

# HSS



Being the best through innovation



# COMBO TAPS

# COMBO GEWINDEBOHRER

- Spiral Point, Spiral Flute Type  
Multi Purpose tapping, YG-1's Patent
- gerade- und drallgenutet  
Mehrzweckgewindebohrer. YG-1 Patent









# SELECTION GUIDE

## COMBO TAPS (Spiral Point & Spiral Flute)

Multi Purpose tapping, YG-1's Patent

### COMBO TAPS

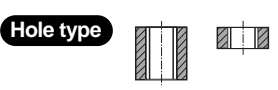
● SPIRAL POINT TAP ● SPIRAL FLUTE TAP

EDP No.	MODEL	Tool Material	Standard	Work Material	Dimensions	Tolerance	Chamfer	Surface Treatment	PAGE
● TC814		HSS-E	M	<b>MU</b>	DIN 371/376	ISO 6H	B	Bright	<b>327</b>
● TC854		HSS-E	MF	<b>MU</b>	DIN 374	ISO 6H	B	Bright	<b>328</b>
● TC834		HSS-E	UNC	<b>MU</b>	DIN 371/376	2B	B	Bright	<b>330</b>
● TC874		HSS-E	UNF	<b>MU</b>	DIN 371/374	2B	B	Bright	<b>331</b>
● TC804		HSS-E	M	<b>MU</b>	DIN 371/376	ISO 6H	C	Bright	<b>332</b>
● TC844		HSS-E	MF	<b>MU</b>	DIN 374	ISO 6H	C	Bright	<b>333</b>
● TC824		HSS-E	UNC	<b>MU</b>	DIN 371/376	2B	C	Bright	<b>335</b>
● TC864		HSS-E	UNF	<b>MU</b>	DIN 371/374	2B	C	Bright	<b>336</b>

**M ISO Metric coarse threads DIN 13**  
**Metrisches ISO-Gewinde DIN 13**

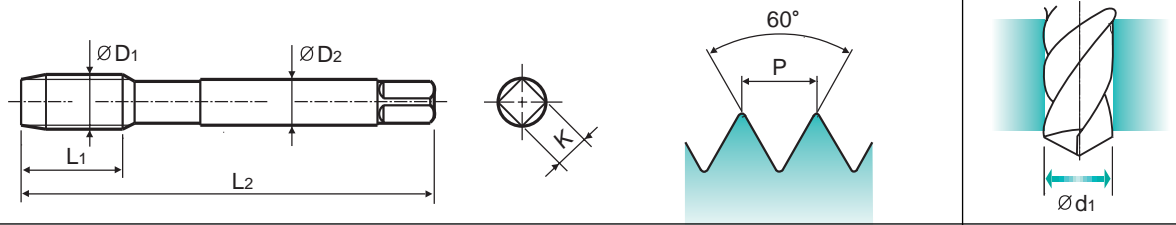
► For using multi-purpose, and correct thread profiles & long tool life due to special tap geometry. YG-1 company has a patent.

► Für vielfältigen Einsatz, genaue Gewindeprofile und lange Standzeit dank einer besonderen Schneidengeometrie. Von YG-1 patentiert.



Material groups **MU** HSS-E DIN 371/376 6H 60° B Bright

Machine taps  
Maschinengewindebohrer



SIZE	Pitch	EDP No.	Thread Length	Overall Length	Shank Diameter	Square Size	Tapping drill diameter
ØD1	P		L1	L2	ØD2	K	Ød1
M2	× 0.4	TC814136	8	45	2.8	2.1	1.6
M2.2	× 0.45	TC814156	8	45	2.8	2.1	1.75
M2.3	× 0.4	TC814196	8	45	2.8	2.1	1.9
M2.5	× 0.45	TC814176	9	50	2.8	2.1	2.05
M2.6	× 0.45	TC814496	9	50	2.8	2.1	2.1
M3	× 0.5	TC814206	11	56	3.5	2.7	2.5
M3.5	× 0.6	TC814226	12	56	4	3	2.9
M4	× 0.7	TC814246	13	63	4.5	3.4	3.3
M4.5	× 0.75	TC814266	14	70	6	4.9	3.7
M5	× 0.8	TC814286	15	70	6	4.9	4.2
M6	× 1.0	TC814316	17	80	6	4.9	5
M7	× 1.0	TC814346	17	80	7	5.5	6
M8	× 1.25	TC814366	20	90	8	6.2	6.8
M9	× 1.25	TC814396	20	90	9	7	7.8
M10	× 1.5	TC814426	22	100	10	8	8.5
M11	× 1.5	TC814466	22	100	8	6.2	9.5
M12	× 1.75	TC814506	24	110	9	7	10.2
M14	× 2.0	TC814546	26	110	11	9	12
M16	× 2.0	TC814606	27	110	12	9	14
M18	× 2.5	TC814656	30	125	14	11	15.5
M20	× 2.5	TC814706	32	140	16	12	17.5
M22	× 2.5	TC814746	32	140	18	14.5	18.5
M24	× 3.0	TC814786	34	160	18	14.5	21
M27	× 3.0	TC814866	36	160	20	16	24
M30	× 3.5	TC814946	40	180	22	18	26.5

► DIN371 (M2~M10) and DIN376 (M11~M30)  
 ► Coating(TiN, TiCN or TiAlN) or Surface Treatment(Steam Homo) is available on your request.

Unit : N/mm<sup>2</sup> ◎ : Excellent ○ : Good

Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

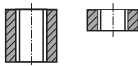
- HSS
- CARBIDE
- COMBO TAPS
- SPIRAL POINT TAPS
- SPIRAL FLUTE TAPS
- STRAIGHT FLUTE TAPS
- COLD FORMING TAPS
- NUT TAPS
- STI TAPS
- HAND TAPS
- PIPE TAPS
- CARBIDE TAPS
- THREAD MILLS
- TECHNICAL DATA

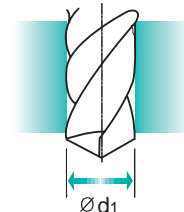
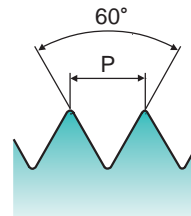
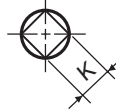
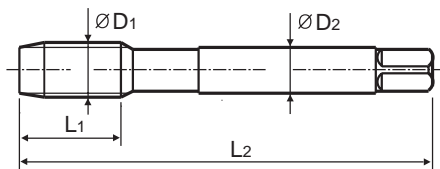
# MF ISO Metric fine threads DIN 13

## Metrisches ISO-Feingewinde DIN 13

► For using multi-purpose, and correct thread profiles & long tool life due to special tap geometry. YG-1 company has a patent.

► Für vielfältigen Einsatz, genaue Gewindeprofile und lange Standzeitendank einer besonderen Schneidengeometrie. Von YG-1 patentiert.

**Hole type**

**DIN 374**
**MU**
**HSS-E**
**DIN 374**
**6H**

**Bright**
**Machine taps**  
**Maschinengewindebohrer**


Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Shank Diameter	Square Size	Tapping drill diameter
ØD1	P		L1	L2	ØD2	K	Ød1
M4	× 0.5	<b>TC854256</b>	10	63	2.8	2.1	3.5
M5	× 0.5	<b>TC854296</b>	11	70	3.5	2.7	4.5
M6	× 0.75	<b>TC854326</b>	13	80	4.5	3.4	5.2
M6	× 0.5	<b>TC854336</b>	13	80	4.5	3.4	5.5
M7	× 0.75	<b>TC854356</b>	14	80	5.5	4.3	6.2
M8	× 1.0	<b>TC854376</b>	17	90	6	4.9	7
M8	× 0.75	<b>TC854386</b>	14	80	6	4.9	7.2
M10	× 1.25	<b>TC854436</b>	22	100	7	5.5	8.8
M10	× 1.0	<b>TC854446</b>	18	90	7	5.5	9
M10	× 0.75	<b>TC854456</b>	18	90	7	5.5	9.2
M12	× 1.5	<b>TC854516</b>	22	100	9	7	10.5
M12	× 1.25	<b>TC854526</b>	22	100	9	7	10.8
M12	× 1.0	<b>TC854536</b>	18	100	9	7	11
M14	× 1.5	<b>TC854556</b>	22	100	11	9	12.5
M14	× 1.25	<b>TC854566</b>	22	100	11	9	12.8
M14	× 1.0	<b>TC854576</b>	18	100	11	9	13

► Coating(TIN, TiCN or TiAlN) or Surface Treatment(Steam Homo) is available on your request.

Unit : N/mm<sup>2</sup>

◎ : Excellent ○ : Good

Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
○	○	○	○	○	○	○	○	○	○	○	○	○	○	○
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

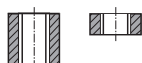
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Hole type



DIN 374

Material groups  
**MU**

HSS-E

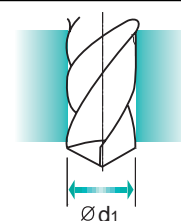
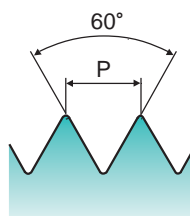
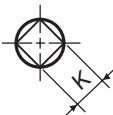
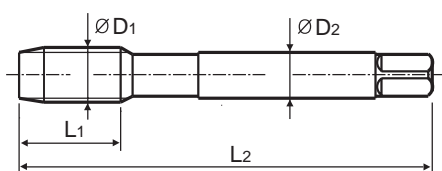
DIN 374

6H



Bright

Machine taps  
Maschinengewindebohrer



Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Shank Diameter	Square Size	Tapping drill diameter
ØD1	P		L1	L2	ØD2	K	Ød1
M16	× 1.5	TC854616	22	100	12	9	14.5
M16	× 1.0	TC854626	18	100	12	9	15
M18	× 1.5	TC854676	25	110	14	11	16.5
M18	× 1.0	TC854686	20	110	14	11	17
M20	× 1.5	TC854726	25	125	16	12	18.5
M20	× 1.0	TC854736	20	125	16	12	19
M22	× 1.5	TC854766	25	125	18	14.5	20.5
M22	× 1.0	TC854776	20	125	18	14.5	21
M24	× 2.0	TC854796	27	140	18	14.5	22
M24	× 1.5	TC854806	27	140	18	14.5	22.5
M26	× 1.5	TC854856	28	140	18	14.5	24.5
M27	× 2.0	TC854876	28	140	20	16	25
M27	× 1.5	TC854886	28	140	20	16	25.5
M28	× 1.5	TC854916	28	140	20	16	26.5
M30	× 2.0	TC854966	30	150	22	18	28
M30	× 1.5	TC854976	30	150	22	18	28.5

► Coating(TIN, TiCN or TiAlN) or Surface Treatment(Steam Homo) is available on your request.

Unit : N/mm<sup>2</sup>

◎ : Excellent ○ : Good

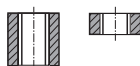
Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

**UNC** Unified coarse threads  
Unified Grobgewinde

► For using multi-purpose, and correct thread profiles & long tool life due to special tap geometry. YG-1 company has a patent.

► Für vielfältigen Einsatz, genaue Gewindeprofile und lange Standzeitendank einer besonderen Schneidengeometrie. Von YG-1 patentiert.

Hole type



HSS-E

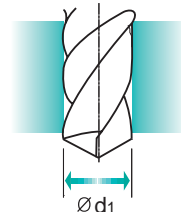
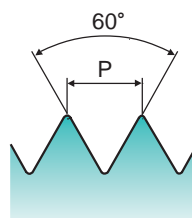
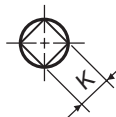
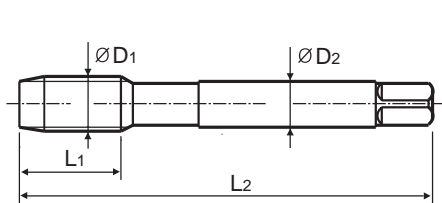
DIN 371/376

2B



Bright

Machine taps  
Maschinengewindebohrer



Unit : mm

SIZE	TPI	EDP No.	Thread Length	Overall Length	Shank Diameter	Square Size	Tapping drill diameter
ØD1			L1	L2	ØD2	K	Ød1
#4	- 40 UNC	TC834162	11	56	3.5	2.7	2.3
#5	- 40 UNC	TC834202	11	56	3.5	2.7	2.6
#6	- 32 UNC	TC834242	12	56	4	3	2.85
#8	- 32 UNC	TC834282	13	63	4.5	3.4	3.5
#10	- 24 UNC	TC834322	15	70	6	4.9	3.9
#12	- 24 UNC	TC834362	16	80	6	4.9	4.5
1/4"	- 20 UNC	TC834402	17	80	7	5.5	5.2
5/16"	- 18 UNC	TC834442	20	90	8	6.2	6.6
3/8"	- 16 UNC	TC834482	22	100	9	7	8
7/16"	- 14 UNC	TC834522	22	100	8	6.2	9.4
1/2"	- 13 UNC	TC834562	25	110	9	7	10.75
9/16"	- 12 UNC	TC834602	26	110	11	9	12.25
5/8"	- 11 UNC	TC834642	27	110	12	9	13.5
3/4"	- 10 UNC	TC834702	30	125	14	11	16.5
7/8"	- 9 UNC	TC834742	32	140	18	14.5	19.5
1"	- 8 UNC	TC834782	36	160	20	16	22.25

► DIN371 (#4~3/8") and DIN376 (7/16"~1")

► Coating(TiN, TiCN or TiAlN) or Surface Treatment(Steam Homo) is available on your request.

Unit : N/mm<sup>2</sup>

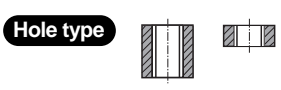
◎ : Excellent ○ : Good

Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

**UNF** Unified fine threads  
Unified Feingewinde

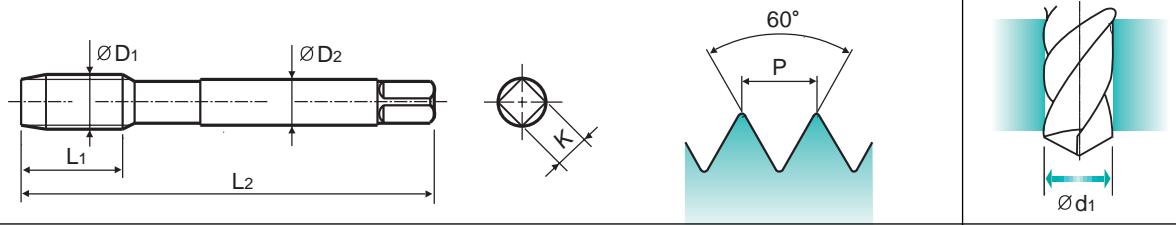
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Material groups **MU** HSS-E DIN 371/374 2B 60° B Bright

Machine taps  
Maschinengewindebohrer



SIZE	TPI	EDP No.	Thread Length	Overall Length	Shank Diameter	Square Size	Tapping drill diameter
ØD1			L1	L2	ØD2	K	Ød1
#4	- 48UNF	TC874182	11	56	3.5	2.7	2.4
#5	- 44UNF	TC874222	11	56	3.5	2.7	2.7
#6	- 40UNF	TC874262	12	56	4	3	3
#8	- 36UNF	TC874302	13	63	4.5	3.4	3.5
#10	- 32UNF	TC874342	15	70	6	4.9	4.1
#12	- 28UNF	TC874382	16	80	6	4.9	4.7
1/4"	- 28UNF	TC874422	17	80	7	5.5	5.5
5/16"	- 24UNF	TC874462	17	90	8	6.2	6.9
3/8"	- 24UNF	TC874502	18	100	9	7	8.5
7/16"	- 20UNF	TC874542	22	100	8	6.2	9.9
1/2"	- 20UNF	TC874582	22	100	9	7	11.5
9/16"	- 18UNF	TC874622	22	100	11	9	12.9
5/8"	- 18UNF	TC874662	22	100	12	9	14.5
3/4"	- 16UNF	TC874722	25	110	14	11	17.5
7/8"	- 14UNF	TC874762	26	125	18	14.5	20.5
1"	- 12UNF	TC874802	28	140	20	16	23.25

Unit : mm

► DIN371 (#4~3/8") and DIN374 (7/16"~1")  
 ► Coating(TiN, TiCN or TiAlN) or Surface Treatment(Steam Homo) is available on your request.

Unit : N/mm<sup>2</sup> © : Excellent ○ : Good

Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
○	○	○	○	○	○	○	○	○	○	○	○	○	○	○
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

- HSS
- CARBIDE
- COMBO TAPS
- SPIRAL POINT TAPS
- SPIRAL FLUTE TAPS
- STRAIGHT FLUTE TAPS
- COLD FORMING TAPS
- NUT TAPS
- STI TAPS
- HAND TAPS
- PIPE TAPS
- CARBIDE TAPS
- THREAD MILLS
- TECHNICAL DATA

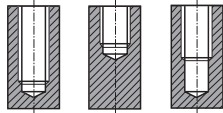
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## Metrisches ISO-Gewinde DIN 13

► For using multi-purpose, and correct thread profiles & long tool life due to special tap geometry. YG-1 company has a patent.

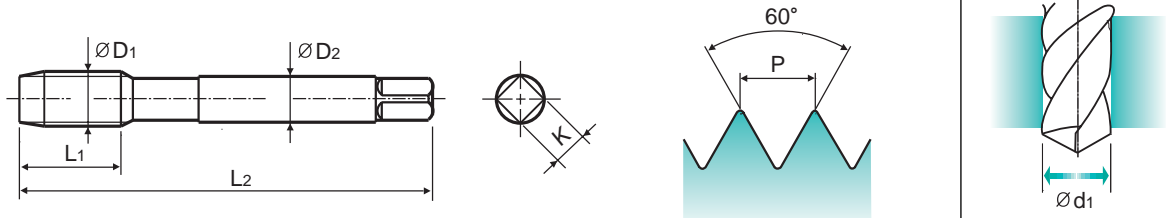
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Hole type



HSS-E
DIN 371/376
6H
60°
C
Bright
R40

Machine taps  
Maschinengewindebohrer



Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Shank Diameter	Square Size	Tapping drill diameter
ØD1	P		L1	L2	ØD2	K	Ød1
M2	× 0.4	TC804136	8	45	2.8	2.1	1.6
M2.2	× 0.45	TC804156	8	45	2.8	2.1	1.75
M2.3	× 0.4	TC804196	8	45	2.8	2.1	1.9
M2.5	× 0.45	TC804176	9	50	2.8	2.1	2.05
M2.6	× 0.45	TC804496	9	50	2.8	2.1	2.1
M3	× 0.5	TC804206	6	56	3.5	2.7	2.5
M3.5	× 0.6	TC804226	7	56	4	3	2.9
M4	× 0.7	TC804246	7	63	4.5	3.4	3.3
M4.5	× 0.75	TC804266	8	70	6	4.9	3.7
M5	× 0.8	TC804286	8	70	6	4.9	4.2
M6	× 1.0	TC804316	10	80	6	4.9	5
M7	× 1.0	TC804346	10	80	7	5.5	6
M8	× 1.25	TC804366	13	90	8	6.2	6.8
M9	× 1.25	TC804396	13	90	9	7	7.8
M10	× 1.5	TC804426	15	100	10	8	8.5
M11	× 1.5	TC804466	17	100	8	6.2	9.5
M12	× 1.75	TC804506	18	110	9	7	10.2
M14	× 2.0	TC804546	20	110	11	9	12
M16	× 2.0	TC804606	20	110	12	9	14
M18	× 2.5	TC804656	25	125	14	11	15.5
M20	× 2.5	TC804706	25	140	16	12	17.5
M22	× 2.5	TC804746	25	140	18	14.5	19.5
M24	× 3.0	TC804786	30	160	18	14.5	21
M27	× 3.0	TC804866	30	160	20	16	24
M30	× 3.5	TC804946	35	180	22	18	26.5

► DIN371 (M2~M10) and DIN376 (M11~M30)

► Coating(TiN, TiCN or TiAlN) or Surface Treatment(Steam Homo) is available on your request.

Unit : N/mm<sup>2</sup>

◎ : Excellent ○ : Good

Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

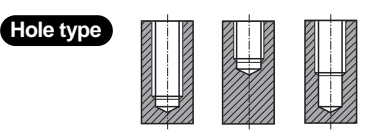


# MF ISO Metric fine threads DIN 13

## Metrisches ISO-Feingewinde DIN 13

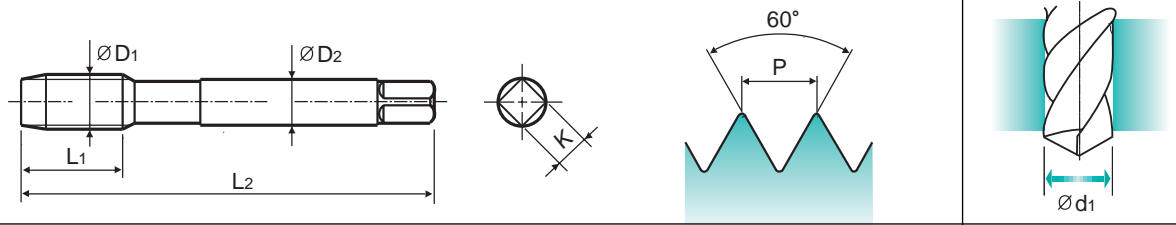
► For using multi-purpose, and correct thread profiles & long tool life due to special tap geometry. YG-1 company has a patent.

► Für vielfältigen Einsatz, genaue Gewindeprofile und lange Standzeit dank einer besonderen Schneidengeometrie. Von YG-1 patentiert.



Material groups **MU** **HSS-E** **DIN 374** **6H** **60°** **C** **Bright** **R40**

Machine taps  
Maschinengewindebohrer



SIZE	Pitch	EDP No.	Thread Length	Overall Length	Shank Diameter	Square Size	Tapping drill diameter
ØD1	P		L1	L2	ØD2	K	Ød1
M4	× 0.5	<b>TC844256</b>	5	63	2.8	2.1	3.5
M5	× 0.5	<b>TC844296</b>	5	70	3.5	2.7	4.5
M6	× 0.75	<b>TC844326</b>	8	80	4.5	3.4	5.2
M6	× 0.5	<b>TC844336</b>	5	80	4.5	3.4	5.5
M7	× 0.75	<b>TC844356</b>	10	80	5.5	4.3	6.2
M8	× 1.0	<b>TC844376</b>	10	90	6	4.9	7
M8	× 0.75	<b>TC844386</b>	8	80	6	4.9	7.2
M10	× 1.25	<b>TC844436</b>	16	100	7	5.5	8.8
M10	× 1.0	<b>TC844446</b>	10	90	7	5.5	9
M10	× 0.75	<b>TC844456</b>	10	90	7	5.5	9.2
M12	× 1.5	<b>TC844516</b>	15	100	9	7	10.5
M12	× 1.25	<b>TC844526</b>	15	100	9	7	10.8
M12	× 1.0	<b>TC844536</b>	11	100	9	7	11
M14	× 1.5	<b>TC844556</b>	15	100	11	9	12.5
M14	× 1.25	<b>TC844566</b>	15	100	11	9	12.8
M14	× 1.0	<b>TC844576</b>	11	100	11	9	13

Unit : mm

► Coating(TIN, TiCN or TiAlN) or Surface Treatment(Steam Homo) is available on your request.

Unit : N/mm<sup>2</sup> ◎ : Excellent ○ : Good

Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

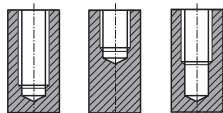
- HSS
- CARBIDE
- COMBO TAPS
- SPIRAL POINT TAPS
- SPIRAL FLUTE TAPS
- STRAIGHT FLUTE TAPS
- COLD FORMING TAPS
- NUT TAPS
- STI TAPS
- HAND TAPS
- PIPE TAPS
- CARBIDE TAPS
- THREAD MILLS
- TECHNICAL DATA

**MF ISO Metric fine threads DIN 13**  
**Metrisches ISO-Feingewinde DIN 13**

► For using multi-purpose, and correct thread profiles & long tool life due to special tap geometry. YG-1 company has a patent.

► Für vielfältigen Einsatz, genaue Gewindeprofile und lange Standzeit dank einer besonderen Schneidengeometrie. Von YG-1 patentiert.

Hole type



DIN 374



HSS-E

DIN 374

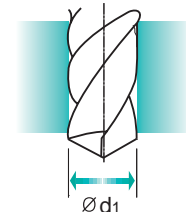
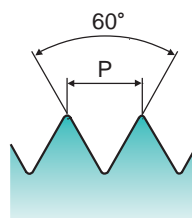
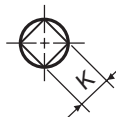
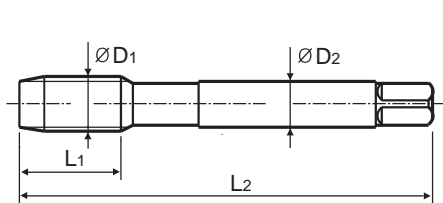
6H



Bright



Machine taps  
Maschinengewindebohrer



Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Shank Diameter	Square Size	Tapping drill diameter
ØD1	P		L1	L2	ØD2	K	Ød1
M16	× 1.5	TC844616	15	100	12	9	14.5
M16	× 1.0	TC844626	12	100	12	9	15
M18	× 1.5	TC844676	17	110	14	11	16.5
M18	× 1.0	TC844686	13	110	14	11	17
M20	× 1.5	TC844726	17	125	16	12	18.5
M20	× 1.0	TC844736	14	125	16	12	19
M22	× 1.5	TC844766	17	125	18	14.5	20.5
M22	× 1.0	TC844776	14	125	18	14.5	21
M24	× 2.0	TC844796	20	140	18	14.5	22
M24	× 1.5	TC844806	20	140	18	14.5	22.5
M26	× 1.5	TC844856	20	140	18	14.5	24.5
M27	× 2.0	TC844876	20	140	20	16	25
M27	× 1.5	TC844886	20	140	20	16	25.5
M28	× 1.5	TC844916	20	140	20	16	26.5
M30	× 2.0	TC844966	22	150	22	18	28
M30	× 1.5	TC844976	22	150	22	18	28.5

► Coating(TIN, TiCN or TiAlN) or Surface Treatment(Steam Homo) is available on your request.

Unit : N/mm<sup>2</sup>

◎ : Excellent ○ : Good

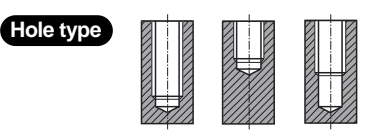
Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

# UNC Unified coarse threads

## Unified Grobgewinde

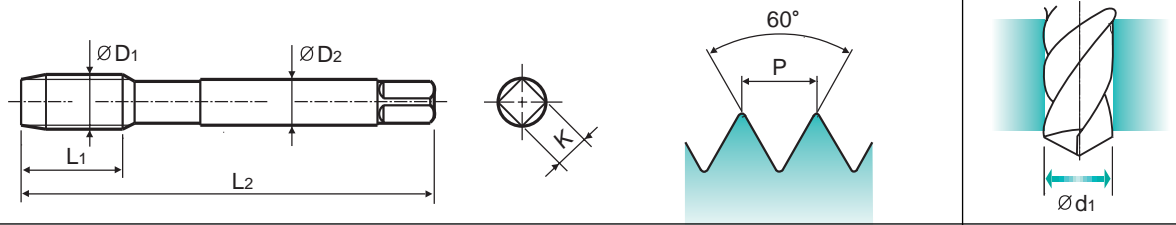
► For using multi-purpose, and correct thread profiles & long tool life due to special tap geometry. YG-1 company has a patent.

► Für vielfältigen Einsatz, genaue Gewindeprofile und lange Standzeit dank einer besonderen Schneidengeometrie. Von YG-1 patentiert.



Material groups **MU** HSS-E DIN 371/376 2B 60° C Bright R40

Machine taps  
Maschinengewindebohrer



SIZE	TPI	EDP No.	Thread Length	Overall Length	Shank Diameter	Square Size	Tapping drill diameter
ØD1			L1	L2	ØD2	K	Ød1
#4	- 40 UNC	TC824162	6	56	3.5	2.7	2.3
#5	- 40 UNC	TC824202	7	56	3.5	2.7	2.6
#6	- 32 UNC	TC824242	7	56	4	3	2.85
#8	- 32 UNC	TC824282	8	63	4.5	3.4	3.5
#10	- 24 UNC	TC824322	10	70	6	4.9	3.9
#12	- 24 UNC	TC824362	10	80	6	4.9	4.5
1/4"	- 20 UNC	TC824402	13	80	7	5.5	5.2
5/16"	- 18 UNC	TC824442	14	90	8	6.2	6.6
3/8"	- 16 UNC	TC824482	16	100	9	7	8
7/16"	- 14 UNC	TC824522	17	100	8	6.2	9.4
1/2"	- 13 UNC	TC824562	20	110	9	7	10.75
9/16"	- 12 UNC	TC824602	20	110	11	9	12.25
5/8"	- 11 UNC	TC824642	22	110	12	9	13.5
3/4"	- 10 UNC	TC824702	25	125	14	11	16.5
7/8"	- 9 UNC	TC824742	27	140	18	14.5	19.5
1"	- 8 UNC	TC824782	30	160	20	16	22.25

► DIN371 (#4~3/8") and DIN376 (7/16"~1")  
 ► Coating(TiN, TiCN or TiAlN) or Surface Treatment(Steam Homo) is available on your request.

Unit : N/mm<sup>2</sup> © : Excellent ○ : Good

Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
○	○	○	○	○	○	○	○	○	○	○	○	○	○	○
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

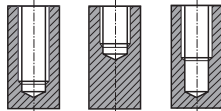
- HSS
- CARBIDE
- COMBO TAPS
- SPIRAL POINT TAPS
- SPIRAL FLUTE TAPS
- STRAIGHT FLUTE TAPS
- COLD FORMING TAPS
- NUT TAPS
- STI TAPS
- HAND TAPS
- PIPE TAPS
- CARBIDE TAPS
- THREAD MILLS
- TECHNICAL DATA

# UNF

## Unified fine threads Unified Feingewinde

► For using multi-purpose, and correct thread profiles & long tool life due to special tap geometry. YG-1 company has a patent.

► Für vielfältigen Einsatz, genaue Gewindeprofile und lange Standzeitendank einer besonderen Schneidengeometrie. Von YG-1 patentiert.

**Hole type**


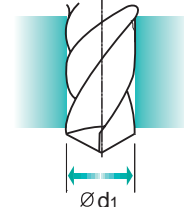
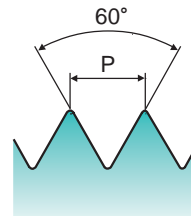
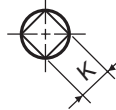
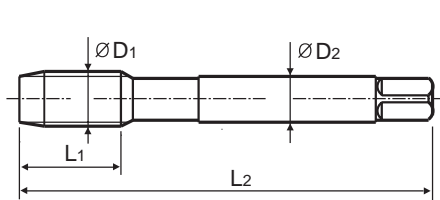
HSS-E

DIN  
371/374

2B



Bright


**Machine taps  
Maschinengewindebohrer**


Unit : mm

SIZE	TPI	EDP No.	Thread Length	Overall Length	Shank Diameter	Square Size	Tapping drill diameter
ØD1			L1	L2	ØD2	K	Ød1
#4	- 48UNF	<b>TC864182</b>	6	56	3.5	2.7	2.4
#5	- 44UNF	<b>TC864222</b>	7	56	3.5	2.7	2.7
#6	- 40UNF	<b>TC864262</b>	7	56	4	3	3
#8	- 36UNF	<b>TC864302</b>	8	63	4.5	3.4	3.5
#10	- 32UNF	<b>TC864342</b>	10	70	6	4.9	4.1
#12	- 28UNF	<b>TC864382</b>	10	80	6	4.9	4.7
1/4"	- 28UNF	<b>TC864422</b>	10	80	7	5.5	5.5
5/16"	- 24UNF	<b>TC864462</b>	10	90	8	6.2	6.9
3/8"	- 24UNF	<b>TC864502</b>	10	100	9	7	8.5
7/16"	- 20UNF	<b>TC864542</b>	13	100	8	6.2	9.9
1/2"	- 20UNF	<b>TC864582</b>	13	100	9	7	11.5
9/16"	- 18UNF	<b>TC864622</b>	15	100	11	9	12.9
5/8"	- 18UNF	<b>TC864662</b>	15	100	12	9	14.5
3/4"	- 16UNF	<b>TC864722</b>	17	110	14	11	17.5
7/8"	- 14UNF	<b>TC864762</b>	17	125	18	14.5	20.5
1"	- 12UNF	<b>TC864802</b>	20	140	20	16	23.25

► DIN371 (#4~3/8") and DIN374 (7/16"~1")

► Coating(TiN, TiCN or TiAlN) or Surface Treatment(Steam Homo) is available on your request.

Unit : N/mm<sup>2</sup>

◎ : Excellent ○ : Good

Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎