



Leading Through Innovation



HSS-PM



YG TAP Ti Ni

YG TAP Ti Ni

- For Heat Resistant Super Alloys and Titanium Alloys Applied with Cutting Edge Rake Angles and Thread Relief
- Für hitzebeständige Superlegierungen und Titanlegierungen, mit Schneidkanten-Spanwinkeln und Gewindehinterschliff

SELECTION GUIDE



HSS-PM
YG TAP
Ti Ni

For Heat Resistant Super Alloys and Titanium Alloys
Applied with Cutting Edge Rake Angles and Thread Relief



Please visit
globalyg1.com/mat
for material search

◎ : Excellent ○ : Good

Recommended cutting conditions : P.268

HOLE TYPE		Max. 2.5xD Blind Hole		Max. 3.0xD Through Hole		
TOOL MATERIAL		HSS-PM				
CHAMFER LEAD ACC. TO DIN2197		C	C	B	B	
FLUTE TYPE		Spiral Flute	Spiral Flute	Spiral Point	Spiral Point	
SPIRAL FLUTE ANGLE		R25	R25	-	-	
SERIES	M	DIN371/376	TM903 (P.256)	TZ903 (P.257)	TM293 (P.258)	TZ293 (P.259)
		DIN352				
		DIN357/LONG				
	MF	DIN374				
		DIN2181				
	UNC	DIN371/376				
		DIN351				
	UNF	DIN371/374				
		DIN2181				
	BSW	DIN2182/2183				
		DIN351				
	G(BSP)	DIN5156/5157				
	EG-M	DIN371/376				
	EG-UNC	DIN371/376				
EG-UNF	DIN371/374					
SURFACE TREATMENT		Bright	TiAIN	Bright	TiAIN	
MODEL						

ISO	VDI 3323	Material Description	Composition / Structure / Heat Treatment	HB	HRc				
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		Ferritic	160	3				
	18	Nodular cast iron	Pearlitic	250	25				
	19		Ferritic	130					
	20	Malleable cast iron	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 Rubber, Wood, etc.					
	30								
S	31	Heat Resistant Super Alloys	Fe Based Annealed	200	15	○	○	○	○
	32		Cured	280	30			○	○
	33		Annealed	250	25			○	○
	34		Ni or Co Based 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				



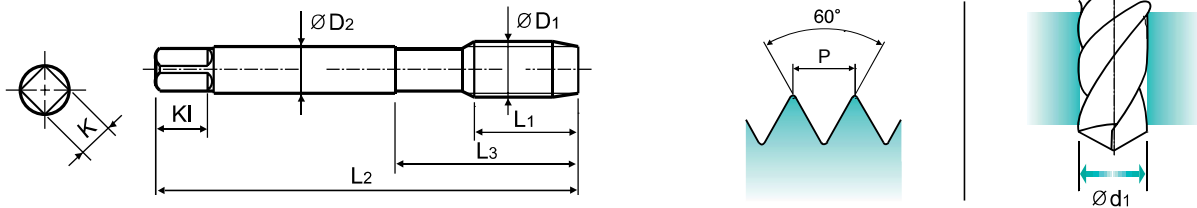
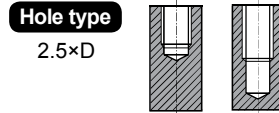
TM903 SERIES

M ISO metric coarse threads DIN 13

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

► 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.



Material groups: **Ti** HSS-PM DIN 371/376 6H 60° C Bright R25 Machine taps Maschinengewindebohrer

Recommended Cutting Page : P.268 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	KI	Z	Ød1
M2 × 0.4		TM903136	8	45	13	2.8	2.1	5	3	1.6
M2.2 × 0.45		TM903156	8	45	13	2.8	2.1	5	3	1.75
*M2.3 × 0.4		TM903196	8	45	13	2.8	2.1	5	3	1.9
M2.5 × 0.45		TM903176	9	50	15	2.8	2.1	5	3	2.05
*M2.6 × 0.45		TM903496	9	50	15	2.8	2.1	5	3	2.1
M3 × 0.5		TM903206	6	56	18	3.5	2.7	6	3	2.5
M3.5 × 0.6		TM903226	7	56	20	4	3	6	3	2.9
M4 × 0.7		TM903246	7	63	21	4.5	3.4	6	3	3.3
M4.5 × 0.75		TM903266	8	70	25	6	4.9	8	3	3.7
M5 × 0.8		TM903286	8	70	25	6	4.9	8	3	4.2
M6 × 1		TM903316	10	80	30	6	4.9	8	3	5
M7 × 1		TM903346	10	80	30	7	5.5	8	3	6
M8 × 1.25		TM903366	13	90	35	8	6.2	9	3	6.8
M9 × 1.25		TM903396	13	90	35	9	7	10	3	7.8
M10 × 1.5		TM903426	15	100	39	10	8	11	3	8.5
M11 × 1.5		TM903466	17	100	40	8	6.2	9	3	9.5
M12 × 1.75		TM903506	18	110	44	9	7	10	3	10.2
M14 × 2		TM903546	20	110	44	11	9	12	3	12
M16 × 2		TM903606	20	110	44	12	9	12	3	14
M18 × 2.5		TM903656	25	125	50	14	11	14	4	15.5
M20 × 2.5		TM903706	25	140	54	16	12	15	4	17.5
M22 × 2.5		TM903746	25	140	54	18	14.5	17	4	19.5
M24 × 3		TM903786	30	160	60	18	14.5	17	4	21
M27 × 3		TM903866	30	160	60	20	16	19	4	24
M30 × 3.5		TM903946	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				
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230		
Recommended						○	○	○	○													

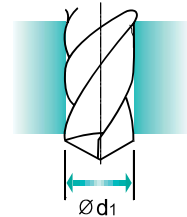
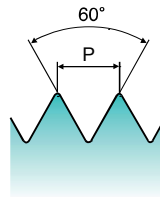
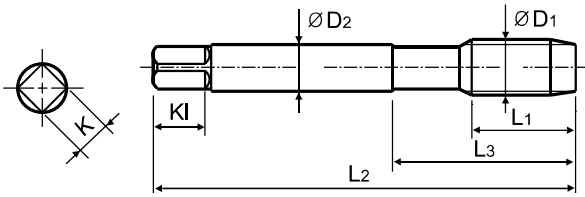
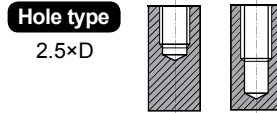
ISO	N										S						H				
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys				Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron		
VDI 3323	21	22	23	24	25	26	27	28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

M ISO metric coarse threads DIN 13

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

► 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.



Ti

HSS-PM

DIN 371/376

6H

60°

C

TiAlN

R25

 Machine taps
 Maschinengewindebohrer

Recommended Cutting Page : P.268

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	TiAlN	L1	L2	L3	ØD2	K	KI	Z	Ød1
M2 × 0.4		TZ903136	8	45	13	2.8	2.1	5	3	1.6
M2.2 × 0.45		TZ903156	8	45	13	2.8	2.1	5	3	1.75
*M2.3 × 0.4		TZ903196	8	45	13	2.8	2.1	5	3	1.9
M2.5 × 0.45		TZ903176	9	50	15	2.8	2.1	5	3	2.05
*M2.6 × 0.45		TZ903496	9	50	15	2.8	2.1	5	3	2.1
M3 × 0.5		TZ903206	6	56	18	3.5	2.7	6	3	2.5
M3.5 × 0.6		TZ903226	7	56	20	4	3	6	3	2.9
M4 × 0.7		TZ903246	7	63	21	4.5	3.4	6	3	3.3
M4.5 × 0.75		TZ903266	8	70	25	6	4.9	8	3	3.7
M5 × 0.8		TZ903286	8	70	25	6	4.9	8	3	4.2
M6 × 1		TZ903316	10	80	30	6	4.9	8	3	5
M7 × 1		TZ903346	10	80	30	7	5.5	8	3	6
M8 × 1.25		TZ903366	13	90	35	8	6.2	9	3	6.8
M9 × 1.25		TZ903396	13	90	35	9	7	10	3	7.8
M10 × 1.5		TZ903426	15	100	39	10	8	11	3	8.5
M11 × 1.5		TZ903466	17	100	40	8	6.2	9	3	9.5
M12 × 1.75		TZ903506	18	110	44	9	7	10	3	10.2
M14 × 2		TZ903546	20	110	44	11	9	12	3	12
M16 × 2		TZ903606	20	110	44	12	9	12	3	14
M18 × 2.5		TZ903656	25	125	50	14	11	14	4	15.5
M20 × 2.5		TZ903706	25	140	54	16	12	15	4	17.5
M22 × 2.5		TZ903746	25	140	54	18	14.5	17	4	19.5
M24 × 3		TZ903786	30	160	60	18	14.5	17	4	21
M27 × 3		TZ903866	30	160	60	20	16	19	4	24
M30 × 3.5		TZ903946	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	42	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											○					○	◎						

THREAD MILLS

SYNCHRO TAPS

COMBO TAPS

YG TAP GENERAL

YG TAP STEEL

YG TAP HARDENED

YG TAP INOX

YG TAP CAST IRON

YG TAP ALU

YG TAP Ti Ni

YG TAP FORMING

NUT TAPS

STI TAPS

PIPE TAPS

TECHNICAL DATA



TM293 SERIES

THREAD MILLS

SYNCHRO TAPS

COMBO TAPS

YG TAP GENERAL

YG TAP STEEL

YG TAP HARDENED

YG TAP INOX

YG TAP CAST IRON

YG TAP ALU

YG TAP Ti Ni

YG TAP FORMING

NUT TAPS

STI TAPS

PIPE TAPS

TECHNICAL DATA

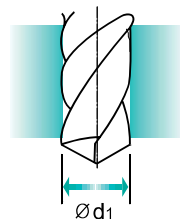
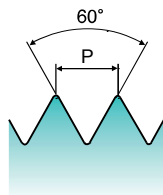
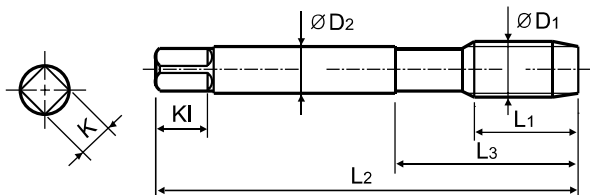
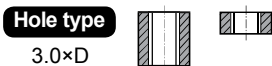
ISO metric coarse threads DIN 13

M-Az

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

► Interrupted tap to reduce contact area and tapping torque, and to give more chip space.

► Gewindebohrer mit ausgesetzten Zähnen um die Kontaktzone mit dem Werkstück und das Drehmoment zu minimieren und dem Span mehr Raum zu geben.



Material groups: **Ti** **HSS-PM** **DIN 371/376** **6H** **60°** **B** **Bright**

Machine taps
Maschinengewindebohrer

Recommended Cutting Page : P.268

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	KI	Z	Ød1
M2 × 0.4		TM293136	8	45	13	2.8	2.1	5	3	1.6
M2.2 × 0.45		TM293156	8	45	13	2.8	2.1	5	3	1.75
*M2.3 × 0.4		TM293196	8	45	13	2.8	2.1	5	3	1.9
M2.5 × 0.45		TM293176	9	50	15	2.8	2.1	5	3	2.05
*M2.6 × 0.45		TM293496	9	50	15	2.8	2.1	5	3	2.1
M3 × 0.5		TM293206	11	56	18	3.5	2.7	6	3	2.5
M3.5 × 0.6		TM293226	12	56	20	4	3	6	3	2.9
M4 × 0.7		TM293246	13	63	21	4.5	3.4	6	3	3.3
M4.5 × 0.75		TM293266	14	70	25	6	4.9	8	3	3.7
M5 × 0.8		TM293286	15	70	25	6	4.9	8	3	4.2
M6 × 1		TM293316	17	80	30	6	4.9	8	3	5
M7 × 1		TM293346	17	80	30	7	5.5	8	3	6
M8 × 1.25		TM293366	20	90	35	8	6.2	9	3	6.8
M9 × 1.25		TM293396	20	90	35	9	7	10	3	7.8
M10 × 1.5		TM293426	22	100	39	10	8	11	3	8.5
M11 × 1.5		TM293466	22	100	40	8	6.2	9	3	9.5
M12 × 1.75		TM293506	24	110	44	9	7	10	3	10.2
M14 × 2		TM293546	26	110	44	11	9	12	3	12
M16 × 2		TM293606	27	110	44	12	9	12	3	14
M18 × 2.5		TM293656	30	125	50	14	11	14	4	15.5
M20 × 2.5		TM293706	32	140	54	16	12	15	4	17.5
M22 × 2.5		TM293746	32	140	54	18	14.5	17	4	19.5
M24 × 3		TM293786	34	160	60	18	14.5	17	4	21
M27 × 3		TM293866	36	160	60	20	16	19	4	24
M30 × 3.5		TM293946	40	180	70	22	18	21	4	26.5

► DIN 371(M2~M10) and DIN 376(M11~M30)

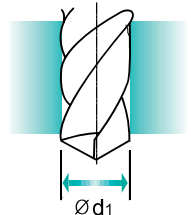
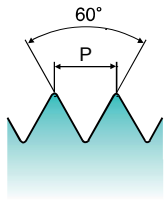
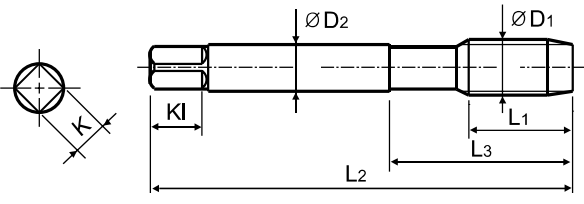
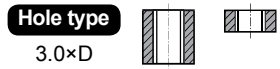
► * DIN profile not ISO

◎ : Excellent ○ : Good

ISO Material Description	P									M				K							
	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel				Stainless steel		Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	
HRc		13	25	28	32	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 Material Description	N										S						H				
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys						Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			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											○	○	○	○	○	○	◎				○

M-Az ISO metric coarse threads DIN 13
 ● Metrisches ISO-Gewinde DIN 13
 ○ ISO MÉTRIQUE DIN13
 ○ ISO Metrico passo grosso DIN 13

▶ Interrupted tap to reduce contact area and tapping torque, and to give more chip space.
 ▶ Gewindebohrer mit ausgesetzten Zähnen um die Kontaktzone mit dem Werkstück und das Drehmoment zu minimieren und dem Span mehr Raum zu geben.



Material groups: **Ti** HSS-PM DIN 371/376 6H 60° B TiAlN

Machine taps
Maschinengewindebohrer

Recommended Cutting Page : P.268 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	TiAlN	L1	L2	L3	ØD2	K	KI	Z	Ød1
M2 × 0.4		TZ293136	8	45	13	2.8	2.1	5	3	1.6
M2.2 × 0.45		TZ293156	8	45	13	2.8	2.1	5	3	1.75
*M2.3 × 0.4		TZ293196	8	45	13	2.8	2.1	5	3	1.9
M2.5 × 0.45		TZ293176	9	50	15	2.8	2.1	5	3	2.05
*M2.6 × 0.45		TZ293496	9	50	15	2.8	2.1	5	3	2.1
M3 × 0.5		TZ293206	11	56	18	3.5	2.7	6	3	2.5
M3.5 × 0.6		TZ293226	12	56	20	4	3	6	3	2.9
M4 × 0.7		TZ293246	13	63	21	4.5	3.4	6	3	3.3
M4.5 × 0.75		TZ293266	14	70	25	6	4.9	8	3	3.7
M5 × 0.8		TZ293286	15	70	25	6	4.9	8	3	4.2
M6 × 1		TZ293316	17	80	30	6	4.9	8	3	5
M7 × 1		TZ293346	17	80	30	7	5.5	8	3	6
M8 × 1.25		TZ293366	20	90	35	8	6.2	9	3	6.8
M9 × 1.25		TZ293396	20	90	35	9	7	10	3	7.8
M10 × 1.5		TZ293426	22	100	39	10	8	11	3	8.5
M11 × 1.5		TZ293466	22	100	40	8	6.2	9	3	9.5
M12 × 1.75		TZ293506	24	110	44	9	7	10	3	10.2
M14 × 2		TZ293546	26	110	44	11	9	12	3	12
M16 × 2		TZ293606	27	110	44	12	9	12	3	14
M18 × 2.5		TZ293656	30	125	50	14	11	14	4	15.5
M20 × 2.5		TZ293706	32	140	54	16	12	15	4	17.5
M22 × 2.5		TZ293746	32	140	54	18	14.5	17	4	19.5
M24 × 3		TZ293786	34	160	60	18	14.5	17	4	21
M27 × 3		TZ293866	36	160	60	20	16	19	4	24
M30 × 3.5		TZ293946	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	42	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											○	○	○	○	○	○	○			○			



TM933 SERIES

M ISO metric coarse threads DIN 13

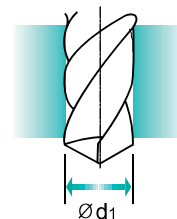
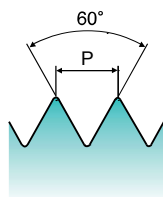
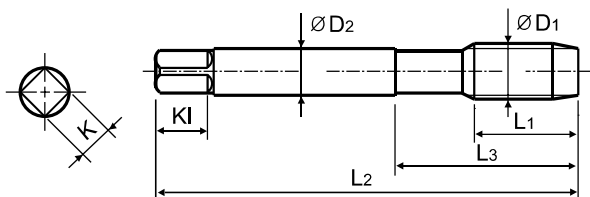
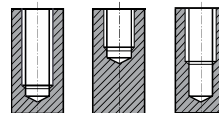
- Metrisches ISO-Gewinde DIN 13
- ISO MÉTRIQUE DIN13
- ISO Metrico passo grosso DIN 13

► For tapping Nickel alloys and heat resistant alloy steels which are used in aerospace and chemical industries.

► Zum Gewindeschneiden von Nickellegierungen und hitzefesten Legierungsstählen, die in der Luftfahrtindustrie und chemischen Industrie verwendet werden.



Hole type
2.5×D



Material groups: **Ni** (HSS-PM, DIN 371/376, 6H, 60°, C, Bright, R40)

Machine taps
Maschinengewindebohrer

Recommended Cutting Page : P.268

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	KI	Z	Ød1
M2 × 0.4		TM933136	8	45	13	2.8	2.1	5	3	1.6
M2.2 × 0.45		TM933156	8	45	13	2.8	2.1	5	3	1.75
*M2.3 × 0.4		TM933196	8	45	13	2.8	2.1	5	3	1.9
M2.5 × 0.45		TM933176	9	50	15	2.8	2.1	5	3	2.05
*M2.6 × 0.45		TM933496	9	50	15	2.8	2.1	5	3	2.1
M3 × 0.5		TM933206	6	56	18	3.5	2.7	6	3	2.5
M3.5 × 0.6		TM933226	7	56	20	4	3	6	3	2.9
M4 × 0.7		TM933246	7	63	21	4.5	3.4	6	3	3.3
M4.5 × 0.75		TM933266	8	70	25	6	4.9	8	3	3.7
M5 × 0.8		TM933286	8	70	25	6	4.9	8	3	4.2
M6 × 1		TM933316	10	80	30	6	4.9	8	3	5
M7 × 1		TM933346	10	80	30	7	5.5	8	3	6
M8 × 1.25		TM933366	13	90	35	8	6.2	9	3	6.8
M9 × 1.25		TM933396	13	90	35	9	7	10	3	7.8
M10 × 1.5		TM933426	15	100	39	10	8	11	3	8.5
M11 × 1.5		TM933466	17	100	40	8	6.2	9	3	9.5
M12 × 1.75		TM933506	18	110	44	9	7	10	3	10.2
M14 × 2		TM933546	20	110	44	11	9	12	3	12
M16 × 2		TM933606	20	110	44	12	9	12	3	14
M18 × 2.5		TM933656	25	125	50	14	11	14	4	15.5
M20 × 2.5		TM933706	25	140	54	16	12	15	4	17.5
M22 × 2.5		TM933746	25	140	54	18	14.5	17	4	19.5
M24 × 3		TM933786	30	160	60	18	14.5	17	4	21
M27 × 3		TM933866	30	160	60	20	16	19	4	24
M30 × 3.5		TM933946	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 Material Description	P									M				K						
	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel				Stainless steel		Grey cast iron		Nodular cast iron		Malleable cast iron
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	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						◎	◎	◎	◎											

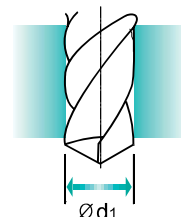
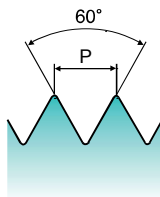
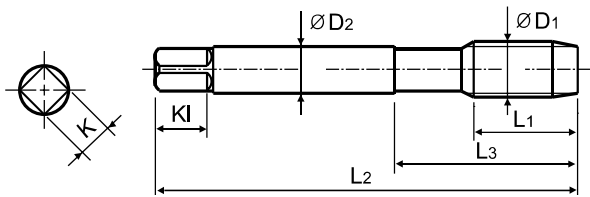
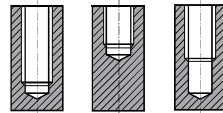
ISO Material Description	N										S						H				
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys						Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			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											◎	◎	◎	◎	◎		○				

M ISO metric coarse threads DIN 13

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

► For tapping Nickel alloys and heat resistant alloy steels which are used in aerospace and chemical industries.

► Zum Gewindeschneiden von Nickellegierungen und hitzefesten Legierungsstählen, die in der Luftfahrtindustrie und chemischen Industrie verwendet werden.


Hole type
2.5×D

Ni
HSS-PM
DIN 371/376
6H

TiAlN

 Machine taps
Maschinengewindebohrer

Recommended Cutting Page : P.268

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	TiAlN	L1	L2	L3	ØD2	K	KI	Z	Ød1
M2 × 0.4		TZ933136	8	45	13	2.8	2.1	5	3	1.6
M2.2 × 0.45		TZ933156	8	45	13	2.8	2.1	5	3	1.75
*M2.3 × 0.4		TZ933196	8	45	13	2.8	2.1	5	3	1.9
M2.5 × 0.45		TZ933176	9	50	15	2.8	2.1	5	3	2.05
*M2.6 × 0.45		TZ933496	9	50	15	2.8	2.1	5	3	2.1
M3 × 0.5		TZ933206	6	56	18	3.5	2.7	6	3	2.5
M3.5 × 0.6		TZ933226	7	56	20	4	3	6	3	2.9
M4 × 0.7		TZ933246	7	63	21	4.5	3.4	6	3	3.3
M4.5 × 0.75		TZ933266	8	70	25	6	4.9	8	3	3.7
M5 × 0.8		TZ933286	8	70	25	6	4.9	8	3	4.2
M6 × 1		TZ933316	10	80	30	6	4.9	8	3	5
M7 × 1		TZ933346	10	80	30	7	5.5	8	3	6
M8 × 1.25		TZ933366	13	90	35	8	6.2	9	3	6.8
M9 × 1.25		TZ933396	13	90	35	9	7	10	3	7.8
M10 × 1.5		TZ933426	15	100	39	10	8	11	3	8.5
M11 × 1.5		TZ933466	17	100	40	8	6.2	9	3	9.5
M12 × 1.75		TZ933506	18	110	44	9	7	10	3	10.2
M14 × 2		TZ933546	20	110	44	11	9	12	3	12
M16 × 2		TZ933606	20	110	44	12	9	12	3	14
M18 × 2.5		TZ933656	25	125	50	14	11	14	4	15.5
M20 × 2.5		TZ933706	25	140	54	16	12	15	4	17.5
M22 × 2.5		TZ933746	25	140	54	18	14.5	17	4	19.5
M24 × 3		TZ933786	30	160	60	18	14.5	17	4	21
M27 × 3		TZ933866	30	160	60	20	16	19	4	24
M30 × 3.5		TZ933946	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	42	55		
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											◎	◎	◎	◎	◎						



TM923 SERIES

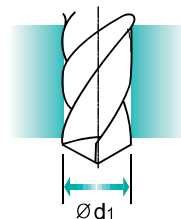
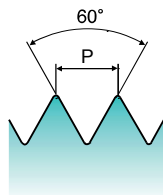
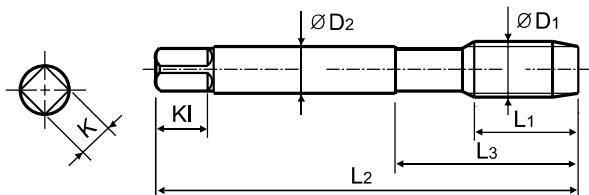
M ISO metric coarse threads DIN 13



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

► For tapping Nickel alloys and heat resistant alloy steels which are used in aero space and chemical industries.

► Zum Gewindeschneiden von Nickellegierungen und hitzefesten Legierungsstählen, die in der Luftfahrtindustrie und chemischen Industrie verwendet werden.



Material groups: **Ni** (HSS-PM, DIN 371/376, 6H, 60°, B, Bright)

Machine taps
Maschinengewindebohrer

Recommended Cutting Page : P.268

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	KI	Z	Ød1
M2 × 0.4		TM923136	8	45	13	2.8	2.1	5	3	1.6
M2.2 × 0.45		TM923156	8	45	13	2.8	2.1	5	3	1.75
*M2.3 × 0.4		TM923196	8	45	13	2.8	2.1	5	3	1.9
M2.5 × 0.45		TM923176	9	50	15	2.8	2.1	5	3	2.05
*M2.6 × 0.45		TM923496	9	50	15	2.8	2.1	5	3	2.1
M3 × 0.5		TM923206	11	56	18	3.5	2.7	6	3	2.5
M3.5 × 0.6		TM923226	12	56	20	4	3	6	3	2.9
M4 × 0.7		TM923246	13	63	21	4.5	3.4	6	3	3.3
M4.5 × 0.75		TM923266	14	70	25	6	4.9	8	3	3.7
M5 × 0.8		TM923286	15	70	25	6	4.9	8	3	4.2
M6 × 1		TM923316	17	80	30	6	4.9	8	3	5
M7 × 1		TM923346	17	80	30	7	5.5	8	3	6
M8 × 1.25		TM923366	20	90	35	8	6.2	9	3	6.8
M9 × 1.25		TM923396	20	90	35	9	7	10	3	7.8
M10 × 1.5		TM923426	22	100	39	10	8	11	3	8.5
M11 × 1.5		TM923466	22	100	40	8	6.2	9	3	9.5
M12 × 1.75		TM923506	24	110	44	9	7	10	3	10.2
M14 × 2		TM923546	26	110	44	11	9	12	3	12
M16 × 2		TM923606	27	110	44	12	9	12	3	14
M18 × 2.5		TM923656	30	125	50	14	11	14	4	15.5
M20 × 2.5		TM923706	32	140	54	16	12	15	4	17.5
M22 × 2.5		TM923746	32	140	54	18	14.5	17	4	19.5
M24 × 3		TM923786	34	160	60	18	14.5	17	4	21
M27 × 3		TM923866	36	160	60	20	16	19	4	24
M30 × 3.5		TM923946	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						◎	◎	◎	◎													

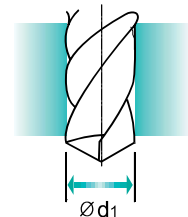
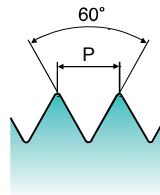
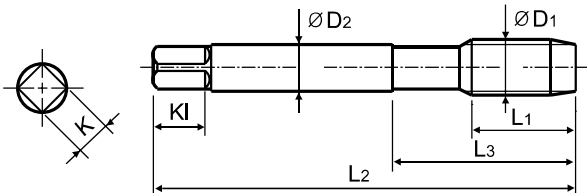
ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron	
VDI 3323	21	22	23	24	25	26	27	28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

M ISO metric coarse threads DIN 13

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

► For tapping Nickel alloys and heat resistant alloy steels which are used in aero space and chemical industries.

► Zum Gewindeschneiden von Nickellegierungen und hitzefesten Legierungsstählen, die in der Luftfahrtindustrie und chemischen Industrie verwendet werden.



Ni HSS-PM DIN 371/376 6H 60° B TiAlN

Machine taps
Maschinengewindebohrer

Recommended Cutting Page : P.268

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	TiAlN	L1	L2	L3	ØD2	K	KI	Z	Ød1
M2 × 0.4		TZ923136	8	45	13	2.8	2.1	5	3	1.6
M2.2 × 0.45		TZ923156	8	45	13	2.8	2.1	5	3	1.75
*M2.3 × 0.4		TZ923196	8	45	13	2.8	2.1	5	3	1.9
M2.5 × 0.45		TZ923176	9	50	15	2.8	2.1	5	3	2.05
*M2.6 × 0.45		TZ923496	9	50	15	2.8	2.1	5	3	2.1
M3 × 0.5		TZ923206	11	56	18	3.5	2.7	6	3	2.5
M3.5 × 0.6		TZ923226	12	56	20	4	3	6	3	2.9
M4 × 0.7		TZ923246	13	63	21	4.5	3.4	6	3	3.3
M4.5 × 0.75		TZ923266	14	70	25	6	4.9	8	3	3.7
M5 × 0.8		TZ923286	15	70	25	6	4.9	8	3	4.2
M6 × 1		TZ923316	17	80	30	6	4.9	8	3	5
M7 × 1		TZ923346	17	80	30	7	5.5	8	3	6
M8 × 1.25		TZ923366	20	90	35	8	6.2	9	3	6.8
M9 × 1.25		TZ923396	20	90	35	9	7	10	3	7.8
M10 × 1.5		TZ923426	22	100	39	10	8	11	3	8.5
M11 × 1.5		TZ923466	22	100	40	8	6.2	9	3	9.5
M12 × 1.75		TZ923506	24	110	44	9	7	10	3	10.2
M14 × 2		TZ923546	26	110	44	11	9	12	3	12
M16 × 2		TZ923606	27	110	44	12	9	12	3	14
M18 × 2.5		TZ923656	30	125	50	14	11	14	4	15.5
M20 × 2.5		TZ923706	32	140	54	16	12	15	4	17.5
M22 × 2.5		TZ923746	32	140	54	18	14.5	17	4	19.5
M24 × 3		TZ923786	34	160	60	18	14.5	17	4	21
M27 × 3		TZ923866	36	160	60	20	16	19	4	24
M30 × 3.5		TZ923946	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	42	55		
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											◎	◎	◎	◎	◎			○	○	○	○



M ISO metric coarse threads DIN 13

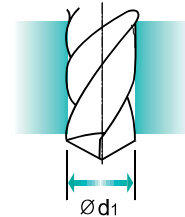
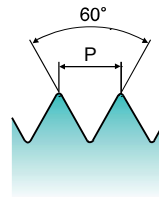
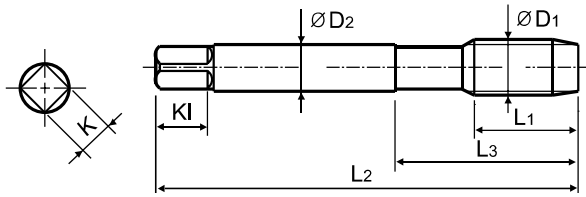
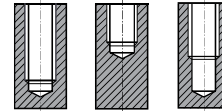
- Metrisches ISO-Gewinde DIN 13
- ISO MÉTRIQUE DIN13
- ISO Metrico passo grosso DIN 13

► 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.



Hole type
2.5×D



Material groups



Machine taps
Maschinengewindebohrer

Recommended Cutting Page : P.268

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	KI	Z	Ød1
M2 × 0.4		TQ833136	8	45	13	2.8	2.1	5	3	1.6
M2.2 × 0.45		TQ833156	8	45	13	2.8	2.1	5	3	1.75
M2.5 × 0.45		TQ833176	9	50	15	2.8	2.1	5	3	2.05
M3 × 0.5		TQ833206	6	56	18	3.5	2.7	6	3	2.5
M3.5 × 0.6		TQ833226	7	56	20	4	3	6	3	2.9
M4 × 0.7		TQ833246	7	63	21	4.5	3.4	6	3	3.3
M4.5 × 0.75		TQ833266	8	70	25	6	4.9	8	3	3.7
M5 × 0.8		TQ833286	8	70	25	6	4.9	8	3	4.2
M6 × 1		TQ833316	10	80	30	6	4.9	8	3	5
M7 × 1		TQ833346	10	80	30	7	5.5	8	3	6
M8 × 1.25		TQ833366	13	90	35	8	6.2	9	3	6.8
M10 × 1.5		TQ833426	15	100	39	10	8	11	3	8.5
M12 × 1.75		TQ833506	18	110	44	9	7	10	3	10.2

►DIN 371(M2~M10) and DIN 376(M12)

◎ : Excellent ○ : Good

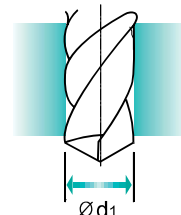
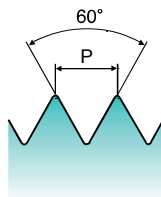
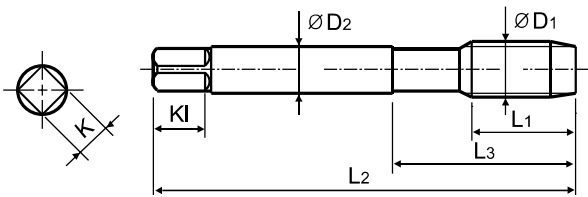
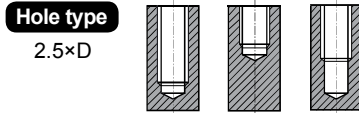
ISO Material Description	P									M				K							
	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel		Grey cast iron		Nodular cast iron		Malleable cast iron			
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	
HRc		13	25	28	32	10	29	32	38	15	35	15	23	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 Material Description	N										S						H				
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys						Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			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											◎	◎	◎	◎	◎	◎	◎	◎			

M ISO metric coarse threads DIN 13

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

► 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.



Ti Ni

HSS-PM

DIN 371/376

6H

60°

C

Bright

R40

Machine taps
Maschinengewindebohrer

Recommended Cutting Page : P.268

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	K1	Z	Ød1
M2 × 0.4		TR833136	8	45	13	2.8	2.1	5	3	1.6
M2.2 × 0.45		TR833156	8	45	13	2.8	2.1	5	3	1.75
M2.5 × 0.45		TR833176	9	50	15	2.8	2.1	5	3	2.05
M3 × 0.5		TR833206	6	56	18	3.5	2.7	6	3	2.5
M3.5 × 0.6		TR833226	7	56	20	4	3	6	3	2.9
M4 × 0.7		TR833246	7	63	21	4.5	3.4	6	3	3.3
M4.5 × 0.75		TR833266	8	70	25	6	4.9	8	3	3.7
M5 × 0.8		TR833286	8	70	25	6	4.9	8	3	4.2
M6 × 1		TR833316	10	80	30	6	4.9	8	3	5
M7 × 1		TR833346	10	80	30	7	5.5	8	3	6
M8 × 1.25		TR833366	13	90	35	8	6.2	9	3	6.8
M10 × 1.5		TR833426	15	100	39	10	8	11	3	8.5
M12 × 1.75		TR833506	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				
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											◎	◎	◎	◎	◎	○	◎				

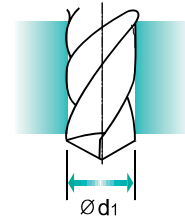
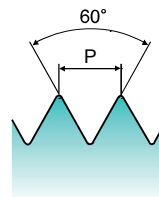
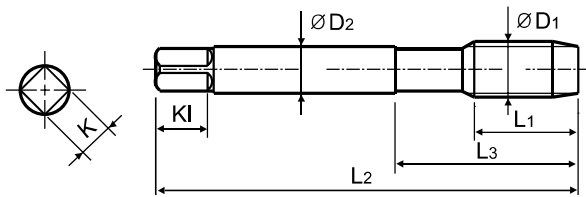
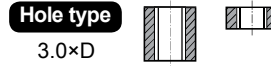


M ISO metric coarse threads DIN 13

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

► 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.



Material groups: **Ti Ni** HSS-PM DIN 371/376 6H 60° B Vap

Machine taps
Maschinengewindebohrer

Recommended Cutting Page : P.268

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	KI	Z	Ød1
M2 × 0.4		TQ873136	8	45	13	2.8	2.1	5	3	1.6
M2.2 × 0.45		TQ873156	8	45	13	2.8	2.1	5	3	1.75
M2.5 × 0.45		TQ873176	9	50	15	2.8	2.1	5	3	2.05
M3 × 0.5		TQ873206	11	56	18	3.5	2.7	6	3	2.5
M3.5 × 0.6		TQ873226	12	56	20	4	3	6	3	2.9
M4 × 0.7		TQ873246	13	63	21	4.5	3.4	6	3	3.3
M4.5 × 0.75		TQ873266	14	70	25	6	4.9	8	3	3.7
M5 × 0.8		TQ873286	15	70	25	6	4.9	8	3	4.2
M6 × 1		TQ873316	17	80	30	6	4.9	8	3	5
M7 × 1		TQ873346	17	80	30	7	5.5	8	3	6
M8 × 1.25		TQ873366	20	90	35	8	6.2	9	3	6.8
M10 × 1.5		TQ873426	22	100	39	10	8	11	3	8.5
M12 × 1.75		TQ873506	24	110	44	9	7	10	3	10.2

► DIN 371(M2~M10) and DIN 376(M12)

◎ : Excellent ○ : Good

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

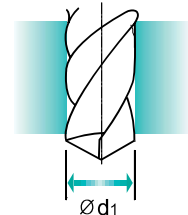
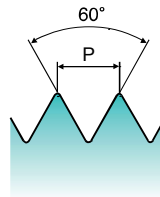
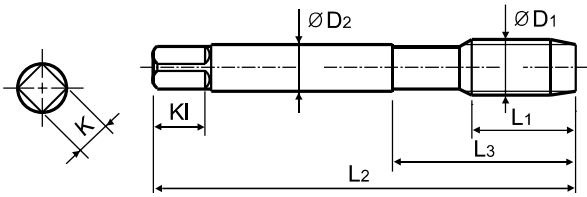
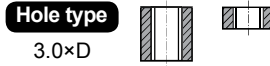
ISO	N										S							H			
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)		Non Metallic Materials			Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron	
Material Description	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
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											◎	◎	◎	◎	◎	○	◎			○	

M ISO metric coarse threads DIN 13

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

► 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.



Material groups: **Ti Ni**, **HSS-PM**, **DIN 371/376**, **6H**, **60°**, **B**, **Bright**

Machine taps
Maschinengewindebohrer

Recommended Cutting Page : P.268

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	KI	Z	Ød1
M2 × 0.4		TR873136	8	45	13	2.8	2.1	5	3	1.6
M2.2 × 0.45		TR873156	8	45	13	2.8	2.1	5	3	1.75
M2.5 × 0.45		TR873176	9	50	15	2.8	2.1	5	3	2.05
M3 × 0.5		TR873206	11	56	18	3.5	2.7	6	3	2.5
M3.5 × 0.6		TR873226	12	56	20	4	3	6	3	2.9
M4 × 0.7		TR873246	13	63	21	4.5	3.4	6	3	3.3
M4.5 × 0.75		TR873266	14	70	25	6	4.9	8	3	3.7
M5 × 0.8		TR873286	15	70	25	6	4.9	8	3	4.2
M6 × 1		TR873316	17	80	30	6	4.9	8	3	5
M7 × 1		TR873346	17	80	30	7	5.5	8	3	6
M8 × 1.25		TR873366	20	90	35	8	6.2	9	3	6.8
M10 × 1.5		TR873426	22	100	39	10	8	11	3	8.5
M12 × 1.75		TR873506	24	110	44	9	7	10	3	10.2

► DIN 371(M2~M10) and DIN 376(M12)

◎ : Excellent ○ : Good

ISO	P										M				K						
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel				Stainless steel		Grey cast iron		Nodular cast iron		Malleable cast iron
Material Description	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	
HRC																					
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										
	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							
Material Description	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRC																					
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550
Recommended											◎	◎	◎	◎	◎	○	◎			○	



RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDKONDITIONEN

THREAD MILLS

SYNCHRO TAPS

COMBO TAPS

YG TAP GENERAL

YG TAP STEEL

YG TAP HARDENED

YG TAP INOX

YG TAP CAST IRON

YG TAP ALU

YG TAP Ti Ni

YG TAP FORMING

NUT TAPS

STI TAPS

PIPE TAPS

TECHNICAL DATA

					TM903	TZ903	TM293	TZ293	TM933	TZ933	TM923	TZ923	TQ833	TR833	TQ873	TR873
ISO	VDI 3323	Material Description	HB	HRC	Vc (m/min)											
P	1	Non-alloy steel	125													
	2		190	13												
	3		250	25												
	4		270	28												
	5		300	32												
	6	Low alloy steel	180	10					10-15	10-15	10-15	10-15	10-15	10-15	10-15	10-15
	7		275	29	10-15	10-15	10-15	10-15	10-15	10-15	10-15	10-15	10-15	10-15	10-15	
	8		300	32	6-10	6-10	6-10	6-10	6-10	6-10	6-10	6-10	6-10	6-10	6-10	
	9		350	38	3-5	3-5	3-5	3-5	3-5	3-5	3-5	3-5	3-5	3-5	3-5	
	10		High alloyed steel, and tool steel	200	15											
	11	325		35												
M	12	Stainless steel	200	15												
	13		240	23												
	14		180	10												
K	15	Grey cast iron	180	10												
	16		260	26												
	17	Nodular cast iron	160	3												
	18		250	25												
	19		Malleable cast iron	130												
20	230	21														
N	21	Aluminum-wrought alloy	60													
	22		100													
	23	Aluminum-cast, alloyed	75													
	24		90													
	25		130													
	26		Copper and Copper Alloys (Bronze / Brass)	110												
	27	90														
	28	100														
	29	Non Metallic Materials														
	30															
S	31	Heat Resistant Super Alloys	200	15	10-15	10-15	10-15	10-15	10-15	10-15	10-15	10-15	10-15	10-15	10-15	
	32		280	30			10-15	10-15	10-15	10-15	10-15	10-15	10-15	10-15	10-15	
	33		250	25			2-4	2-4	2-4	2-4	2-4	2-4	2-4	2-4	2-4	
	34		350	38			2-4	2-4	2-4	2-4	2-4	2-4	2-4	2-4	2-4	
	35		320	34			2-4	2-4	2-4	2-4	2-4	2-4	2-4	2-4	2-4	
	36	Titanium Alloys	400Rm		10-15	10-15	10-15	10-15					10-15	10-15	10-15	10-15
	37		1050Rm		4-6	4-6	4-6	4-6	4-6	4-6	4-6	4-6	4-6	4-6	4-6	
H	38	Hardened steel	550	55								3-5				
	39		630	60												
	40	Chilled Cast Iron	400	42			3-5	3-5			3-5	3-5			3-5	3-5
	41	Hardened Cast Iron	550	55												

HIGH QUALITY PRODUCTS and ON TIME DELIVERY for WORLD-WIDE CUSTOMERS

Since 1982, YG-1 has been committed to quality, innovation and the unique customer experience. Our performance and experience have granted YG-1 the global impression of one of the leading manufacturers of high quality cutting tool solutions. This global footprint expands over 75 countries, with international logistic centers, pledging to our customers to give the best service available today - and tomorrow.

EUROPE

 BELGIUM	 FINLAND	 ITALY	 PORTUGAL	 SLOVENIA	 THE NETHERLANDS
 CROATIA	 FRANCE	 LITHUANIA	 ROMANIA	 SPAIN	 TURKEY
 CZECH REPUBLIC	 GERMANY	 NORWAY	 RUSSIA	 SWEDEN	 UNITED KINGDOM
 DENMARK	 HUNGARY	 POLAND	 SERBIA	 SWITZERLAND	

ASIA PACIFIC

 AUSTRALIA	 INDONESIA	 MALAYSIA	 SINGAPORE	 UNITED ARAB EMIRATES
 CHINA	 ISRAEL	 PAKISTAN	 SOUTH KOREA	 VIETNAM
 HONG KONG	 JAPAN	 PHILIPPINES	 TAIWAN	
 INDIA	 KINGDOM OF SAUDI ARABIA		 THAILAND	

AMERICAS

 BRAZIL	 CANADA	 COLOMBIA	 MEXICO	 UNITED STATES
--	--	--	--	---

AFRICA

 EGYPT	 SOUTH AFRICA
---	--



HEAD OFFICE

211, Sewolcheon-ro, Bupyeong-gu, Incheon, South Korea

Phone: +82-32-526-0909

Http://www.yg1.kr E-mail: yg1@yg1.kr

Note The information is provided for reference only. Tool specifications are subject to change without prior notice.
Although we endeavor to supply accurate and timely information, there can be no guarantee to cover every particular application.
YG-1 or publishers are not liable for any damage for use of the information.



Search 'YG-1' on social media outlets