



Leading Through Innovation

HSS & HSS-E

YG TAP GENERAL

YG Gewindebohrer Universal

- Suitable for Tapping Blind / Through Holes due to Flute Geometry and Excellent Chip Evacuation
- Geeignet für das Gewindeschneiden von Grund- und Durchgangsbohrungen aufgrund der Nutengeometrie und der hervorragenden Spanabfuhr

B268 phone:+82-32-526-0909, www.yg1.solutions, E-mail:yg1@yg1.solutions **YG-1 CO., LTD.**

YG-1 CO., LTD. phone:+82-32-526-0909, www.yg1.solutions, E-mail:yg1@yg1.solutions **B269**

SELECTION GUIDE



HSS & HSS-E
YG TAP
GENERAL

Suitable for Tapping Blind / Through Holes
due to Flute Geometry and Excellent Chip Evacuation

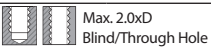


Please visit
globalyg1.com/mat
for material search

◎ : Excellent ○ : Good

Recommended cutting conditions : p.B307

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				HSS-E		
I / II / III	I / III	I / II / III	I / II / III	I / II / III	I / II / III	
Straight Flute	Straight Flute	Straight Flute	Straight Flute	Straight Flute	Straight Flute	
-	-	-	Left Hand Cut	-	-	
						M
			T7343 (p.B304)	TB373 (p.B305)	TC353 (p.B306)	MF
						UNC
T7363 (p.B301)						UNF
	T7509 (p.B302)					BSW
		T7609 (p.B303)				G(BSP)
						EG-M
						EG-UNC
						EG-UNF
Bright	Bright	Bright	Bright	VAP	Bright	
○	○	○	○	○	○	1
○	○	○	○	○	○	2
○	○	○	○	○	○	3
○	○	○	○	○	○	4
						5
○	○	○	○	○	○	6
○	○	○	○	○	○	7
						8
						9
						10
						11
				○		12
				○		13
				○		14
						15
○	○	○	○			16
○	○	○	○			17
						18
						19
						20
						21
						22
						23
○	○	○	○			24
○	○	○	○			25
○	○	○	○			26
○	○	○	○			27
						28
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						40
						41

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

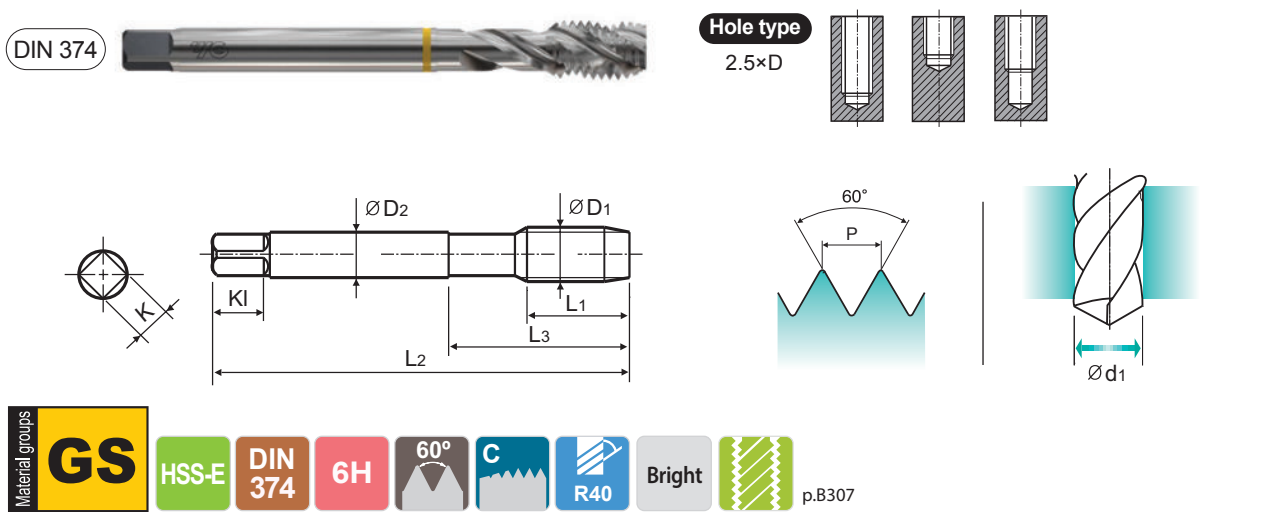
MF ISO metric fine threads DIN 13

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

Machine taps
Maschinengewindebohrer

► Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

► Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.



SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
$\varnothing D_1$	P	Bright	L_1	L_2	L_3	$\varnothing D_2$	K	KI	Z	$\varnothing d_1$
M4	× 0.5	TC411256	5	63	21	2.8	2.1	5	3	3.5
M5	× 0.5	TC411296	5	70	25	3.5	2.7	6	3	4.5
M6	× 0.75	TC411326	8	80	30	4.5	3.4	6	3	5.2
M6	× 0.5	TC411336	5	80	30	4.5	3.4	6	3	5.5
M7	× 0.75	TC411356	10	80	30	5.5	4.3	7	3	6.2
M8	× 1.0	TC411376	10	90	36	6	4.9	8	3	7
M8	× 0.75	TC411386	8	80	30	6	4.9	8	3	7.2
M8	× 0.5	TC411936	5	80	30	6	4.9	8	3	7.5
M10	× 1.25	TC411436	16	100	40	7	5.5	8	3	8.8
M10	× 1.0	TC411446	10	90	36	7	5.5	8	3	9
M10	× 0.75	TC411456	10	90	36	7	5.5	8	3	9.2
M12	× 1.5	TC411516	15	100	40	9	7	10	3	10.5
M12	× 1.0	TC411536	11	100	40	9	7	10	3	11
M14	× 1.5	TC411556	15	100	40	11	9	12	3	12.5
M14	× 1.25	TC411566	15	100	40	11	9	12	3	12.8
M14	× 1.0	TC411576	11	100	40	11	9	12	3	13
M16	× 1.5	TC411616	15	100	40	12	9	12	3	14.5
M16	× 1.0	TC411626	12	100	40	12	9	12	3	15
M18	× 1.5	TC411676	17	110	44	14	11	14	4	16.5
M18	× 1.0	TC411686	13	110	44	14	11	14	4	17

► NEXT PAGE

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

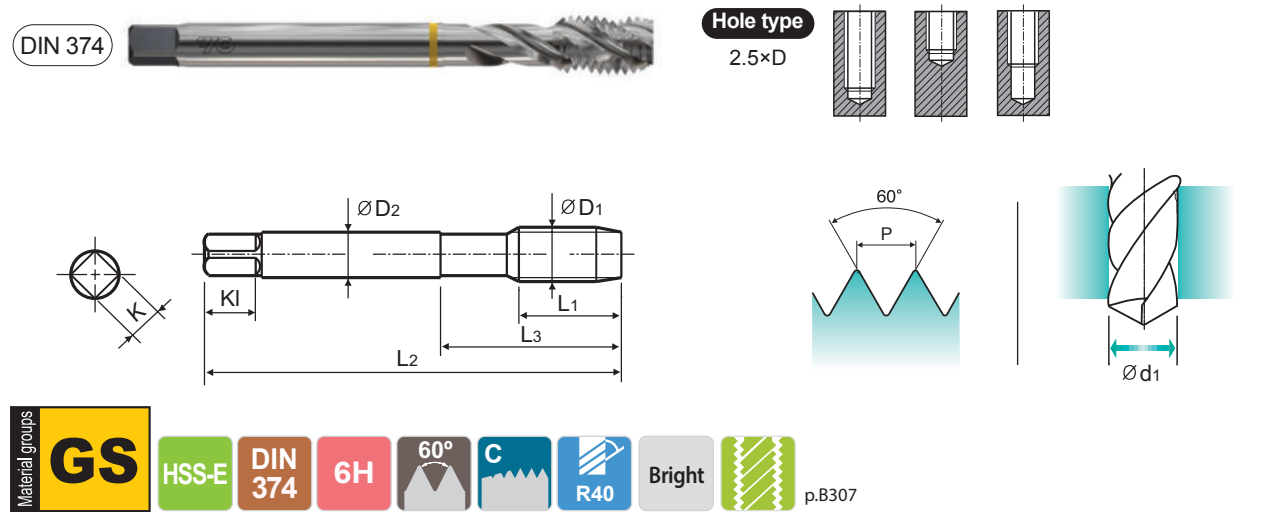
MF ISO metric fine threads DIN 13

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

Machine taps
Maschinengewindebohrer

► Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

► Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.



SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
$\varnothing D_1$	P	Bright	L_1	L_2	L_3	$\varnothing D_2$	K	KI	Z	$\varnothing d_1$
M20	× 1.5	TC411726	17	125	50	16	12	15	4	18.5
M22	× 1.5	TC411766	17	125	50	18	14.5	17	4	20.5
M22	× 1.0	TC411776	14	125	50	18	14.5	17	4	21
M24	× 2.0	TC411796	20	140	54	18	14.5	17	4	22
M24	× 1.5	TC411806	20	140	54	18	14.5	17	4	22.5
M26	× 1.5	TC411856	20	140	54	18	14.5	17	4	24.5
M27	× 2.0	TC411876	20	140	54	20	16	19	4	25
M28	× 1.5	TC411916	20	140	54	20	16	19	4	26.5
M30	× 2.0	TC411966	22	150	57	22	18	21	4	28
M30	× 1.5	TC411976	22	150	57	22	18	21	4	28.5

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

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

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DIN 374

Hole type 2.5×D

Material groups: **GS** HSS-E DIN 374 6H 60° C R40 TiN p.B307

Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1	P	TiN	L1	L2	L3	ØD2	K	KI	Z	Ød1
M4	× 0.5	TD411256	5	63	21	2.8	2.1	5	3	3.5
M6	× 0.75	TD411326	8	80	30	4.5	3.4	6	3	5.2
M6	× 0.5	TD411336	5	80	30	4.5	3.4	6	3	5.5
M7	× 0.75	TD411356	10	80	30	5.5	4.3	7	3	6.2
M8	× 1.0	TD411376	10	90	36	6	4.9	8	3	7
M8	× 0.5	TD411936	5	80	30	6	4.9	8	3	7.5
M10	× 1.25	TD411436	16	100	40	7	5.5	8	3	8.8
M10	× 1.0	TD411446	10	90	36	7	5.5	8	3	9
M12	× 1.5	TD411516	15	100	40	9	7	10	3	10.5
M12	× 1.0	TD411536	11	100	40	9	7	10	3	11
M14	× 1.5	TD411556	15	100	40	11	9	12	3	12.5
M16	× 1.5	TD411616	15	100	40	12	9	12	3	14.5
M16	× 1.0	TD411626	12	100	40	12	9	12	3	15
M18	× 1.5	TD411676	17	110	44	14	11	14	4	16.5
M18	× 1.0	TD411686	13	110	44	14	11	14	4	17
M30	× 2.0	TD411966	22	150	57	22	18	21	4	28

◎ : Excellent ○ : Good

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

UNC **Unified coarse threads**

Unified Grobgewinde
UNC
Unificato passo grosso

Machine taps
Maschinengewindebohrer

► Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

► Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

DIN 371

Hole type 2.5×D

Material groups: **GS** HSS-E DIN 371/376 2B 60° C R40 Bright p.B307

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	L1	L2	L3	ØD2	K	KI	Z	Ød1
#4	-40UNC	TC144162	6	56	18	3.5	2.7	6	3	2.3
#5	-40UNC	TC144202	7	56	18	3.5	2.7	6	3	2.6
#6	-32UNC	TC144242	7	56	20	4	3	6	3	2.85
#8	-32UNC	TC144282	8	63	21	4.5	3.4	6	3	3.5
#10	-24UNC	TC144322	10	70	25	6	4.9	8	3	3.9
#12	-24UNC	TC144362	10	80	30	6	4.9	8	3	4.5
1/4	-20UNC	TC144402	13	80	30	7	5.5	8	3	5.2
5/16	-18UNC	TC144442	14	90	35	8	6.2	9	3	6.6
3/8	-16UNC	TC144482	16	100	39	9	7	10	3	8
7/16	-14UNC	TC144522	17	100	40	8	6.2	9	3	9.4
1/2	-13UNC	TC144562	20	110	44	9	7	10	3	10.75
9/16	-12UNC	TC144602	20	110	44	11	9	12	3	12.25
5/8	-11UNC	TC144642	22	110	44	12	9	12	3	13.5
3/4	-10UNC	TC144702	25	125	50	14	11	14	4	16.5
7/8	-9UNC	TC144742	27	140	54	18	14.5	17	4	19.5
1	-8UNC	TC144782	30	160	60	20	16	19	4	22.25
1-1/8	-7UNC	TC144822	35	180	65	22	18	21	4	25

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

◎ : Excellent ○ : Good

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

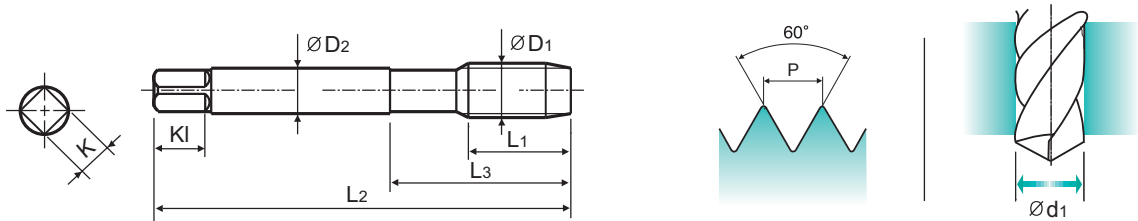
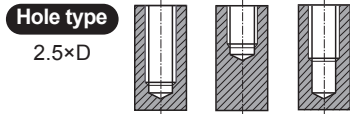
UNF Unified fine threads

Unified Feingewinde
UNF
Unificato passo fine

Machine taps
Maschinengewindebohrer

► Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

► Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.



SIZE	TPI	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
			L ₁	L ₂	L ₃	ØD ₂	K	KI	Z	Ød ₁
#5	-44UNF	TC124222	7	56	18	3.5	2.7	6	3	2.7
1/4	-28UNF	TC124422	10	80	30	7	5.5	8	3	5.5
5/16	-24UNF	TC124462	10	90	35	8	6.2	9	3	6.9
3/8	-24UNF	TC124502	10	100	39	9	7	10	3	8.5
7/16	-20UNF	TC124542	13	100	40	8	6.2	9	3	9.9
1/2	-20UNF	TC124582	13	100	40	9	7	10	3	11.5
9/16	-18UNF	TC124622	15	100	40	11	9	12	3	12.9
5/8	-18UNF	TC124662	15	100	40	12	9	12	3	14.5
3/4	-16UNF	TC124722	17	110	44	14	11	14	4	17.5
7/8	-14UNF	TC124762	17	125	50	18	14.5	17	4	20.5

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

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	13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25	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	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	○	○	○	○	◎	○	○	◎												

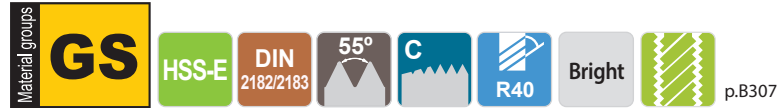
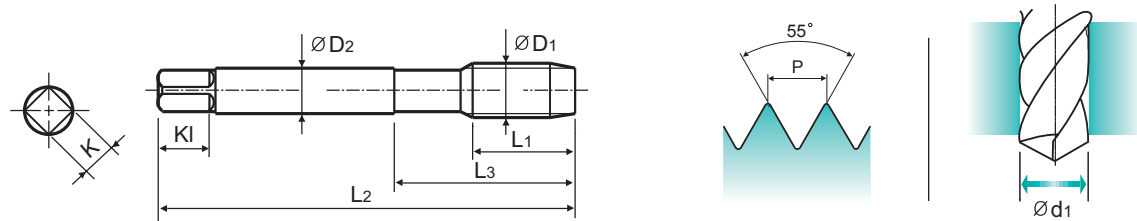
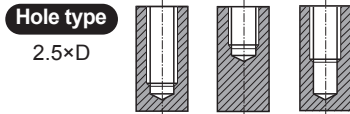
BSW Whitworth threads

Whitworth Gewinde
BSW
Unificato passo grosso

Machine taps
Maschinengewindebohrer

► Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

► Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.



SIZE	TPI	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
			L ₁	L ₂	L ₃	ØD ₂	K	KI	Z	Ød ₁
W1/8	-40	TC134200	7	56	18	3.5	2.7	6	3	2.5
W5/32	-32	TC134280	7	63	21	4.5	3.4	6	3	3.1
W3/16	-24	TC134320	10	70	25	6	4.9	8	3	3.6
W7/32	-24	TC134360	10	80	30	6	4.9	8	3	4.4
W1/4	-20	TC134400	13	80	30	7	5.5	8	3	5.1
W5/16	-18	TC134440	14	90	35	8	6.2	9	3	6.5
W3/8	-16	TC134480	16	100	39	9	7	10	3	7.9
W7/16	-14	TC134520	17	100	40	8	6.2	9	3	9.3
W9/16	-12	TC134600	20	110	44	11	9	12	3	12
W5/8	-11	TC134640	22	110	40	12	9	12	3	13.5
W3/4	-10	TC134700	25	125	50	14	11	14	4	16.5
W7/8	-9	TC134740	27	140	54	18	14.5	17	4	19.25
W1	-8	TC134780	30	160	60	20	16	19	4	22
W1-1/8	-7	TC134820	35	180	65	22	18	21	4	24.75

► DIN 2182(W1/8~W3/8) and DIN 2183(W7/16~W1-1/8)

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	13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25	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	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	○	○	○	○	◎	○	○	◎												

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YG-1 CO., LTD. phone:+82-32-526-0909, www.yg1.solutions, E-mail:yg1@yg1.solutions **B281**

CARBIDE

HSS

YG TAP GENERAL

TC127 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

Suitable for through hole in more cutting speed than other taps due to thick web.

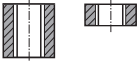
Geeignet für Durchgangslöcher in höherer Schnittgeschwindigkeit als bei anderen Gewindebohrern dank größerer Kerndicke.

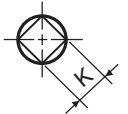
DIN 371

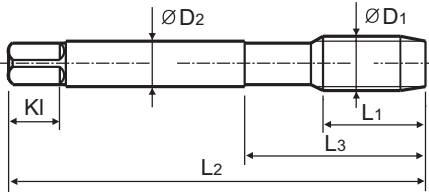


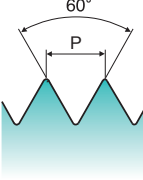
Hole type

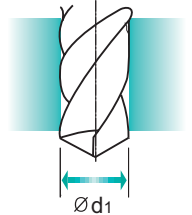
3.0×D











Material groups

GS

HSS-E

DIN 371

6H

60°

B

Bright



p.B307

Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1	P	Bright	L1	L2	L3	ØD2	K	KI	Z	Ød1
M2	× 0.4	TC127136	8	45	13	2.8	2.1	5	3	1.6
M2.2	× 0.45	TC127156	8	45	13	2.8	2.1	5	3	1.75
*M2.3	× 0.4	TC127196	8	45	13	2.8	2.1	5	3	1.9
M2.5	× 0.45	TC127176	9	50	15	2.8	2.1	5	3	2.05
*M2.6	× 0.45	TC127496	9	50	15	2.8	2.1	5	3	2.1
M3	× 0.5	TC127206	11	56	18	3.5	2.7	6	3	2.5
M3.5	× 0.6	TC127226	12	56	20	4	3	6	3	2.9
M4	× 0.7	TC127246	13	63	21	4.5	3.4	6	3	3.3
M4.5	× 0.75	TC127266	14	70	25	6	4.9	8	3	3.7
M5	× 0.8	TC127286	15	70	25	6	4.9	8	3	4.2
M6	× 1.0	TC127316	17	80	30	6	4.9	8	3	5
M7	× 1.0	TC127346	17	80	30	7	5.5	8	3	6
M8	× 1.25	TC127366	20	90	35	8	6.2	9	3	6.8
M9	× 1.25	TC127396	20	90	35	9	7	10	3	7.8
M10	× 1.5	TC127426	22	100	39	10	8	11	3	8.5
M11	× 1.5	TC127466	22	100	39	11	9	12	3	9.5
M12	× 1.75	TC127506	24	110	44	12	9	12	3	10.2

* DIN profile not ISO

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
HRc	13	25	28	32	30	10	29	32	38	15	35	15	23	10
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180
Recommended	○	◎	◎	◎	◎	◎	◎	○	○	○	○	◎	◎	◎

	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	○	○	○	○	◎	○	○	◎							

	Titanium Alloys					Hardened steel					Chilled Cast Iron				
Material Description	Titanium Alloys					Hardened steel					Chilled Cast Iron				
VDI 3323	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50
HRc	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50
HB	400Rm	1050Rm	550	630	400	550	630	400	550		400	550			
Recommended															

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CARBIDE

HSS

YG TAP GENERAL

TD127 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

Suitable for through hole in more cutting speed than other taps due to thick web.

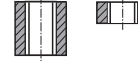
Geeignet für Durchgangslöcher in höherer Schnittgeschwindigkeit als bei anderen Gewindebohrern dank größerer Kerndicke.

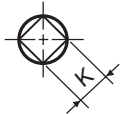
DIN 371

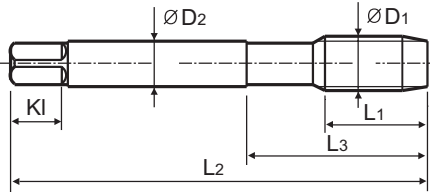


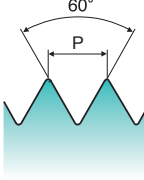
Hole type

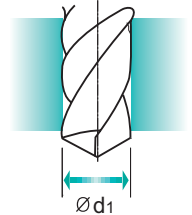
3.0×D











Material groups

GS

HSS-E

DIN 371

6H

60°

B

TiN



p.B307

Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1	P	TiN	L1	L2	L3	ØD2	K	KI	Z	Ød1
M2	× 0.4	TD127136	8	45	13	2.8	2.1	5	3	1.6
M2.5	× 0.45	TD127176	9	50	15	2.8	2.1	5	3	2.05
M3	× 0.5	TD127206	11	56	18	3.5	2.7	6	3	2.5
M3.5	× 0.6	TD127226	12	56	20	4	3	6	3	2.9
M4	× 0.7	TD127246	13	63	21	4.5	3.4	6	3	3.3
M4.5	× 0.75	TD127266	14	70	25	6	4.9	8	3	3.7
M5	× 0.8	TD127286	15	70	25	6	4.9	8	3	4.2
M6	× 1.0	TD127316	17	80	30	6	4.9	8	3	5
M7	× 1.0	TD127346	17	80	30	7	5.5	8	3	6
M8	× 1.25	TD127366	20	90	35	8	6.2	9	3	6.8
M9	× 1.25	TD127396	20	90	35	9	7	10	3	7.8
M10	× 1.5	TD127426	22	100	39	10	8	11	3	8.5
M12	× 1.75	TD127506	24	110	44	12	9	12	3	10.2

*DIN profile not ISO

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
HRc	13	25	28	32	30	10	29	32	38	15	35	15	23	10
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180
Recommended	○	◎	◎	◎	◎	◎	◎	○	○	○	○	◎	◎	◎

	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	○	○	○	○	◎	○	○	◎							

	Titanium Alloys					Hardened steel					Chilled Cast Iron				
Material Description	Titanium Alloys					Hardened steel					Chilled Cast Iron				
VDI 3323	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50
HRc	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50
HB	400Rm	1050Rm	550	630	400	550	630	400	550		400	550			
Recommended															

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CARBIDE

HSS

YG TAP GENERAL

TD127 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

Suitable for through hole in more cutting speed than other taps due to thick web.

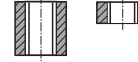
Geeignet für Durchgangslöcher in höherer Schnittgeschwindigkeit als bei anderen Gewindebohrern dank größerer Kerndicke.

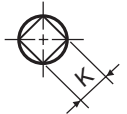
DIN 371

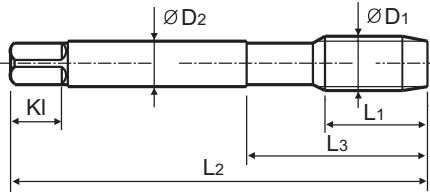


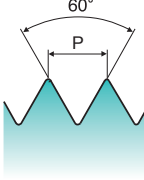
Hole type

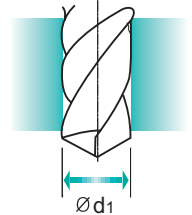
3.0×D











Material groups

GS

HSS-E

DIN 371

6H

60°

B

TiN



p.B307

Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1	P	TiN	L1	L2	L3	ØD2	K	KI	Z	Ød1
M2	× 0.4	TD127136	8	45	13	2.8	2.1	5	3	1.6
M2.5	× 0.45	TD127176	9	50	15	2.8	2.1	5	3	2.05
M3	× 0.5	TD127206	11	56	18	3.5	2.7	6	3	2.5
M3.5	× 0.6	TD127226	12	56	20	4	3	6	3	2.9
M4	× 0.7	TD127246	13	63	21	4.5	3.4	6	3	3.3
M4.5	× 0.75	TD127266	14	70	25	6	4.9	8	3	3.7
M5	× 0.8	TD127286	15	70	25	6	4.9	8	3	4.2
M6	× 1.0	TD127316	17	80	30	6	4.9	8	3	5
M7	× 1.0	TD127346	17	80	30	7	5.5	8	3	6
M8	× 1.25	TD127366	20	90	35	8	6.2	9	3	6.8
M9	× 1.25	TD127396	20	90	35	9	7	10	3	7.8
M10	× 1.5	TD127426	22	100	39	10	8	11	3	8.5
M12	× 1.75	TD127506	24	110	44	12	9	12	3	10.2

*DIN profile not ISO

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
HRc	13	25	28	32	30	10	29	32	38	15	35	15	23	10
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180
Recommended	○	◎	◎	◎	◎	◎	◎	○	○	○	○	◎	◎	◎

	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	○	○	○	○	◎	○	○	◎							

	Titanium Alloys				
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M

ISO metric coarse threads DIN 13

Metrisches ISO-Gewinde DIN 13

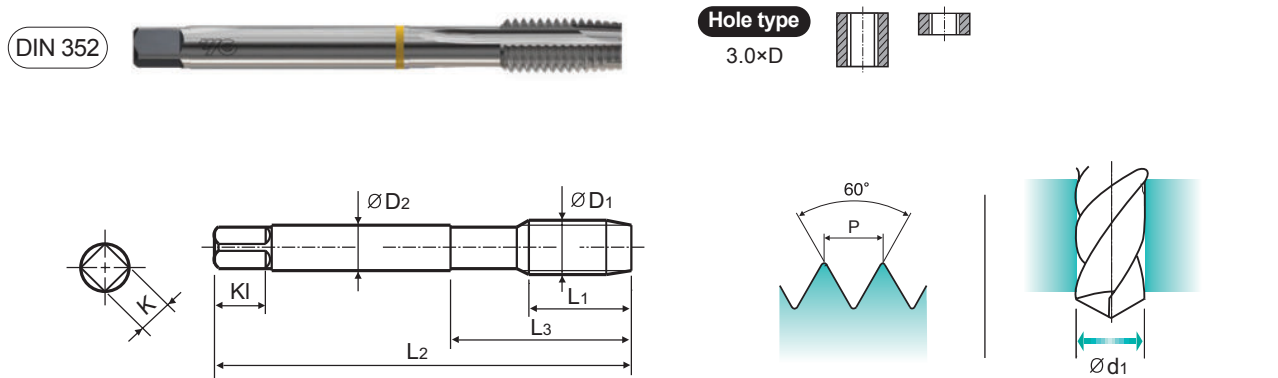
ISO MÉTRIQUE DIN13

ISO Metrico passo grosso DIN 13

Machine taps
Maschinengewindebohrer

► Suitable for through hole in more cutting speed than other taps due to thick web.

► Geeignet für Durchgangslöcher in höherer Schnittgeschwindigkeit als bei anderen Gewindebohrern dank größerer Kerndicke.



Material groups

GS

HSS-E

DIN 352

6H

60°

B

Bright

p.B307

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1	P	Bright	L1	L2	L3	ØD2	K	KI	Z	Ød1
M3	× 0.5	TC122206	11	40	18	3.5	2.7	6	3	2.5
M4	× 0.7	TC122246	13	45	21	4.5	3.4	6	3	3.3
M5	× 0.8	TC122286	16	52	26	6	4.9	8	3	4.2
M6	× 1.0	TC122316	18	56	27	6	4.9	8	3	5
M8	× 1.25	TC122366	20	63	34	6	4.9	8	3	6.8
M10	× 1.5	TC122426	22	70	38	7	5.5	8	3	8.5
M12	× 1.75	TC122506	24	80	45	9	7	10	3	10.2
M14	× 2.0	TC122546	26	80	45	11	9	12	3	12
M16	× 2.0	TC122606	27	80	45	12	9	12	3	14

Unit : mm

◎ : 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	○		○	○	◎	○		◎															

MF

ISO metric fine threads DIN 13

Metrisches ISO-Feingewinde DIN 13

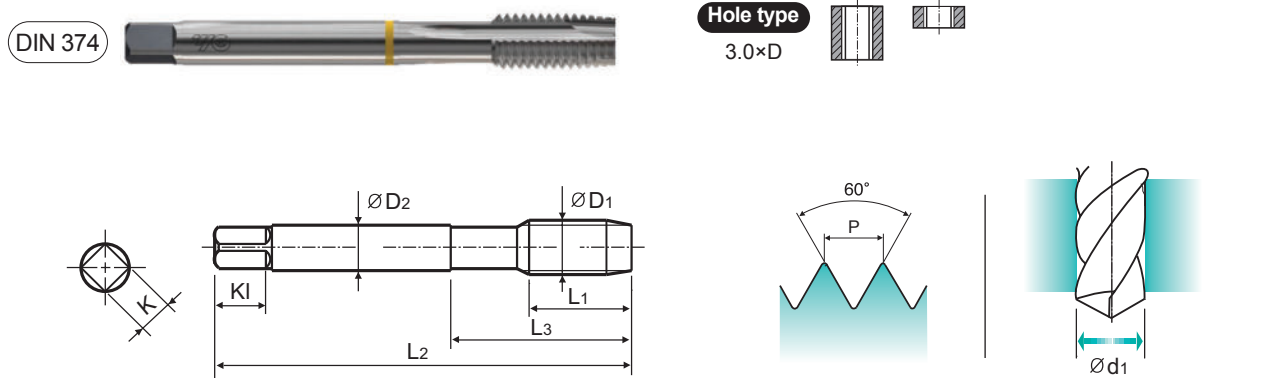
ISO MÉTRIQUE PAS FINS DIN13

ISO Metrico passo fine DIN 13

Machine taps
Maschinengewindebohrer

► Suitable for through hole in more cutting speed than other taps due to thick web.

► Geeignet für Durchgangslöcher in höherer Schnittgeschwindigkeit als bei anderen Gewindebohrern dank größerer Kerndicke.



Material groups

GS

HSS-E

DIN 374

6H

60°

B

Bright

p.B307

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1	P	Bright	L1	L2	L3	ØD2	K	KI	Z	Ød1
M5	× 0.5	TC222296	11	70	25	3.5	2.7	6	3	4.5
M6	× 0.75	TC222326	13	80	30	4.5	3.4	6	3	5.2
M6	× 0.5	TC222336	13	80	30	4.5	3.4	6	3	5.5
M8	× 1.0	TC222376	17	90	36	6	4.9	8	3	7
M8	× 0.75	TC222386	14	80	30	6	4.9	8	3	7.2
M8	× 0.5	TC222936	14	80	30	6	4.9	8	3	7.5
M10	× 1.25	TC222436	22	100	40	7	5.5	8	3	8.8
M10	× 1.0	TC222446	18	90	36	7	5.5	8	3	9
M10	× 0.75	TC222456	18	90	36	7	5.5	8	3	9.2
M12	× 1.5	TC222516	22	100	40	9	7	10	3	10.5
M12	× 1.25	TC222526	22	100	40	9	7	10	3	10.8
M12	× 1.0	TC222536	18	100	40	9	7	10	3	11
M14	× 1.5	TC222556	22	100	40	11	9	12	3	12.5
M14	× 1.25	TC222566	22	100	40	11	9	12	3	12.8
M14	× 1.0	TC222576	18	100	40	11	9	12	3	13
M16	× 1.5	TC222616	22	100	40	12	9	12	3	14.5
M16	× 1.0	TC222626	18	100	40	12	9	12	3	15
M18	× 1.5	TC222676	25	110	44	14	11	14	4	16.5
M18	× 1.0	TC222686	20	110	44	14	11	14	4	17
M20	× 1.5	TC222726	25	125	50	16	12	15	4	18.5
M20	× 1.0	TC222736	20	125	50	16	12	15	4	19
M22	× 1.5	TC222766	25	125	50	18	14.5	17	4	20.5

► 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	36	37	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	○		○	○	◎	○		◎															

BSW

Whitworth threads

Whitworth Gewinde

BSW

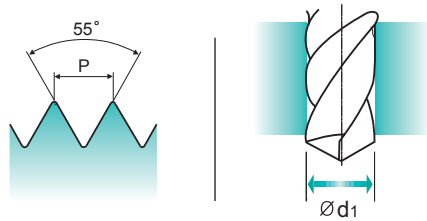
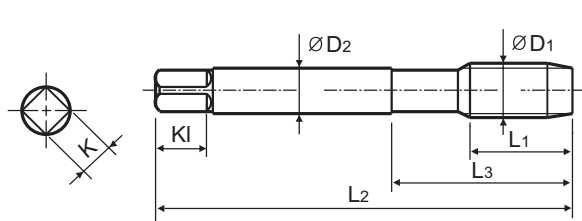
Filettatura Whitworth

Machine taps

Maschinengewindebohrer

► Suitable for through hole in more cutting speed than other taps due to thick web.

► Geeignet für Durchgangslöcher in höherer Schnittgeschwindigkeit als bei anderen Gewindebohrern dank größerer Kerndicke.



SIZE	TPI	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
			L ₁	L ₂	L ₃	ØD ₂	K	KI	Z	Ød ₁
ØD ₁		Bright								
W1/8 - 40		TC224200	11	56	18	3.5	2.7	6	3	2.5
W5/32 - 32		TC224280	13	63	21	4.5	3.4	6	3	3.1
W3/16 - 24		TC224320	15	70	25	6	4.9	8	3	3.6
W7/32 - 24		TC224360	16	80	30	6	4.9	8	3	4.4
W1/4 - 20		TC224400	17	80	30	7	5.5	8	3	5.1
W5/16 - 18		TC224440	20	90	35	8	6.2	9	3	6.5
W3/8 - 16		TC224480	22	100	39	9	7	10	3	7.9
W7/16 - 14		TC224520	22	100	40	8	6.2	9	3	9.3
W1/2 - 12		TC224560	25	110	44	9	7	10	3	10.5
W5/8 - 11		TC224640	27	110	44	12	9	12	3	13.5
W3/4 - 10		TC224700	30	125	50	14	11	14	4	16.5
W7/8 - 9		TC224740	32	140	54	18	14.5	17	4	19.25
W1 - 8		TC224780	36	160	60	20	16	19	4	22
W1-1/8 - 7		TC224820	40	180	65	22	18	21	4	24.75

► DIN 2182(W1/8~W3/8) and DIN 2183(W7/16~W1-1/8)

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	13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25	21	
HRC	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
HB																				
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																				
Recommended	○		○	○	◎	○		◎												

M

ISO metric coarse threads DIN 13

Metrisches ISO-Gewinde DIN 13

ISO MÉTRIQUE DIN13

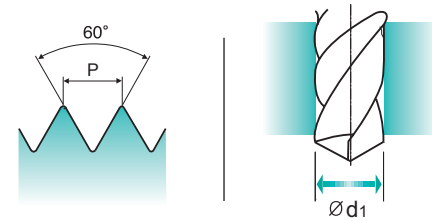
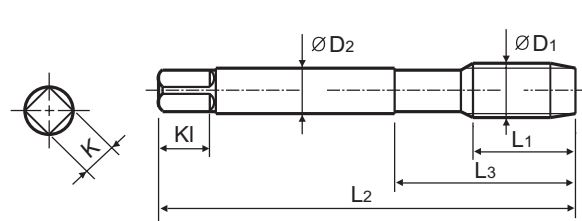
ISO Metrico passo grosso DIN 13

Machine taps

Maschinengewindebohrer

► Suitable for through hole in more cutting speed than other taps due to thick web.

► Geeignet für Durchgangslöcher in höherer Schnittgeschwindigkeit als bei anderen Gewindebohrern dank größerer Kerndicke.



SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
			L ₁	L ₂	L ₃	ØD ₂	K	KI	Z	Ød ₁
ØD ₁	P	Bright								
M3 × 0.5		TC227206	11	56	18	2.2	1.8	5	3	2.5
M3.5 × 0.6		TC227226	12	56	20	2.5	2.1	5	3	2.9
M4 × 0.7		TC227246	13	63	21	2.8	2.1	5	3	3.3
M4.5 × 0.75		TC227266	14	70	25	3.5	2.7	6	3	3.7
M5 × 0.8		TC227286	15	70	25	3.5	2.7	6	3	4.2
M6 × 1.0		TC227316	17	80	30	4.5	3.4	6	3	5
M7 × 1.0		TC227346	17	80	30	5.5	4.3	7	3	6
M8 × 1.25		TC227366	20	90	36	6	4.9	8	3	6.8
M9 × 1.25		TC227396	20	90	36	7	5.5	8	3	7.8
M10 × 1.5		TC227426	22	100	40	7	5.5	8	3	8.5
M11 × 1.5		TC227466	22	100	40	8	6.2	9	3	9.5
M12 × 1.75		TC227506	24	110	44	9	7	10	3	10.2
M14 × 2.0		TC227546	26	110	44	11	9	12	3	12
M16 × 2.0		TC227606	27	110	44	12	9	12	3	14
M18 × 2.5		TC227656	30	125	50	14	11	14	4	15.5
M20 × 2.5		TC227706	32	140	54	16	12	15	4	17.5
M22 × 2.5		TC227746	32	140	54	18	14.5	17	4	19.5
M24 × 3.0		TC227786	34	160	60	18	14.5	17	4	21
M27 × 3.0		TC227866	36	160	60	20	16	19	4	24
M30 × 3.5		TC227946	40	180	70	22	18	21	4	26.5

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																				
Recommended	○		○	○	◎	○		◎												

CARBIDE

HSS

YG TAP GENERAL

TD227 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

► Suitable for through hole in more cutting speed than other taps due to thick web.

► Geeignet für Durchgangslöcher in höherer Schnittgeschwindigkeit als bei anderen Gewindebohrern dank größerer Kerndicke.

DIN 376

Hole type

3.0×D

Material groups

GS

HSS-E

DIN 376

6H

60°

B

TiN

p.B307

Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1	P	TiN	L1	L2	L3	ØD2	K	KI	Z	Ød1
M3	× 0.5	TD227206	11	56	18	2.2	1.8	5	3	2.5
M3.5	× 0.6	TD227226	12	56	20	2.5	2.1	5	3	2.9
M4	× 0.7	TD227246	13	63	21	2.8	2.1	5	3	3.3
M4.5	× 0.75	TD227266	14	70	25	3.5	2.7	6	3	3.7
M5	× 0.8	TD227286	15	70	25	3.5	2.7	6	3	4.2
M6	× 1.0	TD227316	17	80	30	4.5	3.4	6	3	5
M7	× 1.0	TD227346	17	80	30	5.5	4.3	7	3	6
M8	× 1.25	TD227366	20	90	36	6	4.9	8	3	6.8
M9	× 1.25	TD227396	20	90	36	7	5.5	8	3	7.8
M10	× 1.5	TD227426	22	100	40	7	5.5	8	3	8.5
M11	× 1.5	TD227466	22	100	40	8	6.2	9	3	9.5
M12	× 1.75	TD227506	24	110	44	9	7	10	3	10.2
M14	× 2.0	TD227546	26	110	44	11	9	12	3	12
M16	× 2.0	TD227606	27	110	44	12	9	12	3	14
M18	× 2.5	TD227656	30	125	50	14	11	14	4	15.5
M20	× 2.5	TD227706	32	140	54	16	12	15	4	17.5
M22	× 2.5	TD227746	32	140	54	18	14.5	17	4	19.5
M24	× 3.0	TD227786	34	160	60	18	14.5	17	4	21
M30	× 3.5	TD227946	40	180	70	22	18	21	4	26.5

ISO

Material Description

VDI 3323

HRc

HB

Recommended

P

Non-alloy steel

Low alloy steel

High alloyed steel, and tool steel

M

Stainless steel

Grey cast iron

Nodular cast iron

Malleable cast iron

1

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12

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125

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ISO

Material Description

VDI 3323

HRc

HB

Recommended

N

Aluminum-wrought alloy

Aluminum-cast, alloyed

Copper and Copper Alloys (Bronze / Brass)

Non Metallic Materials

S

Heat Resistant Super Alloys

Titanium Alloys

Hardened steel

Chilled Cast Iron

Hardened Cast Iron

21

22

23

24

25

26

27

28

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31

32

33

34

35

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38

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41

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200

280

250

350

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400Rm

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B292

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YG-1 CO., LTD.

CARBIDE

HSS

YG TAP GENERAL

TC211 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

► Left spiral flute and right hand thread tap to push chips ahead in powerful than spiral point taps.

► Rechtsschneidender Gewindebohrer mit Linksdrall um kraftvoller nach vorne zu entspanen als mit Gewindebohrern mit Rechtsdrall.

DIN 371

DIN 376

Hole type

3.0×D

Material groups

GS

HSS-E

DIN 371/376

6H

60°

C

Bright

L20

p.B307

Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1	P	Bright	L1	L2	L3	ØD2	K	KI	Z	Ød1
M2	× 0.4	TC211136	8	45	13	2.8	2.1	5	3	1.6
M2.5	× 0.45	TC211176	9	50	15	2.8	2.1	5	3	2.05
M3	× 0.5	TC211206	11	56	18	3.5	2.7	6	3	2.5
M3.5	× 0.6	TC211226	12	56	20	4	3	6	3	2.9
M4	× 0.7	TC211246	13	63	21	4.5	3.4	6	3	3.3
M5	× 0.8	TC211286	15	70	25	6	4.9	8	3	4.2
M6	× 1.0	TC211316	17	80	30	6	4.9	8	3	5
M7	× 1.0	TC211346	17	80	30	7	5.5	8	3	6
M8	× 1.25	TC211366	20	90	35	8	6.2	9	3	6.8
M10	× 1.5	TC211426	22	100	39	10	8	11	3	8.5
M11	× 1.5	TC211466	22	100	40	8	6.2	9	3	9.5
M12	× 1.75	TC211506	24	110	44	9	7	10	3	10.2
M14	× 2.0	TC211546	26	110	44	11	9	12	3	12
M16	× 2.0	TC211606	27	110	44	12	9	12	3	14
M20	× 2.5	TC211706	32	140	54	16	12	15	4	17.5
M24	× 3.0	TC211786	34	160	60	18	14.5	17	4	21
M27	× 3.0	TC211866	36	160	60	20	16	19	4	24
M30	× 3.5	TC211946	40	180	70	22	18	21	4	26.5

ISO

Material Description

VDI 3323

HRc

HB

Recommended

P

Non-alloy steel

Low alloy steel

High alloyed steel, and tool steel

M

Stainless steel

Grey cast iron

Nodular cast iron

Malleable cast iron

1

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12

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14

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125

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ISO

Material Description

VDI 3323

HRc

HB

Recommended

N

Aluminum-wrought alloy

Aluminum-cast, alloyed

Copper and Copper Alloys (Bronze / Brass)

Non Metallic Materials

S

Heat Resistant Super Alloys

Titanium Alloys

Hardened steel

Chilled Cast Iron

Hardened Cast Iron

21

22

23

24

25

26

27

28

29

30

31

32

33

34

35

36

37

38

39

40

41

60

100

75

90

130

110

90

100

15

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25

38

34

200

280

250

350

320

400Rm

1050Rm

550

630

400

550

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YG-1 CO., LTD.

CARBIDE

HSS

YG TAP GENERAL

TC211 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

► Left spiral flute and right hand thread tap to push chips ahead in powerful than spiral point taps.

► Rechtsschneidender Gewindebohrer mit Linksdrall um kraftvoller nach vorne zu entspanen als mit Gewindebohrern mit Rechtsdrall.

DIN 371

DIN 376

Hole type

3.0×D

Material groups

GS

HSS-E

DIN 371/376

6H

60°

C

Bright

L20

p.B307

Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1	P	Bright	L1	L2	L3	ØD2	K	KI	Z	Ød1
M2	× 0.4	TC211136	8	45	13	2.8	2.1	5	3	1.6
M2.5	× 0.45	TC211176	9	50	15	2.8	2.1	5	3	2.05
M3	× 0.5	TC211206	11	56	18	3.5	2.7	6	3	2.5
M3.5	× 0.6	TC211226	12	56	20	4	3	6	3	2.9
M4	× 0.7	TC211246	13	63	21	4.5	3.4	6	3	3.3
M5	× 0.8	TC211286	15	70	25	6	4.9	8	3	4.2
M6	× 1.0	TC211316	17	80	30	6	4.9	8	3	5
M7	× 1.0	TC211346	17	80	30	7	5.5	8	3	6
M8	× 1.25	TC211366	20	90	35	8	6.2	9	3	6.8
M10	× 1.5	TC211426	22	100	39	10	8	11	3	8.5
M11	× 1.5	TC211466	22	100	40	8	6.2	9	3	9.5
M12	× 1.75	TC211506	24	110	44	9	7	10	3	10.2
M14	× 2.0	TC211546	26	110	44	11	9	12	3	12
M16	× 2.0	TC211606	27	110	44	12	9	12	3	14
M20	× 2.5	TC211706	32	140	54	16	12	15	4	17.5
M24	× 3.0	TC211786	34	160	60	18	14.5	17	4	21
M27	× 3.0	TC211866	36	160	60	20	16	19	4	24
M30	× 3.5	TC211946	40	180	70	22	18	21	4	26.5

ISO

Material Description

VDI 3323

HRc

HB

Recommended

P

Non-alloy steel

Low alloy steel

High alloyed steel, and tool steel

M

Stainless steel

Grey cast iron

Nodular cast iron

Malleable cast iron

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ISO

Material Description

VDI 3323

HRc

HB

Recommended

N

Aluminum-wrought alloy

Aluminum-cast, alloyed

Copper and Copper Alloys (Bronze / Brass)

Non Metallic Materials

S

Heat Resistant Super Alloys

Titanium Alloys

Hardened steel

Chilled Cast Iron

Hardened Cast Iron

21

22

23

24

25

26

27

28

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30

31

32

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34

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41

60

100

75

90

130

110

90

100

15

30

25

38

34

200

280

250

350

320

400Rm

1050Rm

550

630

400

550

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B292

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

YG-1 CO., LTD.

M

ISO metric coarse threads DIN 13

Metrisches ISO-Gewinde DIN 13

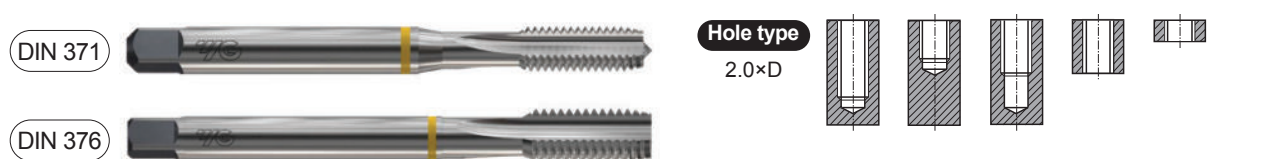
ISO MÉTRIQUE DIN13

ISO Metrico passo grosso DIN 13

Machine taps
Maschinengewindebohrer

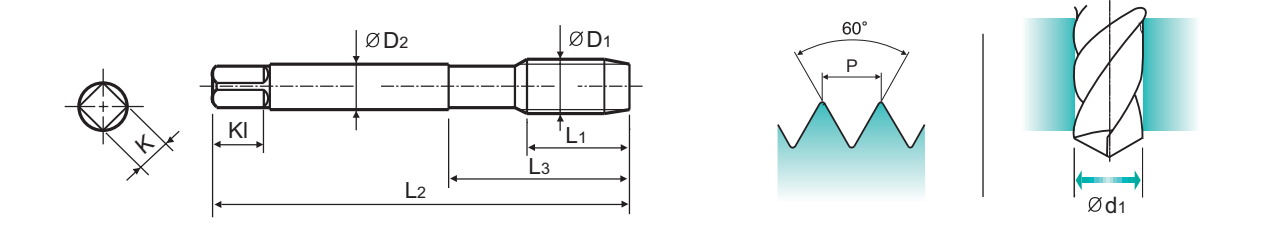
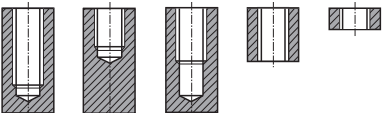
► Suitable for tapping shallow holes and the blind holes having enough chip space at the bottom of holes.

► Geeignet zum Schneiden von kurzem Durchgangsgewinde und in Sacklöchern mit ausreichendem Raum für Späne am Bohrungsgrund.



Hole type

2.0×D



Material groups

GS

HSS-E

DIN 371/376

6H

60°

C

Bright



p.B307

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1	P	Bright	L1	L2	L3	ØD2	K	KI	Z	Ød1
M3	× 0.5	TC463206	11	56	18	3.5	2.7	6	3	2.5
M3.5	× 0.6	TC463226	12	56	20	4	3	6	3	2.9
M4	× 0.7	TC463246	13	63	21	4.5	3.4	6	3	3.3
M4.5	× 0.75	TC463266	14	70	25	6	4.9	8	3	3.7
M5	× 0.8	TC463286	15	70	25	6	4.9	8	3	4.2
M6	× 1.0	TC463316	17	80	30	6	4.9	8	3	5
M8	× 1.25	TC463366	20	90	35	8	6.2	9	3	6.8
M10	× 1.5	TC463426	22	100	39	10	8	11	3	8.5
M12	× 1.75	TC463506	24	110	44	9	7	10	3	10.2
M14	× 2.0	TC463546	26	110	44	11	9	12	3	12
M16	× 2.0	TC463606	27	110	44	12	9	12	3	14
M18	× 2.5	TC463656	30	125	50	14	11	14	4	15.5

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

► * DIN profile not ISO

ISO	P										M					K				
Material Description	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel					Stainless steel				
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc	13	25	28	32	30	10	29	32	38	15	35	15	23	10	10	26	3	25	21	
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○
ISO	N										S					H				
Material Description	Aluminum-wrought alloy					Aluminum-cast, alloyed					Copper and Copper Alloys (Bronze / Brass)					Non Metallic Materials				
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40
HRc	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					○	○	○	○												

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

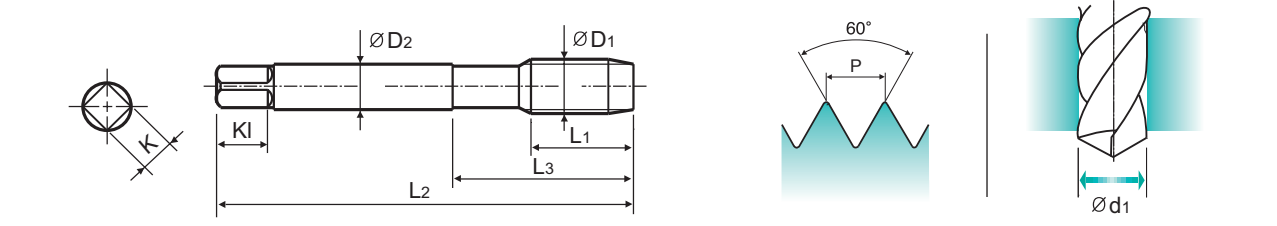
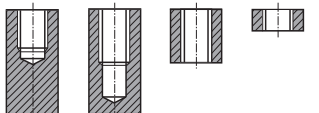
► Suitable for tapping shallow holes.

► Geeignet zum Gewindeschneiden flacher Sacklöcher.



Hole type

2.0×D



Material groups

GS

HSS-E

DIN 374

6H

60°

C

Bright



p.B307

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1	P	Bright	L1	L2	L3	ØD2	K	KI	Z	Ød1
M4	× 0.5	TC473256	10	63	21	2.8	2.1	5	3	3.5
M5	× 0.5	TC473296	11	70	25	3.5	2.7	6	3	4.5
M6	× 0.75	TC473326	13	80	30	4.5	3.4	6	3	5.2
M7	× 0.75	TC473356	14	80	30	5.5	4.3	7	3	6.2
M8	× 1.0	TC473376	17	90	36	6	4.9	8	3	7
M8	× 0.75	TC473386	14	80	30	6	4.9	8	3	7.2
M8	× 0.5	TC473936	14	80	30	6	4.9	8	3	7.5
M10	× 1.25	TC473436	22	100	40	7	5.5	8	3	8.8
M10	× 0.75	TC473456	18	90	36	7	5.5	8	3	9.2
M12	× 1.5	TC473516	22	100	40	9	7	10	3	10.5
M12	× 1.0	TC473536	18	100	40	9	7	10	3	11
M14	× 1.25	TC473566	22	100	40	11	9	12	3	12.8
M14	× 1.0	TC473576	18	100	40	11	9	12	3	13
M16	× 1.5	TC473616	22	100	40	12	9	12	3	14.5

ISO	P										M					K				
Material Description	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel					Stainless steel				
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc	13	25	28	32	30	10	29	32	38	15	35	15	23	10	10	26	3	25	21	
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○
ISO	N										S					H				
Material Description	Aluminum-wrought alloy					Aluminum-cast, alloyed					Copper and Copper Alloys (Bronze / Brass)					Non Metallic Materials				
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40
HRc	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					○	○	○	○												

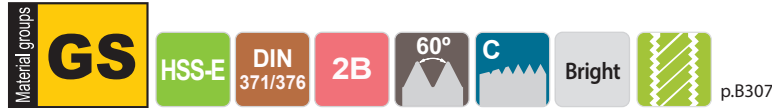
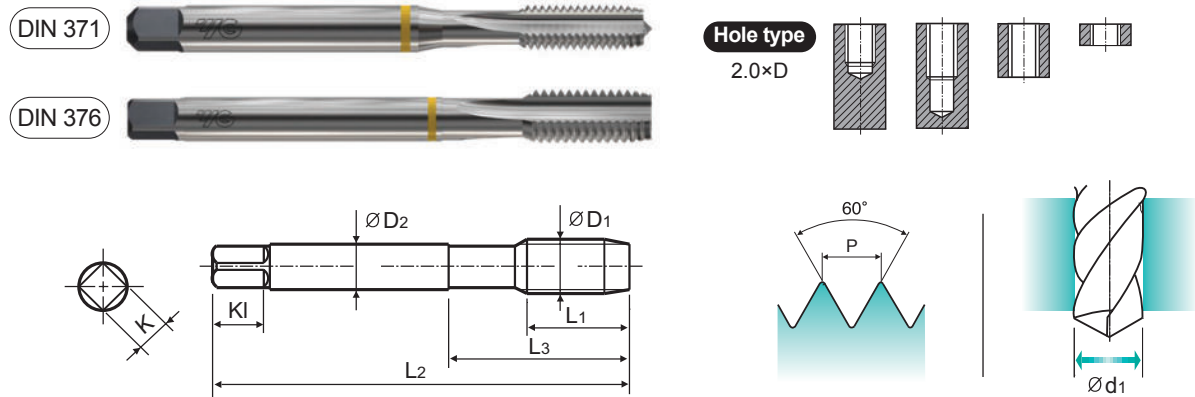
UNC Unified coarse threads

Unified Grobgewinde
UNC
Unificato passo grosso

Machine taps
Maschinengewindebohrer

► Suitable for tapping shallow holes.

► Geeignet zum Gewindeschneiden flacher Sacklöcher.



Unit : mm										
SIZE	TPI	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
$\varnothing D_1$		Bright	L_1	L_2	L_3	$\varnothing D_2$	K	KI	Z	$\varnothing d_1$
#4	- 40UNC	TC424162	11	56	18	3.5	2.7	6	3	2.3
1/4	- 20UNC	TC424402	17	80	30	7	5.5	8	3	5.2
3/8	- 16UNC	TC424482	22	100	39	9	7	10	3	8
7/16	- 14UNC	TC424522	22	100	40	8	6.2	9	3	9.4
1/2	- 13UNC	TC424562	25	110	44	9	7	10	3	10.75
9/16	- 12UNC	TC424602	26	110	44	11	9	12	3	12.25
5/8	- 11UNC	TC424642	27	110	44	12	9	12	3	13.5
1	- 8UNC	TC424782	36	160	60	20	16	19	4	22.25

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

◎ : Excellent ○ : Good										
ISO	P									
Material Description	Non-alloy steel					M				
VDI 3323	1	2	3	4	5	6	7	8	9	10
HRc	13	25	28	32	38	10	29	32	38	15
HB	125	190	250	270	300	180	275	300	350	200
Recommended	○	○	○	○	○	○	○	○	○	○
ISO	N									
Material Description	Aluminum-wrought alloy					S				
VDI 3323	21	22	23	24	25	26	27	28	29	30
HRc	21	22	23	24	25	26	27	28	29	30
HB	60	100	75	90	130	110	90	100		
Recommended	○	○	○	○	○	○	○	○	○	○

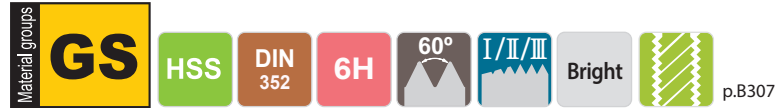
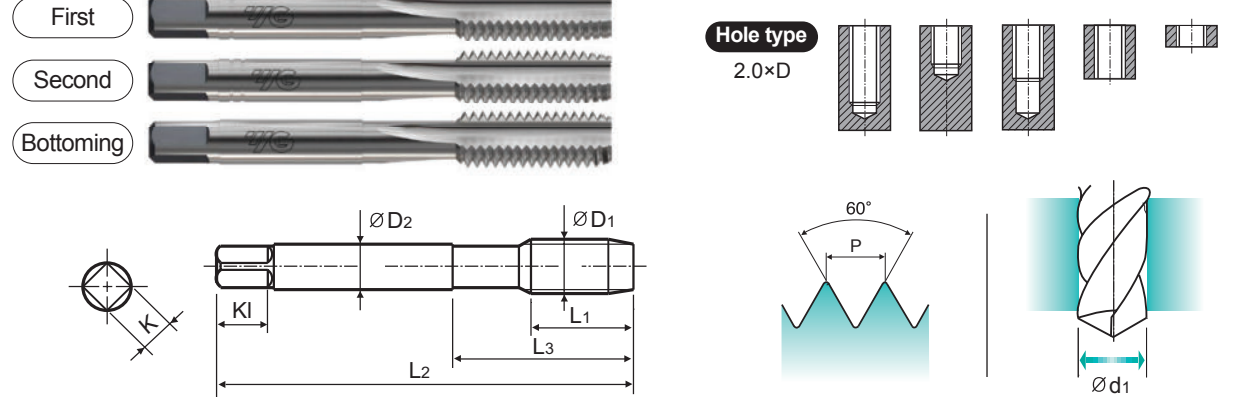
M ISO metric coarse threads DIN 13

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

Sets of taps
Gewindebohrer -Satz

► This tap is a serial hand tap in set, First, Second and Bottoming.
► Bottoming tap of set has final internal thread dimensions only.

► Dies ist ein Handgewindebohrer im Satz mit Vor-, Mittel- und Fertigschneider.
► Nur der Fertigschneider kann das gewünschte Gewinde schneiden



Unit : mm										
SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
$\varnothing D_1$	P	Bright	L_1	L_2	L_3	$\varnothing D_2$	K	KI	Z	$\varnothing d_1$
M2	× 0.4	T7109139	8	36	13	2.8	2.1	5	3	1.6
*M2.3	× 0.4	T7109199	9	36	13	2.8	2.1	5	3	1.9
M2.5	× 0.45	T7109179	9	40	15	2.8	2.1	5	3	2.05
*M2.6	× 0.45	T7109499	9	40	15	2.8	2.1	5	3	2.1
M3	× 0.5	T7109209	11	40	18	3.5	2.7	6	3	2.5
M3.5	× 0.6	T7109229	13	45	21	4	3	6	3	2.9
M4	× 0.7	T7109249	13	45	21	4.5	3.4	6	3	3.3
M4.5	× 0.75	T7109269	16	50	25	6	4.9	8	3	3.7
M5	× 0.8	T7109289	16	52	26	6	4.9	8	3	4.2
M5.5	× 0.9	T7109N69	18	56	27	6	4.9	8	3	4.6
M6	× 1.0	T7109319	18	56	27	6	4.9	8	3	5
M7	× 1.0	T7109349	18	56	28.5	6	4.9	8	3	6
M8	× 1.25	T7109369	20	63	34	6	4.9	8	3	6.8
M9	× 1.25	T7109399	20	63	34	7	5.5	8	4	7.8
M10	× 1.5	T7109429	22	70	38	7	5.5	8	4	8.5
M11	× 1.5	T7109469	22	70	38	8	6.2	9	4	9.5
M12	× 1.75	T7109509	24	80	45	9	7	10	4	10.2
M14	× 2.0	T7109549	26	80	45	11	9	12	4	12
M16	× 2.0	T7109609	27	80	45	12	9	12	4	14
M18	× 2.5	T7109659	30	95	58	14	11	14	4	15.5
M20	× 2.5	T7109709	32	95	58	16	12	15	4	17.5

► *DIN profile not ISO

► NEXT PAGE

◎ : Excellent ○ : Good										
ISO	P									
Material Description	Non-alloy steel					M				
VDI 3323	1	2	3	4	5	6	7	8	9	10
HRc	13	25	28	32	38	10	29	32	38	15
HB	125	190	250	270	300	180	275	300	350	200
Recommended	○	○	○	○	○	○	○	○	○	○
ISO	N									
Material Description	Aluminum-wrought alloy					S				
VDI 3323	21	22	23	24	25	26	27	28	29	30
HRc	21	22	23	24	25	26	27	28	29	30
HB	60	100	75	90	130	110	90	100		
Recommended	○	○	○	○	○	○	○	○	○	○

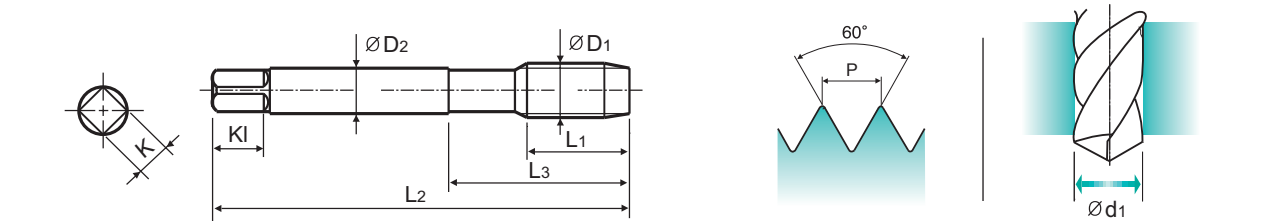
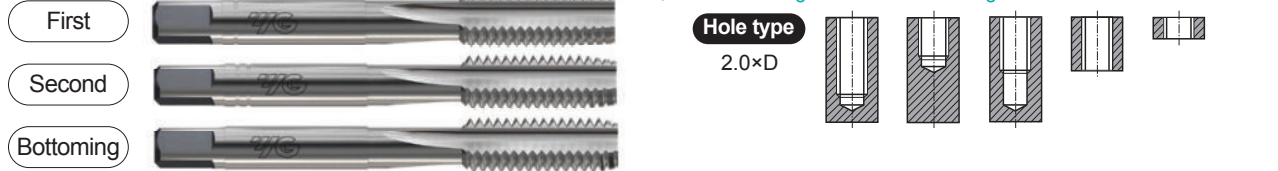
M ISO metric coarse threads DIN 13

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

Sets of taps
Gewindebohrer-Satz

This tap is a serial hand tap in set, First, Second and Bottoming.
Bottoming tap of set has final internal thread dimensions only.

Dies ist ein Handgewindebohrer im Satz mit Vor-, Mittel- und Fertigschneider.
Nur der Fertigschneider kann das gewünschte Gewinde schneiden.



SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1	P	Bright	L1	L2	L3	ØD2	K	KI	Z	Ød1
M22 × 2.5		T7109749	32	100	62	18	14.5	17	4	19.5
M24 × 3.0		T7109789	34	110	69	18	14.5	17	4	21
M27 × 3.0		T7109869	36	110	69	20	16	19	4	24
M30 × 3.5		T7109949	40	125	77	22	18	21	4	26.5
M33 × 3.5		T7109A49	40	125	77	25	20	23	4	29.5
M36 × 4.0		T7109B39	50	150	88	28	22	25	4	32
M39 × 4.0		T7109C09	50	150	88	32	24	27	4	35
M42 × 4.5		T7109C89	56	150	88	32	24	27	4	37.5
M45 × 4.5		T7109D59	58	160	93	36	29	32	4	40.5
M52 × 5.0		T7109F39	65	180	102	40	32	35	4	47

*DIN profile not ISO

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

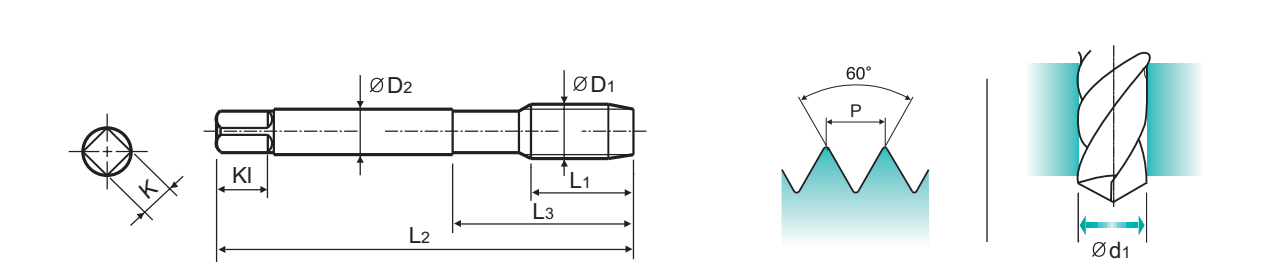
MF ISO metric fine threads DIN 13

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

Sets of taps
Gewindebohrer-Satz

This tap is a serial hand tap in set, First and Bottoming.
Bottoming tap of set has final internal thread dimensions only.

Handgewindebohrersatz mit Vor- und Fertigschneider.
Nur der Fertigschneider kann das gewünschte Gewinde schneiden.



SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1	P	Bright	L1	L2	L3	ØD2	K	KI	Z	Ød1
M3 × 0.35		T7309219	9	40	18	3.5	2.7	6	3	2.65
M4 × 0.5		T7309259	10	45	18	4.5	3.4	6	3	3.5
M5 × 0.5		T7309299	13	52	22	6	4.9	8	3	4.5
M6 × 0.75		T7309329	14	56	24	6	4.9	8	3	5.2
M6 × 0.5		T7309339	13	56	24	6	4.9	8	3	5.5
M7 × 0.75		T7309359	14	56	27	6	4.9	8	3	6.2
M8 × 1.0		T7309379	17	63	27	6	4.9	8	3	7
M8 × 0.75		T7309389	14	63	27	6	4.9	8	3	7.2
M8 × 0.5		T7309939	14	63	27	6	4.9	8	3	7.5
M9 × 1.0		T7309409	17	63	27	7	5.5	8	4	8
M10 × 1.25		T7309439	22	70	32	7	5.5	8	4	8.8
M10 × 1.0		T7309449	18	63	27	7	5.5	8	4	9
M10 × 0.75		T7309459	18	63	27	7	5.5	8	4	9.2
M11 × 1.0		T7309479	18	63	27	8	6.2	9	4	10
M12 × 1.5		T7309519	20	70	32	9	7	10	4	10.5
M12 × 1.25		T7309529	20	70	32	9	7	10	4	10.8
M12 × 1.0		T7309539	18	70	32	9	7	10	4	11
M13 × 1.5		T7309N19	20	70	32	11	9	12	4	11.5
M13 × 1.0		T7309N29	18	70	32	11	9	12	4	12
M14 × 1.5		T7309559	20	70	32	11	9	12	4	12.5
M14 × 1.0		T7309579	18	70	32	11	9	12	4	13
M15 × 1.5		T7309589	20	70	32	12	9	12	4	13.5
M15 × 1.0		T7309599	18	70	32	12	9	12	4	14
M16 × 1.5		T7309619	20	70	32	12	9	12	4	14.5

NEXT PAGE

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

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YG TAP GENERAL

T7509 SERIES

UNF

Unified fine threads

Unified Feingewinde

UNF

Unificato passo fine

Sets of taps
Gewindebohrer-Satz

This tap is a serial hand tap in set, First and Bottoming.

Bottoming tap of set has final internal thread dimensions only.

Handgewindebohrersatz mit Vor- und Fertigschneider.

Nur der Fertigschneider kann das gewünschte Gewinde schneiden.

First

Bottoming

Hole type

2.0×D

60°

P

ØD1

ØD2

L1

L2

L3

KI

Ød1

GS

HSS

DIN 2181

2B

60°

I/III

Bright

p.B307

SIZE	TPI	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1		Bright	L1	L2	L3	ØD2	K	KI	Z	Ød1
#4	- 48 UNF	T7509189	10	42	18	3.5	2.7	6	3	2.4
#5	- 44 UNF	T7509229	10	42	18	3.5	2.7	6	3	2.7
#6	- 40 UNF	T7509269	11	45	18	4	3	6	3	3
#8	- 36 UNF	T7509309	12	48	23	4.5	3.4	6	3	3.5
#10	- 32 UNF	T7509349	14	52	22	6	4.9	8	3	4.1
#12	- 28 UNF	T7509389	16	56	24	6	4.9	8	3	4.7
1/4	- 28 UNF	T7509429	16	56	24	6	4.9	8	3	5.5
5/16	- 24 UNF	T7509469	17	63	27	6	4.9	8	3	6.9
3/8	- 24 UNF	T7509509	18	63	27	7	5.5	8	4	8.5
7/16	- 20 UNF	T7509549	20	70	32	8	6.2	9	4	9.9
1/2	- 20 UNF	T7509589	20	70	32	9	7	10	4	11.5
9/16	- 18 UNF	T7509629	20	70	32	11	9	12	4	12.9
5/8	- 18 UNF	T7509669	20	70	32	12	9	12	4	14.5
3/4	- 16 UNF	T7509729	22	80	38	14	11	14	4	17.5
7/8	- 14 UNF	T7509769	22	80	38	18	14.5	17	4	20.5
1	- 12 UNF	T7509809	22	90	40	18	14.5	17	4	23.25
1-1/8	- 12 UNF	T7509849	22	90	40	22	18	21	4	26.5

© : Excellent ○ : Good

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

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

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YG TAP GENERAL

T7609 SERIES

BSW

Whitworth threads

Whitworth Gewinde

BSW

Filettatura Whitworth

Sets of taps
Gewindebohrer-Satz

This tap is a serial hand tap in set, First, Second and Bottoming.

Bottoming tap of set has final internal thread dimensions only.

Dies ist ein Handgewindebohrer im Satz mit Vor-, Mittel- und Fertigschneider.

Nur der Fertigschneider kann das gewünschte Gewinde schneiden.

First

Second

Bottoming

Hole type

2.0×D

55°

P

ØD1

ØD2

L1

L2

L3

KI

Ød1

GS

HSS

DIN 351

55°

I/II/III

Bright

p.B307

SIZE	TPI	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1		Bright	L1	L2	L3	ØD2	K	KI	Z	Ød1
W3/32	- 48	T7609129	10	40	15	2.8	2.1	5	3	1.8
W1/8	- 40	T7609209	10	42	18	3.5	2.7	6	3	2.5
W5/32	- 32	T7609289	12	48	23	4.5	3.4	6	3	3.1
W3/16	- 24	T7609329	14	52	26	6	4.9	8	3	3.6
W7/32	- 24	T7609369	16	56	27	6	4.9	8	3	4.4
W1/4	- 20	T7609409	16	56	27	6	4.9	8	3	5.1
W5/16	- 18	T7609449	20	63	34	6	4.9	8	3	6.5
W3/8	- 16	T7609489	22	70	38	7	5.5	8	4	7.9
W7/16	- 14	T7609529	22	70	38	8	6.2	9	4	9.3
W1/2	- 12	T7609569	25	80	45	9	7	10	4	10.5
W9/16	- 12	T7609609	26	80	45	11	9	12	4	12
W5/8	- 11	T7609649	27	90	55	12	9	12	4	13.5
W3/4	- 10	T7609709	32	105	65	14	11	14	4	16.5
W7/8	- 9	T7609749	32	110	69	18	14.5	17	4	19.25
W1	- 8	T7609789	36	110	69	20	16	19	4	22
W1-1/8	- 7	T7609829	40	125	77	22	18	21	4	24.75
W1-3/4	- 5	T7609B89	58	160	93	36	29	32	4	39

© : Excellent ○ : Good

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

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

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YG TAP GENERAL

T7343 SERIES

ISO metric coarse threads DIN 13

M-LH

Metrisches ISO-Gewinde DIN 13

ISO MÉTRIQUE DIN13

ISO Metrico passo grosso DIN 13

Sets of taps
Gewindebohrer-Satz

This tap is a serial hand tap in set, First, Second and Bottoming.
Bottoming tap of set has final internal thread dimensions only.

Dies ist ein Handgewindebohrer im Satz mit Vor-, Mittel- und Fertigschneider.
Nur der Fertigschneider kann das gewünschte Gewinde schneiden.

First

Second

Bottoming

Hole type

2.0×D

60°

P

ØD1

ØD2

L1

L2

L3

KI

GS

HSS

DIN 352

6H

60°

I/II/III

Bright

p.B307

Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1	P	Bright	L1	L2	L3	ØD2	K	KI	Z	Ød1
M3	× 0.5	T7343209	11	40	18	3.5	2.7	6	3	2.5
M4	× 0.7	T7343249	13	45	21	4.5	3.4	6	3	3.3
M5	× 0.8	T7343289	16	52	26	6	4.9	8	3	4.2
M6	× 1.0	T7343319	18	56	27	6	4.9	8	3	5
M8	× 1.25	T7343369	20	63	34	6	4.9	8	3	6.8
M10	× 1.5	T7343429	22	70	38	7	5.5	8	4	8.5
M12	× 1.75	T7343509	24	80	45	9	7	10	4	10.2
M14	× 2.0	T7343549	26	80	45	11	9	12	4	12
M16	× 2.0	T7343609	27	80	45	12	9	12	4	14
M18	× 2.5	T7343659	30	95	58	14	11	14	4	15.5
M20	× 2.5	T7343709	32	95	58	16	12	15	4	17.5
M22	× 2.5	T7343749	32	100	62	18	14.5	17	4	19.5
M24	× 3.0	T7343789	34	110	69	18	14.5	17	4	21

► LH=Left hand thread

© : Excellent ○ : Good

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

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YG TAP GENERAL

TB373 SERIES

ISO metric coarse threads DIN 13

M

Metrisches ISO-Gewinde DIN 13

ISO MÉTRIQUE DIN13

ISO Metrico passo grosso DIN 13

Sets of taps
Gewindebohrer-Satz

This tap is a serial hand tap in set, First, Second and Bottoming.
Bottoming tap of set has final internal thread dimensions only.

Dies ist ein Handgewindebohrer im Satz mit Vor-, Mittel- und Fertigschneider.
Nur der Fertigschneider kann das gewünschte Gewinde schneiden.

First

Second

Bottoming

Hole type

2.0×D

60°

P

ØD1

ØD2

L1

L2

L3

KI

GS

HSS-E

DIN 352

6HX

60°

I/II/III

Vap

p.B307

Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1	P	Vap	L1	L2	L3	ØD2	K	KI	Z	Ød1
M3	× 0.5	TB373209	11	40	18	3.5	2.7	6	3	2.5
M4	× 0.7	TB373249	13	45	21	4.5	3.4	6	3	3.3
M5	× 0.8	TB373289	16	52	26	6	4.9	8	3	4.2
M6	× 1.0	TB373319	18	56	27	6	4.9	8	3	5
M8	× 1.25	TB373369	20	63	34	6	4.9	8	3	6.8
M10	× 1.5	TB373429	22	70	38	7	5.5	8	4	8.5
M12	× 1.75	TB373509	24	80	45	9	7	10	4	10.2
M14	× 2.0	TB373549	26	80	45	11	9	12	4	12
M16	× 2.0	TB373609	27	80	45	12	9	12	4	14
M18	× 2.5	TB373659	30	95	58	14	11	14	4	15.5
M20	× 2.5	TB373709	32	95	58	16	12	15	4	17.5

► First with pilot guide

© : Excellent ○ : Good

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

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B305

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YG TAP GENERAL

TB373 SERIES

ISO metric coarse threads DIN 13

M

Metrisches ISO-Gewinde DIN 13

ISO MÉTRIQUE DIN13

ISO Metrico passo grosso DIN 13

Sets of taps
Gewindebohrer-Satz

This tap is a serial hand tap in set, First, Second and Bottoming.
Bottoming tap of set has final internal thread dimensions only.

Dies ist ein Handgewindebohrer im Satz mit Vor-, Mittel- und Fertigschneider.
Nur der Fertigschneider kann das gewünschte Gewinde schneiden.

First

Second

Bottoming

Hole type

2.0×D

60°

P

ØD1

ØD2

L1

L2

L3

KI

GS

HSS-E

DIN 352

6HX

60°

I/II/III

Vap

p.B307

Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1	P	Vap	L1	L2	L3	ØD2	K	KI	Z	Ød1
M3	× 0.5	TB373209	11	40	18	3.5	2.7	6	3	2.5
M4	× 0.7	TB373249	13	45	21	4.5	3.4	6	3	3.3
M5	× 0.8	TB373289	16	52	26	6	4.9	8	3	4.2
M6	× 1.0	TB373319	18	56	27	6	4.9	8	3	5
M8	× 1.25	TB373369	20	63	34	6	4.9	8	3	6.8
M10	× 1.5	TB373429	22	70	38	7	5.5	8	4	8.5
M12	× 1.75	TB373509	24	80	45	9	7	10	4	10.2
M14	× 2.0	TB373549	26	80	45	11	9	12	4	12
M16	× 2.0	TB373609	27	80	45	12	9	12	4	14
M18	× 2.5	TB373659	30	95	58	14	11	14	4	15.5
M20	× 2.5	TB373709	32	95	58	16	12	15	4	17.5

► First with pilot guide

© : Excellent ○ : Good

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

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B304

B305

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YG TAP GENERAL

TC353 SERIES

ISO metric coarse threads DIN 13

Metrisches ISO-Gewinde DIN 13

ISO MÉTRIQUE DIN13

ISO Metrico passo grosso DIN 13

Sets of taps
Gewindebohrer-Satz

This tap is a serial hand tap in set, First, Second and Bottoming.

Bottoming tap of set has final internal thread dimensions only..

Dies ist ein Handgewindebohrer im Satz mit Vor-, Mittel- und Fertigschneider.

Nur der Fertigschneider kann das gewünschte Gewinde schneiden.

First

Second

Bottoming

Hole type

2.0×D

60°

P

ØD1

ØD2

ØD1

L1

L2

L3

KI

Material groups

VG

HSS-E

DIN 352

6H

60°

I/II/III

Bright

p.B307

Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1	P	Bright	L1	L2	L3	ØD2	K	KI	Z	Ød1
M3	× 0.5	TC353209	11	40	18	3.5	2.7	6	3	2.5
M3.5	× 0.6	TC353229	13	45	21	4	3	6	3	2.9
M4	× 0.7	TC353249	13	45	21	4.5	3.4	6	3	3.3
M4.5	× 0.75	TC353269	16	50	25	6	4.9	8	3	3.7
M5	× 0.8	TC353289	16	52	26	6	4.9	8	3	4.2
M6	× 1.0	TC353319	18	56	27	6	4.9	8	3	5
M8	× 1.25	TC353369	20	63	34	6	4.9	8	3	6.8
M10	× 1.5	TC353429	22	70	38	7	5.5	8	4	8.5
M12	× 1.75	TC353509	24	80	45	9	7	10	4	10.2
M14	× 2.0	TC353549	26	80	45	11	9	12	4	12
M16	× 2.0	TC353609	27	80	45	12	9	12	4	14
M18	× 2.5	TC353659	30	95	58	14	11	14	4	15.5
M20	× 2.5	TC353709	32	95	58	16	12	15	4	17.5

► First with pilot guide

© : 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				
HB	125	13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25	21					
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			
HB	60	100	75	90	130	110	90	100			15	30	25	38	34	55	60	55	60	42	55			
Recommended	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	

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YG TAP GENERAL

RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDKONDITIONEN

TC711
TC411
TC144
TC124
TC134

TD711
TD411

TC517
TC612

TC127
TC122
TC214
TC234
TC224

TD127
TD222

TC227

TD227

TC211

TC463
TC473
TC424

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	20-25	15-20	15-20	
	2		190	13	15-20	20-25	15-20	15-20	20-25	15-20	20-25	15-20	15-20	
	3		250	25	12-18	18-24	12-18	12-18	18-24	12-18	18-24	12-18	12-18	
	4		270	28	10-15	15-20	10-15	10-15	15-20	10-15	15-20	10-15	10-15	
	5	Low alloy steel	300	32	6-10	10-14	6-10	6-10	10-14	6-10	10-14	6-10	6-10	
	6		180	10	10-15	15-20	10-15	10-15	15-20	10-15	15-20	10-15	10-15	
	7		275	29	10-15	15-20	10-15	10-15	15-20	10-15	15-20	10-15	10-15	
	8		300	32	6-10	10-14	6-10	6-10	10-14	6-10	10-14	6-10	6-10	
M	12	Stainless steel	200	15	7-10	10-13	7-10	7-10	10-13	7-10	10-13	7-10	7-10	
	13		240	23	5-8	8-11	5-8	5-8	8-11	5-8	8-11	5-8	5-8	
K	15	Grey cast iron	180	10									10-15	
	16		260	26									5-8	
	17	Nodular cast iron	160	3	10-15	15-20	10-15	10-15	15-20	10-15	15-20	10-15	10-15	
	18		250	25	5-8	8-11	5-8	5-8	8-11	5-8	8-11	5-8	5-8	
N	21	Aluminum-wrought alloy	60		10-15	15-20	10-15	10-15	15-20	10-15	15-20	10-15		
	23	Aluminum-cast, alloyed	75		15-20	20-25	15-20	15-20	20-25	15-20	20-25	15-20		
	24		90		15-20	20-25	15-20	15-20	20-25	15-20	20-25	15-20		
	25		130		10-15	15-20	10-15	10-15	15-20	10-15	15-20	10-15	10-15	
	26	Copper and Copper Alloys (Bronze / Brass)	110		25-35	35-40	25-35	25-35	35-40	25-35	35-40	25-35	25-35	
	27		90										8-12	
	28		100		15-20	20-25	15-20	15-20	20-25	15-20	20-25	15-20		

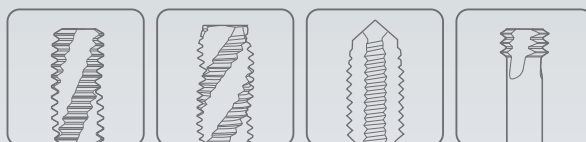
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Global Cutting Tool Leader **YG-1**



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