# YG TAP CHIP BREAKER

**TDE27 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

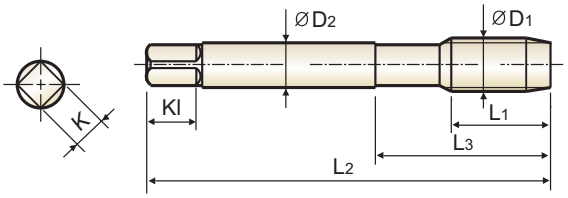
- Solving the productivity problem caused by long chips.
- Particularly suitable for machining non-alloy steel, low alloy steel, high alloy steel, and tool steel

- Lösung des durch lange Späne verursachten Produktivitätsproblems
- Besonders geeignet für die Bearbeitung von unlegiertem Stahl, niedriglegiertem Stahl, hochlegiertem Stahl und Werkzeugstahl

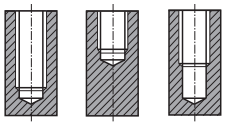
DIN 374

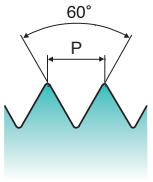


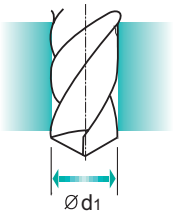
**Short Chamfer**




**Hole type**
2.0×D






HSS-E | DIN 374 | 6H | 60° | E | R15° | TiN

p.B169

Recommended ToolHolder: Plain Shank, SYNCHRO 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 |
| M8 | × 1.0 | TDE27376R | 10 | 90 | 36 | 6 | 4.9 | 8 | 3 | 7.0 |
| M10 | × 1.25 | TDE27436R | 16 | 100 | 40 | 7 | 5.5 | 8 | 3 | 8.8 |
| M10 | × 1.0 | TDE27446R | 10 | 90 | 36 | 7 | 5.5 | 8 | 3 | 9.0 |
| M12 | × 1.5 | TDE27516R | 15 | 100 | 40 | 9 | 7.0 | 10 | 3 | 10.5 |
| M12 | × 1.25 | TDE27526R | 15 | 100 | 40 | 9 | 7.0 | 10 | 3 | 10.8 |
| M14 | × 1.5 | TDE27556R | 15 | 100 | 40 | 11 | 9.0 | 12 | 3 | 12.5 |
| M16 | × 1.5 | TDE27616R | 15 | 100 | 40 | 12 | 9.0 | 12 | 3 | 14.5 |
| M18 | × 1.5 | TDE27676R | 17 | 110 | 44 | 14 | 11.0 | 14 | 4 | 16.5 |
| M20 | × 1.5 | TDE27726R | 17 | 125 | 50 | 16 | 12.0 | 15 | 4 | 18.5 |

◎ : 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 | | | | | | | | | | | | | | | | | | | | | |


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