

HSS



Being the best through innovation



COMBO TAPS

COMBO GEWINDEBOHRER

- Spiral Point, Spiral Flute Type
Excellent performance on various work materials. YG-1's Patent
- Schälanschnitt, Spiralgenutet
Ausgezeichnete Leistung in verschiedenen Arbeitsmaterialien. YG-1 Patent

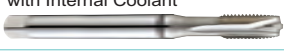
SELECTION GUIDE

COMBO TAPS (Spiral Point & Spiral Flute)

Excellent performance on various work materials. 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
● TC804 TD804		HSS-E	M	MU	DIN371/376	ISO 6H	C	Bright TiN	375
● TC844 TD844		HSS-E	MF	MU	DIN374	ISO 6H	C	Bright TiN	376
● TC804-IC	with Internal Coolant 	HSS-E	M	MU	DIN371/376	ISO 6H	C	Bright	378
● TC807		HSS-E	M	MU	DIN371/376	ISO 6H	E	Bright	379
● TC633		HSS-E	M	MU	LONG	ISO 6H	C	Bright	380
● TQ744 TB744		HSS-PM HSS-E	M	VA	DIN371/376	ISO 6H	C	Vap	381
● TQ754 TB754		HSS-PM HSS-E	MF	VA	DIN374	ISO 6H	C	Vap	382
● TC824 TD824		HSS-E	UNC	MU	DIN371/376	2B	C	Bright TiN	384
● TC864 TD864		HSS-E	UNF	MU	DIN371/374	2B	C	Bright TiN	385
● TC814 TD814		HSS-E	M	MU	DIN371/376	ISO 6H	B	Bright TiN	386
● TC854 TD854		HSS-E	MF	MU	DIN374	ISO 6H	B	Bright TiN	387
● TC814-IC	with Internal Coolant 	HSS-E	M	MU	DIN371/376	ISO 6H	B	Bright	389
● TC445		HSS-E	M	MU	LONG	ISO 6H	B	Bright	390
● TQ428 TB428		HSS-PM HSS-E	M	VA	DIN371/376	ISO 6H	B	Vap	391
● TQ438 TB438		HSS-PM HSS-E	MF	VA	DIN374	ISO 6H	B	Vap	392
● TC834 TD834		HSS-E	UNC	MU	DIN371/376	2B	B	Bright TiN	394
● TC874 TD874		HSS-E	UNF	MU	DIN371/374	2B	B	Bright TiN	395

**COMBO TAPS****Combo** TAP**TC804** SERIES

Bright

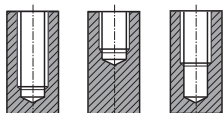
TD804 SERIES

TIN

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.

Hole type

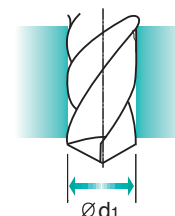
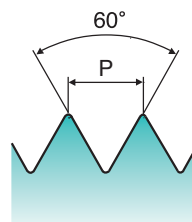
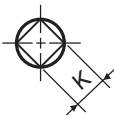
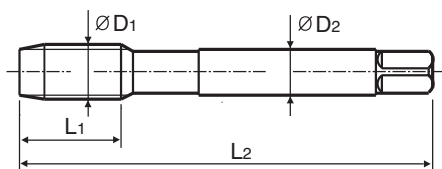
Material groups

MU

HSS-E

DIN 371/376

6H

Bright
TiNMachine taps
Maschinengewindebohrer

Unit : mm

SIZE ØD1	Pitch P	EDP No.		Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping Drill Diameter Ød1
		Bright	TiN					
M2	× 0.4	TC804136	TD804136	8	45	2.8	2.1	1.6
M2.2	× 0.45	TC804156	TD804156	8	45	2.8	2.1	1.75
M2.3	× 0.4	TC804196	TD804196	8	45	2.8	2.1	1.9
M2.5	× 0.45	TC804176	TD804176	9	50	2.8	2.1	2.05
M2.6	× 0.45	TC804496	TD804496	9	50	2.8	2.1	2.1
M3	× 0.5	TC804206	TD804206	6	56	3.5	2.7	2.5
M3.5	× 0.6	TC804226	TD804226	7	56	4	3	2.9
M4	× 0.7	TC804246	TD804246	7	63	4.5	3.4	3.3
M4.5	× 0.75	TC804266	TD804266	8	70	6	4.9	3.7
M5	× 0.8	TC804286	TD804286	8	70	6	4.9	4.2
M6	× 1.0	TC804316	TD804316	10	80	6	4.9	5
M7	× 1.0	TC804346	TD804346	10	80	7	5.5	6
M8	× 1.25	TC804366	TD804366	13	90	8	6.2	6.8
M9	× 1.25	TC804396	TD804396	13	90	9	7	7.8
M10	× 1.5	TC804426	TD804426	15	100	10	8	8.5
M11	× 1.5	TC804466	TD804466	17	100	8	6.2	9.5
M12	× 1.75	TC804506	TD804506	18	110	9	7	10.2
M14	× 2.0	TC804546	TD804546	20	110	11	9	12
M16	× 2.0	TC804606	TD804606	20	110	12	9	14
M18	× 2.5	TC804656	TD804656	25	125	14	11	15.5
M20	× 2.5	TC804706	TD804706	25	140	16	12	17.5
M22	× 2.5	TC804746	TD804746	25	140	18	14.5	19.5
M24	× 3.0	TC804786	TD804786	30	160	18	14.5	21
M27	× 3.0	TC804866	TD804866	30	160	20	16	24
M30	× 3.5	TC804946	TD804946	35	180	22	18	26.5

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

* The other coating(TiCN or TiAlN) or Surface Treatment(Steam Homo) is available on your request.

Unit : N/mm²

◎ : 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
TAPSSPIRAL
FLUTE TAPSSPIRAL
POINT TAPSSTRAIGHT
FLUTE TAPSCOLD
FORMING
TAPS

NUT TAPS

STI TAPS

HAND TAPS

PIPE TAPS

CARBIDE
TAPSTHREAD
MILLSTECHNICAL
DATA

HSS

CARBIDE

COMBO
TAPSSPIRAL
FLUTE TAPSSPIRAL
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FORMING
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STI TAPS

HAND TAPS

PIPE TAPS

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DATA

COMBO TAPS

Combo^{TAP}

TC844 SERIES

Bright

TD844 SERIES

TiN

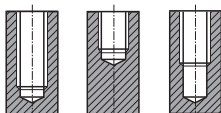
MF ISO Metric fine threads DIN 13

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.

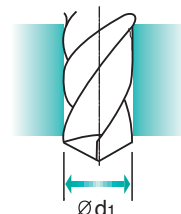
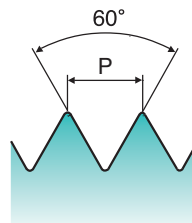
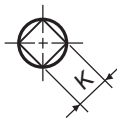
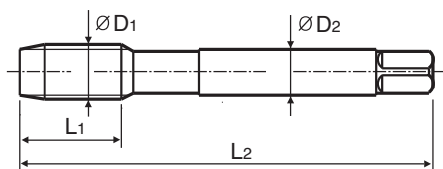
Hole type

Material groups
MU

HSS-E

DIN
374

6H

Bright
TiNMachine taps
Maschinengewindebohrer

Unit : mm

SIZE	Pitch	EDP No.		Thread Length	Overall Length	Shank Diameter	Square Size	Tapping Drill Diameter
ØD1	P	Bright	TiN	L1	L2	ØD2	K	Ød1
M4	× 0.5	TC844256	TD844256	5	63	2.8	2.1	3.5
M5	× 0.5	TC844296	TD844296	5	70	3.5	2.7	4.5
M6	× 0.75	TC844326	TD844326	8	80	4.5	3.4	5.2
M6	× 0.5	TC844336	TD844336	5	80	4.5	3.4	5.5
M7	× 0.75	TC844356	TD844356	10	80	5.5	4.3	6.2
M8	× 1.0	TC844376	TD844376	10	90	6	4.9	7
M8	× 0.75	TC844386	TD844386	8	80	6	4.9	7.2
M10	× 1.25	TC844436	TD844436	16	100	7	5.5	8.8
M10	× 1.0	TC844446	TD844446	10	90	7	5.5	9
M10	× 0.75	TC844456	TD844456	10	90	7	5.5	9.2
M12	× 1.5	TC844516	TD844516	15	100	9	7	10.5
M12	× 1.25	TC844526	TD844526	15	100	9	7	10.8
M12	× 1.0	TC844536	TD844536	11	100	9	7	11
M14	× 1.5	TC844556	TD844556	15	100	11	9	12.5
M14	× 1.25	TC844566	TD844566	15	100	11	9	12.8
M14	× 1.0	TC844576	TD844576	11	100	11	9	13

* The other coating(TiCN or TiAlN) or Surface Treatment(Steam Homo) is available on your request.

Unit : N/mm²

◎ : 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	Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

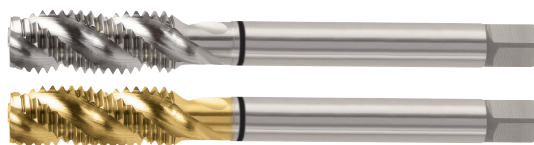
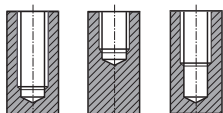
MF ISO Metric fine threads DIN 13

Metrisches ISO-Feingewinde DIN 13

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Hole type



Material groups
MU

HSS-E

DIN 374

6H

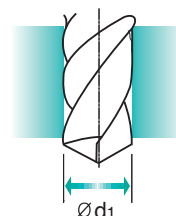
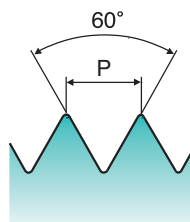
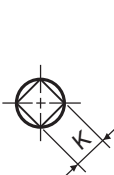
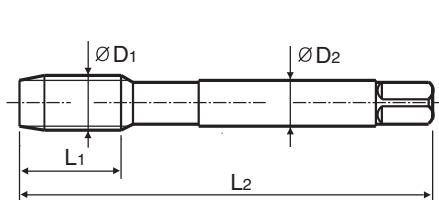
60°

C

Bright
TiN

R40

Machine taps
Maschinengewindebohrer



Unit : mm

SIZE	Pitch	EDP No.		Thread Length	Overall Length	Shank Diameter	Square Size	Tapping Drill Diameter
ØD1	P	Bright	TiN	L1	L2	ØD2	K	Ød1
M16 × 1.5		TC844616	TD844616	15	100	12	9	14.5
M16 × 1.0		TC844626	TD844626	12	100	12	9	15
M18 × 1.5		TC844676	TD844676	17	110	14	11	16.5
M18 × 1.0		TC844686	TD844686	13	110	14	11	17
M20 × 1.5		TC844726	TD844726	17	125	16	12	18.5
M20 × 1.0		TC844736	TD844736	14	125	16	12	19
M22 × 1.5		TC844766	TD844766	17	125	18	14.5	20.5
M22 × 1.0		TC844776	TD844776	14	125	18	14.5	21
M24 × 2.0		TC844796	TD844796	20	140	18	14.5	22
M24 × 1.5		TC844806	TD844806	20	140	18	14.5	22.5
M26 × 1.5		TC844856	TD844856	20	140	18	14.5	24.5
M27 × 2.0		TC844876	TD844876	20	140	20	16	25
M27 × 1.5		TC844886	TD844886	20	140	20	16	25.5
M28 × 1.5		TC844916	TD844916	20	140	20	16	26.5
M30 × 2.0		TC844966	TD844966	22	150	22	18	28
M30 × 1.5		TC844976	TD844976	22	150	22	18	28.5

* The other coating(TiCN or TiAlN) or Surface Treatment(Steam Homo) is available on your request.

Unit : N/mm²

◎ : 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	Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎



COMBO TAPS

Combo^{TAP}

TC804-IC SERIES

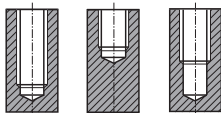
M ISO Metric coarse threads DIN 13

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.

Hole type



with Internal Coolant

Material groups
MU

HSS-E

DIN
371/376

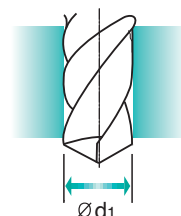
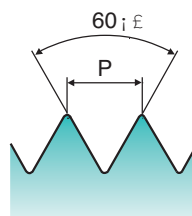
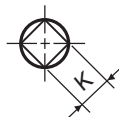
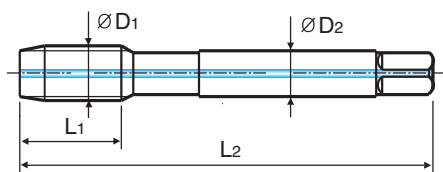
6H

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
M6	× 1.0	TC804316IC	10	80	6	4.9	5
M8	× 1.25	TC804366IC	13	90	8	6.2	6.8
M10	× 1.5	TC804426IC	15	100	10	8	8.5
M12	× 1.75	TC804506IC	18	110	9	7	10.2
M14	× 2.0	TC804546IC	20	110	11	9	12
M16	× 2.0	TC804606IC	20	110	12	9	14
M18	× 2.5	TC804656IC	25	125	14	11	15.5
M20	× 2.5	TC804706IC	25	140	16	12	17.5

► DIN371 (M6~M10) and DIN376 (M12~M20)

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

Unit : N/mm²

◎ : 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	Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
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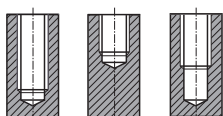
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Hole type



Short Chamfer

Material groups
MU

HSS-E

DIN 371/376

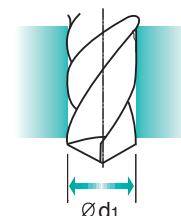
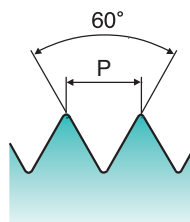
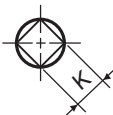
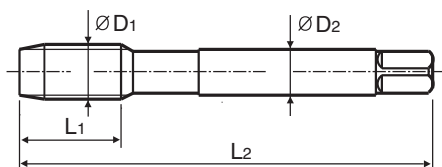
6H



Bright



Machine taps
Maschinengewindebohrer



Unit : mm

SIZE ØD1	Pitch P	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping Drill Diameter Ød1
M2	× 0.4	TC807136	8	45	2.8	2.1	1.6
M2.2	× 0.45	TC807156	8	45	2.8	2.1	1.75
M2.3	× 0.4	TC807196	8	45	2.8	2.1	1.9
M2.5	× 0.45	TC807176	9	50	2.8	2.1	2.05
M2.6	× 0.45	TC807496	9	50	2.8	2.1	2.1
M3	× 0.5	TC807206	6	56	3.5	2.7	2.5
M3.5	× 0.6	TC807226	7	56	4	3	2.9
M4	× 0.7	TC807246	7	63	4.5	3.4	3.3
M4.5	× 0.75	TC807266	8	70	6	4.9	3.7
M5	× 0.8	TC807286	8	70	6	4.9	4.2
M6	× 1.0	TC807316	10	80	6	4.9	5
M7	× 1.0	TC807346	10	80	7	5.5	6
M8	× 1.25	TC807366	13	90	8	6.2	6.8
M9	× 1.25	TC807396	13	90	9	7	7.8
M10	× 1.5	TC807426	15	100	10	8	8.5
M11	× 1.5	TC807466	17	100	8	6.2	9.5
M12	× 1.75	TC807506	18	110	9	7	10.2
M14	× 2.0	TC807546	20	110	11	9	12
M16	× 2.0	TC807606	20	110	12	9	14
M18	× 2.5	TC807656	25	125	14	11	15.5
M20	× 2.5	TC807706	25	140	16	12	17.5
M22	× 2.5	TC807746	25	140	18	14.5	18.5
M24	× 3.0	TC807786	30	160	18	14.5	21
M27	× 3.0	TC807866	30	160	20	16	24
M30	× 3.5	TC807946	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/mm²

◎ : 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	Si ≤ 10%	Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

HSS

CARBIDE

COMBO
TAPSSPIRAL
FLUTE TAPSSPIRAL
POINT TAPSSTRAIGHT
FLUTE TAPSCOLD
FORMING
TAPS

NUT TAPS

STI TAPS

HAND TAPS

PIPE TAPS

CARBIDE
TAPSTHREAD
MILLSTECHNICAL
DATA

COMBO TAPS

Combo^{TAP}

TC633 SERIES

M ISO Metric coarse threads DIN 13

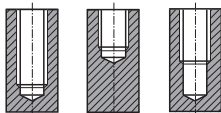
Metrisches ISO-Gewinde DIN 13

► 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.



Hole type



Long Shank

Material groups
MU

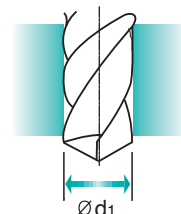
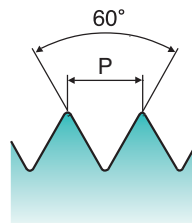
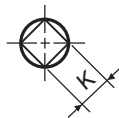
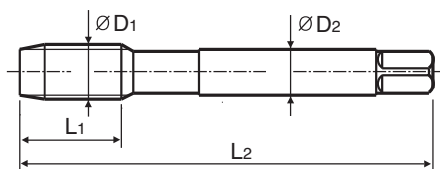
HSS-E

LONG

6H



Bright

Machine taps
Maschinengewindebohrer

Unit : mm

SIZE ØD1	Pitch P	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping Drill Diameter Ød1
M3	× 0.5	TC633206	11	100	3.5	2.7	2.5
M4	× 0.7	TC633246	13	125	4.5	3.4	3.3
M5	× 0.8	TC633286	15	140	6	4.9	4.2
M6	× 1.0	TC633316	17	160	6	4.9	5
M8	× 1.25	TC633366	20	180	6	4.9	6.8
M10	× 1.5	TC633426	22	200	7	5.5	8.5
M12	× 1.75	TC633506	24	220	9	7	10.2
M14	× 2.0	TC633546	26	220	11	9	12
M16	2.0	TC633606	27	220	12	9	14
M20	2.5	TC633706	32	280	16	12	17.5

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

Unit : N/mm²

◎ : 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	Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

M

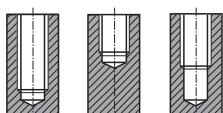
ISO Metric coarse threads DIN 13

Metrisches ISO-Gewinde DIN 13

► For stainless steels and correct thread profiles & long tool life due to special tap geometry. YG-1 company has a patent.

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

Hole type



Material groups
VA

up to M12

over M12

HSS-PM

HSS-E

DIN 371/376

6H

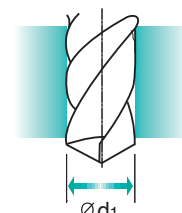
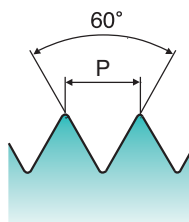
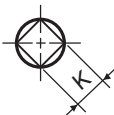
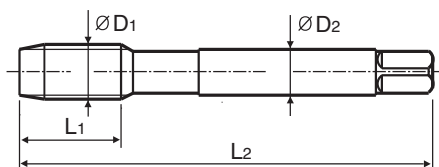
60°

C

Vap

R45

Machine taps
Maschinen-
gewindebohrer



Unit : mm

SIZE ØD1	Pitch P	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping Drill Diameter Ød1
M2	× 0.4	TQ744136	8	45	2.8	2.1	1.6
M2.2	× 0.45	TQ744156	8	45	2.8	2.1	1.75
M2.3	× 0.4	TQ744196	8	45	2.8	2.1	1.9
M2.5	× 0.45	TQ744176	9	50	2.8	2.1	2.05
M2.6	× 0.45	TQ744496	9	50	2.8	2.1	2.1
M3	× 0.5	TQ744206	6	56	3.5	2.7	2.5
M3.5	× 0.6	TQ744226	7	56	4	3	2.9
M4	× 0.7	TQ744246	7	63	4.5	3.4	3.3
M4.5	× 0.75	TQ744266	8	70	6	4.9	3.7
M5	× 0.8	TQ744286	8	70	6	4.9	4.2
M6	× 1.0	TQ744316	10	80	6	4.9	5
M7	× 1.0	TQ744346	10	80	7	5.5	6
M8	× 1.25	TQ744366	13	90	8	6.2	6.8
M9	× 1.25	TQ744396	13	90	9	7	7.8
M10	× 1.5	TQ744426	15	100	10	8	8.5
M11	× 1.5	TQ744466	17	100	8	6.2	9.5
M12	× 1.75	TQ744506	18	110	9	7	10.2
M14	× 2.0	TB744546	20	110	11	9	12
M16	× 2.0	TB744606	20	110	12	9	14
M18	× 2.5	TB744656	25	125	14	11	15.5
M20	× 2.5	TB744706	25	140	16	12	17.5
M22	× 2.5	TB744746	25	140	18	14.5	18.5
M24	× 3.0	TB744786	30	160	18	14.5	21
M27	× 3.0	TB744866	30	160	20	16	24
M30	× 3.5	TB744946	35	180	22	18	26.5

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

► HSS-PM(M2~M12/TQ744) and HSS-E(M14~M30/TB744)

* Coating(TiN, TiCN or TiAlN) is available on your request.

Unit : N/mm²

◎ : 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
○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

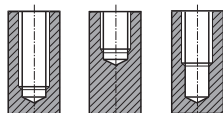
MF ISO Metric fine threads DIN 13

Metrisches ISO-Feingewinde DIN 13

► For stainless steels and correct thread profiles & long tool life due to special tap geometry. YG-1 company has a patent.

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

Hole type



up to M12

over M12

HSS-PM

HSS-E

DIN 374

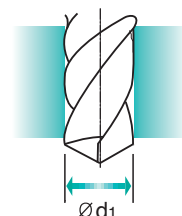
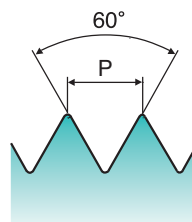
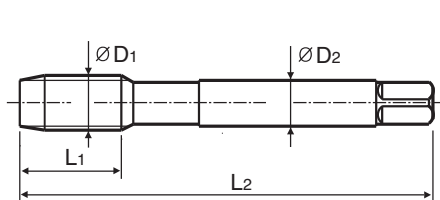
6H

60°

C

Vap

R45

Machine taps
Maschinen-
gewindebohrer

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	TQ754256	5	63	2.8	2.1	3.5
M5	× 0.5	TQ754296	5	70	3.5	2.7	4.5
M6	× 0.75	TQ754326	8	80	4.5	3.4	5.2
M6	× 0.5	TQ754336	5	80	4.5	3.4	5.5
M7	× 0.75	TQ754356	10	80	5.5	4.3	6.2
M8	× 1.0	TQ754376	10	90	6	4.9	7
M8	× 0.75	TQ754386	8	80	6	4.9	7.2
M10	× 1.25	TQ754436	16	100	7	5.5	8.8
M10	× 1.0	TQ754446	10	90	7	5.5	9
M10	× 0.75	TQ754456	10	90	7	5.5	9.2
M12	× 1.5	TQ754516	15	100	9	7	10.5
M12	× 1.25	TQ754526	15	100	9	7	10.8
M12	× 1.0	TQ754536	11	100	9	7	11
M14	× 1.5	TB754556	15	100	11	9	12.5
M14	× 1.25	TB754566	15	100	11	9	12.8
M14	× 1.0	TB754576	11	100	11	9	13

► HSS-PM(M4~M12/TQ754) and HSS-E(M14~M30/TB754)

* Coating(TiN, TiCN or TiAlN) s available on your request.

Unit : N/mm²

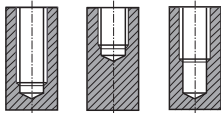
◎ : Excellent ○ : Good

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
				○										

**COMBO TAPS****Combo** TAP**TQ754** SERIES**TB754** SERIES**MF****ISO Metric fine threads DIN 13****Metrisches ISO-Feingewinde DIN 13**

► For stainless steels and correct thread profiles & long tool life due to special tap geometry. YG-1 company has a patent.

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

Hole type

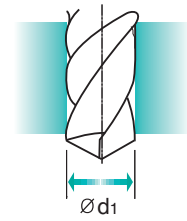
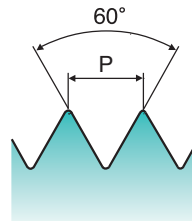
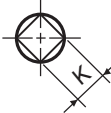
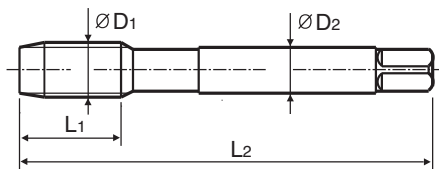
Material groups

VA

up to M12

HSS-PM

over M12

HSS-E**DIN 374****6H****Vap**Machine taps
Maschinengewindebohrer

Unit : mm

SIZE ØD1	Pitch P	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping Drill Diameter Ød1
M16	× 1.5	TB754616	15	100	12	9	14.5
M16	× 1.0	TB754626	12	100	12	9	15
M18	× 1.5	TB754676	17	110	14	11	16.5
M18	× 1.0	TB754686	13	110	14	11	17
M20	× 1.5	TB754726	17	125	16	12	18.5
M20	× 1.0	TB754736	14	125	16	12	19
M22	× 1.5	TB754766	17	125	18	14.5	20.5
M22	× 1.0	TB754776	14	125	18	14.5	21
M24	× 2.0	TB754796	20	140	18	14.5	22
M24	× 1.5	TB754806	20	140	18	14.5	22.5
M26	× 1.5	TB754856	20	140	18	14.5	24.5
M27	× 2.0	TB754876	20	140	20	16	25
M27	× 1.5	TB754886	20	140	20	16	25.5
M28	× 1.5	TB754916	20	140	20	16	26.5
M30	× 2.0	TB754966	22	150	22	18	28
M30	× 1.5	TB754976	22	150	22	18	28.5

► HSS-PM(M4~M12/TQ754) and HSS-E(M14~M30/TB754)

* Coating(TiN, TiCN or TiAlN) is available on your request.

Unit : N/mm²

◎ : 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
TAPSSPIRAL
FLUTE TAPSSPIRAL
POINT TAPSSTRAIGHT
FLUTE TAPSCOLD
FORMING
TAPS

NUT TAPS

STI TAPS

HAND TAPS

PIPE TAPS

CARBIDE
TAPSTHREAD
MILLSTECHNICAL
DATA

HSS

CARBIDE

COMBO
TAPSSPIRAL
FLUTE TAPSSPIRAL
POINT TAPSSTRAIGHT
FLUTE TAPSCOLD
FORMING
TAPS

NUT TAPS

STI TAPS

HAND TAPS

PIPE TAPS

CARBIDE
TAPSTHREAD
MILLSTECHNICAL
DATA

COMBO TAPS

Combo^{TAP}

TC824 SERIES

Bright

TD824 SERIES

TiN

UNC

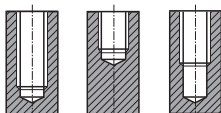
Unified coarse threads

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.

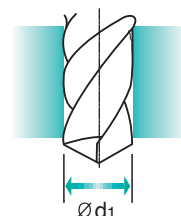
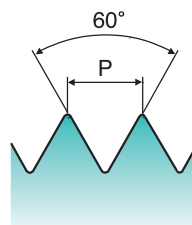
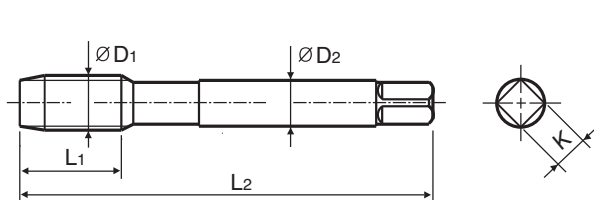
Hole type

Material groups
MU

HSS-E

DIN
371/376

2B

Bright
TiNMachine taps
Maschinengewindebohrer

Unit : mm

SIZE	TPI	EDP No.		Thread Length	Overall Length	Shank Diameter	Square Size	Tapping Drill Diameter
ØD1		Bright	TiN	L1	L2	ØD2	K	Ød1
#4	- 40 UNC	TC824162	TD824162	6	56	3.5	2.7	2.3
#5	- 40 UNC	TC824202	TD824202	7	56	3.5	2.7	2.6
#6	- 32 UNC	TC824242	TD824242	7	56	4	3	2.85
#8	- 32 UNC	TC824282	TD824282	8	63	4.5	3.4	3.5
#10	- 24 UNC	TC824322	TD824322	10	70	6	4.9	3.9
#12	- 24 UNC	TC824362	TD824362	10	80	6	4.9	4.5
1/4"	- 20 UNC	TC824402	TD824402	13	80	7	5.5	5.2
5/16"	- 18 UNC	TC824442	TD824442	14	90	8	6.2	6.6
3/8"	- 16 UNC	TC824482	TD824482	16	100	9	7	8
7/16"	- 14 UNC	TC824522	TD824522	17	100	8	6.2	9.4
1/2"	- 13 UNC	TC824562	TD824562	20	110	9	7	10.75
9/16"	- 12 UNC	TC824602	TD824602	20	110	11	9	12.25
5/8"	- 11 UNC	TC824642	TD824642	22	110	12	9	13.5
3/4"	- 10 UNC	TC824702	TD824702	25	125	14	11	16.5
7/8"	- 9 UNC	TC824742	TD824742	27	140	18	14.5	19.5
1"	- 8 UNC	TC824782	TD824782	30	160	20	16	22.25

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

* The other coating(TiCN or TiAlN) or Surface Treatment(Steam Homo) is available on your request.

Unit : N/mm²

◎ : Excellent ○ : Good

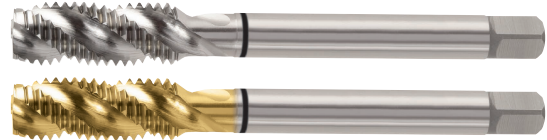
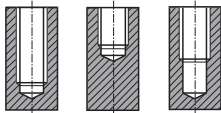
Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400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

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 Standzeit dank einer besonderen Schneidengeometrie. Von YG-1 patentiert.

Hole type



Material groups
MU

HSS-E

DIN 371/374

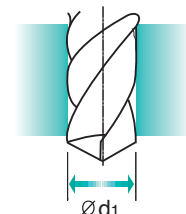
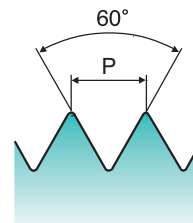
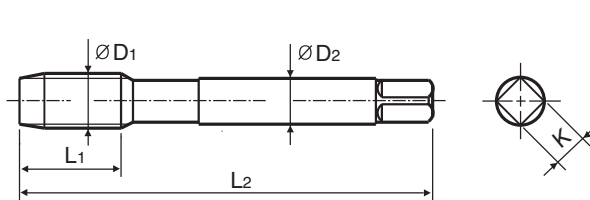
2B



Bright
TiN



Machine taps
Maschinengewindebohrer



Unit : mm

SIZE ØD1	TPI	EDP No.		Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping Drill Diameter Ød1
		Bright	TiN					
#4	- 48UNF	TC864182	TD864182	6	56	3.5	2.7	2.4
#5	- 44UNF	TC864222	TD864222	7	56	3.5	2.7	2.7
#6	- 40UNF	TC864262	TD864262	7	56	4	3	3
#8	- 36UNF	TC864302	TD864302	8	63	4.5	3.4	3.5
#10	- 32UNF	TC864342	TD864342	10	70	6	4.9	4.1
#12	- 28UNF	TC864382	TD864382	10	80	6	4.9	4.7
1/4"	- 28UNF	TC864422	TD864422	10	80	7	5.5	5.5
5/16"	- 24UNF	TC864462	TD864462	10	90	8	6.2	6.9
3/8"	- 24UNF	TC864502	TD864502	10	100	9	7	8.5
7/16"	- 20UNF	TC864542	TD864542	13	100	8	6.2	9.9
1/2"	- 20UNF	TC864582	TD864582	13	100	9	7	11.5
9/16"	- 18UNF	TC864622	TD864622	15	100	11	9	12.9
5/8"	- 18UNF	TC864662	TD864662	15	100	12	9	14.5
3/4"	- 16UNF	TC864722	TD864722	17	110	14	11	17.5
7/8"	- 14UNF	TC864762	TD864762	17	125	18	14.5	20.5
1"	- 12UNF	TC864802	TD864802	20	140	20	16	23.25

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

* The other coating(TiCN or TiAlN) or Surface Treatment(Steam Homo) is available on your request.

Unit : N/mm²

◎ : 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	Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

**COMBO TAPS****Combo** TAP**TC814** SERIES

Bright

TD814 SERIES

TiN

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 Standzeitendank einer besonderen Schneidengeometrie. Von YG-1 patentiert.

Hole type**MU**

HSS-E

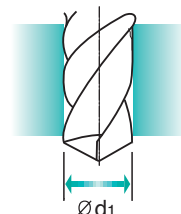
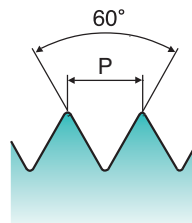
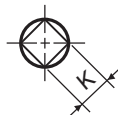
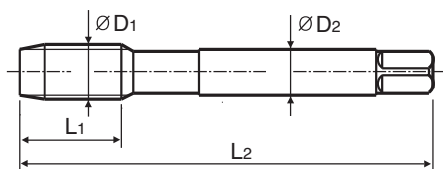
DIN
371/376

6H



Bright

TiN

Machine taps
Maschinengewindebohrer

Unit : mm

SIZE	Pitch	EDP No.		Thread Length	Overall Length	Shank Diameter	Square Size	Tapping Drill Diameter
ØD1	P	Bright	TiN	L1	L2	ØD2	K	Ød1
M2	× 0.4	TC814136	TD814136	8	45	2.8	2.1	1.6
M2.2	× 0.45	TC814156	TD814156	8	45	2.8	2.1	1.75
M2.3	× 0.4	TC814196	TD814196	8	45	2.8	2.1	1.9
M2.5	× 0.45	TC814176	TD814176	9	50	2.8	2.1	2.05
M2.6	× 0.45	TC814496	TD814496	9	50	2.8	2.1	2.1
M3	× 0.5	TC814206	TD814206	11	56	3.5	2.7	2.5
M3.5	× 0.6	TC814226	TD814226	12	56	4	3	2.9
M4	× 0.7	TC814246	TD814246	13	63	4.5	3.4	3.3
M4.5	× 0.75	TC814266	TD814266	14	70	6	4.9	3.7
M5	× 0.8	TC814286	TD814286	15	70	6	4.9	4.2
M6	× 1.0	TC814316	TD814316	17	80	6	4.9	5
M7	× 1.0	TC814346	TD814346	17	80	7	5.5	6
M8	× 1.25	TC814366	TD814366	20	90	8	6.2	6.8
M9	× 1.25	TC814396	TD814396	20	90	9	7	7.8
M10	× 1.5	TC814426	TD814426	22	100	10	8	8.5
M11	× 1.5	TC814466	TD814466	22	100	8	6.2	9.5
M12	× 1.75	TC814506	TD814506	24	110	9	7	10.2
M14	× 2.0	TC814546	TD814546	26	110	11	9	12
M16	× 2.0	TC814606	TD814606	27	110	12	9	14
M18	× 2.5	TC814656	TD814656	30	125	14	11	15.5
M20	× 2.5	TC814706	TD814706	32	140	16	12	17.5
M22	× 2.5	TC814746	TD814746	32	140	18	14.5	18.5
M24	× 3.0	TC814786	TD814786	34	160	18	14.5	21
M27	× 3.0	TC814866	TD814866	36	160	20	16	24
M30	× 3.5	TC814946	TD814946	40	180	22	18	26.5

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

* The other coating(TiCN or TiAlN) or Surface Treatment(Steam Homo) is available on your request.

Unit : N/mm²

◎ : 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	Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

MF ISO Metric fine threads DIN 13

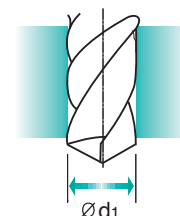
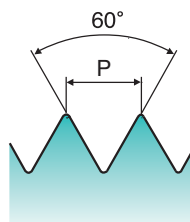
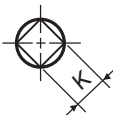
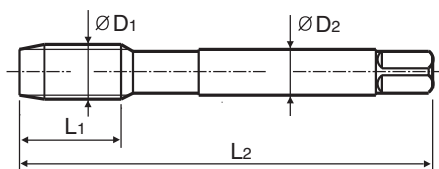
Metrisches ISO-Feingewinde DIN 13

► 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.



Machine taps
Maschinengewindebohrer



Unit : mm

SIZE	Pitch	EDP No.		Thread Length	Overall Length	Shank Diameter	Square Size	Tapping Drill Diameter
ØD1	P	Bright	TiN	L1	L2	ØD2	K	Ød1
M4	× 0.5	TC854256	TD854256	10	63	2.8	2.1	3.5
M5	× 0.5	TC854296	TD854296	11	70	3.5	2.7	4.5
M6	× 0.75	TC854326	TD854326	13	80	4.5	3.4	5.2
M6	× 0.5	TC854336	TD854336	13	80	4.5	3.4	5.5
M7	× 0.75	TC854356	TD854356	14	80	5.5	4.3	6.2
M8	× 1.0	TC854376	TD854376	17	90	6	4.9	7
M8	× 0.75	TC854386	TD854386	14	80	6	4.9	7.2
M10	× 1.25	TC854436	TD854436	22	100	7	5.5	8.8
M10	× 1.0	TC854446	TD854446	18	90	7	5.5	9
M10	× 0.75	TC854456	TD854456	18	90	7	5.5	9.2
M12	× 1.5	TC854516	TD854516	22	100	9	7	10.5
M12	× 1.25	TC854526	TD854526	22	100	9	7	10.8
M12	× 1.0	TC854536	TD854536	18	100	9	7	11
M14	× 1.5	TC854556	TD854556	22	100	11	9	12.5
M14	× 1.25	TC854566	TD854566	22	100	11	9	12.8
M14	× 1.0	TC854576	TD854576	18	100	11	9	13

* The other coating(TiCN or TiAlN) or Surface Treatment(Steam Homo) is available on your request.

Unit : N/mm²

◎ : 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	Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

HSS

CARBIDE

COMBO
TAPSSPIRAL
FLUTE TAPSSPIRAL
POINT TAPSSTRAIGHT
FLUTE TAPSCOLD
FORMING
TAPS

NUT TAPS

STI TAPS

HAND TAPS

PIPE TAPS

CARBIDE
TAPSTHREAD
MILLSTECHNICAL
DATA**YG COMBO TAPS****Combo** TAP**TC854** SERIES

Bright

TD854 SERIES

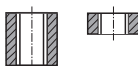
TiN

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

**MU**

HSS-E

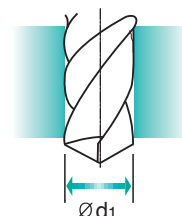
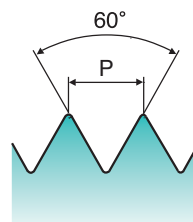
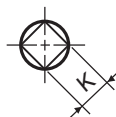
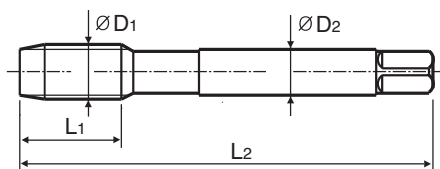
DIN
374

6H



Bright

TiN

Machine taps
Maschinengewindebohrer

Unit : mm

SIZE	Pitch	EDP No.		Thread Length	Overall Length	Shank Diameter	Square Size	Tapping Drill Diameter
ØD1	P	Bright	TiN	L1	L2	ØD2	K	Ød1
M16 × 1.5		TC854616	TD854616	22	100	12	9	14.5
M16 × 1.0		TC854626	TD854626	18	100	12	9	15
M18 × 1.5		TC854676	TD854676	25	110	14	11	16.5
M18 × 1.0		TC854686	TD854686	20	110	14	11	17
M20 × 1.5		TC854726	TD854726	25	125	16	12	18.5
M20 × 1.0		TC854736	TD854736	20	125	16	12	19
M22 × 1.5		TC854766	TD854766	25	125	18	14.5	20.5
M22 × 1.0		TC854776	TD854776	20	125	18	14.5	21
M24 × 2.0		TC854796	TD854796	27	140	18	14.5	22
M24 × 1.5		TC854806	TD854806	27	140	18	14.5	22.5
M26 × 1.5		TC854856	TD854856	28	140	18	14.5	24.5
M27 × 2.0		TC854876	TD854876	28	140	20	16	25
M27 × 1.5		TC854886	TD854886	28	140	20	16	25.5
M28 × 1.5		TC854916	TD854916	28	140	20	16	26.5
M30 × 2.0		TC854966	TD854966	30	150	22	18	28
M30 × 1.5		TC854976	TD854976	30	150	22	18	28.5

* The other coating(TiCN or TiAlN) or Surface Treatment(Steam Homo) is available on your request.

Unit : N/mm²

◎ : 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	Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
◎	◎	○	○	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

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.

Hole type



with Internal Coolant

Material groups
MU

HSS-E

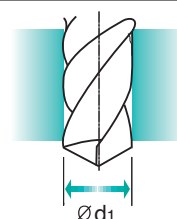
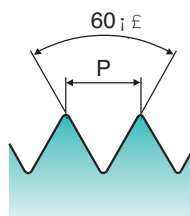
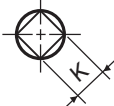
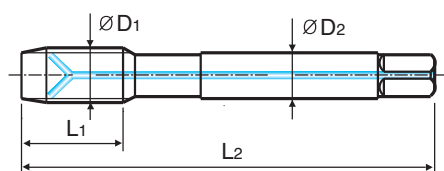
DIN 371/376

6H



Bright

Machine taps
Maschinengewindebohrer



Unit : mm

SIZE ØD1	Pitch P	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping Drill Diameter Ød1
M6	× 1.0	TC814316IC	17	80	6	4.9	5
M8	× 1.25	TC814366IC	20	90	8	6.2	6.8
M10	× 1.5	TC814426IC	22	100	10	8	8.5
M12	× 1.75	TC814506IC	24	110	9	7	10.2
M14	× 2.0	TC814546IC	26	110	11	9	12
M16	× 2.0	TC814606IC	27	110	12	9	14
M18	× 2.5	TC814656IC	30	125	14	11	15.5
M20	× 2.5	TC814706IC	32	140	16	12	17.5

► DIN371 (M6~M10) and DIN376 (M12~M20)

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

Unit : N/mm²

◎ : 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
TAPSSPIRAL
FLUTE TAPSSPIRAL
POINT TAPSSTRAIGHT
FLUTE TAPSCOLD
FORMING
TAPS

NUT TAPS

STI TAPS

HAND TAPS

PIPE TAPS

CARBIDE
TAPSTHREAD
MILLSTECHNICAL
DATA

COMBO TAPS

Combo^{TAP}

TC445 SERIES

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.

Hole type



Long Shank

Material groups
MU

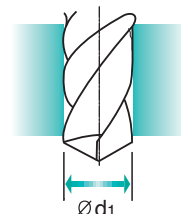
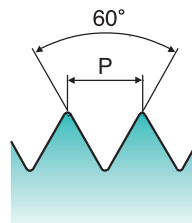
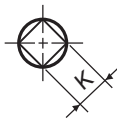
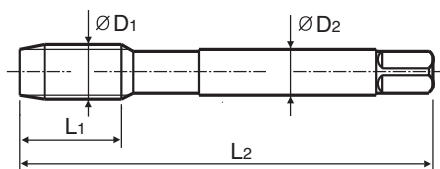
HSS-E

LONG

6H



Bright

Machine taps
Maschinengewindebohrer

Unit : mm

SIZE ØD1	Pitch P	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping Drill Diameter Ød1
M3	× 0.5	TC445206	11	100	3.5	2.7	2.5
M4	× 0.7	TC445246	13	125	4.5	3.4	3.3
M5	× 0.8	TC445286	15	140	6	4.9	4.2
M6	× 1.0	TC445316	17	160	6	4.9	5
M8	× 1.25	TC445366	20	180	6	4.9	6.8
M10	× 1.5	TC445426	22	200	7	5.5	8.5
M12	× 1.75	TC445506	24	220	9	7	10.2
M14	× 2.0	TC445546	26	220	11	9	12
M16	2.0	TC445606	27	220	12	9	14
M20	2.5	TC445706	32	280	16	12	17.5

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

Unit : N/mm²

◎ : 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	Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
◎	◎	○	○	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

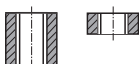
**COMBO TAPS****Combo** TAP**TQ428** SERIES**TB428** SERIES

M ISO Metric coarse threads DIN 13

Metrisches ISO-Gewinde DIN 13

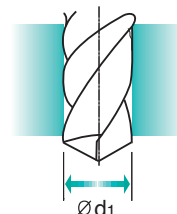
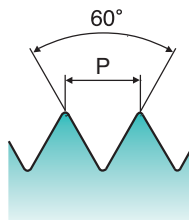
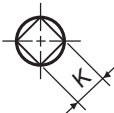
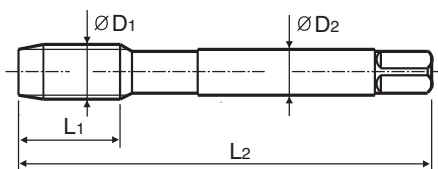
► For stainless steels and correct thread profiles & long tool life due to special tap geometry. YG-1 company has a patent.

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

Hole typeMaterial groups
VA

up to M12

over M12

HSS-PM**HSS-E****DIN 371/376****6H****Vap**Machine taps
Maschinengewindebohrer

Unit : mm

SIZE ØD1	Pitch P	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping Drill Diameter Ød1
M2	× 0.4	TQ428136	8	45	2.8	2.1	1.6
M2.2	× 0.45	TQ428156	8	45	2.8	2.1	1.75
M2.3	× 0.4	TQ428196	8	45	2.8	2.1	1.9
M2.5	× 0.45	TQ428176	9	50	2.8	2.1	2.05
M2.6	× 0.45	TQ428496	9	50	2.8	2.1	2.1
M3	× 0.5	TQ428206	11	56	3.5	2.7	2.5
M3.5	× 0.6	TQ428226	12	56	4	3	2.9
M4	× 0.7	TQ428246	13	63	4.5	3.4	3.3
M4.5	× 0.75	TQ428266	14	70	6	4.9	3.7
M5	× 0.8	TQ428286	15	70	6	4.9	4.2
M6	× 1.0	TQ428316	17	80	6	4.9	5
M7	× 1.0	TQ428346	17	80	7	5.5	6
M8	× 1.25	TQ428366	20	90	8	6.2	6.8
M9	× 1.25	TQ428396	20	90	9	7	7.8
M10	× 1.5	TQ428426	22	100	10	8	8.5
M11	× 1.5	TQ428466	22	100	8	6.2	9.5
M12	× 1.75	TQ428506	24	110	9	7	10.2
M14	× 2.0	TB428546	26	110	11	9	12
M16	× 2.0	TB428606	27	110	12	9	14
M18	× 2.5	TB428656	30	125	14	11	15.5
M20	× 2.5	TB428706	32	140	16	12	17.5
M22	× 2.5	TB428746	32	140	18	14.5	18.5
M24	× 3.0	TB428786	34	160	18	14.5	21
M27	× 3.0	TB428866	36	160	20	16	24
M30	× 3.5	TB428946	40	180	22	18	26.5

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

► HSS-PM(M2~M12/TQ428) and HSS-E(M14~M30/TB428)

* Coating(TiN, TiCN or TiAlN) is available on your request.

Unit : N/mm²

◎ : 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
TAPSSPIRAL
FLUTE TAPSSPIRAL
POINT TAPSSTRAIGHT
FLUTE TAPSCOLD
FORMING
TAPS

NUT TAPS

STI TAPS

HAND TAPS

PIPE TAPS

CARBIDE
TAPSTHREAD
MILLSTECHNICAL
DATA

HSS

CARBIDE

COMBO
TAPSSPIRAL
FLUTE TAPSSPIRAL
POINT TAPSSTRAIGHT
FLUTE TAPSCOLD
FORMING
TAPS

NUT TAPS

STI TAPS

HAND TAPS

PIPE TAPS

CARBIDE
TAPSTHREAD
MILLSTECHNICAL
DATA

COMBO TAPS

Combo^{TAP}

TQ438 SERIES

TB438 SERIES

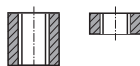
MF ISO Metric fine threads DIN 13

Metrisches ISO-Feingewinde DIN 13

► For stainless steels and correct thread profiles & long tool life due to special tap geometry. YG-1 company has a patent.

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

Hole type



up to M12

over M12

HSS-PM

HSS-E

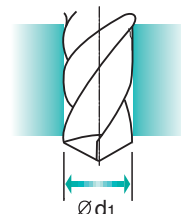
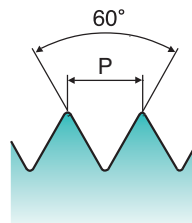
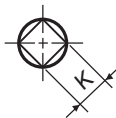
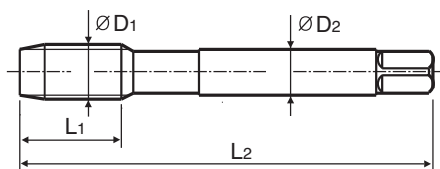
DIN
374

6H

60°

B

Vap

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	TQ438256	10	63	2.8	2.1	3.5
M5	× 0.5	TQ438296	11	70	3.5	2.7	4.5
M6	× 0.75	TQ438326	13	80	4.5	3.4	5.2
M6	× 0.5	TQ438336	13	80	4.5	3.4	5.5
M7	× 0.75	TQ438356	14	80	5.5	4.3	6.2
M8	× 1.0	TQ438376	17	90	6	4.9	7
M8	× 0.75	TQ438386	14	80	6	4.9	7.2
M10	× 1.25	TQ438436	22	100	7	5.5	8.8
M10	× 1.0	TQ438446	18	90	7	5.5	9
M10	× 0.75	TQ438456	18	90	7	5.5	9.2
M12	× 1.5	TQ438516	22	100	9	7	10.5
M12	× 1.25	TQ438526	22	100	9	7	10.8
M12	× 1.0	TQ438536	18	100	9	7	11
M14	× 1.5	TB438556	22	100	11	9	12.5
M14	× 1.25	TB438566	22	100	11	9	12.8
M14	× 1.0	TB438576	18	100	11	9	13

► HSS-PM(M4~M12/TQ438) and HSS-E(M14~M30/TB438)

* Coating(TiN, TiCN or TiAlN) is available on your request.

Unit : N/mm²

◎ : 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
				○										

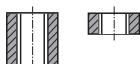
MF ISO Metric fine threads DIN 13

Metrisches ISO-Feingewinde DIN 13

► For stainless steels and correct thread profiles & long tool life due to special tap geometry. YG-1 company has a patent.

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

Hole type



Material groups
VA

up to M12

HSS-PM

over M12

HSS-E

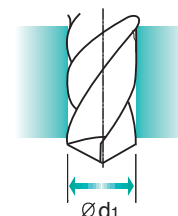
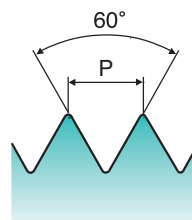
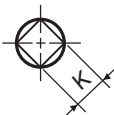
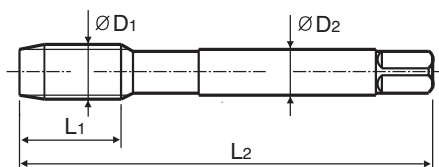
DIN 374

6H



Vap

Machine taps
Maschinengewindebohrer



Unit : mm

SIZE ØD1	Pitch P	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping Drill Diameter Ød1
M16	× 1.5	TB438616	22	100	12	9	14.5
M16	× 1.0	TB438626	18	100	12	9	15
M18	× 1.5	TB438676	25	110	14	11	16.5
M18	× 1.0	TB438686	20	110	14	11	17
M20	× 1.5	TB438726	25	125	16	12	18.5
M20	× 1.0	TB438736	20	125	16	12	19
M22	× 1.5	TB438766	25	125	18	14.5	20.5
M22	× 1.0	TB438776	20	125	18	14.5	21
M24	× 2.0	TB438796	27	140	18	14.5	22
M24	× 1.5	TB438806	27	140	18	14.5	22.5
M26	× 1.5	TB438856	28	140	18	14.5	24.5
M27	× 2.0	TB438876	28	140	20	16	25
M27	× 1.5	TB438886	28	140	20	16	25.5
M28	× 1.5	TB438916	28	140	20	16	26.5
M30	× 2.0	TB438966	30	150	22	18	28
M30	× 1.5	TB438976	30	150	22	18	28.5

► HSS-PM(M4~M12/TQ438) and HSS-E(M14~M30/TB438)

* Coating(TiN, TiCN or TiAlN) is available on your request.

Unit : N/mm²

◎ : 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
TAPSSPIRAL
FLUTE TAPSSPIRAL
POINT TAPSSTRAIGHT
FLUTE TAPSCOLD
FORMING
TAPS

NUT TAPS

STI TAPS

HAND TAPS

PIPE TAPS

CARBIDE
TAPSTHREAD
MILLSTECHNICAL
DATA

COMBO TAPS

Combo TAP

TC834 SERIES

Bright

TD834 SERIES

TiN

UNC

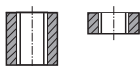
Unified coarse threads

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.

Hole type

Material groups
MU

HSS-E

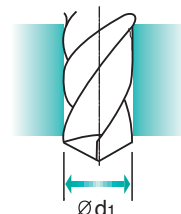
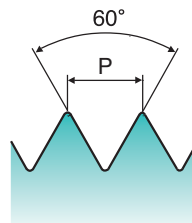
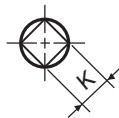
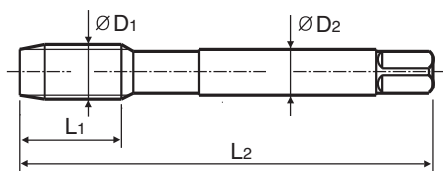
DIN
371/376

2B



Bright

TiN

Machine taps
Maschinengewindebohrer

Unit : mm

SIZE	TPI	EDP No.		Thread Length	Overall Length	Shank Diameter	Square Size	Tapping Drill Diameter
Ø D1		Bright	TiN	L1	L2	Ø D2	K	Ø d1
#4	- 40 UNC	TC834162	TD834162	11	56	3.5	2.7	2.3
#5	- 40 UNC	TC834202	TD834202	11	56	3.5	2.7	2.6
#6	- 32 UNC	TC834242	TD834242	12	56	4	3	2.85
#8	- 32 UNC	TC834282	TD834282	13	63	4.5	3.4	3.5
#10	- 24 UNC	TC834322	TD834322	15	70	6	4.9	3.9
#12	- 24 UNC	TC834362	TD834362	16	80	6	4.9	4.5
1/4"	- 20 UNC	TC834402	TD834402	17	80	7	5.5	5.2
5/16"	- 18 UNC	TC834442	TD834442	20	90	8	6.2	6.6
3/8"	- 16 UNC	TC834482	TD834482	22	100	9	7	8
7/16"	- 14 UNC	TC834522	TD834522	22	100	8	6.2	9.4
1/2"	- 13 UNC	TC834562	TD834562	25	110	9	7	10.75
9/16"	- 12 UNC	TC834602	TD834602	26	110	11	9	12.25
5/8"	- 11 UNC	TC834642	TD834642	27	110	12	9	13.5
3/4"	- 10 UNC	TC834702	TD834702	30	125	14	11	16.5
7/8"	- 9 UNC	TC834742	TD834742	32	140	18	14.5	19.5
1"	- 8 UNC	TC834782	TD834782	36	160	20	16	22.25

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

* The other coating(TiCN or TiAlN) or Surface Treatment(Steam Homo) is available on your request.

Unit : N/mm²

◎ : 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	Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
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UNF

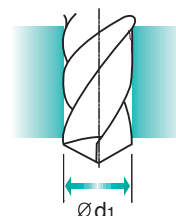
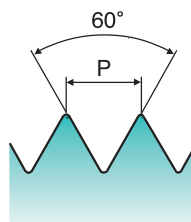
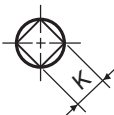
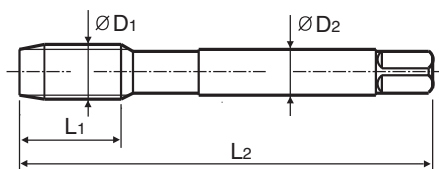
Unified fine threads Unified Feingewinde

► 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.



Machine taps
Maschinengewindebohrer



Unit : mm

SIZE	TPI	EDP No.		Thread Length	Overall Length	Shank Diameter	Square Size	Tapping Drill Diameter
ØD1		Bright	TiN	L1	L2	ØD2	K	Ød1
#4	- 48UNF	TC874182	TD874182	11	56	3.5	2.7	2.4
#5	- 44UNF	TC874222	TD874222	11	56	3.5	2.7	2.7
#6	- 40UNF	TC874262	TD874262	12	56	4	3	3
#8	- 36UNF	TC874302	TD874302	13	63	4.5	3.4	3.5
#10	- 32UNF	TC874342	TD874342	15	70	6	4.9	4.1
#12	- 28UNF	TC874382	TD874382	16	80	6	4.9	4.7
1/4"	- 28UNF	TC874422	TD874422	17	80	7	5.5	5.5
5/16"	- 24UNF	TC874462	TD874462	17	90	8	6.2	6.9
3/8"	- 24UNF	TC874502	TD874502	18	100	9	7	8.5
7/16"	- 20UNF	TC874542	TD874542	22	100	8	6.2	9.9
1/2"	- 20UNF	TC874582	TD874582	22	100	9	7	11.5
9/16"	- 18UNF	TC874622	TD874622	22	100	11	9	12.9
5/8"	- 18UNF	TC874662	TD874662	22	100	12	9	14.5
3/4"	- 16UNF	TC874722	TD874722	25	110	14	11	17.5
7/8"	- 14UNF	TC874762	TD874762	26	125	18	14.5	20.5
1"	- 12UNF	TC874802	TD874802	28	140	20	16	23.25

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

* The other coating(TiCN or TiAlN) or Surface Treatment(Steam Homo) is available on your request.

Unit : N/mm²

◎ : 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	Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎