Leading Through Innovation

HSS-E & HSS-PM

YG TAP STEEL

YG Gewindebohrer Stähle

- For Steel Materials but also other Long Chip Forming Materials
- Für Stahlwerkstoffe, aber auch andere langspanende Werkstoffe

SELECTION GUIDE

YG THREADING TOOLS

HSS-E & HSS-PM YG TAP STEEL

For Steel Materials but also other Long Chip Forming Materials

Please visit globalyg1.com/mat for material search

◎ : Excellent ○ : Good

Recommended cutting conditions : p.B159

SERIES		HOLE TYPE	Max. 2.5xD Blind Hole			
		TOOL MATERIAL	HSS-PM		HSS-E	
		CHAMFER LEAD ACC. TO DIN2197	C	C	C	C
		FLUTE TYPE	Spiral Flute	Spiral Flute	Spiral Flute	Spiral Flute
		SPIRAL FLUTE ANGLE	R40	R40	R40	R40
M	DIN371/376		TQ823 (p.B136)	TR823 (p.B137)	TC312 (p.B138)	TD312 (p.B139)
M	DIN352					
M	DIN357/LONG					
MF	DIN374				TC413 (p.B142)	TD413 (p.B143)
MF	DIN2181					
UNC	DIN371/376				TC174 (p.B144)	TD174 (p.B145)
UNC	DIN351					
UNF	DIN371/374				TC184 (p.B146)	
UNF	DIN2181					
BSW	DIN2182/2183					
BSW	DIN351					
G(BSP)	DIN5156/5157					
EG-M	DIN371/376					
EG-UNC	DIN371/376					
EG-UNF	DIN371/374					
SURFACE TREATMENT			VAP	Bright	Bright	TiN
MODEL						

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

	Max. 2.5xD Blind Hole			Max. 3.0xD Through Hole					
	HSS-E			HSS-PM		HSS-E			
	C	C	C	B	B	B	B	B	B
	Spiral Flute	Spiral Flute	Spiral Flute	Spiral Point	Spiral Point	Spiral Point	Spiral Point	Spiral Point	Spiral Point
	R40	R40	R40	-	-	-	-	-	-
M	TB312 (p.B140)	TY312 (p.B141)	TB913 (p.B147)	TQ863 (p.B148)	TR863 (p.B149)	TC422 (p.B150)	TD422 (p.B151)	TE422 (p.B152)	TY422 (p.B153)
M									
M									
MF						TC263 (p.B154)	TD263 (p.B155)		
MF									
UNC						TC244 (p.B156)	TD244 (p.B157)		
UNC									
UNF						TC254 (p.B158)			
UNF									
BSW									
BSW									
G(BSP)									
EG-M									
EG-UNC									
EG-UNF									
SURFACE TREATMENT	VAP	TiAlN	VAP	VAP	Bright	Bright	TiN	Nitride	TiAlN
MODEL									

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

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

YG TAP STEEL

TQ823 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

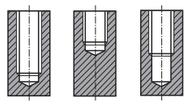
▶ Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

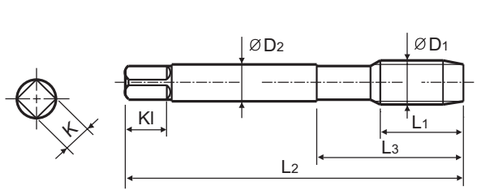
▶ Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

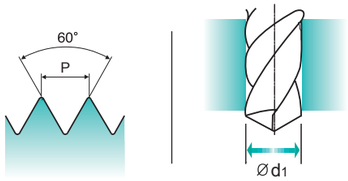
DIN 371

DIN 376

Hole type
2.5×D







Material groups **VG** | HSS PM | DIN 371/376 | 6H | 60° | C | R40 | Vap | p.B159

Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1	P	Vap	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M2.5 ×	0.45	**TQ823176**	9	50	15	2.8	2.1	5	3	2.05
M3 ×	0.5	**TQ823206**	6	56	18	3.5	2.7	6	3	2.5
M3.5 ×	0.6	**TQ823226**	7	56	20	4	3	6	3	2.9
M4 ×	0.7	**TQ823246**	7	63	21	4.5	3.4	6	3	3.3
M4.5 ×	0.75	**TQ823266**	8	70	25	6	4.9	8	3	3.7
M5 ×	0.8	**TQ823286**	8	70	25	6	4.9	8	3	4.2
M6 ×	1.0	**TQ823316**	10	80	30	6	4.9	8	3	5
M8 ×	1.25	**TQ823366**	13	90	35	8	6.2	9	3	6.8
M10 ×	1.5	**TQ823426**	15	100	39	10	8	11	3	8.5
M12 ×	1.75	**TQ823506**	18	110	44	9	7	10	3	10.2

▶ DIN 371(M2~M10) and DIN 376(M12)

◎ : 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											○					○					

YG TAP STEEL

TR823 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

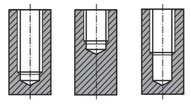
▶ Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

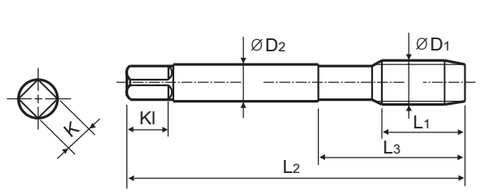
▶ Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

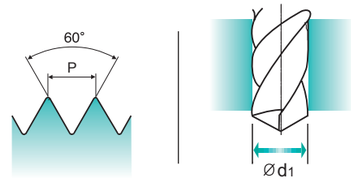
DIN 371

DIN 376

Hole type
2.5×D







Material groups **VG** | HSS PM | DIN 371/376 | 6H | 60° | C | R40 | Bright | p.B159

Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1	P	Bright	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M2.5 ×	0.45	**TR823176**	9	50	15	2.8	2.1	5	3	2.05
M3.5 ×	0.6	**TR823226**	7	56	20	4	3	6	3	2.9
M4 ×	0.7	**TR823246**	7	63	21	4.5	3.4	6	3	3.3
M5 ×	0.8	**TR823286**	8	70	25	6	4.9	8	3	4.2
M6 ×	1.0	**TR823316**	10	80	30	6	4.9	8	3	5
M8 ×	1.25	**TR823366**	13	90	35	8	6.2	9	3	6.8
M10 ×	1.5	**TR823426**	15	100	39	10	8	11	3	8.5
M12 ×	1.75	**TR823506**	18	110	44	9	7	10	3	10.2

▶ DIN 371(M2~M10) and DIN 376(M12)

◎ : 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

YG TAP STEEL

TC312 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

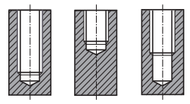
▶ Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

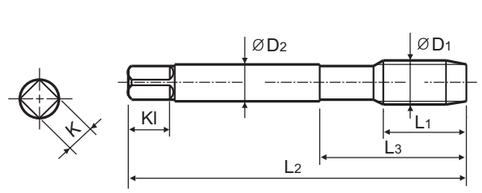
▶ Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

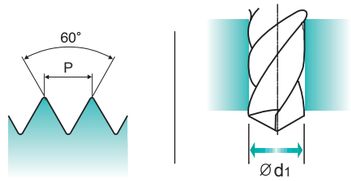
DIN 371

DIN 376

Hole type
2.5×D







Material groups VG | HSS-E | DIN 371/376 | 6H | 60° | C | R40 | Bright | p.B159

Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1	P	Bright	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M2	× 0.4	**TC312136**	8	45	13	2.8	2.1	5	3	1.6
M2.2	× 0.45	**TC312156**	8	45	13	2.8	2.1	5	3	1.75
*M2.3	× 0.4	**TC312196**	8	45	13	2.8	2.1	5	3	1.9
M2.5	× 0.45	**TC312176**	9	50	15	2.8	2.1	5	3	2.05
*M2.6	× 0.45	**TC312496**	9	50	15	2.8	2.1	5	3	2.1
M3	× 0.5	**TC312206**	6	56	18	3.5	2.7	6	3	2.5
M3.5	× 0.6	**TC312226**	7	56	20	4	3	6	3	2.9
M4	× 0.7	**TC312246**	7	63	21	4.5	3.4	6	3	3.3
M4.5	× 0.75	**TC312266**	8	70	25	6	4.9	8	3	3.7
M5	× 0.8	**TC312286**	8	70	25	6	4.9	8	3	4.2
M6	× 1.0	**TC312316**	10	80	30	6	4.9	8	3	5
M7	× 1.0	**TC312346**	10	80	30	7	5.5	8	3	6
M8	× 1.25	**TC312366**	13	90	35	8	6.2	9	3	6.8
M9	× 1.25	**TC312396**	13	90	35	9	7	10	3	7.8
M10	× 1.5	**TC312426**	15	100	39	10	8	11	3	8.5
M11	× 1.5	**TC312466**	17	100	40	8	6.2	9	3	9.5
M12	× 1.75	**TC312506**	18	110	44	9	7	10	3	10.2
M14	× 2.0	**TC312546**	20	110	44	11	9	12	3	12
M16	× 2.0	**TC312606**	20	110	44	12	9	12	3	14
M18	× 2.5	**TC312656**	25	125	50	14	11	14	4	15.5
M20	× 2.5	**TC312706**	25	140	54	16	12	15	4	17.5
M24	× 3.0	**TC312786**	30	160	60	18	14.5	17	4	21
M27	× 3.0	**TC312866**	30	160	60	20	16	19	4	24
M30	× 3.5	**TC312946**	35	180	70	22	18	21	4	26.5

▶ DIN 371(M2~M10) and DIN 376(M11~M30)
▶ * DIN profile not ISO

◎ : 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											○					○					

YG TAP STEEL

TD312 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

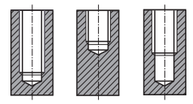
▶ Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

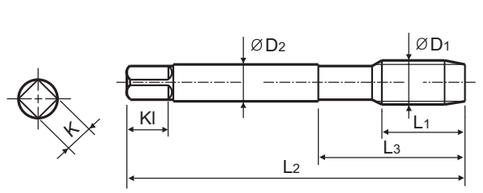
▶ Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

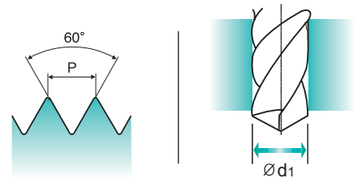
DIN 371

DIN 376

Hole type
2.5×D







Material groups VG | HSS-E | DIN 371/376 | 6H | 60° | C | R40 | TiN | p.B159

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	Kl	Z	Ød1
M2	× 0.4	**TD312136**	8	45	13	2.8	2.1	5	3	1.6
M3	× 0.5	**TD312206**	6	56	18	3.5	2.7	6	3	2.5
M3.5	× 0.6	**TD312226**	7	56	20	4	3	6	3	2.9
M4	× 0.7	**TD312246**	7	63	21	4.5	3.4	6	3	3.3
M5	× 0.8	**TD312286**	8	70	25	6	4.9	8	3	4.2
M6	× 1.0	**TD312316**	10	80	30	6	4.9	8	3	5
M7	× 1.0	**TD312346**	10	80	30	7	5.5	8	3	6
M8	× 1.25	**TD312366**	13	90	35	8	6.2	9	3	6.8
M10	× 1.5	**TD312426**	15	100	39	10	8	11	3	8.5
M12	× 1.75	**TD312506**	18	110	44	9	7	10	3	10.2
M14	× 2.0	**TD312546**	20	110	44	11	9	12	3	12
M16	× 2.0	**TD312606**	20	110	44	12	9	12	3	14
M18	× 2.5	**TD312656**	25	125	50	14	11	14	4	15.5
M20	× 2.5	**TD312706**	25	140	54	16	12	15	4	17.5
M22	× 2.5	**TD312746**	25	140	54	18	14.5	17	4	19.5
M24	× 3.0	**TD312786**	30	160	60	18	14.5	17	4	21
M27	× 3.0	**TD312866**	30	160	60	20	16	19	4	24
M30	× 3.5	**TD312946**	35	180	70	22	18	21	4	26.5

▶ DIN 371(M2~M10) and DIN 376(M11~M30)
▶ * DIN profile not ISO

◎ : 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											○					○					

YG TAP STEEL

TB312 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

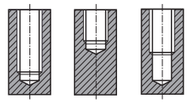
▶ Suitable for threading blind holes due to excellent chip evacuation of tempered steels or similar work materials.

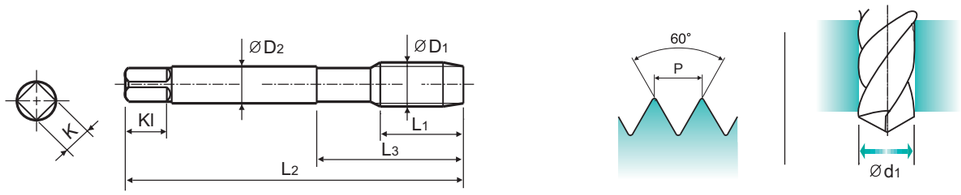
▶ Geeignet zum Gewinden von Sacklöchern dank ausgezeichneter Spanabfuhr von angelassenen Stählen oder ähnlichen Werkstoffen.

DIN 371

DIN 376

Hole type
2.5×D





Material groups **VG** | HSS-E | DIN 371/376 | 6H | 60° | C | R40 | Vap | p.B159

Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1	P	Vap	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M2	× 0.4	**TB312136**	8	45	13	2.8	2.1	5	3	1.6
M2.5	× 0.45	**TB312176**	9	50	15	2.8	2.1	5	3	2.05
M3	× 0.5	**TB312206**	6	56	18	3.5	2.7	6	3	2.5
M3.5	× 0.6	**TB312226**	7	56	20	4	3	6	3	2.9
M4	× 0.7	**TB312246**	7	63	21	4.5	3.4	6	3	3.3
M5	× 0.8	**TB312286**	8	70	25	6	4.9	8	3	4.2
M6	× 1.0	**TB312316**	10	80	30	6	4.9	8	3	5
M7	× 1.0	**TB312346**	10	80	30	7	5.5	8	3	6
M8	× 1.25	**TB312366**	13	90	35	8	6.2	9	3	6.8
M9	× 1.25	**TB312396**	13	90	35	9	7	10	3	7.8
M10	× 1.5	**TB312426**	15	100	39	10	8	11	3	8.5
M12	× 1.75	**TB312506**	18	110	44	9	7	10	3	10.2
M14	× 2.0	**TB312546**	20	110	44	11	9	12	3	12
M16	× 2.0	**TB312606**	20	110	44	12	9	12	3	14
M18	× 2.5	**TB312656**	25	125	50	14	11	14	4	15.5
M20	× 2.5	**TB312706**	25	140	54	16	12	15	4	17.5
M22	× 2.5	**TB312746**	25	140	54	18	14.5	17	4	19.5
M24	× 3.0	**TB312786**	30	160	60	18	14.5	17	4	21
M30	× 3.5	**TB312946**	35	180	70	22	18	21	4	26.5

▶ DIN 371(M2~M10) and DIN 376(M11~M30)
▶ * DIN profile not ISO

◎ : 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											○					○					

YG TAP STEEL

TY312 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

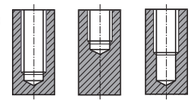
▶ Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

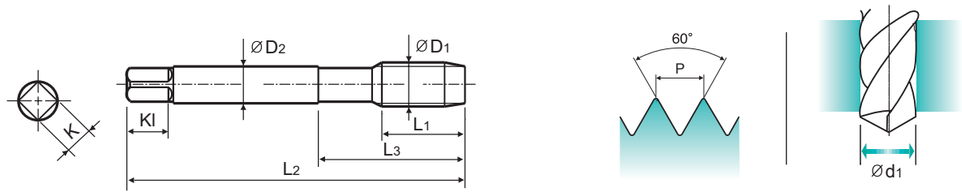
▶ Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

DIN 371

DIN 376

Hole type
2.5×D





Material groups **VG** | HSS-E | DIN 371/376 | 6H | 60° | C | R40 | TiAlN | p.B159

Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1	P	TiAlN	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M2	× 0.4	**TY312136**	8	45	13	2.8	2.1	5	3	1.6
*M2.3	× 0.4	**TY312196**	8	45	13	2.8	2.1	5	3	1.9
M2.5	× 0.45	**TY312176**	9	50	15	2.8	2.1	5	3	2.05
M3	× 0.5	**TY312206**	6	56	18	3.5	2.7	6	3	2.5
M3.5	× 0.6	**TY312226**	7	56	20	4	3	6	3	2.9
M4	× 0.7	**TY312246**	7	63	21	4.5	3.4	6	3	3.3
M5	× 0.8	**TY312286**	8	70	25	6	4.9	8	3	4.2
M6	× 1.0	**TY312316**	10	80	30	6	4.9	8	3	5
M7	× 1.0	**TY312346**	10	80	30	7	5.5	8	3	6
M8	× 1.25	**TY312366**	13	90	35	8	6.2	9	3	6.8
M9	× 1.25	**TY312396**	13	90	35	9	7	10	3	7.8
M10	× 1.5	**TY312426**	15	100	39	10	8	11	3	8.5
M11	× 1.5	**TY312466**	17	100	40	8	6.2	9	3	9.5
M12	× 1.75	**TY312506**	18	110	44	9	7	10	3	10.2
M14	× 2.0	**TY312546**	20	110	44	11	9	12	3	12
M16	× 2.0	**TY312606**	20	110	44	12	9	12	3	14
M20	× 2.5	**TY312706**	25	140	54	16	12	15	4	17.5
M22	× 2.5	**TY312746**	25	140	54	18	14.5	17	4	19.5
M24	× 3.0	**TY312786**	30	160	60	18	14.5	17	4	21
M27	× 3.0	**TY312866**	30	160	60	20	16	19	4	24
M30	× 3.5	**TY312946**	35	180	70	22	18	21	4	26.5

▶ DIN 371(M2~M10) and DIN 376(M11~M30)
▶ * DIN profile not ISO

◎ : 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											○					○					

YG TAP STEEL

TC413 SERIES

MF ISO metric fine threads DIN 13

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

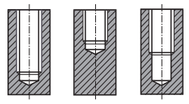
Machine taps
Maschinengewindebohrer

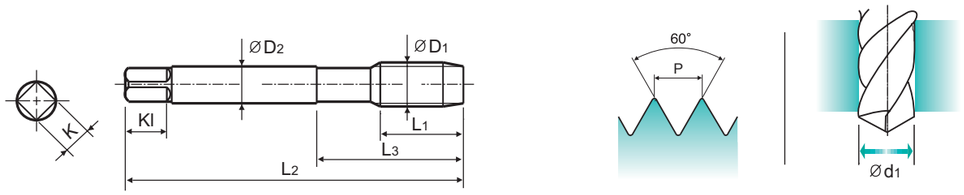
▶ Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

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

DIN 374

Hole type
2.5×D





Material groups **VG** | HSS-E | DIN 374 | 6H | 60° | C | R40 | Bright | p.B159

Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1	P	Bright	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M4	× 0.5	**TC413256**	5	63	21	2.8	2.1	5	3	3.5
M5	× 0.5	**TC413296**	5	70	25	3.5	2.7	6	3	4.5
M6	× 0.75	**TC413326**	8	80	30	4.5	3.4	6	3	5.2
M6	× 0.5	**TC413336**	5	80	30	4.5	3.4	6	3	5.5
M8	× 1.0	**TC413376**	10	90	36	6	4.9	8	3	7
M8	× 0.75	**TC413386**	8	80	30	6	4.9	8	3	7.2
M10	× 1.25	**TC413436**	16	100	40	7	5.5	8	3	8.8
M10	× 1.0	**TC413446**	10	90	36	7	5.5	8	3	9
M10	× 0.75	**TC413456**	10	90	36	7	5.5	8	3	9.2
M12	× 1.5	**TC413516**	15	100	40	9	7	10	3	10.5
M12	× 1.25	**TC413526**	15	100	40	9	7	10	3	10.8
M12	× 1.0	**TC413536**	11	100	40	9	7	10	3	11
M14	× 1.5	**TC413556**	15	100	40	11	9	12	3	12.5
M14	× 1.25	**TC413566**	15	100	40	11	9	12	3	12.8
M16	× 1.5	**TC413616**	15	100	40	12	9	12	3	14.5
M18	× 1.5	**TC413676**	17	110	44	14	11	14	4	16.5
M20	× 1.5	**TC413726**	17	125	50	16	12	15	4	18.5
M22	× 1.5	**TC413766**	17	125	50	18	14.5	17	4	20.5

◎ : 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											○					○					

YG TAP STEEL

TD413 SERIES

MF ISO metric fine threads DIN 13

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

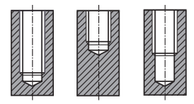
Machine taps
Maschinengewindebohrer

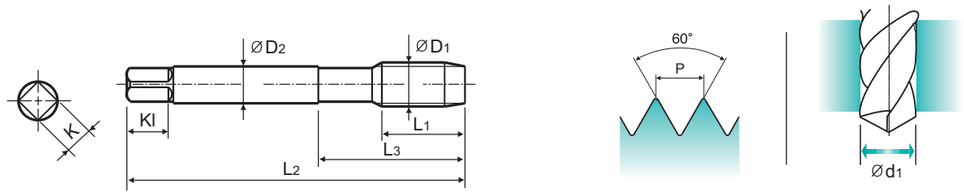
▶ Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

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

DIN 374

Hole type
2.5×D





Material groups **VG** | HSS-E | DIN 374 | 6H | 60° | C | R40 | TiN | p.B159

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	Kl	Z	Ød1
M5	× 0.5	**TD413296**	5	70	25	3.5	2.7	6	3	4.5
M6	× 0.75	**TD413326**	8	80	30	4.5	3.4	6	3	5.2
M6	× 0.5	**TD413336**	5	80	30	4.5	3.4	6	3	5.5
M7	× 0.75	**TD413356**	10	80	30	5.5	4.3	7	3	6.2
M8	× 1.0	**TD413376**	10	90	36	6	4.9	8	3	7
M8	× 0.75	**TD413386**	8	80	30	6	4.9	8	3	7.2
M10	× 1.25	**TD413436**	16	100	40	7	5.5	8	3	8.8
M10	× 1.0	**TD413446**	10	90	36	7	5.5	8	3	9
M10	× 0.75	**TD413456**	10	90	36	7	5.5	8	3	9.2
M12	× 1.5	**TD413516**	15	100	40	9	7	10	3	10.5
M12	× 1.25	**TD413526**	15	100	40	9	7	10	3	10.8
M12	× 1.0	**TD413536**	11	100	40	9	7	10	3	11
M14	× 1.5	**TD413556**	15	100	40	11	9	12	3	12.5
M16	× 1.5	**TD413616**	15	100	40	12	9	12	3	14.5
M18	× 1.5	**TD413676**	17	110	44	14	11	14	4	16.5
M24	× 1.5	**TD413806**	20	140	54	18	14.5	17	4	22.5

◎ : 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

YG TAP STEEL

TC174 SERIES

UNC Unified coarse threads

Unified Grobgewinde
UNC
Unificato passo grosso

Machine taps
Maschinengewindebohrer

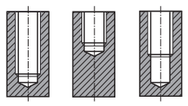
▶ Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

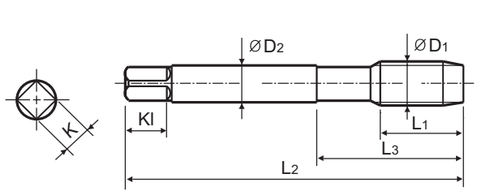
▶ Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

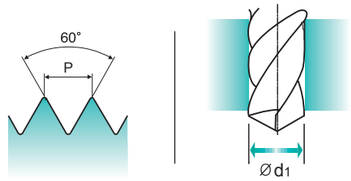
DIN 371

DIN 376

Hole type
2.5×D







Material groups VG | HSS-E | DIN 371/376 | 2B | 60° | C | R40 | Bright | p.B159

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	Kl	Z	Ød1
#4 -	40UNC	TC174162	6	56	18	3.5	2.7	6	3	2.3
#6 -	32UNC	TC174242	7	56	20	4	3	6	3	2.85
#8 -	32UNC	TC174282	8	63	21	4.5	3.4	6	3	3.5
#10 -	24UNC	TC174322	10	70	25	6	4.9	8	3	3.9
#12 -	24UNC	TC174362	10	80	30	6	4.9	8	3	4.5
1/4 -	20UNC	TC174402	13	80	30	7	5.5	8	3	5.2
5/16 -	18UNC	TC174442	14	90	35	8	6.2	9	3	6.6
3/8 -	16UNC	TC174482	16	100	39	9	7	10	3	8
1/2 -	13UNC	TC174562	20	110	44	9	7	10	3	10.75
9/16 -	12UNC	TC174602	20	110	44	11	9	12	3	12.25
5/8 -	11UNC	TC174642	22	110	44	12	9	12	3	13.5
3/4 -	10UNC	TC174702	25	125	50	14	11	14	4	16.5

▶ 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			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											○					○					

YG TAP STEEL

TD174 SERIES

UNC Unified coarse threads

Unified Grobgewinde
UNC
Unificato passo grosso

Machine taps
Maschinengewindebohrer

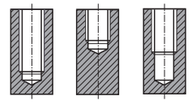
▶ Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

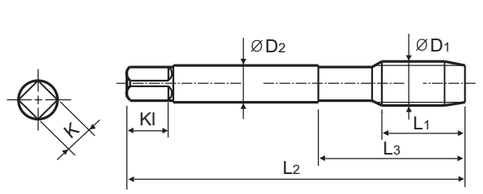
▶ Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

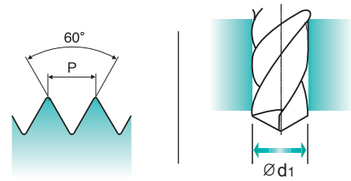
DIN 371

DIN 376

Hole type
2.5×D







Material groups VG | HSS-E | DIN 371/376 | 2B | 60° | C | R40 | TiN | p.B159

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		TiN	L1	L2	L3	ØD2	K	Kl	Z	Ød1
#4 -	40UNC	TD174162	6	56	18	3.5	2.7	6	3	2.3
#8 -	32UNC	TD174282	8	63	21	4.5	3.4	6	3	3.5
#10 -	24UNC	TD174322	10	70	25	6	4.9	8	3	3.9
#12 -	24UNC	TD174362	10	80	30	6	4.9	8	3	4.5
1/4 -	20UNC	TD174402	13	80	30	7	5.5	8	3	5.2
3/8 -	16UNC	TD174482	16	100	39	9	7	10	3	8
1/2 -	13UNC	TD174562	20	110	44	9	7	10	3	10.75
5/8 -	11UNC	TD174642	22	110	44	12	9	12	3	13.5
3/4 -	10UNC	TD174702	25	125	50	14	11	14	4	16.5

▶ 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			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

YG TAP STEEL

TC184 SERIES

UNF

Unified fine threads

Unified Feingewinde
UNF
Unificato passo fine

Machine taps
Maschinengewindebohrer

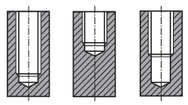
▶ Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

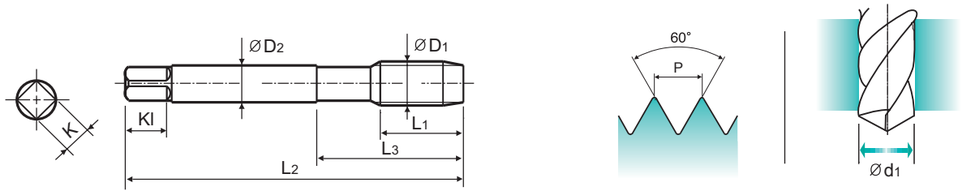
▶ Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

DIN 371

DIN 374

Hole type
2.5×D





Material groups **VG** | HSS-E | DIN 371/374 | 2B | 60° | C | R40 | Bright p.B159

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	Kl	Z	Ød1
#4	- 48UNF	**TC184182**	6	56	18	3.5	2.7	6	3	2.4
#5	- 44UNF	**TC184222**	7	56	18	3.5	2.7	6	3	2.7
#6	- 40UNF	**TC184262**	7	56	20	4	3	6	3	3
#10	- 32UNF	**TC184342**	10	70	25	6	4.9	8	3	4.1
#12	- 28UNF	**TC184382**	10	80	30	6	4.9	8	3	4.7
1/4	- 28UNF	**TC184422**	10	80	30	7	5.5	8	3	5.5
5/16	- 24UNF	**TC184462**	10	90	35	8	6.2	9	3	6.9
3/8	- 24UNF	**TC184502**	10	100	39	9	7	10	3	8.5
1/2	- 20UNF	**TC184582**	13	100	40	9	7	10	3	11.5
5/8	- 18UNF	**TC184662**	15	100	40	12	9	12	3	14.5
3/4	- 16UNF	**TC184722**	17	110	44	14	11	14	4	17.5
7/8	- 14UNF	**TC184762**	17	125	50	18	14.5	17	4	20.5
1	- 12UNF	**TC184802**	20	140	54	18	14.5	17	4	23.25

▶ DIN 371(#4~3/8) and DIN 374(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			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											○					○					

YG TAP STEEL

TB913 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

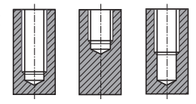
▶ With recessed threads for machine tapping of deep blind holes.
▶ Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

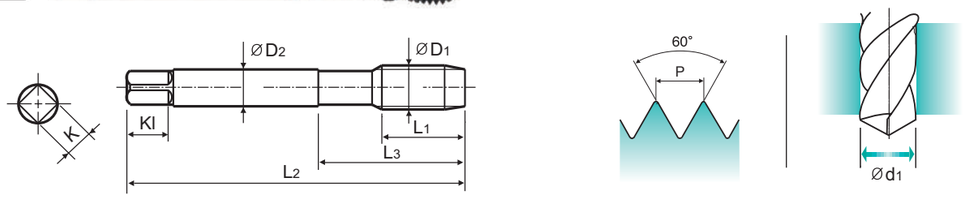
▶ Mit abgesetztem Gewinde zum Schneiden von tiefen Sacklochgewinden.
▶ Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

DIN 371

DIN 376

Hole type
2.5×D





Material groups **VG** | HSS-E | DIN 371/376 | 6H | 60° | C | R40 | Vap p.B159

Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1	P	Vap	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M2	× 0.4	**TB913136**	8	45	13	2.8	2.1	5	3	1.6
M2.5	× 0.45	**TB913176**	9	50	15	2.8	2.1	5	3	2.05
M3	× 0.5	**TB913206**	6	56	18	3.5	2.7	6	3	2.5
M4	× 0.7	**TB913246**	7	63	21	4.5	3.4	6	3	3.3
M5	× 0.8	**TB913286**	8	70	25	6	4.9	8	3	4.2
M6	× 1.0	**TB913316**	10	80	30	6	4.9	8	3	5
M8	× 1.25	**TB913366**	13	90	35	8	6.2	9	3	6.8
M9	× 1.25	**TB913396**	13	90	35	9	7	10	3	7.8
M10	× 1.5	**TB913426**	15	100	39	10	8	11	3	8.5
M11	× 1.5	**TB913466**	17	100	40	8	6.2	9	3	9.5
M12	× 1.75	**TB913506**	18	110	44	9	7	10	3	10.2
M14	× 2.0	**TB913546**	20	110	44	11	9	12	3	12
M20	× 2.5	**TB913706**	25	140	54	16	12	15	4	17.5
M22	× 2.5	**TB913746**	25	140	54	18	14.5	17	4	19.5
M24	× 3.0	**TB913786**	30	160	60	18	14.5	17	4	21
M27	× 3.0	**TB913866**	30	160	60	20	16	19	4	24
M30	× 3.5	**TB913946**	35	180	70	22	18	21	4	26.5

▶ DIN 371(M2~M10) and DIN 376(M11~M30)
▶ * DIN profile not ISO

◎ : 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											○					○					

YG TAP STEEL

TQ863 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

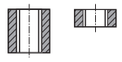
▶ Suitable for through hole in more cutting speed than other taps due to thick web and the best substrate.

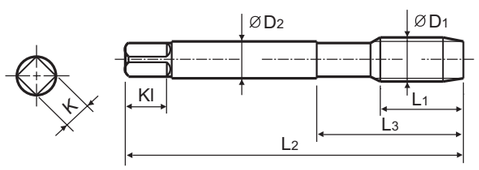
▶ Geeignet für Durchgangslöcher in höherer Schnittgeschwindigkeit als bei anderen Gewindebohrern dank größerer Kerndicke und bestem Werkstoff.

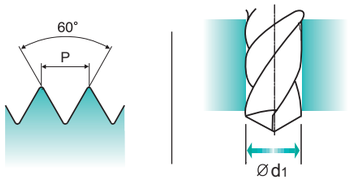
DIN 371

DIN 376

Hole type
3.0×D







Material groups VG | HSS PM | DIN 371/376 | 6H | 60° | B | Vap | p.B159

Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1	P	Vap	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M2	× 0.4	**TQ863136**	8	45	13	2.8	2.1	5	3	1.6
M3	× 0.5	**TQ863206**	11	56	18	3.5	2.7	6	3	2.5
M4	× 0.7	**TQ863246**	13	63	21	4.5	3.4	6	3	3.3
M4.5	× 0.75	**TQ863266**	14	70	25	6	4.9	8	3	3.7
M5	× 0.8	**TQ863286**	15	70	25	6	4.9	8	3	4.2
M6	× 1.0	**TQ863316**	17	80	30	6	4.9	8	3	5
M8	× 1.25	**TQ863366**	20	90	35	8	6.2	9	3	6.8
M10	× 1.5	**TQ863426**	22	100	39	10	8	11	3	8.5
M12	× 1.75	**TQ863506**	24	110	44	9	7	10	3	10.2

▶ DIN 371(M2~M10) and DIN 376(M12)

◎ : 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											○					○					

YG TAP STEEL

TR863 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

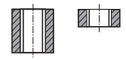
▶ Suitable for through hole in more cutting speed than other taps due to thick web and the best substrate.

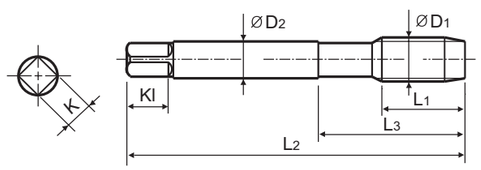
▶ Geeignet für Durchgangslöcher in höherer Schnittgeschwindigkeit als bei anderen Gewindebohrern dank größerer Kerndicke und bestem Werkstoff.

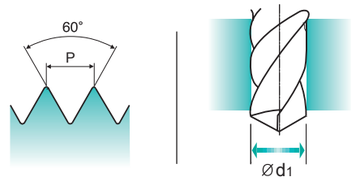
DIN 371

DIN 376

Hole type
3.0×D







Material groups VG | HSS PM | DIN 371/376 | 6H | 60° | B | Bright | p.B159

Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1	P	Bright	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M2.5	× 0.45	**TR863176**	9	50	15	2.8	2.1	5	3	2.05
M5	× 0.8	**TR863286**	15	70	25	6	4.9	8	3	4.2
M7	× 1.0	**TR863346**	17	80	30	7	5.5	8	3	6
M8	× 1.25	**TR863366**	20	90	35	8	6.2	9	3	6.8
M10	× 1.5	**TR863426**	22	100	39	10	8	11	3	8.5
M12	× 1.75	**TR863506**	24	110	44	9	7	10	3	10.2

▶ DIN 371(M2~M10) and DIN 376(M12)

◎ : 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											○					○					

YG TAP STEEL

TC422 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

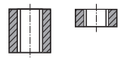
▶ Suitable for through hole in more cutting speed than other taps due to thick web.

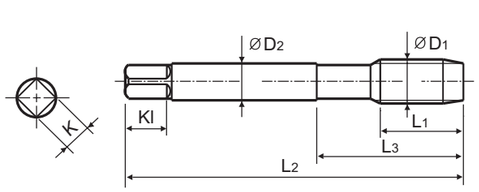
▶ Geeignet für Durchgangslöcher in höherer Schnittgeschwindigkeit als bei anderen Gewindebohrern dank größerer Kerndicke.

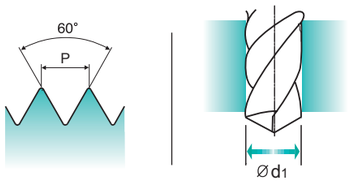
DIN 371

DIN 376

Hole type
3.0×D







Material groups **VG** | HSS-E | DIN 371/376 | 6H | 60° | B | Bright | p.B159

Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1	P	Bright	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M2	× 0.4	**TC422136**	8	45	13	2.8	2.1	5	3	1.6
M2.2	× 0.45	**TC422156**	8	45	13	2.8	2.1	5	3	1.75
*M2.3	× 0.4	**TC422196**	8	45	13	2.8	2.1	5	3	1.9
M2.5	× 0.45	**TC422176**	9	50	15	2.8	2.1	5	3	2.05
*M2.6	× 0.45	**TC422496**	9	50	15	2.8	2.1	5	3	2.1
M3	× 0.5	**TC422206**	11	56	18	3.5	2.7	6	3	2.5
M4	× 0.7	**TC422246**	13	63	21	4.5	3.4	6	3	3.3
M4.5	× 0.75	**TC422266**	14	70	25	6	4.9	8	3	3.7
M5	× 0.8	**TC422286**	15	70	25	6	4.9	8	3	4.2
M6	× 1.0	**TC422316**	17	80	30	6	4.9	8	3	5
M7	× 1.0	**TC422346**	17	80	30	7	5.5	8	3	6
M8	× 1.25	**TC422366**	20	90	35	8	6.2	9	3	6.8
M10	× 1.5	**TC422426**	22	100	39	10	8	11	3	8.5
M11	× 1.5	**TC422466**	22	100	40	8	6.2	9	3	9.5
M12	× 1.75	**TC422506**	24	110	44	9	7	10	3	10.2
M14	× 2.0	**TC422546**	26	110	44	11	9	12	3	12
M16	× 2.0	**TC422606**	27	110	44	12	9	12	3	14
M18	× 2.5	**TC422656**	30	125	50	14	11	14	4	15.5
M20	× 2.5	**TC422706**	32	140	54	16	12	15	4	17.5
M22	× 2.5	**TC422746**	32	140	54	18	14.5	17	4	19.5
M24	× 3.0	**TC422786**	34	160	60	18	14.5	17	4	21
M27	× 3.0	**TC422866**	36	160	60	20	16	19	4	24
M30	× 3.5	**TC422946**	40	180	70	22	18	21	4	26.5

▶ DIN 371(M2~M10) and DIN 376(M11~M30)
▶ * DIN profile not ISO

◎ : Excellent ○ : Good

ISO	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											○					○					

YG TAP STEEL

TD422 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

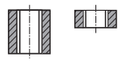
▶ Suitable for through hole in more cutting speed than other taps due to thick web.

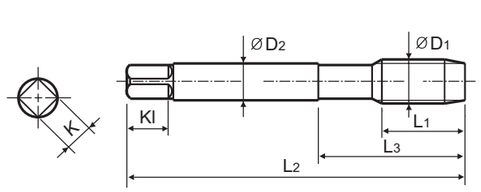
▶ Geeignet für Durchgangslöcher in höherer Schnittgeschwindigkeit als bei anderen Gewindebohrern dank größerer Kerndicke.

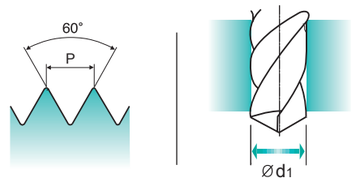
DIN 371

DIN 376

Hole type
3.0×D







Material groups **VG** | HSS-E | DIN 371/376 | 6H | 60° | B | TiN | p.B159

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	Kl	Z	Ød1
M2	× 0.4	**TD422136**	8	45	13	2.8	2.1	5	3	1.6
M2.5	× 0.45	**TD422176**	9	50	15	2.8	2.1	5	3	2.05
M3	× 0.5	**TD422206**	11	56	18	3.5	2.7	6	3	2.5
M3.5	× 0.6	**TD422226**	12	56	20	4	3	6	3	2.9
M4	× 0.7	**TD422246**	13	63	21	4.5	3.4	6	3	3.3
M4.5	× 0.75	**TD422266**	14	70	25	6	4.9	8	3	3.7
M5	× 0.8	**TD422286**	15	70	25	6	4.9	8	3	4.2
M6	× 1.0	**TD422316**	17	80	30	6	4.9	8	3	5
M8	× 1.25	**TD422366**	20	90	35	8	6.2	9	3	6.8
M10	× 1.5	**TD422426**	22	100	39	10	8	11	3	8.5
M11	× 1.5	**TD422466**	22	100	40	8	6.2	9	3	9.5
M12	× 1.75	**TD422506**	24	110	44	9	7	10	3	10.2
M14	× 2.0	**TD422546**	26	110	44	11	9	12	3	12
M16	× 2.0	**TD422606**	27	110	44	12	9	12	3	14
M18	× 2.5	**TD422656**	30	125	50	14	11	14	4	15.5
M20	× 2.5	**TD422706**	32	140	54	16	12	15	4	17.5
M22	× 2.5	**TD422746**	32	140	54	18	14.5	17	4	19.5
M27	× 3.0	**TD422866**	36	160	60	20	16	19	4	24
M30	× 3.5	**TD422946**	40	180	70	22	18	21	4	26.5

▶ DIN 371(M2~M10) and DIN 376(M11~M30)
▶ * DIN profile not ISO

◎ : Excellent ○ : Good

ISO	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

YG TAP STEEL

TE422 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

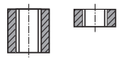
▶ Recommended for tapping abrasive materials due to nitriding, not suitable for tapping tough or high strength materials.

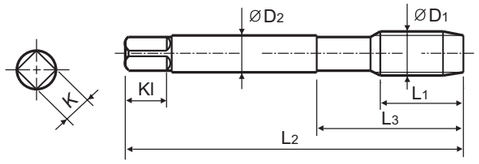
▶ Empfohlen für das Gewindeschneiden verschleißfordernder Werkstoffe wegen der Nitrierung; nicht geeignet für das Gewinden zaher oder hochfester Werkstoffe.

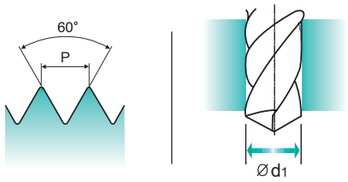
DIN 371

DIN 376

Hole type
3.0×D







Material groups **VG** | HSS-E | DIN 371/376 | 6H | 60° | B | Nitride

p.B159

Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1	P	Ni	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M2	× 0.4	**TE422136**	8	45	13	2.8	2.1	5	3	1.6
M3	× 0.5	**TE422206**	11	56	18	3.5	2.7	6	3	2.5
M4	× 0.7	**TE422246**	13	63	21	4.5	3.4	6	3	3.3
M5	× 0.8	**TE422286**	15	70	25	6	4.9	8	3	4.2
M6	× 1.0	**TE422316**	17	80	30	6	4.9	8	3	5
M7	× 1.0	**TE422346**	17	80	30	7	5.5	8	3	6
M8	× 1.25	**TE422366**	20	90	35	8	6.2	9	3	6.8
M9	× 1.25	**TE422396**	20	90	35	9	7	10	3	7.8
M10	× 1.5	**TE422426**	22	100	39	10	8	11	3	8.5
M12	× 1.75	**TE422506**	24	110	44	9	7	10	3	10.2
M14	× 2.0	**TE422546**	26	110	44	11	9	12	3	12
M16	× 2.0	**TE422606**	27	110	44	12	9	12	3	14
M20	× 2.5	**TE422706**	32	140	54	16	12	15	4	17.5
M22	× 2.5	**TE422746**	32	140	54	18	14.5	17	4	19.5
M27	× 3.0	**TE422866**	36	160	60	20	16	19	4	24
M30	× 3.5	**TE422946**	40	180	70	22	18	21	4	26.5

▶ DIN 371(M2~M10) and DIN 376(M11~M30)
▶ * DIN profile not ISO

◎ : Excellent ○ : Good

ISO	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											○					○					

YG TAP STEEL

TY422 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

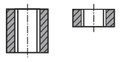
▶ Suitable for through hole in more cutting speed than other taps due to thick web.

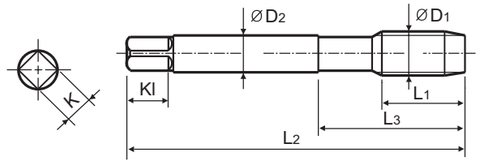
▶ Geeignet für Durchgangslöcher in höherer Schnittgeschwindigkeit als bei anderen Gewindebohrern dank größerer Kerndicke.

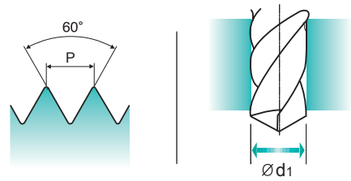
DIN 371

DIN 376

Hole type
3.0×D







Material groups **VG** | HSS-E | DIN 371/376 | 6H | 60° | B | TiAlN

p.B159

Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1	P	TiAlN	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M2	× 0.4	**TY422136**	8	45	13	2.8	2.1	5	3	1.6
M2.2	× 0.45	**TY422156**	8	45	13	2.8	2.1	5	3	1.75
*M2.3	× 0.4	**TY422196**	8	45	13	2.8	2.1	5	3	1.9
*M2.6	× 0.45	**TY422496**	9	50	15	2.8	2.1	5	3	2.1
M3	× 0.5	**TY422206**	11	56	18	3.5	2.7	6	3	2.5
M3.5	× 0.6	**TY422226**	12	56	20	4	3	6	3	2.9
M4	× 0.7	**TY422246**	13	63	21	4.5	3.4	6	3	3.3
M4.5	× 0.75	**TY422266**	14	70	25	6	4.9	8	3	3.7
M5	× 0.8	**TY422286**	15	70	25	6	4.9	8	3	4.2
M6	× 1.0	**TY422316**	17	80	30	6	4.9	8	3	5
M7	× 1.0	**TY422346**	17	80	30	7	5.5	8	3	6
M8	× 1.25	**TY422366**	20	90	35	8	6.2	9	3	6.8
M9	× 1.25	**TY422396**	20	90	35	9	7	10	3	7.8
M10	× 1.5	**TY422426**	22	100	39	10	8	11	3	8.5
M11	× 1.5	**TY422466**	22	100	40	8	6.2	9	3	9.5
M12	× 1.75	**TY422506**	24	110	44	9	7	10	3	10.2
M14	× 2.0	**TY422546**	26	110	44	11	9	12	3	12
M16	× 2.0	**TY422606**	27	110	44	12	9	12	3	14
M18	× 2.5	**TY422656**	30	125	50	14	11	14	4	15.5
M20	× 2.5	**TY422706**	32	140	54	16	12	15	4	17.5
M22	× 2.5	**TY422746**	32	140	54	18	14.5	17	4	19.5
M24	× 3.0	**TY422786**	34	160	60	18	14.5	17	4	21
M27	× 3.0	**TY422866**	36	160	60	20	16	19	4	24
M30	× 3.5	**TY422946**	40	180	70	22	18	21	4	26.5

▶ DIN 371(M2~M10) and DIN 376(M11~M30)
▶ * DIN profile not ISO

◎ : Excellent ○ : Good

ISO	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											○					○					

YG TAP STEEL

TC263 SERIES

MF

ISO metric fine threads DIN 13

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

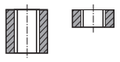
Machine taps
Maschinengewindebohrer

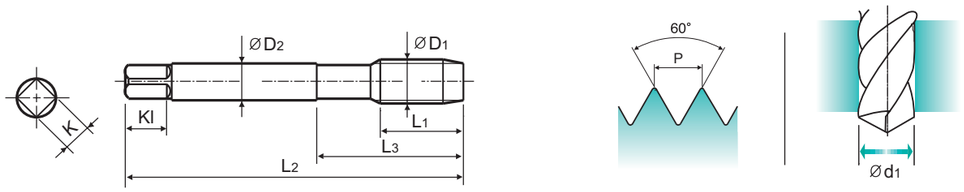
▶ Suitable for through hole in more cutting speed than other taps due to thick web.

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

DIN 374

Hole type
3.0×D





Material groups VG | HSS-E | DIN 374 | 6H | 60° | B | Bright

p.B159

Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1	P	Bright	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M5	× 0.5	**TC263296**	11	70	25	3.5	2.7	6	3	4.5
M7	× 0.75	**TC263356**	14	80	30	5.5	4.3	7	3	6.2
M8	× 1.0	**TC263376**	17	90	36	6	4.9	8	3	7
M8	× 0.75	**TC263386**	14	80	30	6	4.9	8	3	7.2
M10	× 1.25	**TC263436**	22	100	40	7	5.5	8	3	8.8
M10	× 1.0	**TC263446**	18	90	36	7	5.5	8	3	9
M10	× 0.75	**TC263456**	18	90	36	7	5.5	8	3	9.2
M12	× 1.5	**TC263516**	22	100	40	9	7	10	3	10.5
M12	× 1.25	**TC263526**	22	100	40	9	7	10	3	10.8
M12	× 1.0	**TC263536**	18	100	40	9	7	10	3	11
M14	× 1.5	**TC263556**	22	100	40	11	9	12	3	12.5
M24	× 1.5	**TC263806**	27	140	54	18	14.5	17	4	22.5

◎ : 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											○					○					

YG TAP STEEL

TD263 SERIES

MF

ISO metric fine threads DIN 13

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

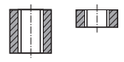
Machine taps
Maschinengewindebohrer

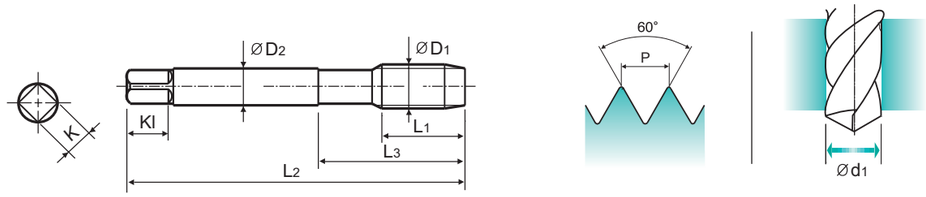
▶ Suitable for through hole in more cutting speed than other taps due to thick web.

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

DIN 374

Hole type
3.0×D





Material groups VG | HSS-E | DIN 374 | 6H | 60° | B | TiN

p.B159

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	Kl	Z	Ød1
M5	× 0.5	**TD263296**	11	70	25	3.5	2.7	6	3	4.5
M6	× 0.75	**TD263326**	13	80	30	4.5	3.4	6	3	5.2
M7	× 0.75	**TD263356**	14	80	30	5.5	4.3	7	3	6.2
M8	× 1.0	**TD263376**	17	90	36	6	4.9	8	3	7
M8	× 0.75	**TD263386**	14	80	30	6	4.9	8	3	7.2
M10	× 1.25	**TD263436**	22	100	40	7	5.5	8	3	8.8
M10	× 1.0	**TD263446**	18	90	36	7	5.5	8	3	9
M10	× 0.75	**TD263456**	18	90	36	7	5.5	8	3	9.2
M12	× 1.5	**TD263516**	22	100	40	9	7	10	3	10.5
M12	× 1.25	**TD263526**	22	100	40	9	7	10	3	10.8
M12	× 1.0	**TD263536**	18	100	40	9	7	10	3	11
M14	× 1.5	**TD263556**	22	100	40	11	9	12	3	12.5
M16	× 1.5	**TD263616**	22	100	40	12	9	12	3	14.5
M18	× 1.5	**TD263676**	25	110	44	14	11	14	4	16.5
M20	× 1.5	**TD263726**	25	125	50	16	12	15	4	18.5
M22	× 1.5	**TD263766**	25	125	50	18	14.5	17	4	20.5

◎ : 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

YG TAP STEEL

TC244 SERIES

UNC Unified coarse threads

Unified Grobgewinde
UNC
Unificato passo grosso

Machine taps
Maschinengewindebohrer

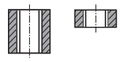
▶ Suitable for through hole in more cutting speed than other taps due to thick web.

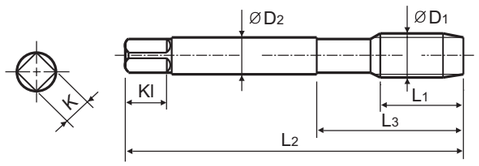
▶ Geeignet für Durchgangslöcher in höherer Schnittgeschwindigkeit als bei anderen Gewindebohrern dank größerer Kerndicke.

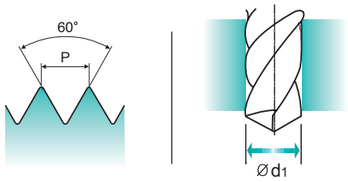
DIN 371

DIN 376

Hole type
3.0×D







Material groups VG | HSS-E | DIN 371/376 | 2B | 60° | B | Bright p.B159

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	Kl	Z	Ød1
#5	- 40UNC	**TC244202**	11	56	18	3.5	2.7	6	3	2.6
#6	- 32UNC	**TC244242**	12	56	20	4	3	6	3	2.85
#10	- 24UNC	**TC244322**	15	70	25	6	4.9	8	3	3.9
#12	- 24UNC	**TC244362**	16	80	30	6	4.9	8	3	4.5
1/4	- 20UNC	**TC244402**	17	80	30	7	5.5	8	3	5.2
5/16	- 18UNC	**TC244442**	20	90	35	8	6.2	9	3	6.6
3/8	- 16UNC	**TC244482**	22	100	39	9	7	10	3	8
1/2	- 13UNC	**TC244562**	25	110	44	9	7	10	3	10.75
5/8	- 11UNC	**TC244642**	27	110	44	12	9	12	3	13.5
7/8	- 9UNC	**TC244742**	32	140	54	18	14.5	17	4	19.5
1	- 8UNC	**TC244782**	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											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											○					○					

YG TAP STEEL

TD244 SERIES

UNC Unified coarse threads

Unified Grobgewinde
UNC
Unificato passo grosso

Machine taps
Maschinengewindebohrer

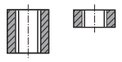
▶ Suitable for through hole in more cutting speed than other taps due to thick web.

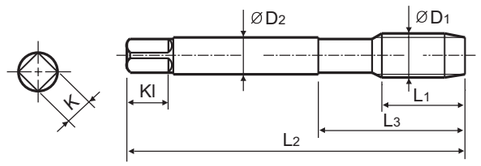
▶ Geeignet für Durchgangslöcher in höherer Schnittgeschwindigkeit als bei anderen Gewindebohrern dank größerer Kerndicke.

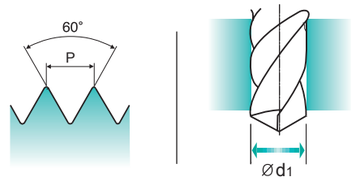
DIN 371

DIN 376

Hole type
3.0×D







Material groups VG | HSS-E | DIN 371/376 | 2B | 60° | B | TiN p.B159

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		TiN	L1	L2	L3	ØD2	K	Kl	Z	Ød1
#4	- 40UNC	**TD244162**	11	56	18	3.5	2.7	6	3	2.3
#5	- 40UNC	**TD244202**	11	56	18	3.5	2.7	6	3	2.6
#6	- 32UNC	**TD244242**	12	56	20	4	3	6	3	2.85
#8	- 32UNC	**TD244282**	13	63	21	4.5	3.4	6	3	3.5
#10	- 24UNC	**TD244322**	15	70	25	6	4.9	8	3	3.9
#12	- 24UNC	**TD244362**	16	80	30	6	4.9	8	3	4.5
1/4	- 20UNC	**TD244402**	17	80	30	7	5.5	8	3	5.2
5/16	- 18UNC	**TD244442**	20	90	35	8	6.2	9	3	6.6
7/16	- 14UNC	**TD244522**	22	100	40	8	6.2	9	3	9.4
7/8	- 9UNC	**TD244742**	32	140	54	18	14.5	17	4	19.5

▶ 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			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

YG TAP STEEL

TC254 SERIES

UNF Unified fine threads

- Unified Feingewinde
- UNF
- Unificato passo fine

Machine taps
Maschinengewindebohrer

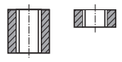
▶ Suitable for through hole in more cutting speed than other taps due to thick web.

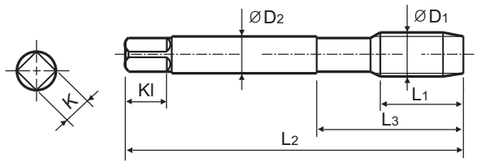
▶ Geeignet für Durchgangslöcher in höherer Schnittgeschwindigkeit als bei anderen Gewindebohrern dank größerer Kerndicke.

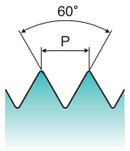
DIN 371

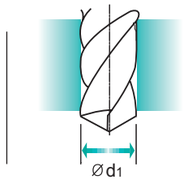
DIN 374

Hole type
3.0×D









Material groups **VG** | HSS-E | DIN 371/374 | 2B | 60° | B | Bright

p.B159

Unit : mm

SIZE ØD1	TPI	EDP No. Bright	Thread Length L1	Overall Length L2	Neck Length L3	Shank Diameter ØD2	Square Size K	Square Length Kl	No. of Flute Z	Tapping Drill Diameter Ød1
#5	44UNF	**TC254222**	11	56	18	3.5	2.7	6	3	2.7
#10	32UNF	**TC254342**	15	70	25	6	4.9	8	3	4.1
1/4	28UNF	**TC254422**	17	80	30	7	5.5	8	3	5.5
3/8	24UNF	**TC254502**	18	100	39	9	7	10	3	8.5
9/16	18UNF	**TC254622**	22	100	40	11	9	12	3	12.9
3/4	16UNF	**TC254722**	25	110	44	14	11	14	4	17.5
1	12UNF	**TC254802**	28	140	54	18	14.5	17	4	23.25

▶ DIN 371(#4~3/8) and DIN 374(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			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											○					○					

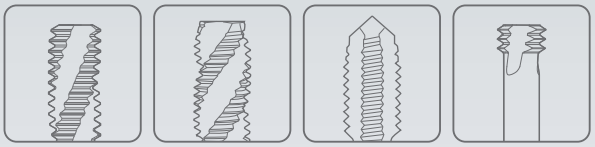
YG TAP STEEL

RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDKONDITIONEN

ISO	VDI 3323	Material Description	HB	HRc	TQ823	TR823	TC312 TC413 TC174 TC184	TD312 TD413 TD174	TB312	TY312	TB913	TQ863	TR863	TC422 TC263 TC244 TC254	TD422 TD263 TD244	TE422	TY422
					Vc (m/min.)												
	2	Low alloy steel	190	13	15-20	15-20	15-20	20-25	15-20	20-25	15-20	15-20	15-20	15-20	15-20	20-25	20-25
	3		250	25	12-18	12-18	12-18	18-24	12-18	18-24	12-18	12-18	12-18	12-18	12-18	18-24	18-24
	4		270	28	10-15	10-15	10-15	15-20	10-15	15-20	10-15	10-15	10-15	10-15	10-15	15-20	15-20
	5		300	32	6-10	6-10	6-10	10-14	6-10	10-14	6-10	6-10	6-10	6-10	6-10	10-14	10-14
	6		180	10	10-15	10-15	10-15	15-20	10-15	15-20	10-15	10-15	10-15	10-15	10-15	15-20	15-20
	7		275	29	10-15	10-15	10-15	15-20	10-15	15-20	10-15	10-15	10-15	10-15	10-15	15-20	15-20
	8		300	32	6-10	6-10	6-10	10-14	6-10	10-14	6-10	6-10	6-10	6-10	6-10	10-14	10-14
	9		350	38	3-5	3-5	3-5	5-7	3-5	5-7	3-5	3-5	3-5	3-5	3-5	5-7	5-7
	10	High alloyed steel, and tool steel	200	15	3-5	3-5	3-5	5-7	3-5	5-7	3-5	3-5	3-5	3-5	3-5	5-7	5-7
M	12	Stainless steel	200	15								7-10	7-10	7-10	7-10	10-15	10-15
	13		240	23								5-8	5-8	5-8	5-8	8-11	8-11
	14		180	10	4-6	4-6	4-6	6-8	4-6	6-8	4-6	4-6	4-6	4-6	4-6	6-8	6-8
S	31	Heat Resistant Super Alloys	200	15	10-15	10-15	10-15	15-20	10-15	15-20	10-15	10-15	10-15	10-15	10-15	15-20	15-20
	36	Titanium Alloys	400Rm		10-15	10-15	10-15	15-20	10-15	15-20	10-15	10-15	10-15	10-15	10-15	15-20	15-20

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

Global Cutting Tool Leader **YG-1**



THREADING