



Leading Through Innovation

HSS-E & HSS-PM

YG TAP FORMING

YG INNENGEWINDEFORMER

- Tapping by Forming Soft Materials
- Gewindeherstellung durch Formen von weichen Materialien

Tapping by Forming Soft Materials

[illegible]

CARBIDE

HSS

YG TAP FORMING

TD703 SERIES

M

ISO metric coarse threads DIN 13

Metrisches ISO-Gewinde DIN 13

ISO MÉTRIQUE DIN13

ISO Metrico passo grosso DIN 13

Cold forming taps with oil grooves
Gewindeformer mit Schmiernuten

Suitable for threading soft materials with at least 8-10% elongation.

The pre-drilling holes are bigger than normal sized holes.

Geeignet zum Gewindeformen weicher Werkstoffe mit mindestens 8-10% Dehnung.

Die Kernlochbohrungen sind größer als normale Kernlöcher.

DIN 371

DIN 376

Hole type

3.0×D

60°

P

ØD2

ØD1

KI

L2

L3

L1

Ød1

Material groups

GV

HSS-E

DIN 371/376

6HX

60°

C

TiN

p.B265

Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	Tapping Drill Diameter
ØD1	P	TiN	L1	L2	L3	ØD2	K	KI	Ød1
M2	× 0.4	TD703136	8	45	13	2.8	2.1	5	1.83
M2.2	× 0.45	TD703156	8	45	13	2.8	2.1	5	2
*M2.3	× 0.4	TD703196	8	45	13	2.8	2.1	5	2.1
M2.5	× 0.45	TD703176	9	50	15	2.8	2.1	5	2.3
*M2.6	× 0.45	TD703496	9	50	15	2.8	2.1	5	2.4
M3	× 0.5	TD703206	11	56	18	3.5	2.7	6	2.8
M3.5	× 0.6	TD703226	12	56	20	4	3	6	3.25
M4	× 0.7	TD703246	13	63	21	4.5	3.4	6	3.7
M4.5	× 0.75	TD703266	14	70	25	6	4.9	8	4.15
M5	× 0.8	TD703286	15	70	25	6	4.9	8	4.65
M6	× 1.0	TD703316	17	80	30	6	4.9	8	5.55
M7	× 1.0	TD703346	17	80	30	7	5.5	8	6.55
M8	× 1.25	TD703366	20	90	35	8	6.2	9	7.4
M9	× 1.25	TD703396	20	90	35	9	7	10	8.4
M10	× 1.5	TD703426	22	100	39	10	8	11	9.3
M11	× 1.5	TD703466	22	100	40	8	6.2	9	10.3
M12	× 1.75	TD703506	24	110	44	9	7	10	11.2
M14	× 2.0	TD703546	26	110	44	11	9	12	13
M16	× 2.0	TD703606	27	110	44	12	9	12	15
M20	× 2.5	TD703706	32	140	54	16	12	15	18.8

Suitable for DIN 371(M2~M10) and DIN 376(M11~M20)

* 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					
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	41
HRC																					
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550
Recommended	◎	◎	○	○		○		○													

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YG TAP FORMING

TE703 SERIES

M

ISO metric coarse threads DIN 13

Metrisches ISO-Gewinde DIN 13

ISO MÉTRIQUE DIN13

ISO Metrico passo grosso DIN 13

Cold forming taps with oil grooves
Gewindeformer mit Schmiernuten

Suitable for threading soft materials with at least 8-10% elongation.

The pre-drilling holes are bigger than normal sized holes.

Geeignet zum Gewindeformen weicher Werkstoffe mit mindestens 8-10% Dehnung.

Die Kernlochbohrungen sind größer als normale Kernlöcher.

DIN 371

DIN 376

Hole type

3.0×D

60°

P

ØD2

ØD1

KI

L2

L3

L1

Ød1

Material groups

GV

HSS-E

DIN 371/376

6HX

60°

C

Nitride

p.B265

Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	Tapping Drill Diameter
ØD1	P	Ni	L1	L2	L3	ØD2	K	KI	Ød1
M2	× 0.4	TE703136	8	45	13	2.8	2.1	5	1.83
M2.5	× 0.45	TE703176	9	50	15	2.8	2.1	5	2.3
M3.5	× 0.6	TE703226	12	56	20	4	3	6	3.25
M4	× 0.7	TE703246	13	63	21	4.5	3.4	6	3.7
M5	× 0.8	TE703286	15	70	25	6	4.9	8	4.65
M6	× 1.0	TE703316	17	80	30	6	4.9	8	5.55
M7	× 1.0	TE703346	17	80	30	7	5.5	8	6.55
M8	× 1.25	TE703366	20	90	35	8	6.2	9	7.4
M12	× 1.75	TE703506	24	110	44	9	7	10	11.2
M14	× 2.0	TE703546	26	110	44	11	9	12	13
M16	× 2.0	TE703606	27	110	44	12	9	12	15
M18	× 2.5	TE703656	30	125	50	14	11	14	16.8
M20	× 2.5	TE703706	32	140	54	16	12	15	18.8

Suitable for DIN 371(M2~M10) and DIN 376(M11~M20)

* 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					
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	41
HRC																					
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550
Recommended	◎	◎	○	○		○		○													

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TY703 SERIES

M

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ISO Metrico passo grosso DIN 13

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Gewindeformer mit Schmiernuten

Suitable for threading soft materials with at least 8-10% elongation.

The pre-drilling holes are bigger than normal sized holes.

Geeignet zum Gewindeformen weicher Werkstoffe mit mindestens 8-10% Dehnung.

Die Kernlochbohrungen sind größer als normale Kernlöcher.

DIN 371

DIN 376

Hole type

3.0×D

60°

P

ØD2

ØD1

KI

L2

L3

L1

Ød1

Material groups

GV

HSS-E

DIN 371/376

6HX

60°

C

TiAlN

p.B265

Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	Tapping Drill Diameter
ØD1	P	TiAlN	L1	L2	L3	ØD2	K	KI	Ød1
M2	× 0.4	TY703136	8	45	13	2.8	2.1	5	1.83
M2.2	× 0.45	TY703156	8	45	13	2.8	2.1	5	2
*M2.3	× 0.4	TY703196	8	45	13	2.8	2.1	5	2.1
M2.5	× 0.45	TY703176	9	50	15	2.8	2.1	5	2.3
*M2.6	× 0.45	TY703496	9	50	15	2.8	2.1	5	2.4
M3	× 0.5	TY703206	11	56	18	3.5	2.7	6	2.8
M3.5	× 0.6	TY703226	12	56	20	4	3	6	3.25
M4	× 0.7	TY703246	13	63	21	4.5	3.4	6	3.7
M4.5	× 0.75	TY703266	14	70	25	6	4.9	8	4.15
M5	× 0.8	TY703286	15	70	25	6	4.9	8	4.65
M6	× 1.0	TY703316	17	80	30	6	4.9	8	5.55
M7	× 1.0	TY703346	17	80	30	7	5.5	8	6.55
M8	× 1.25	TY703366	20	90	35	8	6.2	9	7.4
M9	× 1.25	TY703396	20	90	35	9	7	10	8.4
M10	× 1.5	TY703426	22	100	39	10	8	11	9.3
M11	× 1.5	TY703466	22	100	40	8	6.2	9	10.3
M12	× 1.75	TY703506	24	110	44	9	7	10	11.2
M14	× 2.0	TY703546	26	110	44	11	9	12	13
M16	× 2.0	TY703606	27	110	44	12	9	12	15
M18	× 2.5	TY703656	30	125	50	14	11	14	16.8
M20	× 2.5	TY703706	32	140	54	16	12	15	18.8

Suitable for threading soft materials with at least 8-10% elongation.

The pre-drilling holes are bigger than normal sized holes.

* DIN profile not ISO

ISO

Material Description

VDI 3323

HRC

HB

Recommended

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

ISO

Material Description

VDI 3323

HRC

HB

Recommended

	N					S					H				
	Aluminum-wrought alloy					Aluminum-cast, alloyed					Copper and Copper Alloys (Bronze / Brass)				
	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35
	15	30	25	38	34	15	30	25	38	34	15	30	25	38	34
	60	100	75	90	130	110	90	100			200	280	250	350	320
	⊙	⊙	○	○		○		⊙							

⊙ : Excellent ○ : Good

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TQ703 SERIES

M

ISO metric coarse threads DIN 13

Metrisches ISO-Gewinde DIN 13

ISO MÉTRIQUE DIN13

ISO Metrico passo grosso DIN 13

Cold forming taps with oil grooves
Gewindeformer mit Schmiernuten

Suitable for threading soft materials with at least 8-10% elongation in the best substrate.

The pre-drilling holes are bigger than normal sized holes.

Aus bestem Werkstoff geeignet zum Gewindeformen weicher Werkstoffe mit mindestens 8-10% Dehnung.

Die Kernlochbohrungen sind größer als normale Kernlöcher.

DIN 371

DIN 376

Hole type

3.0×D

60°

P

ØD2

ØD1

KI

L2

L3

L1

Ød1

Material groups

GV

HSS PM

DIN 371/376

6HX

60°

C

Vap

p.B265

Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	Tapping Drill Diameter
ØD1	P	Vap	L1	L2	L3	ØD2	K	KI	Ød1
M2	× 0.4	TQ703136	8	45	13	2.8	2.1	5	1.83
M2.5	× 0.45	TQ703176	9	50	15	2.8	2.1	5	2.3
*M2.6	× 0.45	TQ703496	9	50	15	2.8	2.1	5	2.4
M3	× 0.5	TQ703206	11	56	18	3.5	2.7	6	2.8
M3.5	× 0.6	TQ703226	12	56	20	4	3	6	3.25
M4	× 0.7	TQ703246	13	63	21	4.5	3.4	6	3.7
M4.5	× 0.75	TQ703266	14	70	25	6	4.9	8	4.15
M5	× 0.8	TQ703286	15	70	25	6	4.9	8	4.65
M6	× 1.0	TQ703316	17	80	30	6	4.9	8	5.55
M8	× 1.25	TQ703366	20	90	35	8	6.2	9	7.4
M10	× 1.5	TQ703426	22	100	39	10	8	11	9.3
M12	× 1.75	TQ703506	24	110	44	9	7	10	11.2
M14	× 2.0	TQ703546	26	110	44	11	9	12	13
M16	× 2.0	TQ703606	27	110	44	12	9	12	15
M20	× 2.5	TQ703706	32	140	54	16	12	15	18.8

Suitable for threading soft materials with at least 8-10% elongation in the best substrate.

The pre-drilling holes are bigger than normal sized holes.

* DIN profile not ISO

ISO

Material Description

VDI 3323

HRC

HB

Recommended

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

ISO

Material Description

VDI 3323

HRC

HB

Recommended

	N					S					H				
	Aluminum-wrought alloy					Aluminum-cast, alloyed					Copper and Copper Alloys (Bronze / Brass)				
	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35
	15	30	25	38	34	15	30	25	38	34	15	30	25	38	34
	60	100	75	90	130	110	90	100			200	280	250	350	320
	⊙	⊙	○	○		○		⊙							

⊙ : Excellent ○ : Good

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CARBIDE

HSS

YG TAP FORMING

TQ703 SERIES

M

ISO metric coarse threads DIN 13

Metrisches ISO-Gewinde DIN 13

ISO MÉTRIQUE DIN13

ISO Metrico passo grosso DIN 13

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Aus bestem Werkstoff geeignet zum Gewindeformen weicher Werkstoffe mit mindestens 8-10% Dehnung.

Die Kernlochbohrungen sind größer als normale Kernlöcher.

DIN 371

DIN 376

Hole type

3.0×D

60°

P

ØD2

ØD1

KI

L2

L3

L1

Ød1

Material groups

GV

HSS PM

DIN 371/376

6HX

60°

C

Vap

p.B265

Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	Tapping Drill Diameter
ØD1	P	Vap	L1	L2	L3	ØD2	K	KI	Ød1
M2	× 0.4	TQ703136	8	45	13	2.8	2.1	5	1.83
M2.5	× 0.45	TQ703176	9	50	15	2.8	2.1	5	2.3
*M2.6	× 0.45	TQ703496	9	50	15	2.8	2.1	5	2.4
M3	× 0.5	TQ703206	11	56	18	3.5	2.7	6	2.8
M3.5	× 0.6	TQ703226	12	56	20	4	3	6	3.25
M4	× 0.7	TQ703246	13	63	21	4.5	3.4	6	3.7
M4.5	× 0.75	TQ703266	14	70	25	6	4.9	8	4.15
M5	× 0.8	TQ703286	15	70	25	6	4.9	8	4.65
M6	× 1.0	TQ703316	17	80	30	6	4.9	8	5.55
M8	× 1.25	TQ703366	20	90	35	8	6.2	9	7.4
M10	× 1.5	TQ703426	22	100	39	10	8	11	9.3
M12	× 1.75	TQ703506	24	110	44	9	7	10	11.2
M14	× 2.0	TQ703546	26	110	44	11	9	12	13
M16	× 2.0	TQ703606	27	110	44	12	9	12	15
M20	× 2.5	TQ703706	32	140	54	16	12	15	18.8

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ISO

Material Description

VDI 3323

HRC

HB

Recommended

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

ISO

Material Description

VDI 3323

HRC

HB

Recommended

	N					S					H				
	Aluminum-wrought alloy					Aluminum-cast, alloyed					Copper and Copper Alloys (Bronze / Brass)				
	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35
	15	30	25	38	34	15	30	25	38	34	15	30	25	38	34
	60	100	75	90	130	110	90	100			200	280	250	350	320
	⊙	⊙	○	○		○		⊙							

⊙ : Excellent ○ : Good

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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 FORMING

TD723

SERIES

M

ISO metric coarse threads DIN 13

Metrisches ISO-Gewinde DIN 13

ISO MÉTRIQUE DIN13

ISO Metrico passo grosso DIN 13

Cold forming taps
Gewindeformer

Suitable for threading soft materials with at least 8-10% elongation.

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DIN 376

Hole type

3.0×D

60°

P

ØD2

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Ød1

GV

HSS-E

DIN 371/376

6HX

60°

C

TiN

p.B265

Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	Tapping Drill Diameter
ØD1	P	TiN	L1	L2	L3	ØD2	K	KI	Ød1
M2	× 0.4	TD723136	8	45	13	2.8	2.1	5	1.83
M2.2	× 0.45	TD723156	8	45	13	2.8	2.1	5	2
*M2.3	× 0.4	TD723196	8	45	13	2.8	2.1	5	2.1
M2.5	× 0.45	TD723176	9	50	15	2.8	2.1	5	2.3
*M2.6	× 0.45	TD723496	9	50	15	2.8	2.1	5	2.4
M3	× 0.5	TD723206	11	56	18	3.5	2.7	6	2.8
M3.5	× 0.6	TD723226	12	56	20	4	3	6	3.25
M4	× 0.7	TD723246	13	63	21	4.5	3.4	6	3.7
M4.5	× 0.75	TD723266	14	70	25	6	4.9	8	4.15
M5	× 0.8	TD723286	15	70	25	6	4.9	8	4.65
M6	× 1.0	TD723316	17	80	30	6	4.9	8	5.55
M7	× 1.0	TD723346	17	80	30	7	5.5	8	6.55
M8	× 1.25	TD723366	20	90	35	8	6.2	9	7.4
M9	× 1.25	TD723396	20	90	35	9	7	10	8.4
M10	× 1.5	TD723426	22	100	39	10	8	11	9.3
M11	× 1.5	TD723466	22	100	40	8	6.2	9	10.3
M12	× 1.75	TD723506	24	110	44	9	7	10	11.2
M14	× 2.0	TD723546	26	110	44	11	9	12	13
M16	× 2.0	TD723606	27	110	44	12	9	12	15
M18	× 2.5	TD723656	30	125	50	14	11	14	16.8
M20	× 2.5	TD723706	32	140	54	16	12	15	18.8

DIN 371(M2~M10) and DIN 376(M11~M20)

* 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				
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	◎	◎	○	○	○	○	◎													

B260

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YG-1 CO., LTD.

CARBIDE

HSS

THREAD MILL

SYNCHRO TAP

PRIME TAP

COMBO TAP

YG TAP STEEL

YG TAP CHIP BREAKER

YG TAP INOX

YG TAP CAST IRON

YG TAP HARDENED STEEL

YG TAP Ti Ni

YG TAP ALU

YG TAP FORMING

YG TAP GENERAL

PIPE TAP

STI TAP

NUT TAP

YG TAP FORMING

TD733

SERIES

MF

ISO metric fine threads DIN 13

Metrisches ISO-Feingewinde DIN 13

ISO MÉTRIQUE PAS FINS DIN13

ISO Metrico passo fine DIN 13

Cold forming taps with oil grooves
Gewindeformer

Suitable for threading soft materials with at least 8-10% elongation.

The pre-drilling holes are bigger than normal sized holes.

Geeignet zum Gewindeformen weicher Werkstoffe mit mindestens 8-10% Dehnung.

Die Kernlochbohrungen sind größer als normale Kernlöcher.

DIN 374

Hole type

3.0×D

60°

P

ØD2

ØD1

KI

L1

L2

L3

Ød1

GV

HSS-E

DIN 374

6HX

60°

C

TiN

p.B265

Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	Tapping Drill Diameter
ØD1	P	TiN	L1	L2	L3	ØD2	K	KI	Ød1
M4	× 0.5	TD733256	10	63	21	2.8	2.1	5	3.75
M5	× 0.5	TD733296	11	70	25	3.5	2.7	6	4.75
M6	× 0.5	TD733336	13	80	30	4.5	3.4	6	5.75
M7	× 0.75	TD733356	14	80	30	5.5	4.3	7	6.65
M8	× 1.0	TD733376	17	90	36	6	4.9	8	7.5
M8	× 0.75	TD733386	14	80	30	6	4.9	8	7.65
M10	× 1.25	TD733436	22	100	40	7	5.5	8	9.4
M10	× 1.0	TD733446	18	90	36	7	5.5	8	9.5
M12	× 1.5	TD733516	22	100	40	9	7	10	11.25
M12	× 1.25	TD733526	22	100	40	9	7	10	11.4
M12	× 1.0	TD733536	18	100	40	9	7	10	11.5
M14	× 1.5	TD733556	22	100	40	11	9	12	13.25
M14	× 1.25	TD733566	22	100	40	11	9	12	13.4
M16	× 1.5	TD733616	22	100	40	12	9	12	15.25
M18	× 1.5	TD733676	25	110	44	14	11	14	17.25
M20	× 1.5	TD733726	25	125	50	16	12	15	19.25

◎ : Excellent ○ : Good

ISO	P										M					K				
Material Description	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel					Stainless steel				
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRC	13	25	28	32	30	10	29	32	38	15	35	15	23	10	10	26	3	25	21	
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	◎	◎	◎				○	○	○	○	○						

ISO	N										S					H				
Material Description	Aluminum-wrought alloy					Aluminum-cast, alloyed					Copper and Copper Alloys (Bronze / Brass)					Non Metallic Materials				
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40
HRC	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-1 CO., LTD.

CARBIDE

HSS

THREAD MILL

SYNCHRO TAP

PRIME TAP

COMBO TAP

YG TAP STEEL

YG TAP CHIP BREAKER

YG TAP INOX

YG TAP CAST IRON

YG TAP HARDENED STEEL

YG TAP Ti Ni

YG TAP ALU

YG TAP FORMING

YG TAP GENERAL

PIPE TAP

STI TAP

NUT TAP

YG TAP FORMING

TE733

SERIES

MF

ISO metric fine threads DIN 13

Metrisches ISO-Feingewinde DIN 13

ISO MÉTRIQUE PAS FINS DIN13

ISO Metrico passo fine DIN 13

Cold forming taps with oil grooves

Gewindeformer mit Schmiernuten

Suitable for threading soft materials with at least 8-10% elongation.

The pre-drilling holes are bigger than normal sized holes.

Geeignet zum Gewindeformen weicher Werkstoffe mit mindestens 8-10% Dehnung.

Die Kernlochbohrungen sind größer als normale Kernlöcher.

DIN 374

Hole type

3.0×D

GV

HSS-E

DIN 374

6HX

60°

C

Nitride

p.B265

Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	Tapping Drill Diameter
ØD1	P	Ni	L1	L2	L3	ØD2	K	KI	Ød1
M4	× 0.5	TE733256	10	63	21	2.8	2.1	5	3.75
M5	× 0.5	TE733296	11	70	25	3.5	2.7	6	4.75
M6	× 0.75	TE733326	13	80	30	4.5	3.4	6	5.65
M7	× 0.75	TE733356	14	80	30	5.5	4.3	7	6.65
M8	× 1.0	TE733376	17	90	36	6	4.9	8	7.5
M10	× 1.0	TE733446	18	90	36	7	5.5	8	9.5
M12	× 1.5	TE733516	22	100	40	9	7	10	11.25
M12	× 1.0	TE733536	18	100	40	9	7	10	11.5
M14	× 1.5	TE733556	22	100	40	11	9	12	13.25
M16	× 1.5	TE733616	22	100	40	12	9	12	15.25
M18	× 1.5	TE733676	25	110	44	14	11	14	17.25

◎ : Excellent

○ : Good

ISO	P										M					K				
Material Description	Non-alloy steel					Low alloy steel					High alloy 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	◎	◎	○	○		○		○												

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YG

YG-1 CO., LTD.

YG TAP FORMING

TD704

SERIES

UNC

Unified coarse threads

Unified Grobgewinde

UNC

Unificato passo grosso

Cold forming taps with oil grooves

Gewindeformer mit Schmiernuten

Suitable for threading soft materials with at least 8-10% elongation.

The pre-drilling holes are bigger than normal sized holes.

Geeignet zum Gewindeformen weicher Werkstoffe mit mindestens 8-10% Dehnung.

Die Kernlochbohrungen sind größer als normale Kernlöcher.

DIN 371

DIN 376

Hole type

3.0×D

GV

HSS-E

DIN 371/376

2BX

60°

C

TiN

p.B265

Unit : mm

SIZE	TPI	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	Tapping Drill Diameter
ØD1		TiN	L1	L2	L3	ØD2	K	KI	Ød1
#5	- 40 UNC	TD704202	11	56	18	3.5	2.7	6	2.87
#6	- 32 UNC	TD704242	12	56	20	4	3	6	3.1
#8	- 32 UNC	TD704282	13	63	21	4.5	3.4	6	3.8
#12	- 24 UNC	TD704362	16	80	30	6	4.9	8	4.95
1/4	- 20 UNC	TD704402	17	80	30	7	5.5	8	5.75
5/16	- 18 UNC	TD704442	20	90	35	8	6.2	9	7.25
3/8	- 16 UNC	TD704482	22	100	39	9	7	10	8.75
1/2	- 13 UNC	TD704562	25	110	44	9	7	10	11.7
9/16	- 12 UNC	TD704602	26	110	40	11	9	12	13.2
5/8	- 11 UNC	TD704642	27	110	44	12	9	12	14.7
3/4	- 10 UNC	TD704702	30	125	50	14	11	14	17.8

◎ : Excellent

○ : Good

ISO	P										M					K				
Material Description	Non-alloy steel					Low alloy steel					High alloy 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	◎	◎	○	○		○		○												

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YG

YG-1 CO., LTD.



TE704 SERIES

UNC Unified coarse threads

Unified Grobgewinde

UNC

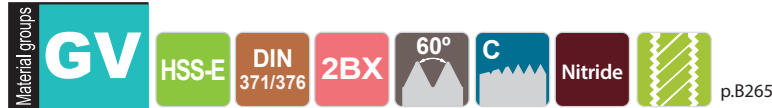
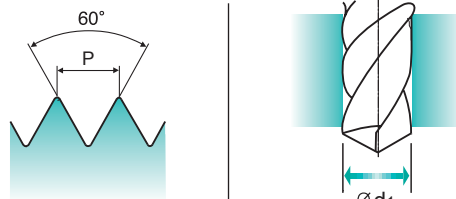
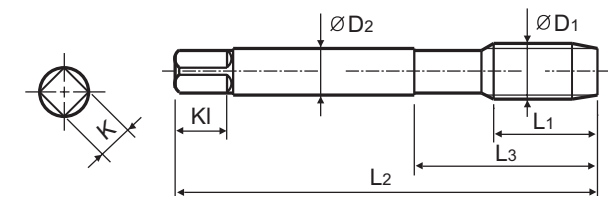
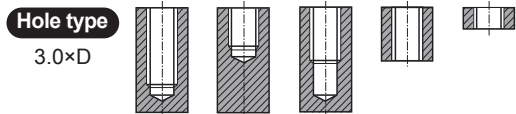
Unificato passo grosso

Cold forming taps with oil grooves

Gewindeformer mit Schmiernuten

- Suitable for threading soft materials with at least 8-10% elongation.
- The pre-drilling holes are bigger than normal sized holes.

- Geeignet zum Gewindeformen weicher Werkstoffe mit mindestens 8-10% Dehnung.
- Die Kernlochbohrungen sind größer als normale Kernlöcher.



Unit : mm									
SIZE	TPI	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	Tapping Drill Diameter
ØD1		Ni	L1	L2	L3	ØD2	K	KI	Ød1
#5	- 40 UNC	TE704202	11	56	18	3.5	2.7	6	2.87
#8	- 32 UNC	TE704282	13	63	21	4.5	3.4	6	3.8
#12	- 24 UNC	TE704362	16	80	30	6	4.9	8	4.95
1/4	- 20 UNC	TE704402	17	80	30	7	5.5	8	5.75
5/16	- 18 UNC	TE704442	20	90	35	8	6.2	9	7.25
3/8	- 16 UNC	TE704482	22	100	39	9	7	10	8.75
7/16	- 14 UNC	TE704522	22	100	40	8	6.2	9	10.2

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

◎ : Excellent ○ : Good

ISO	P										M				K								
Material Description	Non-alloy steel					Low alloy steel				High alloy 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	◎	◎	○	○		○		○															



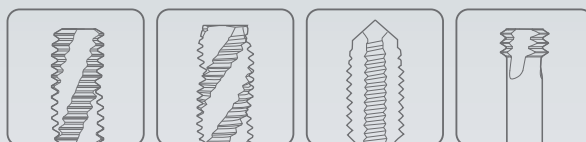
RECOMMENDED CUTTING CONDITIONS

EMPFOHLENE SCHNEIDKONDITIONEN

					TD703 TD733 TD704	TE703 TE733 TE704	TY703	TQ703	TD713	TE713	TQ723	TE723	TD723
ISO	VDI 3323	Material Description	HB	HRc	Vc (m/min)								
P	1	Non-alloy steel	125		15-20	15-20	15-20	15-20	15-20	15-20	15-20	15-20	15-20
	2		190	13	15-20	15-20	15-20	15-20	15-20	15-20	15-20	15-20	15-20
	3		250	25	12-18	12-18	12-18	12-18	12-18	12-18	12-18	12-18	12-18
	6	Low alloy steel	180	10	10-15	10-15	10-15	10-15	10-15	10-15	10-15	10-15	10-15
M	12	Stainless steel	200	15	10-13	7-10	10-13	7-10	10-13	7-10	7-10	7-10	10-13
	13		240	23	8-11	5-8	8-11	5-8	8-11	5-8	5-8	5-8	8-11
	14		180	10	6-8	4-6	6-8	4-6	6-8	4-6	4-6	4-6	6-8
N	21	Aluminum-wrought alloy	60		10-15	10-15	10-15	10-15	10-15	10-15	10-15	10-15	10-15
	22		100		10-15	10-15	10-15	10-15	10-15	10-15	10-15	10-15	10-15
	23	Aluminum-cast, alloyed	75		15-20	15-20	15-20	15-20	15-20	15-20	15-20	15-20	15-20
	24		90		10-15	10-15	10-15	10-15	10-15	10-15	10-15	10-15	10-15
	26	Copper and Copper Alloys (Bronze / Brass)	110		25-35	25-35	25-35	25-35	25-35	25-35	25-35	25-35	25-35
	28		100		15-20	15-20	15-20	15-20	15-20	15-20	15-20	15-20	15-20



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THREADING