COMBO TAP

Bright **TCE02** SERIES
TiN **TDE02** SERIES

UNF — Unified fine threads

- Unified Feingewinde
- UNF
- Unificato passo fine

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.

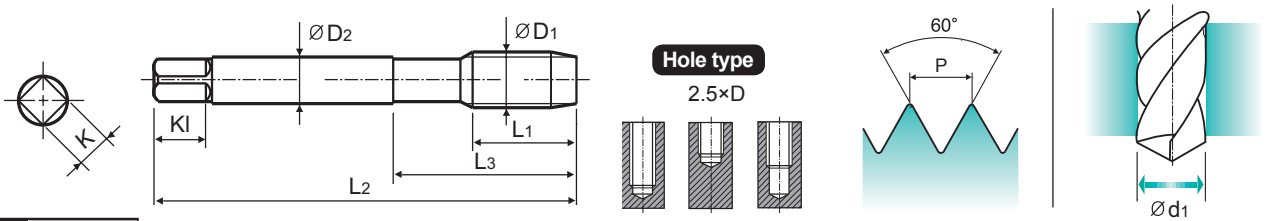
▶ Für vielfältigen Einsatz, genaue Gewindeprofile und lange Standzeitendank einer besonderen Schneidengeometrie. Von YG-1 patentiert.

DIN 371



DIN 374





Material groups **MU** | HSS-E | DIN 371/374 | 3B | 60° | C | R40 | TiN | Bright

p.B130

Recommended ToolHolder: Plain Shank — TAPPING ER CHUCK / TAPPING CHUCK / ONE STEP TAPPING CHUCK

Unit : mm

SIZE ØD1	TPI	EDP No. Bright	EDP No. 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
#4	48UNF	TCE02182	TDE02182	6	56	18	3.5	2.7	6	3	2.4
#5	44UNF	TCE02222	TDE02222	7	56	18	3.5	2.7	6	3	2.7
#6	40UNF	TCE02262	TDE02262	7	56	20	4	3	6	3	3
#8	36UNF	TCE02302	TDE02302	8	63	21	4.5	3.4	6	3	3.5
#10	32UNF	TCE02342	TDE02342	10	70	25	6	4.9	8	3	4.1
#12	28UNF	TCE02382	TDE02382	10	80	30	6	4.9	8	3	4.7
1/4	28UNF	TCE02422	TDE02422	10	80	30	7	5.5	8	3	5.5
5/16	24UNF	TCE02462	TDE02462	10	90	35	8	6.2	9	3	6.9
3/8	24UNF	TCE02502	TDE02502	10	100	39	9	7	10	3	8.5
7/16	20UNF	TCE02542	TDE02542	13	100	40	8	6.2	9	3	9.9
1/2	20UNF	TCE02582	TDE02582	13	100	40	9	7	10	3	11.5
9/16	18UNF	TCE02622	TDE02622	15	100	40	11	9	12	3	12.9
5/8	18UNF	TCE02662	TDE02662	15	100	40	12	9	12	3	14.5
3/4	16UNF	TCE02722	TDE02722	17	110	44	14	11	14	4	17.5
7/8	14UNF	TCE02762	TDE02762	17	125	50	18	14.5	17	4	20.5
1	12UNF	TCE02802	TDE02802	20	140	54	20	16	19	4	23.25

▶ DIN 371(#4~3/8) and DIN 374(7/16~1)
▶ The other coating(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			◎			◎	◎	◎													