Leading Through Innovation

HSS-E & HSS-PM

YG TAP INOX

YG Gewindebohrer INOX

- **For Stainless Steels with Lamellar, Irregular Chip Formation where the Cutting Forces are Higher**
- **Für nichtrostende Stähle mit lamellarer, unregelmäßiger Spänebildung, bei denen die Schnittkräfte größer sind.**

SELECTION GUIDE

THREADING TOOLS

HSS-E & HSS-PM YG TAP INOX

For Stainless Steels with Lamellar, Irregular Chip Formation where the Cutting Forces are Higher

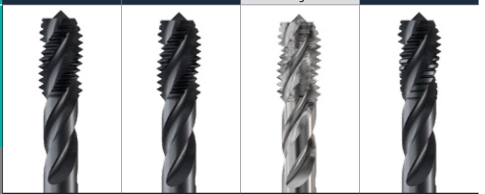
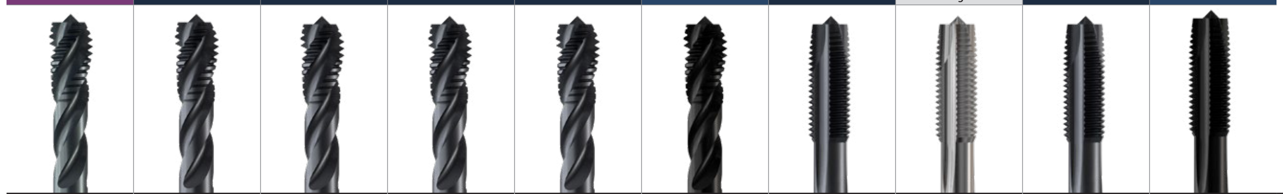
Please visit globalyg1.com/mat for material search

◎ : Excellent ○ : Good

Recommended cutting conditions : p.B193

	TB711	TQ813	TR813	TB914	TI914	TBE15	TBE16	TBE17	TBE18	TCH14	TQ853	TR853	TB623	TCH23
HOLE TYPE	Max. 2.0xD Blind Hole	Max. 2.5xD Blind Hole			Max. 2.5xD Blind Hole						Max. 3.0xD Through Hole			
TOOL MATERIAL	HSS-E	HSS-PM		HSS-E	HSS-E						HSS-PM		HSS-E	
CHAMFER LEAD ACC. TO DIN2197	C	C	C	C	C	C	C	C	C	C	B	B	B	B
FLUTE TYPE	Spiral Flute	Spiral Flute	Spiral Flute	Spiral Flute	Spiral Flute	Spiral Flute	Spiral Flute	Spiral Flute	Spiral Flute	Spiral Flute	Spiral Point	Spiral Point	Spiral Point	Spiral Point
SPIRAL FLUTE ANGLE	R40	R40	R40	R40	R40	R40	R40	R40	R40	R40	-	-	-	-

SERIES		TB711	TQ813	TR813	TB914	TI914	TBE15	TBE16	TBE17	TBE18	TCH14	TQ853	TR853	TB623	TCH23
M	DIN371/376	TB711 (p.B174)	TQ813 (p.B175)	TR813 (p.B176)	TB914 (p.B177)	TI914 (p.B177)	TBE15 (p.B178)	TBE16 (p.B179)	TBE17 (p.B180)	TBE18 (p.B181)	TCH14 (p.B182)	TQ853 (p.B183)	TR853 (p.B184)	TB623 (p.B185)	TCH23 (p.B186)
	DIN352														
	DIN357/LONG														
MF	DIN374				TB183 (p.B187)									TB123 (p.B190)	
	DIN2181														
UNC	DIN371/376				TB904 (p.B188)									TB264 (p.B191)	
	DIN351														
UNF	DIN371/374				TB924 (p.B189)									TB274 (p.B192)	
	DIN2181														
BSW	DIN2182/2183														
	DIN351														
G(BSP)	DIN5156/5157														
EG-M	DIN371/376														
EG-UNC	DIN371/376														
EG-UNF	DIN371/374														

	TB711	TQ813	TR813	TB914	TI914	TBE15	TBE16	TBE17	TBE18	TCH14	TQ853	TR853	TB623	TCH23
SURFACE TREATMENT	VAP	VAP	Bright	VAP	TiCN	VAP	VAP	VAP	VAP	HardSlick	VAP	Bright	VAP	HardSlick
MODEL														

ISO	VDI 3323	Material Description	Composition / Structure / Heat Treatment		HB	HRc	TB711	TQ813	TR813	TB914	TI914	TBE15	TBE16	TBE17	TBE18	TCH14	TQ853	TR853	TB623	TCH23
P	1	Non-alloy steel	About 0.15% C	Annealed	125		◎	○	○	◎	◎	◎	◎	◎	◎	◎	○	○	◎	◎
	2		About 0.45% C	Annealed	190	13	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎
	3		About 0.45% C	Quenched & Tempered	250	25		○	○	○	○	○	○	○	○	○	○	○	○	○
	4		About 0.75% C	Annealed	270	28		○	○	○	○	○	○	○	○	○	○	○	○	○
	5		About 0.75% C	Quenched & Tempered	300	32														
	6	Low alloy steel		Annealed	180	10		○	○	○	○	○	○	○	○	○	○	○	○	○
	7			Quenched & Tempered	275	29														
	8			Quenched & Tempered	300	32														
	9			Quenched & Tempered	350	38														
	10	High alloyed steel, and tool steel		Annealed	200	15														
	11			Quenched & Tempered	325	35														
M	12	Stainless steel	Ferritic / Martensitic	Annealed	200	15	○	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎
	13		Martensitic	Quenched & Tempered	240	23	○	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎
	14		Austenitic		180	10	○	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎
K	15	Grey cast iron	Pearlitic / ferritic		180	10														
	16		Pearlitic (Martensitic)		260	26														
	17	Nodular cast iron	Ferritic		160	3														
	18		Pearlitic		250	25														
	19	Malleable cast iron	Ferritic		130															
	20		Pearlitic		230	21														
N	21	Aluminum-wrought alloy	Not Curable		60		○													
	22		Curable	Hardened	100															
	23	Aluminum-cast, alloyed	≤ 12% Si, Not Curable		75															
	24		≤ 12% Si, Curable	Hardened	90															
	25		> 12% Si, Not Curable		130															
	26	Copper and Copper Alloys (Bronze / Brass)	Cutting Alloys, PB>1%		110															
	27		CuZn, CuSnZn (Brass)		90															
	28		CuSn, lead-free copper and electrolytic copper		100		○													
	29	Non Metallic Materials	Duroplastic, Fiber Reinforced Plastic																	
	30		Rubber, Wood, etc.																	
S	31	Heat Resistant Super Alloys	Fe Based	Annealed	200	15		○	○	○	○	○	○	○	○	○	○	○	○	○
	32			Cured	280	30														
	33		Ni or Co Based	Annealed	250	25														
	34			Cured	350	38														
	35			Cast	320	34														
	36	Titanium Alloys	Pure Titanium		400 Rm			○	○	○	○	○	○	○	○	○	○	○	○	○
	37		Alpha + Beta Alloys	Hardened	1050 Rm															
H	38	Hardened steel		Hardened	550	55														
	39			Hardened	630	60														
	40	Chilled Cast Iron		Cast	400	42														
	41	Hardened Cast Iron		Hardened	550	55														

YG TAP INOX

TB711 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

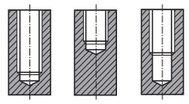
▶ Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

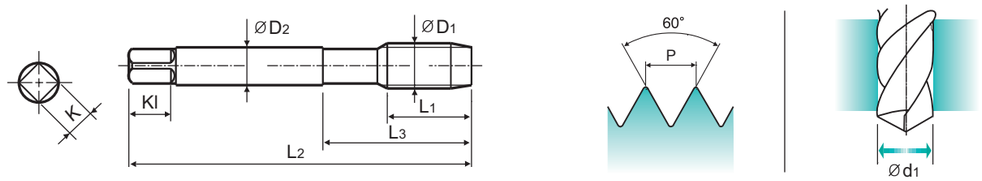
▶ Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

DIN 371

DIN 376

Hole type
2.0×D





Material groups: NW | HSS-E | DIN 371/376 | 6H | 60° | C | R40 | Vap | p.B193

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
M2 ×	0.4	**TB711136**	8	45	13	2.8	2.1	5	3	1.6
M2.5 ×	0.45	**TB711176**	9	50	15	2.8	2.1	5	3	2.05
M3 ×	0.5	**TB711206**	6	56	18	3.5	2.7	6	3	2.5
M4 ×	0.7	**TB711246**	7	63	21	4.5	3.4	6	3	3.3
M5 ×	0.8	**TB711286**	8	70	25	6	4.9	8	3	4.2
M6 ×	1.0	**TB711316**	10	80	30	6	4.9	8	3	5
M8 ×	1.25	**TB711366**	13	90	35	8	6.2	9	3	6.8
M10 ×	1.5	**TB711426**	15	100	39	10	8	11	3	8.5
M12 ×	1.75	**TB711506**	18	110	44	9	7	10	3	10.2
M14 ×	2.0	**TB711546**	20	110	44	11	9	12	3	12
M18 ×	2.5	**TB711656**	25	125	50	14	11	14	4	15.5
M20 ×	2.5	**TB711706**	25	140	54	16	12	15	4	17.5
M24 ×	3.0	**TB711786**	30	160	60	18	14.5	17	4	21
M30 ×	3.5	**TB711946**	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	400 Rm	1050 Rm	550	630	400	550
Recommended	○							○													

YG TAP INOX

TQ813 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

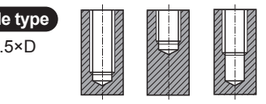
▶ Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

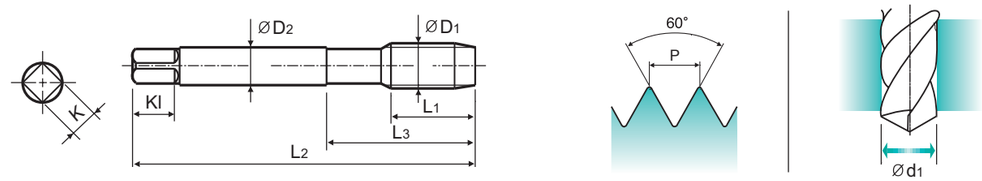
▶ Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

DIN 371

DIN 376

Hole type
2.5×D





Material groups: VA | HSS PM | DIN 371/376 | 6H | 60° | C | R40 | Vap | p.B193

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
M2 ×	0.4	**TQ813136**	8	45	13	2.8	2.1	5	3	1.6
M2.2 ×	0.45	**TQ813156**	8	45	13	2.8	2.1	5	3	1.75
M2.5 ×	0.45	**TQ813176**	9	50	15	2.8	2.1	5	3	2.05
M3 ×	0.5	**TQ813206**	6	56	18	3.5	2.7	6	3	2.5
M3.5 ×	0.6	**TQ813226**	7	56	20	4	3	6	3	2.9
M4 ×	0.7	**TQ813246**	7	63	21	4.5	3.4	6	3	3.3
M4.5 ×	0.75	**TQ813266**	8	70	25	6	4.9	8	3	3.7
M5 ×	0.8	**TQ813286**	8	70	25	6	4.9	8	3	4.2
M6 ×	1.0	**TQ813316**	10	80	30	6	4.9	8	3	5
M7 ×	1.0	**TQ813346**	10	80	30	7	5.5	8	3	6
M8 ×	1.25	**TQ813366**	13	90	35	8	6.2	9	3	6.8
M10 ×	1.5	**TQ813426**	15	100	39	10	8	11	3	8.5
M12 ×	1.75	**TQ813506**	18	110	44	9	7	10	3	10.2

▶ DIN 371(M2~M10) and DIN 376(M12)

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	○	◎	○	○		○						◎	◎	◎						

ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended											○					○					

YG TAP INOX

TR813 SERIES

M ISO metric coarse threads DIN 13

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

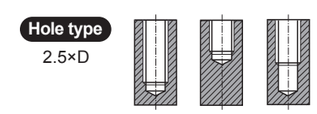
Machine taps
Maschinengewindebohrer

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

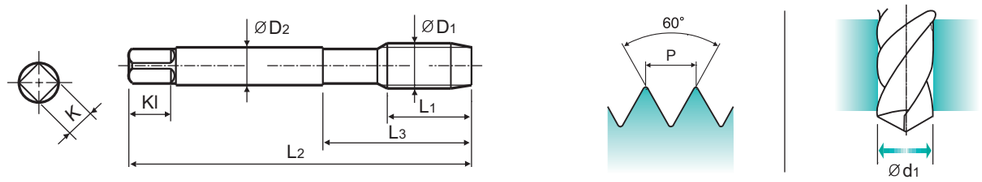
▶ Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

DIN 371

DIN 376



Hole type
2.5×D



Material groups **VA** | HSS PM | DIN 371/376 | 6H | 60° | C | R40 | Bright | p.B193

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	**TR813136**	8	45	13	2.8	2.1	5	3	1.6
M2.2	× 0.45	**TR813156**	8	45	13	2.8	2.1	5	3	1.75
M2.5	× 0.45	**TR813176**	9	50	15	2.8	2.1	5	3	2.05
M3	× 0.5	**TR813206**	6	56	18	3.5	2.7	6	3	2.5
M3.5	× 0.6	**TR813226**	7	56	20	4	3	6	3	2.9
M4	× 0.7	**TR813246**	7	63	21	4.5	3.4	6	3	3.3
M4.5	× 0.75	**TR813266**	8	70	25	6	4.9	8	3	3.7
M5	× 0.8	**TR813286**	8	70	25	6	4.9	8	3	4.2
M6	× 1.0	**TR813316**	10	80	30	6	4.9	8	3	5
M7	× 1.0	**TR813346**	10	80	30	7	5.5	8	3	6
M8	× 1.25	**TR813366**	13	90	35	8	6.2	9	3	6.8
M10	× 1.5	**TR813426**	15	100	39	10	8	11	3	8.5
M12	× 1.75	**TR813506**	18	110	44	9	7	10	3	10.2

▶ DIN 371(M2~M10) and DIN 376(M12)

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	○	◎	○	○		○						◎	◎	◎						

ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended											○					○					

YG TAP INOX

Vap **TB914 SERIES**
TiCN **TI914 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

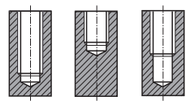
▶ With recessed threads for machine tapping of deep blind holes.
▶ Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

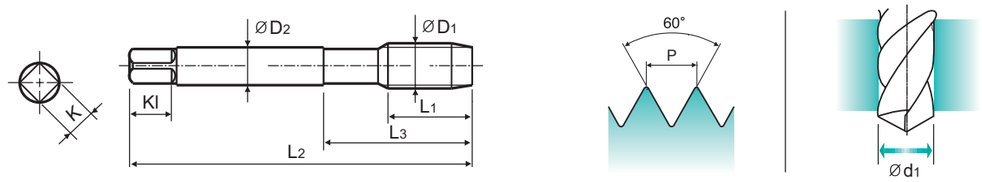
▶ Mit abgesetztem Gewinde zum Schneiden von tiefen Sacklochgewinden.
▶ Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

DIN 371

DIN 376

Hole type
2.5×D





Material groups **VA NW** | HSS-E | DIN 371/376 | 6H | 60° | C | R40 | Vap TiCN | p.B193

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	TiCN	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M2	× 0.4	**TB914136**	**TI914136**	8	45	13	2.8	2.1	5	3	1.6
M2.2	× 0.45	**TB914156**	-	8	45	13	2.8	2.1	5	3	1.75
*M2.3	× 0.4	**TB914196**	-	8	45	13	2.8	2.1	5	3	1.9
M2.5	× 0.45	**TB914176**	**TI914176**	9	50	15	2.8	2.1	5	3	2.05
*M2.6	× 0.45	**TB914496**	-	9	50	15	2.8	2.1	5	3	2.1
M3	× 0.5	**TB914206**	**TI914206**	6	56	18	3.5	2.7	6	3	2.5
M3.5	× 0.6	**TB914226**	-	7	56	20	4	3	6	3	2.9
M4	× 0.7	**TB914246**	**TI914246**	7	63	21	4.5	3.4	6	3	3.3
M4.5	× 0.75	**TB914266**	-	8	70	25	6	4.9	8	3	3.7
M5	× 0.8	**TB914286**	**TI914286**	8	70	25	6	4.9	8	3	4.2
M6	× 1.0	**TB914316**	**TI914316**	10	80	30	6	4.9	8	3	5
M7	× 1.0	**TB914346**	**TI914346**	10	80	30	7	5.5	8	3	6
M8	× 1.25	**TB914366**	**TI914366**	13	90	35	8	6.2	9	3	6.8
M9	× 1.25	**TB914396**	-	13	90	35	9	7	10	3	7.8
M10	× 1.5	**TB914426**	**TI914426**	15	100	39	10	8	11	3	8.5
M11	× 1.5	**TB914466**	-	17	100	40	8	6.2	9	3	9.5
M12	× 1.75	**TB914506**	**TI914506**	18	110	44	9	7	10	3	10.2
M12	× 1.75	**TB914506F4**	**TI914506F4**	18	110	44	9	7	10	4	10.2
M14	× 2.0	**TB914546**	**TI914546**	20	110	44	11	9	12	3	12
M14	× 2.0	**TB914546F4**	**TI914546F4**	20	110	44	11	9	12	4	12
M16	× 2.0	**TB914606**	**TI914606**	20	110	44	12	9	12	3	14
M16	× 2.0	**TB914606F4**	**TI914606F4**	20	110	44	12	9	12	4	14
M18	× 2.5	**TB914656**	**TI914656**	25	125	50	14	11	14	4	15.5
M20	× 2.5	**TB914706**	**TI914706**	25	140	54	16	12	15	4	17.5
M22	× 2.5	**TB914746**	**TI914746**	25	140	54	18	14.5	17	4	19.5
M24	× 3.0	**TB914786**	**TI914786**	30	160	60	18	14.5	17	4	21
M27	× 3.0	**TB914866**	**TI914866**	30	160	60	20	16	19	4	24
M30	× 3.5	**TB914946**	**TI914946**	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	400 Rm	1050 Rm	550	630	400	550
Recommended											○					○					

YG TAP INOX

TBE15 SERIES

M ISO metric coarse threads DIN 13

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

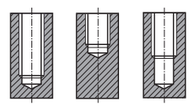
Machine taps
Maschinengewindebohrer

- With recessed threads for machine tapping of deep blind holes.
- Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

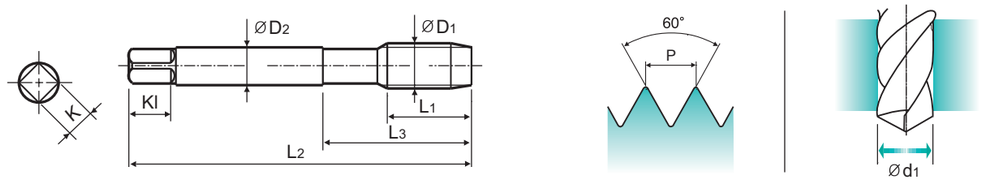
- Mit abgesetztem Gewinde zum Schneiden von tiefen Sacklochgewinden.
- Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

DIN 371

DIN 376



Hole type
2.5×D



Material groups VA NW | HSS-E | DIN 371/376 | 4H | 60° | C | R40 | Vap | p.B193

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
M2 × 0.4		TBE15136	8	45	13	2.8	2.1	5	3	1.6
M2.2 × 0.45		TBE15156	8	45	13	2.8	2.1	5	3	1.75
*M2.3 × 0.4		TBE15196	8	45	13	2.8	2.1	5	3	1.9
M2.5 × 0.45		TBE15176	9	50	15	2.8	2.1	5	3	2.05
*M2.6 × 0.45		TBE15496	9	50	15	2.8	2.1	5	3	2.1
M3 × 0.5		TBE15206	6	56	18	3.5	2.7	6	3	2.5
M3.5 × 0.6		TBE15226	7	56	20	4	3	6	3	2.9
M4 × 0.7		TBE15246	7	63	21	4.5	3.4	6	3	3.3
M4.5 × 0.75		TBE15266	8	70	25	6	4.9	8	3	3.7
M5 × 0.8		TBE15286	8	70	25	6	4.9	8	3	4.2
M6 × 1.0		TBE15316	10	80	30	6	4.9	8	3	5
M7 × 1.0		TBE15346	10	80	30	7	5.5	8	3	6
M8 × 1.25		TBE15366	13	90	35	8	6.2	9	3	6.8
M9 × 1.25		TBE15396	13	90	35	9	7	10	3	7.8
M10 × 1.5		TBE15426	15	100	39	10	8	11	3	8.5
M11 × 1.5		TBE15466	17	100	40	8	6.2	9	3	9.5
M12 × 1.75		TBE15506	18	110	44	9	7	10	3	10.2
M14 × 2.0		TBE15546	20	110	44	11	9	12	3	12
M16 × 2.0		TBE15606	20	110	44	12	9	12	3	14
M18 × 2.5		TBE15656	25	125	50	14	11	14	4	15.5
M20 × 2.5		TBE15706	25	140	54	16	12	15	4	17.5
M22 × 2.5		TBE15746	25	140	54	18	14.5	17	4	19.5
M24 × 3.0		TBE15786	30	160	60	18	14.5	17	4	21
M27 × 3.0		TBE15866	30	160	60	20	16	19	4	24
M30 × 3.5		TBE15946	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											○					○					

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

YG TAP INOX

TBE16 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

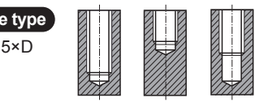
- With recessed threads for machine tapping of deep blind holes.
- Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

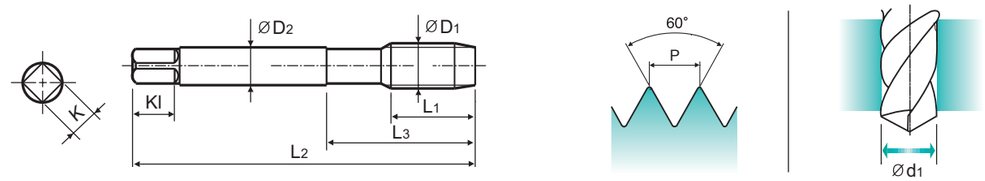
- Mit abgesetztem Gewinde zum Schneiden von tiefen Sacklochgewinden.
- Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

DIN 371

DIN 376

Hole type
2.5×D





Material groups VA NW | HSS-E | DIN 371/376 | 6H+0.1 | 60° | C | R40 | Vap | p.B193

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
M2 × 0.4		TBE16136	8	45	13	2.8	2.1	5	3	1.7
M2.2 × 0.45		TBE16156	8	45	13	2.8	2.1	5	3	1.85
*M2.3 × 0.4		TBE16196	8	45	13	2.8	2.1	5	3	2
M2.5 × 0.45		TBE16176	9	50	15	2.8	2.1	5	3	2.15
*M2.6 × 0.45		TBE16496	9	50	15	2.8	2.1	5	3	2.2
M3 × 0.5		TBE16206	6	56	18	3.5	2.7	6	3	2.6
M3.5 × 0.6		TBE16226	7	56	20	4	3	6	3	3
M4 × 0.7		TBE16246	7	63	21	4.5	3.4	6	3	3.4
M4.5 × 0.75		TBE16266	8	70	25	6	4.9	8	3	3.8
M5 × 0.8		TBE16286	8	70	25	6	4.9	8	3	4.3
M6 × 1.0		TBE16316	10	80	30	6	4.9	8	3	5.1
M7 × 1.0		TBE16346	10	80	30	7	5.5	8	3	6.1
M8 × 1.25		TBE16366	13	90	35	8	6.2	9	3	6.9
M9 × 1.25		TBE16396	13	90	35	9	7	10	3	7.9
M10 × 1.5		TBE16426	15	100	39	10	8	11	3	8.6
M11 × 1.5		TBE16466	17	100	40	8	6.2	9	3	9.6
M12 × 1.75		TBE16506	18	110	44	9	7	10	3	10.3
M14 × 2.0		TBE16546	20	110	44	11	9	12	3	12.1
M16 × 2.0		TBE16606	20	110	44	12	9	12	3	14.1
M18 × 2.5		TBE16656	25	125	50	14	11	14	4	15.6
M20 × 2.5		TBE16706	25	140	54	16	12	15	4	17.6
M22 × 2.5		TBE16746	25	140	54	18	14.5	17	4	19.6
M24 × 3.0		TBE16786	30	160	60	18	14.5	17	4	21.1
M27 × 3.0		TBE16866	30	160	60	20	16	19	4	24.1
M30 × 3.5		TBE16946	35	180	70	22	18	21	4	26.6

- 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 INOX

TBE17 SERIES

M ISO metric coarse threads DIN 13

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

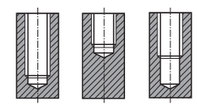
Machine taps
Maschinengewindebohrer

- With recessed threads for machine tapping of deep blind holes.
- Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

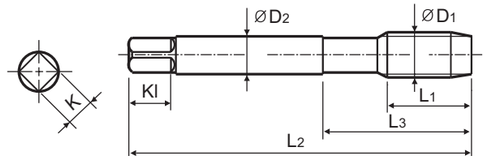
- Mit abgesetztem Gewinde zum Schneiden von tiefen Sacklochgewinden.
- Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

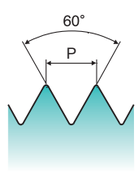
DIN 371

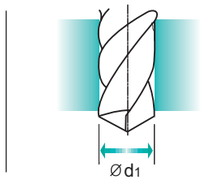
DIN 376



Hole type
2.5×D







Material groups VA NW | HSS-E | DIN 371/376 | 6G | 60° | C | R40 | Vap | p.B193

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
M2.2	× 0.45	**TBE17156**	8	45	13	2.8	2.1	5	3	1.75
*M2.3	× 0.4	**TBE17196**	8	45	13	2.8	2.1	5	3	1.9
M3	× 0.5	**TBE17206**	6	56	18	3.5	2.7	6	3	2.5
M3.5	× 0.6	**TBE17226**	7	56	20	4	3	6	3	2.9
M4	× 0.7	**TBE17246**	7	63	21	4.5	3.4	6	3	3.3
M4.5	× 0.75	**TBE17266**	8	70	25	6	4.9	8	3	3.7
M5	× 0.8	**TBE17286**	8	70	25	6	4.9	8	3	4.2
M6	× 1.0	**TBE17316**	10	80	30	6	4.9	8	3	5
M7	× 1.0	**TBE17346**	10	80	30	7	5.5	8	3	6
M8	× 1.25	**TBE17366**	13	90	35	8	6.2	9	3	6.8
M9	× 1.25	**TBE17396**	13	90	35	9	7	10	3	7.8
M10	× 1.5	**TBE17426**	15	100	39	10	8	11	3	8.5
M11	× 1.5	**TBE17466**	17	100	40	8	6.2	9	3	9.5
M12	× 1.75	**TBE17506**	18	110	44	9	7	10	3	10.2
M14	× 2.0	**TBE17546**	20	110	44	11	9	12	3	12
M16	× 2.0	**TBE17606**	20	110	44	12	9	12	3	14
M18	× 2.5	**TBE17656**	25	125	50	14	11	14	4	15.5
M20	× 2.5	**TBE17706**	25	140	54	16	12	15	4	17.5
M22	× 2.5	**TBE17746**	25	140	54	18	14.5	17	4	19.5
M24	× 3.0	**TBE17786**	30	160	60	18	14.5	17	4	21
M27	× 3.0	**TBE17866**	30	160	60	20	16	19	4	24
M30	× 3.5	**TBE17946**	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											○					○					

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

YG TAP INOX

TBE18 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

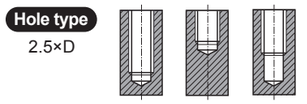
- With recessed threads for machine tapping of deep blind holes.
- Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

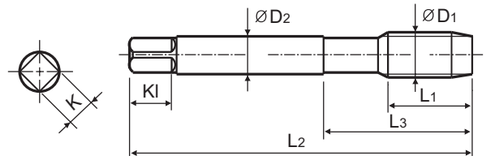
- Mit abgesetztem Gewinde zum Schneiden von tiefen Sacklochgewinden.
- Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

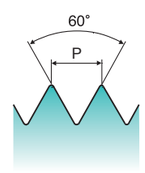
DIN 371

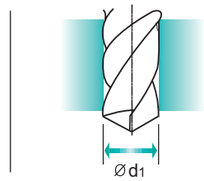
DIN 376

Hole type
2.5×D









Material groups VA NW | HSS-E | DIN 371/376 | 7G | 60° | C | R40 | Vap | p.B193

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
M2	× 0.4	**TBE18136**	8	45	13	2.8	2.1	5	3	1.6
M2.2	× 0.45	**TBE18156**	8	45	13	2.8	2.1	5	3	1.75
*M2.3	× 0.4	**TBE18196**	8	45	13	2.8	2.1	5	3	1.9
M2.5	× 0.45	**TBE18176**	9	50	15	2.8	2.1	5	3	2.05
*M2.6	× 0.45	**TBE18496**	9	50	15	2.8	2.1	5	3	2.1
M3	× 0.5	**TBE18206**	6	56	18	3.5	2.7	6	3	2.5
M3.5	× 0.6	**TBE18226**	7	56	20	4	3	6	3	2.9
M4	× 0.7	**TBE18246**	7	63	21	4.5	3.4	6	3	3.3
M4.5	× 0.75	**TBE18266**	8	70	25	6	4.9	8	3	3.7
M5	× 0.8	**TBE18286**	8	70	25	6	4.9	8	3	4.2
M6	× 1.0	**TBE18316**	10	80	30	6	4.9	8	3	5
M7	× 1.0	**TBE18346**	10	80	30	7	5.5	8	3	6
M8	× 1.25	**TBE18366**	13	90	35	8	6.2	9	3	6.8
M9	× 1.25	**TBE18396**	13	90	35	9	7	10	3	7.8
M10	× 1.5	**TBE18426**	15	100	39	10	8	11	3	8.5
M11	× 1.5	**TBE18466**	17	100	40	8	6.2	9	3	9.5
M12	× 1.75	**TBE18506**	18	110	44	9	7	10	3	10.2
M14	× 2.0	**TBE18546**	20	110	44	11	9	12	3	12
M16	× 2.0	**TBE18606**	20	110	44	12	9	12	3	14
M18	× 2.5	**TBE18656**	25	125	50	14	11	14	4	15.5
M20	× 2.5	**TBE18706**	25	140	54	16	12	15	4	17.5
M22	× 2.5	**TBE18746**	25	140	54	18	14.5	17	4	19.5
M24	× 3.0	**TBE18786**	30	160	60	18	14.5	17	4	21
M27	× 3.0	**TBE18866**	30	160	60	20	16	19	4	24
M30	× 3.5	**TBE18946**	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											○					○					

YG TAP INOX

TCH14 SERIES

M ISO metric coarse threads DIN 13

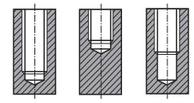
Metrisches ISO-Gewinde DIN 13
ISO MÉTRIQUE DIN13
ISO Metrico passo grosso DIN 13

Machine taps
Maschinengewindebohrer

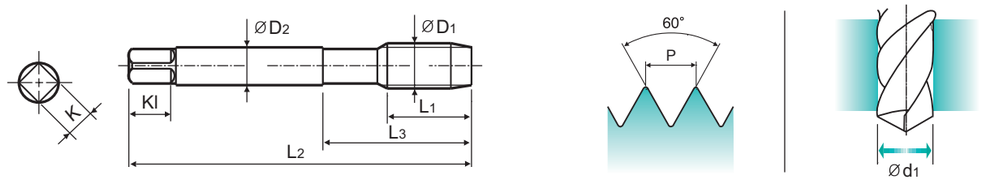
▶ With recessed threads for machine tapping of deep blind holes.
▶ Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

▶ Mit abgesetztem Gewinde zum Schneiden von tiefen Sacklochgewinden.
▶ Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

DIN 371
DIN 376



Hole type
2.5×D



Material groups: VA NW | HSS-E | DIN 371/376 | 6H | 60° | C | R40 | Hardslick

p.B193

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	Hardslick	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M2	× 0.4	TCH14136	8	45	13	2.8	2.1	5	3	1.6
M2.2	× 0.45	TCH14156	8	45	13	2.8	2.1	5	3	1.75
*M2.3	× 0.4	TCH14196	8	45	13	2.8	2.1	5	3	1.9
M2.5	× 0.45	TCH14176	9	50	15	2.8	2.1	5	3	2.05
*M2.6	× 0.45	TCH14496	9	50	15	2.8	2.1	5	3	2.1
M3	× 0.5	TCH14206	6	56	18	3.5	2.7	6	3	2.5
M3.5	× 0.6	TCH14226	7	56	20	4	3	6	3	2.9
M4	× 0.7	TCH14246	7	63	21	4.5	3.4	6	3	3.3
M4.5	× 0.75	TCH14266	8	70	25	6	4.9	8	3	3.7
M5	× 0.8	TCH14286	8	70	25	6	4.9	8	3	4.2
M6	× 1.0	TCH14316	10	80	30	6	4.9	8	3	5
M7	× 1.0	TCH14346	10	80	30	7	5.5	8	3	6
M8	× 1.25	TCH14366	13	90	35	8	6.2	9	3	6.8
M9	× 1.25	TCH14396	13	90	35	9	7	10	3	7.8
M10	× 1.5	TCH14426	15	100	39	10	8	11	3	8.5
M11	× 1.5	TCH14466	17	100	40	8	6.2	9	3	9.5
M12	× 1.75	TCH14506	18	110	44	9	7	10	3	10.2
M14	× 2.0	TCH14546	20	110	44	11	9	12	3	12
M16	× 2.0	TCH14606	20	110	44	12	9	12	3	14
M18	× 2.5	TCH14656	25	125	50	14	11	14	4	15.5
M20	× 2.5	TCH14706	25	140	54	16	12	15	4	17.5
M22	× 2.5	TCH14746	25	140	54	18	14.5	17	4	19.5
M24	× 3.0	TCH14786	30	160	60	18	14.5	17	4	21
M27	× 3.0	TCH14866	30	160	60	20	16	19	4	24
M30	× 3.5	TCH14946	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	400 Rm	1050 Rm	550	630	400	550
Recommended											○					○					

YG TAP INOX

TQ853 SERIES

M ISO metric coarse threads DIN 13

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

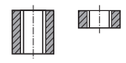
Machine taps
Maschinengewindebohrer

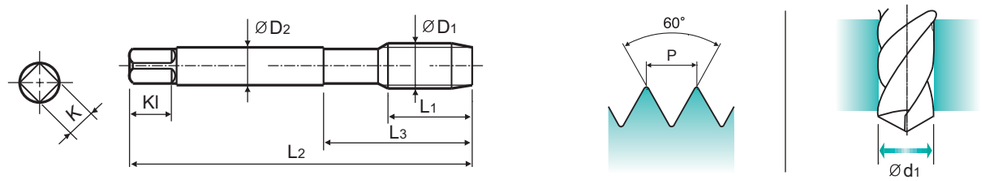
▶ Suitable for through hole in more cutting speed than other taps due to thick web and the best substrate.

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

DIN 371
DIN 376

Hole type
3.0×D





Material groups: VA | HSS PM | DIN 371/376 | 6H | 60° | B | Vap

p.B193

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
M2	× 0.4	TQ853136	8	45	13	2.8	2.1	5	3	1.6
M2.2	× 0.45	TQ853156	8	45	13	2.8	2.1	5	3	1.75
M3	× 0.5	TQ853206	11	56	18	3.5	2.7	6	3	2.5
M3.5	× 0.6	TQ853226	12	56	20	4	3	6	3	2.9
M4	× 0.7	TQ853246	13	63	21	4.5	3.4	6	3	3.3
M4.5	× 0.75	TQ853266	14	70	25	6	4.9	8	3	3.7
M5	× 0.8	TQ853286	15	70	25	6	4.9	8	3	4.2
M6	× 1.0	TQ853316	17	80	30	6	4.9	8	3	5
M7	× 1.0	TQ853346	17	80	30	7	5.5	8	3	6
M8	× 1.25	TQ853366	20	90	35	8	6.2	9	3	6.8
M10	× 1.5	TQ853426	22	100	39	10	8	11	3	8.5
M12	× 1.75	TQ853506	24	110	44	9	7	10	3	10.2

▶ DIN 371(M2~M10) and DIN 376(M12)

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	○	◎	○	○		○						◎	◎	◎						

ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended											○					○					

YG TAP INOX

TR853 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

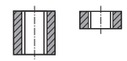
▶ Suitable for through hole in more cutting speed than other taps due to thick web and the best substrate.

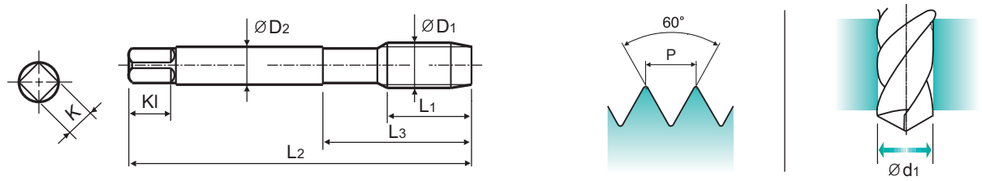
▶ Geeignet für Durchgangslöcher in höherer Schnittgeschwindigkeit als bei anderen Gewindebohrern dank größerer Kerndicke und bestem Werkstoff.

DIN 371

DIN 376

Hole type
3.0×D





Material groups: VA | HSS PM | DIN 371/376 | 6H | 60° | B | Bright

p.B193

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	**TR853136**	8	45	13	2.8	2.1	5	3	1.6
M2.2	× 0.45	**TR853156**	8	45	13	2.8	2.1	5	3	1.75
M2.5	× 0.45	**TR853176**	9	50	15	2.8	2.1	5	3	2.05
M3	× 0.5	**TR853206**	11	56	18	3.5	2.7	6	3	2.5
M3.5	× 0.6	**TR853226**	12	56	20	4	3	6	3	2.9
M4	× 0.7	**TR853246**	13	63	21	4.5	3.4	6	3	3.3
M4.5	× 0.75	**TR853266**	14	70	25	6	4.9	8	3	3.7
M5	× 0.8	**TR853286**	15	70	25	6	4.9	8	3	4.2
M6	× 1.0	**TR853316**	17	80	30	6	4.9	8	3	5
M7	× 1.0	**TR853346**	17	80	30	7	5.5	8	3	6
M8	× 1.25	**TR853366**	20	90	35	8	6.2	9	3	6.8
M10	× 1.5	**TR853426**	22	100	39	10	8	11	3	8.5
M12	× 1.75	**TR853506**	24	110	44	9	7	10	3	10.2

▶ DIN 371(M2~M10) and DIN 376(M12)

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	○	◎	○	○		○						◎	◎	◎						

ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended											○					○					

YG TAP INOX

TB623 SERIES

M ISO metric coarse threads DIN 13

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

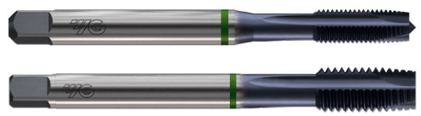
Machine taps
Maschinengewindebohrer

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

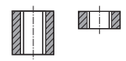
▶ Geeignet für Durchgangslöcher in höherer Schnittgeschwindigkeit als bei anderen Gewindebohrern dank größerer Kerndicke.

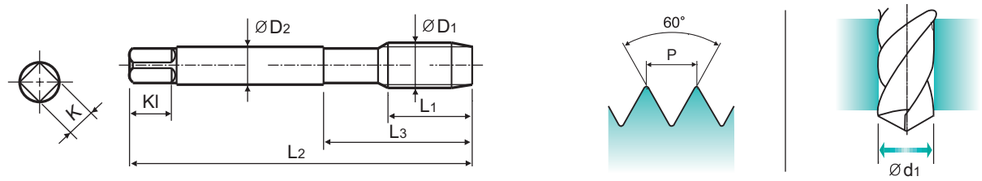
DIN 371

DIN 376



Hole type
3.0×D





Material groups: VA NW | HSS-E | DIN 371/376 | 6HX | 60° | B | Vap

p.B193

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
M2	× 0.4	**TB623136**	8	45	13	2.8	2.1	5	3	1.6
M2.2	× 0.45	**TB623156**	8	45	13	2.8	2.1	5	3	1.75
*M2.3	× 0.4	**TB623196**	8	45	13	2.8	2.1	5	3	1.9
M2.5	× 0.45	**TB623176**	9	50	15	2.8	2.1	5	3	2.05
*M2.6	× 0.45	**TB623496**	9	50	15	2.8	2.1	5	3	2.1
M3	× 0.5	**TB623206**	11	56	18	3.5	2.7	6	3	2.5
M3.5	× 0.6	**TB623226**	12	56	20	4	3	6	3	2.9
M4	× 0.7	**TB623246**	13	63	21	4.5	3.4	6	3	3.3
M4.5	× 0.75	**TB623266**	14	70	25	6	4.9	8	3	3.7
M5	× 0.8	**TB623286**	15	70	25	6	4.9	8	3	4.2
M6	× 1.0	**TB623316**	17	80	30	6	4.9	8	3	5
M7	× 1.0	**TB623346**	17	80	30	7	5.5	8	3	6
M8	× 1.25	**TB623366**	20	90	35	8	6.2	9	3	6.8
M9	× 1.25	**TB623396**	20	90	35	9	7	10	3	7.8
M10	× 1.5	**TB623426**	22	100	39	10	8	11	3	8.5
M11	× 1.5	**TB623466**	22	100	40	8	6.2	9	3	9.5
M12	× 1.75	**TB623506**	24	110	44	9	7	10	4	10.2
M14	× 2.0	**TB623546**	26	110	44	11	9	12	4	12
M16	× 2.0	**TB623606**	27	110	44	12	9	12	4	14
M18	× 2.5	**TB623656**	30	125	50	14	11	14	4	15.5
M20	× 2.5	**TB623706**	32	140	54	16	12	15	4	17.5
M22	× 2.5	**TB623746**	32	140	54	18	14.5	17	4	19.5
M24	× 3.0	**TB623786**	34	160	60	18	14.5	17	4	21
M27	× 3.0	**TB623866**	36	160	60	20	16	19	4	24
M30	× 3.5	**TB623946**	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	400 Rm	1050 Rm	550	630	400	550
Recommended											○					○					

YG TAP INOX

TCH23 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

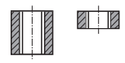
▶ Suitable for through hole in more cutting speed than other taps due to thick web.

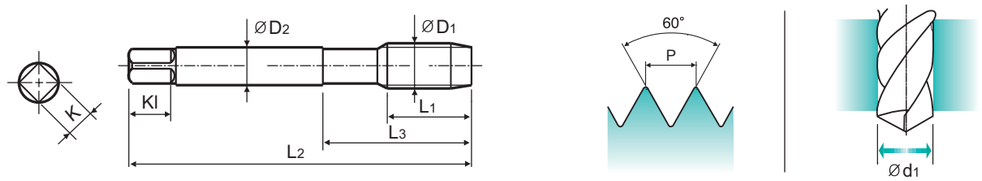
▶ Geeignet für Durchgangslöcher in höherer Schnittgeschwindigkeit als bei anderen Gewindebohrern dank größerer Kerndicke.

DIN 371

DIN 376

Hole type
3.0×D





Material groups: VA NW | HSS-E | DIN 371/376 | 6HX | 60° | B | Hardslick

p.B193

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	Hardslick	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M2 × 0.4		TCH23136	8	45	13	2.8	2.1	5	3	1.6
M2.2 × 0.45		TCH23156	8	45	13	2.8	2.1	5	3	1.75
M2.5 × 0.45		TCH23176	9	50	15	2.8	2.1	5	3	2.05
*M2.6 × 0.45		TCH23496	9	50	15	2.8	2.1	5	3	2.1
M3 × 0.5		TCH23206	11	56	18	3.5	2.7	6	3	2.5
M3.5 × 0.6		TCH23226	12	56	20	4	3	6	3	2.9
M4 × 0.7		TCH23246	13	63	21	4.5	3.4	6	3	3.3
M4.5 × 0.75		TCH23266	14	70	25	6	4.9	8	3	3.7
M5 × 0.8		TCH23286	15	70	25	6	4.9	8	3	4.2
M6 × 1.0		TCH23316	17	80	30	6	4.9	8	3	5
M7 × 1.0		TCH23346	17	80	30	7	5.5	8	3	6
M8 × 1.25		TCH23366	20	90	35	8	6.2	9	3	6.8
M9 × 1.25		TCH23396	20	90	35	9	7	10	3	7.8
M10 × 1.5		TCH23426	22	100	39	10	8	11	3	8.5
M12 × 1.75		TCH23506	24	110	44	9	7	10	4	10.2
M14 × 2.0		TCH23546	26	110	44	11	9	12	4	12
M16 × 2.0		TCH23606	27	110	44	12	9	12	4	14
M18 × 2.5		TCH23656	30	125	50	14	11	14	4	15.5
M20 × 2.5		TCH23706	32	140	54	16	12	15	4	17.5
M22 × 2.5		TCH23746	32	140	54	18	14.5	17	4	19.5
M24 × 3.0		TCH23786	34	160	60	18	14.5	17	4	21
M27 × 3.0		TCH23866	36	160	60	20	16	19	4	24
M30 × 3.5		TCH23946	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	400 Rm	1050 Rm	550	630	400	550
Recommended											○					○					

YG TAP INOX

TB183 SERIES

MF ISO metric fine threads DIN 13

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

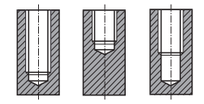
Machine taps
Maschinengewindebohrer

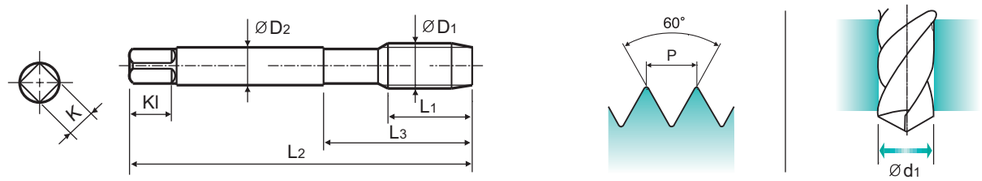
▶ Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

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

DIN 374

Hole type
2.5×D





Material groups: VA NW | HSS-E | DIN 374 | 6H | 60° | C | R40 | Vap

p.B193

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
M4 × 0.5		TB183256	5	63	21	2.8	2.1	5	3	3.5
M5 × 0.5		TB183296	5	70	25	3.5	2.7	6	3	4.5
M6 × 0.75		TB183326	8	80	30	4.5	3.4	6	3	5.2
M6 × 0.5		TB183336	5	80	30	4.5	3.4	6	3	5.5
M7 × 0.75		TB183356	10	80	30	5.5	4.3	7	3	6.2
M8 × 1.0		TB183376	10	90	36	6	4.9	8	3	7
M10 × 1.25		TB183436	16	100	40	7	5.5	8	3	8.8
M10 × 1.0		TB183446	10	90	36	7	5.5	8	3	9
M10 × 0.75		TB183456	10	90	36	7	5.5	8	3	9.2
M12 × 1.5		TB183516	15	100	40	9	7	10	3	10.5
M12 × 1.25		TB183526	15	100	40	9	7	10	3	10.8
M12 × 1.0		TB183536	11	100	40	9	7	10	3	11
M14 × 1.5		TB183556	15	100	40	11	9	12	3	12.5
M14 × 1.25		TB183566	15	100	40	11	9	12	3	12.8
M16 × 1.5		TB183616	15	100	40	12	9	12	3	14.5
M18 × 1.5		TB183676	17	110	44	14	11	14	4	16.5
M20 × 1.5		TB183726	17	125	50	16	12	15	4	18.5
M22 × 1.5		TB183766	17	125	50	18	14.5	17	4	20.5
M24 × 1.5		TB183806	20	140	54	18	14.5	17	4	22.5

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	○	○		○						◎	◎	◎						

ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended											○					○					

YG TAP INOX

TB904 SERIES

UNC — Unified coarse threads

- Unified Grobgewinde
- UNC
- Unificato passo grosso

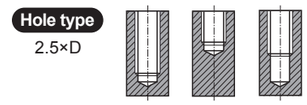
Machine taps
Maschinengewindebohrer

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

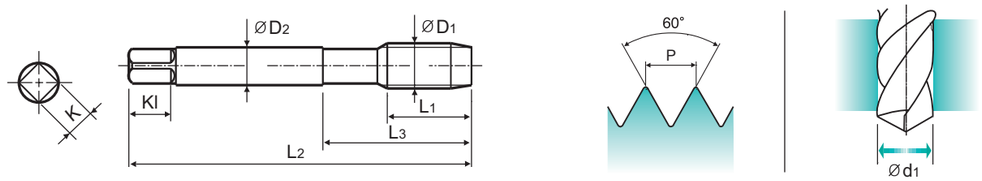
▶ Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

DIN 371

DIN 376



Hole type
2.5×D



Material groups: VA NW | HSS-E | DIN 371/376 | 2B | 60° | C | R40 | Vap | p.B193

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	Kl	Z	Ød1
#4	-	40UNC	**TB904162**	6	56	18	3.5	2.7	6	3	2.3
#5	-	40UNC	**TB904202**	7	56	18	3.5	2.7	6	3	2.6
#6	-	32UNC	**TB904242**	7	56	20	4	3	6	3	2.85
#10	-	24UNC	**TB904322**	10	70	25	6	4.9	8	3	3.9
1/4	-	20UNC	**TB904402**	13	80	30	7	5.5	8	3	5.2
5/16	-	18UNC	**TB904442**	14	90	35	8	6.2	9	3	6.6
3/8	-	16UNC	**TB904482**	16	100	39	9	7	10	3	8
7/16	-	14UNC	**TB904522**	17	100	40	8	6.2	9	3	9.4
5/8	-	11UNC	**TB904642**	22	110	44	12	9	12	3	13.5
3/4	-	10UNC	**TB904702**	25	125	50	14	11	14	4	16.5
1	-	8UNC	**TB904782**	30	160	60	20	16	19	4	22.25

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

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	○	○		○						◎	◎	◎						

ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended											○					○					

YG TAP INOX

TB924 SERIES

UNF — Unified fine threads

- Unified Feingewinde
- UNF
- Unificato passo fine

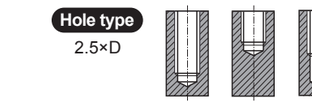
Machine taps
Maschinengewindebohrer

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

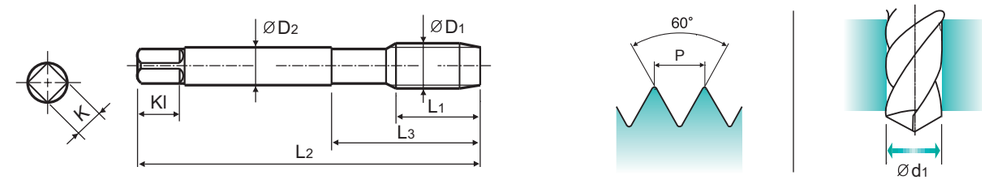
▶ Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

DIN 371

DIN 374



Hole type
2.5×D



Material groups: VA NW | HSS-E | DIN 371/374 | 2B | 60° | C | R40 | Vap | p.B193

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	Kl	Z	Ød1
#5	-	44UNF	**TB924222**	7	56	18	3.5	2.7	6	3	2.7
#8	-	36UNF	**TB924302**	8	63	21	4.5	3.4	6	3	3.5
#10	-	32UNF	**TB924342**	10	70	25	6	4.9	8	3	4.1
#12	-	28UNF	**TB924382**	10	80	30	6	4.9	8	3	4.7
5/16	-	24UNF	**TB924462**	10	90	35	8	6.2	9	3	6.9
3/8	-	24UNF	**TB924502**	10	100	39	9	7	10	3	8.5
7/16	-	20UNF	**TB924542**	13	100	40	8	6.2	9	3	9.9
1/2	-	20UNF	**TB924582**	13	100	40	9	7	10	3	11.5
9/16	-	18UNF	**TB924622**	15	100	40	11	9	12	3	12.9
7/8	-	14UNF	**TB924762**	17	125	50	18	14.5	17	4	20.5

▶ 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	400 Rm	1050 Rm	550	630	400	550
Recommended											○					○					

YG TAP INOX

TB123 SERIES

MF — ISO metric fine threads DIN 13

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

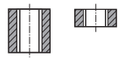
Machine taps
Maschinengewindebohrer

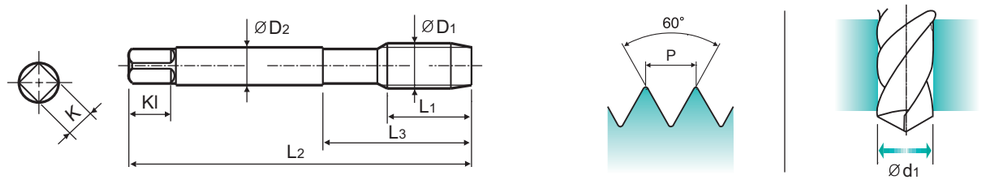
▶ Suitable for through hole in more cutting speed than other taps due to thick web.

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

DIN 374

Hole type 3.0×D





Material groups: VA NW | HSS-E | DIN 374 | 6HX | 60° | B | Vap | p.B193

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
M4 ×	0.5	TB123256	10	63	21	2.8	2.1	5	3	3.5
M5 ×	0.5	TB123296	11	70	25	3.5	2.7	6	3	4.5
M6 ×	0.75	TB123326	13	80	30	4.5	3.4	6	3	5.2
M6 ×	0.5	TB123336	13	80	30	4.5	3.4	6	3	5.5
M7 ×	0.75	TB123356	14	80	30	5.5	4.3	7	3	6.2
M8 ×	1.0	TB123376	17	90	36	6	4.9	8	3	7
M8 ×	0.75	TB123386	14	80	30	6	4.9	8	3	7.2
M10 ×	1.25	TB123436	22	100	40	7	5.5	8	3	8.8
M10 ×	0.75	TB123456	18	90	36	7	5.5	8	3	9.2
M12 ×	1.5	TB123516	22	100	40	9	7	10	4	10.5
M12 ×	1.25	TB123526	22	100	40	9	7	10	3	10.8
M12 ×	1.0	TB123536	18	100	40	9	7	10	3	11
M14 ×	1.5	TB123556	22	100	40	11	9	12	3	12.5
M14 ×	1.25	TB123566	22	100	40	11	9	12	3	12.8
M16 ×	1.5	TB123616	22	100	40	12	9	12	3	14.5
M18 ×	1.5	TB123676	25	110	44	14	11	14	4	16.5
M22 ×	1.5	TB123766	25	125	50	18	14.5	17	4	20.5
M24 ×	1.5	TB123806	27	140	54	18	14.5	17	4	22.5

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	○	○		○						◎	◎	◎						

ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended											○					○					

YG TAP INOX

TB264 SERIES

UNC — Unified coarse threads

- Unified Grobgewinde
- UNC
- Unificato passo grosso

Machine taps
Maschinengewindebohrer

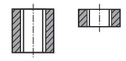
▶ Suitable for through hole in more cutting speed than other taps due to thick web.

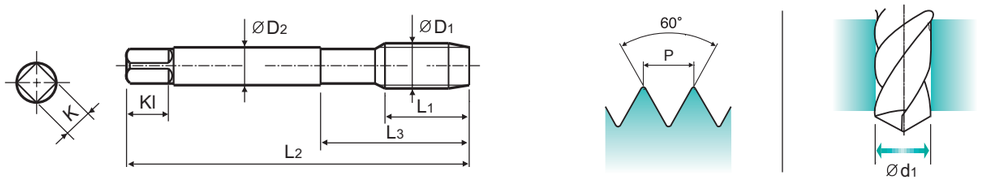
▶ Geeignet für Durchgangslöcher in höherer Schnittgeschwindigkeit als bei anderen Gewindebohrern dank größerer Kerndicke.

DIN 371

DIN 376

Hole type 3.0×D





Material groups: VA NW | HSS-E | DIN 371/376 | 2B | 60° | B | Vap | p.B193

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	Kl	Z	Ød1
#4 -	40UNC	TB264162	11	56	18	3.5	2.7	6	3	2.3
#6 -	32UNC	TB264242	12	56	20	4	3	6	3	2.85
#8 -	32UNC	TB264282	13	63	21	4.5	3.4	6	3	3.5
#10 -	24UNC	TB264322	15	70	25	6	4.9	8	3	3.9
#12 -	24UNC	TB264362	16	80	30	6	4.9	8	3	4.5
1/4 -	20UNC	TB264402	17	80	30	7	5.5	8	3	5.2
5/16 -	18UNC	TB264442	20	90	35	8	6.2	9	3	6.6
3/8 -	16UNC	TB264482	22	100	39	9	7	10	3	8
7/16 -	14UNC	TB264522	22	100	44	8	6.2	9	3	9.4
1/2 -	13UNC	TB264562	25	110	44	9	7	10	3	10.75
9/16 -	12UNC	TB264602	26	110	44	11	9	12	3	12.25
5/8 -	11UNC	TB264642	27	110	44	12	9	12	3	13.5
3/4 -	10UNC	TB264702	30	125	50	14	11	14	4	16.5
7/8 -	9UNC	TB264742	32	140	54	18	14.5	17	4	19.5

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

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	○	○		○						◎	◎	◎						

ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended											○					○					

YG TAP INOX

TB274 SERIES

UNF Unified fine threads

Unified Feingewinde
UNF
Unificato passo fine

Machine taps
Maschinengewindebohrer

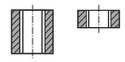
▶ Suitable for through hole in more cutting speed than other taps due to thick web.

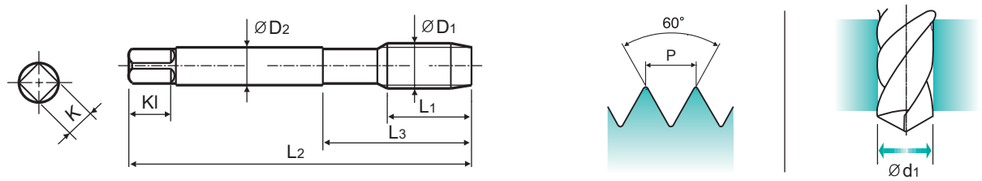
▶ Geeignet für Durchgangslöcher in höherer Schnittgeschwindigkeit als bei anderen Gewindebohrern dank größerer Kerndicke.

DIN 371

DIN 374

Hole type
3.0×D





Material groups VA NW | HSS-E | DIN 371/374 | 2B | 60° | B | Vap

p.B193

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	Kl	Z	Ød1
#4	- 48UNF	**TB274182**	11	56	18	3.5	2.7	6	3	2.4
#5	- 44UNF	**TB274222**	11	56	18	3.5	2.7	6	3	2.7
#10	- 32UNF	**TB274342**	15	70	25	6	4.9	8	3	4.1
1/4	- 28UNF	**TB274422**	17	80	30	7	5.5	8	3	5.5
5/16	- 24UNF	**TB274462**	17	90	35	8	6.2	9	3	6.9
3/8	- 24UNF	**TB274502**	18	100	39	9	7	10	3	8.5
7/16	- 20UNF	**TB274542**	22	100	40	8	6.2	9	3	9.9
1/2	- 20UNF	**TB274582**	22	100	40	9	7	10	3	11.5
5/8	- 18UNF	**TB274662**	22	100	40	12	9	12	3	14.5
3/4	- 16UNF	**TB274722**	25	110	44	14	11	14	4	17.5

▶ 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	◎	◎	○	○		○						◎	◎	◎						

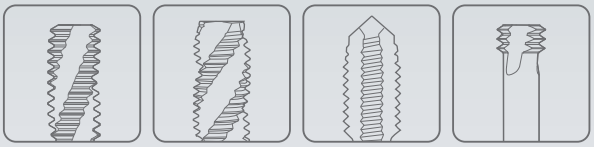
ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	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	400 Rm	1050 Rm	550	630	400	550
Recommended											○					○					

YG TAP INOX

RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDKONDITIONEN

ISO	VDI 3323	Material Description	HB	HRc	TB711	TQ813	TR813	TB914 TB183 TB904 TB924	TI914	TBE15	TBE16	TBE17	TBE18	TCH14	TQ853	TR853	TB623 TB123 TB264 TB274	TCH23
					Vc (m/min.)													
P	1	Non-alloy steel	125		15-20	15-20	15-20	15-20	20-25	15-20	15-20	15-20	15-20	20-25	15-20	15-20	15-20	20-25
	2		190	13	15-20	15-20	15-20	15-20	20-25	15-20	15-20	15-20	15-20	20-25	15-20	15-20	15-20	20-25
	3		250	25		12-18	12-18	12-18	18-24	12-18	12-18	12-18	12-18	18-24	12-18	12-18	12-18	18-24
	4		270	28		10-15	10-15	10-15	15-20	10-15	10-15	10-15	10-15	15-20	10-15	10-15	10-15	15-20
	6	Low alloy steel	180	10		10-15	10-15	10-15	15-20	10-15	10-15	10-15	10-15	15-20	10-15	10-15	10-15	15-20
M	12		200	15	7-10	7-10	7-10	7-10	10-13	7-10	7-10	7-10	7-10	10-13	7-10	7-10	7-10	10-13
	13	Stainless steel	240	23	5-8	5-8	5-8	5-8	8-11	5-8	5-8	5-8	5-8	8-11	5-8	5-8	5-8	8-11
	14		180	10	4-6	4-6	4-6	4-6	6-8	4-6	4-6	4-6	4-6	6-8	4-6	4-6	4-6	6-8
S	31	Heat Resistant Super Alloys	200	15		10-15	10-15	10-15	15-20	10-15	10-15	10-15	10-15	15-20	10-15	10-15	10-15	15-20
	36	Titanium Alloys	400 Rm			10-15	10-15	10-15	15-20	10-15	10-15	10-15	10-15	15-20	10-15	10-15	10-15	15-20

Global Cutting Tool Leader **YG-1**



THREADING