COMBO TAP

Vap **TB864 SERIES**
Bright **TC864 SERIES**
TiN **TD864 SERIES**

UNF — Unified fine threads

Unified Feingewinde
UNF
Unificato passo fine

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.

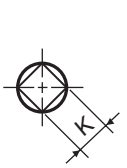
▶ Für vielfältigen Einsatz, genaue Gewindeprofile und lange Standzeitendank einer besonderen Schneidengeometrie. Von YG-1 patentiert.

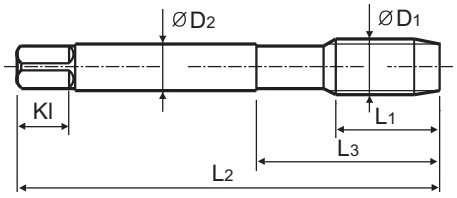
DIN 371



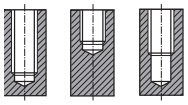
DIN 374

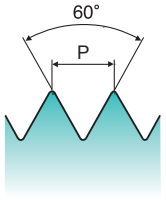


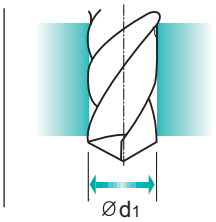




Hole type
2.5×D







Material groups **MU** | HSS-E | DIN 371/374 | 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 -	48UNF	TB864182	TC864182	TD864182	6	56	18	3.5	2.7	6	3	2.4
#5 -	44UNF	TB864222	TC864222	TD864222	7	56	18	3.5	2.7	6	3	2.7
#6 -	40UNF	TB864262	TC864262	TD864262	7	56	20	4	3	6	3	3
#8 -	36UNF	TB864302	TC864302	TD864302	8	63	21	4.5	3.4	6	3	3.5
#10 -	32UNF	TB864342	TC864342	TD864342	10	70	25	6	4.9	8	3	4.1
#12 -	28UNF	TB864382	TC864382	TD864382	10	80	30	6	4.9	8	3	4.7
1/4 -	28UNF	TB864422	TC864422	TD864422	10	80	30	7	5.5	8	3	5.5
5/16 -	24UNF	TB864462	TC864462	TD864462	10	90	35	8	6.2	9	3	6.9
3/8 -	24UNF	TB864502	TC864502	TD864502	10	100	39	9	7	10	3	8.5
7/16 -	20UNF	TB864542	TC864542	TD864542	13	100	40	8	6.2	9	3	9.9
1/2 -	20UNF	TB864582	TC864582	TD864582	13	100	40	9	7	10	3	11.5
9/16 -	18UNF	TB864622	TC864622	TD864622	15	100	40	11	9	12	3	12.9
5/8 -	18UNF	TB864662	TC864662	TD864662	15	100	40	12	9	12	3	14.5
3/4 -	16UNF	TB864722	TC864722	TD864722	17	110	44	14	11	14	4	17.5
7/8 -	14UNF	TB864762	TC864762	TD864762	17	125	50	18	14.5	17	4	20.5
1 -	12UNF	TB864802	TC864802	TD864802	20	140	54	20	16	19	4	23.25

▶ 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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