COMBO TAP

Vap **TB804 SERIES**
Bright **TC804 SERIES**
TiN **TD804 SERIES**

M ISO Metric coarse threads DIN 13

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

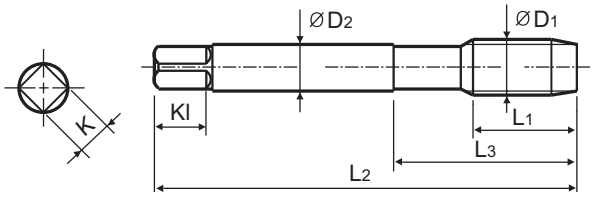
Machine taps
Maschinengewindebohrer

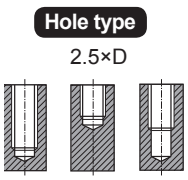
▶ For using multi-purpose and correct thread profiles & long tool life due to special tap geometry. YG-1 company has a patent.

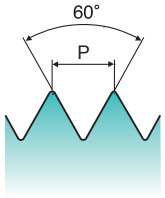
▶ Für vielfältigen Einsatz, genaue Gewindeprofile und lange Standzeitendank einer besonderen Schneidengeometrie. Von YG-1 patentiert.

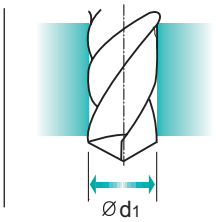












Material groups **MU** | HSS-E | DIN 371/376 | 6H | 60° | C | R40 | Vap Bright TiN

p.B130

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	TB804136	TC804136	TD804136	8	45	13	2.8	2.1	5	3	1.6
M2.2 ×	0.45	TB804156	TC804156	TD804156	8	45	13	2.8	2.1	5	3	1.75
M2.3 ×	0.4	TB804196	TC804196	TD804196	8	45	13	2.8	2.1	5	3	1.9
M2.5 ×	0.45	TB804176	TC804176	TD804176	9	50	15	2.8	2.1	5	3	2.05
M2.6 ×	0.45	TB804496	TC804496	TD804496	9	50	15	2.8	2.1	5	3	2.1
M3 ×	0.5	TB804206	TC804206	TD804206	6	56	18	3.5	2.7	6	3	2.5
M3.5 ×	0.6	TB804226	TC804226	TD804226	7	56	20	4	3	6	3	2.9
M4 ×	0.7	TB804246	TC804246	TD804246	7	63	21	4.5	3.4	6	3	3.3
M4.5 ×	0.75	TB804266	TC804266	TD804266	8	70	25	6	4.9	8	3	3.7
M5 ×	0.8	TB804286	TC804286	TD804286	8	70	25	6	4.9	8	3	4.2
M6 ×	1.0	TB804316	TC804316	TD804316	10	80	30	6	4.9	8	3	5
M7 ×	1.0	TB804346	TC804346	TD804346	10	80	30	7	5.5	8	3	6
M8 ×	1.25	TB804366	TC804366	TD804366	13	90	35	8	6.2	9	3	6.8
M9 ×	1.25	TB804396	TC804396	TD804396	13	90	35	9	7	10	3	7.8
M10 ×	1.5	TB804426	TC804426	TD804426	15	100	39	10	8	11	3	8.5
M11 ×	1.5	TB804466	TC804466	TD804466	17	100	40	8	6.2	9	3	9.5
M12 ×	1.75	TB804506	TC804506	TD804506	18	110	44	9	7	10	3	10.2
M14 ×	2.0	TB804546	TC804546	TD804546	20	110	44	11	9	12	3	12
M16 ×	2.0	TB804606	TC804606	TD804606	20	110	44	12	9	12	3	14
M18 ×	2.5	TB804656	TC804656	TD804656	25	125	50	14	11	14	4	15.5
M20 ×	2.5	TB804706	TC804706	TD804706	25	140	54	16	12	15	4	17.5
M22 ×	2.5	TB804746	TC804746	TD804746	25	140	54	18	14.5	17	4	19.5

▶ DIN 371(M2~M10) and DIN 376(M11~M52)
▶ The other coating(TiCN or TiAlN) is available on your request.

▶ 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			◎			◎	◎	◎													

phone:+82-32-526-0909, www.yg1.solutions, E-mail:yg1@yg1.solutions
YG-1 CO., LTD.

COMBO TAP

Vap **TB804 SERIES**
Bright **TC804 SERIES**
TiN **TD804 SERIES**

M ISO Metric coarse threads DIN 13

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

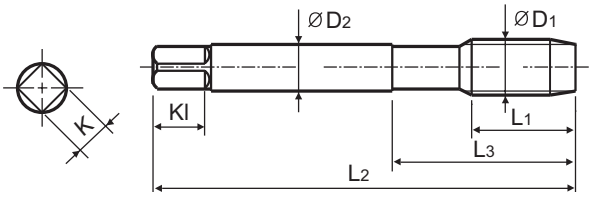
Machine taps
Maschinengewindebohrer

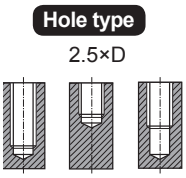
▶ For using multi-purpose and correct thread profiles & long tool life due to special tap geometry. YG-1 company has a patent.

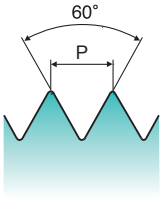
▶ Für vielfältigen Einsatz, genaue Gewindeprofile und lange Standzeitendank einer besonderen Schneidengeometrie. Von YG-1 patentiert.

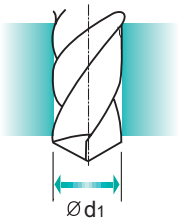












Material groups **MU** | HSS-E | DIN 371/376 | 6H | 60° | C | R40 | Vap Bright TiN

p.B130

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
M24 ×	3.0	TB804786	TC804786	TD804786	30	160	60	18	14.5	17	4	21
M27 ×	3.0	TB804866	TC804866	TD804866	30	160	60	20	16	19	4	24
M30 ×	3.5	TB804946	TC804946	TD804946	35	180	70	22	18	21	4	26.5
M33 x	3.5	-	TC804A46	TD804A46	35	180	70	25	20	23	4	29.5
M36 x	4.0	-	TC804B36	TD804B36	40	200	80	28	22	25	4	32.0
M39 x	4.0	-	TC804C06	TD804C06	40	200	80	32	24	27	4	35.0
M42 x	4.5	-	TC804C86	TD804C86	45	200	85	32	24	27	4	37.5
M45 x	4.5	-	TC804D56	TD804D56	45	220	85	36	29	32	4	40.5
M48 x	5.0	-	TC804E26	TD804E26	50	250	90	36	29	32	4	43.0
M52 x	5.0	-	TC804F36	TD804F36	50	250	90	40	32	35	4	47.0

▶ DIN 371(M2~M10) and DIN 376(M11~M52)
▶ 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			◎			◎	◎	◎													

COMBO TAP

TC804-IC SERIES

M ISO Metric coarse threads DIN 13

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

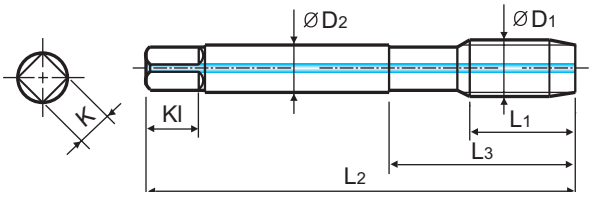
Machine taps
Maschinengewindebohrer

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

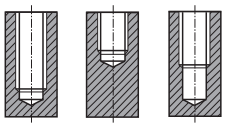
▶ Für vielfältigen Einsatz, genaue Gewindeprofile und lange Standzeitendank einer besonderen Schneidengeometrie. Von YG-1 patentiert.

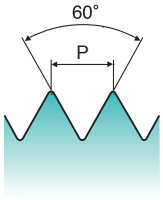


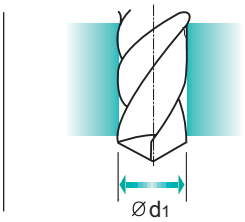
with Internal Coolant



Hole type
2.5×D







Material groups **MU** | HSS-E | DIN 371/376 | 6H | 60° | C | R40 | Bright

p.B130

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
M6 ×	1.0	TC804316IC	10	80	30	6	4.9	8	3	5
M8 ×	1.25	TC804366IC	13	90	35	8	6.2	9	3	6.8
M10 ×	1.5	TC804426IC	15	100	39	10	8	11	3	8.5
M12 ×	1.75	TC804506IC	18	110	44	9	7	10	3	10.2
M14 ×	2.0	TC804546IC	20	110	44	11	9	12	3	12
M16 ×	2.0	TC804606IC	20	110	44	12	9	12	3	14
M18 ×	2.5	TC804656IC	25	125	50	14	11	14	4	15.5
M20 ×	2.5	TC804706IC	25	140	54	16	12	15	4	17.5

▶ DIN 371(M6~M10) and DIN 376(M12~M20)
▶ 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			◎			◎	◎	◎													