YG TAP GENERAL

TC222 SERIES

MF ISO metric fine threads DIN 13

Metrisches ISO-Feingewinde DIN 13
ISO MÉTRIQUE PAS FINS DIN13
ISO Metrico passo fine DIN 13

Machine taps
Maschinengewindebohrer

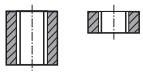
▶ Suitable for through hole in more cutting speed than other taps due to thick web.

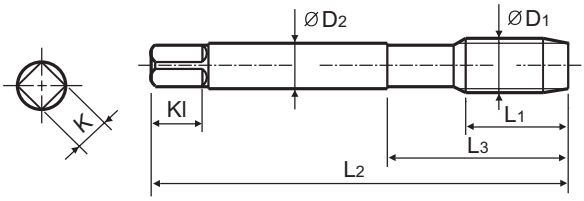
▶ Geeignet für Durchgangslöcher in höherer Schnittgeschwindigkeit als bei anderen Gewindebohrern dank größerer Kerndicke.

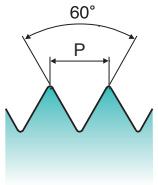
DIN 374

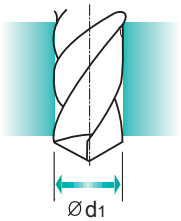


Hole type
3.0×D









Material groups GS | HSS-E | DIN 374 | 6H | 60° | B | Bright



p.B309

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	Bright	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M4	× 0.5	TC222256	10	63	21	2.8	2.1	5	3	3.5
M5	× 0.5	TC222296	11	70	25	3.5	2.7	6	3	4.5
M6	× 0.75	TC222326	13	80	30	4.5	3.4	6	3	5.2
M6	× 0.5	TC222336	13	80	30	4.5	3.4	6	3	5.5
M7	× 0.75	TC222356	14	80	30	5.5	4.3	7	3	6.2
M8	× 1.0	TC222376	17	90	36	6	4.9	8	3	7
M8	× 0.75	TC222386	14	80	30	6	4.9	8	3	7.2
M8	× 0.5	TC222936	14	80	30	6	4.9	8	3	7.5
M10	× 1.25	TC222436	22	100	40	7	5.5	8	3	8.8
M10	× 1.0	TC222446	18	90	36	7	5.5	8	3	9
M10	× 0.75	TC222456	18	90	36	7	5.5	8	3	9.2
M12	× 1.5	TC222516	22	100	40	9	7	10	3	10.5
M12	× 1.25	TC222526	22	100	40	9	7	10	3	10.8
M12	× 1.0	TC222536	18	100	40	9	7	10	3	11
M14	× 1.5	TC222556	22	100	40	11	9	12	3	12.5
M14	× 1.25	TC222566	22	100	40	11	9	12	3	12.8
M14	× 1.0	TC222576	18	100	40	11	9	12	3	13

▶ NEXT PAGE

◎ : 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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YG-1 CO., LTD.

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ISO MÉTRIQUE PAS FINS DIN13
ISO Metrico passo fine DIN 13

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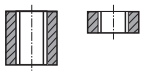

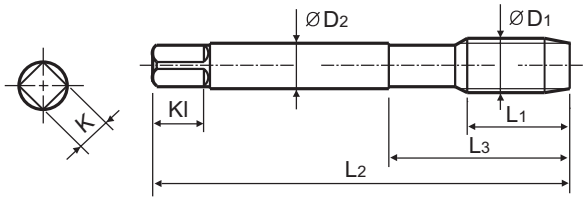

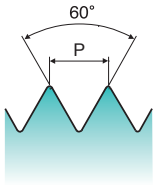

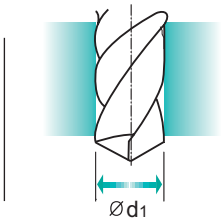

Material groups **GS** | HSS-E | DIN 374 | 6H | 60° | B | Bright

p.B309

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	Bright	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M16	× 1.5	TC222616	22	100	40	12	9	12	3	14.5
M16	× 1.0	TC222626	18	100	40	12	9	12	3	15
M18	× 1.5	TC222676	25	110	44	14	11	14	4	16.5
M18	× 1.0	TC222686	20	110	44	14	11	14	4	17
M20	× 1.5	TC222726	25	125	50	16	12	15	4	18.5
M20	× 1.0	TC222736	20	125	50	16	12	15	4	19
M22	× 1.5	TC222766	25	125	50	18	14.5	17	4	20.5
M22	× 1.0	TC222776	20	125	50	18	14.5	17	4	21
M24	× 2.0	TC222796	27	140	54	18	14.5	17	4	22
M24	× 1.5	TC222806	27	140	54	18	14.5	17	4	22.5
M26	× 1.5	TC222856	28	140	54	18	14.5	17	4	24.5
M27	× 2.0	TC222876	28	140	54	20	16	19	4	25
M27	× 1.5	TC222886	28	140	54	20	16	19	4	25.5
M28	× 1.5	TC222916	28	140	54	20	16	19	4	26.5
M30	× 2.0	TC222966	30	150	57	22	18	21	4	28
M30	× 1.5	TC222976	30	150	57	22	18	21	4	28.5

◎ : Excellent ○ : Good

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HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	○	◎	◎	◎	○	◎	◎	○				○	○				◎	◎		

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HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○		○	○	◎	○		◎													