COMBO TAP

Vap **TB824 SERIES**
Bright **TC824 SERIES**
TiN **TD824 SERIES**

UNC Unified coarse threads

Unified Grobgewinde
UNC
Unificato passo grosso

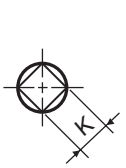
Machine taps
Maschinengewindebohrer

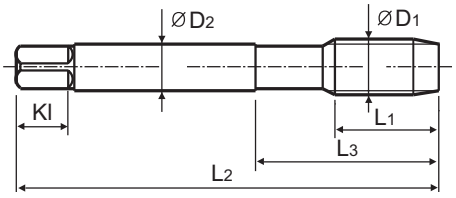
▶ For using multi-purpose and correct thread profiles & long tool life due to special tap geometry. YG-1 company has a patent.

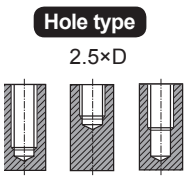
▶ Für vielfältigen Einsatz, genaue Gewindeprofile und lange Standzeitendank einer besonderen Schneidengeometrie. Von YG-1 patentiert.

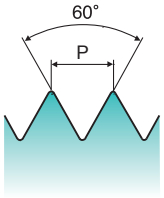


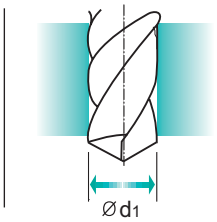












Material groups **MU** | HSS-E | DIN 371/376 | 2B | 60° | C | R40 | Vap Bright TiN

p.B130

Recommended ToolHolder: Plain Shank; TAPPING ER CHUCK; TAPPING CHUCK; ONE STEP TAPPING CHUCK

Unit : mm

SIZE ØD1	TPI	EDP No. Vap	Bright	TiN	Thread Length L1	Overall Length L2	Neck Length L3	Shank Diameter ØD2	Square Size K	Square Length Kl	No. of Flute Z	Tapping Drill Diameter Ød1
#4 -	40UNC	TB824162	TC824162	TD824162	6	56	18	3.5	2.7	6	3	2.3
#5 -	40UNC	TB824202	TC824202	TD824202	7	56	18	3.5	2.7	6	3	2.6
#6 -	32UNC	TB824242	TC824242	TD824242	7	56	20	4	3	6	3	2.85
#8 -	32UNC	TB824282	TC824282	TD824282	8	63	21	4.5	3.4	6	3	3.5
#10 -	24UNC	TB824322	TC824322	TD824322	10	70	25	6	4.9	8	3	3.9
#12 -	24UNC	TB824362	TC824362	TD824362	10	80	30	6	4.9	8	3	4.5
1/4 -	20UNC	TB824402	TC824402	TD824402	13	80	30	7	5.5	8	3	5.2
5/16 -	18UNC	TB824442	TC824442	TD824442	14	90	35	8	6.2	9	3	6.6
3/8 -	16UNC	TB824482	TC824482	TD824482	16	100	39	9	7	10	3	8
7/16 -	14UNC	TB824522	TC824522	TD824522	17	100	40	8	6.2	9	3	9.4
1/2 -	13UNC	TB824562	TC824562	TD824562	20	110	44	9	7	10	3	10.75
9/16 -	12UNC	TB824602	TC824602	TD824602	20	110	44	11	9	12	3	12.25
5/8 -	11UNC	TB824642	TC824642	TD824642	22	110	44	12	9	12	3	13.5
3/4 -	10UNC	TB824702	TC824702	TD824702	25	125	50	14	11	14	4	16.5
7/8 -	9UNC	TB824742	TC824742	TD824742	27	140	54	18	14.5	17	4	19.5
1 -	8UNC	TB824782	TC824782	TD824782	30	160	60	20	16	19	4	22.25

▶ DIN 371(#4~3/8) and DIN 374(7/16~1)
▶ 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			◎			◎	◎	◎													

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