COMBO TAP

Bright **TCJ09 SERIES**
TiN **TDJ09 SERIES**

MF ISO Metric fine threads DIN 13

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

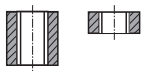
Machine taps
Maschinengewindebohrer

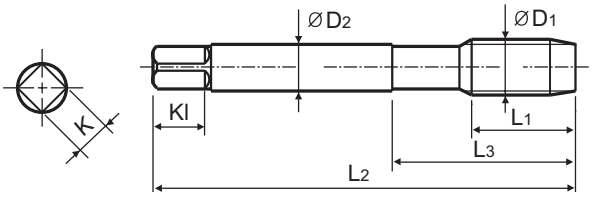
▶ For using multi-purpose and correct thread profiles & long tool life due to special tap geometry. YG-1 company has a patent.

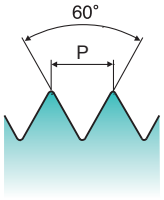
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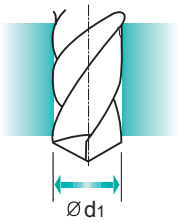


Hole type
3.0×D









Material groups **MU** | HSS-E | DIN 374 | 6G | 60° | B | TiN | Bright

p.B131

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

Unit : mm

SIZE ØD1		Pitch P	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
M4	×	0.5	TCJ09256	TDJ09256	10	63	21	2.8	2.1	5	3	3.5
M5	×	0.5	TCJ09296	TDJ09296	11	70	25	3.5	2.7	6	3	4.5
M6	×	0.75	TCJ09326	TDJ09326	13	80	30	4.5	3.4	6	3	5.2
M6	×	0.5	TCJ09336	TDJ09336	13	80	30	4.5	3.4	6	3	5.5
M7	×	0.75	TCJ09356	TDJ09356	14	80	30	5.5	4.3	7	3	6.2
M8	×	1.0	TCJ09376	TDJ09376	17	90	36	6	4.9	8	3	7
M8	×	0.75	TCJ09386	TDJ09386	14	80	30	6	4.9	8	3	7.2
M10	×	1.25	TCJ09436	TDJ09436	22	100	40	7	5.5	8	3	8.8
M10	×	1.0	TCJ09446	TDJ09446	18	90	36	7	5.5	8	3	9
M10	×	0.75	TCJ09456	TDJ09456	18	90	36	7	5.5	8	3	9.2
M12	×	1.5	TCJ09516	TDJ09516	22	100	40	9	7	10	3	10.5
M12	×	1.25	TCJ09526	TDJ09526	22	100	40	9	7	10	3	10.8
M12	×	1.0	TCJ09536	TDJ09536	18	100	40	9	7	10	3	11
M14	×	1.5	TCJ09556	TDJ09556	22	100	40	11	9	12	3	12.5
M14	×	1.25	TCJ09566	TDJ09566	22	100	40	11	9	12	3	12.8
M14	×	1.0	TCJ09576	TDJ09576	22	100	40	11	9	12	3	13
M16	×	1.5	TCJ09616	TDJ09616	22	100	40	12	9	12	3	14.5
M16	×	1.0	TCJ09626	TDJ09626	18	100	40	12	9	12	3	15
M18	×	1.5	TCJ09676	TDJ09676	25	110	44	14	11	14	4	16.5
M18	×	1.0	TCJ09686	TDJ09686	20	110	44	14	11	14	4	17
M20	×	1.5	TCJ09726	TDJ09726	25	125	50	16	12	15	4	18.5
M20	×	1.0	TCJ09736	TDJ09736	20	125	50	16	12	15	4	19

▶ The other coating(TiCN or TiAlN) or Surface Treatment(Steam Homo) 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	400 Rm	1050 Rm	550	630	400	550
Recommended			◎			◎	◎	◎													

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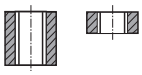
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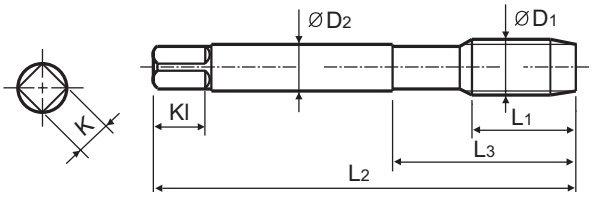
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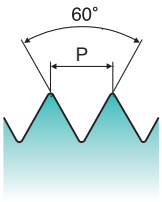
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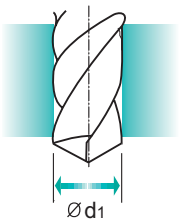


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Unit : mm

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	TiN	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M22 ×	1.5	TCJ09766	TDJ09766	25	125	50	18	14.5	17	4	20.5
M22 ×	1.0	TCJ09776	TDJ09776	20	125	50	18	14.5	17	4	21
M24 ×	2.0	TCJ09796	TDJ09796	27	140	54	18	14.5	17	4	22
M24 ×	1.5	TCJ09806	TDJ09806	27	140	54	18	14.5	17	4	22.5
M26 ×	1.5	TCJ09856	TDJ09856	28	140	54	18	14.5	17	4	24.5
M27 ×	2.0	TCJ09876	TDJ09876	28	140	54	20	16	19	4	25
M27 ×	1.5	TCJ09886	TDJ09886	28	140	54	20	16	19	4	25.5
M28 ×	1.5	TCJ09916	TDJ09916	28	140	54	20	16	19	4	26.5
M30 ×	2.0	TCJ09966	TDJ09966	30	150	57	22	18	21	4	28
M30 ×	1.5	TCJ09976	TDJ09976	30	150	57	22	18	21	4	28.5

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Recommended	○	◎	◎	◎	◎	◎	◎	◎	◎	○		◎	◎	◎	◎	◎	◎	◎		

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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.