YG TAP CAST IRON

TE403 SERIES

MF — ISO metric fine threads DIN 13

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

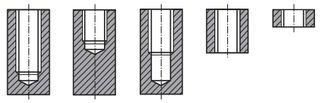
Machine taps
Maschinengewindebohrer

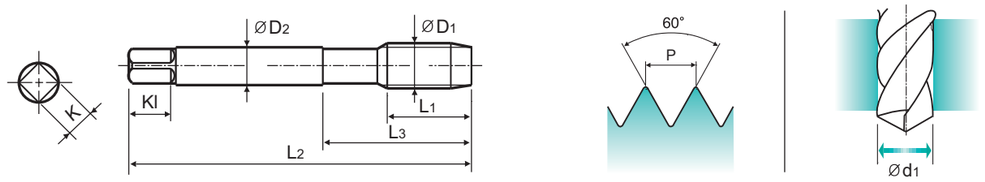
▶ Suitable for tapping cast iron or similar work materials due to nitriding.

▶ Geeignet zum Gewindeschneiden von Guss oder ähnlichen Werkstoffen dank der Nitrierung

DIN 374

Hole type
2.0×D





Material groups: GG | HSS-E | DIN 374 | 6HX | 60° | C | Nitride

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Recommended Toolholder

	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	Ni	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M4	× 0.5	**TE403256**	10	63	21	2.8	2.1	5	3	3.5
M5	× 0.5	**TE403296**	11	70	25	3.5	2.7	6	4	4.5
M6	× 0.75	**TE403326**	13	80	30	4.5	3.4	6	4	5.2
M6	× 0.5	**TE403336**	13	80	30	4.5	3.4	6	4	5.5
M7	× 0.75	**TE403356**	14	80	30	5.5	4.3	7	4	6.2
M8	× 1	**TE403376**	17	90	36	6	4.9	8	4	7
M8	× 0.75	**TE403386**	14	80	30	6	4.9	8	4	7.2
M10	× 1.25	**TE403436**	22	100	40	7	5.5	8	4	8.8
M10	× 1	**TE403446**	18	90	36	7	5.5	8	4	9
M10	× 0.75	**TE403456**	18	90	36	7	5.5	8	4	9.2
M12	× 1.5	**TE403516**	22	100	40	9	7	10	4	10.5
M12	× 1.25	**TE403526**	22	100	40	9	7	10	4	10.8
M12	× 1	**TE403536**	18	100	40	9	7	10	4	11
M14	× 1.5	**TE403556**	22	100	40	11	9	12	4	12.5
M14	× 1.25	**TE403566**	22	100	40	11	9	12	4	12.8
M16	× 1.5	**TE403616**	22	100	40	12	9	12	4	14.5
M18	× 1.5	**TE403676**	25	110	44	14	11	14	4	16.5
M20	× 1.5	**TE403726**	25	125	50	16	12	15	4	18.5
M22	× 1.5	**TE403766**	25	125	50	18	14.5	17	4	20.5
M24	× 1.5	**TE403806**	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	400 Rm	1050 Rm	550	630	400	550
Recommended							○														

YG TAP CAST IRON

TE434 SERIES

UNC — Unified coarse threads

- Unified Grobgewinde
- UNC
- Unificato passo grosso

Machine taps
Maschinengewindebohrer

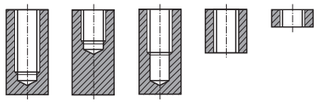
▶ Suitable for tapping cast iron or similar work materials due to nitriding.

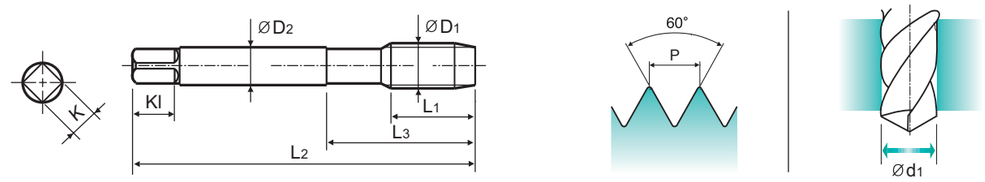
▶ Geeignet zum Gewindeschneiden von Guss oder ähnlichen Werkstoffen dank der Nitrierung

DIN 371

DIN 376

Hole type
2.0×D





Material groups: GG | HSS-E | DIN 371/376 | 2BX | 60° | C | Nitride

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Recommended Toolholder

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

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		Ni	L1	L2	L3	ØD2	K	Kl	Z	Ød1
#4	- 40UNC	**TE434162**	11	56	18	3.5	2.7	6	3	2.3
#5	- 40UNC	**TE434202**	11	56	18	3.5	2.7	6	3	2.6
#6	- 32UNC	**TE434242**	12	56	20	4	3	6	3	2.85
#8	- 32UNC	**TE434282**	13	63	21	4.5	3.4	6	3	3.5
#10	- 24UNC	**TE434322**	15	70	25	6	4.9	8	3	3.9
#12	- 24UNC	**TE434362**	16	80	30	6	4.9	8	3	4.5
1/4	- 20UNC	**TE434402**	17	80	30	7	5.5	8	4	5.2
5/16	- 18UNC	**TE434442**	20	90	35	8	6.2	9	4	6.6
3/8	- 16UNC	**TE434482**	22	100	39	9	7	10	4	8
7/16	- 14UNC	**TE434522**	22	100	40	8	6.2	9	4	9.4
1/2	- 13UNC	**TE434562**	25	110	44	9	7	10	4	10.75
9/16	- 12UNC	**TE434602**	26	110	44	11	9	12	4	12.25
5/8	- 11UNC	**TE434642**	27	110	44	12	9	12	4	13.5
3/4	- 10UNC	**TE434702**	30	125	50	14	11	14	4	16.5
7/8	- 9UNC	**TE434742**	32	140	54	18	14.5	17	4	19.5
1	- 8UNC	**TE434782**	36	160	60	20	16	17	4	22.25
1-1/8	- 7UNC	**TE434822**	40	180	70	22	18	21	4	25

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

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			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							○														