YG TAP GENERAL

TD411 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

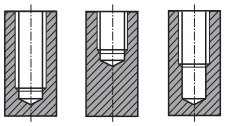
▶ Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

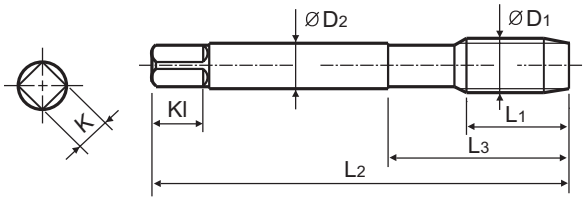
▶ Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

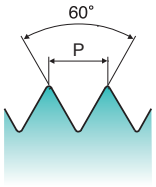
DIN 374

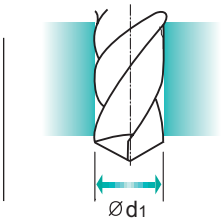


Hole type
2.5×D









Material groups GS | HSS-E | DIN 374 | 6H | 60° | C | R40 | TiN



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	TiN	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M4	× 0.5	TD411256	5	63	21	2.8	2.1	5	3	3.5
M5	× 0.5	TD411296	5	70	25	3.5	2.7	6	3	4.5
M6	× 0.75	TD411326	8	80	30	4.5	3.4	6	3	5.2
M6	× 0.5	TD411336	5	80	30	4.5	3.4	6	3	5.5
M7	× 0.75	TD411356	10	80	30	5.5	4.3	7	3	6.2
M8	× 1.0	TD411376	10	90	36	6	4.9	8	3	7
M8	× 0.75	TD411386	8	80	30	6	4.9	8	3	7.2
M8	× 0.5	TD411936	5	80	30	6	4.9	8	3	7.5
M10	× 1.25	TD411436	16	100	40	7	5.5	8	3	8.8
M10	× 1.0	TD411446	10	90	36	7	5.5	8	3	9
M10	× 0.75	TD411456	10	90	36	7	5.5	8	3	9.2
M12	× 1.5	TD411516	15	100	40	9	7	10	3	10.5
M12	× 1.25	TD411526	15	100	40	9	7	10	3	10.8
M12	× 1.0	TD411536	11	100	40	9	7	10	3	11
M14	× 1.5	TD411556	15	100	40	11	9	12	3	12.5
M14	× 1.25	TD411566	15	100	40	11	9	12	3	12.8
M14	× 1.0	TD411576	11	100	40	11	9	12	3	13
M16	× 1.5	TD411616	15	100	40	12	9	12	3	14.5

▶ 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.

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

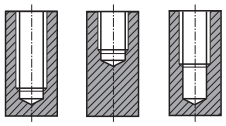
▶ Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

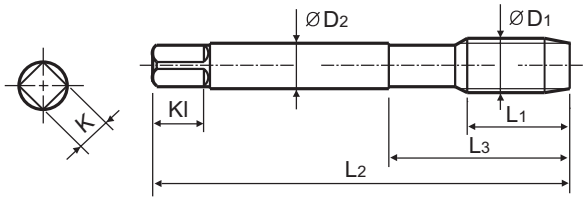
▶ Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

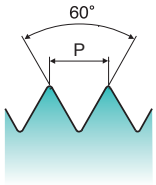
DIN 374

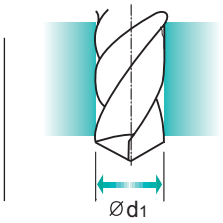


Hole type
2.5×D









Material groups **GS** | HSS-E | DIN 374 | 6H | 60° | C | R40 | TiN

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	TiN	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M16	× 1.0	TD411626	12	100	40	12	9	12	3	15
M18	× 1.5	TD411676	17	110	44	14	11	14	4	16.5
M18	× 1.0	TD411686	13	110	44	14	11	14	4	17
M20	× 1.5	TD411726	17	125	50	16	12	15	4	18.5
M20	× 1.0	TD411736	14	125	50	16	12	15	4	19
M22	× 1.5	TD411766	17	125	50	18	14.5	17	4	20.5
M22	× 1.0	TD411776	14	125	50	18	14.5	17	4	21
M24	× 2.0	TD411796	20	140	54	18	14.5	17	4	22
M24	× 1.5	TD411806	20	140	54	18	14.5	17	4	22.5
M26	× 1.5	TD411856	20	140	54	18	14.5	17	4	24.5
M27	× 2.0	TD411876	20	140	54	20	16	19	4	25
M27	× 1.5	TD411886	20	140	54	20	16	19	4	25.5
M28	× 1.5	TD411916	20	140	54	20	16	19	4	26.5
M30	× 2.0	TD411966	22	150	57	22	18	21	4	28
M30	× 1.5	TD411976	22	150	57	22	18	21	4	28.5

◎ : 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	○		○	○	◎	○		◎													