COMBO TAP

Vap **TBJ08 SERIES**
Bright **TCJ08 SERIES**
TiN **TDJ08 SERIES**

M ISO Metric coarse threads DIN 13

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

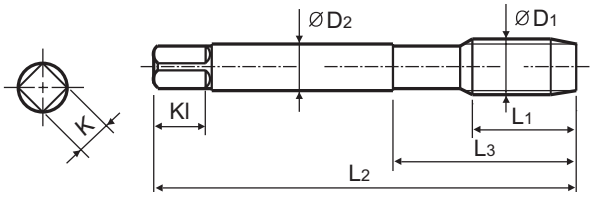
Machine taps
Maschinengewindebohrer

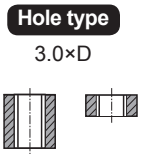
▶ For using multi-purpose and correct thread profiles & long tool life due to special tap geometry. YG-1 company has a patent.

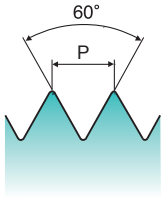
▶ Für vielfältigen Einsatz, genaue Gewindeprofile und lange Standzeitendank einer besonderen Schneidengeometrie. Von YG-1 patentiert.

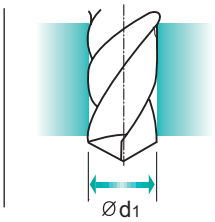












Material groups **MU** | HSS-E | DIN 371/376 | 7G | 60° | B | Vap Bright TiN

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	TBJ08136	TCJ08136	TDJ08136	8	45	13	2.8	2.1	5	3	1.6
M2.2	0.45	TBJ08156	TCJ08156	TDJ08156	8	45	13	2.8	2.1	5	3	1.75
M2.3	0.4	TBJ08196	TCJ08196	TDJ08196	8	45	13	2.8	2.1	5	3	1.9
M2.5	0.45	TBJ08176	TCJ08176	TDJ08176	9	50	15	2.8	2.1	5	3	2.05
M2.6	0.45	TBJ08496	TCJ08496	TDJ08496	9	50	15	2.8	2.1	5	3	2.1
M3	0.5	TBJ08206	TCJ08206	TDJ08206	11	56	18	3.5	2.7	6	3	2.5
M3.5	0.6	TBJ08226	TCJ08226	TDJ08226	12	56	20	4	3	6	3	2.9
M4	0.7	TBJ08246	TCJ08246	TDJ08246	13	63	21	4.5	3.4	6	3	3.3
M4.5	0.75	TBJ08266	TCJ08266	TDJ08266	14	70	25	6	4.9	8	3	3.7
M5	0.8	TBJ08286	TCJ08286	TDJ08286	15	70	25	6	4.9	8	3	4.2
M6	1.0	TBJ08316	TCJ08316	TDJ08316	17	80	30	6	4.9	8	3	5
M7	1.0	TBJ08346	TCJ08346	TDJ08346	17	80	30	7	5.5	8	3	6
M8	1.25	TBJ08366	TCJ08366	TDJ08366	20	90	35	8	6.2	9	3	6.8
M9	1.25	TBJ08396	TCJ08396	TDJ08396	20	90	35	9	7	10	3	7.8
M10	1.5	TBJ08426	TCJ08426	TDJ08426	22	100	39	10	8	11	3	8.5
M11	1.5	TBJ08466	TCJ08466	TDJ08466	22	100	40	8	6.2	9	3	9.5
M12	1.75	TBJ08506	TCJ08506	TDJ08506	24	110	44	9	7	10	3	10.2
M14	2.0	TBJ08546	TCJ08546	TDJ08546	26	110	44	11	9	12	3	12
M16	2.0	TBJ08606	TCJ08606	TDJ08606	27	110	44	12	9	12	3	14
M18	2.5	TBJ08656	TCJ08656	TDJ08656	30	125	50	14	11	14	4	15.5
M20	2.5	TBJ08706	TCJ08706	TDJ08706	32	140	54	16	12	15	4	17.5
M22	2.5	TBJ08746	TCJ08746	TDJ08746	32	140	54	18	14.5	17	4	19.5
M24	3.0	TBJ08786	TCJ08786	TDJ08786	34	160	60	18	14.5	17	4	21
M27	3.0	TBJ08866	TCJ08866	TDJ08866	36	160	60	20	16	19	4	24
M30	3.5	TBJ08946	TCJ08946	TDJ08946	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	400 Rm	1050 Rm	550	630	400	550
Recommended			◎			◎	◎	◎													