



Leading Through Innovation



**SOLID CARBIDE & HSS-E**

# YG TAP HARDENED

## YG HAHN GEHÄRTET

- For Hardened Steels Applications to Control the Continuous and Red-glowing Chips





# SOLID CARBIDE & HSS-E YG TAP HARDENED

For Hardened Steels Applications  
to Control the Continuous and Red-glowing Chips



Please visit  
[globalyg1.com/mat](http://globalyg1.com/mat)  
for material search

◎ : Excellent ○ : Good

Recommended cutting conditions : P.201

HOLE TYPE		Max. 2.0xD Blind / Through Hole	
TOOL MATERIAL		CARBIDE	
CHAMFER LEAD ACC. TO DIN2197		C	D
FLUTE TYPE		Straight Flute	Straight Flute
SPIRAL FLUTE ANGLE		-	-
M	DINB71/376	T0997-TIC (P.194)	T0999-TIC (P.195)
	DINB52		
	DINB57/LONG		
MF	DIN—374		
	DIN2181		
UNC	DINB71/376		
	DINB51		
UNF	DINB71/374		
	DIN2181		
BSW	DIN2182/2183		
	DINB51		
G(BSP)	DIN5156/5157		
EG-M	DINB71/376		
EG-UNC	DINB71/376		
EG-UNF	DINB71/374		
SURFACE TREATMENT		TiCN	TiCN
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	Low alloy steel	About 0.75% C Annealed	270	28		
	5		About 0.75% C Quenched & Tempered	300	32		
	6		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		Fe Based Cured	280	30		
	33		Ni or Co Based Annealed	250	25		
	34		Ni or Co Based Cured	350	38		
	35	Ni or Co Based 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	◎	◎



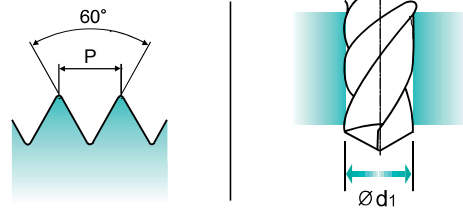
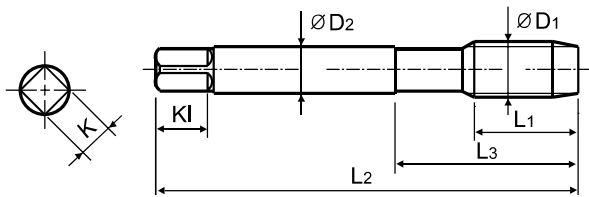
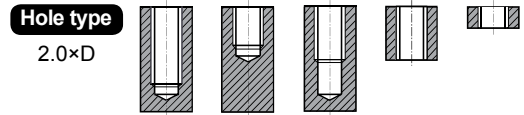


**M ISO metric coarse threads DIN 13**

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

► Carbide tap can increase tool life longer than HSS taps due to higher hardness. Suitable for hardened steels (HRc50~60)

► VHM-Gewindebohrer ermöglichen aufgrund ihrer höheren Härte bessere Standzeiten als HSS-Gewindebohrer. Geeignet für gehärtete Stähle (HRc50~60)



Material groups: **HR** CARBIDE DIN 371/376 6HX 60° C TiCN

Machine taps  
Maschinengewindebohrer

Recommended Cutting Page : P.201

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	TiCN	L1	L2	L3	ØD2	K	KI	Z	Ød1
M3	× 0.5	T0997206TIC	11	56	18	3.5	2.7	6	4	2.55
M4	× 0.7	T0997246TIC	13	63	21	4.5	3.4	6	4	3.4
M5	× 0.8	T0997286TIC	15	70	25	6	4.9	8	4	4.3
M6	× 1	T0997316TIC	17	80	30	6	4.9	8	5	5.1
M8	× 1.25	T0997366TIC	20	90	35	8	6.2	9	5	6.9
M10	× 1.5	T0997426TIC	22	100	39	10	8	11	5	8.6
M12	× 1.75	T0997506TIC	24	110	—	9	7	12	5	10.4
M14	× 2	T0997546TIC	26	110	—	11	9	12	6	12.2
M16	× 2	T0997606TIC	27	110	—	12	9	12	6	14.2
M18	× 2.5	T0997656TIC	30	125	—	14	11	14	6	15.7
M20	× 2.5	T0997706TIC	32	140	—	16	12	15	6	17.7

►DIN 371(M3~M10) and DIN 376(M12~M20)

◎ : 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	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 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																		◎	◎	◎	◎

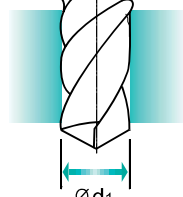
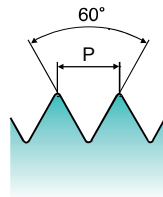
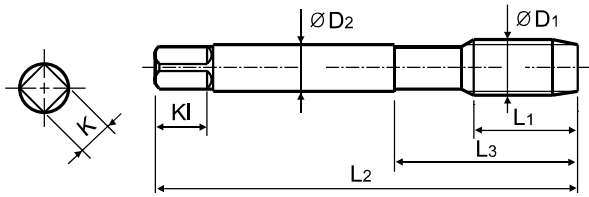
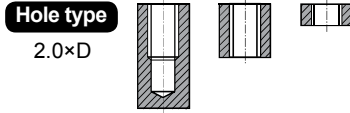


# M ISO metric coarse threads DIN 13

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- ISO Metrico passo grosso DIN 13

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Material groups **HR** **CARBIDE** **DIN 371/376** **6HX** **60°** **D** **TiCN**

Machine taps  
Maschinengewindebohrer

Recommended Cutting Page : P.201

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	TiCN	L1	L2	L3	ØD2	K	KI	Z	Ød1
M3	× 0.5	T0999206TIC	11	56	18	3.5	2.7	6	4	2.55
M4	× 0.7	T0999246TIC	13	63	21	4.5	3.4	6	4	3.4
M5	× 0.8	T0999286TIC	15	70	25	6	4.9	8	4	4.3
M6	× 1	T0999316TIC	17	80	30	6	4.9	8	5	5.1
M8	× 1.25	T0999366TIC	20	90	35	8	6.2	9	5	6.9
M10	× 1.5	T0999426TIC	22	100	39	10	8	11	5	8.6
M12	× 1.75	T0999506TIC	24	110	—	9	7	12	5	10.4
M14	× 2	T0999546TIC	26	110	—	11	9	12	6	12.2
M16	× 2	T0999606TIC	27	110	—	12	9	12	6	14.2
M18	× 2.5	T0999656TIC	30	125	—	14	11	14	6	15.7
M20	× 2.5	T0999706TIC	32	140	—	16	12	15	6	17.7

► DIN 371(M3~M10) and DIN 376(M12~M20)

◎ : 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	13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25	21	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					
	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	60	100	75	90	130	110	90	100			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**

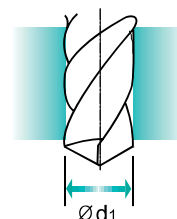
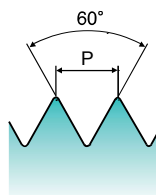
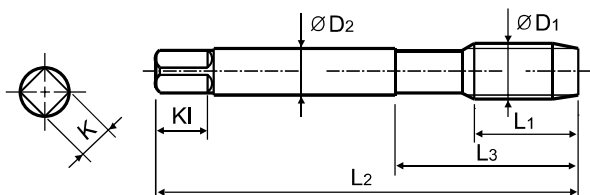
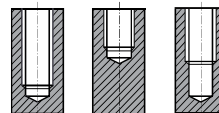
► Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

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



**Hole type**

2.5×D



Material groups

**HR**

HSS-E

DIN 371/376

6H



Bright



Machine taps  
Maschinengewindebohrer

Recommended Cutting Page : P.201

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		TC313136	8	45	13	2.8	2.1	5	3	1.6
M2.2 × 0.45		TC313156	8	45	13	2.8	2.1	5	3	1.75
*M2.3 × 0.4		TC313196	8	45	13	2.8	2.1	5	3	1.9
M2.5 × 0.45		TC313176	9	50	15	2.8	2.1	5	3	2.05
*M2.6 × 0.45		TC313496	9	50	15	2.8	2.1	5	3	2.1
M3 × 0.5		TC313206	6	56	18	3.5	2.7	6	3	2.5
M3.5 × 0.6		TC313226	7	56	20	4	3	6	3	2.9
M4 × 0.7		TC313246	7	63	21	4.5	3.4	6	3	3.3
M4.5 × 0.75		TC313266	8	70	25	6	4.9	8	3	3.7
M5 × 0.8		TC313286	8	70	25	6	4.9	8	3	4.2
M6 × 1		TC313316	10	80	30	6	4.9	8	3	5
M7 × 1		TC313346	10	80	30	7	5.5	8	3	6
M8 × 1.25		TC313366	13	90	35	8	6.2	9	3	6.8
M9 × 1.25		TC313396	13	90	35	9	7	10	3	7.8
M10 × 1.5		TC313426	15	100	39	10	8	11	3	8.5
M11 × 1.5		TC313466	17	100	40	8	6.2	9	3	9.5
M12 × 1.75		TC313506	18	110	44	9	7	10	3	10.2
M14 × 2		TC313546	20	110	44	11	9	12	3	12
M16 × 2		TC313606	20	110	44	12	9	12	3	14
M18 × 2.5		TC313656	25	125	50	14	11	14	4	15.5
M20 × 2.5		TC313706	25	140	54	16	12	15	4	17.5
M22 × 2.5		TC313746	25	140	54	18	14.5	17	4	19.5
M24 × 3		TC313786	30	160	60	18	14.5	17	4	21
M27 × 3		TC313866	30	160	60	20	16	19	4	24
M30 × 3.5		TC313946	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							
	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	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				
	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						○															





**YG TAP  
HARDENED**

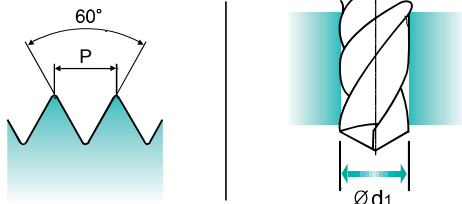
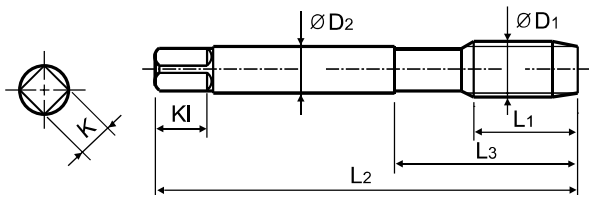
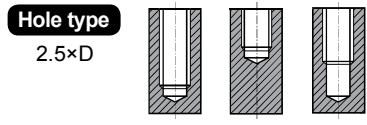
**TB313** SERIES

**M ISO metric coarse threads DIN 13**

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

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



Material groups **HR** **HSS-E** **DIN 371/376** **6H** **60°** **C** **Vap** **R40**

Machine taps  
Maschinengewindebohrer

Recommended Cutting Page : P.201 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		<b>TB313136</b>	8	45	13	2.8	2.1	5	3	1.6
M2.2 × 0.45		<b>TB313156</b>	8	45	13	2.8	2.1	5	3	1.75
*M2.3 × 0.4		<b>TB313196</b>	8	45	13	2.8	2.1	5	3	1.9
M2.5 × 0.45		<b>TB313176</b>	9	50	15	2.8	2.1	5	3	2.05
*M2.6 × 0.45		<b>TB313496</b>	9	50	15	2.8	2.1	5	3	2.1
M3 × 0.5		<b>TB313206</b>	6	56	18	3.5	2.7	6	3	2.5
M3.5 × 0.6		<b>TB313226</b>	7	56	20	4	3	6	3	2.9
M4 × 0.7		<b>TB313246</b>	7	63	21	4.5	3.4	6	3	3.3
M4.5 × 0.75		<b>TB313266</b>	8	70	25	6	4.9	8	3	3.7
M5 × 0.8		<b>TB313286</b>	8	70	25	6	4.9	8	3	4.2
M6 × 1		<b>TB313316</b>	10	80	30	6	4.9	8	3	5
M7 × 1		<b>TB313346</b>	10	80	30	7	5.5	8	3	6
M8 × 1.25		<b>TB313366</b>	13	90	35	8	6.2	9	3	6.8
M9 × 1.25		<b>TB313396</b>	13	90	35	9	7	10	3	7.8
M10 × 1.5		<b>TB313426</b>	15	100	39	10	8	11	3	8.5
M11 × 1.5		<b>TB313466</b>	17	100	40	8	6.2	9	3	9.5
M12 × 1.75		<b>TB313506</b>	18	110	44	9	7	10	3	10.2
M14 × 2		<b>TB313546</b>	20	110	44	11	9	12	3	12
M16 × 2		<b>TB313606</b>	20	110	44	12	9	12	3	14
M18 × 2.5		<b>TB313656</b>	25	125	50	14	11	14	4	15.5
M20 × 2.5		<b>TB313706</b>	25	140	54	16	12	15	4	17.5
M22 × 2.5		<b>TB313746</b>	25	140	54	18	14.5	17	4	19.5
M24 × 3		<b>TB313786</b>	30	160	60	18	14.5	17	4	21
M27 × 3		<b>TB313866</b>	30	160	60	20	16	19	4	24
M30 × 3.5		<b>TB313946</b>	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								
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel					Stainless steel					Grey cast iron		Nodular 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										
	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						○															

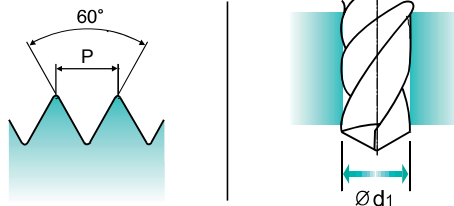
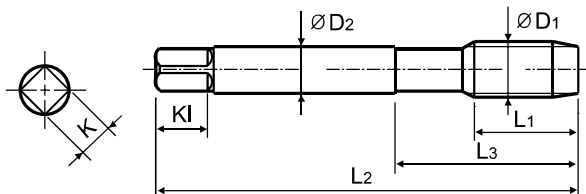
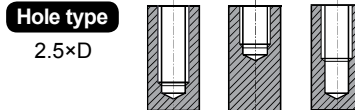


**M ISO metric coarse threads DIN 13**

- 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.



Material groups: **HR** HSS-E DIN 371/376 6H 60° C TiAlN R40

Machine taps  
Maschinengewindebohrer

Recommended Cutting Page : P.201

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		TY313136	8	45	13	2.8	2.1	5	3	1.6
M2.2 × 0.45		TY313156	8	45	13	2.8	2.1	5	3	1.75
*M2.3 × 0.4		TY313196	8	45	13	2.8	2.1	5	3	1.9
M2.5 × 0.45		TY313176	9	50	15	2.8	2.1	5	3	2.05
*M2.6 × 0.45		TY313496	9	50	15	2.8	2.1	5	3	2.1
M3 × 0.5		TY313206	6	56	18	3.5	2.7	6	3	2.5
M3.5 × 0.6		TY313226	7	56	20	4	3	6	3	2.9
M4 × 0.7		TY313246	7	63	21	4.5	3.4	6	3	3.3
M4.5 × 0.75		TY313266	8	70	25	6	4.9	8	3	3.7
M5 × 0.8		TY313286	8	70	25	6	4.9	8	3	4.2
M6 × 1		TY313316	10	80	30	6	4.9	8	3	5
M7 × 1		TY313346	10	80	30	7	5.5	8	3	6
M8 × 1.25		TY313366	13	90	35	8	6.2	9	3	6.8
M9 × 1.25		TY313396	13	90	35	9	7	10	3	7.8
M10 × 1.5		TY313426	15	100	39	10	8	11	3	8.5
M11 × 1.5		TY313466	17	100	40	8	6.2	9	3	9.5
M12 × 1.75		TY313506	18	110	44	9	7	10	3	10.2
M14 × 2		TY313546	20	110	44	11	9	12	3	12
M16 × 2		TY313606	20	110	44	12	9	12	3	14
M18 × 2.5		TY313656	25	125	50	14	11	14	4	15.5
M20 × 2.5		TY313706	25	140	54	16	12	15	4	17.5
M22 × 2.5		TY313746	25	140	54	18	14.5	17	4	19.5
M24 × 3		TY313786	30	160	60	18	14.5	17	4	21
M27 × 3		TY313866	30	160	60	20	16	19	4	24
M30 × 3.5		TY313946	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		
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						○															







# YG TAP HARDENED

## TC283 SERIES

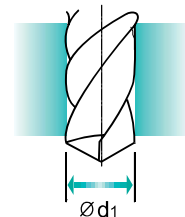
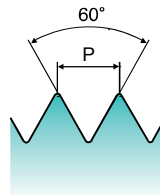
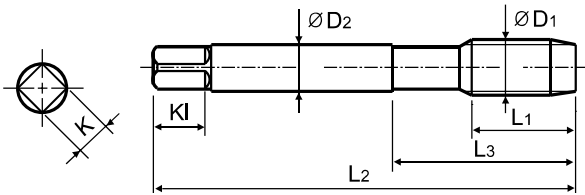
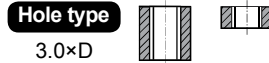
# M

### 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.

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



Material groups **HR**

HSS-E

DIN 371/376

6H



Bright

Machine taps  
Maschinengewindebohrer

Recommended Cutting Page : P.201

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		TC283136	8	45	13	2.8	2.1	5	3	1.6
M2.2 × 0.45		TC283156	8	45	13	2.8	2.1	5	3	1.75
*M2.3 × 0.4		TC283196	8	45	13	2.8	2.1	5	3	1.9
M2.5 × 0.45		TC283176	9	50	15	2.8	2.1	5	3	2.05
*M2.6 × 0.45		TC283496	9	50	15	2.8	2.1	5	3	2.1
M3 × 0.5		TC283206	11	56	18	3.5	2.7	6	3	2.5
M3.5 × 0.6		TC283226	12	56	20	4	3	6	3	2.9
M4 × 0.7		TC283246	13	63	21	4.5	3.4	6	3	3.3
M4.5 × 0.75		TC283266	14	70	25	6	4.9	8	3	3.7
M5 × 0.8		TC283286	15	70	25	6	4.9	8	3	4.2
M6 × 1		TC283316	17	80	30	6	4.9	8	3	5
M7 × 1		TC283346	17	80	30	7	5.5	8	3	6
M8 × 1.25		TC283366	20	90	35	8	6.2	9	3	6.8
M9 × 1.25		TC283396	20	90	35	9	7	10	3	7.8
M10 × 1.5		TC283426	22	100	39	10	8	11	3	8.5
M11 × 1.5		TC283466	22	100	40	8	6.2	9	3	9.5
M12 × 1.75		TC283506	24	110	44	9	7	10	3	10.2
M14 × 2		TC283546	26	110	44	11	9	12	3	12
M16 × 2		TC283606	27	110	44	12	9	12	3	14
M18 × 2.5		TC283656	30	125	50	14	11	14	4	15.5
M20 × 2.5		TC283706	32	140	54	16	12	15	4	17.5
M22 × 2.5		TC283746	32	140	54	18	14.5	17	4	19.5
M24 × 3		TC283786	34	160	60	18	14.5	17	4	21
M27 × 3		TC283866	36	160	60	20	16	19	4	24
M30 × 3.5		TC283946	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			
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 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

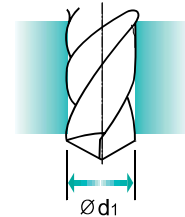
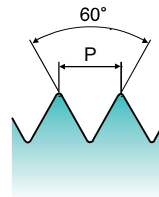
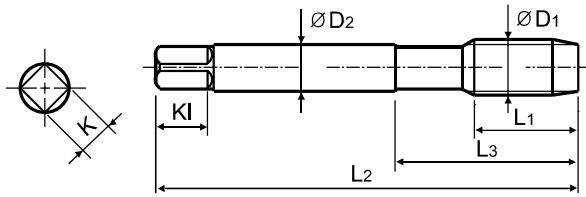


**M ISO metric coarse threads DIN 13**

- 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.

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



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

Machine taps  
Maschinengewindebohrer

Recommended Cutting Page : P.201

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		TY283136	8	45	13	2.8	2.1	5	3	1.6
M2.2 × 0.45		TY283156	8	45	13	2.8	2.1	5	3	1.75
*M2.3 × 0.4		TY283196	8	45	13	2.8	2.1	5	3	1.9
M2.5 × 0.45		TY283176	9	50	15	2.8	2.1	5	3	2.05
*M2.6 × 0.45		TY283496	9	50	15	2.8	2.1	5	3	2.1
M3 × 0.5		TY283206	11	56	18	3.5	2.7	6	3	2.5
M3.5 × 0.6		TY283226	12	56	20	4	3	6	3	2.9
M4 × 0.7		TY283246	13	63	21	4.5	3.4	6	3	3.3
M4.5 × 0.75		TY283266	14	70	25	6	4.9	8	3	3.7
M5 × 0.8		TY283286	15	70	25	6	4.9	8	3	4.2
M6 × 1		TY283316	17	80	30	6	4.9	8	3	5
M7 × 1		TY283346	17	80	30	7	5.5	8	3	6
M8 × 1.25		TY283366	20	90	35	8	6.2	9	3	6.8
M9 × 1.25		TY283396	20	90	35	9	7	10	3	7.8
M10 × 1.5		TY283426	22	100	39	10	8	11	3	8.5
M11 × 1.5		TY283466	22	100	40	8	6.2	9	3	9.5
M12 × 1.75		TY283506	24	110	44	9	7	10	3	10.2
M14 × 2		TY283546	26	110	44	11	9	12	3	12
M16 × 2		TY283606	27	110	44	12	9	12	3	14
M18 × 2.5		TY283656	30	125	50	14	11	14	4	15.5
M20 × 2.5		TY283706	32	140	54	16	12	15	4	17.5
M22 × 2.5		TY283746	32	140	54	18	14.5	17	4	19.5
M24 × 3		TY283786	34	160	60	18	14.5	17	4	21
M27 × 3		TY283866	36	160	60	20	16	19	4	24
M30 × 3.5		TY283946	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		
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						○															



					T0997-TIC	T0999-TIC	TC313 TB313 TY313	TC283 TY283
ISO	VDI 3323	Material Description	HB	HRc	Vc (m/min)			
<b>P</b>	1	Non-alloy steel	125					
	2		190	13				
	3		250	25				
	4		270	28				
	5		300	32				
	6	Low alloy steel	180	10				
	7		275	29			10-15	10-15
	8		300	32			6-10	6-10
	9		350	38	5-8	5-8	3-5	3-5
	10	High alloyed steel, and tool steel	200	15				
	11		325	35				
<b>M</b>	12	Stainless steel	200	15				
	13		240	23				
	14		180	10			4-6	4-6
<b>K</b>	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					
<b>N</b>	21	Aluminum-wrought alloy	60					
	22		100					
	23	Aluminum-cast, alloyed	75					
	24		90					
	25		130					
	26		110				25-35	25-35
	27	Copper and Copper Alloys (Bronze / Brass)	90					
	28		100					
	29	Non Metallic Materials						
	30							
<b>S</b>	31	Heat Resistant Super Alloys	200	15				
	32		280	30				
	33		250	25				
	34		350	38				
	35		320	34				
	36	Titanium Alloys	400 Rm					
	37		1050 Rm					
<b>H</b>	38	Hardened steel	550	55	3-7	3-7		
	39		630	60	3-7	3-7		
	40	Chilled Cast Iron	400	42	3-7	3-7		
	41	Hardened Cast Iron	550	55	3-7	3-7		

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

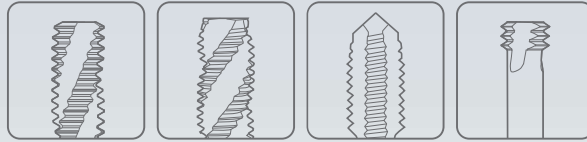
PIPE TAPS

TECHNICAL DATA





Global Cutting Tool Leader **YG-1**



# THREADING



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 EGYPT	 SOUTH AFRICA
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