COMBO TAPS

Vap **TB854** SERIES
Bright **TC854** SERIES
TiN **TD854** SERIES

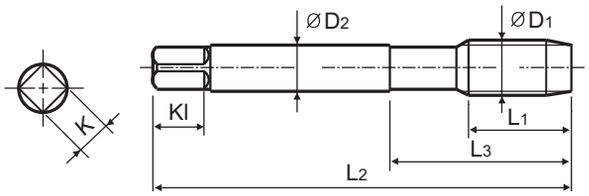
MF ISO Metric fine threads DIN 13

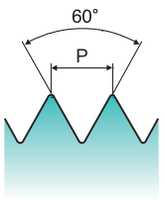
Metrisches ISO-Feingewinde DIN 13
ISO MÉTRIQUE PAS FINS DIN13
ISO Metrico passo grosso DIN 13

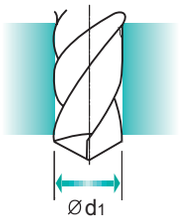
▶ For using multi-purpose and correct thread profiles & long tool life due to special tap geometry. YG-1 company has a patent.

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

Hole type
3.0×D







Material groups **MU** | HSS-E | DIN 374 | 6H | 60° | B | Vap Bright TiN

Machine taps
Maschinengewindebohrer

Recommended Cutting Page : P.116

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	Bright	TiN	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M4	× 0.5	TB854256	TC854256	TD854256	10	63	21	2.8	2.1	5	3	3.5
M5	× 0.5	TB854296	TC854296	TD854296	11	70	25	3.5	2.7	6	3	4.5
M6	× 0.75	TB854326	TC854326	TD854326	13	80	30	4.5	3.4	6	3	5.2
M6	× 0.5	TB854336	TC854336	TD854336	13	80	30	4.5	3.4	6	3	5.5
M7	× 0.75	TB854356	TC854356	TD854356	14	80	30	5.5	4.3	7	3	6.2
M8	× 1	TB854376	TC854376	TD854376	17	90	36	6	4.9	8	3	7
M8	× 0.75	TB854386	TC854386	TD854386	14	80	30	6	4.9	8	3	7.2
M10	× 1.25	TB854436	TC854436	TD854436	22	100	40	7	5.5	8	3	8.8
M10	× 1	TB854446	TC854446	TD854446	18	90	36	7	5.5	8	3	9
M10	× 0.75	TB854456	TC854456	TD854456	18	90	36	7	5.5	8	3	9.2
M12	× 1.5	TB854516	TC854516	TD854516	22	100	40	9	7	10	3	10.5
M12	× 1.25	TB854526	TC854526	TD854526	22	100	40	9	7	10	3	10.8
M12	× 1	TB854536	TC854536	TD854536	18	100	40	9	7	10	3	11
M14	× 1.5	TB854556	TC854556	TD854556	22	100	40	11	9	12	3	12.5
M14	× 1.25	TB854566	TC854566	TD854566	22	100	40	11	9	12	3	12.8
M14	× 1.0	TB854576	TC854576	TD854576	22	100	40	11	9	12	3	13
M16	× 1.5	TB854616	TC854616	TD854616	22	100	40	12	9	12	3	14.5
M16	× 1	TB854626	TC854626	TD854626	18	100	40	12	9	12	3	15
M18	× 1.5	TB854676	TC854676	TD854676	25	110	44	14	11	14	4	16.5
M18	× 1	TB854686	TC854686	TD854686	20	110	44	14	11	14	4	17

* The other coating(TiCN or TiAlN) is available on your request.

▶ NEXT PAGE

◎ : 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			◎			◎	◎	◎													

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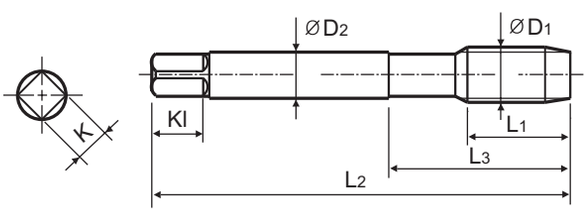

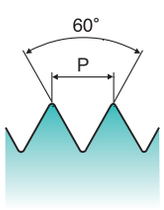

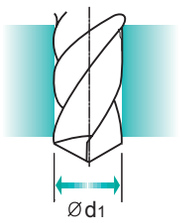

Material groups **MU** | HSS-E | DIN 374 | 6H | 60° | B | Vap Bright TiN

Machine taps
Maschinengewindebohrer

Recommended Cutting Page : P.116

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	Bright	TiN	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M20 × 1.5		TB854726	TC854726	TD854726	25	125	50	16	12	15	4	18.5
M20 × 1		TB854736	TC854736	TD854736	20	125	50	16	12	15	4	19
M22 × 1.5		TB854766	TC854766	TD854766	25	125	50	18	14.5	17	4	20.5
M22 × 1		TB854776	TC854776	TD854776	20	125	50	18	14.5	17	4	21
M24 × 2		TB854796	TC854796	TD854796	27	140	54	18	14.5	17	4	22
M24 × 1.5		TB854806	TC854806	TD854806	27	140	54	18	14.5	17	4	22.5
M26 × 1.5		TB854856	TC854856	TD854856	28	140	54	18	14.5	17	4	24.5
M27 × 2		TB854876	TC854876	TD854876	28	140	54	20	16	19	4	25
M27 × 1.5		TB854886	TC854886	TD854886	28	140	54	20	16	19	4	25.5
M28 × 1.5		TB854916	TC854916	TD854916	28	140	54	20	16	19	4	26.5
M30 × 2		TB854966	TC854966	TD854966	30	150	57	22	18	21	4	28
M30 × 1.5		TB854976	TC854976	TD854976	30	150	57	22	18	21	4	28.5

* The other coating(TiCN or TiAlN) is available on your request.

◎ : 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			◎			◎	◎	◎													

COMBO TAPS

RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDKONDITIONEN

ISO	VDI 3323	Material Description	HB	HRc	TB744 TB754 TQ744 TQ754	TC814 TC854 TC834 TC874	TD814 TD854 TD834 TD874	TB814 TB854 TB834 TB874	TCJ05 TCJ09 TCJ01 TCJ02	TDJ05 TDJ09 TDJ01 TDJ02	TBJ05	TCJ06
					Vc (m/min)							
P	1	Non-alloy steel	125			15-20	20-25	15-20	15-20	20-25	15-20	15-20
	2		190	13	15-20	15-20	20-25	15-20	15-20	20-25	15-20	15-20
	3		250	25		12-18	18-24	12-18	12-18	18-24	12-18	12-18
	4		270	28	10-15	10-15	15-20	10-15	10-15	15-20	10-15	10-15
	5		300	32		6-10	10-14	6-10	6-10	10-14	6-10	6-10
	6	Low alloy steel	180	10	10-15	10-15	15-20	10-15	10-15	15-20	10-15	10-15
	7		275	29	10-15	10-15	15-20	10-15	10-15	15-20	10-15	10-15
	8		300	32		6-10	10-14	6-10	6-10	10-14	6-10	6-10
	9		350	38		3-5	5-7	3-5	3-5	5-7	3-5	3-5
	10	High alloyed steel, and tool steel	200	15		3-5	5-7	3-5	3-5	5-7	3-5	3-5
	11		325	35								
M	12	Stainless steel	200	15	7-10	7-10	10-15	7-10	7-10	10-15	7-10	7-10
	13		240	23	5-8	5-8	8-11	5-8	5-8	8-11	5-8	5-8
	14		180	10	4-6	4-6	6-8	4-6	4-6	6-8	4-6	4-6
K	15	Grey cast iron	180	10		10-15	15-20	10-15	10-15	15-20	10-15	10-15
	16		260	26		5-8	8-11	5-8	5-8	8-11	5-8	5-8
	17	Nodular cast iron	160	3		10-15	15-20	10-15	10-15	15-20	10-15	10-15
	18		250	25		5-8	8-11	5-8	5-8	8-11	5-8	5-8
	19	Malleable cast iron	130									
	20		230	21								
N	21	Aluminum-wrought alloy	60									
	22		100									
	23	Aluminum-cast, alloyed	75			15-20	20-25	15-20	15-20	20-25	15-20	15-20
	24		90									
	25		130									
	26	Copper and Copper Alloys (Bronze / Brass)	110			25-35	35-40	25-35	25-35	35-40	25-35	25-35
	27		90			8-12	12-17	8-12	8-12	12-17	8-12	8-12
	28		100		15-20	15-20	20-25	15-20	15-20	20-25	15-20	15-20
	29	Non Metallic Materials										
	30											
S	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									
H	38	Hardened steel	550	55								
	39		630	60								
	40	Chilled Cast Iron	400	42								
	41	Hardened Cast Iron	550	55								

SURFACE TREATMENT AND COATING

The applied High Speed Steels holds a grant of good wear resistance and toughness. Therefore YG-1 normally delivers taps with bright and unfinished surface. For certain materials, various surface treatments provide higher advantage in machining.

STEAM TEMPERED - Vap

Steam Tempered is a Fe3O4-oxyd-coating which reduces friction between the tool and workpiece, also preventing cold welding.

NITRIDING - NI

Recommend surface treatment for machining materials that affect wear abrasion, such as grey cast iron, alu-alloys with high Si-percentages (more than 10%).

Below are the various surface treatments for excellent finish surfaces suitable for many applications. The surface treatments are produced and developed within the company.

TiN-COATING

TiN-coating yields a hardness of approx. 2,300 HV and also a heat resistant up to approx. 600°C. The current coating is an excellent all-round coating for normal applications.
Colour : Golden Coefficient of friction against steel : 0.4

TiCN-COATING

TiCN takes place of TiN when the conditions require the coating to have a different hardness and toughness.
The TiCN brings advantages for machining very difficult steels or cutting interrupted bores.
The TiCN-coating has a hardness of approx. 3,000 HV, but is heat resistance only holds up to approx. 400°C, meaning that the TiCN needs an excellent cooling system for a long service life.
Colour : Blue-Grey Coefficient of friction against steel : 0.4

TiAlN-COATING

A special coating for machining abrasive materials such as grey cast iron, alu-alloys with silicon, fiber reinforced plastics, etc., or machining at high temperatures with insufficient cooling, or at high speeds ≥ 600m/min. TiAlN has a hardness of approx. 3,000 HV and is heat resistant up to approx. 800°C.
Colour : Violet-Grey Coefficient of friction against steel : 0.4

Hardslick-COATING

Hardslick combines the advantages of an extremely hard, thermally stable TiAlN-coating with the sliding and lubricating properties of an outer WC/C(Tungsten carbide/carbon)-coating in a novel way. The Hardslick coating has a hardness of approx. 3,000 HV and is temperature-resistant up to approx. 800°C.
Colour : Violet-Grey Coefficient of friction against steel : 0.2

SELECTION GUIDE

YG THREADING TOOLS

HSS-E & HSS-PM COMBO TAPS

For Multi Purpose Tapping
YG-1's Patent

Please visit globalyg1.com/mat for material search

◎ : Excellent ○ : Good

Recommended cutting conditions : P.114

HOLE TYPE					Max. 3.0xD Through Hole						
TOOL MATERIAL					HSS-E						
CHAMFER LEAD ACC. TO DIN2197					B	B	B	B	B	B	
FLUTE TYPE					Spiral Point	Spiral Point	Spiral Point	Spiral Point	Spiral Point	Spiral Point	
SPIRAL FLUTE ANGLE					-	-	-	-	-	-	
SERIES	M	DIN371/376			TC814 (P.95)	TD814 (P.95)	TB814 (P.95)	TCJ05 (P.96)	TDJ05 (P.96)	TBJ05 (P.96)	
		DIN352									
		DIN357/LONG									
	MF	DIN374			TC854 (P.100)	TD854 (P.100)	TB854 (P.100)	TCJ09 (P.102)	TDJ09 (P.102)		
		DIN2181									
	UNC	DIN371/376			TC834 (P.109)	TD834 (P.109)	TB834 (P.109)	TCJ01 (P.110)	TDJ01 (P.110)		
		DIN351									
	UNF	DIN371/374			TC874 (P.111)	TD874 (P.111)	TB874 (P.111)	TCJ02 (P.112)	TDJ02 (P.112)		
		DIN2181									
	BSW	DIN2182/2183									
		DIN351									
	G(BSP)	DIN5156/5157									
	EG-M	DIN371/376									
	EG-UNC	DIN371/376									
	EG-UNF	DIN371/374									
SURFACE TREATMENT					Bright	TiN	VAP	Bright	TiN	VAP	
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	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			Cured	280	30						
	33		Ni or Co Based	Annealed	250	25						
	34			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						