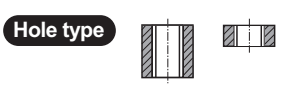


UNF Unified fine threads Unified Feingewinde

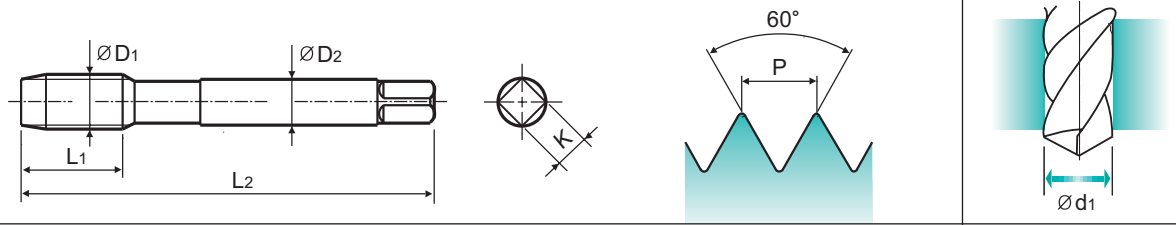
► For using multi-purpose, and correct thread profiles & long tool life due to special tap geometry. YG-1 company has a patent.

► Für vielfältigen Einsatz, genaue Gewindeprofile und lange Standzeit dank einer besonderen Schneidengeometrie. Von YG-1 patentiert.



Material groups **MU** **HSS-E** **DIN 371/374** **2B** **60°** **B** **Bright**

Machine taps
Maschinengewindebohrer



SIZE	TPI	EDP No.	Thread Length	Overall Length	Shank Diameter	Square Size	Tapping drill diameter
ØD1			L1	L2	ØD2	K	Ød1
#4	- 48UNF	TC874182	11	56	3.5	2.7	2.4
#5	- 44UNF	TC874222	11	56	3.5	2.7	2.7
#6	- 40UNF	TC874262	12	56	4	3	3
#8	- 36UNF	TC874302	13	63	4.5	3.4	3.5
#10	- 32UNF	TC874342	15	70	6	4.9	4.1
#12	- 28UNF	TC874382	16	80	6	4.9	4.7
1/4"	- 28UNF	TC874422	17	80	7	5.5	5.5
5/16"	- 24UNF	TC874462	17	90	8	6.2	6.9
3/8"	- 24UNF	TC874502	18	100	9	7	8.5
7/16"	- 20UNF	TC874542	22	100	8	6.2	9.9
1/2"	- 20UNF	TC874582	22	100	9	7	11.5
9/16"	- 18UNF	TC874622	22	100	11	9	12.9
5/8"	- 18UNF	TC874662	22	100	12	9	14.5
3/4"	- 16UNF	TC874722	25	110	14	11	17.5
7/8"	- 14UNF	TC874762	26	125	18	14.5	20.5
1"	- 12UNF	TC874802	28	140	20	16	23.25

Unit : mm

► DIN371 (#4~3/8") and DIN374 (7/16"~1")
 ► Coating(TiN, TiCN or TiAlN) or Surface Treatment(Steam Homo) is available on your request.

Unit : N/mm² ◎ : Excellent ○ : Good

Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

- HSS
- CARBIDE
- COMBO TAPS
- SPIRAL POINT TAPS
- SPIRAL FLUTE TAPS
- STRAIGHT FLUTE TAPS
- COLD FORMING TAPS
- NUT TAPS
- STI TAPS
- HAND TAPS
- PIPE TAPS
- CARBIDE TAPS
- THREAD MILLS
- TECHNICAL DATA

RECOMMENDED TAPPING SPEEDS

Work Materials		Spiral Flute	Tapping Speed	Gun point	Tapping Speed
		TC814,TC834	(m/min)	TC804,TC824	(m/min)
Steels	Structure steels	●	15 ~ 20	●	15 ~ 20
	Plain carbon steels	●	12 ~ 18	●	12 ~ 18
	Alloy steels up to 850N/mm ²	●	10 ~ 15	●	10 ~ 15
	Hardened & Tempered steels up to 1,200N/mm ²	○	6 ~ 10	○	6 ~ 10
Stainless steels	Free machining	●	7 ~ 10	●	7 ~ 10
	Austenitic	●	5 ~ 8	●	5 ~ 8
Cast iron	Grey Cast irons up to 500N/mm ²	○	10 ~ 15	○	10 ~ 15
	Malleable Cast irons up to 700N/mm ²	○	10 ~ 15	○	10 ~ 15
	Nodular graphite up to 700N/mm ²	○	10 ~ 15	○	10 ~ 15
Aluminum	Alloyed Aluminum, Si<10%	○	15 ~ 20	○	15 ~ 20
	Alloyed Aluminum, Si>10%	●	10 ~ 15	●	10 ~ 15
Titanium	Unalloyed Titanium	●	10 ~ 15	●	10 ~ 15
	Alloyed Titanium up to 900N/mm ²	○	8 ~ 12	○	8 ~ 12
Nickel	Unalloyed Nickel	●	8 ~ 12	●	8 ~ 12
	Alloyed Nickel up to 900N/mm ²	○	10 ~ 15	○	10 ~ 15
Copper	Unalloyed Copper	●	8 ~ 12	●	8 ~ 12
	Long chipping Copper	●	15 ~ 20	●	15 ~ 20
Brass	Long chipping Brass	●	15 ~ 20	●	15 ~ 20
Bronze	Long chipping Bronze	●	15 ~ 20	●	15 ~ 20

● : RECOMMENDED
○ : SUITABLE

**International
patent**

FEATURES OF COMBO TAP

1. Thread configuration with a special design. (International patent)
 - * Prevents over-feeding, thin thread and pitch diameter oversize.
2. Flute geometry with special design.
 - * Better chip evacuation.
 - * Prevents chip clogging.
 - * Improves thread quality.
3. Applicable for wide applications.
 - * Blind and through holes.
4. Excellent performance on various materials.
 - * Carbon Steels, Alloyed Steels, Tool Steel etc.