COMBO TAP

Vap **TB844 SERIES**
Bright **TC844 SERIES**
TiN **TD844 SERIES**

MF ISO Metric fine threads DIN 13

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

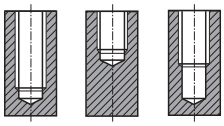
Machine taps
Maschinengewindebohrer

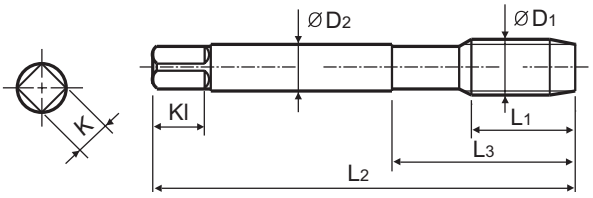
▶ For using multi-purpose and correct thread profiles & long tool life due to special tap geometry. YG-1 company has a patent.

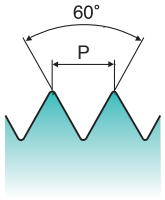
▶ Für vielfältigen Einsatz, genaue Gewindeprofile und lange Standzeitendank einer besonderen Schneidengeometrie. Von YG-1 patentiert.

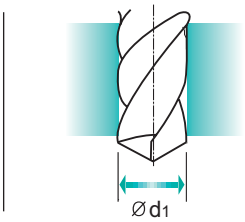


Hole type
2.5×D









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

p.B130

Recommended ToolHolder: Plain Shank — TAPPING ER CHUCK, TAPPING CHUCK, ONE STEP TAPPING CHUCK

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	TB844256	TC844256	TD844256	5	63	21	2.8	2.1	5	3	3.5
M5 ×	0.5	TB844296	TC844296	TD844296	5	70	25	3.5	2.7	6	3	4.5
M6 ×	0.75	TB844326	TC844326	TD844326	8	80	30	4.5	3.4	6	3	5.2
M6 ×	0.5	TB844336	TC844336	TD844336	5	80	30	4.5	3.4	6	3	5.5
M7 ×	0.75	TB844356	TC844356	TD844356	10	80	30	5.5	4.3	7	3	6.2
M8 ×	1.0	TB844376	TC844376	TD844376	10	90	36	6	4.9	8	3	7
M8 ×	0.75	TB844386	TC844386	TD844386	8	80	30	6	4.9	8	3	7.2
M10 ×	1.25	TB844436	TC844436	TD844436	16	100	40	7	5.5	8	3	8.8
M10 ×	1.0	TB844446	TC844446	TD844446	10	90	36	7	5.5	8	3	9
M10 ×	0.75	TB844456	TC844456	TD844456	10	90	36	7	5.5	8	3	9.2
M12 ×	1.5	TB844516	TC844516	TD844516	15	100	40	9	7	10	3	10.5
M12 ×	1.25	TB844526	TC844526	TD844526	15	100	40	9	7	10	3	10.8
M12 ×	1.0	TB844536	TC844536	TD844536	11	100	40	9	7	10	3	11
M14 ×	1.5	TB844556	TC844556	TD844556	15	100	40	11	9	12	3	12.5
M14 ×	1.25	TB844566	TC844566	TD844566	15	100	40	11	9	12	3	12.8
M14 ×	1.0	TB844576	TC844576	TD844576	11	100	40	11	9	12	3	13
M16 ×	1.5	TB844616	TC844616	TD844616	15	100	40	12	9	12	3	14.5
M16 ×	1.0	TB844626	TC844626	TD844626	12	100	40	12	9	12	3	15
M18 ×	1.5	TB844676	TC844676	TD844676	17	110	44	14	11	14	4	16.5
M18 ×	1.0	TB844686	TC844686	TD844686	13	110	44	14	11	14	4	17
M20 ×	1.5	TB844726	TC844726	TD844726	17	125	50	16	12	15	4	18.5
M20 ×	1.0	TB844736	TC844736	TD844736	14	125	50	16	12	15	4	19
M22 ×	1.5	TB844766	TC844766	TD844766	17	125	50	18	14.5	17	4	20.5
M22 ×	1.0	TB844776	TC844776	TD844776	14	125	50	18	14.5	17	4	21

▶ 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			◎			◎	◎	◎													

phone:+82-32-526-0909, www.yg1.solutions, E-mail:yg1@yg1.solutions
YG-1 CO., LTD.

COMBO TAP

Vap **TB844 SERIES**
Bright **TC844 SERIES**
TiN **TD844 SERIES**

MF ISO Metric fine threads DIN 13

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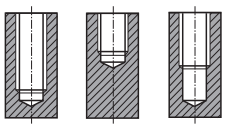

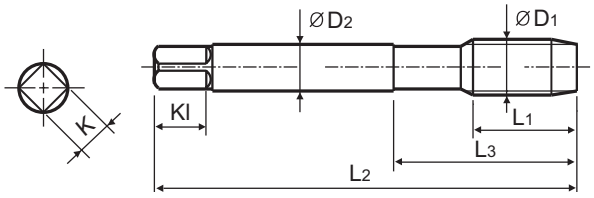

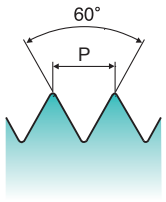

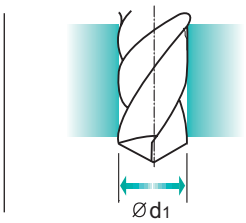

Material groups **MU** | HSS-E | DIN 374 | 6H | 60° | C | R40 | Vap Bright TiN

p.B130

Recommended ToolHolder
Plain Shank
TAPPING ER CHUCK
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ONE STEP TAPPING CHUCK

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
M24 ×	2.0	TB844796	TC844796	TD844796	20	140	54	18	14.5	17	4	22
M24 ×	1.5	TB844806	TC844806	TD844806	20	140	54	18	14.5	17	4	22.5
M26 ×	1.5	TB844856	TC844856	TD844856	20	140	54	18	14.5	17	4	24.5
M27 ×	2.0	TB844876	TC844876	TD844876	20	140	54	20	16	19	4	25
M27 ×	1.5	TB844886	TC844886	TD844886	20	140	54	20	16	19	4	25.5
M28 ×	1.5	TB844916	TC844916	TD844916	20	140	54	20	16	19	4	26.5
M30 ×	2.0	TB844966	TC844966	TD844966	22	150	57	22	18	21	4	28
M30 ×	1.5	TB844976	TC844976	TD844976	22	150	57	22	18	21	4	28.5
M32 x	2.0	-	TC844A16	TD844A16	22	150	57	22	18	21	4	30.0
M32 x	1.5	-	TC844A26	TD844A26	22	150	57	22	18	21	4	30.5
M33 x	2.0	-	TC844A66	TD844A66	24	160	60	25	20	23	4	31.0
M33 x	1.5	-	TC844A76	TD844A76	24	160	60	25	20	23	4	31.5
M34 x	1.5	-	TC844A96	TD844A96	24	170	70	28	22	25	4	32.5
M35 x	1.5	-	TC844B16	TD844B16	24	170	70	28	22	25	4	33.5
M36 x	3.0	-	TC844B46	TD844B46	30	200	80	28	22	25	4	33.0
M36 x	2.0	-	TC844B56	TD844B56	24	170	70	28	22	25	4	34.0
M36 x	1.5	-	TC844B66	TD844B66	24	170	70	28	22	25	4	34.5
M38 x	1.5	-	TC844B86	TD844B86	24	170	70	28	22	25	4	36.5
M39 x	1.5	-	TC844C36	TD844C36	25	170	70	32	24	27	4	37.5
M40 x	1.5	-	TC844C66	TD844C66	25	170	70	32	24	27	4	38.5
M42 x	3.0	-	TC844D06	TD844D06	30	200	80	32	24	27	4	39.0
M42 x	2.0	-	TC844D16	TD844D16	25	170	70	32	24	27	4	40.0
M42 x	1.5	-	TC844D26	TD844D26	25	170	70	32	24	27	4	40.5
M45 x	1.5	-	TC844D96	TD844D96	26	180	80	36	29	32	4	43.5

▶ 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	400 Rm	1050 Rm	550	630	400	550
Recommended			◎			◎	◎	◎													

COMBO TAP

Vap **TB844 SERIES**
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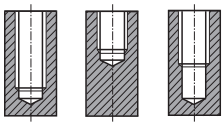

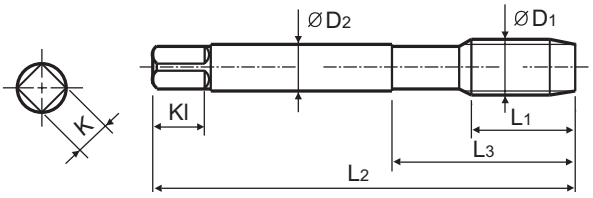

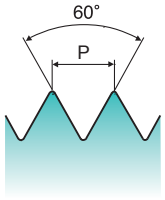

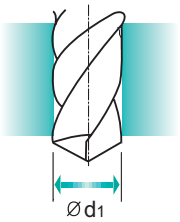

Material groups **MU** | HSS-E | DIN 374 | 6H | 60° | C | R40 | Vap Bright TiN

p.B130

Recommended ToolHolder
Plain Shank
TAPPING ER CHUCK
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ONE STEP TAPPING CHUCK

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
M48 x	3.0	-	TC844E56	TD844E56	36	225	90	36	29	32	4	45.0
M48 x	2.0	-	TC844E66	TD844E66	28	190	80	36	29	32	4	46.0
M48 x	1.5	-	TC844E76	TD844E76	28	190	80	36	29	32	4	46.5
M50 x	1.5	-	TC844F16	TD844F16	28	190	80	36	29	32	4	48.5
M52 x	3.0	-	TC844F56	TD844F56	36	225	90	40	32	35	4	49.0
M52 x	2.0	-	TC844F66	TD844F66	28	190	80	40	32	35	4	50.0
M52 x	1.5	-	TC844F76	TD844F76	28	190	80	40	32	35	4	50.5

▶ 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			
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HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended			◎			◎	◎	◎													