



Leading Through Innovation



HSS & HSS-E

PIPE TAP

GASGEWINDEBOHRER

- Tapping Whitworth Pipe threads
- Zum Gewindeschneiden von Whitworth-Rohrgewinden

B310 phone:+82-32-526-0909, www.yg1.solutions, E-mail:yg1@yg1.solutions **YG-1 CO., LTD.**

125		○			◎	
190	13	○	◎		◎	◎
250	25	○	◎			◎
270	28		◎			◎
300	32					
180	10	○	◎	○		◎
275	29		◎	○		◎
300	32			◎		
350	38			◎		
200	15					
325	35					
200	15				◎	
240	23				◎	
180	10			○	◎	
180	10	○				
260	26	○				
160	3		◎			◎
250	25		◎			◎
130						
230	21					
60		○	○			○
100		○	○			○
75		○	○			○
90			○			○
130			◎			◎
110			◎			◎
90			○			○
100						
200	15					
280	30					
250	25					
350	38					
320	34					
400 Rm						
1050 Rm						
550	55					
630	60					
400	42					
550	55					

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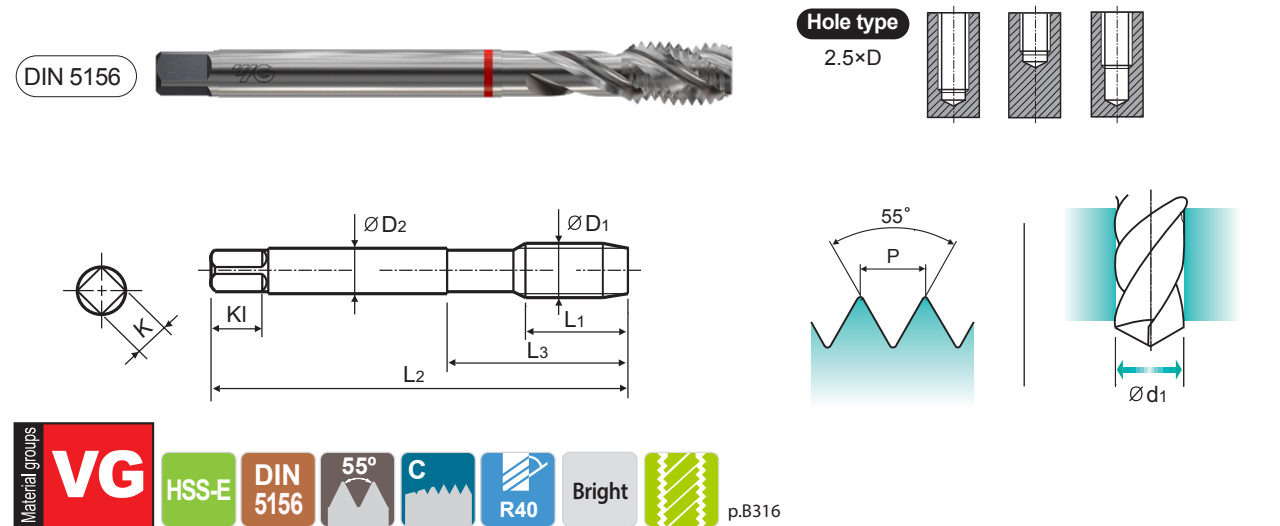


PIPE TAP

TC729 SERIES

G(BSP) Whitworth pipe threads DIN ISO 228/1
 🇩🇪 Whitworth Rohrgewinde DIN ISO 228/1
 🇮🇹 G(BSP) PROFIL 55° DIN ISO 228/1
 🇮🇹 Filettatura Whitworth per tubi DIN ISO 228/1

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



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	KI	Z	Ød1
G1/8 - 28		TC729200	20	90	36	7	5.5	8	3	8.8
G1/4 - 19		TC729400	22	100	40	11	9	12	3	11.8
G3/8 - 19		TC729480	22	100	40	12	9	12	3	15.25
G1/2 - 14		TC729560	25	125	50	16	12	15	4	19
G3/4 - 14		TC729700	28	140	54	20	16	19	4	24.5
G1 - 11		TC729780	30	160	60	25	20	23	4	30.75

[illegible]

CARBIDE

HSS

YG PIPE TAP

TB514 SERIES

G(BSP)

Whitworth pipe threads DIN ISO 228/1

Whitworth Rohrgewinde DIN ISO 228/1

G(BSP) PROFIL 55° DIN ISO 228/1

Filettatura Whitworth per tubi DIN ISO 228/1

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 5156

Hole type

2.5×D

Material groups

VANW

HSS-E

DIN 5156

55°

C

R40

Vap

p.B316

Unit : mm

SIZE	TPI	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1		Vap	L1	L2	L3	ØD2	K	KI	Z	Ød1
G1/8 -	28	TB514200	20	90	36	7	5.5	8	3	8.8
G1/4 -	19	TB514400	22	100	40	11	9	12	3	11.8
G3/8 -	19	TB514480	22	100	40	12	9	12	3	15.25
G1/2 -	14	TB514560	25	125	50	16	12	15	4	19
G3/4 -	14	TB514700	28	140	54	20	16	19	4	24.5
G1 -	11	TB514780	30	160	60	25	20	23	4	30.75

© : 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	30	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																						

B314

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CARBIDE

HSS

YG PIPE TAP

TC727 SERIES

G(BSP)

Whitworth Pipe threads DIN ISO 228/1

Whitworth Rohrgewinde DIN ISO 228/1

G(BSP) PROFIL 55° DIN ISO 228/1

Filettatura Whitworth per tubi DIN ISO 228/1

Machine taps
Maschinengewindebohrer

Suitable for through hole in more cutting speed than other taps due to strong geometry.

Geeignet für Sacklöcher in höherer Schnittgeschwindigkeit als andere Gewindebohrer dank einer stabilen Bohrergeometrie.

DIN 5156

Hole type

3.0×D

Material groups

GS

HSS-E

DIN 5156

55°

B

Bright

p.B316

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	KI	Z	Ød1
G1/8 -	28	TC727200	20	90	36	7	5.5	8	3	8.8
G1/4 -	19	TC727400	22	100	40	11	9	12	3	11.8
G3/8 -	19	TC727480	22	100	40	12	9	12	3	15.25
G1/2 -	14	TC727560	25	125	50	16	12	15	4	19
G3/4 -	14	TC727700	28	140	54	20	16	19	4	24.5
G1 -	11	TC727780	30	160	60	25	20	23	4	30.75

© : 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	30	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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B315



					TC728	TC729	TB514	TC727
ISO	VDI 3323	Material Description	HB	HRC	Vc (m/min.)			
P	1	Non-alloy steel	125				15-20	
	2		190	13	15-20		15-20	15-20
	3		250	25	12-18			12-18
	4		270	28	10-15			10-15
	5		300	32				
	6	Low alloy steel	180	10	10-15	10-15		10-15
	7		275	29	10-15	10-15		10-15
	8		300	32		6-10		
	9		350	38		3-5		
M	12	Stainless steel	200	15			7-10	
	13		240	23			5-8	
	14		180	10		4-6	4-6	
K	17	Nodular cast iron	160	3	10-15			10-15
	18		250	25	5-8			5-8
N	21	Aluminum-wrought alloy	60		10-15			10-15
	22		100		10-15			10-15
	23	Aluminum-cast, alloyed	75		15-20			15-20
	24		90		15-20			15-20
	25		130		10-15			10-15
	26	Copper and Copper Alloys (Bronze / Brass)	110		25-35			25-35
	27		90		8-12			8-12

STI TAP

NUT TAP