COMBO TAP

Vap **TBJ07 SERIES**
Bright **TCJ07 SERIES**
TiN **TDJ07 SERIES**

M ISO Metric coarse threads DIN 13

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

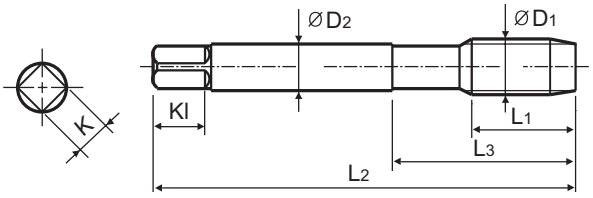
Machine taps
Maschinengewindebohrer

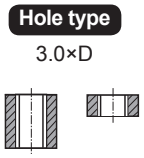
▶ For using multi-purpose and correct thread profiles & long tool life due to special tap geometry. YG-1 company has a patent.

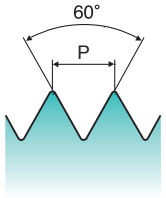
▶ Für vielfältigen Einsatz, genaue Gewindeprofile und lange Standzeitendank einer besonderen Schneidengeometrie. Von YG-1 patentiert.

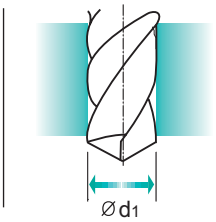












Material groups **MU** | HSS-E | DIN 371/376 | 6G | 60° | B | Vap Bright TiN

p.B131

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	TBJ07136	TCJ07136	TDJ07136	8	45	13	2.8	2.1	5	3	1.6
M2.2	0.45	TBJ07156	TCJ07156	TDJ07156	8	45	13	2.8	2.1	5	3	1.75
M2.3	0.4	TBJ07196	TCJ07196	TDJ07196	8	45	13	2.8	2.1	5	3	1.9
M2.5	0.45	TBJ07176	TCJ07176	TDJ07176	9	50	15	2.8	2.1	5	3	2.05
M2.6	0.45	TBJ07496	TCJ07496	TDJ07496	9	50	15	2.8	2.1	5	3	2.1
M3	0.5	TBJ07206	TCJ07206	TDJ07206	11	56	18	3.5	2.7	6	3	2.5
M3.5	0.6	TBJ07226	TCJ07226	TDJ07226	12	56	20	4	3	6	3	2.9
M4	0.7	TBJ07246	TCJ07246	TDJ07246	13	63	21	4.5	3.4	6	3	3.3
M4.5	0.75	TBJ07266	TCJ07266	TDJ07266	14	70	25	6	4.9	8	3	3.7
M5	0.8	TBJ07286	TCJ07286	TDJ07286	15	70	25	6	4.9	8	3	4.2
M6	1.0	TBJ07316	TCJ07316	TDJ07316	17	80	30	6	4.9	8	3	5
M7	1.0	TBJ07346	TCJ07346	TDJ07346	17	80	30	7	5.5	8	3	6
M8	1.25	TBJ07366	TCJ07366	TDJ07366	20	90	35	8	6.2	9	3	6.8
M9	1.25	TBJ07396	TCJ07396	TDJ07396	20	90	35	9	7	10	3	7.8
M10	1.5	TBJ07426	TCJ07426	TDJ07426	22	100	39	10	8	11	3	8.5
M11	1.5	TBJ07466	TCJ07466	TDJ07466	22	100	40	8	6.2	9	3	9.5
M12	1.75	TBJ07506	TCJ07506	TDJ07506	24	110	44	9	7	10	3	10.2
M14	2.0	TBJ07546	TCJ07546	TDJ07546	26	110	44	11	9	12	3	12
M16	2.0	TBJ07606	TCJ07606	TDJ07606	27	110	44	12	9	12	3	14
M18	2.5	TBJ07656	TCJ07656	TDJ07656	30	125	50	14	11	14	4	15.5
M20	2.5	TBJ07706	TCJ07706	TDJ07706	32	140	54	16	12	15	4	17.5
M22	2.5	TBJ07746	TCJ07746	TDJ07746	32	140	54	18	14.5	17	4	19.5
M24	3.0	TBJ07786	TCJ07786	TDJ07786	34	160	60	18	14.5	17	4	21
M27	3.0	TBJ07866	TCJ07866	TDJ07866	36	160	60	20	16	19	4	24
M30	3.5	TBJ07946	TCJ07946	TDJ07946	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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