



Leading Through Innovation

HSS-E

YG TAP CHIP BREAKER

YG Gewindebohrer Chip Breaker

- TiN Coated Tap with Chip Breaker for Steel Materials
- TiN-beschichteter Gewindebohrer mit Spanbrecher für Stahlwerkstoffe

YG YG-1 CO., LTD. phone:+82-32-526-0909, www.yg1.solutions, E-mail:yg1@yg1.solutions **B163**

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 TiNi

YG TAP ALU

YG TAP FORMING

YG TAP GENERAL

PIPE TAP

STI TAP

NUT TAP

YG TAP

CHIP BREAKER

TDE25

SERIES

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

Solving the productivity problem caused by long chips.

Particularly suitable for machining non-alloy steel, low alloy steel, high alloy steel, and tool steel

Lösung des durch lange Späne verursachten Produktivitätsproblems

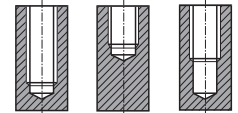
Besonders geeignet für die Bearbeitung von unlegiertem Stahl, niedriglegiertem Stahl, hochlegiertem Stahl und Werkzeugstahl

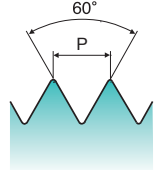
DIN 374

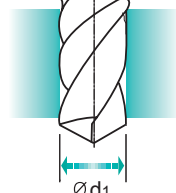


Hole type

2.0×D







ØD2

ØD1

L1

L2

L3

KI

P

60°

R15°

TiN

p.B169

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	KI	Z	Ød1
M8	× 1.0	TDE25376R	10	90	36	6	4.9	8	3	7.0
M10	× 1.25	TDE25436R	16	100	40	7	5.5	8	3	8.8
M10	× 1.0	TDE25446R	10	90	36	7	5.5	8	3	9.0
M12	× 1.5	TDE25516R	15	100	40	9	7.0	10	3	10.5
M12	× 1.25	TDE25526R	15	100	40	9	7.0	10	3	10.8
M14	× 1.5	TDE25556R	15	100	40	11	9.0	12	3	12.5
M16	× 1.5	TDE25616R	15	100	40	12	9.0	12	3	14.5
M18	× 1.5	TDE25676R	17	110	44	14	11.0	14	4	16.5
M20	× 1.5	TDE25726R	17	125	50	16	12.0	15	4	18.5

© : Excellent ○ : Good

ISO	P										M	K									
Material Description	Non-alloy steel					Low alloy steel					High alloy 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																		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																					

B164

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YG

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YG TAP

CHIP BREAKER

TDE26

SERIES

ISO Metric Coarse Threads DIN 13

Metrisches ISO-Gewinde DIN 13

ISO MÉTRIQUE DIN13

ISO Metrico passo grosso DIN 13

Machine taps

Maschinengewindebohrer

Solving the productivity problem caused by long chips.

Particularly suitable for machining non-alloy steel, low alloy steel, high alloy steel, and tool steel

Lösung des durch lange Späne verursachten Produktivitätsproblems

Besonders geeignet für die Bearbeitung von unlegiertem Stahl, niedriglegiertem Stahl, hochlegiertem Stahl und Werkzeugstahl

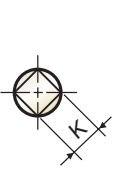
DIN 371



DIN 376

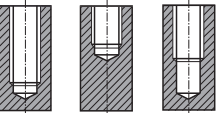


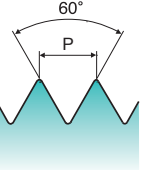
Short Chamfer

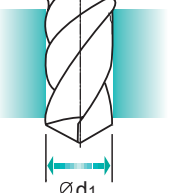


Hole type

2.0×D







ØD2

ØD1

L1

L2

L3

KI

P

60°

R15°

TiN

p.B169

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	KI	Z	Ød1
M4	× 0.7	TDE26246R	7	63	21	4.5	3.4	6	3	3.3
M5	× 0.8	TDE26286R	8	70	25	6	4.9	8	3	4.2
M6	× 1.0	TDE26316R	10	80	30	6	4.9	8	3	5.0
M8	× 1.25	TDE26366R	13	90	35	8	6.2	9	3	6.8
M12	× 1.75	TDE26506R	18	110	44	9	7.0	10	3	10.3
M14	× 2.0	TDE26546R	20	110	44	11	9.0	12	3	12.0
M16	× 2.0	TDE26606R	20	110	44	12	9.0	12	3	14.0
M18	× 2.5	TDE26656R	25	125	50	14	11.0	14	4	15.5
M20	× 2.5	TDE26706R	25	140	54	16	12.0	15	4	17.5

► DIN 371(M4-M10) and DIN 376(M12-M20)

© : Excellent ○ : Good

ISO	P										M	K									
Material Description	Non-alloy steel					Low alloy steel					High alloy 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																		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
CHIP BREAKER

TDE29 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

- Solving the productivity problem caused by long chips.

► Particularly suitable for machining non-alloy steel, low alloy steel, high alloy steel, and tool steel
- Lösung des durch lange Späne verursachten Produktivitätsproblems

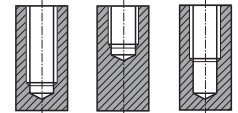
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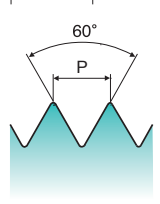
DIN 374

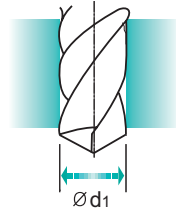


with Internal Coolant

Hole type
2.0×D

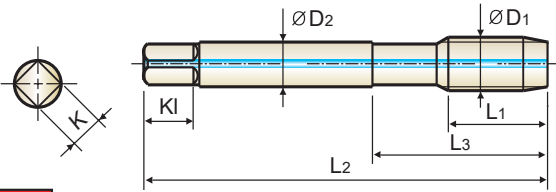






Material groups





Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD ₁	P	TiN	L ₁	L ₂	L ₃	ØD ₂	K	Kl	Z	Ød ₁
M8	× 1.0	TDE29376R	10	90	36	6	4.9	8	3	7.0
M10	× 1.25	TDE29436R	16	100	40	7	5.5	8	3	8.8
M10	× 1.0	TDE29446R	10	90	36	7	5.5	8	3	9.0
M12	× 1.5	TDE29516R	15	100	40	9	7.0	10	3	10.5
M12	× 1.25	TDE29526R	15	100	40	9	7.0	10	3	10.8
M14	× 1.5	TDE29556R	15	100	40	11	9.0	12	3	12.5
M16	× 1.5	TDE29616R	15	100	40	12	9.0	12	3	14.5
M18	× 1.5	TDE29676R	17	110	44	14	11.0	14	4	16.5
M20	× 1.5	TDE29726R	17	125	50	16	12.0	15	4	18.5

◎ : 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																					

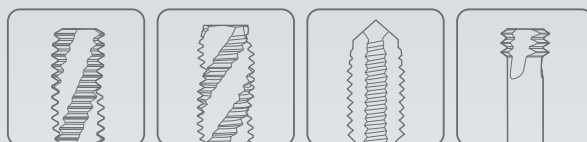
YG TAP
CHIP BREAKER

RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDKONDITIONEN

					TDE24	TDE25	TDE26	TDE27	TDE28	TDE29
ISO	VDI 3323	Material Description	HB	HRc	Vc (m/min.)					
P	1	Non-alloy steel	125		7-12	7-12	7-12	7-12	7-12	7-12
	2		190	13	7-12	7-12	7-12	7-12	7-12	7-12
	3		250	25	4-8	4-8	4-8	4-8	4-8	4-8
	6	Low alloy steel	180	10	7-12	7-12	7-12	7-12	7-12	7-12
	7		275	29	7-12	7-12	7-12	7-12	7-12	7-12
	8		300	32	4-8	4-8	4-8	4-8	4-8	4-8
	9		350	38	4-8	4-8	4-8	4-8	4-8	4-8
	10	High alloyed steel, and tool steel	200	15	6-9	6-9	6-9	6-9	6-9	6-9
	11		325	35	4-8	4-8	4-8	4-8	4-8	4-8



Global Cutting Tool Leader **YG-1**



THREADING