

SYNCHRO TAPS

TTS33 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 TiNi

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

- ▶ Coated HSS-PM(Powder Metallurgy) Taps for high-speed tapping on rigid CNC machines or equivalent machines

▶ Up to 3 times faster in tapping compared to conventional taps

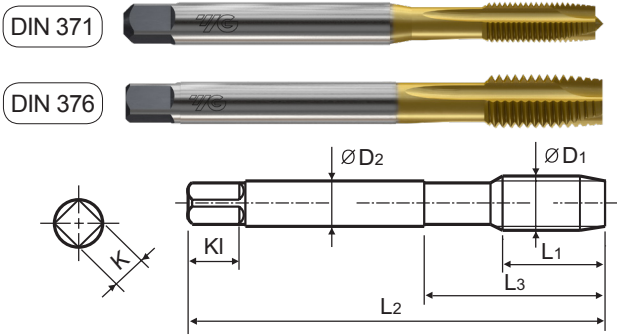
▶ For high-speed synchro tapping, synchro holder for increasing tool life and thread quality is recommended

▶ High precision threads
- ▶ Beschichtete HSS-PM-Gewindebohrer zum Hochgeschwindigkeitsgewindebohren auf starren CNC-Maschinen oder gleichwertige Maschinen

▶ Bis zu dreimal schnelleres Gewindeschneiden als bei herkömmlichen Gewindebohrern

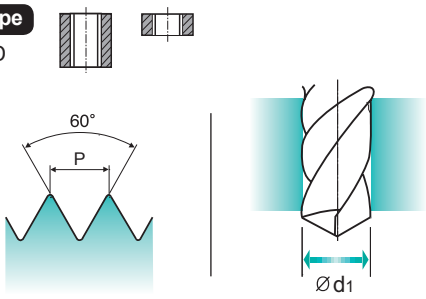
▶ Beim Hochgeschwindigkeits-Gewindebohren wird die Verwendung eines Synchrofutters zur Erhöhung der Werkzeugstandzeit und der Gewindequalität empfohlen

▶ Hoch präzise Gewinde



Hole type

3.0×D



Material groups















Machine taps
Maschinengewindebohrer

Recommended Cutting Page : P.69 Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD ₁	P	TiN	L ₁	L ₂	L ₃	ØD ₂	K	KI	Z	Ød ₁
M3 × 0.5		TTS33206	5	56	18	3.5	2.7	6	3	2.5
M4 × 0.7		TTS33246	7	63	21	4.5	3.4	6	3	3.3
M5 × 0.8		TTS33286	8	70	25	6	4.9	8	3	4.2
M6 × 1		TTS33316	10	80	30	6	4.9	8	3	5
M8 × 1.25		TTS33366	13	90	35	8	6.2	9	3	6.8
M10 × 1.5		TTS33426	15	100	39	10	8	11	3	8.5
M12 × 1.75		TTS33506	18	110	44	9	7	10	4	10.2
M14 × 2		TTS33546	20	110	44	11	9	12	4	12
M16 × 2		TTS33606	20	110	44	12	9	12	4	14
M18 × 2.5		TTS33656	25	125	50	14	11	14	4	15.5
M20 × 2.5		TTS33706	25	140	54	16	12	15	4	17.5

- ▶DIN 371(M3~M10) and DIN 376(M11~M20)
- ▶Coating(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			◎	◎	◎	◎		○														

ISO	VDI 3323	Material Description	HB	HRc	TTS31	TTS33	TKS35	TTS37
					Vc (m/min)			
P	1	Non-alloy steel	125		41-46	41-46	41-46	41-46
	2		190	13	41-46	41-46	41-46	41-46
	3		250	25	35-40	35-40	35-40	35-40
	4		270	28	28-33	28-33	28-33	28-33
	5		300	32				
	6	Low alloy steel	180	10	28-33	28-33	28-33	28-33
	7		275	29	28-33	28-33	28-33	28-33
	8		300	32				
	9		350	38				
	10	High alloyed steel, and tool steel	200	15				
	11		325	35				
M	12	Stainless steel	200	15	18-23	18-23		18-23
	13		240	23	13-18	13-18		13-18
	14		180	10	10-14	10-14		10-14
K	15	Grey cast iron	180	10	28-33	28-33	28-33	
	16		260	26			13-18	
	17	Nodular cast iron	160	3	28-33	28-33	28-33	
	18		250	25			13-18	
	19	Malleable cast iron	130				28-33	
	20		230	21			13-18	
N	21	Aluminum-wrought alloy	60					28-33
	22		100					28-33
	23	Aluminum-cast, alloyed	75		41-46	41-46	41-46	41-46
	24		90		41-46	41-46	41-46	41-46
	25		130		30-35	30-35	30-35	30-35
	26	Copper and Copper Alloys (Bronze / Brass)	110		45-50	45-50		
	27		90					
	28		100		25-30	25-30		25-30
	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 $\geq 600\text{m/min}$. 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



HSS-PM
SYNCHRO
TAPS

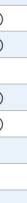
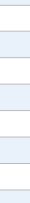
For High Speed Tapping on Rigid CNC Machine



Please visit
globalyg1.com/mat
for material search

◎ : Excellent ○ : Good

Recommended cutting conditions : P.69

HOLE TYPE			 Max. 2.5xD Blind Hole	 Max. 3.0xD Through Hole	 Max. 2.0xD Blind/Through Hole	 Max. 3.0xD Blind/Through Hole
TOOL MATERIAL			HSS-PM			
CHAMFER LEAD ACC. TO DIN2197			C	B	C	C
FLUTE TYPE			Spiral Flute	Spiral Point	Straight Flute	Cold Forming
SPIRAL FLUTE ANGLE			R45	-	-	-
SERIES	M	DIN371/376	TTS31 (P.65)	TTS33 (P.66)	TKS35 (P.67)	TTS37 (P.68)
		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			TiN	TiN	TiCN	TiN
MODEL						
HB	HRc					
125			⊙	⊙	○	⊙
190	13		⊙	⊙	○	⊙
250	25		⊙	⊙	○	⊙
270	28		⊙	⊙	○	⊙
300	32					
180	10		⊙	⊙	○	⊙
275	29		⊙	⊙	○	⊙
300	32					
350	38					
200	15					
325	35					
200	15		⊙	⊙		⊙
240	23		⊙	⊙		⊙
180	10		○	○		⊙
180	10		○	○	⊙	
260	26				⊙	
160	3		⊙	⊙	⊙	
250	25				⊙	
130					○	
230	21				○	
60						⊙
100						⊙
75			⊙	⊙	○	⊙
90			⊙	⊙	○	⊙
130			⊙	⊙	○	○
110			⊙	⊙		
90						
100			○	○		⊙
200	15					
280	30					
250	25					
350	38					
320	34					
400 Rm						
1050 Rm						
550	55					
630	60					
400	42					
550	55					

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	Non Metallic Materials	CuSn, lead-free copper and electrolytic copper		100		○	○		◎
	29		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	Titanium Alloys		Cast	320	34				
	36		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				