COMBO TAP

TC633 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

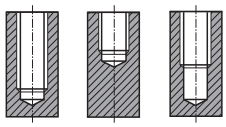
▶ For using multi-purpose and correct thread profiles & long tool life due to special tap geometry. YG-1 company has a patent.

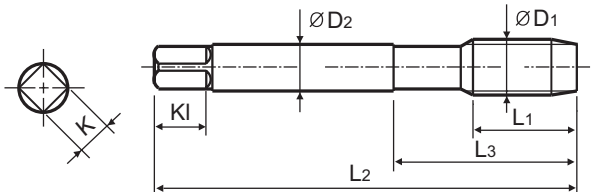
▶ Für vielfältigen Einsatz, genaue Gewindeprofile und lange Standzeitendank einer besonderen Schneidengeometrie. Von YG-1 patentiert.

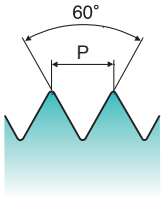


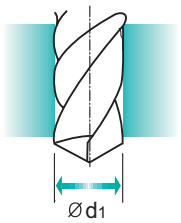
Long Shank

Hole type
2.5×D









Material groups **MU** | HSS-E | LONG | 6H | 60° | C | R40 | Bright

p.B130

Recommended ToolHolder: Plain Shank; TAPPING ER CHUCK; TAPPING CHUCK; ONE STEP TAPPING CHUCK

Unit : mm

SIZE ØD1	Pitch P	EDP No. Bright	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
M3	0.5	TC633206	11	100	18	3.5	2.7	6	3	2.5
M4	0.7	TC633246	13	125	21	4.5	3.4	6	3	3.3
M5	0.8	TC633286	15	140	25	6	4.9	8	3	4.2
M6	1.0	TC633316	17	160	30	6	4.9	8	3	5
M8	1.25	TC633366	20	180	35	6	4.9	8	3	6.8
M10	1.5	TC633426	22	200	39	7	5.5	8	3	8.5
M12	1.75	TC633506	24	220	44	9	7	10	3	10.2
M14	2.0	TC633546	26	220	44	11	9	12	3	12
M16	2.0	TC633606	27	220	44	12	9	12	3	14
M20	2.5	TC633706	32	280	54	16	12	15	4	17.5

▶ Coating(TiN, TiCN or TiAlN) or Surface Treatment(Steam Homo) 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			◎			◎	◎	◎													