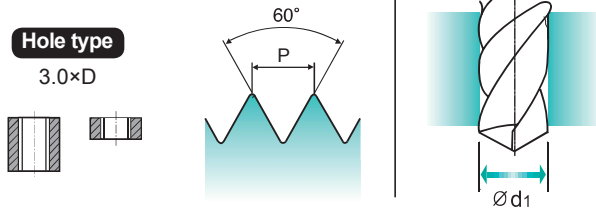
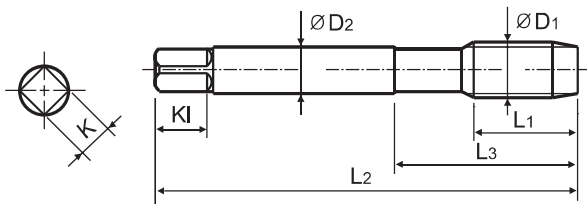


UNC Unified coarse threads

Unified Grobgewinde
 UNC
 Unificato passo grosso

► 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 371/376 2B 60° B Vap Bright TiN

Machine taps
Maschinengewindebohrer

Recommended Cutting Page : P.116

Unit : mm

SIZE	TPI	EDP No.			Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
		Vap	Bright	TiN								
#4	- 40 UNC	TB834162	TC834162	TD834162	11	56	18	3.5	2.7	6	3	2.3
#5	- 40 UNC	TB834202	TC834202	TD834202	11	56	18	3.5	2.7	6	3	2.6
#6	- 32 UNC	TB834242	TC834242	TD834242	12	56	20	4	3	6	3	2.85
#8	- 32 UNC	TB834282	TC834282	TD834282	13	63	21	4.5	3.4	6	3	3.5
#10	- 24 UNC	TB834322	TC834322	TD834322	15	70	25	6	4.9	8	3	3.9
#12	- 24 UNC	TB834362	TC834362	TD834362	16	80	30	6	4.9	8	3	4.5
1/4	- 20 UNC	TB834402	TC834402	TD834402	17	80	30	7	5.5	8	3	5.2
5/16	- 18 UNC	TB834442	TC834442	TD834442	20	90	35	8	6.2	9	3	6.6
3/8	- 16 UNC	TB834482	TC834482	TD834482	22	100	39	9	7	10	3	8
7/16	- 14 UNC	TB834522	TC834522	TD834522	22	100	40	8	6.2	9	3	9.4
1/2	- 13 UNC	TB834562	TC834562	TD834562	25	110	44	9	7	10	3	10.75
9/16	- 12 UNC	TB834602	TC834602	TD834602	26	110	44	11	9	12	3	12.25
5/8	- 11 UNC	TB834642	TC834642	TD834642	27	110	44	12	9	12	3	13.5
3/4	- 10 UNC	TB834702	TC834702	TD834702	30	125	50	14	11	14	4	16.5
7/8	- 9 UNC	TB834742	TC834742	TD834742	32	140	54	18	14.5	17	4	19.5
1	- 8 UNC	TB834782	TC834782	TD834782	36	160	60	20	16	19	4	22.25

► DIN 371(#4~3/8) and DIN 376(7/16~1)

* The other coating(TiCN or TiAlN) is available on your request.

◎ : Excellent ○ : Good

ISO	P										M				K						
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel				Stainless steel		Grey cast iron		Nodular cast iron		Malleable cast iron
Material Description	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	
HRC	125	130	135	140	145	150	155	160	165	170	175	180	185	190	195	200	205	210	215	220	
HB	125	130	135	140	145	150	155	160	165	170	175	180	185	190	195	200	205	210	215	220	
Recommended	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	

ISO	N					S										H					
	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	
Material Description	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRC	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550
Recommended			○			○	○	○													



RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDKONDITIONEN

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

TB744	TC814	TD814	TB814	TCJ05	TDJ05	TBJ05	TCJ06
TB754	TC854	TD854	TB854	TCJ09	TDJ09		
TQ744	TC834	TD834	TB834	TCJ01	TDJ01		
TQ754	TC874	TD874	TB874	TCJ02	TDJ02		

ISO	VDI 3323	Material Description	HB	HRC	Vc (m/min)								
P	1	Non-alloy steel	125			15-20	20-25	15-20	15-20	20-25	15-20	15-20	
	2		190	13	15-20	15-20	20-25	15-20	15-20	20-25	15-20	15-20	
	3		250	25		12-18	18-24	12-18	12-18	18-24	12-18	12-18	
	4		270	28	10-15	10-15	15-20	10-15	10-15	15-20	10-15	10-15	
	5		300	32		6-10	10-14	6-10	6-10	10-14	6-10	6-10	
	6	Low alloy steel	180	10	10-15	10-15	15-20	10-15	10-15	15-20	10-15	10-15	
	7		275	29	10-15	10-15	15-20	10-15	10-15	15-20	10-15	10-15	
	8		300	32		6-10	10-14	6-10	6-10	10-14	6-10	6-10	
	9		350	38		3-5	5-7	3-5	3-5	5-7	3-5	3-5	
	10		High alloyed steel, and tool steel	200	15		3-5	5-7	3-5	3-5	5-7	3-5	3-5
	11			325	35								
M	12	Stainless steel	200	15	7-10	7-10	10-15	7-10	7-10	10-15	7-10	7-10	
	13		240	23	5-8	5-8	8-11	5-8	5-8	8-11	5-8	5-8	
	14		180	10	4-6	4-6	6-8	4-6	4-6	6-8	4-6	4-6	
K	15	Grey cast iron	180	10		10-15	15-20	10-15	10-15	15-20	10-15	10-15	
	16		260	26		5-8	8-11	5-8	5-8	8-11	5-8	5-8	
	17	Nodular cast iron	160	3		10-15	15-20	10-15	10-15	15-20	10-15	10-15	
	18		250	25		5-8	8-11	5-8	5-8	8-11	5-8	5-8	
	19	Malleable cast iron	130										
20	230		21										
N	21	Aluminum-wrought alloy	60										
	22		100										
	23	Aluminum-cast, alloyed	75			15-20	20-25	15-20	15-20	20-25	15-20	15-20	
	24		90										
	25		130										
	26		110			25-35	35-40	25-35	25-35	35-40	25-35	25-35	
	27		90			8-12	12-17	8-12	8-12	12-17	8-12	8-12	
	28		100			15-20	15-20	20-25	15-20	15-20	20-25	15-20	15-20
	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									
	39		630	60									
	40	Chilled Cast Iron	400	42									
	41	Hardened Cast Iron	550	55									