



Vap **TB854** SERIES
Bright **TC854** SERIES
TiN **TD854** SERIES

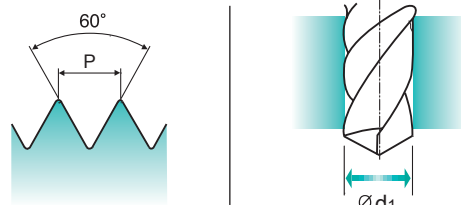
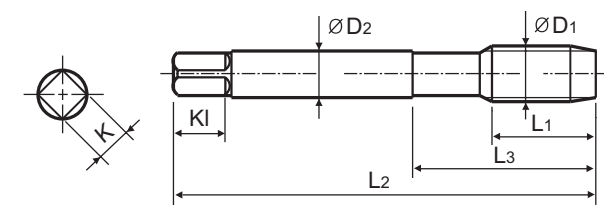
MF ISO Metric fine threads DIN 13

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

Machine taps
Maschinengewindebohrer

► For using multi-purpose and correct thread profiles & long tool life due to special tap geometry. YG-1 company has a patent.

► Für vielfältigen Einsatz, genaue Gewindeprofile und lange Standzeit dank einer besonderen Schneidengeometrie. Von YG-1 patentiert.



Material groups: **MU** HSS-E DIN 374 6H 60° B Vap Bright TiN p.B125

Plain Shank Page
TAPPING ER CHUCK D215-220
TAPPING CHUCK D221-228
ONE STEP TAPPING CHUCK D211-213

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	Bright	TiN	L1	L2	L3	ØD2	K	KI	Z	Ød1
M20 x 1.5		TB854726	TC854726	TD854726	25	125	50	16	12	15	4	18.5
M20 x 1.0		TB854736	TC854736	TD854736	20	125	50	16	12	15	4	19
M22 x 1.5		TB854766	TC854766	TD854766	25	125	50	18	14.5	17	4	20.5
M22 x 1.0		TB854776	TC854776	TD854776	20	125	50	18	14.5	17	4	21
M24 x 2.0		TB854796	TC854796	TD854796	27	140	54	18	14.5	17	4	22
M24 x 1.5		TB854806	TC854806	TD854806	27	140	54	18	14.5	17	4	22.5
M26 x 1.5		TB854856	TC854856	TD854856	28	140	54	18	14.5	17	4	24.5
M27 x 2.0		TB854876	TC854876	TD854876	28	140	54	20	16	19	4	25
M27 x 1.5		TB854886	TC854886	TD854886	28	140	54	20	16	19	4	25.5
M28 x 1.5		TB854916	TC854916	TD854916	28	140	54	20	16	19	4	26.5
M30 x 2.0		TB854966	TC854966	TD854966	30	150	57	22	18	21	4	28
M30 x 1.5		TB854976	TC854976	TD854976	30	150	57	22	18	21	4	28.5
M32 x 2.0		-	TC854A16	TD854A16	30	150	57	22	18	21	4	30.0
M32 x 1.5		-	TC854A26	TD854A26	30	150	57	22	18	21	4	30.5
M33 x 2.0		-	TC854A66	TD854A66	33	160	60	25	20	23	4	31.0
M33 x 1.5		-	TC854A76	TD854A76	32	160	60	25	20	23	4	31.5
M34 x 1.5		-	TC854A96	TD854A96	33	170	70	28	22	25	4	32.5
M35 x 1.5		-	TC854B16	TD854B16	33	170	70	28	22	25	4	33.5
M36 x 3.0		-	TC854B46	TD854B46	45	200	80	28	22	25	4	33.0
M36 x 2.0		-	TC854B56	TD854B56	33	170	70	28	22	25	4	34.0
M36 x 1.5		-	TC854B66	TD854B66	33	170	70	28	22	25	4	34.5
M38 x 1.5		-	TC854B86	TD854B86	33	170	70	28	22	25	4	36.5

* The other coating(TiCN or TiAlN) is available on your request.

► NEXT PAGE

◎ : Excellent ○ : Good

ISO	P										M				K					
	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	35	38	40	42	45	48	50	52	55	58	60	62	65	68	70	72
HB	125	190	250	270	300	180	275	300	350	200	240	180	260	300	160	250	130	250	130	230
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

ISO	N										S				H						
	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	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎



Vap **TB854** SERIES
Bright **TC854** SERIES
TiN **TD854** SERIES

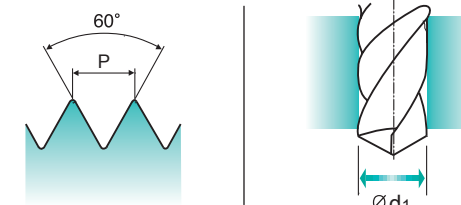
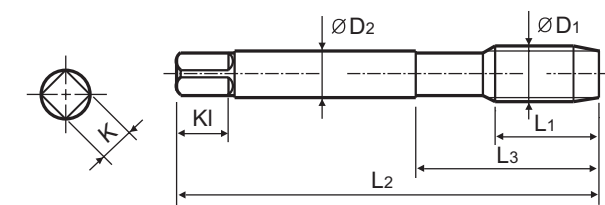
MF ISO Metric fine threads DIN 13

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

Machine taps
Maschinengewindebohrer

► For using multi-purpose and correct thread profiles & long tool life due to special tap geometry. YG-1 company has a patent.

► Für vielfältigen Einsatz, genaue Gewindeprofile und lange Standzeit dank einer besonderen Schneidengeometrie. Von YG-1 patentiert.



Material groups: **MU** HSS-E DIN 374 6H 60° B Vap Bright TiN p.B125

Plain Shank Page
TAPPING ER CHUCK D215-220
TAPPING CHUCK D221-228
ONE STEP TAPPING CHUCK D211-213

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	Bright	TiN	L1	L2	L3	ØD2	K	KI	Z	Ød1
M39 x 1.5		-	TC854C36	TD854C36	33	170	70	32	24	27	4	37.5
M40 x 1.5		-	TC854C66	TD854C66	33	170	70	32	24	27	4	38.5
M42 x 3.0		-	TC854D06	TD854D06	45	200	80	32	24	27	4	39.0
M42 x 2.0		-	TC854D16	TD854D16	33	170	70	32	24	27	4	40.0
M42 x 1.5		-	TC854D26	TD854D26	33	170	70	32	24	27	4	40.5
M45 x 1.5		-	TC854D96	TD854D96	33	180	80	36	29	32	4	43.5
M48 x 3.0		-	TC854E56	TD854E56	45	225	90	36	29	32	4	45.0
M48 x 2.0		-	TC854E66	TD854E66	36	190	80	36	29	32	4	46.0
M48 x 1.5		-	TC854E76	TD854E76	36	190	80	36	29	32	4	46.5
M50 x 1.5		-	TC854F16	TD854F16	36	190	80	36	29	32	4	48.5
M52 x 3.0		-	TC854F56	TD854F56	45	225	90	40	32	35	4	49.0
M52 x 2.0		-	TC854F66	TD854F66	36	190	80	40	32	35	4	50.0
M52 x 1.5		-	TC854F76	TD854F76	36	190	80	40	32	35	4	50.5

* The other coating(TiCN or TiAlN) is available on your request.

◎ : Excellent ○ : Good

ISO	P										M				K					
	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	35	38	40	42	45	48	50	52	55	58	60	62	65	68	70	72
HB	125	190	250	270	300	180	275	300	350	200	240	180	260	300	160	250	130	250	130	230
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

ISO	N										S				H						
	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	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎