COMBO TAP

Vap **TB874 SERIES**
Bright **TC874 SERIES**
TiN **TD874 SERIES**

UNF

Unified fine threads

Unified Feingewindea
UNF
Unificato passo fine

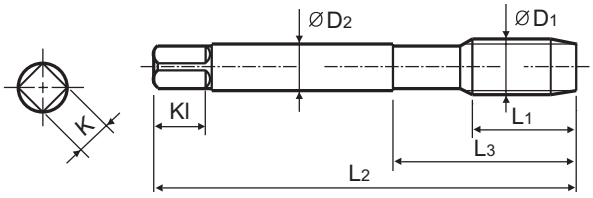
Machine taps
Maschinengewindebohrer

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

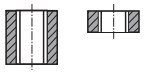
▶ Für vielfältigen Einsatz, genaue Gewindeprofile und lange Standzeitendank einer besonderen Schneidengeometrie. Von YG-1 patentiert.

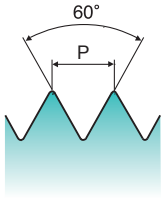


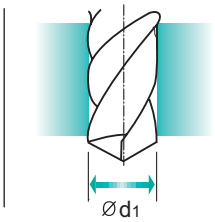




Hole type
3.0×D







Material groups **MU** | HSS-E | DIN 371/374 | 2B | 60° | B | Vap Bright TiN

p.B131

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 -	48 UNF	TB874182	TC874182	TD874182	11	56	18	3.5	2.7	6	3	2.4
#5 -	44 UNF	TB874222	TC874222	TD874222	11	56	18	3.5	2.7	6	3	2.7
#6 -	40 UNF	TB874262	TC874262	TD874262	12	56	20	4	3	6	3	3
#8 -	36 UNF	TB874302	TC874302	TD874302	13	63	21	4.5	3.4	6	3	3.5
#10 -	32 UNF	TB874342	TC874342	TD874342	15	70	25	6	4.9	8	3	4.1
#12 -	28 UNF	TB874382	TC874382	TD874382	16	80	30	6	4.9	8	3	4.7
1/4 -	28 UNF	TB874422	TC874422	TD874422	17	80	30	7	5.5	8	3	5.5
5/16 -	24 UNF	TB874462	TC874462	TD874462	17	90	35	8	6.2	9	3	6.9
3/8 -	24 UNF	TB874502	TC874502	TD874502	18	100	39	9	7	10	3	8.5
7/16 -	20 UNF	TB874542	TC874542	TD874542	22	100	40	8	6.2	9	3	9.9
1/2 -	20 UNF	TB874582	TC874582	TD874582	22	100	40	9	7	10	3	11.5
9/16 -	18 UNF	TB874622	TC874622	TD874622	22	100	40	11	9	12	3	12.9
5/8 -	18 UNF	TB874662	TC874662	TD874662	22	100	40	12	9	12	3	14.5
3/4 -	16 UNF	TB874722	TC874722	TD874722	25	110	44	14	11	14	4	17.5
7/8 -	14 UNF	TB874762	TC874762	TD874762	26	125	50	18	14.5	17	4	20.5
1 -	12 UNF	TB874802	TC874802	TD874802	28	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	400 Rm	1050 Rm	550	630	400	550
Recommended			◎			◎	◎	◎													