COMBO TAP

Vap **TBE06** SERIES
Bright **TCE06** SERIES
TiN **TDE06** SERIES

M ISO Metric coarse threads DIN 13

Metrisches ISO-Gewinde DIN 13
ISO MÉTRIQUE DIN13
ISO Metrico passo grosso DIN 13

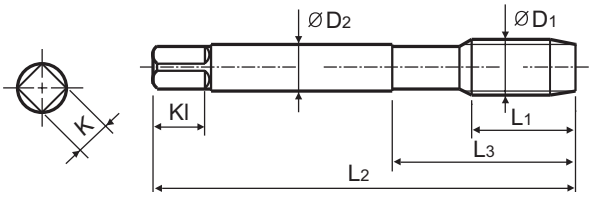
Machine taps
Maschinengewindebohrer

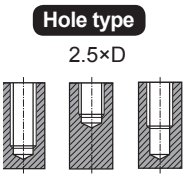
▶ For using multi-purpose and correct thread profiles & long tool life due to special tap geometry. YG-1 company has a patent.

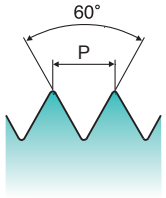
▶ Für vielfältigen Einsatz, genaue Gewindeprofile und lange Standzeitendank einer besonderen Schneidengeometrie. Von YG-1 patentiert.

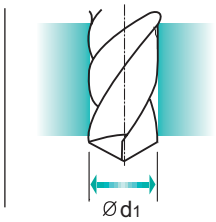












Material groups **MU**

HSS-E | DIN 371/376 | 6H+0.1 | 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	Pitch P	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
M2 ×	0.4	TBE06136	TCE06136	TDE06136	8	45	13	2.8	2.1	5	3	1.7
M2.2 ×	0.45	TBE06156	TCE06156	TDE06156	8	45	13	2.8	2.1	5	3	1.85
M2.3 ×	0.4	TBE06196	TCE06196	TDE06196	8	45	13	2.8	2.1	5	3	2
M2.5 ×	0.45	TBE06176	TCE06176	TDE06176	9	50	15	2.8	2.1	5	3	2.15
M2.6 ×	0.45	TBE06496	TCE06496	TDE06496	9	50	15	2.8	2.1	5	3	2.2
M3 ×	0.5	TBE06206	TCE06206	TDE06206	6	56	18	3.5	2.7	6	3	2.6
M3.5 ×	0.6	TBE06226	TCE06226	TDE06226	7	56	20	4	3	6	3	3
M4 ×	0.7	TBE06246	TCE06246	TDE06246	7	63	21	4.5	3.4	6	3	3.4
M4.5 ×	0.75	TBE06266	TCE06266	TDE06266	8	70	25	6	4.9	8	3	3.8
M5 ×	0.8	TBE06286	TCE06286	TDE06286	8	70	25	6	4.9	8	3	4.3
M6 ×	1.0	TBE06316	TCE06316	TDE06316	10	80	30	6	4.9	8	3	5.1
M7 ×	1.0	TBE06346	TCE06346	TDE06346	10	80	30	7	5.5	8	3	6.1
M8 ×	1.25	TBE06366	TCE06366	TDE06366	13	90	35	8	6.2	9	3	6.9
M9 ×	1.25	TBE06396	TCE06396	TDE06396	13	90	35	9	7	10	3	7.9
M10 ×	1.5	TBE06426	TCE06426	TDE06426	15	100	39	10	8	11	3	8.6
M11 ×	1.5	TBE06466	TCE06466	TDE06466	17	100	40	8	6.2	9	3	9.6
M12 ×	1.75	TBE06506	TCE06506	TDE06506	18	110	44	9	7	10	3	10.3
M14 ×	2.0	TBE06546	TCE06546	TDE06546	20	110	44	11	9	12	3	12.1
M16 ×	2.0	TBE06606	TCE06606	TDE06606	20	110	44	12	9	12	3	14.1
M18 ×	2.5	TBE06656	TCE06656	TDE06656	25	125	50	14	11	14	4	15.6
M20 ×	2.5	TBE06706	TCE06706	TDE06706	25	140	54	16	12	15	4	17.6
M22 ×	2.5	TBE06746	TCE06746	TDE06746	25	140	54	18	14.5	17	4	19.6
M24 ×	3.0	TBE06786	TCE06786	TDE06786	30	160	60	18	14.5	17	4	21.1
M27 ×	3.0	TBE06866	TCE06866	TDE06866	30	160	60	20	16	19	4	24.1
M30 ×	3.5	TBE06946	TCE06946	TDE06946	35	180	70	22	18	21	4	26.6

▶ DIN 371(M2~M10) and DIN 376(M11~M30)
▶ 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			◎			◎	◎	◎													