Leading Through Innovation

HSS & HSS-E

YG TAP GENERAL

YG Gewindebohrer Universal

- **Suitable for Tapping Blind / Through Holes due to Flute Geometry and Excellent Chip Evacuation**
- **Geeignet für das Gewindeschneiden von Grund- und Durchgangsbohrungen aufgrund der Nutengeometrie und der hervorragenden Spanabfuhr**

SELECTION GUIDE

THREADING TOOLS

HSS & HSS-E YG TAP GENERAL

Suitable for Tapping Blind / Through Holes
due to Flute Geometry and Excellent Chip Evacuation

Please visit globalyg1.com/mat for material search

◎ : Excellent ○ : Good

Recommended cutting conditions : p.B309

HOLE TYPE						Max. 2.5xD Blind Hole			Max. 3.0xD Through Hole						Max. 2.0xD Blind/Through Hole								
TOOL MATERIAL						HSS-E			HSS-E														
CHAMFER LEAD ACC. TO DIN2197						C	C	C	B	B	B	B	C	C									
FLUTE TYPE						Spiral Flute	Spiral Flute	Spiral Flute	Spiral Point	Spiral Point	Spiral Point	Spiral Point	Spiral Flute	Straight Flute									
SPIRAL FLUTE ANGLE						R40	R40	R20	-	-	-	-	L20	-									
SERIES	M	DIN371/376				TC711 (p.B272)	TD711 (p.B273)	TC517 (p.B281)	TC127 (p.B283)	TD127 (p.B284)	TC227 (p.B293)	TD227 (p.B294)	TC211 (p.B295)	TC463 (p.B296)									M
		DIN352						TC612 (p.B282)	TC122 (p.B285)														
		DIN357/LONG																					
	MF	DIN374				TC411 (p.B274)	TD411 (p.B276)		TC222 (p.B286)	TD222 (p.B288)				TC473 (p.B297)									MF
		DIN2181																					
	UNC	DIN371/376				TC144 (p.B278)			TC214 (p.B290)					TC424 (p.B298)									UNC
		DIN351																					
	UNF	DIN371/374				TC124 (p.B279)			TC234 (p.B291)														UNF
		DIN2181																					
	BSW	DIN2182/2183				TC134 (p.B280)			TC224 (p.B292)														BSW
		DIN351																					
	G(BSP)	DIN5156/5157																					G(BSP)
	EG-M	DIN371/376																					EG-M
	EG-UNC	DIN371/376																					EG-UNC
	EG-UNF	DIN371/374																					EG-UNF
SURFACE TREATMENT						Bright	TiN	Bright	Bright	TiN	Bright	TiN	Bright	Bright									
MODEL																							
ISO	VDI 3323	Material Description	Composition / Structure / Heat Treatment		HB	HRc																	
P	1	Non-alloy steel	About 0.15% C	Annealed	125		○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	1
	2		About 0.45% C	Annealed	190	13	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	2
	3		About 0.45% C	Quenched & Tempered	250	25	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	3
	4		About 0.75% C	Annealed	270	28	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	4
	5		About 0.75% C	Quenched & Tempered	300	32	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	5
	6	Low alloy steel		Annealed	180	10	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	6
	7			Quenched & Tempered	275	29	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	7
	8			Quenched & Tempered	300	32	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	8
	9			Quenched & Tempered	350	38																	9
	10	High alloyed steel, and tool steel		Annealed	200	15																	10
	11			Quenched & Tempered	325	35																	11
M	12	Stainless steel	Ferritic / Martensitic	Annealed	200	15	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	12
	13		Martensitic	Quenched & Tempered	240	23	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	13
	14		Austenitic		180	10																	14
K	15	Grey cast iron	Pearlitic / ferritic		180	10															○		15
	16		Pearlitic (Martensitic)		260	26															○		16
	17	Nodular cast iron	Ferritic		160	3	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○		17
	18		Pearlitic		250	25	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○		18
	19	Malleable cast iron	Ferritic		130																		19
	20		Pearlitic		230	21																	20
N	21	Aluminum-wrought alloy	Not Curable		60		○	○	○	○	○	○	○	○	○								21
	22		Curable	Hardened	100																		22
	23	Aluminum-cast, alloyed	≤ 12% Si, Not Curable		75		○	○	○	○	○	○	○	○	○								23
	24		≤ 12% Si, Curable	Hardened	90		○	○	○	○	○	○	○	○	○								24
	25		> 12% Si, Not Curable		130		◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○		25
	26	Copper and Copper Alloys (Bronze / Brass)	Cutting Alloys, PB>1%		110		○	○	○	○	○	○	○	○	○	○	○	○	○	○	○		26
	27		CuZn, CuSnZn (Brass)		90																○		27
	28		CuSn, lead-free copper and electrolytic copper		100		◎	◎	◎	◎	◎	◎	◎	◎	◎								28
	29	Non Metallic Materials	Duroplastic, Fiber Reinforced Plastic																				29
	30		Rubber, Wood, etc.																				30
S	31	Heat Resistant Super Alloys	Fe Based	Annealed	200	15																	31
	32			Cured	280	30																	32
	33		Ni or Co Based	Annealed	250	25																	33
	34			Cured	350	38																	34
	35			Cast	320	34																	35
	36	Titanium Alloys	Pure Titanium		400 Rm																		36
	37		Alpha + Beta Alloys	Hardened	1050 Rm																		37
H	38	Hardened steel		Hardened	550	55																	38
	39			Hardened	630	60																	39
	40	Chilled Cast Iron		Cast	400	42																	40
	41	Hardened Cast Iron		Hardened	550	55																	41

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
TECHNICAL DATA

SELECTION GUIDE

THREADING TOOLS

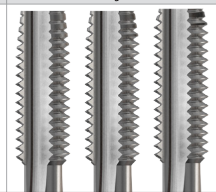
HSS & HSS-E
YG TAP GENERAL

Suitable for Tapping Blind / Through Holes
due to Flute Geometry and Excellent Chip Evacuation

Please visit globalyg1.com/mat for material search

◎ : Excellent ○ : Good

Recommended cutting conditions : p.B309

HOLE TYPE		Max. 2.0xD Blind/Through Hole							
TOOL MATERIAL		HSS						HSS-E	
CHAMFER LEAD ACC. TO DIN2197		I / II / III	I / III	I / II / III	I / III	I / II / III	I / II / III	I / II / III	I / II / III
FLUTE TYPE		Straight Flute	Straight Flute	Straight Flute	Straight Flute	Straight Flute	Straight Flute	Straight Flute	Straight Flute
SPIRAL FLUTE ANGLE		-	-	-	-	-	Left Hand Cut	-	-
M	DIN371/376								
M	DIN352	T7109 (p.B299)					T7343 (p.B306)	TB373 (p.B307)	TC353 (p.B308)
M	DIN357/LONG								
MF	DIN374								
MF	DIN2181		T7309 (p.B301)						
UNC	DIN371/376								
UNC	DIN351			T7363 (p.B303)					
UNF	DIN371/374								
UNF	DIN2181				T7509 (p.B304)				
BSW	DIN2182/2183								
BSW	DIN351					T7609 (p.B305)			
G(BSP)	DIN5156/5157								
EG-M	DIN371/376								
EG-UNC	DIN371/376								
EG-UNF	DIN371/374								
SURFACE TREATMENT		Bright	Bright	Bright	Bright	Bright	Bright	VAP	Bright
MODEL									

ISO	VDI 3323	Material Description	Composition / Structure / Heat Treatment		HB	HRc	T7109	T7309	T7363	T7509	T7609	T7343	TB373	TC353
P	1	Non-alloy steel	About 0.15% C	Annealed	125		○	○	○	○	○	○	○	○
P	2	Non-alloy steel	About 0.45% C	Annealed	190	13	○	○	○	○	○	○	○	○
P	3	Non-alloy steel	About 0.45% C	Quenched & tempered	250	25	○	○	○	○	○	○	○	○
P	4	Non-alloy steel	About 0.75% C	Annealed	270	28	○	○	○	○	○	○	○	○
P	5	Non-alloy steel	About 0.75% C	Quenched & tempered	300	32								
P	6	Low alloy steel		Annealed	180	10	○	○	○	○	○	○	○	○
P	7	Low alloy steel		Quenched & tempered	275	29	○	○	○	○	○	○	○	○
P	8	Low alloy steel		Quenched & tempered	300	32								
P	9	Low alloy steel		Quenched & tempered	350	38								
P	10	High alloyed steel, and tool steel		Annealed	200	15								
P	11	High alloyed steel, and tool steel		Quenched & Tempered	325	35								
M	12	Stainless steel	Ferritic / Martensitic	Annealed	200	15							○	
M	13	Stainless steel	Martensitic	Quenched & Tempered	240	23							○	
M	14	Stainless steel	Austenitic		180	10							○	
K	15	Grey cast iron	Pearlitic / ferritic		180	10								
K	16	Grey cast iron	Pearlitic (Martensitic)		260	26								
K	17	Nodular cast iron	Ferritic		160	3	○	○	○	○	○	○		
K	18	Nodular cast iron	Pearlitic		250	25	○	○	○	○	○	○		
K	19	Malleable cast iron	Ferritic		130									
K	20	Malleable cast iron	Pearlitic		230	21								
N	21	Aluminum-wrought alloy	Not Curable		60									
N	22	Aluminum-wrought alloy	Curable	Hardened	100									
N	23	Aluminum-cast, alloyed	≤ 12% Si, Not Curable		75									
N	24	Aluminum-cast, alloyed	≤ 12% Si, Curable	Hardened	90									
N	25	Aluminum-cast, alloyed	> 12% Si, Not Curable		130		○	○	○	○	○	○		
N	26	Copper and Copper Alloys (Bronze / Brass)	Cutting Alloys, PB>1%		110		○	○	○	○	○	○		
N	27	Copper and Copper Alloys (Bronze / Brass)	CuZn, CuSnZn (Brass)		90		○	○	○	○	○	○		
N	28	Copper and Copper Alloys (Bronze / Brass)	CuSn, lead-free copper and electrolytic copper		100									
N	29	Non Metallic Materials	Duroplastic, Fiber Reinforced Plastic											
N	30	Non Metallic Materials	Rubber, Wood, etc.											
S	31	Heat Resistant Super Alloys	Fe Based	Annealed	200	15								
S	32	Heat Resistant Super Alloys	Fe Based	Cured	280	30								
S	33	Heat Resistant Super Alloys	Ni or Co Based	Annealed	250	25								
S	34	Heat Resistant Super Alloys	Ni or Co Based	Cured	350	38								
S	35	Heat Resistant Super Alloys	Ni or Co Based	Cast	320	34								
S	36	Titanium Alloys	Pure Titanium		400 Rm									
S	37	Titanium Alloys	Alpha + Beta Alloys	Hardened	1050 Rm									
H	38	Hardened steel		Hardened	550	55								
H	39	Hardened steel		Hardened	630	60								
H	40	Chilled Cast Iron		Cast	400	42								
H	41	Hardened Cast Iron		Hardened	550	55								

CARBIDE
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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
TECHNICAL DATA

YG TAP GENERAL

TC711 SERIES

M ISO metric coarse threads DIN 13

Metrisches ISO-Gewinde DIN 13
ISO MÉTRIQUE DIN13
ISO Metrico passo grosso DIN 13

Machine taps
Maschinengewindebohrer

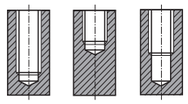
▶ Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

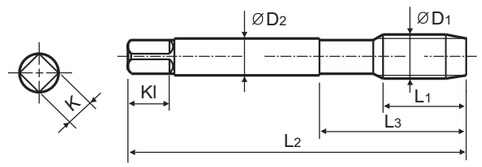
▶ Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

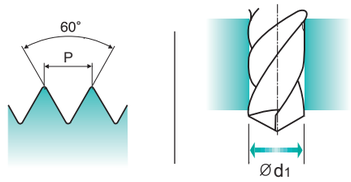
DIN 371

DIN 376

Hole type
2.5×D







Material groups GS | HSS-E | DIN 371/376 | 6H | 60° | C | R40 | Bright | p.B309

Recommended ToolHolder: Plain Shank — TAPPING ER CHUCK, TAPPING CHUCK, ONE STEP TAPPING CHUCK

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	Bright	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M2	× 0.4	**TC711136**	8	45	13	2.8	2.1	5	3	1.6
M2.2	× 0.45	**TC711156**	8	45	13	2.8	2.1	5	3	1.75
*M2.3	× 0.4	**TC711196**	8	45	13	2.8	2.1	5	3	1.9
M2.5	× 0.45	**TC711176**	9	50	15	2.8	2.1	5	3	2.05
*M2.6	× 0.45	**TC711496**	9	50	15	2.8	2.1	5	3	2.1
M3	× 0.5	**TC711206**	6	56	18	3.5	2.7	6	3	2.5
M3.5	× 0.6	**TC711226**	7	56	20	4	3	6	3	2.9
M4	× 0.7	**TC711246**	7	63	21	4.5	3.4	6	3	3.3
M4.5	× 0.75	**TC711266**	8	70	25	6	4.9	8	3	3.7
M5	× 0.8	**TC711286**	8	70	25	6	4.9	8	3	4.2
M6	× 1.0	**TC711316**	10	80	30	6	4.9	8	3	5
M7	× 1.0	**TC711346**	10	80	30	7	5.5	8	3	6
M8	× 1.25	**TC711366**	13	90	35	8	6.2	9	3	6.8
M9	× 1.25	**TC711396**	13	90	35	9	7	10	3	7.8
M10	× 1.5	**TC711426**	15	100	39	10	8	11	3	8.5
M11	× 1.5	**TC711466**	17	100	40	8	6.2	9	3	9.5
M12	× 1.75	**TC711506**	18	110	44	9	7	10	3	10.2
M14	× 2.0	**TC711546**	20	110	44	11	9	12	3	12
M16	× 2.0	**TC711606**	20	110	44	12	9	12	3	14
M18	× 2.5	**TC711656**	25	125	50	14	11	14	4	15.5
M20	× 2.5	**TC711706**	25	140	54	16	12	15	4	17.5
M22	× 2.5	**TC711746**	25	140	54	18	14.5	17	4	19.5
M24	× 3.0	**TC711786**	30	160	60	18	14.5	17	4	21
M27	× 3.0	**TC711866**	30	160	60	20	16	19	4	24
M30	× 3.5	**TC711946**	35	180	70	22	18	21	4	26.5

▶ DIN 371(M2~M10) and DIN 376(M11~M30)
▶ * 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			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	○		○	○	◎	○		◎													

phone:+82-32-526-0909, www.yg1.solutions, E-mail:yg1@yg1.solutions
YG-1 CO., LTD.

YG TAP GENERAL

TD711 SERIES

M ISO metric coarse threads DIN 13

Metrisches ISO-Gewinde DIN 13
ISO MÉTRIQUE DIN13
ISO Metrico passo grosso DIN 13

Machine taps
Maschinengewindebohrer

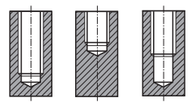
▶ Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

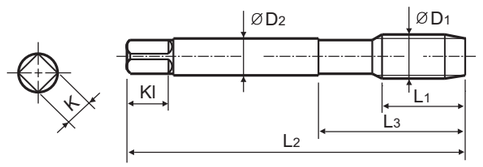
▶ Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

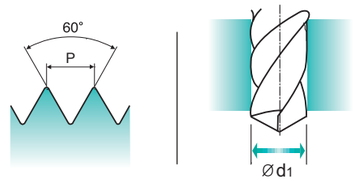
DIN 371

DIN 376

Hole type
2.5×D







Material groups GS | HSS-E | DIN 371/376 | 6H | 60° | C | R40 | TiN | p.B309

Recommended ToolHolder: Plain Shank — TAPPING ER CHUCK, TAPPING CHUCK, ONE STEP TAPPING CHUCK

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	TiN	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M2	× 0.4	**TD711136**	8	45	13	2.8	2.1	5	3	1.6
M2.2	× 0.45	**TD711156**	8	45	13	2.8	2.1	5	3	1.75
*M2.3	× 0.4	**TD711196**	8	45	13	2.8	2.1	5	3	1.9
M2.5	× 0.45	**TD711176**	9	50	15	2.8	2.1	5	3	2.05
*M2.6	× 0.45	**TD711496**	9	50	15	2.8	2.1	5	3	2.1
M3	× 0.5	**TD711206**	6	56	18	3.5	2.7	6	3	2.5
M3.5	× 0.6	**TD711226**	7	56	20	4	3	6	3	2.9
M4	× 0.7	**TD711246**	7	63	21	4.5	3.4	6	3	3.3
M4.5	× 0.75	**TD711266**	8	70	25	6	4.9	8	3	3.7
M5	× 0.8	**TD711286**	8	70	25	6	4.9	8	3	4.2
M6	× 1.0	**TD711316**	10	80	30	6	4.9	8	3	5
M7	× 1.0	**TD711346**	10	80	30	7	5.5	8	3	6
M8	× 1.25	**TD711366**	13	90	35	8	6.2	9	3	6.8
M9	× 1.25	**TD711396**	13	90	35	9	7	10	3	7.8
M10	× 1.5	**TD711426**	15	100	39	10	8	11	3	8.5
M11	× 1.5	**TD711466**	17	100	40	8	6.2	9	3	9.5
M12	× 1.75	**TD711506**	18	110	44	9	7	10	3	10.2
M14	× 2.0	**TD711546**	20	110	44	11	9	12	3	12
M16	× 2.0	**TD711606**	20	110	44	12	9	12	3	14
M18	× 2.5	**TD711656**	25	125	50	14	11	14	4	15.5
M20	× 2.5	**TD711706**	25	140	54	16	12	15	4	17.5
M22	× 2.5	**TD711746**	25	140	54	18	14.5	17	4	19.5
M24	× 3.0	**TD711786**	30	160	60	18	14.5	17	4	21
M27	× 3.0	**TD711866**	30	160	60	20	16	19	4	24
M30	× 3.5	**TD711946**	35	180	70	22	18	21	4	26.5

▶ DIN 371(M2~M10) and DIN 376(M11~M30)
▶ * 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			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	○		○	○	◎	○		◎													

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YG TAP GENERAL

TC411 SERIES

MF ISO metric fine threads DIN 13

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

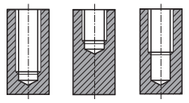
Machine taps
Maschinengewindebohrer

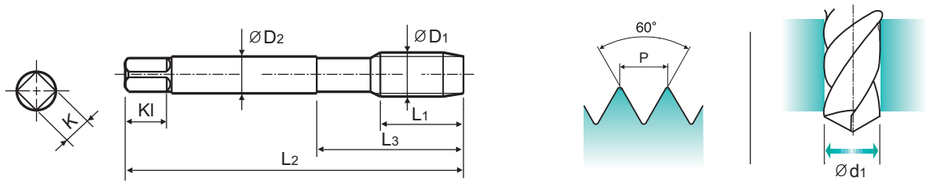
▶ Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

▶ Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

DIN 374

Hole type
2.5×D





Material groups **GS** | HSS-E | DIN 374 | 6H | 60° | C | R40 | Bright | p.B309

Recommended ToolHolder: Plain Shank — TAPPING ER CHUCK, TAPPING CHUCK, ONE STEP TAPPING CHUCK

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	Bright	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M4	× 0.5	**TC411256**	5	63	21	2.8	2.1	5	3	3.5
M5	× 0.5	**TC411296**	5	70	25	3.5	2.7	6	3	4.5
M6	× 0.75	**TC411326**	8	80	30	4.5	3.4	6	3	5.2
M6	× 0.5	**TC411336**	5	80	30	4.5	3.4	6	3	5.5
M7	× 0.75	**TC411356**	10	80	30	5.5	4.3	7	3	6.2
M8	× 1.0	**TC411376**	10	90	36	6	4.9	8	3	7
M8	× 0.75	**TC411386**	8	80	30	6	4.9	8	3	7.2
M8	× 0.5	**TC411936**	5	80	30	6	4.9	8	3	7.5
M10	× 1.25	**TC411436**	16	100	40	7	5.5	8	3	8.8
M10	× 1.0	**TC411446**	10	90	36	7	5.5	8	3	9
M10	× 0.75	**TC411456**	10	90	36	7	5.5	8	3	9.2
M12	× 1.5	**TC411516**	15	100	40	9	7	10	3	10.5
M12	× 1.25	**TC411526**	15	100	40	9	7	10	3	10.8
M12	× 1.0	**TC411536**	11	100	40	9	7	10	3	11
M14	× 1.5	**TC411556**	15	100	40	11	9	12	3	12.5
M14	× 1.25	**TC411566**	15	100	40	11	9	12	3	12.8
M14	× 1.0	**TC411576**	11	100	40	11	9	12	3	13
M16	× 1.5	**TC411616**	15	100	40	12	9	12	3	14.5
M16	× 1.0	**TC411626**	12	100	40	12	9	12	3	15
M18	× 1.5	**TC411676**	17	110	44	14	11	14	4	16.5
M18	× 1.0	**TC411686**	13	110	44	14	11	14	4	17

▶ NEXT PAGE

◎ : 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	400Rm	1050Rm	550	630	400	550
Recommended	○		○	○	◎	○		◎													

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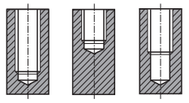
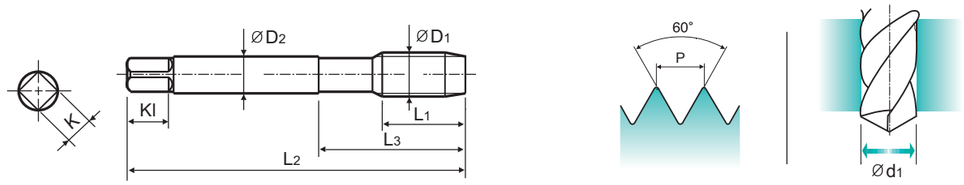
YG-1 CO., LTD.

YG TAP GENERAL
TC411 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 blind holes due to special flute geometry and excellent chip evacuation.
▶ Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.
DIN 374

Hole type
2.5×D





Material groups GS | HSS-E | DIN 374 | 6H | 60° | C | R40 | Bright | p.B309
Recommended ToolHolder: Plain Shank — TAPPING ER CHUCK, TAPPING CHUCK, ONE STEP TAPPING CHUCK
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	Bright	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M20	× 1.5	**TC411726**	17	125	50	16	12	15	4	18.5
M20	× 1.0	**TC411736**	14	125	50	16	12	15	4	19
M22	× 1.5	**TC411766**	17	125	50	18	14.5	17	4	20.5
M22	× 1.0	**TC411776**	14	125	50	18	14.5	17	4	21
M24	× 2.0	**TC411796**	20	140	54	18	14.5	17	4	22
M24	× 1.5	**TC411806**	20	140	54	18	14.5	17	4	22.5
M26	× 1.5	**TC411856**	20	140	54	18	14.5	17	4	24.5
M27	× 2.0	**TC411876**	20	140	54	20	16	19	4	25
M27	× 1.5	**TC411886**	20	140	54	20	16	19	4	25.5
M28	× 1.5	**TC411916**	20	140	54	20	16	19	4	26.5
M30	× 2.0	**TC411966**	22	150	57	22	18	21	4	28
M30	× 1.5	**TC411976**	22	150	57	22	18	21	4	28.5

◎ : 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	400Rm	1050Rm	550	630	400	550
Recommended	○		○	○	◎	○		◎													

YG TAP GENERAL

TD411 SERIES

MF ISO metric fine threads DIN 13

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

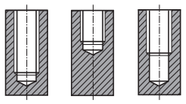
Machine taps
Maschinengewindebohrer

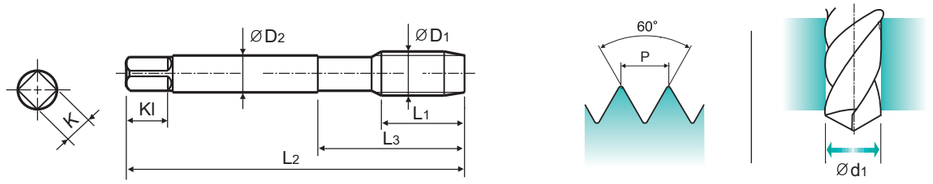
▶ Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

▶ Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

DIN 374

Hole type
2.5×D





Material groups **GS** | HSS-E | DIN 374 | 6H | 60° | C | R40 | TiN | p.B309

Recommended ToolHolder: Plain Shank — TAPPING ER CHUCK, TAPPING CHUCK, ONE STEP TAPPING CHUCK

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	TiN	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M4	× 0.5	**TD411256**	5	63	21	2.8	2.1	5	3	3.5
M5	× 0.5	**TD411296**	5	70	25	3.5	2.7	6	3	4.5
M6	× 0.75	**TD411326**	8	80	30	4.5	3.4	6	3	5.2
M6	× 0.5	**TD411336**	5	80	30	4.5	3.4	6	3	5.5
M7	× 0.75	**TD411356**	10	80	30	5.5	4.3	7	3	6.2
M8	× 1.0	**TD411376**	10	90	36	6	4.9	8	3	7
M8	× 0.75	**TD411386**	8	80	30	6	4.9	8	3	7.2
M8	× 0.5	**TD411936**	5	80	30	6	4.9	8	3	7.5
M10	× 1.25	**TD411436**	16	100	40	7	5.5	8	3	8.8
M10	× 1.0	**TD411446**	10	90	36	7	5.5	8	3	9
M10	× 0.75	**TD411456**	10	90	36	7	5.5	8	3	9.2
M12	× 1.5	**TD411516**	15	100	40	9	7	10	3	10.5
M12	× 1.25	**TD411526**	15	100	40	9	7	10	3	10.8
M12	× 1.0	**TD411536**	11	100	40	9	7	10	3	11
M14	× 1.5	**TD411556**	15	100	40	11	9	12	3	12.5
M14	× 1.25	**TD411566**	15	100	40	11	9	12	3	12.8
M14	× 1.0	**TD411576**	11	100	40	11	9	12	3	13
M16	× 1.5	**TD411616**	15	100	40	12	9	12	3	14.5

▶ NEXT PAGE

◎ : 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	400Rm	1050Rm	550	630	400	550
Recommended	○		○	○	◎	○		◎													

YG TAP GENERAL
TD411 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 blind holes due to special flute geometry and excellent chip evacuation.
▶ Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.
DIN 374
Hole type
2.5×D
Material groups GS | HSS-E | DIN 374 | 6H | 60° | C | R40 | TiN | p.B309
Recommended ToolHolder: Plain Shank — TAPPING ER CHUCK, TAPPING CHUCK, ONE STEP TAPPING CHUCK
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	TiN	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M16	× 1.0	**TD411626**	12	100	40	12	9	12	3	15
M18	× 1.5	**TD411676**	17	110	44	14	11	14	4	16.5
M18	× 1.0	**TD411686**	13	110	44	14	11	14	4	17
M20	× 1.5	**TD411726**	17	125	50	16	12	15	4	18.5
M20	× 1.0	**TD411736**	14	125	50	16	12	15	4	19
M22	× 1.5	**TD411766**	17	125	50	18	14.5	17	4	20.5
M22	× 1.0	**TD411776**	14	125	50	18	14.5	17	4	21
M24	× 2.0	**TD411796**	20	140	54	18	14.5	17	4	22
M24	× 1.5	**TD411806**	20	140	54	18	14.5	17	4	22.5
M26	× 1.5	**TD411856**	20	140	54	18	14.5	17	4	24.5
M27	× 2.0	**TD411876**	20	140	54	20	16	19	4	25
M27	× 1.5	**TD411886**	20	140	54	20	16	19	4	25.5
M28	× 1.5	**TD411916**	20	140	54	20	16	19	4	26.5
M30	× 2.0	**TD411966**	22	150	57	22	18	21	4	28
M30	× 1.5	**TD411976**	22	150	57	22	18	21	4	28.5

◎ : 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	400Rm	1050Rm	550	630	400	550
Recommended	○		○	○	◎	○		◎													

YG TAP GENERAL

TC144 SERIES

UNC

Unified coarse threads

Unified Grobgewinde
UNC
Unificato passo grosso

Machine taps
Maschinengewindebohrer

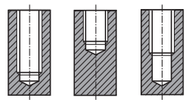
▶ Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

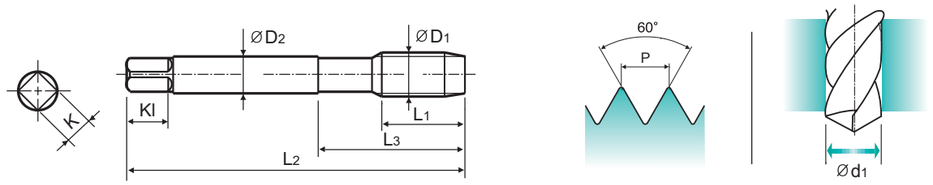
▶ Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

DIN 371

DIN 376

Hole type
2.5×D





Material groups GS | HSS-E | DIN 371/376 | 2B | 60° | C | R40 | Bright | p.B309

Recommended ToolHolder: Plain Shank — TAPPING ER CHUCK, TAPPING CHUCK, ONE STEP TAPPING CHUCK

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		Bright	L1	L2	L3	ØD2	K	Kl	Z	Ød1
#4	-40UNC	**TC144162**	6	56	18	3.5	2.7	6	3	2.3
#5	-40UNC	**TC144202**	7	56	18	3.5	2.7	6	3	2.6
#6	-32UNC	**TC144242**	7	56	20	4	3	6	3	2.85
#8	-32UNC	**TC144282**	8	63	21	4.5	3.4	6	3	3.5
#10	-24UNC	**TC144322**	10	70	25	6	4.9	8	3	3.9
#12	-24UNC	**TC144362**	10	80	30	6	4.9	8	3	4.5
1/4	-20UNC	**TC144402**	13	80	30	7	5.5	8	3	5.2
5/16	-18UNC	**TC144442**	14	90	35	8	6.2	9	3	6.6
3/8	-16UNC	**TC144482**	16	100	39	9	7	10	3	8
7/16	-14UNC	**TC144522**	17	100	40	8	6.2	9	3	9.4
1/2	-13UNC	**TC144562**	20	110	44	9	7	10	3	10.75
9/16	-12UNC	**TC144602**	20	110	44	11	9	12	3	12.25
5/8	-11UNC	**TC144642**	22	110	44	12	9	12	3	13.5
3/4	-10UNC	**TC144702**	25	125	50	14	11	14	4	16.5
7/8	- 9UNC	**TC144742**	27	140	54	18	14.5	17	4	19.5
1	- 8UNC	**TC144782**	30	160	60	20	16	19	4	22.25
1-1/8	- 7UNC	**TC144822**	35	180	65	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	400Rm	1050Rm	550	630	400	550
Recommended	○		○	○	◎	○		◎													

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YG-1 CO., LTD.

YG TAP GENERAL

TC124 SERIES

UNF

Unified fine threads

Unified Feingewinde
UNF
Unificato passo fine

Machine taps
Maschinengewindebohrer

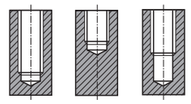
▶ Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

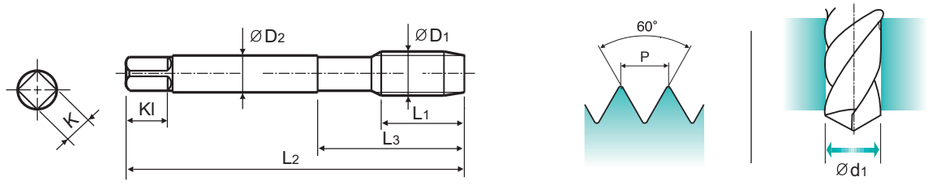
▶ Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

DIN 371

DIN 374

Hole type
2.5×D





Material groups GS | HSS-E | DIN 371/374 | 2B | 60° | C | R40 | Bright | p.B309

Recommended ToolHolder: Plain Shank — TAPPING ER CHUCK, TAPPING CHUCK, ONE STEP TAPPING CHUCK

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		Bright	L1	L2	L3	ØD2	K	Kl	Z	Ød1
#4	-48UNF	**TC124182**	6	56	18	3.5	2.7	6	3	2.4
#5	-44UNF	**TC124222**	7	56	18	3.5	2.7	6	3	2.7
#6	-40UNF	**TC124262**	7	56	20	4	3	6	3	3
#8	-36UNF	**TC124302**	8	63	21	4.5	3.4	6	3	3.5
#10	-32UNF	**TC124342**	10	70	25	6	4.9	8	3	4.1
#12	-28UNF	**TC124382**	10	80	30	6	4.9	8	3	4.7
1/4	-28UNF	**TC124422**	10	80	30	7	5.5	8	3	5.5
5/16	-24UNF	**TC124462**	10	90	35	8	6.2	9	3	6.9
3/8	-24UNF	**TC124502**	10	100	39	9	7	10	3	8.5
7/16	-20UNF	**TC124542**	13	100	40	8	6.2	9	3	9.9
1/2	-20UNF	**TC124582**	13	100	40	9	7	10	3	11.5
9/16	-18UNF	**TC124622**	15	100	40	11	9	12	3	12.9
5/8	-18UNF	**TC124662**	15	100	40	12	9	12	3	14.5
3/4	-16UNF	**TC124722**	17	110	44	14	11	14	4	17.5
7/8	-14UNF	**TC124762**	17	125	50	18	14.5	17	4	20.5
1	-12UNF	**TC124802**	20	140	54	18	14.5	17	4	23.25
1-1/8	-12UNF	**TC124842**	22	150	60	22	18	21	4	26.5

▶ DIN 371(#4~3/8) and DIN 374(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	400Rm	1050Rm	550	630	400	550
Recommended	○		○	○	◎	○		◎													

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phone:+82-32-526-0909, www.yg1.solutions, E-mail:yg1@yg1.solutions

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
TECHNICAL DATA

YG TAP GENERAL

TC134 SERIES

BSW Whitworth threads

Whitworth Gewinde
BSW
Unificato passo grosso

Machine taps
Maschinengewindebohrer

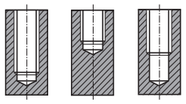
▶ Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

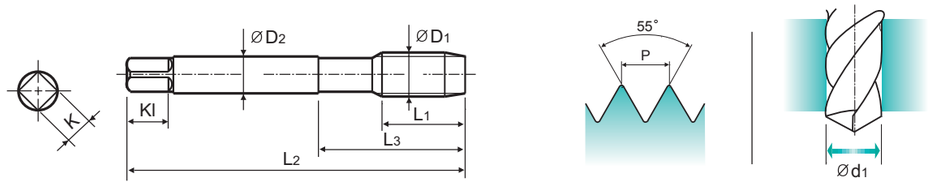
▶ Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

DIN 2182

DIN 2183

Hole type
2.5×D





Material groups GS | HSS-E | DIN 2182/2183 | 55° | C | R40 | Bright | p.B309

Recommended ToolHolder: Plain Shank — TAPPING ER CHUCK, TAPPING CHUCK, ONE STEP TAPPING CHUCK

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		Bright	L1	L2	L3	ØD2	K	Kl	Z	Ød1
W1/8	- 40	TC134200	7	56	18	3.5	2.7	6	3	2.5
W5/32	- 32	TC134280	7	63	21	4.5	3.4	6	3	3.1
W3/16	- 24	TC134320	10	70	25	6	4.9	8	3	3.6
W7/32	- 24	TC134360	10	80	30	6	4.9	8	3	4.4
W1/4	- 20	TC134400	13	80	30	7	5.5	8	3	5.1
W5/16	- 18	TC134440	14	90	35	8	6.2	9	3	6.5
W3/8	- 16	TC134480	16	100	39	9	7	10	3	7.9
W7/16	- 14	TC134520	17	100	40	8	6.2	9	3	9.3
W1/2	- 12	TC134560	20	110	44	9	7	10	3	10.5
W9/16	- 12	TC134600	20	110	44	11	9	12	3	12
W5/8	- 11	TC134640	22	110	40	12	9	12	3	13.5
W3/4	- 10	TC134700	25	125	50	14	11	14	4	16.5
W7/8	- 9	TC134740	27	140	54	18	14.5	17	4	19.25
W1	- 8	TC134780	30	160	60	20	16	19	4	22
W1-1/8	- 7	TC134820	35	180	65	22	18	21	4	24.75

▶ DIN 2182(W1/8~W3/8) and DIN 2183(W7/16~W1-1/8)

◎ : 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	400Rm	1050Rm	550	630	400	550
Recommended	○		○	○	◎	○		◎													

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YG TAP GENERAL

TC517 SERIES

M ISO metric coarse threads DIN 13

Metrisches ISO-Gewinde DIN 13
ISO MÉTRIQUE DIN13
ISO Metrico passo grosso DIN 13

Machine taps
Maschinengewindebohrer

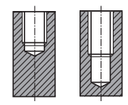
▶ Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

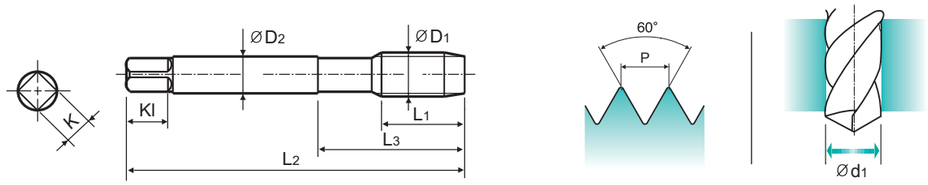
▶ Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

DIN 371

DIN 376

Hole type
2.5×D





Material groups GS | HSS-E | DIN 371/376 | 6H | 60° | C | R20 | Bright | p.B309

Recommended ToolHolder: Plain Shank — TAPPING ER CHUCK, TAPPING CHUCK, ONE STEP TAPPING CHUCK

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	Bright	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M2	× 0.4	TC517136	8	45	13	2.8	2.1	5	3	1.6
M2.2	× 0.45	TC517156	8	45	13	2.8	2.1	5	3	1.75
*M2.3	× 0.4	TC517196	8	45	13	2.8	2.1	5	3	1.9
M2.5	× 0.45	TC517176	9	50	15	2.8	2.1	5	3	2.05
*M2.6	× 0.45	TC517496	9	50	15	2.8	2.1	5	3	2.1
M3	× 0.5	TC517206	6	56	18	3.5	2.7	6	3	2.5
M3.5	× 0.6	TC517226	7	56	20	4	3	6	3	2.9
M4	× 0.7	TC517246	7	63	21	4.5	3.4	6	3	3.3
M4.5	× 0.75	TC517266	8	70	25	6	4.9	8	3	3.7
M5	× 0.8	TC517286	8	70	25	6	4.9	8	3	4.2
M6	× 1.0	TC517316	10	80	30	6	4.9	8	3	5
M7	× 1.0	TC517346	10	80	30	7	5.5	8	3	6
M8	× 1.25	TC517366	13	90	35	8	6.2	9	3	6.8
M9	× 1.25	TC517396	13	90	35	9	7	10	3	7.8
M10	× 1.5	TC517426	15	100	39	10	8	11	3	8.5
M11	× 1.5	TC517466	17	100	40	8	6.2	9	3	9.5
M12	× 1.75	TC517506	18	110	44	9	7	10	3	10.2
M14	× 2.0	TC517546	20	110	44	11	9	12	3	12
M16	× 2.0	TC517606	20	110	44	12	9	12	3	14
M18	× 2.5	TC517656	25	125	50	14	11	14	4	15.5
M20	× 2.5	TC517706	25	140	54	16	12	15	4	17.5
M22	× 2.5	TC517746	25	140	54	18	14.5	17	4	19.5
M24	× 3.0	TC517786	30	160	60	18	14.5	17	4	21
M27	× 3.0	TC517866	30	160	60	20	16	19	4	24
M30	× 3.5	TC517946	35	180	70	22	18	21	4	26.5

▶ DIN 371(M2~M10) and DIN 376(M11~M30)
▶ * 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			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	○		○	○	◎	○		◎													

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YG TAP GENERAL

TC612 SERIES

M ISO metric coarse threads DIN 13

Metrisches ISO-Gewinde DIN 13
ISO MÉTRIQUE DIN13
ISO Metrico passo grosso DIN 13

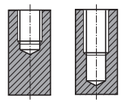
Machine taps
Maschinengewindebohrer

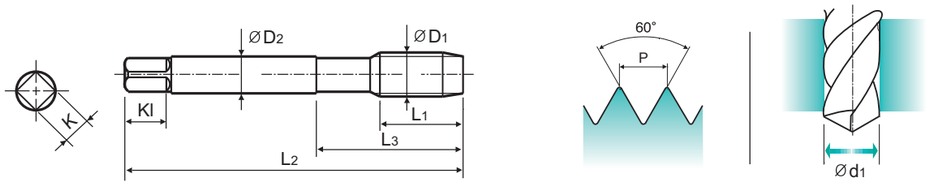
▶ Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

▶ Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

DIN 352

Hole type
2.5×D





Material groups **GS** | HSS-E | DIN 352 | 6H | 60° | C | R20 | Bright | p.B309

Recommended ToolHolder: Plain Shank — TAPPING ER CHUCK, TAPPING CHUCK, ONE STEP TAPPING CHUCK

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	Bright	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M3	× 0.5	**TC612206**	11	40	18	3.5	2.7	6	3	2.5
M4	× 0.7	**TC612246**	13	45	21	4.5	3.4	6	3	3.3
M5	× 0.8	**TC612286**	16	52	26	6	4.9	8	3	4.2
M6	× 1.0	**TC612316**	18	56	27	6	4.9	8	3	5
M8	× 1.25	**TC612366**	20	63	34	6	4.9	8	3	6.8
M10	× 1.5	**TC612426**	22	70	38	7	5.5	8	3	8.5
M12	× 1.75	**TC612506**	24	80	45	9	7	10	3	10.2
M14	× 2.0	**TC612546**	26	80	45	11	9	12	3	12
M16	× 2.0	**TC612606**	27	80	45	12	9	12	3	14
M18	× 2.5	**TC612656**	30	95	58	14	11	14	4	15.5
M20	× 2.5	**TC612706**	32	95	58	16	12	15	4	17.5

◎ : 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	400Rm	1050Rm	550	630	400	550
Recommended	○		○	○	◎	○		◎													

YG TAP GENERAL

TC127 SERIES

M ISO metric coarse threads DIN 13

Metrisches ISO-Gewinde DIN 13
ISO MÉTRIQUE DIN13
ISO Metrico passo grosso DIN 13

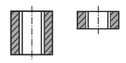
Machine taps
Maschinengewindebohrer

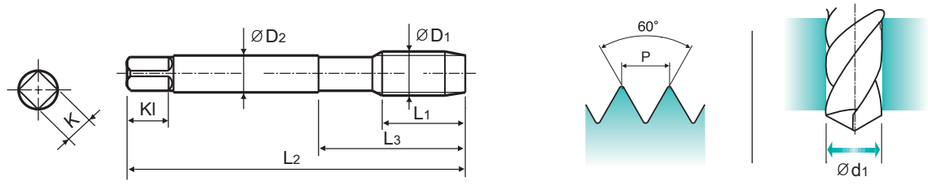
▶ Suitable for through hole in more cutting speed than other taps due to thick web.

▶ Geeignet für Durchgangslöcher in höherer Schnittgeschwindigkeit als bei anderen Gewindebohrern dank größerer Kerndicke.

DIN 371

Hole type
3.0×D





Material groups **GS** | HSS-E | DIN 371 | 6H | 60° | B | Bright | p.B309

Recommended ToolHolder: Plain Shank — TAPPING ER CHUCK, TAPPING CHUCK, ONE STEP TAPPING CHUCK

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	Bright	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M2	× 0.4	**TC127136**	8	45	13	2.8	2.1	5	3	1.6
M2.2	× 0.45	**TC127156**	8	45	13	2.8	2.1	5	3	1.75
*M2.3	× 0.4	**TC127196**	8	45	13	2.8	2.1	5	3	1.9
M2.5	× 0.45	**TC127176**	9	50	15	2.8	2.1	5	3	2.05
*M2.6	× 0.45	**TC127496**	9	50	15	2.8	2.1	5	3	2.1
M3	× 0.5	**TC127206**	11	56	18	3.5	2.7	6	3	2.5
M3.5	× 0.6	**TC127226**	12	56	20	4	3	6	3	2.9
M4	× 0.7	**TC127246**	13	63	21	4.5	3.4	6	3	3.3
M4.5	× 0.75	**TC127266**	14	70	25	6	4.9	8	3	3.7
M5	× 0.8	**TC127286**	15	70	25	6	4.9	8	3	4.2
M6	× 1.0	**TC127316**	17	80	30	6	4.9	8	3	5
M7	× 1.0	**TC127346**	17	80	30	7	5.5	8	3	6
M8	× 1.25	**TC127366**	20	90	35	8	6.2	9	3	6.8
M9	× 1.25	**TC127396**	20	90	35	9	7	10	3	7.8
M10	× 1.5	**TC127426**	22	100	39	10	8	11	3	8.5
M11	× 1.5	**TC127466**	22	100	39	11	9	12	3	9.5
M12	× 1.75	**TC127506**	24	110	44	12	9	12	3	10.2

▶ * 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			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	○		○	○	◎	○		◎													

YG TAP GENERAL

TD127 SERIES

M ISO metric coarse threads DIN 13

Metrisches ISO-Gewinde DIN 13
ISO MÉTRIQUE DIN13
ISO Metrico passo grosso DIN 13

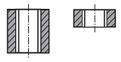
Machine taps
Maschinengewindebohrer

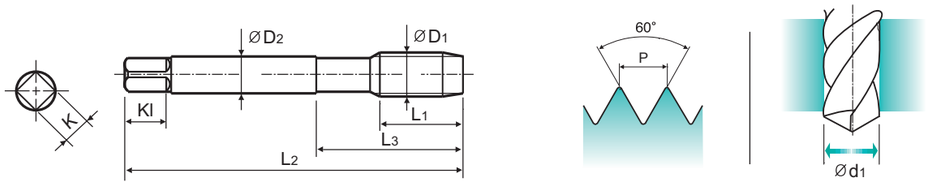
▶ Suitable for through hole in more cutting speed than other taps due to thick web.

▶ Geeignet für Durchgangslöcher in höherer Schnittgeschwindigkeit als bei anderen Gewindebohrern dank größerer Kerndicke.

DIN 371

Hole type
3.0×D





Material groups **GS** | HSS-E | DIN 371 | 6H | 60° | B | TiN | p.B309

Recommended ToolHolder: Plain Shank — TAPPING ER CHUCK, TAPPING CHUCK, ONE STEP TAPPING CHUCK

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	TiN	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M2	× 0.4	**TD127136**	8	45	13	2.8	2.1	5	3	1.6
M2.2	× 0.45	**TD127156**	8	45	13	2.8	2.1	5	3	1.75
*M2.3	× 0.4	**TD127196**	8	45	13	2.8	2.1	5	3	1.9
M2.5	× 0.45	**TD127176**	9	50	15	2.8	2.1	5	3	2.05
*M2.6	× 0.45	**TD127496**	9	50	15	2.8	2.1	5	3	2.1
M3	× 0.5	**TD127206**	11	56	18	3.5	2.7	6	3	2.5
M3.5	× 0.6	**TD127226**	12	56	20	4	3	6	3	2.9
M4	× 0.7	**TD127246**	13	63	21	4.5	3.4	6	3	3.3
M4.5	× 0.75	**TD127266**	14	70	25	6	4.9	8	3	3.7
M5	× 0.8	**TD127286**	15	70	25	6	4.9	8	3	4.2
M6	× 1.0	**TD127316**	17	80	30	6	4.9	8	3	5
M7	× 1.0	**TD127346**	17	80	30	7	5.5	8	3	6
M8	× 1.25	**TD127366**	20	90	35	8	6.2	9	3	6.8
M9	× 1.25	**TD127396**	20	90	35	9	7	10	3	7.8
M10	× 1.5	**TD127426**	22	100	39	10	8	11	3	8.5
M11	× 1.5	**TD127466**	22	100	39	11	9	12	3	9.5
M12	× 1.75	**TD127506**	24	110	44	12	9	12	3	10.2

▶ *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			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	○		○	○	◎	○		◎													

YG TAP GENERAL

TC122 SERIES

M ISO metric coarse threads DIN 13

Metrisches ISO-Gewinde DIN 13
ISO MÉTRIQUE DIN13
ISO Metrico passo grosso DIN 13

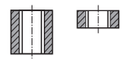
Machine taps
Maschinengewindebohrer

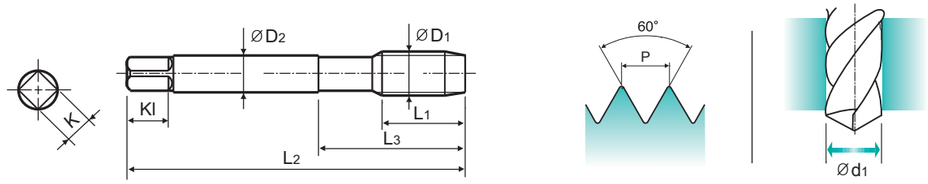
▶ Suitable for through hole in more cutting speed than other taps due to thick web.

▶ Geeignet für Durchgangslöcher in höherer Schnittgeschwindigkeit als bei anderen Gewindebohrern dank größerer Kerndicke.

DIN 352

Hole type
3.0×D





Material groups **GS** | HSS-E | DIN 352 | 6H | 60° | B | Bright | p.B309

Recommended ToolHolder: Plain Shank — TAPPING ER CHUCK, TAPPING CHUCK, ONE STEP TAPPING CHUCK

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	Bright	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M2	× 0.4	**TC122136**	8	36	13	2.8	2.1	5	3	1.6
M2.5	× 0.45	**TC122176**	9	40	15	2.8	2.1	5	3	2.05
M3	× 0.5	**TC122206**	11	40	18	3.5	2.7	6	3	2.5
M4	× 0.7	**TC122246**	13	45	21	4.5	3.4	6	3	3.3
M5	× 0.8	**TC122286**	16	52	26	6	4.9	8	3	4.2
M6	× 1.0	**TC122316**	18	56	27	6	4.9	8	3	5
M8	× 1.25	**TC122366**	20	63	34	6	4.9	8	3	6.8
M10	× 1.5	**TC122426**	22	70	38	7	5.5	8	3	8.5
M12	× 1.75	**TC122506**	24	80	45	9	7	10	3	10.2
M14	× 2.0	**TC122546**	26	80	45	11	9	12	3	12
M16	× 2.0	**TC122606**	27	80	45	12	9	12	3	14

◎ : 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	400Rm	1050Rm	550	630	400	550
Recommended	○		○	○	◎	○		◎													

YG TAP GENERAL

TC222 SERIES

MF ISO metric fine threads DIN 13

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

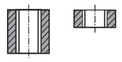
Machine taps
Maschinengewindebohrer

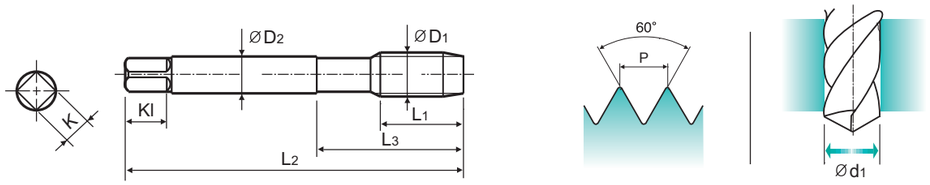
▶ Suitable for through hole in more cutting speed than other taps due to thick web.

▶ Geeignet für Durchgangslöcher in höherer Schnittgeschwindigkeit als bei anderen Gewindebohrern dank größerer Kerndicke.

DIN 374

Hole type
3.0×D





Material groups GS | HSS-E | DIN 374 | 6H | 60° | B | Bright

p.B309

Recommended ToolHolder: Plain Shank — TAPPING ER CHUCK, TAPPING CHUCK, ONE STEP TAPPING CHUCK

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	Bright	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M4	× 0.5	**TC222256**	10	63	21	2.8	2.1	5	3	3.5
M5	× 0.5	**TC222296**	11	70	25	3.5	2.7	6	3	4.5
M6	× 0.75	**TC222326**	13	80	30	4.5	3.4	6	3	5.2
M6	× 0.5	**TC222336**	13	80	30	4.5	3.4	6	3	5.5
M7	× 0.75	**TC222356**	14	80	30	5.5	4.3	7	3	6.2
M8	× 1.0	**TC222376**	17	90	36	6	4.9	8	3	7
M8	× 0.75	**TC222386**	14	80	30	6	4.9	8	3	7.2
M8	× 0.5	**TC222936**	14	80	30	6	4.9	8	3	7.5
M10	× 1.25	**TC222436**	22	100	40	7	5.5	8	3	8.8
M10	× 1.0	**TC222446**	18	90	36	7	5.5	8	3	9
M10	× 0.75	**TC222456**	18	90	36	7	5.5	8	3	9.2
M12	× 1.5	**TC222516**	22	100	40	9	7	10	3	10.5
M12	× 1.25	**TC222526**	22	100	40	9	7	10	3	10.8
M12	× 1.0	**TC222536**	18	100	40	9	7	10	3	11
M14	× 1.5	**TC222556**	22	100	40	11	9	12	3	12.5
M14	× 1.25	**TC222566**	22	100	40	11	9	12	3	12.8
M14	× 1.0	**TC222576**	18	100	40	11	9	12	3	13

▶ NEXT PAGE

◎ : 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	400Rm	1050Rm	550	630	400	550
Recommended	○		○	○	◎	○		◎													

YG TAP GENERAL

TC222 SERIES

MF ISO metric fine threads DIN 13

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

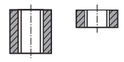
Machine taps
Maschinengewindebohrer

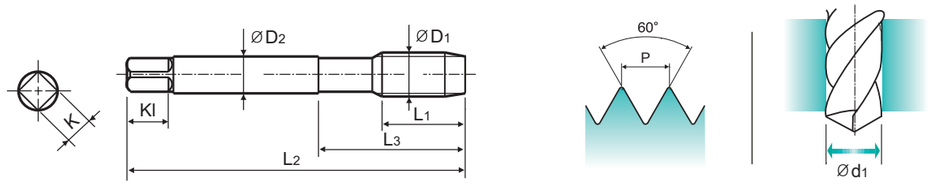
▶ Suitable for through hole in more cutting speed than other taps due to thick web.

▶ Geeignet für Durchgangslöcher in höherer Schnittgeschwindigkeit als bei anderen Gewindebohrern dank größerer Kerndicke.

DIN 374

Hole type
3.0×D





Material groups GS | HSS-E | DIN 374 | 6H | 60° | B | Bright

p.B309

Recommended ToolHolder: Plain Shank — TAPPING ER CHUCK, TAPPING CHUCK, ONE STEP TAPPING CHUCK

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	Bright	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M16	× 1.5	**TC222616**	22	100	40	12	9	12	3	14.5
M16	× 1.0	**TC222626**	18	100	40	12	9	12	3	15
M18	× 1.5	**TC222676**	25	110	44	14	11	14	4	16.5
M18	× 1.0	**TC222686**	20	110	44	14	11	14	4	17
M20	× 1.5	**TC222726**	25	125	50	16	12	15	4	18.5
M20	× 1.0	**TC222736**	20	125	50	16	12	15	4	19
M22	× 1.5	**TC222766**	25	125	50	18	14.5	17	4	20.5
M22	× 1.0	**TC222776**	20	125	50	18	14.5	17	4	21
M24	× 2.0	**TC222796**	27	140	54	18	14.5	17	4	22
M24	× 1.5	**TC222806**	27	140	54	18	14.5	17	4	22.5
M26	× 1.5	**TC222856**	28	140	54	18	14.5	17	4	24.5
M27	× 2.0	**TC222876**	28	140	54	20	16	19	4	25
M27	× 1.5	**TC222886**	28	140	54	20	16	19	4	25.5
M28	× 1.5	**TC222916**	28	140	54	20	16	19	4	26.5
M30	× 2.0	**TC222966**	30	150	57	22	18	21	4	28
M30	× 1.5	**TC222976**	30	150	57	22	18	21	4	28.5

◎ : 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	400Rm	1050Rm	550	630	400	550
Recommended	○		○	○	◎	○		◎													

YG TAP GENERAL

TD222 SERIES

MF ISO metric fine threads DIN 13

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

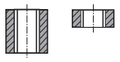
Machine taps
Maschinengewindebohrer

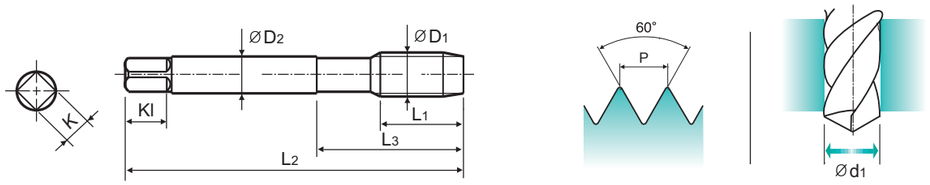
▶ Suitable for through hole in more cutting speed than other taps due to thick web.

▶ Geeignet für Durchgangslöcher in höherer Schnittgeschwindigkeit als bei anderen Gewindebohrern dank größerer Kerndicke.

DIN 374

Hole type
3.0×D





Material groups GS | HSS-E | DIN 374 | 6H | 60° | B | TiN

p.B309

Recommended ToolHolder: Plain Shank — TAPPING ER CHUCK, TAPPING CHUCK, ONE STEP TAPPING CHUCK

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	TiN	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M4	× 0.5	**TD222256**	10	63	21	2.8	2.1	5	3	3.5
M5	× 0.5	**TD222296**	11	70	25	3.5	2.7	6	3	4.5
M6	× 0.75	**TD222326**	13	80	30	4.5	3.4	6	3	5.2
M6	× 0.5	**TD222336**	13	80	30	4.5	3.4	6	3	5.5
M7	× 0.75	**TD222356**	14	80	30	5.5	4.3	7	3	6.2
M8	× 1.0	**TD222376**	17	90	36	6	4.9	8	3	7
M8	× 0.75	**TD222386**	14	80	30	6	4.9	8	3	7.2
M8	× 0.5	**TD222936**	14	80	30	6	4.9	8	3	7.5
M10	× 1.25	**TD222436**	22	100	40	7	5.5	8	3	8.8
M10	× 1.0	**TD222446**	18	90	36	7	5.5	8	3	9
M10	× 0.75	**TD222456**	18	90	36	7	5.5	8	3	9.2
M12	× 1.5	**TD222516**	22	100	40	9	7	10	3	10.5
M12	× 1.25	**TD222526**	22	100	40	9	7	10	3	10.8
M12	× 1.0	**TD222536**	18	100	40	9	7	10	3	11
M14	× 1.5	**TD222556**	22	100	40	11	9	12	3	12.5
M14	× 1.25	**TD222566**	22	100	40	11	9	12	3	12.8
M14	× 1.0	**TD222576**	18	100	40	11	9	12	3	13
M16	× 1.5	**TD222616**	22	100	40	12	9	12	3	14.5

▶ NEXT PAGE

◎ : 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	400Rm	1050Rm	550	630	400	550
Recommended	○		○	○	◎	○		◎													

YG TAP GENERAL

TD222 SERIES

MF ISO metric fine threads DIN 13

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

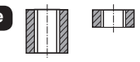
Machine taps
Maschinengewindebohrer

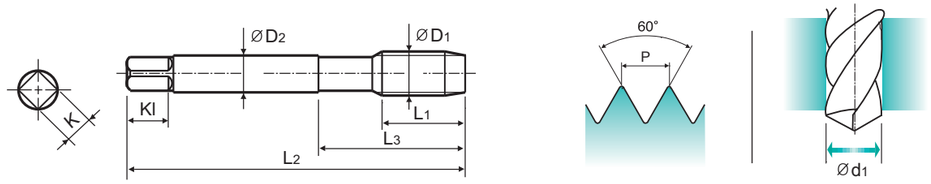
▶ Suitable for through hole in more cutting speed than other taps due to thick web.

▶ Geeignet für Durchgangslöcher in höherer Schnittgeschwindigkeit als bei anderen Gewindebohrern dank größerer Kerndicke.

DIN 374

Hole type
3.0×D





Material groups GS | HSS-E | DIN 374 | 6H | 60° | B | TiN

p.B309

Recommended ToolHolder: Plain Shank — TAPPING ER CHUCK, TAPPING CHUCK, ONE STEP TAPPING CHUCK

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	TiN	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M16	× 1.0	**TD222626**	18	100	40	12	9	12	3	15
M18	× 1.5	**TD222676**	25	110	44	14	11	14	4	16.5
M18	× 1.0	**TD222686**	20	110	44	14	11	14	4	17
M20	× 1.5	**TD222726**	25	125	50	16	12	15	4	18.5
M20	× 1.0	**TD222736**	20	125	50	16	12	15	4	19
M22	× 1.5	**TD222766**	25	125	50	18	14.5	17	4	20.5
M22	× 1.0	**TD222776**	20	125	50	18	14.5	17	4	21
M24	× 2.0	**TD222796**	27	140	54	18	14.5	17	4	22
M24	× 1.5	**TD222806**	27	140	54	18	14.5	17	4	22.5
M26	× 1.5	**TD222856**	28	140	54	18	14.5	17	4	24.5
M27	× 2.0	**TD222876**	28	140	54	20	16	19	4	25
M27	× 1.5	**TD222886**	28	140	54	20	16	19	4	25.5
M28	× 1.5	**TD222916**	28	140	54	20	16	19	4	26.5
M30	× 2.0	**TD222966**	30	150	57	22	18	21	4	28
M30	× 1.5	**TD222976**	30	150	57	22	18	21	4	28.5

◎ : 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	400Rm	1050Rm	550	630	400	550
Recommended	○		○	○	◎	○		◎													

YG TAP GENERAL

TC214 SERIES

UNC

Unified coarse threads

Unified Grobgewinde
UNC
Unificato passo grosso

Machine taps
Maschinengewindebohrer

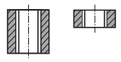
▶ Suitable for through hole in more cutting speed than other taps due to thick web.

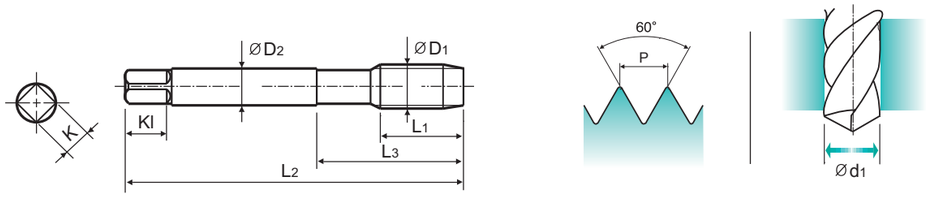
▶ Geeignet für Durchgangslöcher in höherer Schnittgeschwindigkeit als bei anderen Gewindebohrern dank größerer Kerndicke.

DIN 371

DIN 376

Hole type
3.0×D





Material groups **GS** | HSS-E | DIN 371/376 | 2B | 60° | B | Bright

p.B309

Recommended ToolHolder: Plain Shank — TAPPING ER CHUCK, TAPPING CHUCK, ONE STEP TAPPING CHUCK

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			Bright	L1	L2	L3	ØD2	K	Kl	Z	Ød1
#4	-	40UNC	TC214162	11	56	18	3.5	2.7	6	3	2.3
#5	-	40UNC	TC214202	11	56	18	3.5	2.7	6	3	2.6
#6	-	32UNC	TC214242	12	56	20	4	3	6	3	2.85
#8	-	32UNC	TC214282	13	63	21	4.5	3.4	6	3	3.5
#10	-	24UNC	TC214322	15	70	25	6	4.9	8	3	3.9
#12	-	24UNC	TC214362	16	80	30	6	4.9	8	3	4.5
1/4	-	20UNC	TC214402	17	80	30	7	5.5	8	3	5.2
5/16	-	18UNC	TC214442	20	90	35	8	6.2	9	3	6.6
3/8	-	16UNC	TC214482	22	100	39	9	7	10	3	8
7/16	-	14UNC	TC214522	22	100	40	8	6.2	9	3	9.4
1/2	-	13UNC	TC214562	25	110	44	9	7	10	3	10.75
9/16	-	12UNC	TC214602	26	110	44	11	9	12	3	12.25
5/8	-	11UNC	TC214642	27	110	44	12	9	12	3	13.5
3/4	-	10UNC	TC214702	30	125	50	14	11	14	4	16.5
7/8	-	9UNC	TC214742	32	140	54	18	14.5	17	4	19.5
1	-	8UNC	TC214782	36	160	60	20	16	19	4	22.25
1-1/8	-	7UNC	TC214822	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	400Rm	1050Rm	550	630	400	550
Recommended	○		○	○	◎	○		◎													

YG TAP GENERAL

TC234 SERIES

UNF

Unified fine threads

Unified Feingewinde
UNF
Unificato passo fine

Machine taps
Maschinengewindebohrer

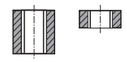
▶ Suitable for through hole in more cutting speed than other taps due to thick web.

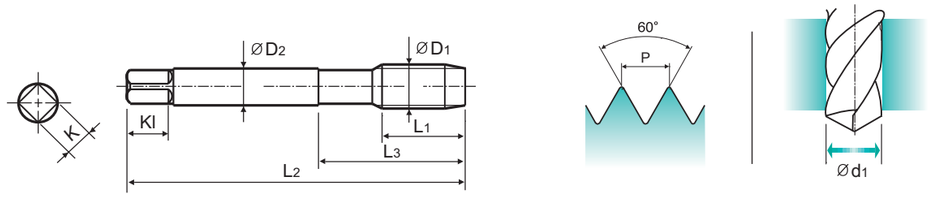
▶ Geeignet für Durchgangslöcher in höherer Schnittgeschwindigkeit als bei anderen Gewindebohrern dank größerer Kerndicke.

DIN 371

DIN 374

Hole type
3.0×D





Material groups **GS** | HSS-E | DIN 371/374 | 2B | 60° | B | Bright

p.B309

Recommended ToolHolder: Plain Shank — TAPPING ER CHUCK, TAPPING CHUCK, ONE STEP TAPPING CHUCK

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			Bright	L1	L2	L3	ØD2	K	Kl	Z	Ød1
#4	-	48UNF	TC234182	11	56	18	3.5	2.7	6	3	2.4
#5	-	44UNF	TC234222	11	56	18	3.5	2.7	6	3	2.7
#6	-	40UNF	TC234262	12	56	20	4	3	6	3	3
#8	-	36UNF	TC234302	13	63	21	4.5	3.4	6	3	3.5
#10	-	32UNF	TC234342	15	70	25	6	4.9	8	3	4.1
#12	-	28UNF	TC234382	16	80	30	6	4.9	8	3	4.7
1/4	-	28UNF	TC234422	17	80	30	7	5.5	8	3	5.5
5/16	-	24UNF	TC234462	17	90	35	8	6.2	9	3	6.9
3/8	-	24UNF	TC234502	18	100	39	9	7	10	3	8.5
7/16	-	20UNF	TC234542	22	100	40	8	6.2	9	3	9.9
1/2	-	20UNF	TC234582	22	100	40	9	7	10	3	11.5
9/16	-	18UNF	TC234622	22	100	40	11	9	12	3	12.9
5/8	-	18UNF	TC234662	22	100	40	12	9	12	3	14.5
3/4	-	16UNF	TC234722	25	110	44	14	11	14	4	17.5
7/8	-	14UNF	TC234762	26	125	50	18	14.5	17	4	20.5
1	-	12UNF	TC234802	28	140	54	18	14.5	17	4	23.25
1-1/8	-	12UNF	TC234842	30	150	60	22	18	21	4	26.5

▶ DIN 371(#4~3/8) and DIN 374(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	400Rm	1050Rm	550	630	400	550
Recommended	○		○	○	◎	○		◎													

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
TECHNICAL DATA

YG TAP GENERAL

TC224 SERIES

BSW Whitworth threads

Whitworth Gewinde
BSW
Filettatura Whitworth

Machine taps
Maschinengewindebohrer

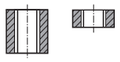
▶ Suitable for through hole in more cutting speed than other taps due to thick web.

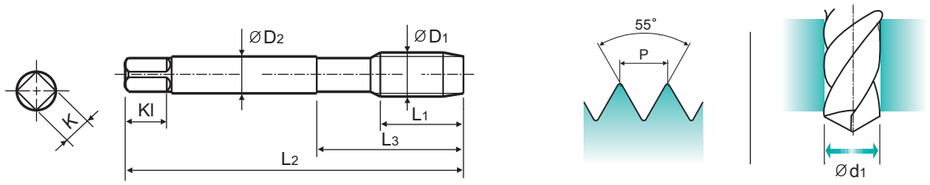
▶ Geeignet für Durchgangslöcher in höherer Schnittgeschwindigkeit als bei anderen Gewindebohrern dank größerer Kerndicke.

DIN 2182

DIN 2183

Hole type
3.0×D





Material groups GS | HSS-E | DIN 2182/2183 | 6H | 55° | B | Bright | p.B309

Recommended ToolHolder: Plain Shank — TAPPING ER CHUCK, TAPPING CHUCK, ONE STEP TAPPING CHUCK

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		Bright	L1	L2	L3	ØD2	K	Kl	Z	Ød1
W1/8	- 40	**TC224200**	11	56	18	3.5	2.7	6	3	2.5
W5/32	- 32	**TC224280**	13	63	21	4.5	3.4	6	3	3.1
W3/16	- 24	**TC224320**	15	70	25	6	4.9	8	3	3.6
W7/32	- 24	**TC224360**	16	80	30	6	4.9	8	3	4.4
W1/4	- 20	**TC224400**	17	80	30	7	5.5	8	3	5.1
W5/16	- 18	**TC224440**	20	90	35	8	6.2	9	3	6.5
W3/8	- 16	**TC224480**	22	100	39	9	7	10	3	7.9
W7/16	- 14	**TC224520**	22	100	40	8	6.2	9	3	9.3
W1/2	- 12	**TC224560**	25	110	44	9	7	10	3	10.5
W9/16	- 12	**TC224600**	26	110	44	11	9	12	3	12
W5/8	- 11	**TC224640**	27	110	44	12	9	12	3	13.5
W3/4	- 10	**TC224700**	30	125	50	14	11	14	4	16.5
W7/8	- 9	**TC224740**	32	140	54	18	14.5	17	4	19.25
W1	- 8	**TC224780**	36	160	60	20	16	19	4	22
W1-1/8	- 7	**TC224820**	40	180	65	22	18	21	4	24.75

▶ DIN 2182(W1/8~W3/8) and DIN 2183(W7/16~W1-1/8)

◎ : 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	400Rm	1050Rm	550	630	400	550
Recommended	○		○	○	◎	○		◎													

YG TAP GENERAL

TC227 SERIES

M ISO metric coarse threads DIN 13

Metrisches ISO-Gewinde DIN 13
ISO MÉTRIQUE DIN13
ISO Metrico passo grosso DIN 13

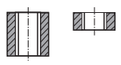
Machine taps
Maschinengewindebohrer

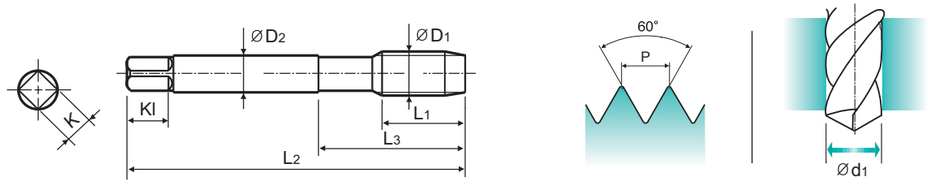
▶ Suitable for through hole in more cutting speed than other taps due to thick web.

▶ Geeignet für Durchgangslöcher in höherer Schnittgeschwindigkeit als bei anderen Gewindebohrern dank größerer Kerndicke.

DIN 376

Hole type
3.0×D





Material groups GS | HSS-E | DIN 376 | 6H | 60° | B | Bright | p.B309

Recommended ToolHolder: Plain Shank — TAPPING ER CHUCK, TAPPING CHUCK, ONE STEP TAPPING CHUCK

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	Bright	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M3	× 0.5	**TC227206**	11	56	18	2.2	1.8	5	3	2.5
M3.5	× 0.6	**TC227226**	12	56	20	2.5	2.1	5	3	2.9
M4	× 0.7	**TC227246**	13	63	21	2.8	2.1	5	3	3.3
M4.5	× 0.75	**TC227266**	14	70	25	3.5	2.7	6	3	3.7
M5	× 0.8	**TC227286**	15	70	25	3.5	2.7	6	3	4.2
M6	× 1.0	**TC227316**	17	80	30	4.5	3.4	6	3	5
M7	× 1.0	**TC227346**	17	80	30	5.5	4.3	7	3	6
M8	× 1.25	**TC227366**	20	90	36	6	4.9	8	3	6.8
M9	× 1.25	**TC227396**	20	90	36	7	5.5	8	3	7.8
M10	× 1.5	**TC227426**	22	100	40	7	5.5	8	3	8.5
M11	× 1.5	**TC227466**	22	100	40	8	6.2	9	3	9.5
M12	× 1.75	**TC227506**	24	110	44	9	7	10	3	10.2
M14	× 2.0	**TC227546**	26	110	44	11	9	12	3	12
M16	× 2.0	**TC227606**	27	110	44	12	9	12	3	14
M18	× 2.5	**TC227656**	30	125	50	14	11	14	4	15.5
M20	× 2.5	**TC227706**	32	140	54	16	12	15	4	17.5
M22	× 2.5	**TC227746**	32	140	54	18	14.5	17	4	19.5
M24	× 3.0	**TC227786**	34	160	60	18	14.5	17	4	21
M27	× 3.0	**TC227866**	36	160	60	20	16	19	4	24
M30	× 3.5	**TC227946**	40	180	70	22	18	21	4	26.5

◎ : 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	400Rm	1050Rm	550	630	400	550
Recommended	○		○	○	◎	○		◎													

YG TAP GENERAL

TD227 SERIES

M ISO metric coarse threads DIN 13

Metrisches ISO-Gewinde DIN 13
ISO MÉTRIQUE DIN13
ISO Metrico passo grosso DIN 13

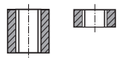
Machine taps
Maschinengewindebohrer

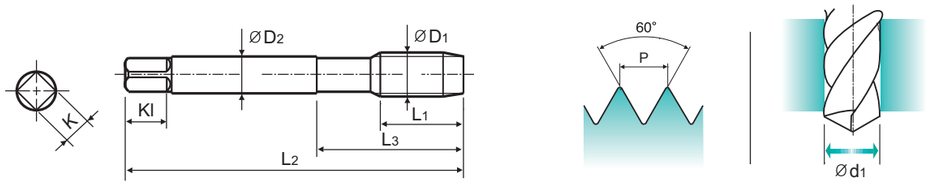
▶ Suitable for through hole in more cutting speed than other taps due to thick web.

▶ Geeignet für Durchgangslöcher in höherer Schnittgeschwindigkeit als bei anderen Gewindebohrern dank größerer Kerndicke.

DIN 376

Hole type
3.0×D





Material groups GS | HSS-E | DIN 376 | 6H | 60° | B | TiN

p.B309

Recommended ToolHolder: Plain Shank — TAPPING ER CHUCK, TAPPING CHUCK, ONE STEP TAPPING CHUCK

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	TiN	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M3	× 0.5	**TD227206**	11	56	18	2.2	1.8	5	3	2.5
M3.5	× 0.6	**TD227226**	12	56	20	2.5	2.1	5	3	2.9
M4	× 0.7	**TD227246**	13	63	21	2.8	2.1	5	3	3.3
M4.5	× 0.75	**TD227266**	14	70	25	3.5	2.7	6	3	3.7
M5	× 0.8	**TD227286**	15	70	25	3.5	2.7	6	3	4.2
M6	× 1.0	**TD227316**	17	80	30	4.5	3.4	6	3	5
M7	× 1.0	**TD227346**	17	80	30	5.5	4.3	7	3	6
M8	× 1.25	**TD227366**	20	90	36	6	4.9	8	3	6.8
M9	× 1.25	**TD227396**	20	90	36	7	5.5	8	3	7.8
M10	× 1.5	**TD227426**	22	100	40	7	5.5	8	3	8.5
M11	× 1.5	**TD227466**	22	100	40	8	6.2	9	3	9.5
M12	× 1.75	**TD227506**	24	110	44	9	7	10	3	10.2
M14	× 2.0	**TD227546**	26	110	44	11	9	12	3	12
M16	× 2.0	**TD227606**	27	110	44	12	9	12	3	14
M18	× 2.5	**TD227656**	30	125	50	14	11	14	4	15.5
M20	× 2.5	**TD227706**	32	140	54	16	12	15	4	17.5
M22	× 2.5	**TD227746**	32	140	54	18	14.5	17	4	19.5
M24	× 3.0	**TD227786**	34	160	60	18	14.5	17	4	21
M27	× 3.0	**TD227866**	36	160	60	20	16	19	4	24
M30	× 3.5	**TD227946**	40	180	70	22	18	21	4	26.5

◎ : 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	400Rm	1050Rm	550	630	400	550
Recommended	○		○	○	◎	○		◎													

YG TAP GENERAL

TC211 SERIES

M ISO metric coarse threads DIN 13

Metrisches ISO-Gewinde DIN 13
ISO MÉTRIQUE DIN13
ISO Metrico passo grosso DIN 13

Machine taps
Maschinengewindebohrer

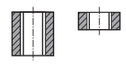
▶ Left spiral flute and right hand thread tap to push chips ahead in powerful than spiral point taps.

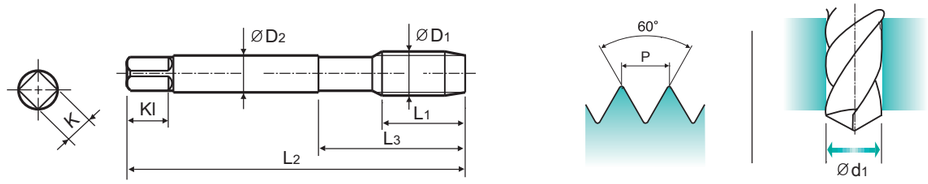
▶ Rechtsschneidender Gewindebohrer mit Linksdrall um kraftvoller nach vorne zu entspanen als mit Gewindebohrern mit Rechtsdrall.

DIN 371

DIN 376

Hole type
3.0×D





Material groups GS | HSS-E | DIN 371/376 | 6H | 60° | C | Bright | L20

p.B309

Recommended ToolHolder: Plain Shank — TAPPING ER CHUCK, TAPPING CHUCK, ONE STEP TAPPING CHUCK

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	Bright	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M2	× 0.4	**TC211136**	8	45	13	2.8	2.1	5	3	1.6
M2.2	× 0.45	**TC211156**	8	45	13	2.8	2.1	5	3	1.75
*M2.3	× 0.4	**TC211196**	8	45	13	2.8	2.1	5	3	1.9
M2.5	× 0.45	**TC211176**	9	50	15	2.8	2.1	5	3	2.05
*M2.6	× 0.45	**TC211496**	9	50	15	2.8	2.1	5	3	2.1
M3	× 0.5	**TC211206**	11	56	18	3.5	2.7	6	3	2.5
M3.5	× 0.6	**TC211226**	12	56	20	4	3	6	3	2.9
M4	× 0.7	**TC211246**	13	63	21	4.5	3.4	6	3	3.3
M4.5	× 0.75	**TC211266**	14	70	25	6	4.9	8	3	3.7
M5	× 0.8	**TC211286**	15	70	25	6	4.9	8	3	4.2
M6	× 1.0	**TC211316**	17	80	30	6	4.9	8	3	5
M7	× 1.0	**TC211346**	17	80	30	7	5.5	8	3	6
M8	× 1.25	**TC211366**	20	90	35	8	6.2	9	3	6.8
M9	× 1.25	**TC211396**	20	90	35	9	7	10	3	7.8
M10	× 1.5	**TC211426**	22	100	39	10	8	11	3	8.5
M11	× 1.5	**TC211466**	22	100	40	8	6.2	9	3	9.5
M12	× 1.75	**TC211506**	24	110	44	9	7	10	3	10.2
M14	× 2.0	**TC211546**	26	110	44	11	9	12	3	12
M16	× 2.0	**TC211606**	27	110	44	12	9	12	3	14
M18	× 2.5	**TC211656**	30	125	50	14	11	14	4	15.5
M20	× 2.5	**TC211706**	32	140	54	16	12	15	4	17.5
M22	× 2.5	**TC211746**	32	140	54	18	14.5	17	4	19.5
M24	× 3.0	**TC211786**	34	160	60	18	14.5	17	4	21
M27	× 3.0	**TC211866**	36	160	60	20	16	19	4	24
M30	× 3.5	**TC211946**	40	180	70	22	18	21	4	26.5

▶ DIN 371(M2~M10) and DIN 376(M11~M30)
▶ * 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			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	○		○	○	◎	○		◎													

YG TAP GENERAL

TC463 SERIES

M ISO metric coarse threads DIN 13

Metrisches ISO-Gewinde DIN 13
ISO MÉTRIQUE DIN13
ISO Metrico passo grosso DIN 13

Machine taps
Maschinengewindebohrer

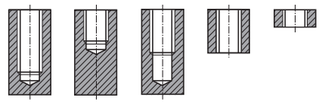
▶ Suitable for tapping shallow holes and the blind holes having enough chip space at the bottom of holes.

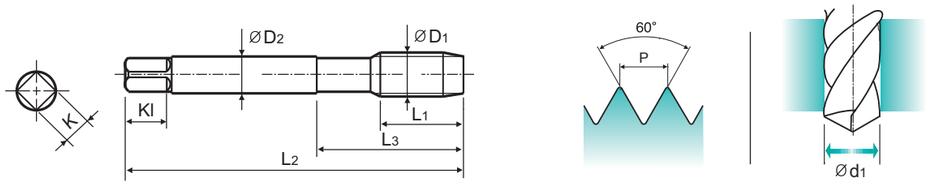
▶ Geeignet zum Schneiden von kurzem Durchgangsgewinde und in Sacklöchern mit ausreichendem Raum für Späne am Bohrungsgrund.

DIN 371

DIN 376

Hole type
2.0×D





Material groups **GS** | HSS-E | DIN 371/376 | 6H | 60° | C | Bright | p.B309

Recommended ToolHolder: Plain Shank — TAPPING ER CHUCK, TAPPING CHUCK, ONE STEP TAPPING CHUCK

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	Bright	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M2	× 0.4	**TC463136**	8	45	13	2.8	2.1	5	3	1.6
M2.2	× 0.45	**TC463156**	8	45	13	2.8	2.1	5	3	1.75
*M2.3	× 0.4	**TC463196**	8	45	13	2.8	2.1	5	3	1.9
M2.5	× 0.45	**TC463176**	9	50	15	2.8	2.1	5	3	2.05
*M2.6	× 0.45	**TC463496**	9	50	15	2.8	2.1	5	3	2.1
M3	× 0.5	**TC463206**	11	56	18	3.5	2.7	6	3	2.5
M3.5	× 0.6	**TC463226**	12	56	20	4	3	6	3	2.9
M4	× 0.7	**TC463246**	13	63	21	4.5	3.4	6	3	3.3
M4.5	× 0.75	**TC463266**	14	70	25	6	4.9	8	3	3.7
M5	× 0.8	**TC463286**	15	70	25	6	4.9	8	3	4.2
M6	× 1.0	**TC463316**	17	80	30	6	4.9	8	3	5
M7	× 1.0	**TC463346**	17	80	30	7	5.5	8	3	6
M8	× 1.25	**TC463366**	20	90	35	8	6.2	9	3	6.8
M9	× 1.25	**TC463396**	20	90	35	9	7	10	3	7.8
M10	× 1.5	**TC463426**	22	100	39	10	8	11	3	8.5
M11	× 1.5	**TC463466**	22	100	40	8	6.2	9	3	9.5
M12	× 1.75	**TC463506**	24	110	44	9	7	10	3	10.2
M14	× 2.0	**TC463546**	26	110	44	11	9	12	3	12
M16	× 2.0	**TC463606**	27	110	44	12	9	12	3	14
M18	× 2.5	**TC463656**	30	125	50	14	11	14	4	15.5
M20	× 2.5	**TC463706**	32	140	54	16	12	15	4	17.5
M22	× 2.5	**TC463746**	32	140	54	18	14.5	17	4	19.5
M24	× 3.0	**TC463786**	34	160	60	18	14.5	17	4	21
M27	× 3.0	**TC463866**	36	160	60	20	16	19	4	24
M30	× 3.5	**TC463946**	40	180	70	22	18	21	4	26.5

▶ DIN 371(M2~M10) and DIN 376(M11~M30)
▶ * 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			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					○	○	○														

YG TAP GENERAL

TC473 SERIES

MF ISO metric fine threads DIN 13

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

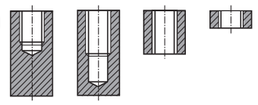
Machine taps
Maschinengewindebohrer

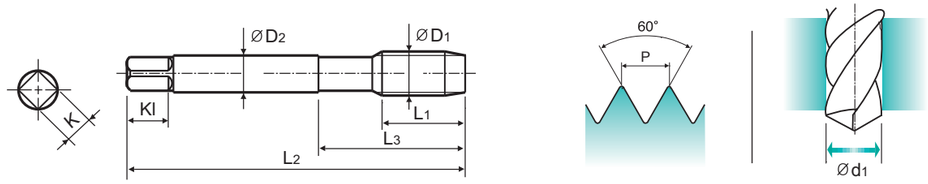
▶ Suitable for tapping shallow holes.

▶ Geeignet zum Gewindeschneiden flacher Sacklöcher.

DIN 374

Hole type
2.0×D





Material groups **GS** | HSS-E | DIN 374 | 6H | 60° | C | Bright | p.B309

Recommended ToolHolder: Plain Shank — TAPPING ER CHUCK, TAPPING CHUCK, ONE STEP TAPPING CHUCK

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	Bright	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M4	× 0.5	**TC473256**	10	63	21	2.8	2.1	5	3	3.5
M5	× 0.5	**TC473296**	11	70	25	3.5	2.7	6	3	4.5
M6	× 0.75	**TC473326**	13	80	30	4.5	3.4	6	3	5.2
M6	× 0.5	**TC473336**	13	80	30	4.5	3.4	6	3	5.5
M7	× 0.75	**TC473356**	14	80	30	5.5	4.3	7	3	6.2
M8	× 1.0	**TC473376**	17	90	36	6	4.9	8	3	7
M8	× 0.75	**TC473386**	14	80	30	6	4.9	8	3	7.2
M8	× 0.5	**TC473936**	14	80	30	6	4.9	8	3	7.5
M10	× 1.25	**TC473436**	22	100	40	7	5.5	8	3	8.8
M10	× 1.0	**TC473446**	18	90	36	7	5.5	8	3	9
M10	× 0.75	**TC473456**	18	90	36	7	5.5	8	3	9.2
M12	× 1.5	**TC473516**	22	100	40	9	7	10	3	10.5
M12	× 1.25	**TC473526**	22	100	40	9	7	10	3	10.8
M12	× 1.0	**TC473536**	18	100	40	9	7	10	3	11
M14	× 1.5	**TC473556**	22	100	40	11	9	12	3	12.5
M14	× 1.25	**TC473566**	22	100	40	11	9	12	3	12.8
M14	× 1.0	**TC473576**	18	100	40	11	9	12	3	13
M16	× 1.5	**TC473616**	22	100	40	12	9	12	3	14.5
M18	× 1.5	**TC473676**	25	110	44	14	11	14	4	16.5
M20	× 1.5	**TC473726**	25	125	50	16	12	15	4	18.5
M22	× 1.5	**TC473766**	25	125	50	18	14.5	17	4	20.5
M24	× 1.5	**TC473806**	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	400Rm	1050Rm	550	630	400	550
Recommended					○	○	○														

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
TECHNICAL DATA

YG TAP GENERAL

TC424 SERIES

UNC Unified coarse threads

- Unified Grobgewinde
- UNC
- Unificato passo grosso

Machine taps
Maschinengewindebohrer

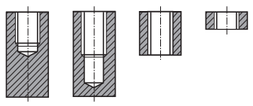
▶ Suitable for tapping shallow holes.

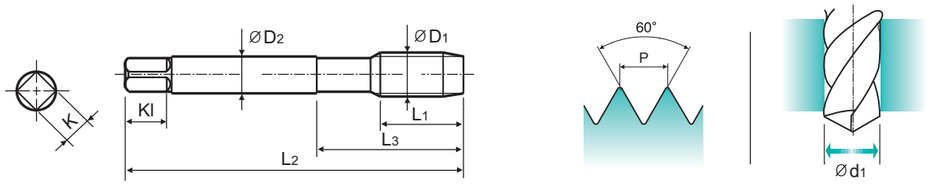
▶ Geeignet zum Gewindeschneiden flacher Sacklöcher.

DIN 371

DIN 376

Hole type
2.0×D





Material groups **GS** | HSS-E | DIN 371/376 | 2B | 60° | C | Bright | p.B309

Recommended ToolHolder: Plain Shank — TAPPING ER CHUCK, TAPPING CHUCK, ONE STEP TAPPING CHUCK

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		Bright	L1	L2	L3	ØD2	K	Kl	Z	Ød1
#4 -	40UNC	TC424162	11	56	18	3.5	2.7	6	3	2.3
#5 -	40UNC	TC424202	11	56	18	3.5	2.7	6	3	2.6
#6 -	32UNC	TC424242	12	56	20	4	3	6	3	2.85
#8 -	32UNC	TC424282	13	63	21	4.5	3.4	6	3	3.5
#10 -	24UNC	TC424322	15	70	25	6	4.9	8	3	3.9
#12 -	24UNC	TC424362	16	80	30	6	4.9	8	3	4.5
1/4 -	20UNC	TC424402	17	80	30	7	5.5	8	3	5.2
5/16 -	18UNC	TC424442	20	90	35	8	6.2	9	3	6.6
3/8 -	16UNC	TC424482	22	100	39	9	7	10	3	8
7/16 -	14UNC	TC424522	22	100	40	8	6.2	9	3	9.4
1/2 -	13UNC	TC424562	25	110	44	9	7	10	3	10.75
9/16 -	12UNC	TC424602	26	110	44	11	9	12	3	12.25
5/8 -	11UNC	TC424642	27	110	44	12	9	12	3	13.5
3/4 -	10UNC	TC424702	30	125	50	14	11	14	4	16.5
7/8 -	9UNC	TC424742	32	140	54	18	14.5	17	4	19.5
1 -	8UNC	TC424782	36	160	60	20	16	19	4	22.25
1-1/8 -	7UNC	TC424822	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	400Rm	1050Rm	550	630	400	550
Recommended					○	○	○														

phone:+82-32-526-0909, www.yg1.solutions, E-mail:yg1@yg1.solutions
YG-1 CO., LTD.

YG TAP GENERAL

T7109 SERIES

M ISO metric coarse threads DIN 13

- Metrisches ISO-Gewinde DIN 13
- ISO MÉTRIQUE DIN13
- ISO Metrico passo grosso DIN 13

Sets of taps
Gewindebohrer -Satz

▶ This tap is a serial hand tap in set, First, Second and Bottoming.
▶ Bottoming tap of set has final internal thread dimensions only.

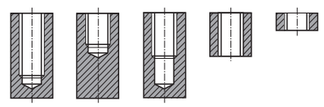
▶ Dies ist ein Handgewindebohrer im Satz mit Vor-, Mittel- und Fertigschneider.
▶ Nur der Fertigschneider kann das gewünschte Gewinde schneiden

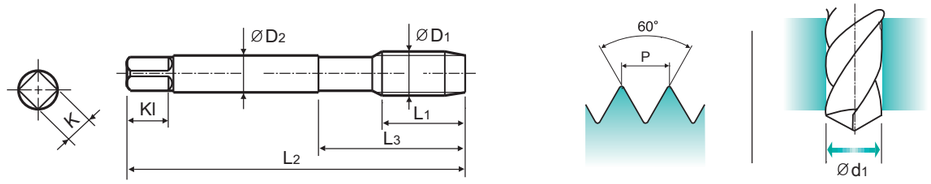
First

Second

Bottoming

Hole type
2.0×D





Material groups **GS** | HSS | DIN 352 | 6H | 60° | I/II/III | Bright | p.B309

Recommended ToolHolder: Plain Shank — TAPPING ER CHUCK, TAPPING CHUCK, ONE STEP TAPPING CHUCK

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	Bright	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M2	× 0.4	T7109139	8	36	13	2.8	2.1	5	3	1.6
M2.2	× 0.45	T7109159	9	36	13	2.8	2.1	5	3	1.75
*M2.3	× 0.4	T7109199	9	36	13	2.8	2.1	5	3	1.9
M2.5	× 0.45	T7109179	9	40	15	2.8	2.1	5	3	2.05
*M2.6	× 0.45	T7109499	9	40	15	2.8	2.1	5	3	2.1
M3	× 0.5	T7109209	11	40	18	3.5	2.7	6	3	2.5
M3.5	× 0.6	T7109229	13	45	21	4	3	6	3	2.9
M4	× 0.7	T7109249	13	45	21	4.5	3.4	6	3	3.3
M4.5	× 0.75	T7109269	16	50	25	6	4.9	8	3	3.7
M5	× 0.8	T7109289	16	52	26	6	4.9	8	3	4.2
M5.5	× 0.9	T7109N69	18	56	27	6	4.9	8	3	4.6
M6	× 1.0	T7109319	18	56	27	6	4.9	8	3	5
M7	× 1.0	T7109349	18	56	28.5	6	4.9	8	3	6
M8	× 1.25	T7109369	20	63	34	6	4.9	8	3	6.8
M9	× 1.25	T7109399	20	63	34	7	5.5	8	4	7.8
M10	× 1.5	T7109429	22	70	38	7	5.5	8	4	8.5
M11	× 1.5	T7109469	22	70	38	8	6.2	9	4	9.5
M12	× 1.75	T7109509	24	80	45	9	7	10	4	10.2
M14	× 2.0	T7109549	26	80	45	11	9	12	4	12
M16	× 2.0	T7109609	27	80	45	12	9	12	4	14
M18	× 2.5	T7109659	30	95	58	14	11	14	4	15.5
M20	× 2.5	T7109709	32	95	58	16	12	15	4	17.5

▶ *DIN profile not ISO

▶ NEXT PAGE

◎ : 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	400Rm	1050Rm	550	630	400	550
Recommended					○	○	○														

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phone:+82-32-526-0909, www.yg1.solutions, E-mail:yg1@yg1.solutions

YG TAP GENERAL

T7109 SERIES

M — ISO metric coarse threads DIN 13

- Metrisches ISO-Gewinde DIN 13
- ISO MÉTRIQUE DIN13
- ISO Metrico passo grosso DIN 13

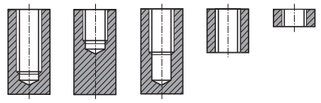
Sets of taps
Gewindebohrer-Satz

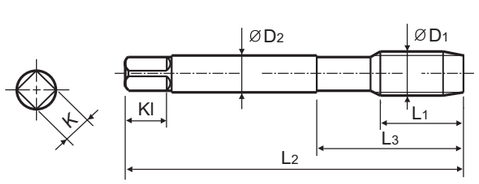
▶ This tap is a serial hand tap in set, First, Second and Bottoming.
▶ Bottoming tap of set has final internal thread dimensions only.

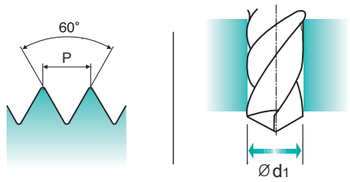
▶ Dies ist ein Handgewindebohrer im Satz mit Vor-, Mittel- und Fertigschneider.
▶ Nur der Fertigschneider kann das gewünschte Gewinde schneiden.

First
Second
Bottoming

Hole type
2.0×D







Material groups **GS** | HSS | DIN 352 | 6H | 60° | I/II/III | Bright | p.B309

Recommended ToolHolder: Plain Shank — TAPPING ER CHUCK, TAPPING CHUCK, ONE STEP TAPPING CHUCK

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	Bright	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M22	× 2.5	**T7109749**	32	100	62	18	14.5	17	4	19.5
M24	× 3.0	**T7109789**	34	110	69	18	14.5	17	4	21
M27	× 3.0	**T7109869**	36	110	69	20	16	19	4	24
M30	× 3.5	**T7109949**	40	125	77	22	18	21	4	26.5
M33	× 3.5	**T7109A49**	40	125	77	25	20	23	4	29.5
M36	× 4.0	**T7109B39**	50	150	88	28	22	25	4	32
M39	× 4.0	**T7109C09**	50	150	88	32	24	27	4	35
M42	× 4.5	**T7109C89**	56	150	88	32	24	27	4	37.5
M45	× 4.5	**T7109D59**	58	160	93	36	29	32	4	40.5
M48	× 5.0	**T7109E29**	65	180	102	36	29	32	4	43
M52	× 5.0	**T7109F39**	65	180	102	40	32	35	4	47

▶ *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			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					○	○	○														

YG TAP GENERAL

T7309 SERIES

MF — ISO metric fine threads DIN 13

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

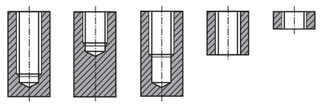
Sets of taps
Gewindebohrer-Satz

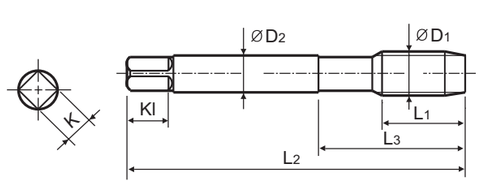
▶ This tap is a serial hand tap in set, First and Bottoming.
▶ Bottoming tap of set has final internal thread dimensions only.

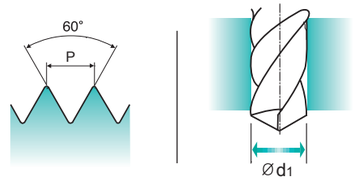
▶ Handgewindebohrersatz mit Vor- und Fertigschneider.
▶ Nur der Fertigschneider kann das gewünschte Gewinde schneiden.

First
Bottoming

Hole type
2.0×D







Material groups **GS** | HSS | DIN 2181 | 6H | 60° | I/III | Bright | p.B309

Recommended ToolHolder: Plain Shank — TAPPING ER CHUCK, TAPPING CHUCK, ONE STEP TAPPING CHUCK

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	Bright	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M3	× 0.35	**T7309219**	9	40	18	3.5	2.7	6	3	2.65
M4	× 0.5	**T7309259**	10	45	18	4.5	3.4	6	3	3.5
M5	× 0.5	**T7309299**	13	52	22	6	4.9	8	3	4.5
M6	× 0.75	**T7309329**	14	56	24	6	4.9	8	3	5.2
M6	× 0.5	**T7309339**	13	56	24	6	4.9	8	3	5.5
M7	× 0.75	**T7309359**	14	56	27	6	4.9	8	3	6.2
M8	× 1.0	**T7309379**	17	63	27	6	4.9	8	3	7
M8	× 0.75	**T7309389**	14	63	27	6	4.9	8	3	7.2
M8	× 0.5	**T7309939**	14	63	27	6	4.9	8	3	7.5
M9	× 1.0	**T7309409**	17	63	27	7	5.5	8	4	8
M10	× 1.25	**T7309439**	22	70	32	7	5.5	8	4	8.8
M10	× 1.0	**T7309449**	18	63	27	7	5.5	8	4	9
M10	× 0.75	**T7309459**	18	63	27	7	5.5	8	4	9.2
M11	× 1.0	**T7309479**	18	63	27	8	6.2	9	4	10
M12	× 1.5	**T7309519**	20	70	32	9	7	10	4	10.5
M12	× 1.25	**T7309529**	20	70	32	9	7	10	4	10.8
M12	× 1.0	**T7309539**	18	70	32	9	7	10	4	11
M13	× 1.5	**T7309N19**	20	70	32	11	9	12	4	11.5
M13	× 1.0	**T7309N29**	18	70	32	11	9	12	4	12
M14	× 1.5	**T7309559**	20	70	32	11	9	12	4	12.5
M14	× 1.25	**T7309569**	20	70	32	11	9	12	4	12.8
M14	× 1.0	**T7309579**	18	70	32	11	9	12	4	13
M15	× 1.5	**T7309589**	20	70	32	12	9	12	4	13.5
M15	× 1.0	**T7309599**	18	70	32	12	9	12	4	14
M16	× 1.5	**T7309619**	20	70	32	12	9	12	4	14.5

▶ NEXT PAGE

◎ : 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	400Rm	1050Rm	550	630	400	550
Recommended					○	○	○														

YG TAP GENERAL

T7309 SERIES

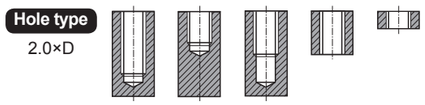
MF ISO metric fine threads DIN 13

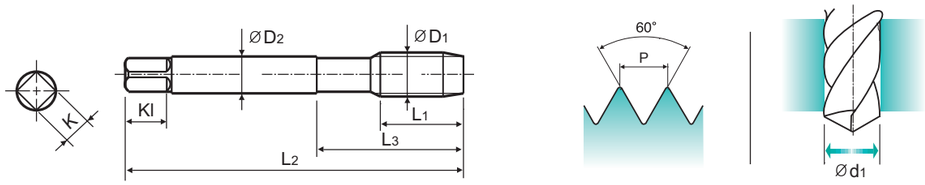
Metrisches ISO-Feingewinde DIN 13
ISO MÉTRIQUE PAS FINS DIN13
ISO Metrico passo fine DIN 13

Sets of taps
Gewindebohrer-Satz

▶ This tap is a serial hand tap in set, First and Bottoming.
▶ Bottoming tap of set has final internal thread dimensions only.

▶ Handgewindebohrersatz mit Vor- und Fertigschneider.
▶ Nur der Fertigschneider kann das gewünschte Gewinde schneiden.





Material groups **GS** | HSS | DIN 2181 | 6H | 60° | I/III | Bright | p.B309

Recommended ToolHolder: Plain Shank — TAPPING ER CHUCK, TAPPING CHUCK, ONE STEP TAPPING CHUCK

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	Bright	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M16	× 1.0	T7309629	18	70	32	12	9	12	4	15
M18	× 2.0	T7309669	22	80	35	14	11	14	4	16
M18	× 1.5	T7309679	22	80	35	14	11	14	4	16.5
M18	× 1.0	T7309689	18	80	35	14	11	14	4	17
M20	× 2.0	T7309719	22	80	35	16	12	15	4	18
M20	× 1.5	T7309729	22	80	35	16	12	15	4	18.5
M20	× 1.0	T7309739	18	80	35	16	12	15	4	19
M22	× 2.0	T7309759	22	80	35	18	14.5	17	4	20
M22	× 1.5	T7309769	22	80	35	18	14.5	17	4	20.5
M22	× 1.0	T7309779	18	80	35	18	14.5	17	4	21
M24	× 2.0	T7309799	22	90	40	18	14.5	17	4	22
M24	× 1.5	T7309809	22	90	40	18	14.5	17	4	22.5
M24	× 1.0	T7309819	18	90	40	18	14.5	17	4	23
M25	× 1.5	T7309839	22	90	40	18	14.5	17	4	23.5
M25	× 1.0	T7309849	18	90	40	18	14.5	17	4	24
M26	× 1.5	T7309859	22	90	40	18	14.5	17	4	24.5
M26	× 1.0	T7309N59	18	90	40	18	14.5	17	4	25
M27	× 2.0	T7309879	22	90	40	20	16	19	4	25
M27	× 1.5	T7309889	22	90	40	20	16	19	4	25.5
M27	× 1.0	T7309899	18	90	40	20	16	19	4	26
M28	× 2.0	T7309909	22	90	40	20	16	19	4	26
M28	× 1.5	T7309919	22	90	40	20	16	19	4	26.5
M30	× 2.0	T7309969	22	90	40	22	18	21	4	28
M30	× 1.5	T7309979	22	90	40	22	18	21	4	28.5
M30	× 1.0	T7309989	18	90	40	22	18	21	4	29

◎ : 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	400Rm	1050Rm	550	630	400	550
Recommended					○	○	○														

phone:+82-32-526-0909, www.yg1.solutions, E-mail:yg1@yg1.solutions
YG-1 CO., LTD.

YG TAP GENERAL

T7363 SERIES

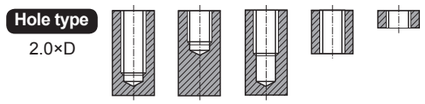
UNC Unified coarse threads

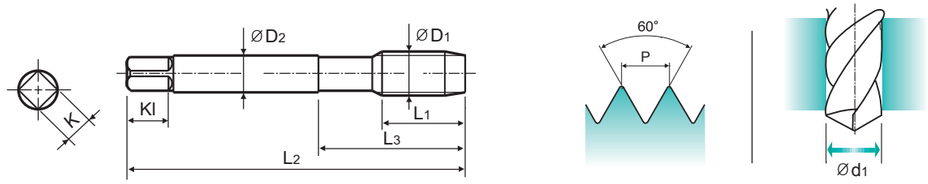
Unified Grobgewinde
UNC
Unificato passo grosso

Sets of taps
Gewindebohrer-Satz

▶ This tap is a serial hand tap in set, First, Second and Bottoming.
▶ Bottoming tap of set has final internal thread dimensions only.

▶ Dies ist ein Handgewindebohrer im Satz mit Vor-, Mittel- und Fertigschneider.
▶ Nur der Fertigschneider kann das gewünschte Gewinde schneiden.





Material groups **GS** | HSS | DIN 351 | 2B | 60° | I/II/III | Bright | p.B309

Recommended ToolHolder: Plain Shank — TAPPING ER CHUCK, TAPPING CHUCK, ONE STEP TAPPING CHUCK

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			Bright	L1	L2	L3	ØD2	K	Kl	Z	Ød1
#2	-	56UNC	T7363089	9	36	13	2.8	2.1	5	3	1.8
#3	-	48UNC	T7363129	10	40	15	2.8	2.1	5	3	2.1
#4	-	40UNC	T7363169	10	42	18	3.5	2.7	6	3	2.3
#5	-	40UNC	T7363209	10	42	18	3.5	2.7	6	3	2.6
#6	-	32UNC	T7363249	11	45	18	4	3	6	3	2.85
#8	-	32UNC	T7363289	12	48	23	4.5	3.4	6	3	3.5
#10	-	24UNC	T7363329	14	52	26	6	4.9	6	3	3.9
#12	-	24UNC	T7363369	16	56	27	6	4.9	8	3	4.5
1/4	-	20UNC	T7363409	16	56	27	6	4.9	8	3	5.2
5/16	-	18UNC	T7363449	20	63	34	6	4.9	8	3	6.6
3/8	-	16UNC	T7363489	22	70	38	7	5.5	8	4	8
7/16	-	14UNC	T7363529	22	70	38	8	6.2	9	4	9.4
1/2	-	13UNC	T7363569	25	80	45	9	7	10	4	10.75
9/16	-	12UNC	T7363609	26	80	45	11	9	12	4	12.25
5/8	-	11UNC	T7363649	27	90	55	12	9	12	4	13.5
3/4	-	10UNC	T7363709	32	105	65	14	11	14	4	16.5
7/8	-	9UNC	T7363749	32	110	69	18	14.5	17	4	19.5
1	-	8UNC	T7363789	36	110	69	20	16	19	4	22.25
1-1/8	-	7UNC	T7363829	40	125	77	22	18	21	4	25
1-1/4	-	7UNC	T7363869	40	125	77	25	20	23	4	28.25
1-1/8	-	6UNC	T7363909	50	150	88	28	22	25	4	30.75
1-1/2	-	6UNC	T7363949	50	150	88	32	24	27	4	34
1-3/4	-	5UNC	T7363B89	58	160	93	36	29	32	4	39.5
2	-	4½UNC	T7363D29	65	180	102	40	32	35	4	45.25

◎ : 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	400Rm	1050Rm	550	630	400	550
Recommended					○	○	○														

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phone:+82-32-526-0909, www.yg1.solutions, E-mail:yg1@yg1.solutions

YG TAP GENERAL

T7509 SERIES

UNF

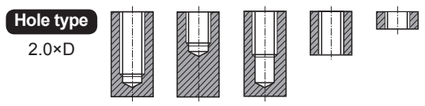
Unified fine threads

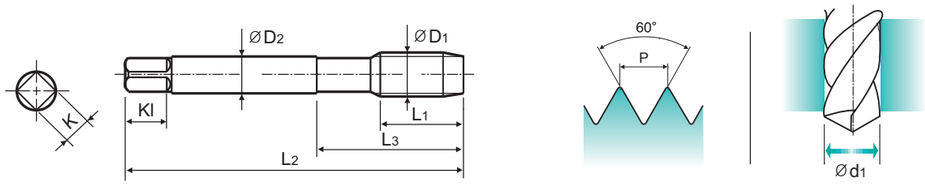
- Unified Feingewinde
- UNF
- Unificato passo fine

Sets of taps
Gewindebohrer-Satz

▶ This tap is a serial hand tap in set, First and Bottoming.
▶ Bottoming tap of set has final internal thread dimensions only.

▶ Handgewindebohrersatz mit Vor- und Fertigschneider.
▶ Nur der Fertigschneider kann das gewünschte Gewinde schneiden.





Material groups **GS** | HSS | DIN 2181 | 2B | 60° | I/III | Bright | p.B309

Recommended ToolHolder: Plain Shank — TAPPING ER CHUCK, TAPPING CHUCK, ONE STEP TAPPING CHUCK

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		Bright	L1	L2	L3	ØD2	K	Kl	Z	Ød1
#4 -	48 UNF	T7509189	10	42	18	3.5	2.7	6	3	2.4
#5 -	44 UNF	T7509229	10	42	18	3.5	2.7	6	3	2.7
#6 -	40 UNF	T7509269	11	45	18	4	3	6	3	3
#8 -	36 UNF	T7509309	12	48	23	4.5	3.4	6	3	3.5
#10 -	32 UNF	T7509349	14	52	22	6	4.9	8	3	4.1
#12 -	28 UNF	T7509389	16	56	24	6	4.9	8	3	4.7
1/4 -	28 UNF	T7509429	16	56	24	6	4.9	8	3	5.5
5/16 -	24 UNF	T7509469	17	63	27	6	4.9	8	3	6.9
3/8 -	24 UNF	T7509509	18	63	27	7	5.5	8	4	8.5
7/16 -	20 UNF	T7509549	20	70	32	8	6.2	9	4	9.9
1/2 -	20 UNF	T7509589	20	70	32	9	7	10	4	11.5
9/16 -	18 UNF	T7509629	20	70	32	11	9	12	4	12.9
5/8 -	18 UNF	T7509669	20	70	32	12	9	12	4	14.5
3/4 -	16 UNF	T7509729	22	80	38	14	11	14	4	17.5
7/8 -	14 UNF	T7509769	22	80	38	18	14.5	17	4	20.5
1 -	12 UNF	T7509809	22	90	40	18	14.5	17	4	23.25
1-1/8 -	12 UNF	T7509849	22	90	40	22	18	21	4	26.5

◎ : 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	400Rm	1050Rm	550	630	400	550
Recommended					○	○	○														

YG TAP GENERAL

T7609 SERIES

BSW

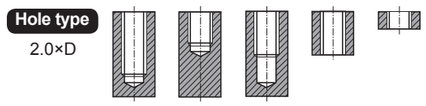
Whitworth threads

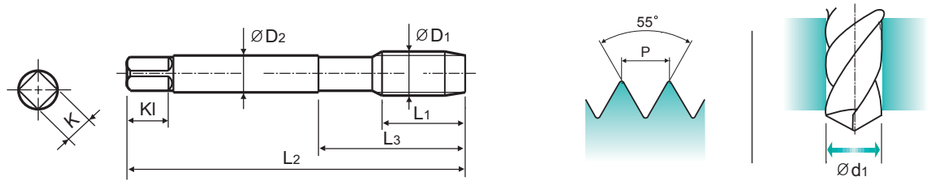
- Whitworth Gewinde
- BSW
- Filettatura Whitworth

Sets of taps
Gewindebohrer-Satz

▶ This tap is a serial hand tap in set, First, Second and Bottoming.
▶ Bottoming tap of set has final internal thread dimensions only.

▶ Dies ist ein Handgewindebohrer im Satz mit Vor-, Mittel- und Fertigschneider.
▶ Nur der Fertigschneider kann das gewünschte Gewinde schneiden.





Material groups **GS** | HSS | DIN 351 | 55° | I/II/III | Bright | p.B309

Recommended ToolHolder: Plain Shank — TAPPING ER CHUCK, TAPPING CHUCK, ONE STEP TAPPING CHUCK

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		Bright	L1	L2	L3	ØD2	K	Kl	Z	Ød1
W3/32 -	48	T7609129	10	40	15	2.8	2.1	5	3	1.8
W1/8 -	40	T7609209	10	42	18	3.5	2.7	6	3	2.5
W5/32 -	32	T7609289	12	48	23	4.5	3.4	6	3	3.1
W3/16 -	24	T7609329	14	52	26	6	4.9	8	3	3.6
W7/32 -	24	T7609369	16	56	27	6	4.9	8	3	4.4
W1/4 -	20	T7609409	16	56	27	6	4.9	8	3	5.1
W5/16 -	18	T7609449	20	63	34	6	4.9	8	3	6.5
W3/8 -	16	T7609489	22	70	38	7	5.5	8	4	7.9
W7/16 -	14	T7609529	22	70	38	8	6.2	9	4	9.3
W1/2 -	12	T7609569	25	80	45	9	7	10	4	10.5
W9/16 -	12	T7609609	26	80	45	11	9	12	4	12
W5/8 -	11	T7609649	27	90	55	12	9	12	4	13.5
W3/4 -	10	T7609709	32	105	65	14	11	14	4	16.5
W7/8 -	9	T7609749	32	110	69	18	14.5	17	4	19.25
W1 -	8	T7609789	36	110	69	20	16	19	4	22
W1-1/8 -	7	T7609829	40	125	77	22	18	21	4	24.75
W1-1/4 -	7	T7609869	40	125	77	25	20	23	4	27.75
W1-3/8 -	6	T7609909	50	150	88	28	22	25	4	30.5
W1-1/2 -	6	T7609949	50	150	88	32	24	27	4	33.5
W1-5/8 -	5	T7609B29	56	150	88	32	24	27	4	35.5
W1-3/4 -	5	T7609B89	58	160	93	36	29	32	4	39
W1-7/8 -	4½	T7609C69	65	180	102	36	29	32	4	41.5
W2 -	4½	T7609D29	65	180	102	40	32	35	4	44.5

◎ : 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	400Rm	1050Rm	550	630	400	550
Recommended					○	○	○														

YG TAP GENERAL

T7343 SERIES

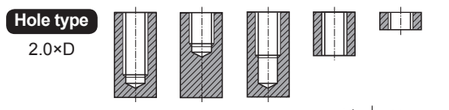
M-LH ISO metric coarse threads DIN 13

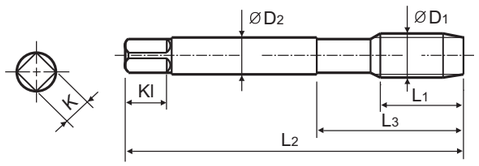
Metrisches ISO-Gewinde DIN 13
ISO MÉTRIQUE DIN13
ISO Metrico passo grosso DIN 13

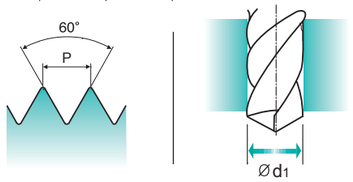
Sets of taps
Gewindebohrer-Satz

▶ This tap is a serial hand tap in set, First, Second and Bottoming.
▶ Bottoming tap of set has final internal thread dimensions only.

▶ Dies ist ein Handgewindebohrer im Satz mit Vor-, Mittel- und Fertigschneider.
▶ Nur der Fertigschneider kann das gewünschte Gewinde schneiden.







Material groups **GS** | HSS | DIN 352 | 6H | 60° | I/II/III | Bright | p.B309

Recommended ToolHolder: Plain Shank — TAPPING ER CHUCK, TAPPING CHUCK, ONE STEP TAPPING CHUCK

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	Bright	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M3	× 0.5	**T7343209**	11	40	18	3.5	2.7	6	3	2.5
M3.5	× 0.6	**T7343229**	13	45	21	4	3	6	3	2.9
M4	× 0.7	**T7343249**	13	45	21	4.5	3.4	6	3	3.3
M4.5	× 0.75	**T7343269**	16	50	25	6	4.9	8	3	3.7
M5	× 0.8	**T7343289**	16	52	26	6	4.9	8	3	4.2
M6	× 1.0	**T7343319**	18	56	27	6	4.9	8	3	5
M8	× 1.25	**T7343369**	20	63	34	6	4.9	8	3	6.8
M10	× 1.5	**T7343429**	22	70	38	7	5.5	8	4	8.5
M12	× 1.75	**T7343509**	24	80	45	9	7	10	4	10.2
M14	× 2.0	**T7343549**	26	80	45	11	9	12	4	12
M16	× 2.0	**T7343609**	27	80	45	12	9	12	4	14
M18	× 2.5	**T7343659**	30	95	58	14	11	14	4	15.5
M20	× 2.5	**T7343709**	32	95	58	16	12	15	4	17.5
M22	× 2.5	**T7343749**	32	100	62	18	14.5	17	4	19.5
M24	× 3.0	**T7343789**	34	110	69	18	14.5	17	4	21
M27	× 3.0	**T7343869**	36	110	69	20	16	19	4	24
M30	× 3.5	**T7343949**	40	125	77	22	18	21	4	26.5

▶ LH=Left hand thread

◎ : 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	400Rm	1050Rm	550	630	400	550
Recommended					○	○	○														

YG TAP GENERAL

TB373 SERIES

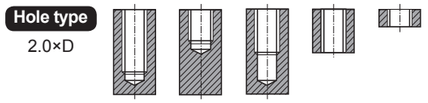
M ISO metric coarse threads DIN 13

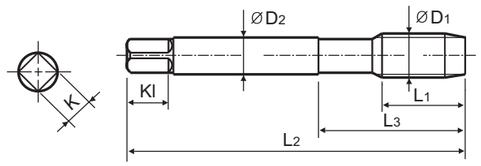
Metrisches ISO-Gewinde DIN 13
ISO MÉTRIQUE DIN13
ISO Metrico passo grosso DIN 13

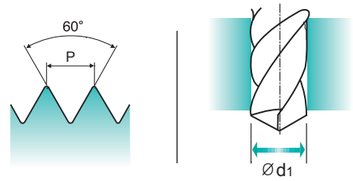
Sets of taps
Gewindebohrer-Satz

▶ This tap is a serial hand tap in set, First, Second and Bottoming.
▶ Bottoming tap of set has final internal thread dimensions only.

▶ Dies ist ein Handgewindebohrer im Satz mit Vor-, Mittel- und Fertigschneider.
▶ Nur der Fertigschneider kann das gewünschte Gewinde schneiden.







Material groups **GS** | HSS-E | DIN 352 | 6HX | 60° | I/II/III | Vap | p.B309

Recommended ToolHolder: Plain Shank — TAPPING ER CHUCK, TAPPING CHUCK, ONE STEP TAPPING CHUCK

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	Kl	Z	Ød1
M3	× 0.5	**TB373209**	11	40	18	3.5	2.7	6	3	2.5
M3.5	× 0.6	**TB373229**	13	45	21	4	3	6	3	2.9
M4	× 0.7	**TB373249**	13	45	21	4.5	3.4	6	3	3.3
M4.5	× 0.75	**TB373269**	16	50	25	6	4.9	8	3	3.7
M5	× 0.8	**TB373289**	16	52	26	6	4.9	8	3	4.2
M6	× 1.0	**TB373319**	18	56	27	6	4.9	8	3	5
M8	× 1.25	**TB373369**	20	63	34	6	4.9	8	3	6.8
M10	× 1.5	**TB373429**	22	70	38	7	5.5	8	4	8.5
M12	× 1.75	**TB373509**	24	80	45	9	7	10	4	10.2
M14	× 2.0	**TB373549**	26	80	45	11	9	12	4	12
M16	× 2.0	**TB373609**	27	80	45	12	9	12	4	14
M18	× 2.5	**TB373659**	30	95	58	14	11	14	4	15.5
M20	× 2.5	**TB373709**	32	95	58	16	12	15	4	17.5

▶ First with pilot guide

◎ : 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	400Rm	1050Rm	550	630	400	550
Recommended																						

YG TAP GENERAL

TC353 SERIES

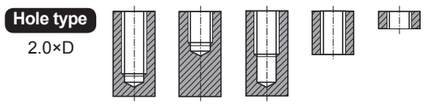
M ISO metric coarse threads DIN 13

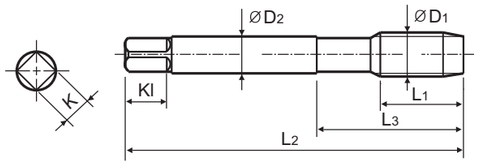
Metrisches ISO-Gewinde DIN 13
ISO MÉTRIQUE DIN13
ISO Metrico passo grosso DIN 13

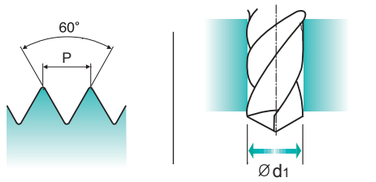
Sets of taps
Gewindebohrer-Satz

▶ This tap is a serial hand tap in set, First, Second and Bottoming.
▶ Bottoming tap of set has final internal thread dimensions only..

▶ Dies ist ein Handgewindebohrer im Satz mit Vor-, Mittel- und Fertigschneider.
▶ Nur der Fertigschneider kann das gewünschte Gewinde schneiden.







Material groups VG | HSS-E | DIN 352 | 6H | 60° | I/II/III | Bright | p.B309

Recommended Toolholder: Plain Shank; TAPPING ER CHUCK; TAPPING CHUCK; ONE STEP TAPPING CHUCK

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	Bright	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M3	× 0.5	**TC353209**	11	40	18	3.5	2.7	6	3	2.5
M3.5	× 0.6	**TC353229**	13	45	21	4	3	6	3	2.9
M4	× 0.7	**TC353249**	13	45	21	4.5	3.4	6	3	3.3
M4.5	× 0.75	**TC353269**	16	50	25	6	4.9	8	3	3.7
M5	× 0.8	**TC353289**	16	52	26	6	4.9	8	3	4.2
M6	× 1.0	**TC353319**	18	56	27	6	4.9	8	3	5
M8	× 1.25	**TC353369**	20	63	34	6	4.9	8	3	6.8
M10	× 1.5	**TC353429**	22	70	38	7	5.5	8	4	8.5
M12	× 1.75	**TC353509**	24	80	45	9	7	10	4	10.2
M14	× 2.0	**TC353549**	26	80	45	11	9	12	4	12
M16	× 2.0	**TC353609**	27	80	45	12	9	12	4	14
M18	× 2.5	**TC353659**	30	95	58	14	11	14	4	15.5
M20	× 2.5	**TC353709**	32	95	58	16	12	15	4	17.5

▶ First with pilot guide

◎ : 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	400Rm	1050Rm	550	630	400	550
Recommended																					

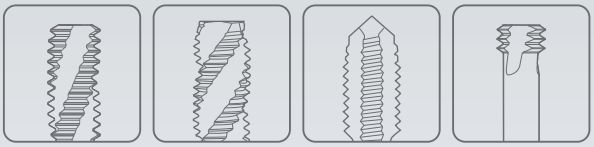
YG TAP GENERAL

RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDKONDITIONEN

ISO	VDI 3323	Material Description	HB	HRc	TC711 TC411 TC144 TC124 TC134	TD711 TD411	TC517 TC612	TC127 TC122 TC222 TC214 TC234 TC224	TD127 TD222	TC227	TD227	TC211	TC463 TC473 TC424
					Vc (m/min.)								
P	1	Non-alloy steel	125		15-20	20-25	15-20	15-20	20-25	15-20	20-25	15-20	15-20
	2		190	13	15-20	20-25	15-20	15-20	20-25	15-20	20-25	15-20	15-20
	3		250	25	12-18	18-24	12-18	12-18	18-24	12-18	18-24	12-18	12-18
	4		270	28	10-15	15-20	10-15	10-15	15-20	10-15	15-20	10-15	10-15
	5		300	32	6-10	10-14	6-10	6-10	10-14	6-10	10-14	6-10	6-10
	6	Low alloy steel	180	10	10-15	15-20	10-15	10-15	15-20	10-15	15-20	10-15	10-15
	7		275	29	10-15	15-20	10-15	10-15	15-20	10-15	15-20	10-15	10-15
	8		300	32	6-10	10-14	6-10	6-10	10-14	6-10	10-14	6-10	6-10
M	12	Stainless steel	200	15	7-10	10-13	7-10	7-10	10-13	7-10	10-13	7-10	7-10
	13		240	23	5-8	8-11	5-8	5-8	8-11	5-8	8-11	5-8	5-8
K	15	Grey cast iron	180	10									10-15
	16		260	26									5-8
	17	Nodular cast iron	160	3	10-15	15-20	10-15	10-15	15-20	10-15	15-20	10-15	10-15
	18		250	25	5-8	8-11	5-8	5-8	8-11	5-8	8-11	5-8	5-8
N	21	Aluminum-wrought alloy	60		10-15	15-20	10-15	10-15	15-20	10-15	15-20	10-15	
	23	Aluminum-cast, alloyed	75		15-20	20-25	15-20	15-20	20-25	15-20	20-25	15-20	
	24		90		15-20	20-25	15-20	15-20	20-25	15-20	20-25	15-20	
	25		130		10-15	15-20	10-15	10-15	15-20	10-15	15-20	10-15	10-15
	26	Copper and Copper Alloys (Bronze / Brass)	110		25-35	35-40	25-35	25-35	35-40	25-35	35-40	25-35	25-35
	27		90										8-12
	28		100		15-20	20-25	15-20	15-20	20-25	15-20	20-25	15-20	

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
TECHNICAL DATA

Global Cutting Tool Leader **YG-1**



THREADING