COMBO TAP

Vap **TBE07 SERIES**
Bright **TCE07 SERIES**
TiN **TDE07 SERIES**

M ISO Metric coarse threads DIN 13

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

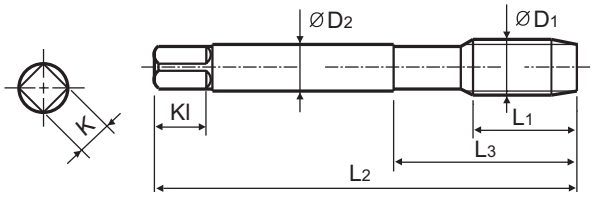
Machine taps
Maschinengewindebohrer

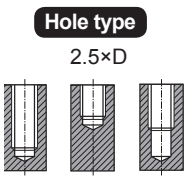
▶ For using multi-purpose and correct thread profiles & long tool life due to special tap geometry. YG-1 company has a patent.

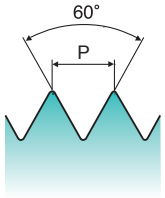
▶ Für vielfältigen Einsatz, genaue Gewindeprofile und lange Standzeitendank einer besonderen Schneidengeometrie. Von YG-1 patentiert.

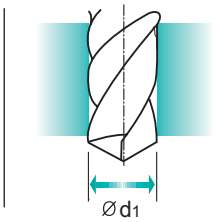












Material groups **MU** | HSS-E | DIN 371/376 | 6G | 60° | C | R40 | Vap Bright TiN

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
M2 ×	0.4	TBE07136	TCE07136	TDE07136	8	45	13	2.8	2.1	5	3	1.6
M2.2 ×	0.45	TBE07156	TCE07156	TDE07156	8	45	13	2.8	2.1	5	3	1.75
M2.3 ×	0.4	TBE07196	TCE07196	TDE07196	8	45	13	2.8	2.1	5	3	1.9
M2.5 ×	0.45	TBE07176	TCE07176	TDE07176	9	50	15	2.8	2.1	5	3	2.05
M2.6 ×	0.45	TBE07496	TCE07496	TDE07496	9	50	15	2.8	2.1	5	3	2.1
M3 ×	0.5	TBE07206	TCE07206	TDE07206	6	56	18	3.5	2.7	6	3	2.5
M3.5 ×	0.6	TBE07226	TCE07226	TDE07226	7	56	20	4	3	6	3	2.9
M4 ×	0.7	TBE07246	TCE07246	TDE07246	7	63	21	4.5	3.4	6	3	3.3
M4.5 ×	0.75	TBE07266	TCE07266	TDE07266	8	70	25	6	4.9	8	3	3.7
M5 ×	0.8	TBE07286	TCE07286	TDE07286	8	70	25	6	4.9	8	3	4.2
M6 ×	1.0	TBE07316	TCE07316	TDE07316	10	80	30	6	4.9	8	3	5
M7 ×	1.0	TBE07346	TCE07346	TDE07346	10	80	30	7	5.5	8	3	6
M8 ×	1.25	TBE07366	TCE07366	TDE07366	13	90	35	8	6.2	9	3	6.8
M9 ×	1.25	TBE07396	TCE07396	TDE07396	13	90	35	9	7	10	3	7.8
M10 ×	1.5	TBE07426	TCE07426	TDE07426	15	100	39	10	8	11	3	8.5
M11 ×	1.5	TBE07466	TCE07466	TDE07466	17	100	40	8	6.2	9	3	9.5
M12 ×	1.75	TBE07506	TCE07506	TDE07506	18	110	44	9	7	10	3	10.2
M14 ×	2.0	TBE07546	TCE07546	TDE07546	20	110	44	11	9	12	3	12
M16 ×	2.0	TBE07606	TCE07606	TDE07606	20	110	44	12	9	12	3	14
M18 ×	2.5	TBE07656	TCE07656	TDE07656	25	125	50	14	11	14	4	15.5
M20 ×	2.5	TBE07706	TCE07706	TDE07706	25	140	54	16	12	15	4	17.5
M22 ×	2.5	TBE07746	TCE07746	TDE07746	25	140	54	18	14.5	17	4	19.5
M24 ×	3.0	TBE07786	TCE07786	TDE07786	30	160	60	18	14.5	17	4	21
M27 ×	3.0	TBE07866	TCE07866	TDE07866	30	160	60	20	16	19	4	24
M30 ×	3.5	TBE07946	TCE07946	TDE07946	35	180	70	22	18	21	4	26.5

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

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