COMBO TAP

Vap **TBJ05 SERIES**
Bright **TCJ05 SERIES**
TiN **TDJ05 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.

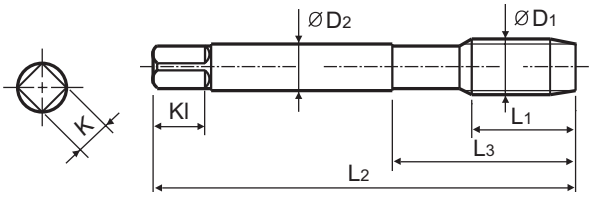
▶ Für vielfältigen Einsatz, genaue Gewindeprofile und lange Standzeitendank einer besonderen Schneidengeometrie. Von YG-1 patentiert.

DIN 371

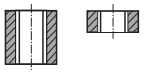


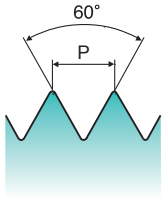
DIN 376

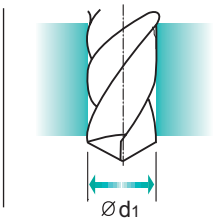




Hole type
3.0×D







Material groups **MU** | HSS-E | DIN 371/376 | 4H | 60° | B | Vap Bright TiN

p.B131

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	TBJ05136	TCJ05136	TDJ05136	8	45	13	2.8	2.1	5	3	1.6
M2.2 ×	0.45	TBJ05156	TCJ05156	TDJ05156	8	45	13	2.8	2.1	5	3	1.75
M2.3 ×	0.4	TBJ05196	TCJ05196	TDJ05196	8	45	13	2.8	2.1	5	3	1.9
M2.5 ×	0.45	TBJ05176	TCJ05176	TDJ05176	9	50	15	2.8	2.1	5	3	2.05
M2.6 ×	0.45	TBJ05496	TCJ05496	TDJ05496	9	50	15	2.8	2.1	5	3	2.1
M3 ×	0.5	TBJ05206	TCJ05206	TDJ05206	11	56	18	3.5	2.7	6	3	2.5
M3.5 ×	0.6	TBJ05226	TCJ05226	TDJ05226	12	56	20	4	3	6	3	2.9
M4 ×	0.7	TBJ05246	TCJ05246	TDJ05246	13	63	21	4.5	3.4	6	3	3.3
M4.5 ×	0.75	TBJ05266	TCJ05266	TDJ05266	14	70	25	6	4.9	8	3	3.7
M5 ×	0.8	TBJ05286	TCJ05286	TDJ05286	15	70	25	6	4.9	8	3	4.2
M6 ×	1.0	TBJ05316	TCJ05316	TDJ05316	17	80	30	6	4.9	8	3	5
M7 ×	1.0	TBJ05346	TCJ05346	TDJ05346	17	80	30	7	5.5	8	3	6
M8 ×	1.25	TBJ05366	TCJ05366	TDJ05366	20	90	35	8	6.2	9	3	6.8
M9 ×	1.25	TBJ05396	TCJ05396	TDJ05396	20	90	35	9	7	10	3	7.8
M10 ×	1.5	TBJ05426	TCJ05426	TDJ05426	22	100	39	10	8	11	3	8.5
M11 ×	1.5	TBJ05466	TCJ05466	TDJ05466	22	100	40	8	6.2	9	3	9.5
M12 ×	1.75	TBJ05506	TCJ05506	TDJ05506	24	110	44	9	7	10	3	10.2
M14 ×	2.0	TBJ05546	TCJ05546	TDJ05546	26	110	44	11	9	12	3	12
M16 ×	2.0	TBJ05606	TCJ05606	TDJ05606	27	110	44	12	9	12	3	14
M18 ×	2.5	TBJ05656	TCJ05656	TDJ05656	30	125	50	14	11	14	4	15.5
M20 ×	2.5	TBJ05706	TCJ05706	TDJ05706	32	140	54	16	12	15	4	17.5
M22 ×	2.5	TBJ05746	TCJ05746	TDJ05746	32	140	54	18	14.5	17	4	19.5
M24 ×	3.0	TBJ05786	TCJ05786	TDJ05786	34	160	60	18	14.5	17	4	21
M27 ×	3.0	TBJ05866	TCJ05866	TDJ05866	36	160	60	20	16	19	4	24
M30 ×	3.5	TBJ05946	TCJ05946	TDJ05946	40	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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