COMBO TAP

Vap **TB814** SERIES
Bright **TC814** SERIES
TiN **TD814** SERIES

M ISO Metric coarse threads DIN 13

- Metrisches ISO-Gewinde DIN 13
- ISO MÉTRIQUE DIN13
- ISO Metrico passo grosso DIN 13

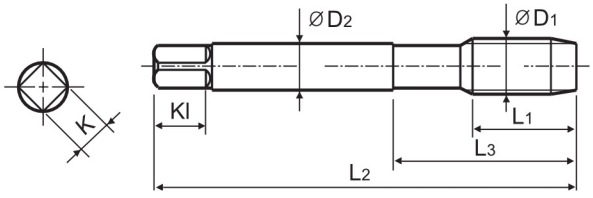
Machine taps
Maschinengewindebohrer

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

' Für vielfältigen Einsatz, genaue Gewindeprofile und lange Standzeitendank einer besonderen Schneidengeometrie. Von YG-1 patentiert.

DIN 371

DIN 376



Hole type
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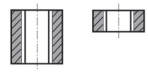

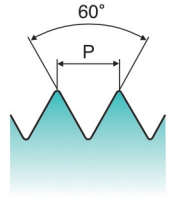

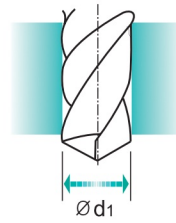

Material groups **MU** | HSS-E | DIN 371/376 | 6H | 60° | B | Vap Bright TiN

p.B131

Recommended ToolHolder: PlainShank, TAPPINGERCHUCK, TAPPINGCHUCK, ONESTEPTAPPINGCHUCK

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	Vap	Bright	TiN	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M2 ×	0.4	TB814136	TC814136	TD814136	8	45	13	2.8	2.1	5	3	1.6
M2.2 ×	0.45	TB814156	TC814156	TD814156	8	45	13	2.8	2.1	5	3	1.75
M2.3 ×	0.4	TB814196	TC814196	TD814196	8	45	13	2.8	2.1	5	3	1.9
M2.5 ×	0.45	TB814176	TC814176	TD814176	9	50	15	2.8	2.1	5	3	2.05
M2.6 ×	0.45	TB814496	TC814496	TD814496	9	50	15	2.8	2.1	5	3	2.1
M3 ×	0.5	TB814206	TC814206	TD814206	11	56	18	3.5	2.7	6	3	2.5
M3.5 ×	0.6	TB814226	TC814226	TD814226	12	56	20	4	3	6	3	2.9
M4 ×	0.7	TB814246	TC814246	TD814246	13	63	21	4.5	3.4	6	3	3.3
M4.5 ×	0.75	TB814266	TC814266	TD814266	14	70	25	6	4.9	8	3	3.7
M5 ×	0.8	TB814286	TC814286	TD814286	15	70	25	6	4.9	8	3	4.2
M6 ×	1.0	TB814316	TC814316	TD814316	17	80	30	6	4.9	8	3	5
M7 ×	1.0	TB814346	TC814346	TD814346	17	80	30	7	5.5	8	3	6
M8 ×	1.25	TB814366	TC814366	TD814366	20	90	35	8	6.2	9	3	6.8
M9 ×	1.25	TB814396	TC814396	TD814396	20	90	35	9	7	10	3	7.8
M10 ×	1.5	TB814426	TC814426	TD814426	22	100	39	10	8	11	3	8.5
M11 ×	1.5	TB814466	TC814466	TD814466	22	100	40	8	6.2	9	3	9.5
M12 ×	1.75	TB814506	TC814506	TD814506	24	110	44	9	7	10	3	10.2
M14 ×	2.0	TB814546	TC814546	TD814546	26	110	44	11	9	12	3	12
M16 ×	2.0	TB814606	TC814606	TD814606	27	110	44	12	9	12	3	14
M18 ×	2.5	TB814656	TC814656	TD814656	30	125	50	14	11	14	4	15.5
M20 ×	2.5	TB814706	TC814706	TD814706	32	140	54	16	12	15	4	17.5
M22 ×	2.5	TB814746	TC814746	TD814746	32	140	54	18	14.5	17	4	19.5

► DIN 371(M2~M10) and DIN 376(M11~M52)
► The other coating(TiCN or TiAlN) is available on your request.

► NEXTPAGE

_ "-`KMTTMV\´ "/WWL

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	□	i	i	i	i	i	i	i	i	□		i	i	i	i	i	i	i		

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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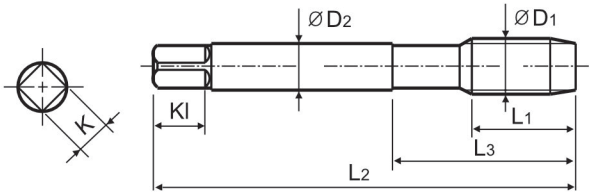

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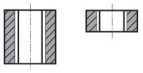

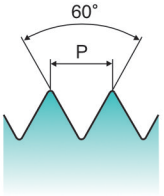

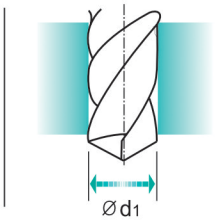

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M24 ×	3.0	TB814786	TC814786	TD814786	34	160	60	18	14.5	17	4	21
M27 ×	3.0	TB814866	TC814866	TD814866	36	160	60	20	16	19	4	24
M30 ×	3.5	TB814946	TC814946	TD814946	40	180	70	22	18	21	4	26.5
M33 x	3.5	-	TC814A46	TD814A46	40	180	70	25	20	23	4	29.5
M36 x	4.0	-	TC814B36	TD814B36	50	200	80	28	22	25	4	32.0
M39 x	4.0	-	TC814C06	TD814C06	50	200	80	32	24	27	4	35.0
M42 x	4.5	-	TC814C86	TD814C86	56	200	85	32	24	27	4	37.5
M45 x	4.5	-	TC814D56	TD814D56	58	220	85	36	29	32	4	40.5
M48 x	5.0	-	TC814E26	TD814E26	65	250	90	36	29	32	4	43.0
M52 x	5.0	-	TC814F36	TD814F36	65	250	90	40	32	35	4	47.0

- ▶ DIN 371 (M2~M10) and DIN 376 (M11~M52)
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HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	□	i	i	i	i	i	i	i	i	□		i	i	i	i	i	i	i		

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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			-			-	-	-													