

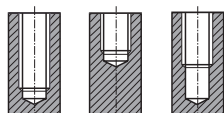
MF ISO Metric fine threads DIN 13

Metrisches ISO-Feingewinde DIN 13

► 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.

Hole type



DIN 374

Material groups
MU

HSS-E

DIN 374

6H

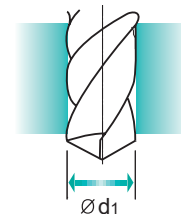
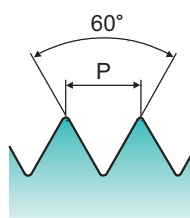
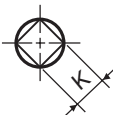
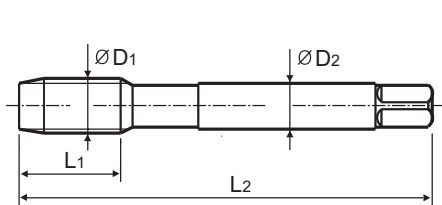
60°

C

Bright

R40

Machine taps
Maschinengewindebohrer



Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Shank Diameter	Square Size	Tapping drill diameter
ØD1	P		L1	L2	ØD2	K	Ød1
M4	× 0.5	TC844256	5	63	2.8	2.1	3.5
M5	× 0.5	TC844296	5	70	3.5	2.7	4.5
M6	× 0.75	TC844326	8	80	4.5	3.4	5.2
M6	× 0.5	TC844336	5	80	4.5	3.4	5.5
M7	× 0.75	TC844356	10	80	5.5	4.3	6.2
M8	× 1.0	TC844376	10	90	6	4.9	7
M8	× 0.75	TC844386	8	80	6	4.9	7.2
M10	× 1.25	TC844436	16	100	7	5.5	8.8
M10	× 1.0	TC844446	10	90	7	5.5	9
M10	× 0.75	TC844456	10	90	7	5.5	9.2
M12	× 1.5	TC844516	15	100	9	7	10.5
M12	× 1.25	TC844526	15	100	9	7	10.8
M12	× 1.0	TC844536	11	100	9	7	11
M14	× 1.5	TC844556	15	100	11	9	12.5
M14	× 1.25	TC844566	15	100	11	9	12.8
M14	× 1.0	TC844576	11	100	11	9	13

► Coating(TiN, TiCN or TiAlN) or Surface Treatment(Steam Homo) is available on your request.

Unit : N/mm²

◎ : Excellent ○ : Good

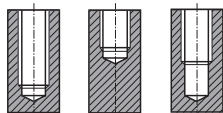
Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	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
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

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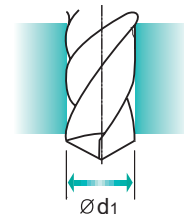
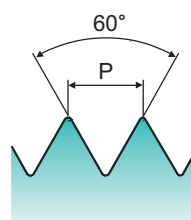
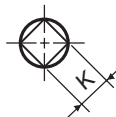
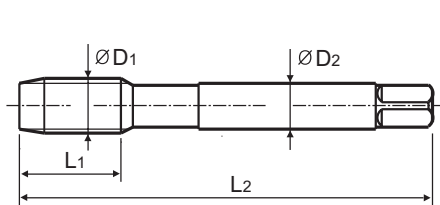
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Bright


 Machine taps
 Maschinengewindebohrer


Unit : mm

SIZE	Pitch		EDP No.	Thread Length	Overall Length	Shank Diameter	Square Size	Tapping drill diameter
	ØD1	P		L1	L2	ØD2	K	Ød1
M16	× 1.5		TC844616	15	100	12	9	14.5
M16	× 1.0		TC844626	12	100	12	9	15
M18	× 1.5		TC844676	17	110	14	11	16.5
M18	× 1.0		TC844686	13	110	14	11	17
M20	× 1.5		TC844726	17	125	16	12	18.5
M20	× 1.0		TC844736	14	125	16	12	19
M22	× 1.5		TC844766	17	125	18	14.5	20.5
M22	× 1.0		TC844776	14	125	18	14.5	21
M24	× 2.0		TC844796	20	140	18	14.5	22
M24	× 1.5		TC844806	20	140	18	14.5	22.5
M26	× 1.5		TC844856	20	140	18	14.5	24.5
M27	× 2.0		TC844876	20	140	20	16	25
M27	× 1.5		TC844886	20	140	20	16	25.5
M28	× 1.5		TC844916	20	140	20	16	26.5
M30	× 2.0		TC844966	22	150	22	18	28
M30	× 1.5		TC844976	22	150	22	18	28.5

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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
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

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.