63.0	21.0	2.8	2.1	5.0	3	3.5
M4 x	0.35	**TRE31696GS**	5.6	63.0	21.0	2.8	2.1	5.0	3	3.7
M5 x	0.5	**TRE31296GS**	6.4	70.0	25.0	3.5	2.7	6.0	3	4.5
M6 x	0.75	**TRE31326GS**	8.0	80.0	30.0	4.5	3.4	6.0	3	5.3
M6 x	0.5	**TRE31336GS**	8.0	80.0	30.0	4.5	3.4	6.0	3	5.5
M8 x	1.0	**TRE31376GS**	10.0	90.0	36.0	6.0	4.9	8.0	3	7.0
M8 x	0.75	**TRE31386GS**	10.0	80.0	30.0	6.0	4.9	8.0	3	7.3
M9 x	1.0	**TRE31406GS**	10.0	90.0	36.0	7.0	5.5	8.0	3	8.0
M9 x	0.75	**TRE31416GS**	10.0	80.0	30.0	7.0	5.5	8.0	3	8.3
M10 x	1.25	**TRE31436GS**	13.0	100.0	40.0	7.0	5.5	8.0	3	8.8
M10 x	0.75	**TRE31456GS**	10.0	90.0	36.0	7.0	5.5	8.0	3	9.3
M12 x	1.5	**TRE31516GS**	15.0	100.0	40.0	9.0	7.0	10.0	3	10.5
M12 x	1.25	**TRE31526GS**	15.0	100.0	40.0	9.0	7.0	10.0	3	10.8
M12 x	1.0	**TRE31536GS**	15.0	100.0	40.0	9.0	7.0	10.0	3	11.0
M14 x	1.5	**TRE31556GS**	15.0	100.0	40.0	11.0	9.0	12.0	3	12.5
M14 x	1.25	**TRE31566GS**	15.0	100.0	40.0	11.0	9.0	12.0	3	12.8
M16 x	1.5	**TRE31616GS**	15.0	100.0	40.0	12.0	9.0	12.0	3	14.5
M16 x	1.0	**TRE31626GS**	15.0	100.0	40.0	12.0	9.0	12.0	3	15.0

▶ 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	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
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

PRIME TAP

TRE31 SERIES

MF ISO Metric Fine Threads DIN 13

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

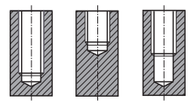
Machine taps
Maschinengewindebohrer

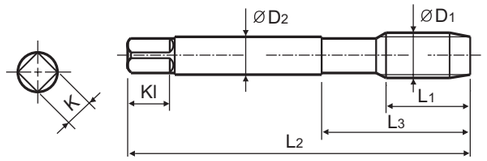
- ▶ High performance on various ductile materials
- ▶ Specially designed to prevent oversized threads and reduce gauging problems

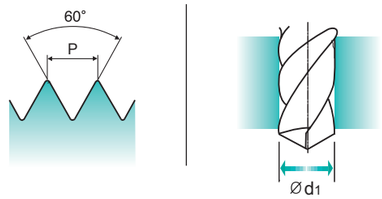
- ▶ Ausgezeichnete Leistung bei verschiedenen Werkstoffen.
- ▶ Speziell entwickelt, um zu groβe Gewindedurchmesser zu vermeiden und Messprobleme zu reduzieren.

DIN 374

Hole type
2.5×D







Material groups **MU** | HSS PM | DIN 374 | 6HX | 60° | C | R45 | X Coating | p.B88

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	X-Coating	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M18 x	2.0	TRE31666GS	20.0	125.0	50.0	14.0	11.0	14.0	4	16.0
M18 x	1.5	TRE31676GS	15.0	110.0	44.0	14.0	11.0	14.0	4	16.5
M18 x	1.0	TRE31686GS	15.0	110.0	44.0	14.0	11.0	14.0	4	17.0
M20 x	2.0	TRE31716GS	20.0	140.0	54.0	16.0	12.0	15.0	4	18.0
M20 x	1.5	TRE31726GS	15.0	125.0	50.0	16.0	12.0	15.0	4	18.5
M20 x	1.0	TRE31736GS	15.0	125.0	50.0	16.0	12.0	15.0	4	19.0
M22 x	2.0	TRE31756GS	20.0	140.0	54.0	18.0	14.5	17.0	4	20.0
M22 x	1.5	TRE31766GS	15.0	125.0	50.0	18.0	14.5	17.0	4	20.5
M22 x	1.0	TRE31776GS	15.0	125.0	50.0	18.0	14.5	17.0	4	21.0
M24 x	2.0	TRE31796GS	20.0	140.0	54.0	18.0	14.5	17.0	4	22.0
M24 x	1.5	TRE31806GS	15.0	140.0	54.0	18.0	14.5	17.0	4	22.5
M24 x	1.0	TRE31816GS	15.0	140.0	54.0	18.0	14.5	17.0	4	23.0

◎ : Excellent ○ : Good

ISO	P																			
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	○	○	◎	◎	○	◎	◎	◎													

PRIME TAP

TRE32 SERIES

UNC Unified Coarse Threads

- Unified Grobgewinde
- UNC
- Unificato passo grosso

Machine taps
Maschinengewindebohrer

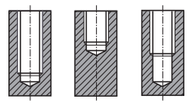
- ▶ High performance on various ductile materials
- ▶ Specially designed to prevent oversized threads and reduce gauging problems

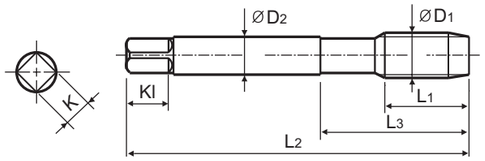
- ▶ Ausgezeichnete Leistung bei verschiedenen Werkstoffen.
- ▶ Speziell entwickelt, um zu groβe Gewindedurchmesser zu vermeiden und Messprobleme zu reduzieren.

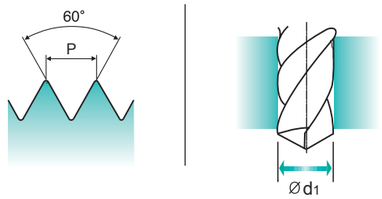
DIN 371

DIN 376

Hole type
2.5×D







Material groups **MU** | HSS PM | DIN 371/376 | 2BX | 60° | C | R45 | X Coating | p.B88

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		X-Coating	L1	L2	L3	ØD2	K	Kl	Z	Ød1
#4 -	40 UNC	TRE32162GS	5.1	56.0	18.0	3.5	2.7	6.0	2	2.30
#5 -	40 UNC	TRE32202GS	5.1	56.0	18.0	3.5	2.7	6.0	3	2.60
#6 -	32 UNC	TRE32242GS	6.4	56.0	20.0	4.0	3.0	6.0	3	2.80
#8 -	32 UNC	TRE32282GS	6.4	63.0	21.0	4.5	3.4	6.0	3	3.40
#10 -	24 UNC	TRE32322GS	8.5	70.0	25.0	6.0	4.9	8.0	3	3.90
#12 -	24 UNC	TRE32362GS	8.5	80.0	30.0	6.0	4.9	8.0	3	4.50
5/16 -	18 UNC	TRE32442GS	14.2	90.0	35.0	8.0	6.2	9.0	3	6.60
7/16 -	14 UNC	TRE32522GS	18.2	100.0	40.0	8.0	6.2	9.0	3	9.40
1/2 -	13 UNC	TRE32562GS	19.6	110.0	44.0	9.0	7.0	10.0	3	10.80
9/16 -	12 UNC	TRE32602GS	21.2	110.0	44.0	11.0	9.0	12.0	3	12.20
5/8 -	11 UNC	TRE32642GS	23.1	110.0	44.0	12.0	9.0	12.0	3	13.60
3/4 -	10 UNC	TRE32702GS	25.4	125.0	50.0	14.0	11.0	14.0	4	16.50
7/8 -	9 UNC	TRE32742GS	28.3	140.0	54.0	18.0	14.5	17.0	4	19.50
1 -	8 UNC	TRE32782GS	31.8	160.0	60.0	20.0	16.0	19.0	4	22.20

▶ DIN 371(#4~3/8) and DIN 376(7/16~1)

◎ : Excellent ○ : Good

ISO	P																			
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	○	○	◎	◎	○	◎	◎	◎													

PRIME TAP

TRE33 SERIES

UNF Unified Fine Threads

- Unified Feingewinde
- UNF
- Unificato passo fine

Machine taps
Maschinengewindebohrer

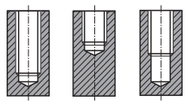
▶ High performance on various ductile materials
▶ Specially designed to prevent oversized threads and reduce gauging problems

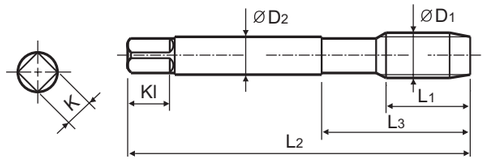
▶ Ausgezeichnete Leistung bei verschiedenen Werkstoffen.
▶ Speziell entwickelt, um zu groβe Gewindedurchmesser zu vermeiden und Messprobleme zu reduzieren.

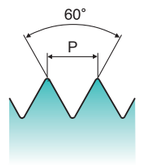
DIN 371

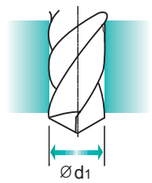
DIN 374

Hole type
2.5×D









Material groups MU | HSS PM | DIN 371/374 | 2BX | 60° | C | R45 | X Coating

p.B88

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		X-Coating	L1	L2	L3	ØD2	K	Kl	Z	Ød1
#4	- 48 UNF	TRE33182GS	5.1	56.0	18.0	3.5	2.7	6.0	2	2.40
#5	- 44 UNF	TRE33222GS	5.1	56.0	18.0	3.5	2.7	6.0	3	2.70
#6	- 40 UNF	TRE33262GS	6.4	56.0	20.0	4.0	3.0	6.0	3	2.90
#8	- 36 UNF	TRE33302GS	6.4	63.0	21.0	4.5	3.4	6.0	3	3.50
#10	- 32 UNF	TRE33342GS	8.5	70.0	25.0	6.0	4.9	8.0	3	4.10
#12	- 28 UNF	TRE33382GS	8.5	80.0	30.0	6.0	4.9	8.0	3	4.60
1/4	- 28 UNF	TRE33422GS	10.2	80.0	30.0	7.0	5.5	8.0	3	5.50
5/16	- 24 UNF	TRE33462GS	10.6	90.0	35.0	8.0	6.2	9.0	3	6.90
3/8	- 24 UNF	TRE33502GS	10.6	100.0	39.0	9.0	7.0	10.0	3	8.50
7/16	- 20 UNF	TRE33542GS	12.7	100.0	40.0	8.0	6.2	9.0	3	9.90
1/2	- 20 UNF	TRE33582GS	12.7	100.0	40.0	9.0	7.0	10.0	3	11.50
9/16	- 18 UNF	TRE33622GS	14.2	100.0	40.0	11.0	9.0	12.0	3	12.90
5/8	- 18 UNF	TRE33662GS	14.2	100.0	40.0	12.0	9.0	12.0	3	14.50
3/4	- 16 UNF	TRE33722GS	15.9	110.0	44.0	14.0	11.0	14.0	4	17.50
7/8	- 14 UNF	TRE33762GS	18.2	125.0	50.0	18.0	14.5	17.0	4	20.50
1	- 12 UNF	TRE33802GS	21.2	140.0	54.0	20.0	16.0	19.0	4	23.20

▶ DIN 371(#4~3/8) and DIN 374(7/16~1)

◎ : 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	○	○	◎	◎	○	◎	◎	◎													

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

PRIME TAP

TRJ15 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

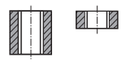
▶ High performance on various ductile materials
▶ Specially designed to prevent oversized threads and reduce gauging problems

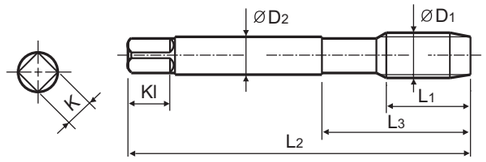
▶ Ausgezeichnete Leistung bei verschiedenen Werkstoffen.
▶ Speziell entwickelt, um zu groβe Gewindedurchmesser zu vermeiden und Messprobleme zu reduzieren.

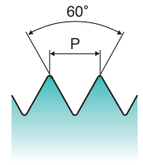
DIN 371

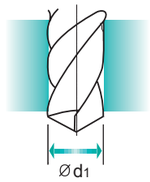
DIN 376

Hole type
3.0×D









Material groups MU | HSS PM | DIN 371/376 | 6HX | 60° | B | X Coating

p.B88

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	X-Coating	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M2	x 0.4	TRJ15136GS	8.0	45.0	13.0	2.8	2.1	5.0	2	1.6
M3	x 0.5	TRJ15206GS	11.0	56.0	18.0	3.5	2.7	6.0	3	2.5
M3.5	x 0.6	TRJ15226GS	12.0	56.0	20.0	4.0	3.0	6.0	3	2.9
M4	x 0.7	TRJ15246GS	13.0	63.0	21.0	4.5	3.4	6.0	3	3.3
M5	x 0.8	TRJ15286GS	15.0	70.0	25.0	6.0	4.9	8.0	3	4.2
M6	x 1.0	TRJ15316GS	17.0	80.0	30.0	6.0	4.9	8.0	3	5.0
M7	x 1.0	TRJ15346GS	17.0	80.0	30.0	7.0	5.5	8.0	3	6.0
M8	x 1.25	TRJ15366GS	20.0	90.0	35.0	8.0	6.2	9.0	3	6.8
M9	x 1.25	TRJ15396GS	20.0	90.0	35.0	9.0	7.0	10.0	3	7.8
M10	x 1.5	TRJ15426GS	22.0	100.0	39.0	10.0	8.0	11.0	3	8.5
M12	x 1.75	TRJ15506GS	24.0	110.0	44.0	9.0	7.0	10.0	3	10.3
M14	x 2.0	TRJ15546GS	26.0	110.0	44.0	11.0	9.0	12.0	3	12.0
M16	x 2.0	TRJ15606GS	27.0	110.0	44.0	12.0	9.0	12.0	3	14.0
M18	x 2.5	TRJ15656GS	30.0	125.0	50.0	14.0	11.0	14.0	3	15.5
M20	x 2.5	TRJ15706GS	32.0	140.0	54.0	16.0	12.0	15.0	3	17.5
M22	x 2.5	TRJ15746GS	32.0	140.0	54.0	18.0	14.5	17.0	3	19.5
M24	x 3.0	TRJ15786GS	34.0	160.0	60.0	18.0	14.5	17.0	3	21.0

▶ DIN 371(M2~M10) and DIN 376(M12~M24)

◎ : 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	○	○	◎	◎	○	◎	◎	◎													

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TRJ16 SERIES

MF ISO Metric Fine Threads DIN 13

Metrisches ISO-Feingewinde DIN 13
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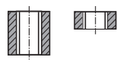
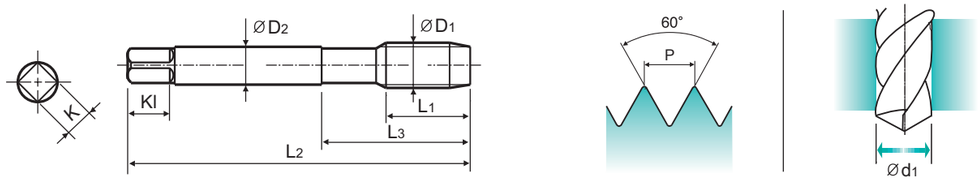
- ▶ Ausgezeichnete Leistung bei verschiedenen Werkstoffen.
- ▶ Speziell entwickelt, um zu groβe Gewindedurchmesser zu vermeiden und Messprobleme zu reduzieren.

DIN 374

Hole type
3.0×D





Material groups MU | HSS PM | DIN 374 | 6HX | 60° | B | X Coating p.B88

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	X-Coating	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M4 x	0.35	TRJ16696GS	10.0	63.0	21.0	2.8	2.1	5.0	3	3.7
M5 x	0.5	TRJ16296GS	11.0	70.0	25.0	3.5	2.7	6.0	3	4.5
M6 x	0.75	TRJ16326GS	13.0	80.0	30.0	4.5	3.4	6.0	3	5.3
M6 x	0.5	TRJ16336GS	13.0	80.0	30.0	4.5	3.4	6.0	3	5.5
M8 x	1.0	TRJ16376GS	17.0	90.0	36.0	6.0	4.9	8.0	3	7.0
M8 x	0.75	TRJ16386GS	14.0	80.0	30.0	6.0	4.9	8.0	3	7.3
M9 x	1.0	TRJ16406GS	20.0	90.0	36.0	7.0	5.5	8.0	3	8.0
M9 x	0.75	TRJ16416GS	17.0	80.0	36.0	7.0	5.5	8.0	3	8.3
M10 x	1.25	TRJ16436GS	22.0	100.0	40.0	7.0	5.5	8.0	3	8.8
M10 x	1.0	TRJ16446GS	18.0	90.0	36.0	7.0	5.5	8.0	3	9.0
M10 x	0.75	TRJ16456GS	18.0	90.0	36.0	7.0	5.5	8.0	3	9.3
M12 x	1.5	TRJ16516GS	22.0	100.0	40.0	9.0	7.0	10.0	3	10.5
M12 x	1.25	TRJ16526GS	22.0	100.0	40.0	9.0	7.0	10.0	3	10.8
M12 x	1.0	TRJ16536GS	18.0	100.0	40.0	9.0	7.0	10.0	3	11.0
M14 x	1.5	TRJ16556GS	22.0	100.0	40.0	11.0	9.0	12.0	3	12.5
M14 x	1.25	TRJ16566GS	22.0	100.0	40.0	11.0	9.0	12.0	3	12.8
M14 x	1.0	TRJ16576GS	18.0	100.0	40.0	11.0	9.0	12.0	3	13.0
M16 x	1.5	TRJ16616GS	22.0	100.0	40.0	12.0	9.0	12.0	3	14.5
M16 x	1.0	TRJ16626GS	18.0	100.0	40.0	12.0	9.0	12.0	3	15.0

▶ 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	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	○	○	◎	◎	○	◎	◎	◎													

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Metrisches ISO-Feingewinde DIN 13
ISO MÉTRIQUE PAS FINS DIN13
ISO Metrico passo grosso DIN 13
Machine taps
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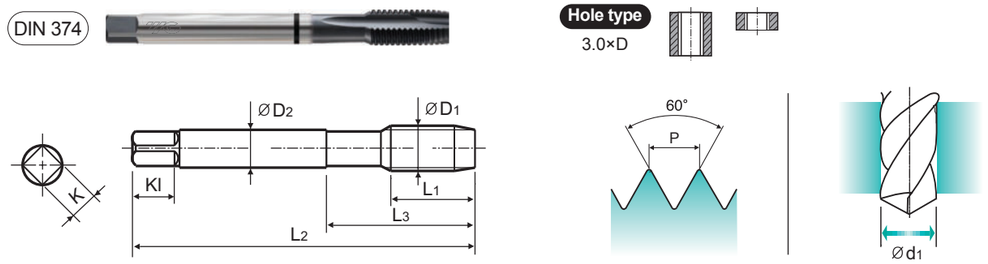
▶ Ausgezeichnete Leistung bei verschiedenen Werkstoffen.
▶ Speziell entwickelt, um zu groβe Gewindedurchmesser zu vermeiden und Messprobleme zu reduzieren.
DIN 374
Hole type
3.0×D



Material groups MU | HSS PM | DIN 374 | 6HX | 60° | B | X Coating p.B88
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	X-Coating	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M18 x	2.0	TRJ16666GS	26.0	125.0	50.0	14.0	11.0	14.0	3	16.0
M18 x	1.5	TRJ16676GS	25.0	110.0	44.0	14.0	11.0	14.0	3	16.5
M18 x	1.0	TRJ16686GS	20.0	110.0	44.0	14.0	11.0	14.0	3	17.0
M20 x	2.0	TRJ16716GS	27.0	140.0	54.0	16.0	12.0	15.0	3	18.0
M20 x	1.5	TRJ16726GS	25.0	125.0	50.0	16.0	12.0	15.0	3	18.5
M20 x	1.0	TRJ16736GS	20.0	125.0	50.0	16.0	12.0	15.0	3	19.0
M22 x	2.0	TRJ16756GS	27.0	140.0	54.0	18.0	14.5	17.0	3	20.0
M22 x	1.5	TRJ16766GS	25.0	125.0	50.0	18.0	14.5	17.0	3	20.5
M22 x	1.0	TRJ16776GS	20.0	125.0	50.0	18.0	14.5	17.0	3	21.0
M24 x	2.0	TRJ16796GS	27.0	140.0	54.0	18.0	14.5	17.0	3	22.0
M24 x	1.5	TRJ16806GS	27.0	140.0	54.0	18.0	14.5	17.0	3	22.5
M24 x	1.0	TRJ16816GS	20.0	140.0	54.0	18.0	14.5	17.0	3	23.0

◎ : 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	○	○	◎	◎	○	◎	◎	◎													

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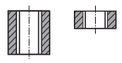
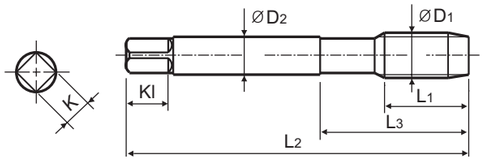
- ▶ Ausgezeichnete Leistung bei verschiedenen Werkstoffen.
- ▶ Speziell entwickelt, um zu gro ß e Gewindedurchmesser zu vermeiden und Messprobleme zu reduzieren.

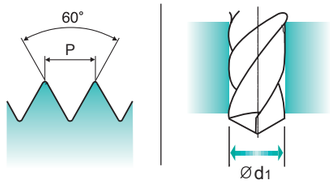
DIN 371

DIN 376

Hole type
3.0×D







Material groups MU | HSS PM | DIN 371/376 | 2BX | 60° | B | X Coating

p.B88

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		X-Coating	L1	L2	L3	ØD2	K	Kl	Z	Ød1
#4	- 40 UNC	TRJ17162GS	11.0	56.0	18.0	3.5	2.7	6.0	2	2.30
#5	- 40 UNC	TRJ17202GS	11.0	56.0	18.0	3.5	2.7	6.0	3	2.60
#6	- 32 UNC	TRJ17242GS	12.0	56.0	20.0	4.0	3.0	6.0	3	2.80
#8	- 32 UNC	TRJ17282GS	13.0	63.0	21.0	4.5	3.4	6.0	3	3.40
#10	- 24 UNC	TRJ17322GS	15.0	70.0	25.0	6.0	4.9	8.0	3	3.90
#12	- 24 UNC	TRJ17362GS	16.0	80.0	30.0	6.0	4.9	8.0	3	4.50
1/4	- 20 UNC	TRJ17402GS	17.0	80.0	30.0	7.0	5.5	8.0	3	5.10
5/16	- 18 UNC	TRJ17442GS	20.0	90.0	35.0	8.0	6.2	9.0	3	6.60
3/8	- 16 UNC	TRJ17482GS	22.0	100.0	39.0	9.0	7.0	10.0	3	8.00
7/16	- 14 UNC	TRJ17522GS	22.0	100.0	40.0	8.0	6.2	9.0	3	9.40
1/2	- 13 UNC	TRJ17562GS	25.0	110.0	44.0	9.0	7.0	10.0	3	10.80
9/16	- 12 UNC	TRJ17602GS	26.0	110.0	44.0	11.0	9.0	12.0	3	12.20
5/8	- 11 UNC	TRJ17642GS	27.0	110.0	44.0	12.0	9.0	12.0	3	13.60
3/4	- 10 UNC	TRJ17702GS	30.0	125.0	50.0	14.0	11.0	14.0	3	16.50
7/8	- 9 UNC	TRJ17742GS	32.0	140.0	54.0	18.0	14.5	17.0	3	19.50
1	- 8 UNC	TRJ17782GS	36.0	160.0	60.0	20.0	16.0	19.0	3	22.20

▶ DIN371 (#4~3/8) and DIN376 (7/16~1)

◎ : Excellent ○ : Good

ISO	P																				
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	○	○	◎	◎	○	◎	◎	◎													

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Unified Feingewinde
UNF
Unificato passo fine

Machine taps
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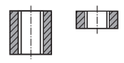
- ▶ High performance on various ductile materials
- ▶ Specially designed to prevent oversized threads and reduce gauging problems

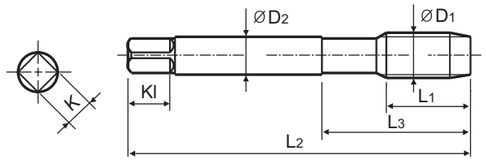
- ▶ Ausgezeichnete Leistung bei verschiedenen Werkstoffen.
- ▶ Speziell entwickelt, um zu gro ß e Gewindedurchmesser zu vermeiden und Messprobleme zu reduzieren.

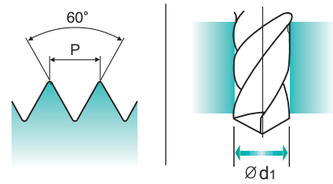
DIN 371

DIN 374

Hole type
3.0×D







Material groups MU | HSS PM | DIN 371/374 | 2BX | 60° | B | X Coating

p.B88

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		X-Coating	L1	L2	L3	ØD2	K	Kl	Z	Ød1
#4	- 48 UNF	TRJ18182GS	11.0	56.0	18.0	3.5	2.7	6.0	2	2.40
#5	- 44 UNF	TRJ18222GS	11.0	56.0	18.0	3.5	2.7	6.0	3	2.70
#6	- 40 UNF	TRJ18262GS	12.0	56.0	20.0	4.0	3.0	6.0	3	2.90
#8	- 36 UNF	TRJ18302GS	13.0	63.0	21.0	4.5	3.4	6.0	3	3.50
#10	- 32 UNF	TRJ18342GS	15.0	70.0	25.0	6.0	4.9	8.0	3	4.10
#12	- 28 UNF	TRJ18382GS	16.0	80.0	30.0	6.0	4.9	8.0	3	4.60
1/4	- 28 UNF	TRJ18422GS	17.0	80.0	30.0	7.0	5.5	8.0	3	5.50
5/16	- 24 UNF	TRJ18462GS	17.0	90.0	35.0	8.0	6.2	9.0	3	6.90
3/8	- 24 UNF	TRJ18502GS	18.0	100.0	39.0	9.0	7.0	10.0	3	8.50
7/16	- 20 UNF	TRJ18542GS	22.0	100.0	40.0	8.0	6.2	9.0	3	9.90
1/2	- 20 UNF	TRJ18582GS	22.0	100.0	40.0	9.0	7.0	10.0	3	11.50
9/16	- 18 UNF	TRJ18622GS	22.0	100.0	40.0	11.0	9.0	12.0	3	12.90
5/8	- 18 UNF	TRJ18662GS	22.0	100.0	40.0	12.0	9.0	12.0	3	14.50
3/4	- 16 UNF	TRJ18722GS	25.0	110.0	44.0	14.0	11.0	14.0	3	17.50
7/8	- 14 UNF	TRJ18762GS	26.0	125.0	50.0	18.0	14.5	17.0	3	20.50
1"	- 12 UNF	TRJ18802GS	28.0	140.0	54.0	20.0	16.0	19.0	3	23.20

▶ DIN371 (#4~3/8) and DIN374 (7/16~1)

◎ : Excellent ○ : Good

ISO	P																				
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	○	○	◎	◎	○	◎	◎	◎													

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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

PRIME TAP

RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDKONDITIONEN

					TRE30, TRE31, TRE32 TRE33, TRE34	TRJ15, TRJ16 TRJ17, TRJ18
ISO	VDI 3323	Material Description	HB	HRc	Vc (m/min.)	
P	1	Non-alloy steel	125		5-20	15-45
	2		190	13	10-50	10-55
	3		250	25	10-50	10-55
	4		270	28	15-40	15-50
	5		300	32	15-40	15-50
	6	Low alloy steel	180	10	8-30	8-30
	7		275	29	8-30	8-30
	8		300	32	8-30	8-30
	9		350	38	8-30	8-30
	10	High alloyed steel, and tool steel	200	15	8-30	8-30
	11		325	35	8-30	8-30
M	12	Stainless steel	200	15	5-15	8-20
	13		240	23	5-15	8-20
	14		180	10	5-15	8-20
K	15	Grey cast iron	180	10	15-35	15-35
	16		260	26	15-35	15-35
	17	Nodular cast iron	160	3	15-35	15-35
	18		250	25	15-35	15-35
N	21	Aluminum-wrought alloy	60		15-35	15-35
	22		100		15-35	15-35
	23	Aluminum-cast, alloyed	75		15-35	15-35
	24		90		15-35	15-35
	25		130		15-35	15-35
	26	Copper and Copper Alloys (Bronze / Brass)	110		15-35	15-35
	27		90		15-35	15-35
	28		100		15-35	15-35