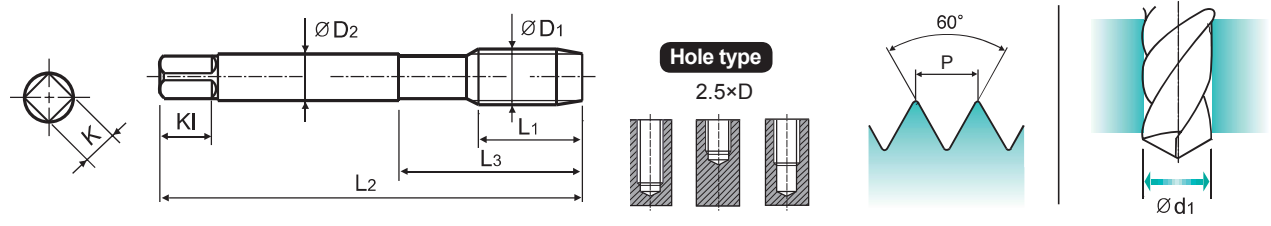


UNF

Unified Grobgewinde
 UNF
 Unificato passo fine

► 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.



HSS-E	DIN 371/374	2B	60°	C	Vap Bright TiN	R40
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Machine taps
Maschinengewindebohrer

Recommended Cutting Page : P.114

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	-48UNF	TB864182	TC864182	TD864182	6	56	18	3.5	2.7	6	3	2.4
#5	-44UNF	TB864222	TC864222	TD864222	7	56	18	3.5	2.7	6	3	2.7
#6	-40UNF	TB864262	TC864262	TD864262	7	56	20	4	3	6	3	3
#8	-36UNF	TB864302	TC864302	TD864302	8	63	21	4.5	3.4	6	3	3.5
#10	-32UNF	TB864342	TC864342	TD864342	10	70	25	6	4.9	8	3	4.1
#12	-28UNF	TB864382	TC864382	TD864382	10	80	30	6	4.9	8	3	4.7
1/4	-28UNF	TB864422	TC864422	TD864422	10	80	30	7	5.5	8	3	5.5
5/16	-24UNF	TB864462	TC864462	TD864462	10	90	35	8	6.2	9	3	6.9
3/8	-24UNF	TB864502	TC864502	TD864502	10	100	39	9	7	10	3	8.5
7/16	-20UNF	TB864542	TC864542	TD864542	13	100	40	8	6.2	9	3	9.9
1/2	-20UNF	TB864582	TC864582	TD864582	13	100	40	9	7	10	3	11.5
9/16	-18UNF	TB864622	TC864622	TD864622	15	100	40	11	9	12	3	12.9
5/8	-18UNF	TB864662	TC864662	TD864662	15	100	40	12	9	12	3	14.5
3/4	-16UNF	TB864722	TC864722	TD864722	17	110	44	14	11	14	4	17.5
7/8	-14UNF	TB864762	TC864762	TD864762	17	125	50	18	14.5	17	4	20.5
1	-12UNF	TB864802	TC864802	TD864802	20	140	54	20	16	19	4	23.25

► DIN 371(#4~3/8) and DIN 374(7/16~1)
 * The other coating(TiCN or TiAlN) is available on your request.

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	13	19	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25	42	21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
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	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550
Recommended	◎	◎	◎	◎	◎	◎	◎	◎			◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎



COMBO TAPS

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

ISO	VDI 3323	Material Description	HB	HRc	TC804	TD804	TB804	TCE05	TDE05	TBE05	TCE06	TDE06
					TC844	TD844	TB844	TCE09	TDE09			
					TC824	TD824	TB824	TCE01	TDE01			
					TC864	TD864	TB864	TCE02	TDE02			
					Vc (m/min)							
P	1	Non-alloy steel	125		15-20	20-25	15-20	15-20	20-25	15-20	15-20	20-25
	2		190	13	15-20	20-25	15-20	15-20	20-25	15-20	15-20	20-25
	3		250	25	12-18	18-24	12-18	12-18	18-24	12-18	12-18	18-24
	4		270	28	10-15	15-20	10-15	10-15	15-20	10-15	10-15	15-20
	5		300	32	6-10	10-14	6-10	6-10	10-14	6-10	6-10	10-14
	6	Low alloy steel	180	10	10-15	15-20	10-15	10-15	15-20	10-15	10-15	15-20
	7		275	29	10-15	15-20	10-15	10-15	15-20	10-15	10-15	15-20
	8		300	32	6-10	10-14	6-10	6-10	10-14	6-10	6-10	10-14
	9		350	38	3-5	5-7	3-5	3-5	5-7	3-5	3-5	5-7
	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	10-15	7-10	7-10	10-15	7-10	7-10	10-15
	13		240	23	5-8	8-11	5-8	5-8	8-11	5-8	5-8	8-11
	14		180	10	4-6	6-8	4-6	4-6	6-8	4-6	4-6	6-8
K	15	Grey cast iron	180	10	10-15	15-20	10-15	10-15	15-20	10-15	10-15	15-20
	16		260	26	5-8	8-11	5-8	5-8	8-11	5-8	5-8	8-11
	17	Nodular cast iron	160	3	10-15	15-20	10-15	10-15	15-20	10-15	10-15	15-20
	18		250	25	5-8	8-11	5-8	5-8	8-11	5-8	5-8	8-11
	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	20-25
	24		90									
	25		130									
	26		110		25-35	35-40	25-35	25-35	35-40	25-35	25-35	35-40
	27	Copper and Copper Alloys (Bronze / Brass)	90		8-12	12-17	8-12	8-12	12-17	8-12	8-12	12-17
	28		100		15-20	20-25	15-20	15-20	20-25	15-20	15-20	20-25
	29											
	30	Non Metallic Materials										
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								