

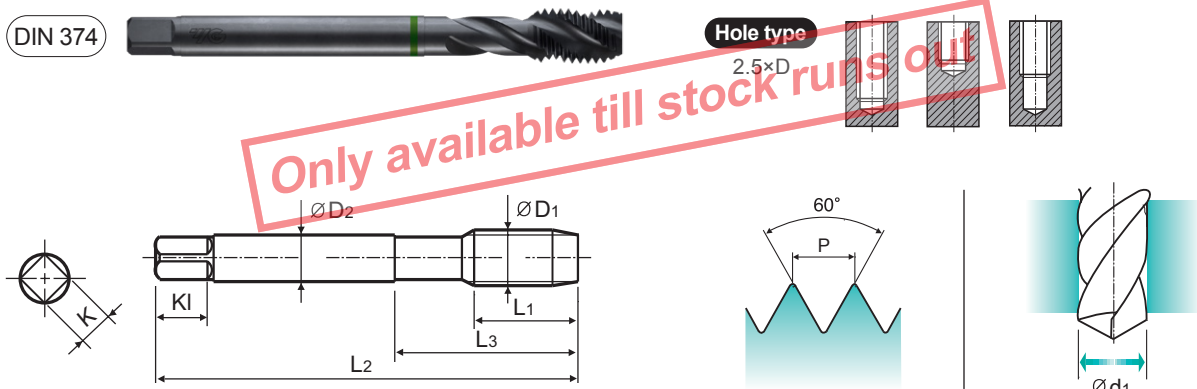
MF ISO Metric fine threads DIN 13

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

Machine taps
Maschinengewindebohrer

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

► Für rostfreie stähle, genaue Gewindeprofile und lange Standzeitendank einer besonderen Schneidengeometrie. Von YG-1 patentiert.



Material groups: **VA** HSS-E DIN 374 6H 60° C R45 Vap p.B125

Recommended ToolHolder: Plain Shank 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	L1	L2	L3	ØD2	K	K1	Z	Ød1
▲ M14 × 1.5		TB754556	15	100	40	11	9	12	3	12.5
▲ M14 × 1.25		TB754566	15	100	40	11	9	12	3	12.8
▲ M14 × 1		TB754576	11	100	40	11	9	12	3	13
▲ M16 × 1.5		TB754616	15	100	40	12	9	12	3	14.5
▲ M16 × 1		TB754626	12	100	40	12	9	12	3	15
▲ M18 × 1.5		TB754676	17	110	44	14	11	14	4	16.5
▲ M18 × 1		TB754686	13	110	44	14	11	14	4	17
▲ M20 × 1.5		TB754726	17	125	50	16	12	15	4	18.5
▲ M20 × 1		TB754736	14	125	50	16	12	15	4	19
▲ M22 × 1.5		TB754766	17	125	50	18	14.5	17	4	20.5
▲ M22 × 1		TB754776	14	125	50	18	14.5	17	4	21
▲ M24 × 2		TB754796	20	140	54	18	14.5	17	4	22
▲ M24 × 1.5		TB754806	20	140	54	18	14.5	17	4	22.5
▲ M26 × 1.5		TB754856	20	140	54	18	14.5	17	4	24.5
▲ M27 × 2		TB754876	20	140	54	20	16	19	4	25
▲ M27 × 1.5		TB754886	20	140	54	20	16	19	4	25.5
▲ M28 × 1.5		TB754916	20	140	54	20	16	19	4	26.5
▲ M30 × 2		TB754966	22	150	57	22	18	21	4	28
▲ M30 × 1.5		TB754976	22	150	57	22	18	21	4	28.5

* Coating(TiN, TiCN or TiAlN) is available on your request.

▲ : Only available till stock runs out

© : Excellent ○ : Good

ISO Material Description	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	30	10	29	32	38	15	35	15	23	10	10	26	3	25	21	21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

ISO Material Description	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	15	30	25	38	34	15	30	25	38	34	15	30	25	38	34	55	60	42	55	55	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

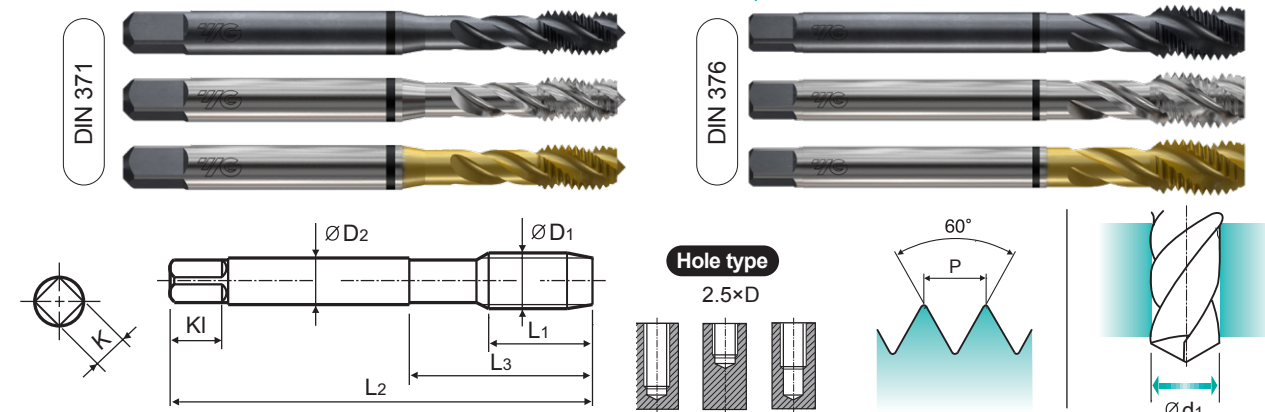
UNC Unified coarse threads

- Unified Grobgewinde
- UNC
- Unificato passo fine

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 Standzeitendank einer besonderen Schneidengeometrie. Von YG-1 patentiert.



Material groups: **MU** HSS-E DIN 371/376 2B 60° C R40 Vap Bright TiN p.B124

Recommended ToolHolder: Plain Shank 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		Vap	Bright	TiN	L1	L2	L3	ØD2	K	K1	Z	Ød1
#4 - 40 UNC		TB824162	TC824162	TD824162	6	56	18	3.5	2.7	6	3	2.3
#5 - 40 UNC		TB824202	TC824202	TD824202	7	56	18	3.5	2.7	6	3	2.6
#6 - 32 UNC		TB824242	TC824242	TD824242	7	56	20	4	3	6	3	2.85
#8 - 32 UNC		TB824282	TC824282	TD824282	8	63	21	4.5	3.4	6	3	3.5
#10 - 24 UNC		TB824322	TC824322	TD824322	10	70	25	6	4.9	8	3	3.9
#12 - 24 UNC		TB824362	TC824362	TD824362	10	80	30	6	4.9	8	3	4.5
1/4 - 20 UNC		TB824402	TC824402	TD824402	13	80	30	7	5.5	8	3	5.2
5/16 - 18 UNC		TB824442	TC824442	TD824442	14	90	35	8	6.2	9	3	6.6
3/8 - 16 UNC		TB824482	TC824482	TD824482	16	100	39	9	7	10	3	8
7/16 - 14 UNC		TB824522	TC824522	TD824522	17	100	40	8	6.2	9	3	9.4
1/2 - 13 UNC		TB824562	TC824562	TD824562	20	110	44	9	7	10	3	10.75
9/16 - 12 UNC		TB824602	TC824602	TD824602	20	110	44	11	9	12	3	12.25
5/8 - 11 UNC		TB824642	TC824642	TD824642	22	110	44	12	9	12	3	13.5
3/4 - 10 UNC		TB824702	TC824702	TD824702	25	125	50	14	11	14	4	16.5
7/8 - 9 UNC		TB824742	TC824742	TD824742	27	140	54	18	14.5	17	4	19.5
1 - 8 UNC		TB824782	TC824782	TD824782	30	160	60	20	16	19	4	22.25

► DIN 371(#4~3/8) and DIN 376(7/16~1)

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

© : Excellent ○ : Good

ISO Material Description	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		
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HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

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