COMBO TAP

Vap **TBE08 SERIES**
Bright **TCE08 SERIES**
TiN **TDE08 SERIES**

M ISO Metric coarse threads DIN 13

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

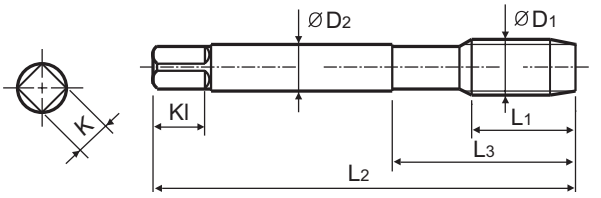
Machine taps
Maschinengewindebohrer

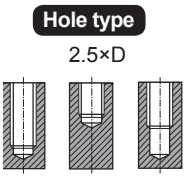
▶ For using multi-purpose and correct thread profiles & long tool life due to special tap geometry. YG-1 company has a patent.

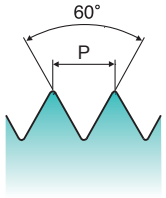
▶ Für vielfältigen Einsatz, genaue Gewindeprofile und lange Standzeitendank einer besonderen Schneidengeometrie. Von YG-1 patentiert.

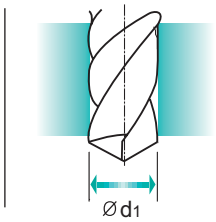












Material groups **MU** | HSS-E | DIN 371/376 | 7G | 60° | C | R40 | Vap Bright TiN

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	TBE08136	TCE08136	TDE08136	8	45	13	2.8	2.1	5	3	1.6
M2.2	0.45	TBE08156	TCE08156	TDE08156	8	45	13	2.8	2.1	5	3	1.75
M2.3	0.4	TBE08196	TCE08196	TDE08196	8	45	13	2.8	2.1	5	3	1.9
M2.5	0.45	TBE08176	TCE08176	TDE08176	9	50	15	2.8	2.1	5	3	2.05
M2.6	0.45	TBE08496	TCE08496	TDE08496	9	50	15	2.8	2.1	5	3	2.1
M3	0.5	TBE08206	TCE08206	TDE08206	6	56	18	3.5	2.7	6	3	2.5
M3.5	0.6	TBE08226	TCE08226	TDE08226	7	56	20	4	3	6	3	2.9
M4	0.7	TBE08246	TCE08246	TDE08246	7	63	21	4.5	3.4	6	3	3.3
M4.5	0.75	TBE08266	TCE08266	TDE08266	8	70	25	6	4.9	8	3	3.7
M5	0.8	TBE08286	TCE08286	TDE08286	8	70	25	6	4.9	8	3	4.2
M6	1.0	TBE08316	TCE08316	TDE08316	10	80	30	6	4.9	8	3	5
M7	1.0	TBE08346	TCE08346	TDE08346	10	80	30	7	5.5	8	3	6
M8	1.25	TBE08366	TCE08366	TDE08366	13	90	35	8	6.2	9	3	6.8
M9	1.25	TBE08396	TCE08396	TDE08396	13	90	35	9	7	10	3	7.8
M10	1.5	TBE08426	TCE08426	TDE08426	15	100	39	10	8	11	3	8.5
M11	1.5	TBE08466	TCE08466	TDE08466	17	100	40	8	6.2	9	3	9.5
M12	1.75	TBE08506	TCE08506	TDE08506	18	110	44	9	7	10	3	10.2
M14	2.0	TBE08546	TCE08546	TDE08546	20	110	44	11	9	12	3	12
M16	2.0	TBE08606	TCE08606	TDE08606	20	110	44	12	9	12	3	14
M18	2.5	TBE08656	TCE08656	TDE08656	25	125	50	14	11	14	4	15.5
M20	2.5	TBE08706	TCE08706	TDE08706	25	140	54	16	12	15	4	17.5
M22	2.5	TBE08746	TCE08746	TDE08746	25	140	54	18	14.5	17	4	19.5
M24	3.0	TBE08786	TCE08786	TDE08786	30	160	60	18	14.5	17	4	21
M27	3.0	TBE08866	TCE08866	TDE08866	30	160	60	20	16	19	4	24
M30	3.5	TBE08946	TCE08946	TDE08946	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	400 Rm	1050 Rm	550	630	400	550
Recommended			◎			◎	◎	◎													