

YE-YTC26 **EUROPE**



SOLID CARBIDE & HSS-PM
High-Performance Taps
for Mass Production
Cast Iron & Cast Aluminum



1st-cut

Andreas Stolze e.K.

Prozessoptimierung
Zerspanungslösung
Werkzeugvertrieb



Fragen zum Produkt oder
Individuelles Angebot?

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www.1st-cut.de



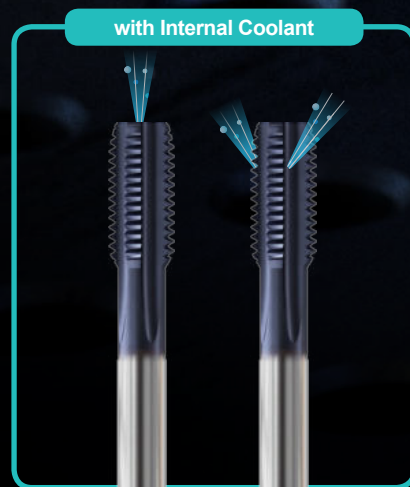
High-Performance Taps for Mass Production Cast Iron & Cast Aluminum

NEW PORTFOLIO!

EXPANSION Carbide and HSS-PM
Straight Flute Taps for Metric and G(BSP)

FEATURE

- **HSS-PM and Solid Carbide Substrates** : Engineered for higher spindle speeds and extended tool life.
- **TiAlN Coating** : Premium coating that delivers excellent heat and wear resistance.
- **Radial or Axial Internal Coolant Options** : Available with or without internal coolant holes.
Optimize performance by delivering coolant directly to the cutting zone for even higher speeds and longer tool life.



Entry Chamfer Options :
Standard short
and extra-short chamfer
styles available
for close clearance tapping
applications.

GUIDE TO ICONS

Working Material



K Cast Iron
N Cast Aluminum

Surface Treatment



Class of Thread
6HX

Tool Raw Material



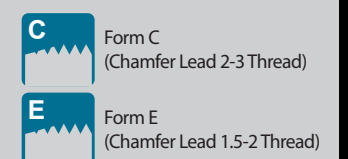
Thread Angle
60° 55°

Standard of Tools



Cutting Condition
Z

Chamfer Lead



SOLID CARBIDE & HSS-PM
High-Performance Taps
for Mass Production
Cast Iron & Cast Aluminum



Please visit
globalyg1.com/mat
for material search

◎ : Excellent ○ : Good

ISO	VDI 3323	Material Description	Composition / Structure / Heat Treatment		HB	HRc	Recommended cutting conditions Vc (m/min.)		
P	1	Non-alloy steel	About 0.15% C	Annealed	125				
	2		About 0.45% C	Annealed	190	13			
	3		About 0.45% C	Quenched & tempered	250	25			
	4		About 0.75% C	Annealed	270	28			
	5		About 0.75% C	Quenched & tempered	300	32			
	6	Low alloy steel		Annealed	180	10			
	7			Quenched & tempered	275	29			
	8			Quenched & tempered	300	32			
	9			Quenched & tempered	350	38			
	10	High alloyed steel, and tool steel		Annealed	200	15			
	11			Quenched & Tempered	325	35			
M	12	Stainless steel	Ferritic / Martensitic	Annealed	200	15			
	13		Martensitic	Quenched & Tempered	240	23			
	14		Austenitic		180	10			
K	15	Grey cast iron	Pearlitic / ferritic		180	10	◎ (15-50)	◎ (15-50)	◎ (10-15)
	16		Pearlitic (Martensitic)		260	26	◎ (10-30)	◎ (10-30)	◎ (5-8)
	17	Nodular cast iron	Ferritic		160	3	◎ (15-50)	◎ (15-50)	◎ (10-18)
	18		Pearlitic		250	25	◎ (10-30)	◎ (10-30)	◎ (5-8)
	19	Malleable cast iron	Ferritic		130		○ (15-50)	○ (15-50)	○ (10-15)
	20		Pearlitic		230	21	○ (10-30)	○ (10-30)	○ (5-8)
N	21	Aluminum-wrought alloy	Not Curable		60				
	22		Curable	Hardened	100				
	23	Aluminum-cast, alloyed	≤ 12% Si, Not Curable		75		◎ (15-50)	◎ (15-50)	◎ (15-20)
	24		≤ 12% Si, Curable	Hardened	90				
	25		> 12% Si, Not Curable		130		◎ (10-40)	◎ (10-40)	◎ (10-15)
	26	Copper and Copper Alloys (Bronze / Brass)	Cutting Alloys, PB>1%		110				
	27		CuZn, CuSnZn (Brass)		90		◎ (12-40)	◎ (12-40)	○ (12-16)
	28		CuSn, lead-free copper and electrolytic copper		100				
	29	Non Metallic Materials	Duroplastic, Fiber Reinforced Plastic						
	30		Rubber, Wood, etc.						
S	31	Heat Resistant Super Alloys	Fe Based	Annealed	200	15			
	32			Cured	280	30			
	33		Ni or Co Based	Annealed	250	25			
	34			Cured	350	38			
	35			Cast	320	34			
	36	Titanium Alloys	Pure Titanium		400 Rm				
	37		Alpha + Beta Alloys	Hardened	1050 Rm				
H	38	Hardened steel		Hardened	550	55			
	39			Hardened	630	60			
	40	Chilled Cast Iron		Cast	400	42	◎ (3-15)	◎ (3-15)	◎ (3-5)
	41	Hardened Cast Iron		Hardened	550	55			

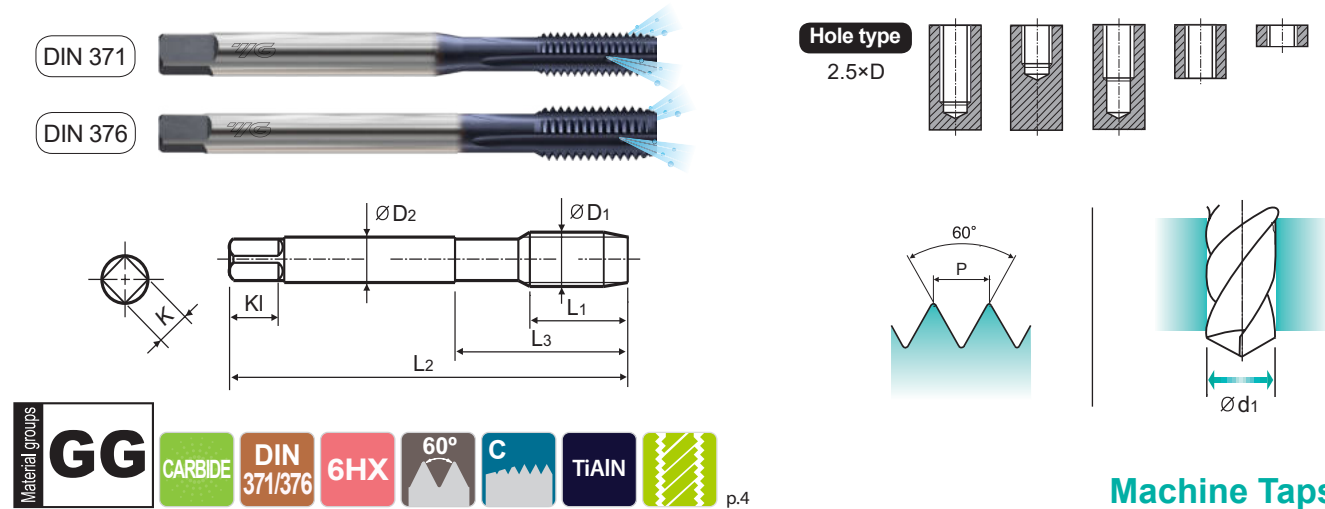
     Max. 2.0xD Blind / Through Hole	     Max. 2.0xD Blind / Through Hole	   Max. 2.5xD Blind Hole	   Max. 2.5xD Blind Hole	     Max. 2.5xD Blind / Through Hole
HSS-PM				
C	E	C	E	C
Straight Flute Tap				
TRB10 (p.9)	TRB06 (p.10)	TRB19 (p.11)	TRB13 (p.12)	TRB23 (p.13)
TRB11 (p.16)	TRB07 (p.17)	TRB20 (p.18)	TRB14 (p.19)	TRB24 (p.20)
TRB12 (p.21)	TRB08 (p.22)	TRB22 (p.23)	TRB18 (p.24)	TRB25 (p.25)
TiAlN				
				
Recommended cutting conditions Vc (m/min.)				

M CARBIDE YG TAP CAST IRON with Oil Hole ISO Metric Coarse Threads - DIN 13

SERIES

T0B04

► Carbide tap can increase tool life longer than HSS taps due to higher hardness.
Suitable for Cast Iron and Cast Aluminum.



Machine Taps

Unit : mm										
SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD ₁	P	TiAlN	L ₁	L ₂	L ₃	ØD ₂	K	KI	Z	Ød ₁
M5	x 0.8	T0B04286TIAP	15	70	25	6	4.9	8	3	4.2
M6	x 1.0	T0B04316TIAP	17	80	30	6	4.9	8	4	5
M8	x 1.25	T0B04366TIAP	20	90	35	8	6.2	9	4	6.75
M10	x 1.5	T0B04426TIAP	22	100	39	10	8	11	4	8.5
M12	x 1.75	T0B04506TIAP	24	110	44	9	7	10	4	10.25

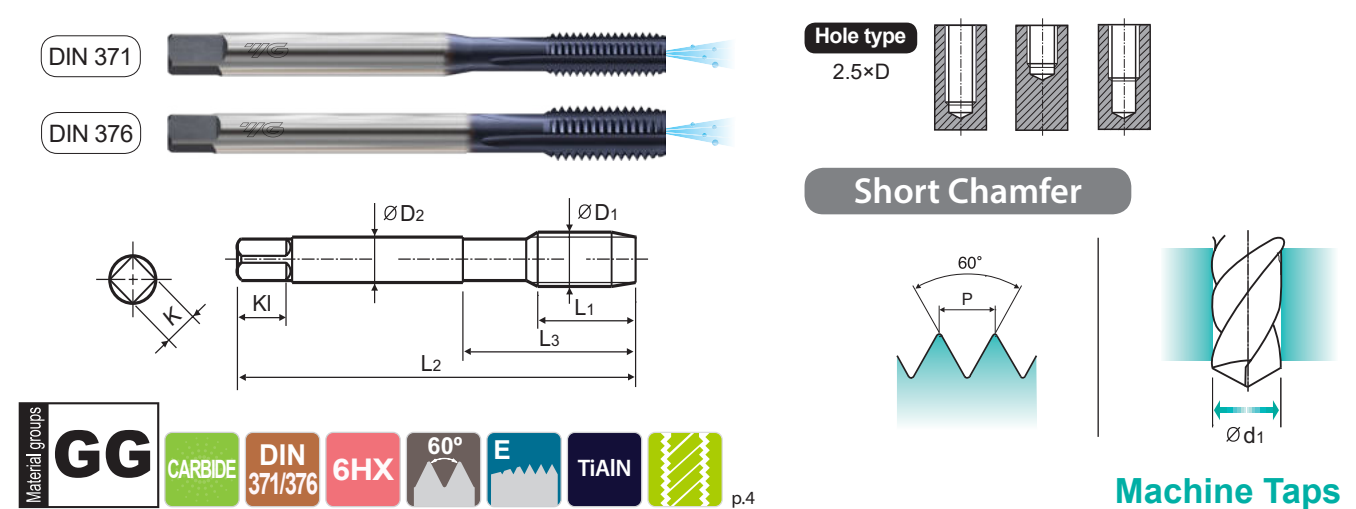
► DIN 371(up to M10) and DIN 376(above M10)

M CARBIDE YG TAP CAST IRON with Oil Hole ISO Metric Coarse Threads - DIN 13

SERIES

T0B01

► Carbide tap can increase tool life longer than HSS taps due to higher hardness.
Suitable for Cast Iron and Cast Aluminum.



Machine Taps

Unit : mm										
SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD ₁	P	TiAlN	L ₁	L ₂	L ₃	ØD ₂	K	KI	Z	Ød ₁
M5	x 0.8	T0B01286TIA	15	70	25	6	4.9	8	3	4.2
M6	x 1.0	T0B01316TIA	17	80	30	6	4.9	8	4	5
M8	x 1.25	T0B01366TIA	20	90	35	8	6.2	9	4	6.75
M10	x 1.5	T0B01426TIA	22	100	39	10	8	11	4	8.5
M12	x 1.75	T0B01506TIA	24	110	44	9	7	10	4	10.25

► DIN 371(up to M10) and DIN 376(above M10)

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

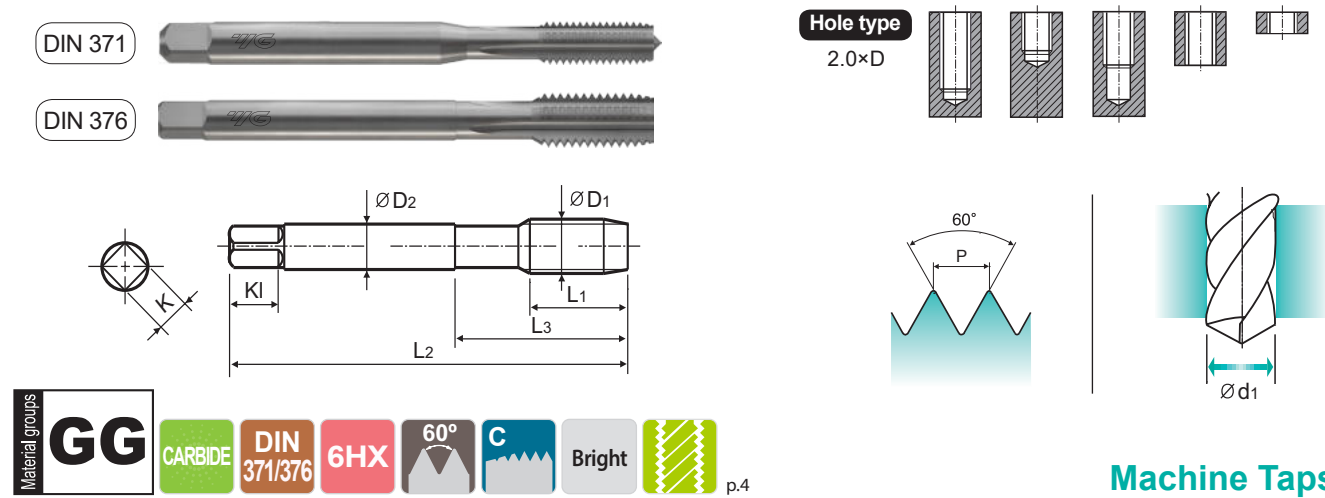
◎ : Excellent ○ : Good																					
ISO	P										M					K					
Material Description	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	
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	400 Rm	1050 Rm	550	630	400	550
Recommended			◎		◎		◎													◎	

M CARBIDE YG TAP CAST IRON ISO Metric Coarse Threads - DIN 13

SERIES

T0993

► Carbide tap can increase tool life longer than HSS taps due to higher hardness.
Suitable for Cast Iron and Cast Aluminum.



Machine Taps

Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD ₁	P	Bright	L ₁	L ₂	L ₃	ØD ₂	K	KI	Z	Ød ₁
M3	x 0.5	T0993206	11	56	18	3.5	2.7	6	3	2.5
M3.5	x 0.6	T0993226	12	56	20	4	3	6	3	2.9
M4	x 0.7	T0993246	13	63	21	4.5	3.4	6	3	3.3
M5	x 0.8	T0993286	15	70	25	6	4.9	8	4	4.2
M6	x 1.0	T0993316	17	80	30	6	4.9	8	4	5
M8	x 1.25	T0993366	20	90	35	8	6.2	9	4	6.8
M10	x 1.5	T0993426	22	100	39	10	8	11	4	8.5
M12	x 1.75	T0993506	24	110	44	9	7	10	4	10.2
M14	x 2.0	T0993546	26	110	44	11	9	12	4	12
M16	x 2.0	T0993606	27	110	44	12	9	12	4	14
M18	x 2.5	T0993656	30	125	50	14	11	14	4	15.5
M20	x 2.5	T0993706	32	140	54	16	12	15	4	17.5

► DIN 371(up to M10) and DIN 376(above M10)

◎ : Excellent ○ : Good

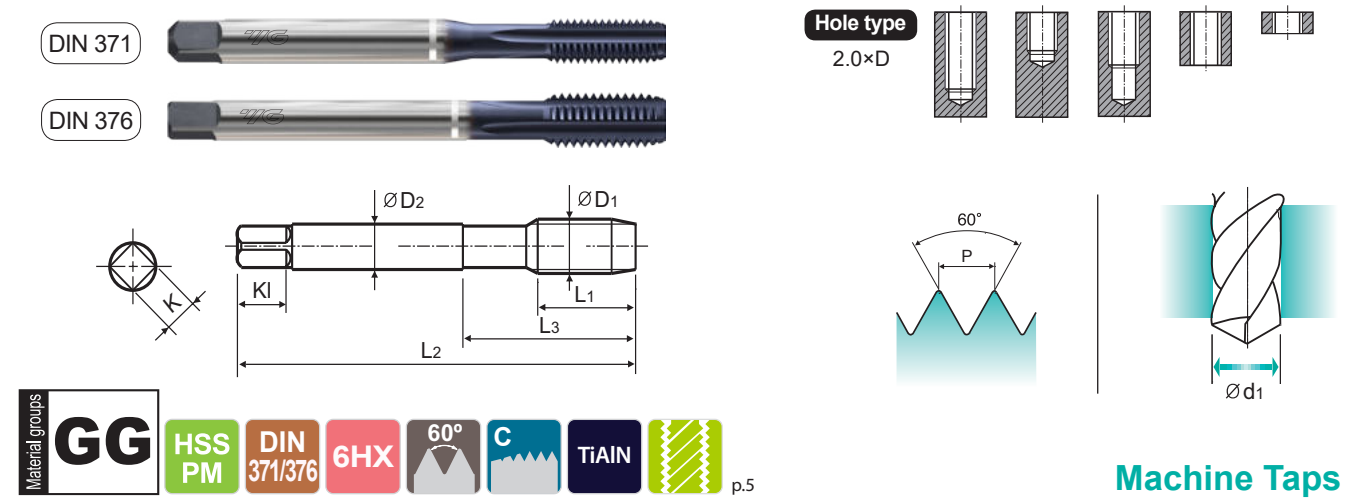
ISO	P										M					K				
Material Description	Non-alloy steel					Low alloy steel					Stainless steel					Grey cast iron				
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRC	13	25	28	32	35	10	29	32	38	15	35	15	23	10	10	26	3	25	19	21
HB	125	190	250	270	300	180	275	300	350	200	325	200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

M HSS-PM YG TAP CAST IRON ISO Metric Coarse Threads - DIN 13

SERIES

TRB10

► HSS-PM versatile solution with advanced geometry, ensuring stable performance in Cast Iron and Cast Aluminum.



Machine Taps

Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD ₁	P	TiAlN	L ₁	L ₂	L ₃	ØD ₂	K	KI	Z	Ød ₁
M3	x 0.5	TRB10206TIA	11	56	18	3.5	2.7	6	3	2.5
M4	x 0.7	TRB10246TIA	13	63	21	4.5	3.4	6	3	3.3
M5	x 0.8	TRB10286TIA	15	70	25	6	4.9	8	3	4.2
M6	x 1.0	TRB10316TIA	17	80	30	6	4.9	8	4	5
M8	x 1.25	TRB10366TIA	20	90	35	8	6.2	9	4	6.75
M10	x 1.5	TRB10426TIA	22	100	39	10	8	11	4	8.5
M12	x 1.75	TRB10506TIA	24	110	44	9	7	10	4	10.25
M14	x 2.0	TRB10546TIA	26	110	44	11	9	12	5	12
M16	x 2.0	TRB10606TIA	27	110	44	12	9	12	5	14
M18	x 2.5	TRB10656TIA	30	125	50	14	11	14	5	15.5
M20	x 2.5	TRB10706TIA	32	140	54	16	12	15	5	17.5

► DIN 371(up to M10) and DIN 376(above M10)

◎ : Excellent ○ : Good

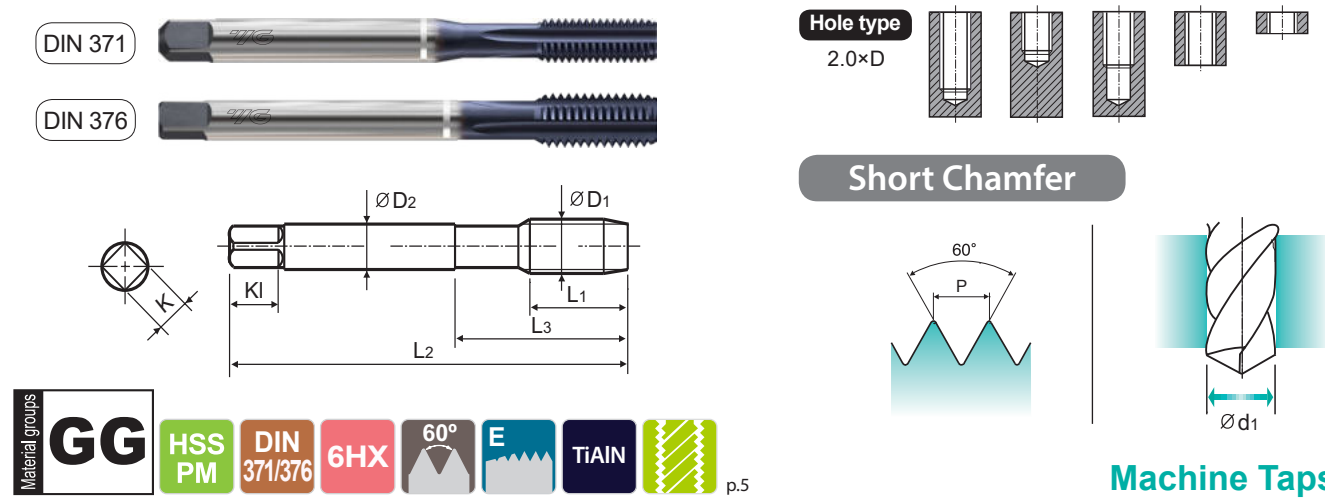
ISO	P										M					K				
Material Description	Non-alloy steel					Low alloy steel					Stainless steel					Grey cast iron				
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRC	13	25	28	32	35	10	29	32	38	15	35	15	23	10	10	26	3	25	19	21
HB	125	190	250	270	300	180	275	300	350	200	325	200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

M HSS-PM YG TAP CAST IRON ISO Metric Coarse Threads - DIN 13

SERIES

TRB06

► HSS-PM versatile solution with advanced geometry, ensuring stable performance in Cast Iron and Cast Aluminum.



SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD ₁	P	TiAlN	L ₁	L ₂	L ₃	ØD ₂	K	KI	Z	Ød ₁
M3	x 0.5	TRB06206TIA	11	56	18	3.5	2.7	6	3	2.5
M4	x 0.7	TRB06246TIA	13	63	21	4.5	3.4	6	3	3.3
M5	x 0.8	TRB06286TIA	15	70	25	6	4.9	8	3	4.2
M6	x 1.0	TRB06316TIA	17	80	30	6	4.9	8	4	5
M8	x 1.25	TRB06366TIA	20	90	35	8	6.2	9	4	6.75
M10	x 1.5	TRB06426TIA	22	100	39	10	8	11	4	8.5
M12	x 1.75	TRB06506TIA	24	110	44	9	7	10	4	10.25
M14	x 2.0	TRB06546TIA	26	110	44	11	9	12	5	12
M16	x 2.0	TRB06606TIA	27	110	44	12	9	12	5	14
M18	x 2.5	TRB06656TIA	30	125	50	14	11	14	5	15.5
M20	x 2.5	TRB06706TIA	32	140	54	16	12	15	5	17.5

► DIN 371(up to M10) and DIN 376(above M10)

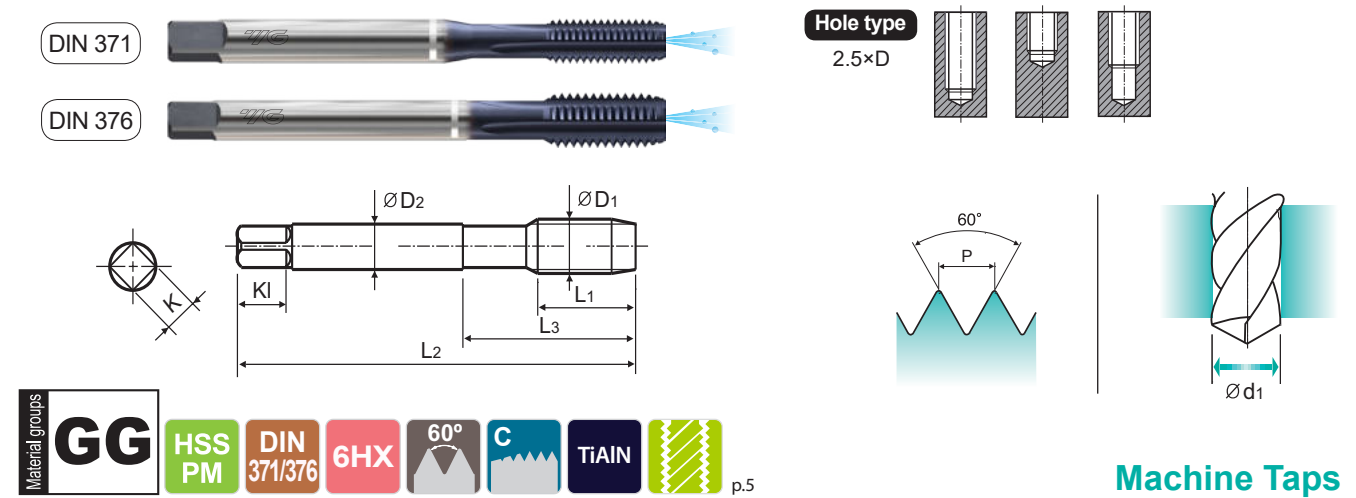
ISO	P										M					K				
Material Description	Non-alloy steel					Low alloy steel					Stainless steel					Grey cast iron				
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRC	13	25	28	32	38	10	29	32	38	15	35	15	23	10	10	26	3	25	19	21
HB	125	190	250	270	300	180	275	300	350	200	325	200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

M HSS-PM YG TAP CAST IRON with Oil Hole ISO Metric Coarse Threads - DIN 13

SERIES

TRB19

► HSS-PM versatile solution with advanced geometry, ensuring stable performance in Cast Iron and Cast Aluminum.



SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD ₁	P	TiAlN	L ₁	L ₂	L ₃	ØD ₂	K	KI	Z	Ød ₁
M5	x 0.8	TRB19286TIA	15	70	25	6	4.9	8	3	4.2
M6	x 1.0	TRB19316TIA	17	80	30	6	4.9	8	4	5
M8	x 1.25	TRB19366TIA	20	90	35	8	6.2	9	4	6.75
M10	x 1.5	TRB19426TIA	22	100	39	10	8	11	4	8.5
M12	x 1.75	TRB19506TIA	24	110	44	9	7	10	4	10.25
M14	x 2.0	TRB19546TIA	26	110	44	11	9	12	5	12
M16	x 2.0	TRB19606TIA	27	110	44	12	9	12	5	14
M18	x 2.5	TRB19656TIA	30	125	50	14	11	14	5	15.5
M20	x 2.5	TRB19706TIA	32	140	54	16	12	15	5	17.5

► DIN 371(up to M10) and DIN 376(above M10)

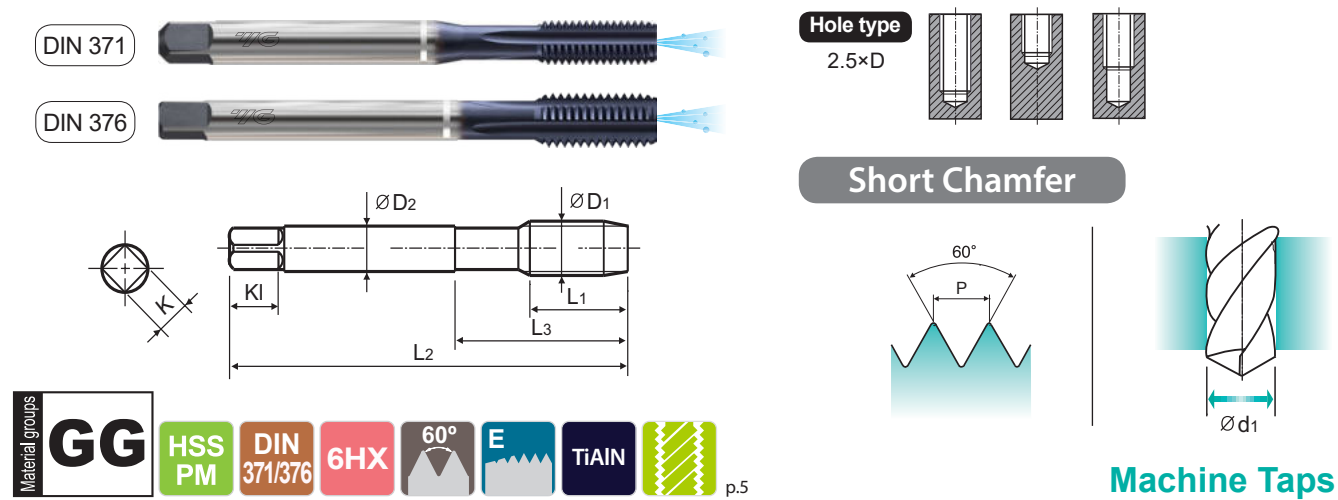
ISO	P										M					K				
Material Description	Non-alloy steel					Low alloy steel					Stainless steel					Grey cast iron				
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRC	13	25	28	32	38	10	29	32	38	15	35	15	23	10	10	26	3	25	19	21
HB	125	190	250	270	300	180	275	300	350	200	325	200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

M HSS-PM YG TAP CAST IRON with Oil Hole ISO Metric Coarse Threads - DIN 13

SERIES

TRB13

► HSS-PM versatile solution with advanced geometry, ensuring stable performance in Cast Iron and Cast Aluminum.



SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
$\varnothing D_1$	P	TiAlN	L_1	L_2	L_3	$\varnothing D_2$	K	KL	Z	$\varnothing d_1$
M5	x 0.8	TRB13286TIA	15	70	25	6	4.9	8	3	4.2
M6	x 1.0	TRB13316TIA	17	80	30	6	4.9	8	4	5
M8	x 1.25	TRB13366TIA	20	90	35	8	6.2	9	4	6.75
M10	x 1.5	TRB13426TIA	22	100	39	10	8	11	4	8.5
M12	x 1.75	TRB13506TIA	24	110	44	9	7	10	4	10.25
M14	x 2.0	TRB13546TIA	26	110	44	11	9	12	5	12
M16	x 2.0	TRB13606TIA	27	110	44	12	9	12	5	14
M18	x 2.5	TRB13656TIA	30	125	50	14	11	14	5	15.5
M20	x 2.5	TRB13706TIA	32	140	54	16	12	15	5	17.5

► DIN 371(up to M10) and DIN 376(above M10)

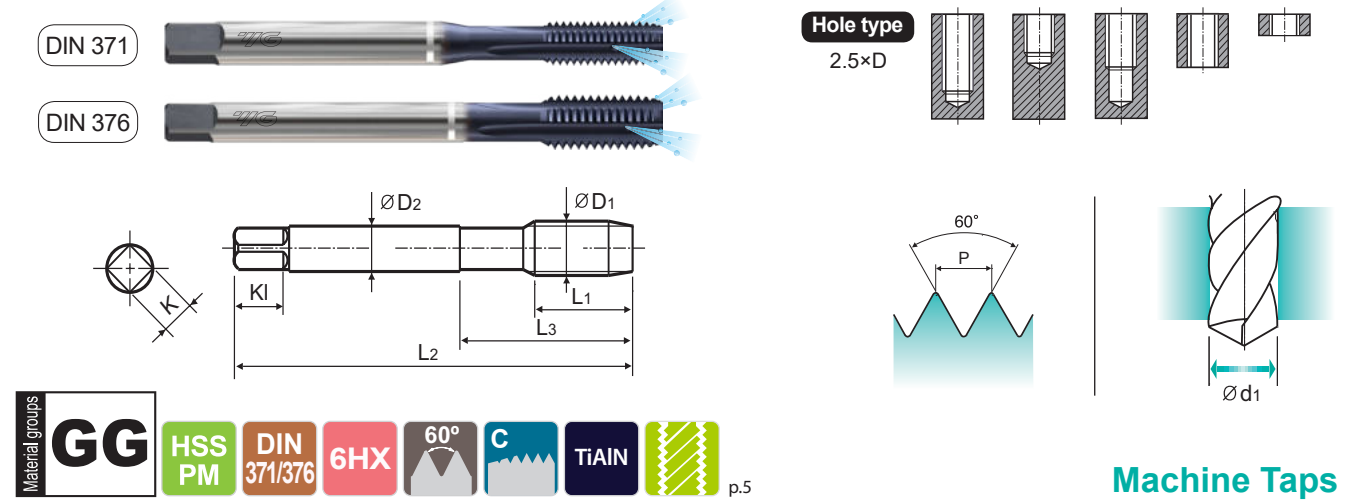
ISO	P										M					K				
Material Description	Non-alloy steel					Low alloy steel					Stainless steel					Grey cast iron				
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRC	13	25	28	32	38	10	29	32	38	15	35	23	10	10	26	3	25	3	25	21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240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

M HSS-PM YG TAP CAST IRON with Oil Hole ISO Metric Coarse Threads - DIN 13

SERIES

TRB23

► HSS-PM versatile solution with advanced geometry, ensuring stable performance in Cast Iron and Cast Aluminum.



SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
$\varnothing D_1$	P	TiAlN	L_1	L_2	L_3	$\varnothing D_2$	K	KL	Z	$\varnothing d_1$
M5	x 0.8	TRB23286TIAP	15	70	25	6	4.9	8	3	4.2
M6	x 1.0	TRB23316TIAP	17	80	30	6	4.9	8	4	5
M8	x 1.25	TRB23366TIAP	20	90	35	8	6.2	9	4	6.75
M10	x 1.5	TRB23426TIAP	22	100	39	10	8	11	4	8.5
M12	x 1.75	TRB23506TIAP	24	110	44	9	7	10	4	10.25
M14	x 2.0	TRB23546TIAP	26	110	44	11	9	12	5	12
M16	x 2.0	TRB23606TIAP	27	110	44	12	9	12	5	14
M18	x 2.5	TRB23656TIAP	30	125	50	14	11	14	5	15.5
M20	x 2.5	TRB23706TIAP	32	140	54	16	12	15	5	17.5

► DIN 371(up to M10) and DIN 376(above M10)

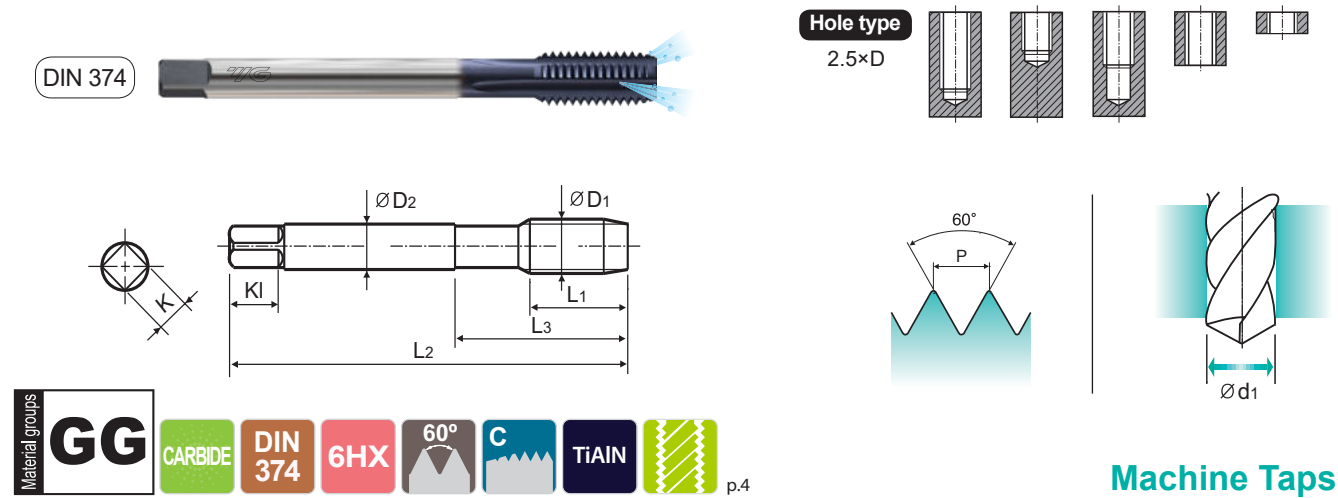
ISO	P										M					K				
Material Description	Non-alloy steel					Low alloy steel					Stainless steel					Grey cast iron				
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRC	13	25	28	32	38	10	29	32	38	15	35	23	10	10	26	3	25	3	25	21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240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

MF CARBIDE YG TAP CAST IRON with Oil Hole ISO Metric Fine Threads - DIN 13

SERIES

T0B05

► Carbide tap can increase tool life longer than HSS taps due to higher hardness.
Suitable for Cast Iron and Cast Aluminum.



Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD ₁	P	TiAlN	L ₁	L ₂	L ₃	ØD ₂	K	KI	Z	Ød ₁
M8	x 1.0	T0B05376TIAP	17	90	36	6	4.9	8	4	7
M8	x 0.75	T0B05386TIAP	14	80	30	6	4.9	8	4	7.25
M10	x 1.25	T0B05436TIAP	22	100	40	7	5.5	8	4	8.75
M10	x 1.0	T0B05446TIAP	18	90	36	7	5.5	8	4	9
M12	x 1.5	T0B05516TIAP	22	100	40	9	7	10	4	10.5
M12	x 1.25	T0B05526TIAP	22	100	40	9	7	10	4	10.75
M12	x 1.0	T0B05536TIAP	18	100	40	9	7	10	4	11

◎ : Excellent ○ : Good

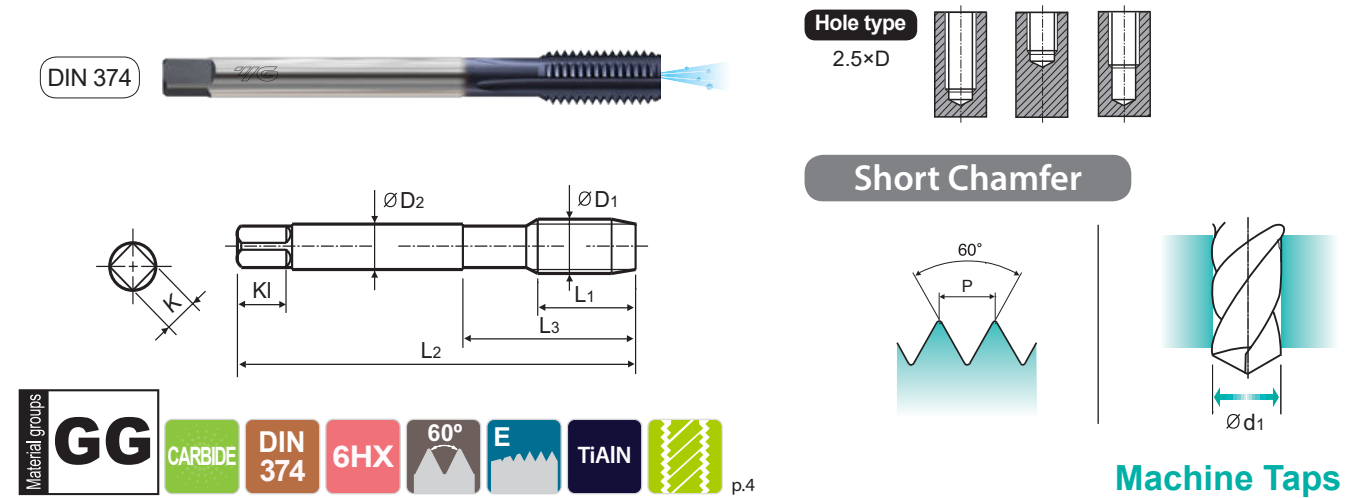
ISO	P										M				K						
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron		
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	
HRC		13	25	28	32	10	29	32	38	15	35	15	23	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	400 Rm	1050 Rm	550	630	400	550
Recommended			◎		◎		◎													◎	

MF CARBIDE YG TAP CAST IRON with Oil Hole ISO Metric Fine Threads - DIN 13

SERIES

T0B02

► Carbide tap can increase tool life longer than HSS taps due to higher hardness.
Suitable for Cast Iron and Cast Aluminum.



Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD ₁	P	TiAlN	L ₁	L ₂	L ₃	ØD ₂	K	KI	Z	Ød ₁
M8	x 1.0	T0B02376TIA	17	90	36	6	4.9	8	4	7
M8	x 0.75	T0B02386TIA	14	80	30	6	4.9	8	4	7.25
M10	x 1.25	T0B02436TIA	22	100	40	7	5.5	8	4	8.75
M10	x 1.0	T0B02446TIA	18	90	36	7	5.5	8	4	9
M12	x 1.5	T0B02516TIA	22	100	40	9	7	10	4	10.5
M12	x 1.25	T0B02526TIA	22	100	40	9	7	10	4	10.75
M12	x 1.0	T0B02536TIA	18	100	40	9	7	10	4	11

◎ : Excellent ○ : Good

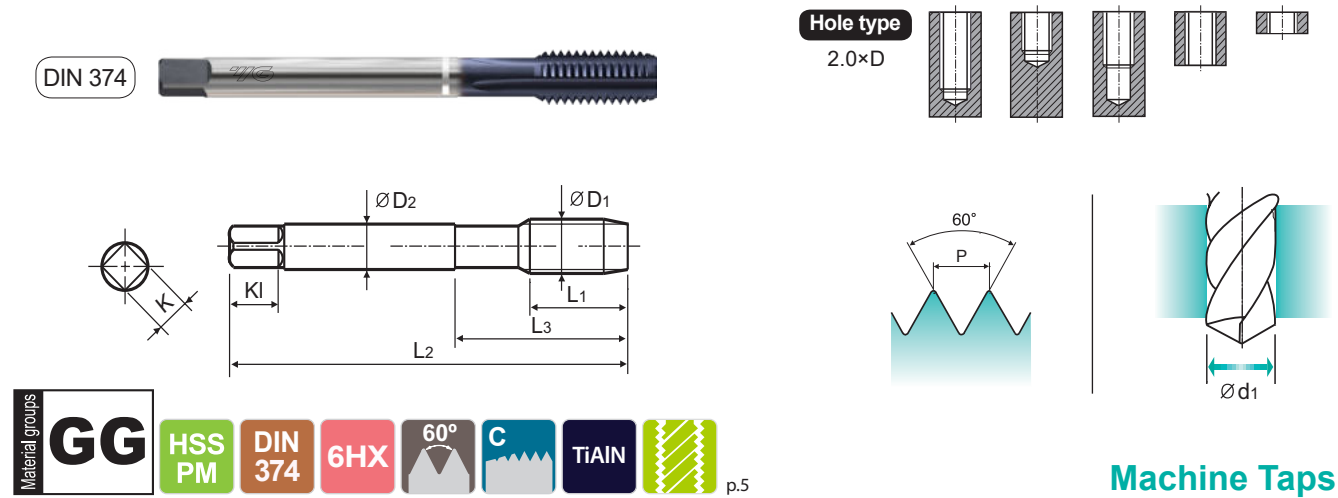
ISO	P										M				K								
Material Description	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron			
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20			
HRC		13	25	28	32	10	29	32	38	15	35	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	400 Rm	1050 Rm	550	630	400	550		
Recommended			◎		◎		◎													◎			

MF HSS-PM YG TAP CAST IRON ISO Metric Fine Threads - DIN 13

SERIES

TRB11

► HSS-PM versatile solution with advanced geometry, ensuring stable performance in Cast Iron and Cast Aluminum.



Machine Taps

Unit : mm										
SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
$\varnothing D_1$	P	TiAlN	L_1	L_2	L_3	$\varnothing D_2$	K	KI	Z	$\varnothing d_1$
M8	x 1.0	TRB11376TIA	17	90	36	6	4.9	8	4	7
M8	x 0.75	TRB11386TIA	14	80	30	6	4.9	8	4	7.25
M10	x 1.25	TRB11436TIA	22	100	40	7	5.5	8	4	8.75
M10	x 1.0	TRB11446TIA	18	90	36	7	5.5	8	4	9
M12	x 1.5	TRB11516TIA	22	100	40	9	7	10	4	10.5
M12	x 1.25	TRB11526TIA	22	100	40	9	7	10	4	10.75
M12	x 1.0	TRB11536TIA	18	100	40	9	7	10	4	11
M14	x 1.5	TRB11556TIA	22	100	40	11	9	12	5	12.5
M14	x 1.25	TRB11566TIA	22	100	40	11	9	12	5	12.75
M14	x 1.0	TRB11576TIA	18	100	40	11	9	12	5	13
M16	x 1.5	TRB11616TIA	22	100	40	12	9	12	5	14.5
M16	x 1.0	TRB11626TIA	18	100	40	12	9	12	5	15
M18	x 1.5	TRB11676TIA	25	110	44	14	11	14	5	16.5
M20	x 1.5	TRB11726TIA	25	125	50	16	12	15	5	18.5
M22	x 1.5	TRB11766TIA	25	125	50	18	14.5	17	5	20.5
M24	x 1.5	TRB11806TIA	27	140	54	18	14.5	17	5	22.5

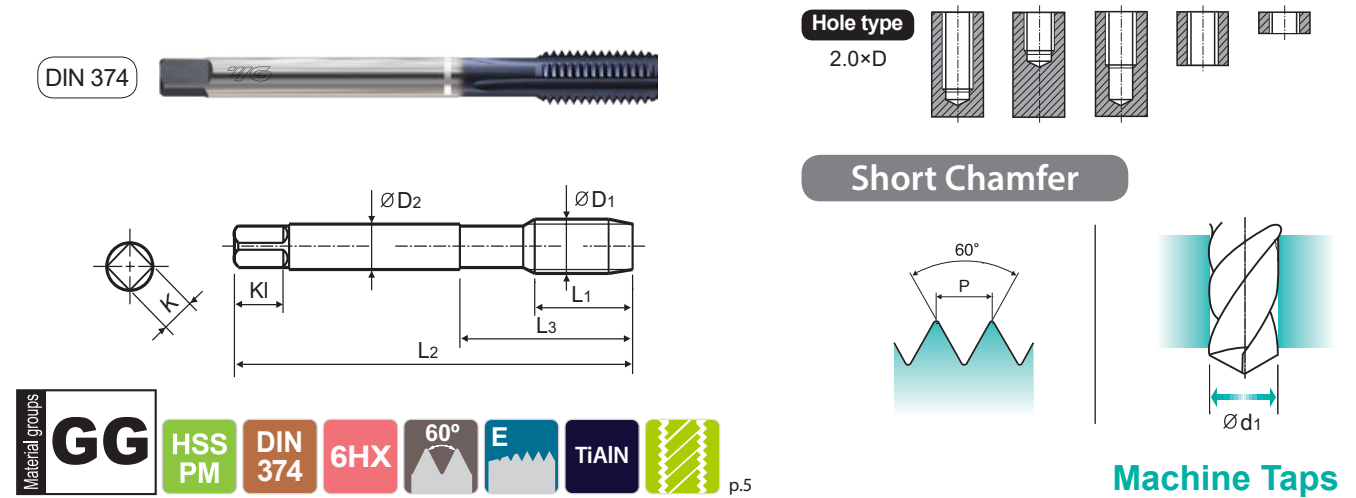
◎ : Excellent ○ : Good																									
ISO	P										M					K									
Material Description	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel					Stainless steel					Grey cast iron		Nodular cast iron		Malleable cast iron
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	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					
HRC											15	30	25	38	34			55	60	42					
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400					
Recommended			◎		◎		◎																		

MF HSS-PM YG TAP CAST IRON ISO Metric Fine Threads - DIN 13

SERIES

TRB07

► HSS-PM versatile solution with advanced geometry, ensuring stable performance in Cast Iron and Cast Aluminum.



Machine Taps

Unit : mm										
SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
$\varnothing D_1$	P	TiAlN	L_1	L_2	L_3	$\varnothing D_2$	K	KI	Z	$\varnothing d_1$
M8	x 1.0	TRB07376TIA	17	90	36	6	4.9	8	4	7
M8	x 0.75	TRB07386TIA	14	80	30	6	4.9	8	4	7.25
M10	x 1.25	TRB07436TIA	22	100	40	7	5.5	8	4	8.75
M10	x 1.0	TRB07446TIA	18	90	36	7	5.5	8	4	9
M12	x 1.5	TRB07516TIA	22	100	40	9	7	10	4	10.5
M12	x 1.25	TRB07526TIA	22	100	40	9	7	10	4	10.75
M12	x 1.0	TRB07536TIA	18	100	40	9	7	10	4	11
M14	x 1.5	TRB07556TIA	22	100	40	11	9	12	5	12.5
M14	x 1.25	TRB07566TIA	22	100	40	11	9	12	5	12.75
M14	x 1.0	TRB07576TIA	18	100	40	11	9	12	5	13
M16	x 1.5	TRB07616TIA	22	100	40	12	9	12	5	14.5
M16	x 1.0	TRB07626TIA	18	100	40	12	9	12	5	15
M18	x 1.5	TRB07676TIA	25	110	44	14	11	14	5	16.5
M20	x 1.5	TRB07726TIA	25	125	50	16	12	15	5	18.5
M22	x 1.5	TRB07766TIA	25	125	50	18	14.5	17	5	20.5
M24	x 1.5	TRB07806TIA	27	140	54	18	14.5	17	5	22.5

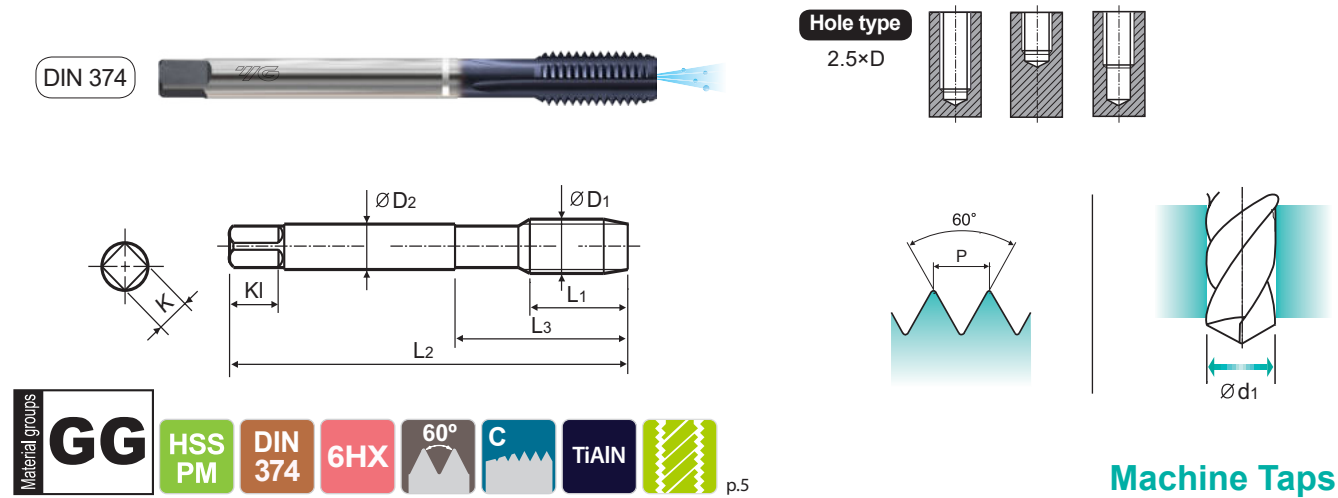
◎ : Excellent ○ : Good																					
ISO	P										M			K							
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron		
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	
HRC		13	25	28	32	10	29	32	38	15	35	23	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	400 Rm	1050 Rm	550	630	400	550
Recommended			◎		◎		◎														

MF HSS-PM YG TAP CAST IRON with Oil Hole ISO Metric Fine Threads - DIN 13

SERIES

TRB20

► HSS-PM versatile solution with advanced geometry, ensuring stable performance in Cast Iron and Cast Aluminum.



Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD ₁	P	TiAlN	L ₁	L ₂	L ₃	ØD ₂	K	KI	Z	Ød ₁
M8	x 1.0	TRB20376TIA	17	90	36	6	4.9	8	4	7
M8	x 0.75	TRB20386TIA	14	80	30	6	4.9	8	4	7.25
M10	x 1.25	TRB20436TIA	22	100	40	7	5.5	8	4	8.75
M10	x 1.0	TRB20446TIA	18	90	36	7	5.5	8	4	9
M12	x 1.5	TRB20516TIA	22	100	40	9	7	10	4	10.5
M12	x 1.25	TRB20526TIA	22	100	40	9	7	10	4	10.75
M12	x 1.0	TRB20536TIA	18	100	40	9	7	10	4	11
M14	x 1.5	TRB20556TIA	22	100	40	11	9	12	5	12.5
M14	x 1.25	TRB20566TIA	22	100	40	11	9	12	5	12.75
M14	x 1.0	TRB20576TIA	18	100	40	11	9	12	5	13
M16	x 1.5	TRB20616TIA	22	100	40	12	9	12	5	14.5
M16	x 1.0	TRB20626TIA	18	100	40	12	9	12	5	15
M18	x 1.5	TRB20676TIA	25	110	44	14	11	14	5	16.5
M20	x 1.5	TRB20726TIA	25	125	50	16	12	15	5	18.5
M22	x 1.5	TRB20766TIA	25	125	50	18	14.5	17	5	20.5
M24	x 1.5	TRB20806TIA	27	140	54	18	14.5	17	5	22.5

◎ : Excellent ○ : Good

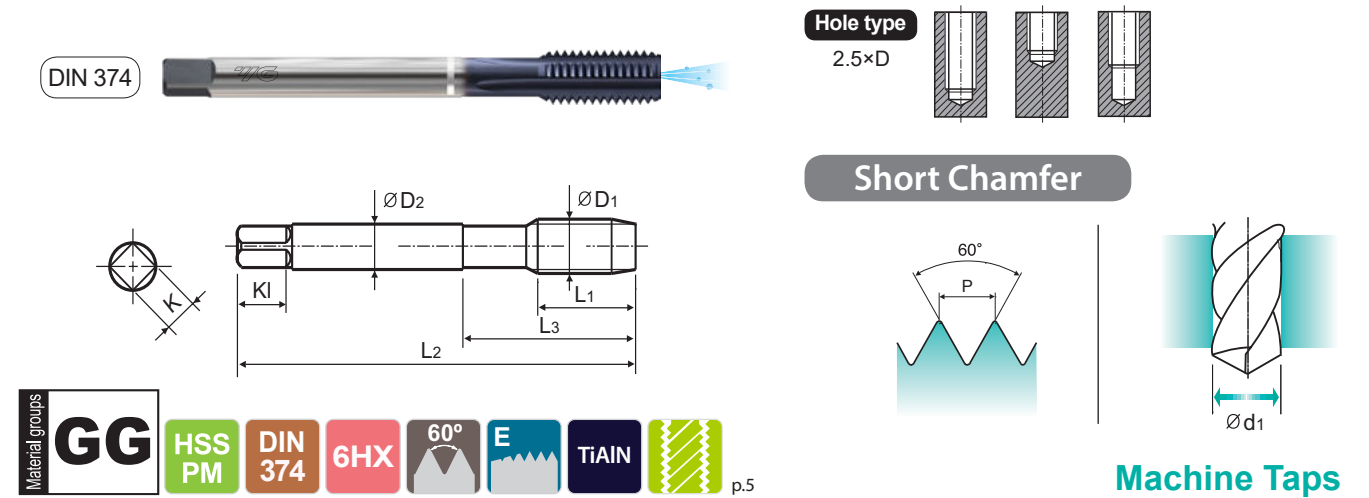
ISO	P										M					K				
Material Description	Non-alloy steel					Low alloy steel					Stainless steel					Grey cast iron				
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRC	13	25	28	32	38	10	29	32	38	15	35	15	23	10	180	260	3	25	130	21
HB	125	190	250	270	300	180	275	300	350	200	325	200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

MF HSS-PM YG TAP CAST IRON with Oil Hole ISO Metric Fine Threads - DIN 13

SERIES

TRB14

► HSS-PM versatile solution with advanced geometry, ensuring stable performance in Cast Iron and Cast Aluminum.



Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD ₁	P	TiAlN	L ₁	L ₂	L ₃	ØD ₂	K	KI	Z	Ød ₁
M8	x 1.0	TRB14376TIA	17	90	36	6	4.9	8	4	7
M8	x 0.75	TRB14386TIA	14	80	30	6	4.9	8	4	7.25
M10	x 1.25	TRB14436TIA	22	100	40	7	5.5	8	4	8.75
M10	x 1.0	TRB14446TIA	18	90	36	7	5.5	8	4	9
M12	x 1.5	TRB14516TIA	22	100	40	9	7	10	4	10.5
M12	x 1.25	TRB14526TIA	22	100	40	9	7	10	4	10.75
M12	x 1.0	TRB14536TIA	18	100	40	9	7	10	4	11
M14	x 1.5	TRB14556TIA	22	100	40	11	9	12	5	12.5
M14	x 1.25	TRB14566TIA	22	100	40	11	9	12	5	12.75
M14	x 1.0	TRB14576TIA	18	100	40	11	9	12	5	13
M16	x 1.5	TRB14616TIA	22	100	40	12	9	12	5	14.5
M16	x 1.0	TRB14626TIA	18	100	40	12	9	12	5	15
M18	x 1.5	TRB14676TIA	25	110	44	14	11	14	5	16.5
M20	x 1.5	TRB14726TIA	25	125	50	16	12	15	5	18.5
M22	x 1.5	TRB14766TIA	25	125	50	18	14.5	17	5	20.5
M24	x 1.5	TRB14806TIA	27	140	54	18	14.5	17	5	22.5

◎ : Excellent ○ : Good

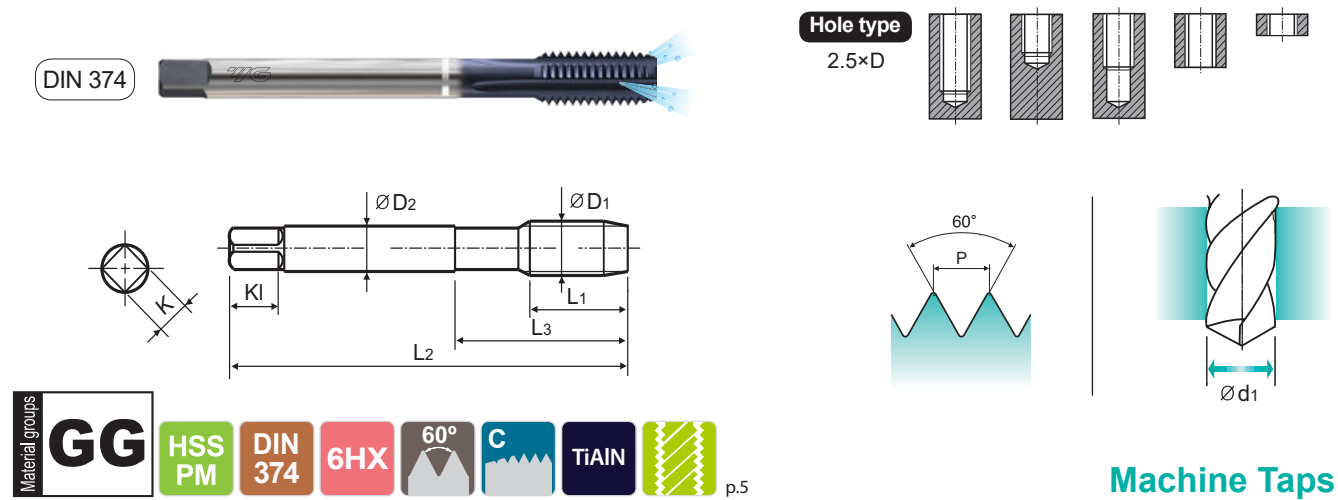
ISO	P										M					K				
Material Description	Non-alloy steel					Low alloy steel					Stainless steel					Grey cast iron				
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRC	13	25	28	32	38	10	29	32	38	15	35	15	23	10	180	260	3	25	130	21
HB	125	190	250	270	300	180	275	300	350	200	325	200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

MF HSS-PM YG TAP CAST IRON with Oil Hole ISO Metric Fine Threads - DIN 13

SERIES

TRB24

► HSS-PM versatile solution with advanced geometry, ensuring stable performance in Cast Iron and Cast Aluminum.



Machine Taps

Unit : mm										
SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD ₁	P	TiAlN	L ₁	L ₂	L ₃	ØD ₂	K	KI	Z	Ød ₁
M8	x 1.0	TRB24376TIAP	17	90	36	6	4.9	8	4	7
M8	x 0.75	TRB24386TIAP	14	80	30	6	4.9	8	4	7.25
M10	x 1.25	TRB24436TIAP	22	100	40	7	5.5	8	4	8.75
M10	x 1.0	TRB24446TIAP	18	90	36	7	5.5	8	4	9
M12	x 1.5	TRB24516TIAP	22	100	40	9	7	10	4	10.5
M12	x 1.25	TRB24526TIAP	22	100	40	9	7	10	4	10.75
M12	x 1.0	TRB24536TIAP	18	100	40	9	7	10	4	11
M14	x 1.5	TRB24556TIAP	22	100	40	11	9	12	5	12.5
M14	x 1.25	TRB24566TIAP	22	100	40	11	9	12	5	12.75
M14	x 1.0	TRB24576TIAP	18	100	40	11	9	12	5	13
M16	x 1.5	TRB24616TIAP	22	100	40	12	9	12	5	14.5
M16	x 1.0	TRB24626TIAP	18	100	40	12	9	12	5	15
M18	x 1.5	TRB24676TIAP	25	110	44	14	11	14	5	16.5
M20	x 1.5	TRB24726TIAP	25	125	50	16	12	15	5	18.5
M22	x 1.5	TRB24766TIAP	25	125	50	18	14.5	17	5	20.5
M24	x 1.5	TRB24806TIAP	27	140	54	18	14.5	17	5	22.5

◎ : Excellent ○ : Good

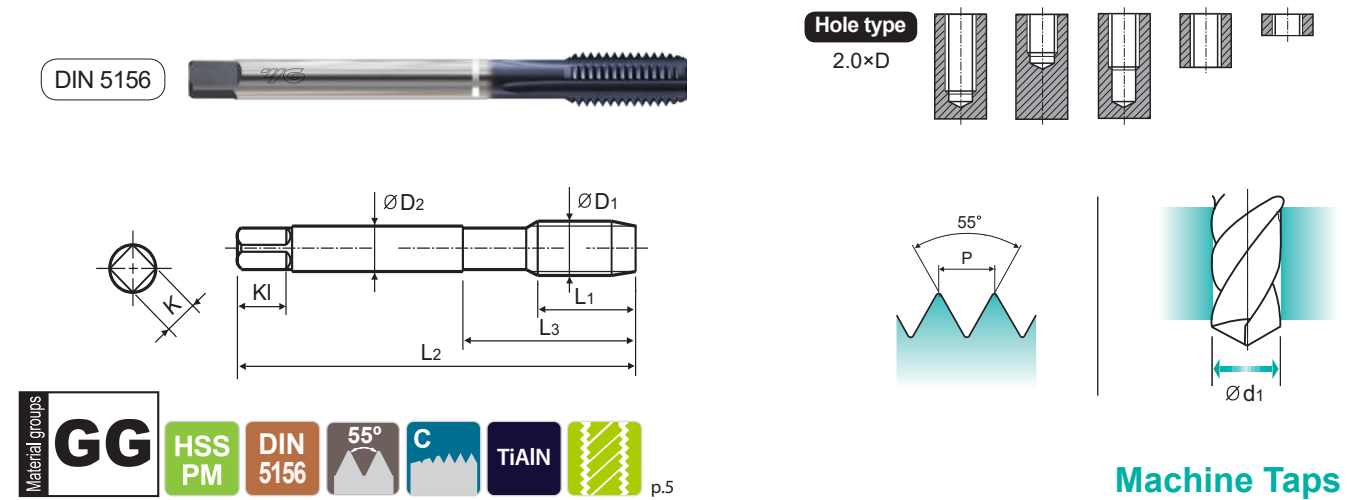
ISO	P										M					K					
Material Description	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	
HRC		13	25	28	32	10	29	32	38	15	35	15	23	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	400 Rm	1050 Rm	550	630	400	550
Recommended			◎		◎		◎														

G(BSP) HSS-PM YG TAP CAST IRON Whitworth Pipe Threads DIN ISO 228/1

SERIES

TRB12

► HSS-PM versatile solution with advanced geometry, ensuring stable performance in Cast Iron and Cast Aluminum.



Machine Taps

Unit : mm										
SIZE	TPI	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD ₁		TiAlN	L ₁	L ₂	L ₃	ØD ₂	K	KI	Z	Ød ₁
G1/16 - 28		TRB12020TIA	20	90	36	6	4.9	8	4	6.8
G1/8 - 28		TRB12200TIA	20	90	36	7	5.5	8	4	8.8
G1/4 - 19		TRB12400TIA	22	100	48	11	9	12	5	11.8
G3/8 - 19		TRB12480TIA	22	100	52	12	9	12	5	15.25
G1/2 - 14		TRB12560TIA	25	125	70	16	12	15	5	19
G3/4 - 14		TRB12700TIA	28	140	82	20	16	19	5	24.5

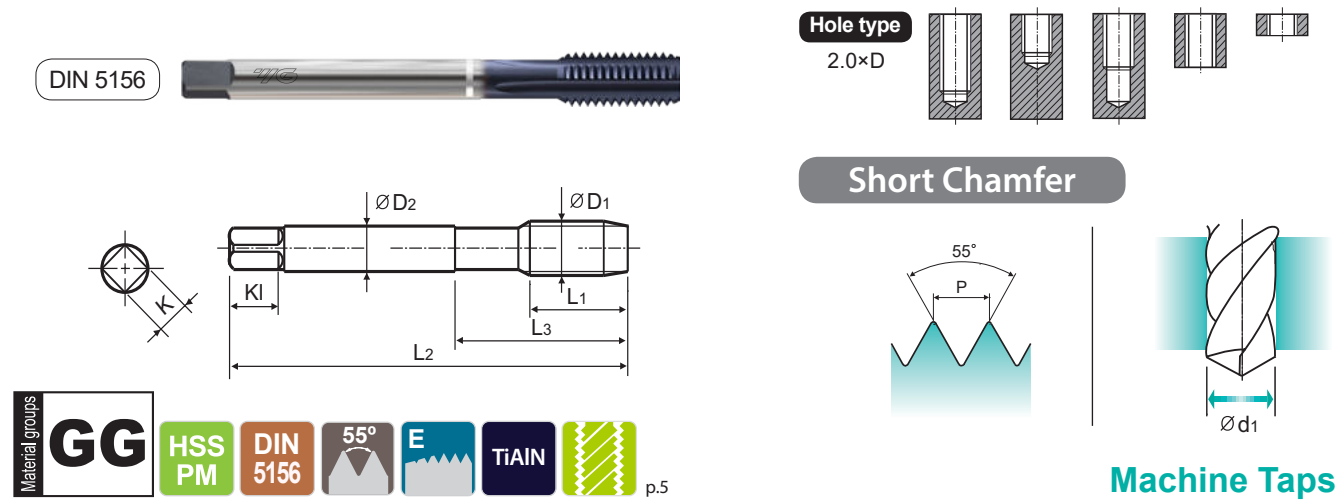
◎ : Excellent ○ : Good																					
ISO	P										M				K						
Material Description	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	
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	400 Rm	1050 Rm	550	630	400	550
Recommended			◎		◎		◎														

G(BSP) HSS-PM YG TAP CAST IRON Whitworth Pipe Threads DIN ISO 228/1

SERIES

TRB08

► HSS-PM versatile solution with advanced geometry, ensuring stable performance in Cast Iron and Cast Aluminum.



Machine Taps

Unit : mm										
SIZE	TPI	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
$\varnothing D_1$		TiAlN	L_1	L_2	L_3	$\varnothing D_2$	K	KI	Z	$\varnothing d_1$
G1/16 - 28		TRB08020TIA	20	90	36	6	4.9	8	4	6.8
G1/8 - 28		TRB08200TIA	20	90	36	7	5.5	8	4	8.8
G1/4 - 19		TRB08400TIA	22	100	48	11	9	12	5	11.8
G3/8 - 19		TRB08480TIA	22	100	52	12	9	12	5	15.25
G1/2 - 14		TRB08560TIA	25	125	70	16	12	15	5	19
G3/4 - 14		TRB08700TIA	28	140	82	20	16	19	5	24.5

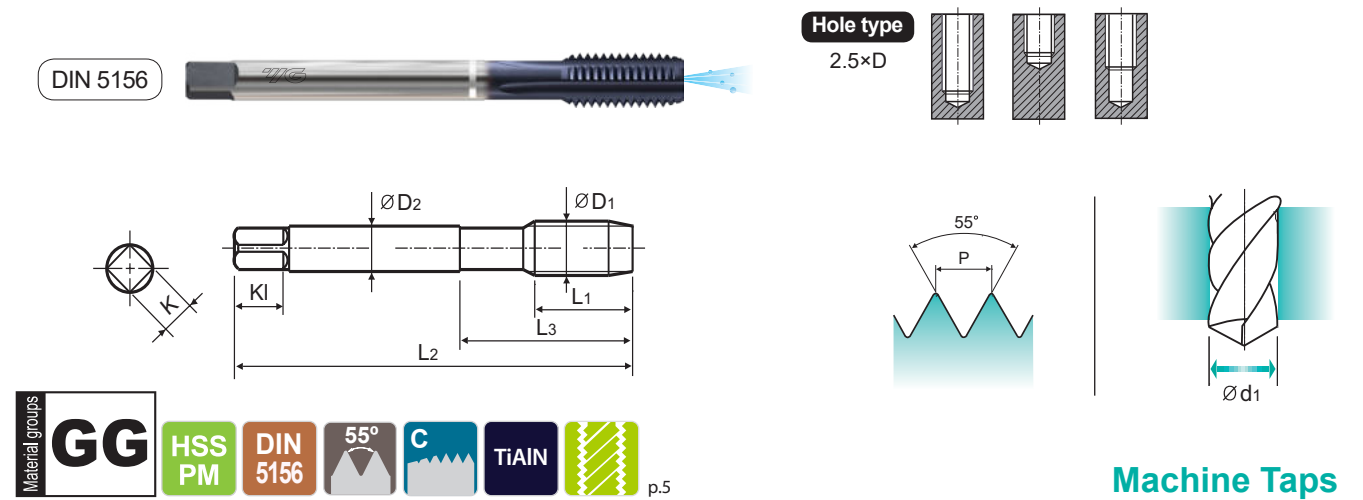
◎ : Excellent ○ : Good																						
ISO	P										M					K						
Material Description	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron		
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	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	400 Rm	1050 Rm	550	630	400	550	
Recommended			◎		◎		◎															

G(BSP) HSS-PM YG TAP CAST IRON with Oil Hole Whitworth Pipe Threads DIN ISO 228/1

SERIES

TRB22

► HSS-PM versatile solution with advanced geometry, ensuring stable performance in Cast Iron and Cast Aluminum.



Machine Taps

Unit : mm										
SIZE	TPI	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
$\varnothing D_1$		TiAlN	L_1	L_2	L_3	$\varnothing D_2$	K	KI	Z	$\varnothing d_1$
G1/16 - 28		TRB22020TIA	20	90	36	6	4.9	8	4	6.8
G1/8 - 28		TRB22200TIA	20	90	36	7	5.5	8	4	8.8
G1/4 - 19		TRB22400TIA	22	100	48	11	9	12	5	11.8
G3/8 - 19		TRB22480TIA	22	100	52	12	9	12	5	15.25
G1/2 - 14		TRB22560TIA	25	125	70	16	12	15	5	19

◎ : Excellent ○ : Good

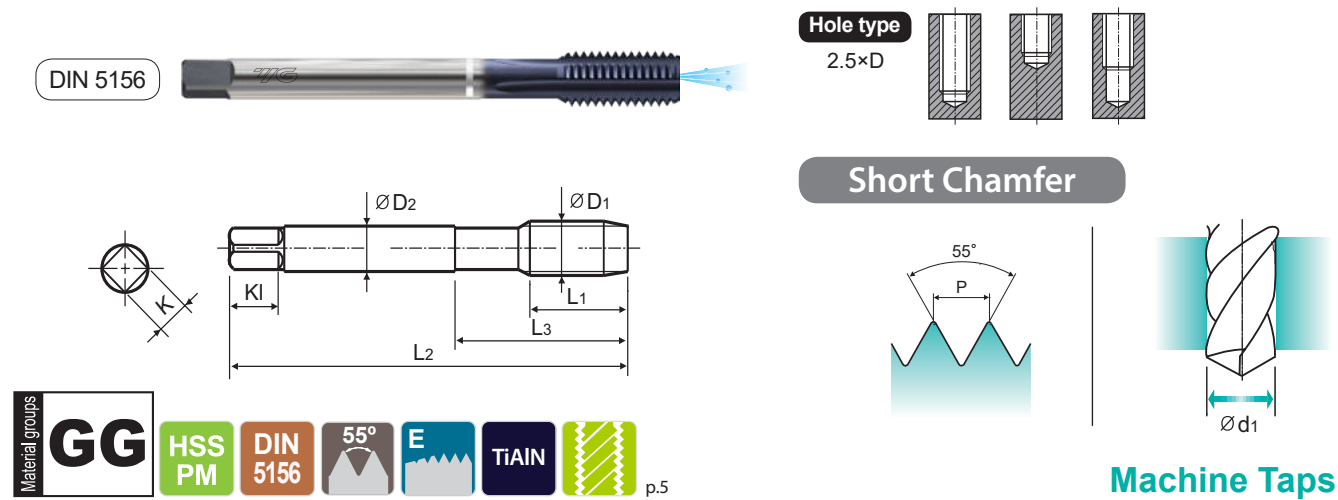
ISO	P										M					K					
Material Description	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	
HRC		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21	
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180			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	400 Rm	1050 Rm	550	630	400	550
Recommended			◎		◎		◎														

G(BSP) HSS-PM YG TAP CAST IRON with Oil Hole Whitworth Pipe Threads DIN ISO 228/1

SERIES

TRB18

► HSS-PM versatile solution with advanced geometry, ensuring stable performance in Cast Iron and Cast Aluminum.



SIZE	TPI	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
$\varnothing D_1$		TiAlN	L_1	L_2	L_3	$\varnothing D_2$	K	KI	Z	$\varnothing d_1$
G1/16 - 28		TRB18020TIA	20	90	36	6	4.9	8	4	6.8
G1/8 - 28		TRB18200TIA	20	90	36	7	5.5	8	4	8.8
G1/4 - 19		TRB18400TIA	22	100	48	11	9	12	5	11.8
G3/8 - 19		TRB18480TIA	22	100	52	12	9	12	5	15.25
G1/2 - 14		TRB18560TIA	25	125	70	16	12	15	5	19

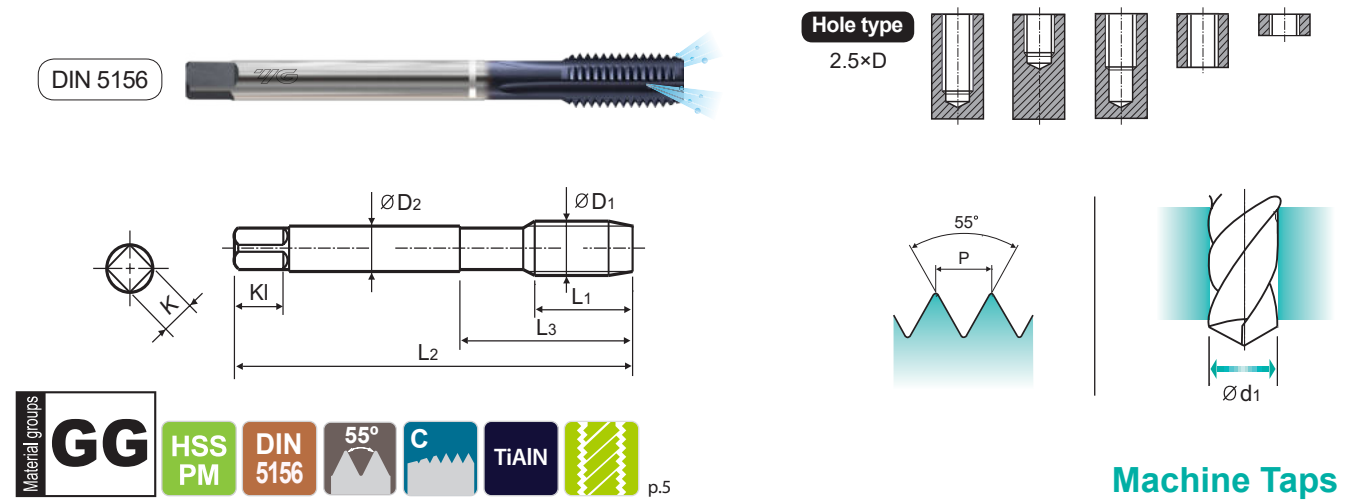
ISO	P										M					K				
	Non-alloy steel					Low alloy steel					Stainless steel					Grey cast iron				
Material Description	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRC	13	25	28	32	38	10	29	32	38	15	35	15	23	10	10	26	3	25	21	
HB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

G(BSP) HSS-PM YG TAP CAST IRON with Oil Hole Whitworth Pipe Threads DIN ISO 228/1

SERIES

TRB25

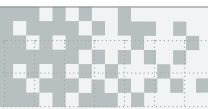
► HSS-PM versatile solution with advanced geometry, ensuring stable performance in Cast Iron and Cast Aluminum.



SIZE	TPI	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
$\varnothing D_1$		TiAlN	L_1	L_2	L_3	$\varnothing D_2$	K	KI	Z	$\varnothing d_1$
G1/16 - 28		TRB25020TIAP	20	90	36	6	4.9	8	4	6.8
G1/8 - 28		TRB25200TIAP	20	90	36	7	5.5	8	4	8.8
G1/4 - 19		TRB25400TIAP	22	100	48	11	9	12	5	11.8
G3/8 - 19		TRB25480TIAP	22	100	52	12	9	12	5	15.25
G1/2 - 14		TRB25560TIAP	25	125	70	16	12	15	5	19

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

MEMO



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