



Leading Through Innovation



HSS-E

NUT TAPS

MUTTERGEWINDEBOHRER

- Nut Tapping Machines
- Zum Gewindeschneiden von Muttern

SELECTION GUIDE



**HSS-E
NUT
TAPS**

Nut Tapping Machines



Please visit globalyg1.com/mat for material search

◎ : Excellent ○ : Good

Recommended cutting conditions : P.288

HOLE TYPE		Max. 2.0xD Through Hole
TOOL MATERIAL		HSS-E
CHAMFER LEAD ACC. TO DIN2197		Long
FLUTE TYPE		Straight Flute
SPIRAL FLUTE ANGLE		-
SERIES	M	DIN371/376
		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
MODEL		

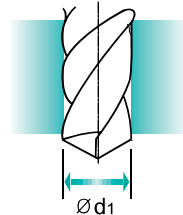
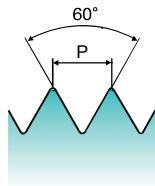
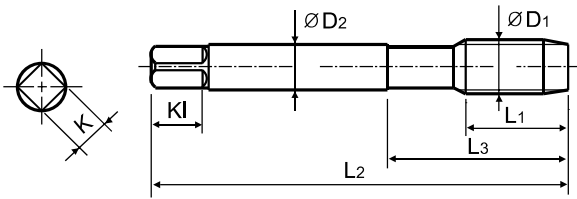
ISO	VDI 3323	Material Description	Composition / Structure / Heat Treatment	HB	Hrc		Vc (m/min)
P	1	Non-alloy steel	About 0.15% C Annealed	125		○	15-20
	2		About 0.45% C Annealed	190	13	○	15-20
	3		About 0.45% C Quenched & Tempered	250	25	○	12-18
	4		About 0.75% C Annealed	270	28	○	10-15
	5	About 0.75% C Quenched & Tempered	300	32			
	6	Low alloy steel	Annealed	180	10	○	10-15
	7		Quenched & Tempered	275	29	○	10-15
	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	○	10-15
	18		Pearlitic	250	25	○	5-8
	19		Ferritic	130			
20	Malleable cast iron	Pearlitic	230	21			
N	21	Aluminum-wrought alloy	Not Curable	60			
	22		Curable Hardened	100			
	23		≤ 12% Si, Not Curable	75			
	24	Aluminum-cast, alloyed	≤ 12% Si, Curable Hardened	90			
	25		> 12% Si, Not Curable	130		○	10-15
	26	Copper and Copper Alloys (Bronze / Brass)	Cutting Alloys, PB>1%	110		○	25-35
	27		CuZn, CuSnZn (Brass)	90		○	8-12
	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		Annealed	250	25		
	34		Ni or Co Based Cured	350	38		
	35		Cast	320	34		
	36	Titanium Alloys	Pure Titanium	400 Rm			
H	37	Hardened steel	Alpha + Beta Alloys Hardened	1050 Rm			
	38		Hardened	550	55		
	39		Hardened	630	60		
	40	Chilled Cast Iron	Cast	400	42		
	41	Hardened Cast Iron	Hardened	550	55		

M ISO metric coarse threads DIN 13
M

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

- ▶ For making nuts on machines.
- ▶ The work pieces can be taken out from shank side only.

- ▶ Zur Herstellung von Muttern auf Sondermaschinen.
- ▶ Die fertigen Muttern können nur über das Schaftende entnommen werden.



Material groups: **GS** **HSS-E** **DIN 357** **6H** **60°** **LONG** **Bright**

 Nut taps
Muttergewindebohrer

Recommended Cutting Page : P.288

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
M4	× 0.7	TC803246	25	90	45	2.8	2.1	5	3	3.3
M5	× 0.8	TC803286	28	100	50	3.5	2.7	6	3	4.2
M6	× 1	TC803316	32	110	55	4.5	3.4	6	3	5
M7	× 1	TC803346	36	110	55	5.5	4.3	7	3	6
M8	× 1.25	TC803366	40	125	62	6	4.9	8	3	6.8
M10	× 1.5	TC803426	45	140	70	7	5.5	8	3	8.5
M12	× 1.75	TC803506	50	180	90	9	7	10	3	10.2
M14	× 2	TC803546	56	200	100	11	9	12	4	12
M16	× 2	TC803606	63	200	100	12	9	12	4	14
M18	× 2.5	TC803656	63	220	110	14	11	14	4	15.5
M20	× 2.5	TC803706	70	250	125	16	12	15	4	17.5

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 TiNi

YG TAP FORMING

NUT TAPS

STI TAPS

PIPE TAPS

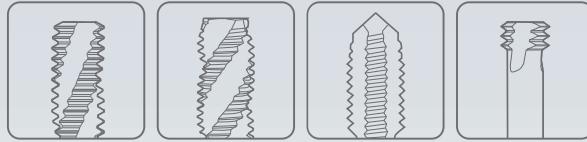
TECHNICAL DATA

◎ : 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	125	130	135	140	145	150	155	160	165	170	175	180	185	190	200	210	220	230	240	250						
HB	125	130	135	140	145	150	155	160	165	170	175	180	185	190	200	210	220	230	240	250						
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	60	100	75	90	130	110	90	100			15	30	25	38	34	200	280	250	350	320	400Rm	1050Rm	550	630	400	550
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550					
Recommended					○	○	○	○																		



Global Cutting Tool Leader **YG-1**



THREADING

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

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 **YG-1 CO., LTD.**

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