

ISO	VDI 3323	Material Description	HB	HRc	T0997-TIC	T0999-TIC	TC313 TB313 TY313	TC283 TY283
					Vc (m/min)			
P	1	Non-alloy steel	125					
	2		190	13				
	3		250	25				
	4		270	28				
	5		300	32				
	6	Low alloy steel	180	10				
	7		275	29			10-15	10-15
	8		300	32			6-10	6-10
	9		350	38	5-8	5-8	3-5	3-5
	10	High alloyed steel, and tool steel	200	15				
	11		325	35				
M	12	Stainless steel	200	15				
	13		240	23				
	14		180	10			4-6	4-6
K	15	Grey cast iron	180	10				
	16		260	26				
	17	Nodular cast iron	160	3				
	18		250	25				
	19	Malleable cast iron	130					
20	230		21					
N	21	Aluminum- wrought alloy	60					
	22		100					
	23	Aluminum- cast, alloyed	75					
	24		90					
	25		130					
	26		110			25-35	25-35	
	27	Copper and Copper Alloys (Bronze / Brass)	90					
	28		100					
	29	Non Metallic Materials						
	30							
S	31	Heat Resistant Super Alloys	200	15				
	32		280	30				
	33		250	25				
	34		350	38				
	35		320	34				
	36	Titanium Alloys	400 Rm					
	37		1050 Rm					
H	38	Hardened steel	550	55	3-7	3-7		
	39		630	60	3-7	3-7		
	40	Chilled Cast Iron	400	42	3-7	3-7		
	41	Hardened Cast Iron	550	55	3-7	3-7		

THREAD  
MILLS

SYNCHRO  
TAPS

COMBO  
TAPS

YG TAP  
GENERAL

YG TAP  
STEEL

YG TAP  
HARDENED

YG TAP  
INOX

YG TAP  
CAST  
IRON

YG TAP  
ALU

YG TAP  
Ti Ni

YG TAP  
FORMING

NUT TAPS

STI TAPS

PIPE TAPS

TECHNICAL  
DATA