YU-PT26 **AMERICAS**

BEST VALUE IN THE WORLD OF CUTTING TOOLS

TAP PRIME

HSS-PM(Powder Metallurgy) Premium Taps

- Spiral Point, Spiral Flute, and Forming Taps for CNC Machines
- High and Reliable Performance in Various Ductile Materials

NEW PORTFOLIO!

EXPANSION **Spiral Point, Spiral Flute Cutting Tap**

NEW **with Internal Coolant**

Prime X-Coated Tap for CNC Machining in Various Ductile Materials

The special grinding process provides a unique geometry for spiral flute and spiral point taps to optimize chip evacuation, while Forming Taps form threads through material displacement without chip evacuation, resulting in stronger threads and improved surface finish.

Spiral Flute

Spiral Point

GUIDE TO ICONS

Working Material

Material groups **MU** Multi-Purpose

Helix Angle

R45

Tool Raw Material

HSS PM YG-1 Premium Powder Metallurgy HSS

Cutting Condition

Tap Limits

H D

Finish

X Coating YG-1 X-Coating

Thread Angle

60°

Chamfer Type

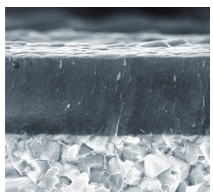
1P~2P 2P~3P 4P~5P

Thread Designation

UNC UNF M/MF

FEATURES & BENEFITS

High and Reliable Performance on Various Ductile Materials



YG-1's X-Coating

- **YG-1's High Performance Coating for high heat and wear resistance**

YG-1 Special Thread Structure

- **Reduction in torque, wear, and the risk of over feeding** as compared to conventional taps

Extra Short Threaded Body and Recess

- **Minimize bird nesting, reduced chipping, improved thread finish**

Optimized Edge Preparation

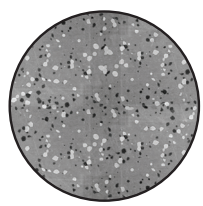
- **Consistent performance and process stability** to prevent chipping

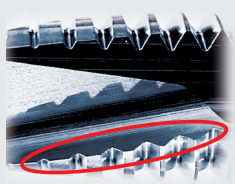
Optimized Flute Geometry for Excellent Chip Flow

- **Increased tool life as a result of an optimum combination of material, geometry,** and coating which gives unrestricted chip flow

HSS-PM(Powder Metallurgy) Premium Taps

Powdered Metal Technology for a tough-chipping resistant cutting edge for long tool life and reliable thread finish





Premium Cutting Edge Strength

- More controlled structure with high wear resistance
- Consistent performance and process stability with chipping resistance

CASE STUDY

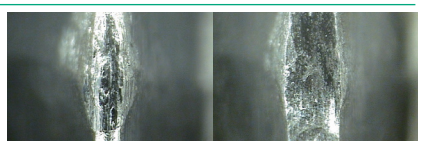
TEST I FORMING TAP (M6x1.0)

Cutting Condition

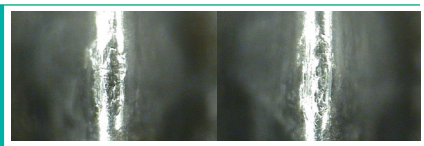
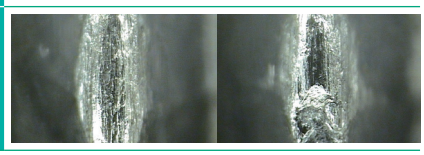
Tool	Forming Tap
Size	M6x1.0
Work Material	- JIS: SCM440(HRc35) - DIN: 42CrMo4 - WR: 1.7225
SFM	22
Vc	33 ft/min.

Feed	1.0 mm/rev.
Tap Drill Size	.2161"
Tapping Depth	.4724"
Tapping Holes	1,000
Machine	Machining Center (Horizontal)

RESULT 1

YG-1 (1,000 Holes)	
Competitor (1,000 Holes)	

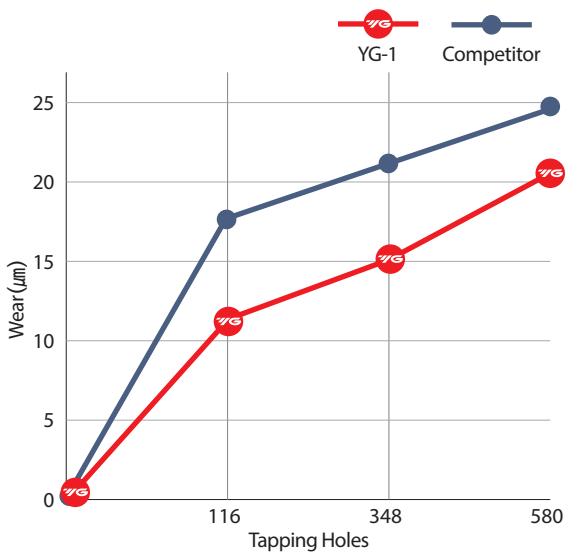
RESULT 2

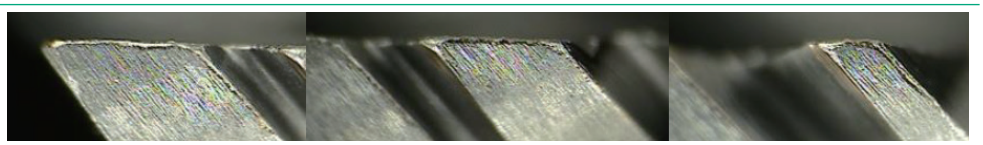
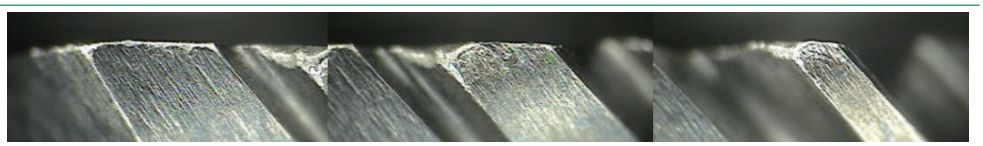
YG-1 (1,000 Holes)	
Competitor (1,000 Holes)	

TEST II SPIRAL FLUTE TAP (M4x0.7)

Cutting Condition

Tool	Spiral Flute Tap
Size	M4x0.7
Work Material	- JIS: SCM440(HRc30) - DIN: 42CrMo4 - WR: 1.7225
SFM	98
Vc	98 ft/min.
Feed	0.7 mm/rev.
Tap Drill Size	.1299"
Tapping Depth	.3150"
Tapping Holes	580
Coolant	Wet Cut



YG-1 (580 Holes)	
Competitor (580 Holes)	

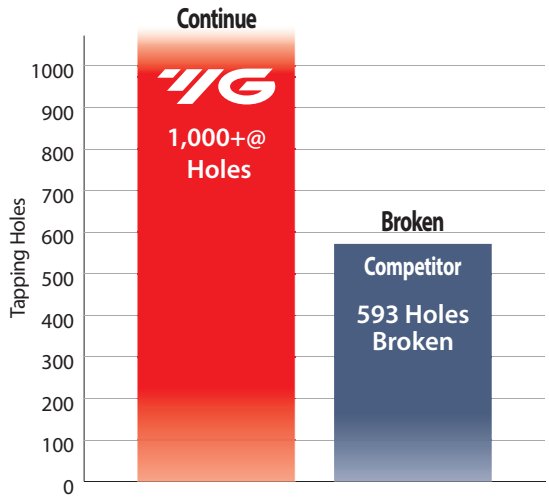
Phone: 800-765-8665 | Technical Support : 888-868-5988 | yg1usa.com

CASE STUDY

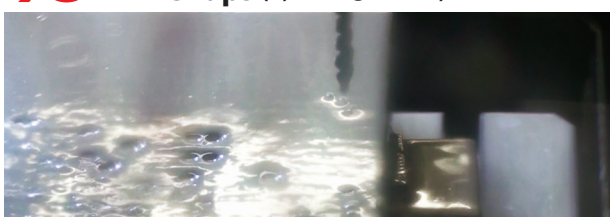
TEST III SPIRAL FLUTE TAP (M6x1.0)

Cutting Condition

Tool	Sprial Flute Tap
Size	M6x1.0
Work Material	- JIS: SUS304 - DIN: X16CrNi1810 - WR: 1.4350
SFM	33
Vc	33 ft/min.
Feed	1.0 mm/rev.
Tap Drill Size	.2008"
Tapping Depth	.4724"
Tapping Holes	YG-1: 1,000+@ / Competitor: 593
Coolant	Wet Cut



YG Prime Taps (1,000+@ Holes)



Competitor (593 Holes, Broken)

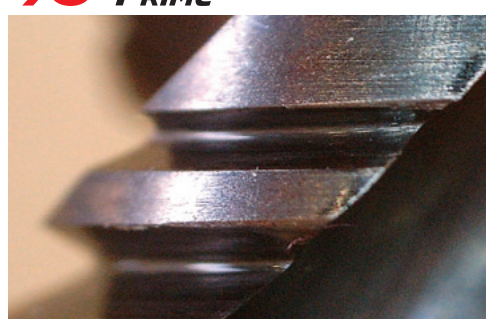
TEST IV SPIRAL FLUTE TAP (M8x1.25)

Cutting Condition

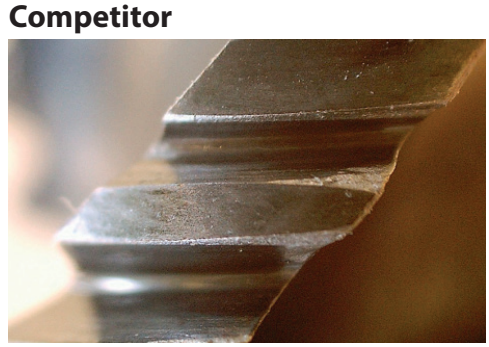
Tool	Sprial Flute Tap
Size	M8x1.25
Work Material	- JIS: S45C - DIN: CK45 - WR: 1.1191
SFM	66
Vc	66 ft/min.
Feed	1.25 mm/rev.
Tap Drill Size	.2677"
Tapping Depth	.6693"
Tapping Holes	YG-1: 1,350+@ / Competitor: 1,350+@
Coolant	Wet Cut

Comparison of Wear Resistance

YG PRIME TAP



Competitor



HSS-PM
PRIME TAP

Premium HSS-PM X-Coated Tap
for CNC Machines

Please visit
globalyg1.com/mat
for material search

◎ : Excellent ○ : Good

HOLE TYPE		Max. 2.5xD Blind Hole		Max. 3.0xD Through Hole
TOOL MATERIAL		HSS-PM		
CHAMFER LEAD ACC. TO DIN2197		2P~3P	1P~2P	4P~5P
FLUTE TYPE		Spiral Flute		Spiral Point
SPIRAL FLUTE ANGLE		R45		-
M	USCTI 302A			
M/MF	USCTI 302A			
	DIN Length-ANSI Shank	**TRF04** (p.12)	**TRF24** (p.16)	**TRK04** (p.20)
	Extension			
UNC	USCTI Long Shank			
UNC/UNF	USCTI 302			
	USCTI 302A			
	DIN Length-ANSI Shank	**TRF14** (p.8)	**TRF34** (p.14)	**TRK14** (p.17)
	Extension			
SURFACE TREATMENT / COATING		X-Coating		
MODEL				

ISO	VDI 3323	Material Description	Composition / Structure / Heat Treatment		HB	HRc	Examples	Recommended cutting conditions (SFM)		
P	1	Non-alloy steel	About 0.15% C	Annealed	125		S15C, C15, 1015	○ (16-66)	○ (16-66)	◎ (49-148)
	2		About 0.45% C	Annealed	190	13	S45C, C45, 1045	◎ (33-164)	◎ (33-164)	◎ (33-180)
	3		About 0.45% C	Quenched & Tempered	250	25		◎ (33-164)	◎ (33-164)	◎ (33-180)
	4		About 0.75% C	Annealed	270	28	SK5, Ck75, 1080	◎ (49-131)	◎ (49-131)	◎ (49-164)
	5		About 0.75% C	Quenched & Tempered	300	32		◎ (49-131)	◎ (49-131)	◎ (49-164)
	6	Low alloy steel		Annealed	180	10	SCM440, 42CrMo4, 410	◎ (26-98)	◎ (26-98)	◎ (26-98)
	7			Quenched & Tempered	275	29		◎ (26-98)	◎ (26-98)	◎ (26-98)
	8			Quenched & Tempered	300	32		◎ (26-98)	◎ (26-98)	◎ (26-98)
	9			Quenched & Tempered	350	38		○ (26-98)	○ (26-98)	◎ (26-98)
	10	High alloyed steel, and tool steel		Annealed	200	15	SKD, D2	○ (26-98)	○ (26-98)	○ (26-98)
	11			Quenched & Tempered	325	35	SKH, SUH, M42	○ (26-98)	○ (26-98)	○ (26-98)
M	12	Stainless steel	Ferritic / Martensitic	Annealed	200	15	SUS 420, X40Cr13, 420	◎ (16-49)	◎ (16-49)	◎ (26-66)
	13		Martensitic	Quenched & Tempered	240	23		◎ (16-49)	◎ (16-49)	◎ (26-66)
	14			Austenitic	180	10	SUS 316, 316, X5CrNiMo 17 12 2	◎ (16-49)	◎ (16-49)	◎ (26-66)
K	15	Grey cast iron	Pearlitic / ferritic		180	10		○ (49-115)	○ (49-115)	◎ (49-115)
	16		Pearlitic (Martensitic)		260	26		○ (49-115)	○ (49-115)	◎ (49-115)
	17	Nodular cast iron	Ferritic		160	3	FCD, GGG, EN-GJS-500-7	◎ (49-115)	◎ (49-115)	◎ (49-115)
	18		Pearlitic		250	25		◎ (49-115)	◎ (49-115)	◎ (49-115)
	19	Malleable cast iron	Ferritic		130		FCMW, FCMP, GTS, GJMB350-10			
	20		Pearlitic		230	21				
N	21	Aluminum-wrought alloy	Not Curable		60		SAE 1000, AlMg 1, 3.3315	○ (49-115)	○ (49-115)	○ (49-115)
	22		Curable	Hardened	100		SAE 7050, AlCuMg 1, 3.1325	○ (49-115)	○ (49-115)	○ (49-115)
	23	Aluminum-cast, alloyed	≤ 12% Si, Not Curable		75		ADC12, G-AlSi12, 3.2581	◎ (49-115)	◎ (49-115)	◎ (49-115)
	24		≤ 12% Si, Curable	Hardened	90		C4BS, G-AlSi10Mg, 3.2381	◎ (49-115)	◎ (49-115)	◎ (49-115)
	25		> 12% Si, Not Curable		130			○ (49-115)	○ (49-115)	○ (49-115)
	26	Copper and Copper Alloys (Bronze / Brass)	Cutting Alloys, PB>1%		110		CuZn36Pb 3, 2.0375	◎ (49-115)	◎ (49-115)	◎ (49-115)
	27		CuZn, CuSnZn (Brass)		90		CuZn 15, 2.0240	◎ (49-115)	◎ (49-115)	◎ (49-115)
	28		CuSn, lead-free copper and electrolytic copper		100		G-CuZn40Fe, 2.0590	◎ (49-115)	◎ (49-115)	◎ (49-115)
	29	Non Metallic Materials	Duroplastic, Fiber Reinforced Plastic				CFRP			
	30		Rubber, Wood, etc.							
S	31	Heat Resistant Super Alloys	Fe Based	Annealed	200	15	X12 NiCrSi 36-16, 1.4864			
	32			Cured	280	30				
	33		Ni or Co Based	Annealed	250	25	Inconel 718, NiCr20TiAl, 2.4631			
	34			Cured	350	38	NiCu30Al, 2.4375			
	35			Cast	320	34	G-X120Mn12, 1.3401			
	36	Titanium Alloys	Pure Titanium		400 Rm					
	37		Alpha + Beta Alloys	Hardened	1050 Rm		TiAl6V4, 3.7165			
H	38	Hardened steel		Hardened	550	55	SK3			
	39			Hardened	630	60				
	40	Chilled Cast Iron		Cast	400	42				
	41	Hardened Cast Iron		Hardened	550	55				

Max. 2.5xD Blind Hole		Max. 3.0xD Through Hole	Max. 2.5xD Blind Hole	Max. 3.0xD Through Hole	Max. 3.0xD Blind/Through Hole				
HSS-PM									
2P~3P	1P~2P	4P~5P	2P~3P	4P~5P	1P~2P	2P~3P	1P~2P	2P~3P	
Spiral Flute	Spiral Flute	Spiral Point	Spiral Flute	Spiral Point	Forming				
R45	R45	-	R45	-	-	-	-	-	
TRF26 (p.25)	**TRF28** (p.29)	**TRK16** (p.32)			**TRR13** (p.44)	**TRR12** (p.50)	**TRR17** (p.54)	**TRR16** (p.57)	
			TRF29 (p.36)	**TRK29** (p.40)					
TRF25 (p.22)	**TRF27** (p.27)	**TRK15** (p.30)			**TRR11** (p.42)	**TRR10** (p.46)	**TRR15** (p.53)	**TRR14** (p.55)	
			TRF30 (p.34)	**TRK30** (p.38)					
X-Coating									
									
Recommended cutting conditions (SFM)									
○ (16-73)	○ (16-73)	◎ (49-163)	○ (16-66)	◎ (49-148)	◎ (49-131)	◎ (49-131)	◎ (49-131)	◎ (49-131)	1
◎ (33-180)	◎ (33-180)	◎ (33-198)	◎ (33-164)	◎ (33-180)	◎ (49-98)	◎ (49-98)	◎ (49-98)	◎ (49-98)	2
◎ (33-180)	◎ (33-180)	◎ (33-198)	◎ (33-164)	◎ (33-180)	◎ (49-98)	◎ (49-98)	◎ (49-98)	◎ (49-98)	3
◎ (49-144)	◎ (49-144)	◎ (49-181)	◎ (49-131)	◎ (49-164)	◎ (49-98)	◎ (49-98)	◎ (49-98)	◎ (49-98)	4
◎ (49-144)	◎ (49-144)	◎ (49-181)	◎ (49-131)	◎ (49-164)	◎ (49-98)	◎ (49-98)	◎ (49-98)	◎ (49-98)	5
◎ (26-108)	◎ (26-108)	◎ (26-108)	◎ (26-98)	◎ (26-98)	◎ (49-98)	◎ (49-98)	◎ (49-98)	◎ (49-98)	6 P
◎ (26-108)	◎ (26-108)	◎ (26-108)	◎ (26-98)	◎ (26-98)	◎ (49-98)	◎ (49-98)	◎ (49-98)	◎ (49-98)	7
◎ (26-108)	◎ (26-108)	◎ (26-108)	◎ (26-98)	◎ (26-98)	◎ (16-65)	◎ (16-65)	◎ (16-65)	◎ (16-65)	8
○ (26-108)	○ (26-108)	○ (26-108)	○ (26-98)	◎ (26-98)	◎ (16-65)	◎ (16-65)	◎ (16-65)	◎ (16-65)	9
○ (26-108)	○ (26-108)	○ (26-108)	○ (26-98)	○ (26-98)	◎ (16-65)	◎ (16-65)	◎ (16-65)	◎ (16-65)	10
○ (26-108)	○ (26-108)	○ (26-108)	○ (26-98)	○ (26-98)	◎ (16-65)	◎ (16-65)	◎ (16-65)	◎ (16-65)	11
◎ (16-54)	◎ (16-54)	◎ (26-73)	◎ (16-49)	◎ (26-66)	◎ (16-49)	◎ (16-49)	◎ (16-49)	◎ (16-49)	12
◎ (16-54)	◎ (16-54)	◎ (26-73)	◎ (16-49)	◎ (26-66)	◎ (16-49)	◎ (16-49)	◎ (16-49)	◎ (16-49)	13 M
◎ (16-54)	◎ (16-54)	◎ (26-73)	◎ (16-49)	◎ (26-66)	◎ (10-30)	◎ (10-30)	◎ (10-30)	◎ (10-30)	14
○ (49-127)	○ (49-127)	○ (49-127)	○ (49-115)	◎ (49-115)					15
○ (49-127)	○ (49-127)	○ (49-127)	○ (49-115)	◎ (49-115)					16
◎ (49-127)	◎ (49-127)	◎ (49-127)	◎ (49-115)	◎ (49-115)					17
◎ (49-127)	◎ (49-127)	◎ (49-127)	◎ (49-115)	◎ (49-115)					18 K
									19
									20
○ (49-127)	○ (49-127)	○ (49-127)	○ (49-115)	○ (49-115)	◎ (65-164)	◎ (65-164)	◎ (65-164)	◎ (65-164)	21
○ (49-127)	○ (49-127)	○ (49-127)	○ (49-115)	○ (49-115)	◎ (65-164)	◎ (65-164)	◎ (65-164)	◎ (65-164)	22
◎ (49-127)	◎ (49-127)	◎ (49-127)	◎ (49-115)	◎ (49-115)	◎ (65-131)	◎ (65-131)	◎ (65-131)	◎ (65-131)	23
◎ (49-127)	◎ (49-127)	◎ (49-127)	◎ (49-115)	◎ (49-115)	◎ (65-131)	◎ (65-131)	◎ (65-131)	◎ (65-131)	24
○ (49-127)	○ (49-127)	○ (49-127)	○ (49-115)	○ (49-115)	◎ (65-131)	◎ (65-131)	◎ (65-131)	◎ (65-131)	25
◎ (49-127)	◎ (49-127)	◎ (49-127)	◎ (49-115)	◎ (49-115)	◎ (32-98)	◎ (32-98)	◎ (32-98)	◎ (32-98)	26 N
◎ (49-127)	◎ (49-127)	◎ (49-127)	◎ (49-115)	◎ (49-115)	◎ (32-98)	◎ (32-98)	◎ (32-98)	◎ (32-98)	27
◎ (49-127)	◎ (49-127)	◎ (49-127)	◎ (49-115)	◎ (49-115)	◎ (32-98)	◎ (32-98)	◎ (32-98)	◎ (32-98)	28
									29
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									41

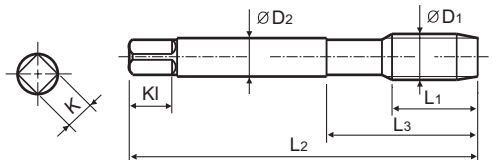
X-Coating, HSS-PM

Spiral Flute Taps for Multipurpose

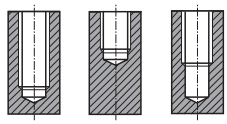
SERIES **TRF14**

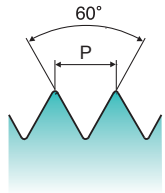
- ▶ High performance on various ductile materials
- ▶ Specially designed to prevent oversized threads and reduce gauging problems

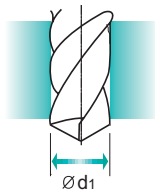
DIN/ANSI



Hole type 2.5×D







Material groups **MU** | HSS PM | UNC UNF | H | 60° | 2P~3P | R45 | X Coating

p.6

Machine Taps

Unit: Inch

Size ØD1	TPI	EDP No.	Limits	Thread Length L1	Overall Length L2	Neck Length L3	Shank Diameter ØD2	Square Size K	Square Length Kl	No. of Flute Z	Tapping Drill Diameter (Ød1) Inch	Metric
#4	40	**TRF14162GS**	H2	.200	2.21	.708	.141	.110	.19	2	-	2.3
#4	48	**TRF14182GS**	H2	.200	2.21	.708	.141	.110	.19	2	3/32	-
#5	40	**TRF14202GS**	H2	.200	2.21	.708	.141	.110	.19	3	-	2.6
#6	32	**TRF14242GS**	H2	.248	2.21	.783	.141	.110	.19	3	-	2.8
#6	32	**TRF14243GS**	H3	.248	2.21	.783	.141	.110	.19	3	-	2.8
#6	40	**TRF14262GS**	H2	.248	2.21	.783	.141	.110	.19	3	-	2.9
#8	32	**TRF14282GS**	H2	.251	2.48	.826	.168	.131	.25	3	-	3.4
#8	32	**TRF14283GS**	H3	.251	2.48	.826	.168	.131	.25	3	-	3.4
#8	36	**TRF14302GS**	H2	.251	2.48	.826	.168	.131	.25	3	-	3.5
#10	24	**TRF14323GS**	H3	.326	2.75	.976	.194	.152	.25	3	-	3.9
#10	32	**TRF14342GS**	H2	.326	2.75	.976	.194	.152	.25	3	-	4.1
#10	32	**TRF14343GS**	H3	.326	2.75	.976	.194	.152	.25	3	-	4.1
#12	24	**TRF14363GS**	H3	.330	3.15	1.177	.220	.165	.28	3	-	4.5
#12	28	**TRF14383GS**	H3	.330	3.15	1.177	.220	.165	.28	3	-	4.7
1/4	20	**TRF14403GS**	H3	.397	3.15	1.177	.255	.191	.31	3	-	5.2
1/4	20	**TRF14405GS**	H5	.397	3.15	1.177	.255	.191	.31	3	-	5.2
1/4	28	**TRF14423GS**	H3	.397	3.15	1.177	.255	.191	.31	3	-	5.5
1/4	28	**TRF14424GS**	H4	.397	3.15	1.177	.255	.191	.31	3	-	5.5
5/16	18	**TRF14443GS**	H3	.556	3.54	1.377	.318	.238	.38	3	-	6.7
5/16	18	**TRF14445GS**	H5	.556	3.54	1.377	.318	.238	.38	3	-	6.7

▶ NEXT PAGE

◎ : Excellent ○ : Good

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	○	◎	◎	◎	◎	◎	◎	◎	○	○	○	◎	◎	◎	○	○	◎	◎		

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	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	◎	◎	○	◎	◎	◎													

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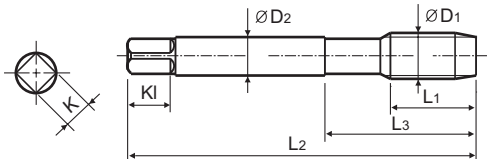
X-Coating, HSS-PM

Spiral Flute Taps for Multipurpose

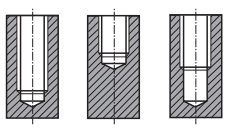
SERIES **TRF14**

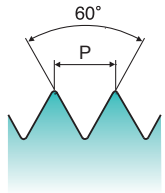
▶ High performance on various ductile materials
▶ Specially designed to prevent oversized threads and reduce gauging problems

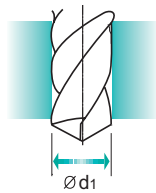
DIN/ANSI



Hole type 2.5×D







Material groups **MU** | HSS PM | UNC UNF | H | 60° | 2P~3P | R45 | X Coating

p.6

Machine Taps

Unit: Inch

Size ØD1	TPI	EDP No.	Limits	Thread Length L1	Overall Length L2	Neck Length L3	Shank Diameter ØD2	Square Size K	Square Length Kl	No. of Flute Z	Tapping Drill Diameter (Ød1) Inch	Metric
5/16	24	**TRF14463GS**	H3	.417	3.54	1.377	.318	.238	.38	3	-	7.0
5/16	24	**TRF14464GS**	H4	.417	3.54	1.377	.318	.238	.38	3	-	7.0
3/8	16	**TRF14483GS**	H3	.625	3.94	1.535	.381	.286	.44	3	-	8.1
3/8	16	**TRF14485GS**	H5	.625	3.94	1.535	.381	.286	.44	3	-	8.1
3/8	24	**TRF14503GS**	H3	.417	3.94	1.377	.381	.286	.44	3	-	8.6
3/8	24	**TRF14504GS**	H4	.417	3.94	1.377	.381	.286	.44	3	-	8.6
7/16	14	**TRF14523GS**	H3	.714	3.94	1.712	.323	.242	.41	3	-	9.5
7/16	14	**TRF14525GS**	H5	.714	3.94	1.712	.323	.242	.41	3	-	9.5
7/16	20	**TRF14543GS**	H3	.500	3.94	1.712	.323	.242	.41	3	-	10.0
7/16	20	**TRF14545GS**	H5	.500	3.94	1.712	.323	.242	.41	3	-	10.0
1/2	13	**TRF14563GS**	H3	.769	4.33	1.933	.367	.275	.44	3	-	11.0
1/2	13	**TRF14565GS**	H5	.769	4.33	1.933	.367	.275	.44	3	-	11.0
1/2	20	**TRF14583GS**	H3	.500	3.94	1.933	.367	.275	.44	3	-	11.6
1/2	20	**TRF14585GS**	H5	.500	3.94	1.933	.367	.275	.44	3	-	11.6
9/16	12	**TRF14603GS**	H3	.833	4.33	1.972	.429	.322	.50	3	-	12.5
9/16	12	**TRF14605GS**	H5	.833	4.33	1.972	.429	.322	.50	3	-	12.5
9/16	18	**TRF14623GS**	H3	.556	3.94	1.972	.429	.322	.50	3	-	13.0
9/16	18	**TRF14625GS**	H5	.556	3.94	1.972	.429	.322	.50	3	-	13.0
5/8	11	**TRF14643GS**	H3	.909	4.33	2.125	.480	.360	.56	3	-	13.9
5/8	11	**TRF14645GS**	H5	.909	4.33	2.125	.480	.360	.56	3	-	13.9

▶ NEXT PAGE

◎ : Excellent ○ : Good

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	○	◎	◎	◎	◎	◎	◎	◎	○	○	○	◎	◎	◎	○	○	◎	◎		

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	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	◎	◎	○	◎	◎	◎													

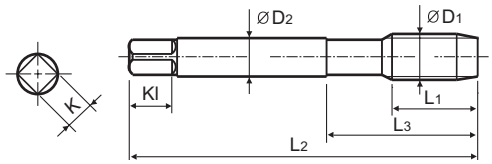
X-Coating, HSS-PM

Spiral Flute Taps for Multipurpose

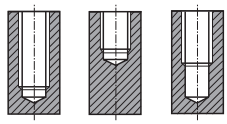
SERIES **TRF14**

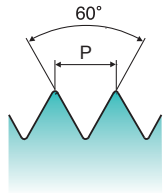
- ▶ High performance on various ductile materials
- ▶ Specially designed to prevent oversized threads and reduce gauging problems

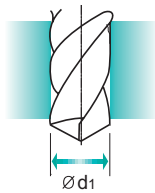
DIN/ANSI



Hole type 2.5×D







Material groups **MU** | HSS PM | UNC UNF | H | 60° | 2P~3P | R45 | X Coating

p.6

Machine Taps

Unit: Inch

Size ØD1	TPI	EDP No.	Limits	Thread Length L1	Overall Length L2	Neck Length L3	Shank Diameter ØD2	Square Size K	Square Length Kl	No. of Flute Z	Tapping Drill Diameter (Ød1) Inch	Metric
5/8	18	**TRF14663GS**	H3	.556	3.94	2.125	.480	.360	.56	3	-	14.6
5/8	18	**TRF14665GS**	H5	.556	3.94	2.125	.480	.360	.56	3	-	14.6
3/4	10	**TRF14703GS**	H3	1.000	4.92	2.433	.590	.442	.69	4	-	16.9
3/4	10	**TRF14705GS**	H5	1.000	4.92	2.433	.590	.442	.69	4	-	16.9
3/4	16	**TRF14723GS**	H3	.625	4.33	2.433	.590	.442	.69	4	-	17.7
3/4	16	**TRF14725GS**	H5	.625	4.33	2.433	.590	.442	.69	4	-	17.7
7/8	9	**TRF14744GS**	H4	1.111	5.51	2.653	697	.523	.75	4	-	19.8
7/8	9	**TRF14746GS**	H6	1.111	5.51	2.653	697	.523	.75	4	-	19.8
7/8	14	**TRF14764GS**	H4	.714	4.92	2.653	697	.523	.75	4	-	20.5
7/8	14	**TRF14766GS**	H6	.714	4.92	2.653	697	.523	.75	4	-	20.5
1"	8	**TRF14786GS**	H6	1.251	6.30	3.012	.800	.600	.81	4	-	22.7
1"	8	**TRF14784GS**	H4	1.251	6.30	3.012	.800	.600	.81	4	-	22.7
1"	12	**TRF14804GS**	H4	.833	5.51	3.012	.800	.600	.81	4	-	23.5
1"	12	**TRF14806GS**	H6	.833	5.51	3.012	.800	.600	.81	4	-	23.5
1"	14	**TRF14816GS**	H6	.714	5.51	3.012	.800	.600	.81	4	-	23.7
1-1/8	7	**TRF14829GS**	H9	1.429	7.08	3.818	.896	.672	.88	4	-	25.5
1-1/8	8	**TRF14839GS**	H9	1.250	7.08	3.818	.896	.672	.88	4	-	25.7
1-1/8	12	**TRF14848GS**	H8	.833	5.90	3.070	.896	.672	.88	4	1-3/64	-
1-1/4	7	**TRF14860GS**	H10	1.429	7.08	3.937	1.021	.766	1.00	4	-	28.5
1-1/4	8	**TRF14879GS**	H9	1.250	7.08	3.937	1.021	.766	1.00	4	-	29.0

▶ NEXT PAGE

◎ : Excellent ○ : Good

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	○	◎	◎	◎	◎	◎	◎	◎	○	○	○	◎	◎	◎	○	○	◎	◎		

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	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	◎	◎	○	◎	◎	◎													

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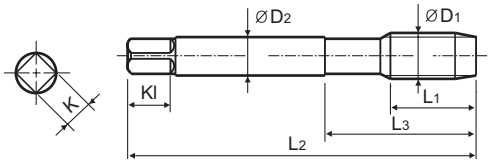
X-Coating, HSS-PM

Spiral Flute Taps for Multipurpose

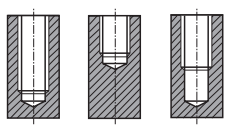
SERIES **TRF14**

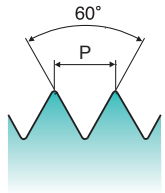
- ▶ High performance on various ductile materials
- ▶ Specially designed to prevent oversized threads and reduce gauging problems

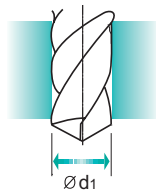
DIN/ANSI



Hole type 2.5×D







Material groups **MU** | HSS PM | UNC UNF | H | 60° | 2P~3P | R45 | X Coating

p.6

Machine Taps

Unit: Inch

Size ØD1	TPI	EDP No.	Limits	Thread Length L1	Overall Length L2	Neck Length L3	Shank Diameter ØD2	Square Size K	Square Length Kl	No. of Flute Z	Tapping Drill Diameter (Ød1) Inch	Metric
1-1/4 -	12	**TRF14888GS**	H8	.833	5.90	3.070	1.021	.766	1.00	4	1-11/64	-
1-3/8 -	6	**TRF14900GS**	H10	1.667	7.87	4.527	1.108	.831	1.06	4	-	31.0
1-3/8 -	8	**TRF14919GS**	H9	1.250	7.87	4.527	1.108	.831	1.06	4	-	32.0
1-3/8 -	12	**TRF14928GS**	H8	.833	6.69	3.582	1.108	.831	1.06	4	-	33.0
1-1/2 -	6	**TRF14940GS**	H10	1.667	7.87	4.527	1.233	.925	1.13	4	1-11/32	-
1-1/2 -	8	**TRF14959GS**	H9	1.250	7.87	4.527	1.233	.925	1.13	4	-	35.0
1-1/2 -	12	**TRF14968GS**	H8	.833	6.69	3.582	1.233	.925	1.13	4	-	36.0

◎ : Excellent ○ : Good

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	○	◎	◎	◎	◎	◎	◎	◎	○	○	○	◎	◎	◎	○	○	◎	◎		

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	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	◎	◎	○	◎	◎	◎													

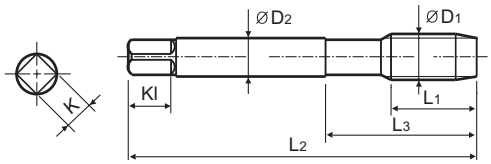
X-Coating, HSS-PM

Spiral Flute Taps for Multipurpose

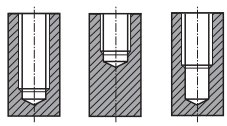
SERIES **TRF04**

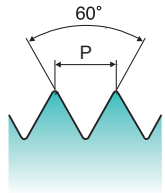
- ▶ High performance on various ductile materials
- ▶ Specially designed to prevent oversized threads and reduce gauging problems

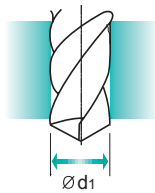
DIN/ANSI



Hole type 2.5×D







Material groups **MU** | HSS PM | M/MF | D | 60° | 2P~3P | R45 | X Coating

p.6

Machine Taps

Unit: Inch

Size	Pitch	EDP No.	Limits	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter (Ød1)	
ØD1	P			L1	L2	L3	ØD2	K	Kl	Z	Inch	Metric
M2 x	0.4	**TRF04132GS**	D2	.126	1.77	.393	.141	.110	.19	2	-	1.6
M2.5 x	0.45	**TRF04173GS**	D3	.126	1.97	.511	.141	.110	.19	2	-	2.1
M3 x	0.5	**TRF04203GS**	D3	.158	2.21	.708	.141	.110	.19	3	-	2.5
M3.5 x	0.6	**TRF04224GS**	D4	.189	2.21	.787	.141	.110	.19	3	-	2.9
M4 x	0.7	**TRF04244GS**	D4	.221	2.48	.823	.168	.131	.25	3	-	3.4
M5 x	0.8	**TRF04284GS**	D4	.252	2.75	.988	.194	.152	.25	3	-	4.3
M6 x	1.0	**TRF04315GS**	D5	.315	3.15	1.177	.255	.191	.31	3	-	5.1
M6 x	0.75	**TRF04324GS**	D4	.315	3.15	1.177	.255	.191	.31	3	-	5.3
M7 x	1.0	**TRF04345GS**	D5	.394	3.15	1.181	.318	.238	.38	3	-	6.1
M8 x	1.25	**TRF04365GS**	D5	.492	3.54	1.378	.318	.238	.38	3	-	6.9
M8 x	1.0	**TRF04375GS**	D5	.394	3.54	1.378	.318	.238	.38	3	-	7.1
M9 x	1.25	**TRF04395GS**	D5	.492	3.54	1.378	.381	.286	.44	3	-	7.9
M9 x	1.0	**TRF04405GS**	D5	.394	3.54	1.378	.381	.286	.44	3	-	8.1
M10 x	1.5	**TRF04426GS**	D6	.591	3.94	1.535	.381	.286	.44	3	-	8.7
M10 x	1.25	**TRF04435GS**	D5	.492	3.94	1.535	.381	.286	.44	3	-	8.9
M10 x	1.0	**TRF04445GS**	D5	.394	3.54	1.378	.381	.286	.44	3	-	9.1
M12 x	1.75	**TRF04506GS**	D6	.689	4.33	1.933	.367	.275	.44	3	-	10.5
M12 x	1.5	**TRF04516GS**	D6	.591	3.94	1.933	.367	.275	.44	3	-	10.7
M12 x	1.25	**TRF04525GS**	D5	.492	3.94	1.933	.367	.275	.44	3	-	10.9
M14 x	2.0	**TRF04547GS**	D7	.787	4.33	1.972	.429	.322	.50	3	-	12.3

▶ NEXT PAGE

◎ : Excellent ○ : Good

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	○	◎	◎	◎	◎	◎	◎	◎	○	○	○	◎	◎	◎	○	○	◎	◎		

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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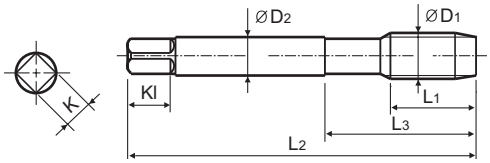
X-Coating, HSS-PM

Spiral Flute Taps for Multipurpose

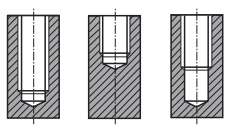
SERIES **TRF04**

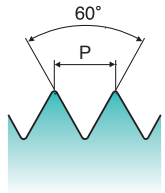
- ▶ High performance on various ductile materials
- ▶ Specially designed to prevent oversized threads and reduce gauging problems

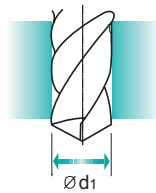
DIN/ANSI



Hole type 2.5×D







Material groups **MU** | HSS PM | M/MF | D | 60° | 2P~3P | R45 | X Coating

p.6

Machine Taps

Unit: Inch

Size	Pitch	EDP No.	Limits	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter (Ød1)	
ØD1	P			L1	L2	L3	ØD2	K	Kl	Z	Inch	Metric
M14 x	1.5	**TRF04556GS**	D6	.591	3.94	1.972	.429	.322	.50	3	-	12.7
M14 x	1.25	**TRF04566GS**	D6	.492	3.94	1.972	.429	.322	.50	3	-	12.9
M16 x	2.0	**TRF04607GS**	D7	.787	4.33	2.126	.480	.360	.56	3	-	14.3
M16 x	1.5	**TRF04616GS**	D6	.591	3.94	2.126	.480	.360	.56	3	-	14.7
M18 x	2.5	**TRF04657GS**	D7	.984	4.92	2.165	.542	.406	.63	4	-	15.8
M18 x	1.5	**TRF04676GS**	D6	.591	4.33	2.165	.542	.406	.63	4	-	16.7
M20 x	2.5	**TRF04708GS**	D8	.984	5.51	2.433	.652	.489	.69	4	-	17.8
M20 x	1.5	**TRF04726GS**	D6	.591	4.92	2.433	.652	.489	.69	4	-	18.7
M22 x	2.5	**TRF04748GS**	D8	.984	5.51	2.653	.697	.523	.75	4	-	19.8
M22 x	1.5	**TRF04766GS**	D6	.591	4.92	2.653	.697	.523	.75	4	-	20.7
M24 x	3.0	**TRF04788GS**	D8	1.181	6.30	2.693	.760	.570	.75	4	27/32	-
M24 x	1.5	**TRF04806GS**	D6	.591	5.51	2.693	.760	.570	.75	4	-	22.7
M27 x	3.0	**TRF04868GS**	D8	1.181	6.30	3.150	.896	.672	.88	4	-	24.4
M27 x	1.5	**TRF04886GS**	D6	.591	5.51	2.362	.896	.672	.88	4	-	25.7
M30 x	3.5	**TRF04949GS**	D9	1.378	7.08	3.937	1.021	.766	1.00	4	-	27.0
M30 x	1.5	**TRF04976GS**	D6	.591	5.90	2.756	1.021	.766	1.00	4	-	28.6

◎ : Excellent ○ : Good

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	○	◎	◎	◎	◎	◎	◎	◎	○	○	○	◎	◎	◎	○	○	◎	◎		

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	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	◎	◎	○	◎	◎	◎													

X-Coating, HSS-PM

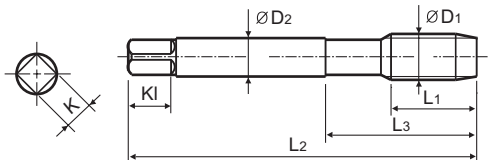
Spiral Flute Taps for Multipurpose

SERIES **TRF34**

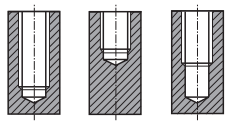
- ▶ High performance on various ductile materials
- ▶ Specially designed to prevent oversized threads and reduce gauging problems

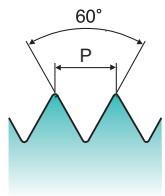
DIN/ANSI

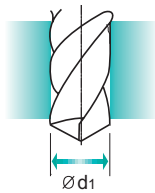
Short Chamfer



Hole type 2.5×D







Material groups **MU** | HSS PM | UNC UNF | H | 60° | 1P~2P | R45 | X Coating

p.6

Machine Taps

Unit: Inch

Size ØD1	TPI	EDP No.	Limits	Thread Length L1	Overall Length L2	Neck Length L3	Shank Diameter ØD2	Square Size K	Square Length Kl	No. of Flute Z	Tapping Drill Diameter (Ød1) Inch	Metric
#4	- 40	**TRF34162GS**	H2	.200	2.21	.708	.141	.110	.19	2	-	2.3
#4	- 48	**TRF34182GS**	H2	.200	2.21	.708	.141	.110	.19	2	3/32	-
#5	- 40	**TRF34202GS**	H2	.200	2.21	.708	.141	.110	.19	3	-	2.6
#6	- 32	**TRF34242GS**	H2	.248	2.21	.783	.141	.110	.19	3	-	2.8
#6	- 32	**TRF34243GS**	H3	.248	2.21	.783	.141	.110	.19	3	-	2.8
#6	- 40	**TRF34262GS**	H2	.248	2.21	.783	.141	.110	.19	3	-	2.9
#8	- 32	**TRF34282GS**	H2	.251	2.48	.826	.168	.131	.25	3	-	3.4
#8	- 32	**TRF34283GS**	H3	.251	2.48	.826	.168	.131	.25	3	-	3.4
#8	- 36	**TRF34302GS**	H2	.251	2.48	.826	.168	.131	.25	3	-	3.5
#10	- 24	**TRF34323GS**	H3	.326	2.75	.976	.194	.152	.25	3	-	3.9
#10	- 32	**TRF34342GS**	H2	.326	2.75	.976	.194	.152	.25	3	-	4.1
#10	- 32	**TRF34343GS**	H3	.326	2.75	.976	.194	.152	.25	3	-	4.1
#12	- 24	**TRF34363GS**	H3	.330	3.15	1.177	.220	.165	.28	3	-	4.5
#12	- 28	**TRF34383GS**	H3	.330	3.15	1.177	.220	.165	.28	3	-	4.7
1/4	- 20	**TRF34403GS**	H3	.397	3.15	1.177	.255	.191	.31	3	-	5.2
1/4	- 20	**TRF34405GS**	H5	.397	3.15	1.177	.255	.191	.31	3	-	5.2
1/4	- 28	**TRF34423GS**	H3	.397	3.15	1.177	.255	.191	.31	3	-	5.5
1/4	- 28	**TRF34424GS**	H4	.397	3.15	1.177	.255	.191	.31	3	-	5.5
5/16	- 18	**TRF34443GS**	H3	.556	3.54	1.377	.318	.238	.38	3	-	6.7
5/16	- 18	**TRF34445GS**	H5	.556	3.54	1.377	.318	.238	.38	3	-	6.7
5/16	- 24	**TRF34463GS**	H3	.417	3.54	1.377	.318	.238	.38	3	-	7.0
5/16	- 24	**TRF34464GS**	H4	.417	3.54	1.377	.318	.238	.38	3	-	7.0

▶ NEXT PAGE

◎ : Excellent ○ : Good

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	○	◎	◎	◎	◎	◎	◎	◎	○	○	○	◎	◎	◎	○	○	◎	◎		

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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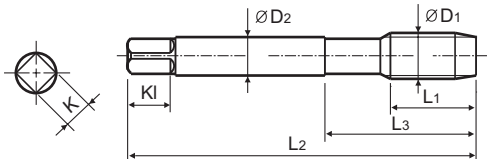
X-Coating, HSS-PM

Spiral Flute Taps for Multipurpose

SERIES **TRF34**

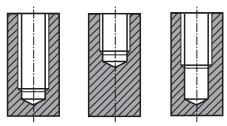
- ▶ High performance on various ductile materials
- ▶ Specially designed to prevent oversized threads and reduce gauging problems

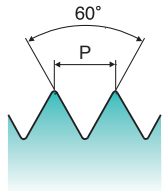
DIN/ANSI

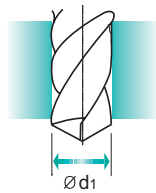


Short Chamfer

Hole type 2.5×D







Material groups **MU** | HSS PM | UNC UNF | H | 60° | 1P~2P | R45 | X Coating

p.6

Machine Taps

Unit: Inch

Size ØD1	TPI	EDP No.	Limits	Thread Length L1	Overall Length L2	Neck Length L3	Shank Diameter ØD2	Square Size K	Square Length Kl	No. of Flute Z	Tapping Drill Diameter (Ød1) Inch	Metric
3/8	- 16	**TRF34483GS**	H3	.625	3.94	1.535	.381	.286	.44	3	-	8.1
3/8	- 16	**TRF34485GS**	H5	.625	3.94	1.535	.381	.286	.44	3	-	8.1
3/8	- 24	**TRF34503GS**	H3	.417	3.94	1.377	.381	.286	.44	3	-	8.6
3/8	- 24	**TRF34504GS**	H4	.417	3.94	1.377	.381	.286	.44	3	-	8.6
7/16	- 14	**TRF34523GS**	H3	.714	3.94	1.712	.323	.242	.41	3	-	9.5
7/16	- 14	**TRF34525GS**	H5	.714	3.94	1.712	.323	.242	.41	3	-	9.5
7/16	- 20	**TRF34543GS**	H3	.500	3.94	1.712	.323	.242	.41	3	-	10.0
7/16	- 20	**TRF34545GS**	H5	.500	3.94	1.712	.323	.242	.41	3	-	10.0
1/2	- 13	**TRF34563GS**	H3	.769	4.33	1.933	.367	.275	.44	3	-	11.0
1/2	- 13	**TRF34565GS**	H5	.769	4.33	1.933	.367	.275	.44	3	-	11.0
1/2	- 20	**TRF34583GS**	H3	.500	3.94	1.933	.367	.275	.44	3	-	11.6
1/2	- 20	**TRF34585GS**	H5	.500	3.94	1.933	.367	.275	.44	3	-	11.6
9/16	- 12	**TRF34603GS**	H3	.833	4.33	1.972	.429	.322	.50	3	-	12.5
9/16	- 12	**TRF34605GS**	H5	.833	4.33	1.972	.429	.322	.50	3	-	12.5
9/16	- 18	**TRF34623GS**	H3	.556	3.94	1.972	.429	.322	.50	3	-	13.0
9/16	- 18	**TRF34625GS**	H5	.556	3.94	1.972	.429	.322	.50	3	-	13.0
5/8	- 11	**TRF34643GS**	H3	.909	4.33	2.125	.480	.360	.56	3	-	13.9
5/8	- 11	**TRF34645GS**	H5	.909	4.33	2.125	.480	.360	.56	3	-	13.9
5/8	- 18	**TRF34663GS**	H3	.556	3.94	2.125	.480	.360	.56	3	-	14.6
5/8	- 18	**TRF34665GS**	H5	.556	3.94	2.125	.480	.360	.56	3	-	14.6

◎ : Excellent ○ : Good

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	○	◎	◎	◎	◎	◎	◎	◎	○	○	○	◎	◎	◎	○	○	◎	◎		

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	○	○	◎	◎	○	◎	◎	◎													

X-Coating, HSS-PM

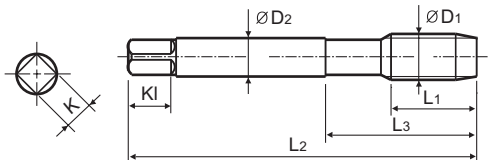
Spiral Flute Taps for Multipurpose

SERIES **TRF24**

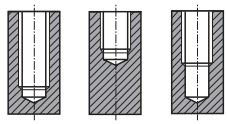
- ▶ High performance on various ductile materials
- ▶ Specially designed to prevent oversized threads and reduce gauging problems

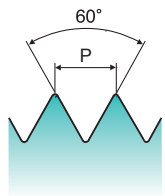
DIN/ANSI

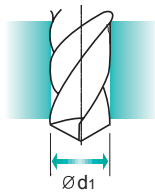
Short Chamfer



Hole type 2.5×D







Material groups **MU** | HSS PM | M/MF | D | 60° | 1P~2P | R45 | X Coating

p.6

Machine Taps

Unit: Inch

Size	Pitch	EDP No.	Limits	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter (Ød1)	
ØD1	P			L1	L2	L3	ØD2	K	Kl	Z	Inch	Metric
M3 x	0.5	**TRF24203GS**	D3	.158	2.21	.708	.141	.110	.19	3	-	2.5
M3.5 x	0.6	**TRF24224GS**	D4	.189	2.21	.787	.141	.110	.19	3	-	2.9
M4 x	0.7	**TRF24244GS**	D4	.221	2.48	.823	.168	.131	.25	3	-	3.4
M5 x	0.8	**TRF24284GS**	D4	.252	2.75	.988	.194	.152	.25	3	-	4.3
M6 x	1.0	**TRF24315GS**	D5	.315	3.15	1.177	.255	.191	.31	3	-	5.1
M8 x	1.25	**TRF24365GS**	D5	.492	3.54	1.378	.318	.238	.38	3	-	6.9
M9 x	1.25	**TRF24395GS**	D5	.492	3.54	1.378	.381	.286	.44	3	-	7.9
M10 x	1.5	**TRF24426GS**	D6	.591	3.94	1.535	.381	.286	.44	3	-	8.7
M10 x	1.25	**TRF24435GS**	D5	.492	3.94	1.535	.381	.286	.44	3	-	8.9
M10 x	1.0	**TRF24445GS**	D5	.394	3.54	1.378	.381	.286	.44	3	-	9.1
M12 x	1.75	**TRF24506GS**	D6	.689	4.33	1.933	.367	.275	.44	3	-	10.5
M12 x	1.5	**TRF24516GS**	D6	.591	3.94	1.933	.367	.275	.44	3	-	10.7
M12 x	1.25	**TRF24525GS**	D5	.492	3.94	1.933	.367	.275	.44	3	-	10.9
M14 x	2.0	**TRF24547GS**	D7	.787	4.33	1.972	.429	.322	.50	3	-	12.3
M14 x	1.5	**TRF24556GS**	D6	.591	3.94	1.972	.429	.322	.50	3	-	12.7
M14 x	1.25	**TRF24566GS**	D6	.492	3.94	1.972	.429	.322	.50	3	-	12.9
M16 x	2.0	**TRF24607GS**	D7	.787	4.33	2.126	.480	.360	.56	3	-	14.3
M16 x	1.5	**TRF24616GS**	D6	.591	3.94	2.126	.480	.360	.56	3	-	14.7
M18 x	1.5	**TRF24676GS**	D6	.591	4.33	2.165	.542	.406	.63	4	-	16.7

◎ : Excellent ○ : Good

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	○	◎	◎	◎	◎	◎	◎	◎	○	○	○	◎	◎	◎	○	○	◎	◎		

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	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	◎	◎	○	◎	◎	◎													

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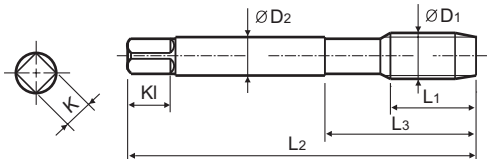
X-Coating, HSS-PM

Spiral Point Taps for Multipurpose

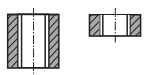
SERIES **TRK14**

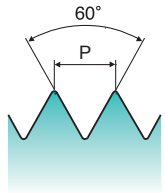
▶ High performance on various ductile materials

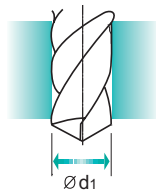
DIN/ANSI



Hole type 3.0×D







Material groups **MU** | HSS PM | UNC UNF | H | 60° | 4P~5P | X Coating

p.6

Machine Taps

Unit: Inch

Size ØD1	TPI	EDP No.	Limits	Thread Length L1	Overall Length L2	Neck Length L3	Shank Diameter ØD2	Square Size K	Square Length Kl	No. of Flute Z	Tapping Drill Diameter (Ød1) Inch	Metric
#2 - 56		TRK14082GS	H2	.437	1.77	.476	.141	.110	.19	2	-	1.8
#2 - 64		TRK14102GS	H2	.437	1.77	.476	.141	.110	.19	2	-	1.8
#3 - 48		TRK14122GS	H2	.500	1.97	.539	.141	.110	.19	2	-	2.0
#3 - 56		TRK14142GS	H2	.500	1.97	.539	.141	.110	.19	2	-	2.1
#4 - 40		TRK14162GS	H2	.335	2.21	.708	.141	.110	.19	2	-	2.3
#4 - 48		TRK14182GS	H2	.335	2.21	.708	.141	.110	.19	2	3/32	-
#5 - 40		TRK14202GS	H2	.374	2.21	.708	.141	.110	.19	3	-	2.6
#5 - 44		TRK14222GS	H2	.374	2.21	.708	.141	.110	.19	3	-	2.6
#6 - 32		TRK14242GS	H2	.413	2.21	.787	.141	.110	.19	3	-	2.8
#6 - 32		TRK14243GS	H3	.413	2.21	.787	.141	.110	.19	3	-	2.8
#6 - 40		TRK14262GS	H2	.413	2.21	.787	.141	.110	.19	3	-	2.9
#8 - 32		TRK14282GS	H2	.453	2.48	.826	.168	.131	.25	3	-	3.4
#8 - 32		TRK14283GS	H3	.453	2.48	.826	.168	.131	.25	3	-	3.4
#8 - 36		TRK14302GS	H2	.453	2.48	.826	.168	.131	.25	3	-	3.5
#10 - 24		TRK14323GS	H3	.531	2.75	.984	.194	.152	.25	3	-	3.9
#10 - 32		TRK14342GS	H2	.531	2.75	.984	.194	.152	.25	3	-	4.1
#10 - 32		TRK14343GS	H3	.531	2.75	.984	.194	.152	.25	3	-	4.1
#12 - 24		TRK14363GS	H3	.571	3.15	1.181	.220	.165	.28	3	-	4.5
#12 - 28		TRK14383GS	H3	.571	3.15	1.181	.220	.165	.28	3	-	4.7

▶ NEXT PAGE

◎ : Excellent ○ : Good

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	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	◎	◎	◎	◎	◎	◎	◎		

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	○	○	◎	◎	○	◎	◎	◎													

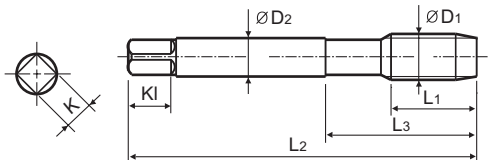
X-Coating, HSS-PM

Spiral Point Taps for Multipurpose

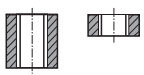
SERIES **TRK14**

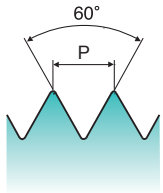
▶ High performance on various ductile materials

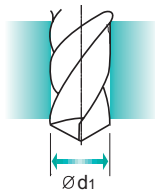
DIN/ANSI



Hole type 3.0×D







Material groups **MU** | HSS PM | UNC UNF | H | 60° | 4P~5P | X Coating

p.6

Machine Taps

Unit: Inch

Size ØD1	TPI	EDP No.	Limits	Thread Length L1	Overall Length L2	Neck Length L3	Shank Diameter ØD2	Square Size K	Square Length Kl	No. of Flute Z	Tapping Drill Diameter (Ød1) Inch	Metric
1/4	- 20	**TRK14403GS**	H3	.591	3.15	1.177	.255	.191	.31	3	-	5.2
1/4	- 20	**TRK14405GS**	H5	.591	3.15	1.177	.255	.191	.31	3	-	5.2
1/4	- 28	**TRK14423GS**	H3	.591	3.15	1.177	.255	.191	.31	3	-	5.5
1/4	- 28	**TRK14424GS**	H4	.591	3.15	1.177	.255	.191	.31	3	-	5.5
5/16	- 18	**TRK14443GS**	H3	.669	3.54	1.377	.318	.238	.38	3	-	6.7
5/16	- 18	**TRK14445GS**	H5	.669	3.54	1.377	.318	.238	.38	3	-	6.7
5/16	- 24	**TRK14463GS**	H3	.669	3.54	1.377	.318	.238	.38	3	-	7.0
5/16	- 24	**TRK14464GS**	H4	.669	3.54	1.377	.318	.238	.38	3	-	7.0
3/8	- 16	**TRK14483GS**	H3	.748	3.94	1.535	.381	.286	.44	3	-	8.1
3/8	- 16	**TRK14485GS**	H5	.748	3.94	1.535	.381	.286	.44	3	-	8.1
3/8	- 24	**TRK14503GS**	H3	.748	3.94	1.377	.381	.286	.44	3	-	8.6
3/8	- 24	**TRK14504GS**	H4	.748	3.94	1.377	.381	.286	.44	3	-	8.6
7/16	- 14	**TRK14523GS**	H3	.866	3.94	1.437	.323	.242	.41	3	-	9.5
7/16	- 14	**TRK14525GS**	H5	.866	3.94	1.437	.323	.242	.41	3	-	9.5
7/16	- 20	**TRK14543GS**	H3	.866	3.94	1.437	.323	.242	.41	3	-	10.0
7/16	- 20	**TRK14545GS**	H5	.866	3.94	1.437	.323	.242	.41	3	-	10.0
1/2	- 13	**TRK14563GS**	H3	.984	4.33	1.657	.367	.275	.44	3	-	11.0
1/2	- 13	**TRK14565GS**	H5	.984	4.33	1.657	.367	.275	.44	3	-	11.0
1/2	- 20	**TRK14583GS**	H3	.984	3.94	1.657	.367	.275	.44	3	-	11.6
1/2	- 20	**TRK14585GS**	H5	.984	3.94	1.657	.367	.275	.44	3	-	11.6

▶ NEXT PAGE

◎ : Excellent ○ : Good

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	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	◎	◎	◎	◎	◎	◎	◎		

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	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	◎	◎	○	◎	◎	◎													

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Spiral Point Taps for Multipurpose

SERIES **TRK14**

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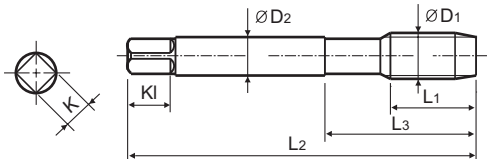
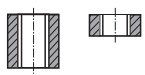
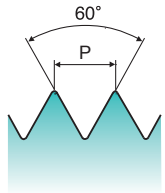
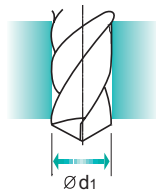
DIN/ANSI



Hole type 3.0×D







Material groups **MU** | HSS PM | UNC UNF | H | 60° | 4P~5P | X Coating

p.6

Machine Taps

Unit: Inch

Size ØD1	TPI	EDP No.	Limits	Thread Length L1	Overall Length L2	Neck Length L3	Shank Diameter ØD2	Square Size K	Square Length Kl	No. of Flute Z	Tapping Drill Diameter (Ød1) Inch	Metric
9/16	12	**TRK14603GS**	H3	.984	4.33	1.657	.429	.322	.50	3	-	12.5
9/16	12	**TRK14605GS**	H5	.984	4.33	1.657	.429	.322	.50	3	-	12.5
9/16	18	**TRK14623GS**	H3	.984	3.94	1.657	.429	.322	.50	3	-	13.0
9/16	18	**TRK14625GS**	H5	.984	3.94	1.657	.429	.322	.50	3	-	13.0
5/8	11	**TRK14643GS**	H3	1.083	4.33	1.811	.480	.360	.56	3	-	13.9
5/8	11	**TRK14645GS**	H5	1.083	4.33	1.811	.480	.360	.56	3	-	13.9
5/8	18	**TRK14663GS**	H3	1.083	3.94	1.811	.480	.360	.56	3	-	14.6
5/8	18	**TRK14665GS**	H5	1.083	3.94	1.811	.480	.360	.56	3	-	14.6
3/4	10	**TRK14703GS**	H3	1.201	4.92	2.000	.590	.442	.69	3	-	16.9
3/4	10	**TRK14705GS**	H5	1.201	4.92	2.000	.590	.442	.69	3	-	16.9
3/4	16	**TRK14723GS**	H3	1.201	4.33	2.000	.590	.442	.69	3	-	17.7
3/4	16	**TRK14725GS**	H5	1.201	4.33	2.000	.590	.442	.69	3	-	17.7
7/8	9	**TRK14744GS**	H4	1.339	5.51	2.224	697	.523	.75	3	-	19.8
7/8	9	**TRK14746GS**	H6	1.339	5.51	2.224	697	.523	.75	3	-	19.8
7/8	14	**TRK14764GS**	H4	1.339	4.92	2.224	697	.523	.75	3	-	20.5
7/8	14	**TRK14766GS**	H6	1.339	4.92	2.224	697	.523	.75	3	-	20.5
1"	8	**TRK14786GS**	H6	1.496	6.30	2.500	.800	.600	.81	3	-	22.7
1"	12	**TRK14806GS**	H6	1.496	5.51	2.500	.800	.600	.81	3	-	23.5
1"	14	**TRK14816GS**	H6	1.496	5.51	2.500	.800	.600	.81	3	-	23.7

◎ : Excellent ○ : Good

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	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	◎	◎	◎	◎	◎	◎	◎		

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	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	◎	◎	○	◎	◎	◎													

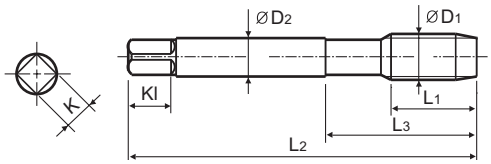
X-Coating, HSS-PM

Spiral Point Taps for Multipurpose

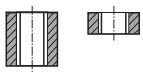
SERIES **TRK04**

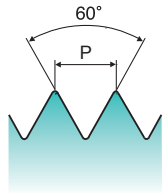
▶ High performance on various ductile materials

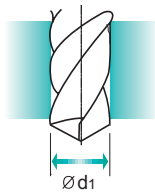
DIN/ANSI



Hole type 3.0×D







Material groups **MU** | HSS PM | M/MF | D | 60° | 4P~5P | X Coating

p.6

Machine Taps

Unit: Inch

Size	Pitch	EDP No.	Limits	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter (Ød1)	
ØD1	P			L1	L2	L3	ØD2	K	Kl	Z	Inch	Metric
M2	x 0.4	**TRK04132GS**	D2	.433	1.77	.472	.141	.110	.19	2	-	1.6
M2.5	x 0.45	**TRK04173GS**	D3	.472	1.97	.539	.141	.110	.19	2	-	2.1
M3	x 0.5	**TRK04203GS**	D3	.374	2.21	.705	.141	.110	.19	3	-	2.5
M3.5	x 0.6	**TRK04224GS**	D4	.413	2.21	.780	.141	.110	.19	3	-	2.9
M4	x 0.7	**TRK04244GS**	D4	.453	2.48	.819	.168	.131	.25	3	-	3.4
M5	x 0.8	**TRK04284GS**	D4	.531	2.75	.976	.194	.152	.25	3	-	4.3
M6	x 1.0	**TRK04315GS**	D5	.591	3.15	1.169	.255	.191	.31	3	-	5.1
M6	x 0.75	**TRK04324GS**	D4	.591	3.15	1.169	.255	.191	.31	3	-	5.3
M7	x 1.0	**TRK04345GS**	D5	.669	3.15	1.169	.318	.238	.38	3	-	6.1
M8	x 1.25	**TRK04365GS**	D5	.669	3.54	1.366	.318	.238	.38	3	-	6.9
M8	x 1.0	**TRK04375GS**	D5	.669	3.54	1.366	.318	.238	.38	3	-	7.1
M9	x 1.25	**TRK04395GS**	D5	.669	3.54	1.370	.381	.286	.44	3	-	7.9
M9	x 1.0	**TRK04405GS**	D5	.669	3.54	1.370	.381	.286	.44	3	-	8.1
M10	x 1.5	**TRK04426GS**	D6	.748	3.94	1.531	.381	.286	.44	3	-	8.7
M10	x 1.25	**TRK04435GS**	D5	.748	3.94	1.531	.381	.286	.44	3	-	8.9
M10	x 1.0	**TRK04445GS**	D5	.748	3.54	1.370	.381	.286	.44	3	-	9.1
M12	x 1.75	**TRK04506GS**	D6	.984	4.33	1.657	.367	.275	.44	3	-	10.5
M12	x 1.5	**TRK04516GS**	D6	.984	3.94	1.657	.367	.275	.44	3	-	10.7
M12	x 1.25	**TRK04525GS**	D5	.984	3.94	1.657	.367	.275	.44	3	-	10.9

▶ NEXT PAGE

◎ : Excellent ○ : Good

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	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	◎	◎	◎	◎	◎	◎	◎		

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	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	◎	◎	○	◎	◎	◎													

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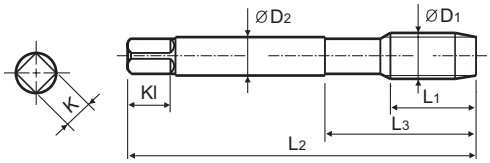
X-Coating, HSS-PM

Spiral Point Taps for Multipurpose

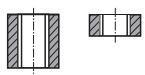
SERIES **TRK04**

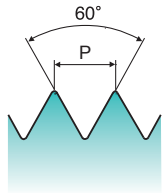
▶ High performance on various ductile materials

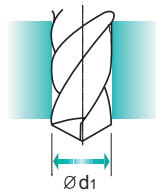
DIN/ANSI



Hole type 3.0×D







Material groups **MU** | HSS PM | M/MF | D | 60° | 4P~5P | X Coating

p.6

Machine Taps

Unit: Inch

Size	Pitch	EDP No.	Limits	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter (Ød1)	
ØD1	P			L1	L2	L3	ØD2	K	Kl	Z	Inch	Metric
M14 x	2.0	**TRK04547GS**	D7	.984	4.33	1.657	.429	.322	.50	3	-	12.3
M14 x	1.5	**TRK04556GS**	D6	.984	3.94	1.657	.429	.322	.50	3	-	12.7
M14 x	1.25	**TRK04566GS**	D6	.984	3.94	1.657	.429	.322	.50	3	-	12.9
M16 x	2.0	**TRK04607GS**	D7	1.083	4.33	1.811	.480	.360	.56	3	-	14.3
M16 x	1.5	**TRK04616GS**	D6	1.083	3.94	1.811	.480	.360	.56	3	-	14.7
M18 x	2.5	**TRK04657GS**	D7	1.083	4.92	1.811	.542	.406	.63	3	-	15.8
M18 x	1.5	**TRK04676GS**	D6	1.083	4.33	1.811	.542	.406	.63	3	-	16.7
M20 x	2.5	**TRK04708GS**	D8	1.201	5.51	2.126	.652	.489	.69	3	-	17.8
M20 x	1.5	**TRK04726GS**	D6	1.201	4.92	2.000	.652	.489	.69	3	-	18.7
M22 x	2.5	**TRK04748GS**	D8	1.339	5.51	2.126	.697	.523	.75	3	-	19.8
M22 x	1.5	**TRK04766GS**	D6	1.339	4.92	2.000	.697	.523	.75	3	-	20.7
M24 x	3.0	**TRK04788GS**	D8	1.339	6.30	2.362	.760	.570	.75	3	27/32	-
M24 x	1.5	**TRK04806GS**	D6	1.339	5.51	2.126	.760	.570	.75	3	-	22.7

◎ : Excellent ○ : Good

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	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	◎	◎	◎	◎	◎	◎	◎		

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	○	○	◎	◎	○	◎	◎	◎													

X-Coating, HSS-PM

Spiral Flute Taps for Multipurpose

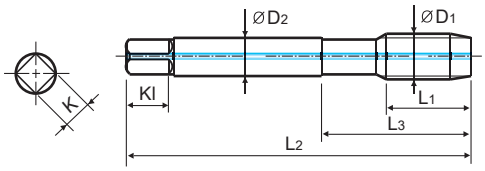
NEW SERIES

TRF25

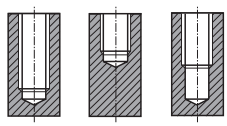
- ▶ High performance on various ductile materials
- ▶ Specially designed to prevent oversized threads and reduce gauging problems

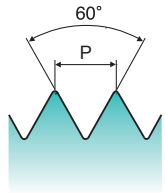
DIN/ANSI

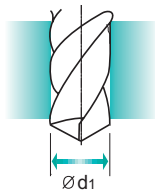
with Internal Coolant



Hole type 2.5×D







Material groups **MU** | HSS PM | UNC UNF | H | 60° | 2P~3P | R45 | X Coating

p.7

Machine Taps

Unit: Inch

Size ØD1	TPI	EDP No.	Limits	Thread Length L1	Overall Length L2	Neck Length L3	Shank Diameter ØD2	Square Size K	Square Length Kl	No. of Flute Z	Tapping Drill Diameter (Ød1) Inch	Metric
1/4	- 20UNC	**TRF25403GS**	H3	.500	3.15	1.177	.255	.191	.31	3	-	5.2
1/4	- 20UNC	**TRF25405GS**	H5	.500	3.15	1.177	.255	.191	.31	3	-	5.2
1/4	- 28UNF	**TRF25423GS**	H3	.358	3.15	1.177	.255	.191	.31	3	-	5.5
1/4	- 28UNF	**TRF25424GS**	H4	.358	3.15	1.177	.255	.191	.31	3	-	5.5
5/16	- 18UNC	**TRF25443GS**	H3	.555	3.54	1.377	.318	.238	.38	3	-	6.7
5/16	- 18UNC	**TRF25445GS**	H5	.555	3.54	1.377	.318	.238	.38	3	-	6.7
5/16	- 24UNF	**TRF25463GS**	H3	.417	3.54	1.377	.318	.238	.38	3	-	7.0
5/16	- 24UNF	**TRF25464GS**	H4	.417	3.54	1.377	.318	.238	.38	3	-	7.0
3/8	- 16UNC	**TRF25483GS**	H3	.626	3.94	1.535	.381	.286	.44	3	-	8.1
3/8	- 16UNC	**TRF25485GS**	H5	.626	3.94	1.535	.381	.286	.44	3	-	8.1
3/8	- 24UNF	**TRF25503GS**	H3	.417	3.94	1.535	.381	.286	.44	3	-	8.6
3/8	- 24UNF	**TRF25504GS**	H4	.417	3.94	1.535	.381	.286	.44	3	-	8.6
7/16	- 14UNC	**TRF25523GS**	H3	.713	3.94	1.712	.323	.242	.41	3	-	9.5
7/16	- 14UNC	**TRF25525GS**	H5	.713	3.94	1.712	.323	.242	.41	3	-	9.5
7/16	- 20UNF	**TRF25543GS**	H3	.500	3.94	1.712	.323	.242	.41	3	-	10.0
7/16	- 20UNF	**TRF25545GS**	H5	.500	3.94	1.712	.323	.242	.41	3	-	10.0
1/2	- 13UNC	**TRF25563GS**	H3	.768	4.33	1.933	.367	.275	.44	3	-	11.0
1/2	- 13UNC	**TRF25565GS**	H5	.768	4.33	1.933	.367	.275	.44	3	-	11.0
1/2	- 20UNF	**TRF25583GS**	H3	.500	3.94	1.933	.367	.275	.44	3	-	11.6
1/2	- 20UNF	**TRF25585GS**	H5	.500	3.94	1.933	.367	.275	.44	3	-	11.6

▶ NEXT PAGE

◎ : Excellent ○ : Good

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	○	◎	◎	◎	◎	◎	◎	◎	○	○	○	◎	◎	◎	○	○	◎	◎		

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	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	◎	◎	○	◎	◎	◎													

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X-Coating, HSS-PM

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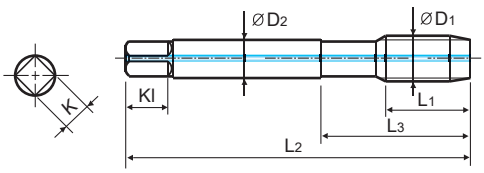
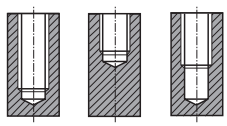
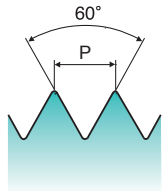
DIN/ANSI

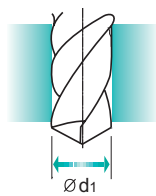
with Internal Coolant



Hole type 2.5×D







Material groups **MU** | HSS PM | UNC UNF | H | 60° | 2P~3P | R45 | X Coating

p.7

Machine Taps

Unit: Inch

Size ØD1	TPI	EDP No.	Limits	Thread Length L1	Overall Length L2	Neck Length L3	Shank Diameter ØD2	Square Size K	Square Length Kl	No. of Flute Z	Tapping Drill Diameter (Ød1) Inch	Metric
9/16	- 12UNC	**TRF25603GS**	H3	.835	4.33	1.972	.429	.322	.50	3	-	12.5
9/16	- 12UNC	**TRF25605GS**	H5	.835	4.33	1.972	.429	.322	.50	3	-	12.5
9/16	- 18UNF	**TRF25623GS**	H3	.555	3.94	1.972	.429	.322	.50	3	-	13.0
9/16	- 18UNF	**TRF25625GS**	H5	.555	3.94	1.972	.429	.322	.50	3	-	13.0
5/8	- 11UNC	**TRF25643GS**	H3	.909	4.33	2.125	.480	.360	.56	3	-	13.9
5/8	- 11UNC	**TRF25645GS**	H5	.909	4.33	2.125	.480	.360	.56	3	-	13.9
5/8	- 18UNF	**TRF25663GS**	H3	.555	3.94	2.125	.480	.360	.56	3	-	14.6
5/8	- 18UNF	**TRF25665GS**	H5	.555	3.94	2.125	.480	.360	.56	3	-	14.6
3/4	- 10UNC	**TRF25703GS**	H3	1.000	4.92	2.433	.590	.442	.69	4	-	16.9
3/4	- 10UNC	**TRF25705GS**	H5	1.000	4.92	2.433	.590	.442	.69	4	-	16.9
3/4	- 16UNF	**TRF25723GS**	H3	.626	4.33	2.433	.590	.442	.69	4	-	17.7
3/4	- 16UNF	**TRF25725GS**	H5	.626	4.33	2.433	.590	.442	.69	4	-	17.7
7/8	- 9UNC	**TRF25744GS**	H4	1.110	5.51	2.654	.697	.523	.75	4	-	19.8
7/8	- 9UNC	**TRF25746GS**	H6	1.110	5.51	2.654	.697	.523	.75	4	-	19.8
7/8	- 14UNF	**TRF25764GS**	H4	.713	4.92	2.654	.697	.523	.75	4	-	20.5
7/8	- 14UNF	**TRF25766GS**	H6	.713	4.92	2.654	.697	.523	.75	4	-	20.5
1"	- 8UNC	**TRF25786GS**	H6	1.252	6.30	3.012	.800	.600	.81	4	-	22.7
1"	- 8UNC	**TRF25784GS**	H4	1.252	6.30	3.012	.800	.600	.81	4	-	22.7
1"	- 12UNF	**TRF25804GS**	H4	.835	5.51	3.012	.800	.600	.81	4	-	23.5
1"	- 12UNF	**TRF25806GS**	H6	.835	5.51	3.012	.800	.600	.81	4	-	23.5

▶ NEXT PAGE

◎ : Excellent ○ : Good

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	○	◎	◎	◎	◎	◎	◎	◎	○	○	○	◎	◎	◎	○	○	◎	◎		

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	○	○	◎	◎	○	◎	◎	◎													

X-Coating, HSS-PM

Spiral Flute Taps for Multipurpose

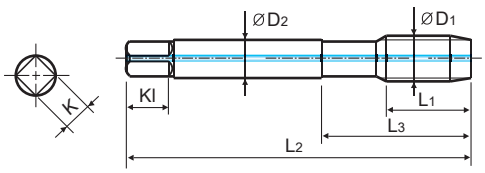
NEW SERIES

TRF25

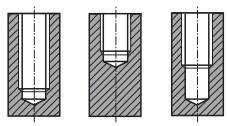
- ▶ High performance on various ductile materials
- ▶ Specially designed to prevent oversized threads and reduce gauging problems

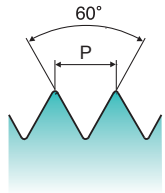
DIN/ANSI

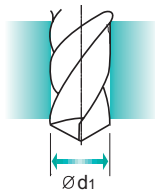
with Internal Coolant



Hole type 2.5×D







Material groups **MU** | HSS PM | UNC UNF | H | 60° | 2P~3P | R45 | X Coating

p.7

Machine Taps

Unit: Inch

Size ØD1	TPI	EDP No.	Limits	Thread Length L1	Overall Length L2	Neck Length L3	Shank Diameter ØD2	Square Size K	Square Length Kl	No. of Flute Z	Tapping Drill Diameter (Ød1) Inch	Metric
1"	- 14UNS	**TRF25816GS**	H6	.713	5.51	3.012	.800	.600	.81	4	-	23.7
1-1/8	- 7UNC	**TRF25829GS**	H9	1.429	7.09	3.819	.896	.672	.88	4	-	25.5
1-1/8	- 8UN	**TRF25839GS**	H9	1.252	7.09	3.819	.896	.672	.88	4	-	25.7
1-1/8	- 12UNF	**TRF25848GS**	H8	.835	5.91	3.071	.896	.672	.88	4	1-3/64	-
1-1/4	- 7UNC	**TRF25860GS**	H10	1.429	7.09	3.937	1.021	.766	1.00	4	-	28.5
1-1/4	- 8UN	**TRF25879GS**	H9	1.252	7.09	3.937	1.021	.766	1.00	4	-	29.0
1-1/4	- 12UNF	**TRF25888GS**	H8	.835	5.91	3.071	1.021	.766	1.00	4	1-11/64	-
1-3/8	- 6UNC	**TRF25900GS**	H10	1.665	7.87	4.528	1.108	.831	1.06	4	-	31.0
1-3/8	- 8UN	**TRF25919GS**	H9	1.252	7.87	4.528	1.108	.831	1.06	4	-	32.0
1-3/8	- 12UNF	**TRF25928GS**	H8	.835	6.69	3.583	1.108	.831	1.06	4	-	33.0
1-1/2	- 6UNC	**TRF25940GS**	H10	1.665	7.87	4.528	1.233	.925	1.13	4	1-11/32	-
1-1/2	- 8UN	**TRF25959GS**	H9	1.252	7.87	4.528	1.233	.925	1.13	4	-	35.0
1-1/2	- 12UNF	**TRF25968GS**	H8	.835	6.69	3.583	1.233	.925	1.13	4	-	36.0

◎ : Excellent ○ : Good

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	○	◎	◎	◎	◎	◎	◎	◎	○	○	○	◎	◎	◎	○	○	◎	◎		

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	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	◎	◎	○	◎	◎	◎													

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X-Coating, HSS-PM

Spiral Flute Taps for Multipurpose

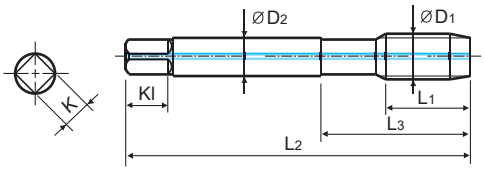
NEW SERIES

TRF26

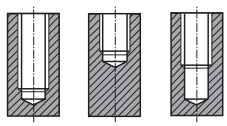
▶ High performance on various ductile materials
▶ Specially designed to prevent oversized threads and reduce gauging problems

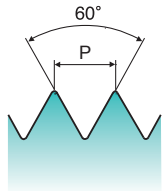
DIN/ANSI

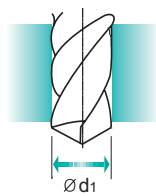
with Internal Coolant



Hole type 2.5×D







Material groups **MU** | HSS PM | M/MF | D | 60° | 2P~3P | R45 | X Coating

p.7

Machine Taps

Unit: Inch

Size ØD1	Pitch P	EDP No.	Limits	Thread Length L1	Overall Length L2	Neck Length L3	Shank Diameter ØD2	Square Size K	Square Length Kl	No. of Flute Z	Tapping Drill Diameter (Ød1) Inch	Metric
M6	x 1.0	**TRF26315GS**	D5	.394	3.15	1.177	.255	.191	.31	3	-	5.1
M6	x 0.75	**TRF26324GS**	D4	.315	3.15	1.177	.255	.191	.31	3	-	5.3
M7	x 1.0	**TRF26345GS**	D5	.394	3.15	1.181	.318	.238	.38	3	-	6.1
M8	x 1.25	**TRF26365GS**	D5	.492	3.54	1.378	.318	.238	.38	3	-	6.9
M8	x 1.0	**TRF26375GS**	D5	.394	3.54	1.378	.318	.238	.38	3	-	7.1
M9	x 1.25	**TRF26395GS**	D5	.492	3.54	1.378	.381	.286	.44	3	-	7.9
M9	x 1.0	**TRF26405GS**	D5	.394	3.54	1.378	.381	.286	.44	3	-	8.1
M10	x 1.5	**TRF26426GS**	D6	.591	3.94	1.535	.381	.286	.44	3	-	8.7
M10	x 1.25	**TRF26435GS**	D5	.492	3.94	1.535	.381	.286	.44	3	-	8.9
M10	x 1.0	**TRF26445GS**	D5	.394	3.54	1.378	.381	.286	.44	3	-	9.1
M12	x 1.75	**TRF26506GS**	D6	.689	4.33	1.933	.367	.275	.44	3	-	10.5
M12	x 1.5	**TRF26516GS**	D6	.591	3.94	1.933	.367	.275	.44	3	-	10.7
M12	x 1.25	**TRF26525GS**	D5	.492	3.94	1.933	.367	.275	.44	3	-	10.9
M14	x 2.0	**TRF26547GS**	D7	.787	4.33	1.972	.429	.322	.50	3	-	12.3
M14	x 1.5	**TRF26556GS**	D6	.591	3.94	1.972	.429	.322	.50	3	-	12.7
M14	x 1.25	**TRF26566GS**	D6	.492	3.94	1.972	.429	.322	.50	3	-	12.9
M16	x 2.0	**TRF26607GS**	D7	.787	4.33	2.126	.480	.360	.56	3	-	14.3
M16	x 1.5	**TRF26616GS**	D6	.591	3.94	2.126	.480	.360	.56	3	-	14.7
M18	x 2.5	**TRF26657GS**	D7	.984	4.92	2.165	.542	.406	.63	4	-	15.8
M18	x 1.5	**TRF26676GS**	D6	.591	4.33	2.165	.542	.406	.63	4	-	16.7

▶ NEXT PAGE

◎ : Excellent ○ : Good

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	○	◎	◎	◎	◎	◎	◎	◎	○	○	○	◎	◎	◎	○	○	◎	◎		

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	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	◎	◎	○	◎	◎	◎													

X-Coating, HSS-PM

Spiral Flute Taps for Multipurpose

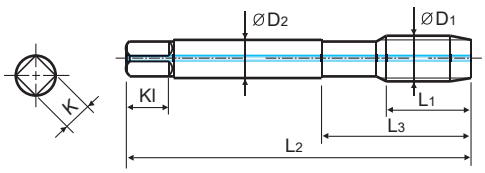
NEW SERIES

TRF26

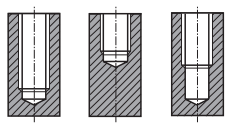
- ▶ High performance on various ductile materials
- ▶ Specially designed to prevent oversized threads and reduce gauging problems

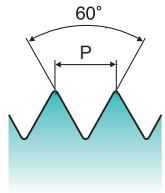
DIN/ANSI

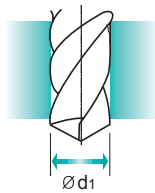
with Internal Coolant



Hole type 2.5×D







Material groups **MU** | HSS PM | M/MF | D | 60° | 2P~3P | R45 | X Coating

p.7

Machine Taps

Unit: Inch

Size	Pitch	EDP No.	Limits	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter (Ød1)	
ØD1	P			L1	L2	L3	ØD2	K	Kl	Z	Inch	Metric
M20 x 2.5		**TRF26708GS**	D8	.984	5.51	2.433	.652	.489	.69	4	-	17.8
M20 x 1.5		**TRF26726GS**	D6	.591	4.92	2.433	.652	.489	.69	4	-	18.7
M22 x 2.5		**TRF26748GS**	D8	.984	5.51	2.653	.697	.523	.75	4	-	19.8
M22 x 1.5		**TRF26766GS**	D6	.591	4.92	2.653	.697	.523	.75	4	-	20.7
M24 x 3.0		**TRF26788GS**	D8	1.181	6.30	2.693	.760	.570	.75	4	27/32	-
M24 x 1.5		**TRF26806GS**	D6	.591	5.51	2.693	.760	.570	.75	4	-	22.7
M27 x 3.0		**TRF26868GS**	D8	1.181	6.30	3.150	.896	.672	.88	4	-	24.4
M27 x 1.5		**TRF26886GS**	D6	.591	5.51	2.362	.896	.672	.88	4	-	25.7
M30 x 3.5		**TRF26949GS**	D9	1.378	7.09	3.937	1.021	.766	1.00	4	-	27.0
M30 x 1.5		**TRF26976GS**	D6	.591	5.91	2.756	1.021	.766	1.00	4	-	28.6

◎ : Excellent ○ : Good

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	○	◎	◎	◎	◎	◎	◎	◎	○	○	○	◎	◎	◎	○	○	◎	◎		

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	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	◎	◎	○	◎	◎	◎													

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Spiral Flute Taps for Multipurpose

NEW SERIES

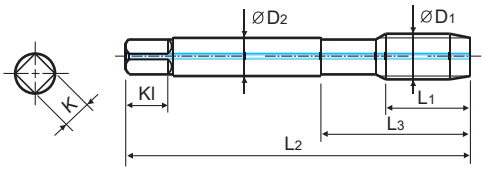
TRF27

▶ High performance on various ductile materials
▶ Specially designed to prevent oversized threads and reduce gauging problems

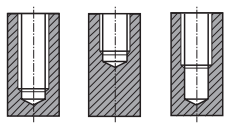
DIN/ANSI

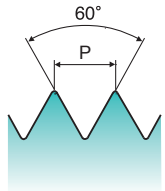
Short Chamfer

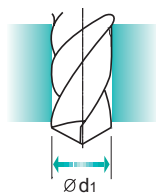
with Internal Coolant



Hole type 2.5×D







Material groups **MU** | HSS PM | UNC UNF | H | 60° | 1P~2P | R45 | X Coating

p.7

Machine Taps

Unit: Inch

Size ØD1	TPI	EDP No.	Limits	Thread Length L1	Overall Length L2	Neck Length L3	Shank Diameter ØD2	Square Size K	Square Length Kl	No. of Flute Z	Tapping Drill Diameter (Ød1) Inch	Metric
1/4	- 20UNC	**TRF27403GS**	H3	.500	3.15	1.177	.255	.191	.31	3	-	5.2
1/4	- 20UNC	**TRF27405GS**	H5	.500	3.15	1.177	.255	.191	.31	3	-	5.2
1/4	- 28UNF	**TRF27423GS**	H3	.358	3.15	1.177	.255	.191	.31	3	-	5.5
1/4	- 28UNF	**TRF27424GS**	H4	.358	3.15	1.177	.255	.191	.31	3	-	5.5
5/16	- 18UNC	**TRF27443GS**	H3	.555	3.54	1.377	.318	.238	.38	3	-	6.7
5/16	- 18UNC	**TRF27445GS**	H5	.555	3.54	1.377	.318	.238	.38	3	-	6.7
5/16	- 24UNF	**TRF27463GS**	H3	.417	3.54	1.377	.318	.238	.38	3	-	7.0
5/16	- 24UNF	**TRF27464GS**	H4	.417	3.54	1.377	.318	.238	.38	3	-	7.0
3/8	- 16UNC	**TRF27483GS**	H3	.626	3.94	1.535	.381	.286	.44	3	-	8.1
3/8	- 16UNC	**TRF27485GS**	H5	.626	3.94	1.535	.381	.286	.44	3	-	8.1
3/8	- 24UNF	**TRF27503GS**	H3	.417	3.94	1.535	.381	.286	.44	3	-	8.6
3/8	- 24UNF	**TRF27504GS**	H4	.417	3.94	1.535	.381	.286	.44	3	-	8.6
7/16	- 14UNC	**TRF27523GS**	H3	.713	3.94	1.712	.323	.242	.41	3	-	9.5
7/16	- 14UNC	**TRF27525GS**	H5	.713	3.94	1.712	.323	.242	.41	3	-	9.5
7/16	- 20UNF	**TRF27543GS**	H3	.500	3.94	1.712	.323	.242	.41	3	-	10.0
7/16	- 20UNF	**TRF27545GS**	H5	.500	3.94	1.712	.323	.242	.41	3	-	10.0
1/2	- 13UNC	**TRF27563GS**	H3	.768	4.33	1.933	.367	.275	.44	3	-	11.0
1/2	- 13UNC	**TRF27565GS**	H5	.768	4.33	1.933	.367	.275	.44	3	-	11.0
1/2	- 20UNF	**TRF27583GS**	H3	.500	3.94	1.933	.367	.275	.44	3	-	11.6
1/2	- 20UNF	**TRF27585GS**	H5	.500	3.94	1.933	.367	.275	.44	3	-	11.6

▶ NEXT PAGE

◎ : Excellent ○ : Good

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	○	◎	◎	◎	◎	◎	◎	◎	○	○	○	◎	◎	◎	○	○	◎	◎		

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	○	○	◎	◎	○	◎	◎	◎													

X-Coating, HSS-PM

Spiral Flute Taps for Multipurpose

NEW SERIES

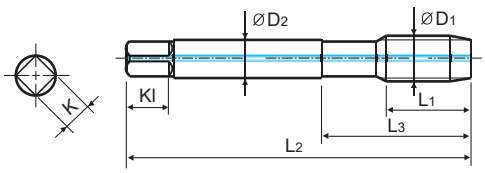
TRF27

- ▶ High performance on various ductile materials
- ▶ Specially designed to prevent oversized threads and reduce gauging problems

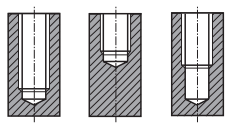
DIN/ANSI

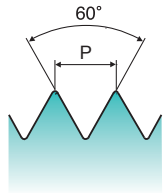
Short Chamfer

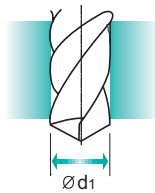
with Internal Coolant



Hole type 2.5×D







Material groups **MU** | HSS PM | UNC UNF | H | 60° | 1P~2P | R45 | X Coating

p.7

Machine Taps

Unit: Inch

Size ØD1	TPI	EDP No.	Limits	Thread Length L1	Overall Length L2	Neck Length L3	Shank Diameter ØD2	Square Size K	Square Length Kl	No. of Flute Z	Tapping Drill Diameter (Ød1) Inch	Metric
9/16	- 12UNC	**TRF27603GS**	H3	.835	4.33	1.972	.429	.322	.50	3	-	12.5
9/16	- 12UNC	**TRF27605GS**	H5	.835	4.33	1.972	.429	.322	.50	3	-	12.5
9/16	- 18UNF	**TRF27623GS**	H3	.555	3.94	1.972	.429	.322	.50	3	-	13.0
9/16	- 18UNF	**TRF27625GS**	H5	.555	3.94	1.972	.429	.322	.50	3	-	13.0
5/8	- 11UNC	**TRF27643GS**	H3	.909	4.33	2.125	.480	.360	.56	3	-	13.9
5/8	- 11UNC	**TRF27645GS**	H5	.909	4.33	2.125	.480	.360	.56	3	-	13.9
5/8	- 18UNF	**TRF27663GS**	H3	.555	3.94	2.125	.480	.360	.56	3	-	14.6
5/8	- 18UNF	**TRF27665GS**	H5	.555	3.94	2.125	.480	.360	.56	3	-	14.6

◎ : Excellent ○ : Good

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	○	◎	◎	◎	◎	◎	◎	◎	○	○	○	◎	◎	◎	○	○	◎	◎		

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	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	◎	◎	○	◎	◎	◎													

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X-Coating, HSS-PM

Spiral Flute Taps for Multipurpose

NEW SERIES

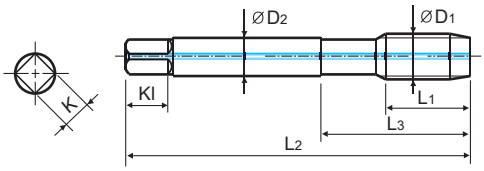
TRF28

▶ High performance on various ductile materials
▶ Specially designed to prevent oversized threads and reduce gauging problems

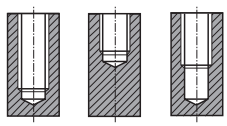
DIN/ANSI

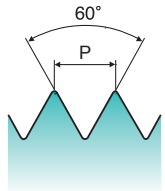
Short Chamfer

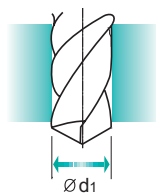
with Internal Coolant



Hole type 2.5×D







Material groups **MU** | HSS PM | M/MF | D | 60° | 1P~2P | R45 | X Coating

p.7

Machine Taps

Unit: Inch

Size	Pitch	EDP No.	Limits	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter (Ød1)	
ØD1	P			L1	L2	L3	ØD2	K	Kl	Z	Inch	Metric
M6 x	1.0	**TRF28315GS**	D5	.394	3.15	1.177	.255	.191	.31	3	-	5.1
M8 x	1.25	**TRF28365GS**	D5	.492	3.54	1.378	.318	.238	.38	3	-	6.9
M9 x	1.25	**TRF28395GS**	D5	.492	3.54	1.378	.381	.286	.44	3	-	7.9
M10 x	1.5	**TRF28426GS**	D6	.591	3.94	1.535	.381	.286	.44	3	-	8.7
M10 x	1.25	**TRF28435GS**	D5	.492	3.94	1.535	.381	.286	.44	3	-	8.9
M10 x	1.0	**TRF28445GS**	D5	.394	3.54	1.378	.381	.286	.44	3	-	9.1
M12 x	1.75	**TRF28506GS**	D6	.689	4.33	1.933	.367	.275	.44	3	-	10.5
M12 x	1.5	**TRF28516GS**	D6	.591	3.94	1.933	.367	.275	.44	3	-	10.7
M12 x	1.25	**TRF28525GS**	D5	.492	3.94	1.933	.367	.275	.44	3	-	10.9
M14 x	2.0	**TRF28547GS**	D7	.787	4.33	1.972	.429	.322	.50	3	-	12.3
M14 x	1.5	**TRF28556GS**	D6	.591	3.94	1.972	.429	.322	.50	3	-	12.7
M14 x	1.25	**TRF28566GS**	D6	.492	3.94	1.972	.429	.322	.50	3	-	12.9
M16 x	2.0	**TRF28607GS**	D7	.787	4.33	2.126	.480	.360	.56	3	-	14.3
M16 x	1.5	**TRF28616GS**	D6	.591	3.94	2.126	.480	.360	.56	3	-	14.7
M18 x	1.5	**TRF28676GS**	D6	.591	4.33	2.165	.542	.406	.63	4	-	16.7

◎ : Excellent ○ : Good

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	○	◎	◎	◎	◎	◎	◎	◎	○	○	○	◎	◎	◎	○	○	◎	◎		

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	○	○	◎	◎	○	◎	◎	◎													

X-Coating, HSS-PM

Spiral Point Taps for Multipurpose

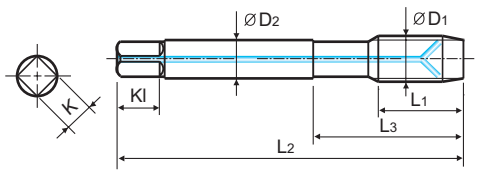
NEW SERIES

TRK15

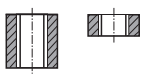
▶ High performance on various ductile materials

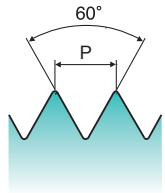
DIN/ANSI

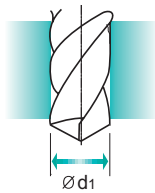
with Internal Coolant



Hole type 3.0×D







Material groups **MU** | HSS PM | UNC UNF | H | 60° | 4P~5P | X Coating

p.7

Machine Taps

Unit: Inch

Size ØD1	TPI	EDP No.	Limits	Thread Length L1	Overall Length L2	Neck Length L3	Shank Diameter ØD2	Square Size K	Square Length Kl	No. of Flute Z	Tapping Drill Diameter (Ød1) Inch	Metric
1/4	- 20UNC	**TRK15403GSP**	H3	.591	3.15	1.177	.255	.191	.31	3	-	5.2
1/4	- 20UNC	**TRK15405GSP**	H5	.591	3.15	1.177	.255	.191	.31	3	-	5.2
1/4	- 28UNF	**TRK15423GSP**	H3	.591	3.15	1.177	.255	.191	.31	3	-	5.5
1/4	- 28UNF	**TRK15424GSP**	H4	.591	3.15	1.177	.255	.191	.31	3	-	5.5
5/16	- 18UNC	**TRK15443GSP**	H3	.669	3.54	1.377	.318	.238	.38	3	-	6.7
5/16	- 18UNC	**TRK15445GSP**	H5	.669	3.54	1.377	.318	.238	.38	3	-	6.7
5/16	- 24UNF	**TRK15463GSP**	H3	.669	3.54	1.377	.318	.238	.38	3	-	7.0
5/16	- 24UNF	**TRK15464GSP**	H4	.669	3.54	1.377	.318	.238	.38	3	-	7.0
3/8	- 16UNC	**TRK15483GSP**	H3	.748	3.94	1.535	.381	.286	.44	3	-	8.1
3/8	- 16UNC	**TRK15485GSP**	H5	.748	3.94	1.535	.381	.286	.44	3	-	8.1
3/8	- 24UNF	**TRK15503GSP**	H3	.748	3.94	1.535	.381	.286	.44	3	-	8.6
3/8	- 24UNF	**TRK15504GSP**	H4	.748	3.94	1.535	.381	.286	.44	3	-	8.6
7/16	- 14UNC	**TRK15523GSP**	H3	.866	3.94	1.712	.323	.242	.41	3	-	9.5
7/16	- 14UNC	**TRK15525GSP**	H5	.866	3.94	1.712	.323	.242	.41	3	-	9.5
7/16	- 20UNF	**TRK15543GSP**	H3	.866	3.94	1.712	.323	.242	.41	3	-	10.0
7/16	- 20UNF	**TRK15545GSP**	H5	.866	3.94	1.712	.323	.242	.41	3	-	10.0
1/2	- 13UNC	**TRK15563GSP**	H3	.984	4.33	1.933	.367	.275	.44	3	-	11.0
1/2	- 13UNC	**TRK15565GSP**	H5	.984	4.33	1.933	.367	.275	.44	3	-	11.0
1/2	- 20UNF	**TRK15583GSP**	H3	.984	3.94	1.933	.367	.275	.44	3	-	11.6
1/2	- 20UNF	**TRK15585GSP**	H5	.984	3.94	1.933	.367	.275	.44	3	-	11.6

▶ NEXT PAGE

◎ : Excellent ○ : Good

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	◎	◎	◎	◎	◎	◎	◎	◎	○	○	○	◎	◎	◎	○	○	◎	◎		

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	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	◎	◎	○	◎	◎	◎													

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X-Coating, HSS-PM

Spiral Point Taps for Multipurpose

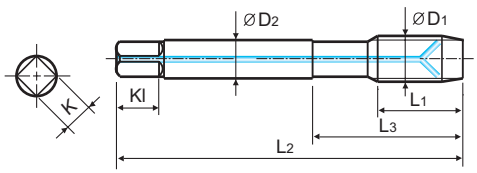
NEW SERIES

TRK15

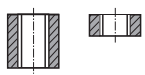
▶ High performance on various ductile materials

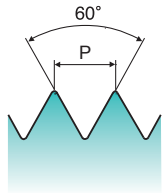
DIN/ANSI

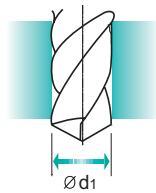
with Internal Coolant



Hole type 3.0×D







Material groups **MU** | HSS PM | UNC UNF | H | 60° | 4P~5P | X Coating

p.7

Machine Taps

Unit: Inch

Size ØD1	TPI	EDP No.	Limits	Thread Length L1	Overall Length L2	Neck Length L3	Shank Diameter ØD2	Square Size K	Square Length Kl	No. of Flute Z	Tapping Drill Diameter (Ød1) Inch	Metric
9/16	- 12UNC	**TRK15603GSP**	H3	.984	4.33	1.972	.429	.322	.50	3	-	12.5
9/16	- 12UNC	**TRK15605GSP**	H5	.984	4.33	1.972	.429	.322	.50	3	-	12.5
9/16	- 18UNF	**TRK15623GSP**	H3	.984	3.94	1.972	.429	.322	.50	3	-	13.0
9/16	- 18UNF	**TRK15625GSP**	H5	.984	3.94	1.972	.429	.322	.50	3	-	13.0
5/8	- 11UNC	**TRK15643GSP**	H3	1.083	4.33	2.125	.480	.360	.56	3	-	13.9
5/8	- 11UNC	**TRK15645GSP**	H5	1.083	4.33	2.125	.480	.360	.56	3	-	13.9
5/8	- 18UNF	**TRK15663GSP**	H3	1.083	3.94	2.125	.480	.360	.56	3	-	14.6
5/8	- 18UNF	**TRK15665GSP**	H5	1.083	3.94	2.125	.480	.360	.56	3	-	14.6
3/4	- 10UNC	**TRK15703GSP**	H3	1.201	4.92	2.433	.590	.442	.69	3	-	16.9
3/4	- 10UNC	**TRK15705GSP**	H5	1.201	4.92	2.433	.590	.442	.69	3	-	16.9
3/4	- 16UNF	**TRK15723GSP**	H3	1.201	4.33	2.433	.590	.442	.69	3	-	17.7
3/4	- 16UNF	**TRK15725GSP**	H5	1.201	4.33	2.433	.590	.442	.69	3	-	17.7
7/8	- 9UNC	**TRK15744GSP**	H4	1.339	5.51	2.654	.697	.523	.75	3	-	19.8
7/8	- 9UNC	**TRK15746GSP**	H6	1.339	5.51	2.654	.697	.523	.75	3	-	19.8
7/8	- 14UNF	**TRK15764GSP**	H4	1.339	4.92	2.654	.697	.523	.75	3	-	20.5
7/8	- 14UNF	**TRK15766GSP**	H6	1.339	4.92	2.654	.697	.523	.75	3	-	20.5
1"	- 8UNC	**TRK15786GSP**	H6	1.496	6.30	3.012	.800	.600	.81	3	-	22.7
1"	- 12UNF	**TRK15806GSP**	H6	1.496	5.51	3.012	.800	.600	.81	3	-	23.5
1"	- 14UNS	**TRK15816GSP**	H6	1.496	5.51	3.012	.800	.600	.81	3	-	23.7

◎ : Excellent ○ : Good

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	◎	◎	◎	◎	◎	◎	◎	◎	○	○	○	◎	◎	◎	○	○	◎	◎		

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	○	○	◎	◎	○	◎	◎	◎													

X-Coating, HSS-PM

Spiral Point Taps for Multipurpose

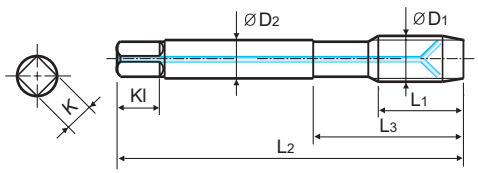
NEW SERIES

TRK16

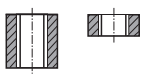
▶ High performance on various ductile materials

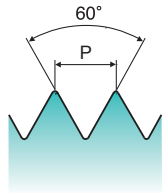
DIN/ANSI

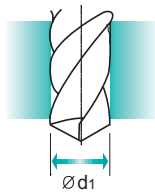
with Internal Coolant



Hole type 3.0×D







Material groups **MU** | HSS PM | M/MF | D | 60° | 4P~5P | X Coating

p.7

Machine Taps

Unit: Inch

Size	Pitch	EDP No.	Limits	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter (Ød1)	
ØD1	P			L1	L2	L3	ØD2	K	Kl	Z	Inch	Metric
M6 x	1.0	TRK16315GSP	D5	.591	3.15	1.177	.255	.191	.31	3	-	5.1
M6 x	0.75	TRK16324GSP	D4	.591	3.15	1.177	.255	.191	.31	3	-	5.3
M7 x	1.0	TRK16345GSP	D5	.669	3.15	1.181	.318	.238	.38	3	-	6.1
M8 x	1.25	TRK16365GSP	D5	.669	3.54	1.378	.318	.238	.38	3	-	6.9
M8 x	1.0	TRK16375GSP	D5	.669	3.54	1.378	.318	.238	.38	3	-	7.1
M9 x	1.25	TRK16395GSP	D5	.669	3.54	1.378	.381	.286	.44	3	-	7.9
M9 x	1.0	TRK16405GSP	D5	.669	3.54	1.378	.381	.286	.44	3	-	8.1
M10 x	1.5	TRK16426GSP	D6	.748	3.94	1.535	.381	.286	.44	3	-	8.7
M10 x	1.25	TRK16435GSP	D5	.748	3.94	1.535	.381	.286	.44	3	-	8.9
M10 x	1.0	TRK16445GSP	D5	.748	3.54	1.378	.381	.286	.44	3	-	9.1
M12 x	1.75	TRK16506GSP	D6	.984	4.33	1.933	.367	.275	.44	3	-	10.5
M12 x	1.5	TRK16516GSP	D6	.984	3.94	1.933	.367	.275	.44	3	-	10.7
M12 x	1.25	TRK16525GSP	D5	.984	3.94	1.933	.367	.275	.44	3	-	10.9
M14 x	2.0	TRK16547GSP	D7	.984	4.33	1.972	.429	.322	.50	3	-	12.3
M14 x	1.5	TRK16556GSP	D6	.984	3.94	1.972	.429	.322	.50	3	-	12.7
M14 x	1.25	TRK16566GSP	D6	.984	3.94	1.972	.429	.322	.50	3	-	12.9
M16 x	2.0	TRK16607GSP	D7	1.083	4.33	2.126	.480	.360	.56	3	-	14.3
M16 x	1.5	TRK16616GSP	D6	1.083	3.94	2.126	.480	.360	.56	3	-	14.7
M18 x	2.5	TRK16657GSP	D7	1.083	4.92	2.165	.542	.406	.63	3	-	15.8
M18 x	1.5	TRK16676GSP	D6	1.083	4.33	2.165	.542	.406	.63	3	-	16.7

▶ NEXT PAGE

◎ : Excellent ○ : Good

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	◎	◎	◎	◎	◎	◎	◎	◎	○	○	○	◎	◎	◎	○	○	◎	◎		

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	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	◎	◎	○	◎	◎	◎													

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X-Coating, HSS-PM

Spiral Point Taps for Multipurpose

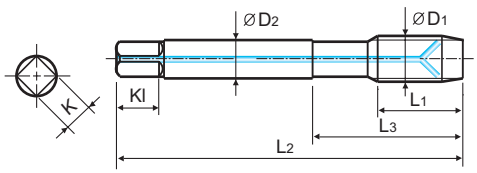
NEW SERIES

TRK16

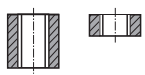
▶ High performance on various ductile materials

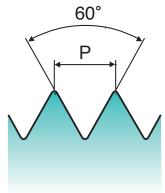
DIN/ANSI

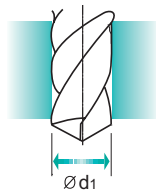
with Internal Coolant



Hole type 3.0×D







Material groups **MU** | HSS PM | M/MF | D | 60° | 4P~5P | X Coating

p.7

Machine Taps

Unit: Inch

Size	Pitch	EDP No.	Limits	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter (Ød1)	
ØD1	P			L1	L2	L3	ØD2	K	Kl	Z	Inch	Metric
M20 x	2.5	**TRK16708GSP**	D8	1.201	5.51	2.433	.652	.489	.69	3	-	17.8
M20 x	1.5	**TRK16726GSP**	D6	1.201	4.92	2.433	.652	.489	.69	3	-	18.7
M22 x	2.5	**TRK16748GSP**	D8	1.339	5.51	2.653	.697	.523	.75	3	-	19.8
M22 x	1.5	**TRK16766GSP**	D6	1.339	4.92	2.653	.697	.523	.75	3	-	20.7
M24 x	3.0	**TRK16788GSP**	D8	1.339	6.30	2.693	.760	.570	.75	3	27/32	-
M24 x	1.5	**TRK16806GSP**	D6	1.339	5.51	2.693	.760	.570	.75	3	-	22.7

◎ : Excellent ○ : Good

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	◎	◎	◎	◎	◎	◎	◎	◎	○	○	○	◎	◎	◎	○	○	◎	◎		

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	○	○	◎	◎	○	◎	◎	◎													

X-Coating, HSS-PM

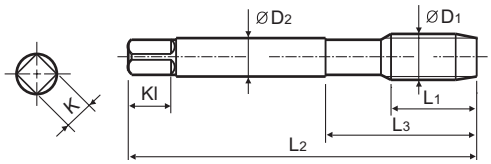
Spiral Flute Taps for Multipurpose

NEW SERIES

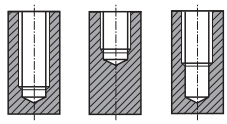
TRF30

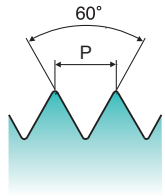
- ▶ High performance on various ductile materials
- ▶ Specially designed to prevent oversized threads and reduce gauging problems

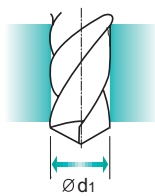
EXTENDED LENGTH



Hole type 2.5×D







Material groups **MU** | HSS PM | UNC UNF | H | 60° | 2P~3P | R45 | X Coating

p.7

Machine Taps

Unit: Inch

Size ØD1	TPI	EDP No.	Limits	Thread Length L1	Overall Length L2	Neck Length L3	Shank Diameter ØD2	Square Size K	Square Length Kl	No. of Flute Z	Tapping Drill Diameter (Ød1) Inch	Metric
#4	- 40UNC	**TRF30162GS**	H2	.201	3.15	.709	.141	.110	.19	2	-	2.3
#4	- 48UNF	**TRF30182GS**	H2	.201	3.15	.709	.141	.110	.19	2	3/32	-
#5	- 40UNC	**TRF30202GS**	H2	.201	3.94	.709	.141	.110	.19	3	-	2.6
#6	- 32UNC	**TRF30243GS**	H3	.248	4.72	.787	.141	.110	.19	3	-	2.8
#6	- 40UNF	**TRF30262GS**	H2	.248	3.94	.787	.141	.110	.19	3	-	2.9
#8	- 32UNC	**TRF30283GS**	H3	.252	4.72	.827	.168	.131	.24	3	-	3.4
#8	- 36UNF	**TRF30302GS**	H2	.252	3.94	.827	.168	.131	.24	3	-	3.5
#10	- 24UNC	**TRF30323GS**	H3	.327	4.92	.984	.194	.152	.24	3	-	3.9
#10	- 32UNF	**TRF30343GS**	H3	.327	5.91	.984	.194	.152	.24	3	-	4.1
#12	- 24UNC	**TRF30363GS**	H3	.331	4.92	1.181	.220	.165	.27	3	-	4.5
#12	- 28UNF	**TRF30383GS**	H3	.331	4.92	1.181	.220	.165	.27	3	-	4.7
1/4	- 20UNC	**TRF30405GS**	H5	.398	5.91	1.260	.255	.191	.31	3	-	5.2
1/4	- 28UNF	**TRF30424GS**	H4	.398	5.91	1.260	.255	.191	.31	3	-	5.5
5/16	- 18UNC	**TRF30445GS**	H5	.555	5.91	1.378	.318	.238	.38	3	-	6.7
5/16	- 24UNF	**TRF30464GS**	H4	.417	5.91	1.378	.318	.238	.38	3	-	7.0
3/8	- 16UNC	**TRF30485GS**	H5	.626	5.91	1.535	.381	.286	.44	3	-	8.1
3/8	- 24UNF	**TRF30504GS**	H4	.417	5.91	1.378	.381	.286	.44	3	-	8.6
7/16	- 14UNC	**TRF30525GS**	H5	.713	5.91	2.362	.323	.242	.39	3	-	9.5
7/16	- 20UNF	**TRF30545GS**	H5	.500	5.91	2.362	.323	.242	.39	3	-	10.0

▶ NEXT PAGE

◎ : Excellent ○ : Good

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	○	◎	◎	◎	◎	◎	◎	◎	○	○	○	◎	◎	◎	○	○	◎	◎		

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	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	◎	◎	○	◎	◎	◎													

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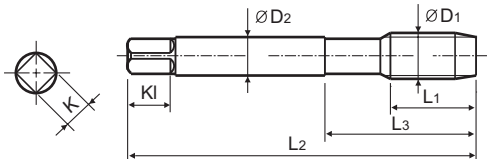
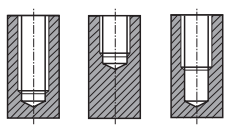
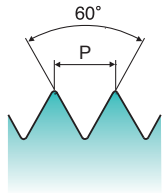
▶ Specially designed to prevent oversized threads and reduce gauging problems

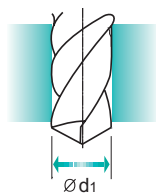
EXTENDED LENGTH



Hole type 2.5×D







Material groups **MU** | HSS PM | UNC UNF | H | 60° | 2P~3P | R45 | X Coating

p.7

Machine Taps

Unit: Inch

Size ØD1	TPI	EDP No.	Limits	Thread Length L1	Overall Length L2	Neck Length L3	Shank Diameter ØD2	Square Size K	Square Length Kl	No. of Flute Z	Tapping Drill Diameter (Ød1) Inch	Metric
1/2	- 13UNC	**TRF30565GS**	H5	.768	7.09	2.835	.367	.275	.44	3	-	11.0
1/2	- 20UNF	**TRF30585GS**	H5	.500	7.09	2.835	.367	.275	.44	3	-	11.6
9/16	- 12UNC	**TRF30605GS**	H5	.835	7.09	2.835	.429	.322	.50	3	-	12.5
9/16	- 18UNF	**TRF30625GS**	H5	.555	7.09	2.835	.429	.322	.50	3	-	13.0
5/8	- 11UNC	**TRF30645GS**	H5	.909	7.09	2.835	.480	.360	.56	3	-	13.9
5/8	- 18UNF	**TRF30665GS**	H5	.555	7.09	2.835	.480	.360	.56	3	-	14.6
3/4	- 10UNC	**TRF30705GS**	H5	1.000	7.87	3.150	.590	.442	.67	4	-	16.9
3/4	- 16UNF	**TRF30725GS**	H5	.626	7.87	3.150	.590	.442	.67	4	-	17.7
7/8	- 9UNC	**TRF30746GS**	H6	1.110	7.87	3.150	.697	.523	.74	4	-	19.8
7/8	- 14UNF	**TRF30766GS**	H6	.713	7.87	3.150	.697	.523	.74	4	-	20.5
1"	- 8UNC	**TRF30786GS**	H6	1.252	7.87	3.465	.800	.600	.80	4	-	22.7
1"	- 12UNF	**TRF30806GS**	H6	.835	7.87	3.465	.800	.600	.80	4	-	23.5

◎ : Excellent ○ : Good

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	○	◎	◎	◎	◎	◎	◎	◎	○	○	○	◎	◎	◎	○	○	◎	◎		

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	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	◎	◎	○	◎	◎	◎													

X-Coating, HSS-PM

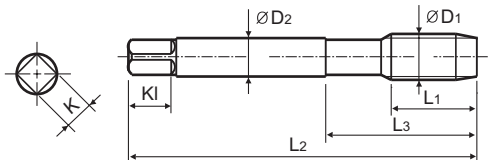
Spiral Flute Taps for Multipurpose

NEW SERIES

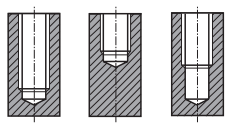
TRF29

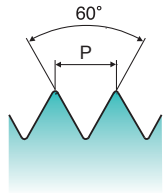
- ▶ High performance on various ductile materials
- ▶ Specially designed to prevent oversized threads and reduce gauging problems

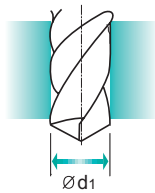
EXTENDED LENGTH



Hole type 2.5×D







Material groups **MU** | HSS PM | M/MF | D | 60° | 2P~3P | R45 | X Coating

p.7

Machine Taps

Unit: Inch

Size	Pitch	EDP No.	Limits	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter (Ød1)	
ØD1	P			L1	L2	L3	ØD2	K	Kl	Z	Inch	Metric
M3 x	0.5	**TRF29203GS**	D3	.157	3.94	.709	.141	.110	.19	3	-	2.5
M4 x	0.7	**TRF29244GS**	D4	.220	3.94	.827	.168	.191	.31	3	-	3.4
M5 x	0.8	**TRF29284GS**	D4	.252	4.92	.984	.194	.191	.31	3	-	4.3
M6 x	1.0	**TRF29315GS**	D5	.315	5.91	1.181	.255	.191	.31	3	-	5.1
M6 x	0.75	**TRF29324GS**	D4	.315	5.91	1.181	.255	.191	.31	3	-	5.3
M8 x	1.25	**TRF29365GS**	D5	.492	5.91	1.378	.318	.238	.38	3	-	6.9
M8 x	1.0	**TRF29375GS**	D5	.394	5.91	1.378	.318	.238	.38	3	-	7.1
M10 x	1.5	**TRF29426GS**	D6	.591	5.91	1.378	.381	.286	.44	3	-	8.7
M10 x	1.25	**TRF29435GS**	D5	.492	5.91	1.535	.381	.286	.44	3	-	8.9
M10 x	1.0	**TRF29445GS**	D5	.394	5.91	1.535	.381	.286	.44	3	-	9.1
M12 x	1.75	**TRF29506GS**	D6	.689	7.09	2.835	.367	.275	.44	3	-	10.5
M12 x	1.5	**TRF29516GS**	D6	.591	7.09	2.835	.367	.275	.44	3	-	10.7
M12 x	1.25	**TRF29526GS**	D6	.492	7.09	2.835	.367	.275	.44	3	-	10.9
M14 x	2.0	**TRF29547GS**	D7	.492	7.09	2.835	.429	.322	.50	3	-	12.3
M14 x	1.5	**TRF29556GS**	D6	.591	7.09	2.835	.429	.322	.50	3	-	12.7
M14 x	1.25	**TRF29566GS**	D6	.492	7.09	2.835	.429	.322	.50	3	-	12.9
M16 x	2.0	**TRF29607GS**	D7	.591	7.09	2.835	.480	.360	.56	3	-	14.3
M16 x	1.5	**TRF29616GS**	D6	.787	7.09	2.835	.480	.360	.56	3	-	14.7
M18 x	2.5	**TRF29657GS**	D7	.984	7.09	2.835	.542	.406	.61	4	-	15.8
M18 x	1.5	**TRF29676GS**	D6	.591	7.09	2.835	.542	.406	.61	4	-	16.7

▶ NEXT PAGE

◎ : Excellent ○ : Good

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	○	◎	◎	◎	◎	◎	◎	◎	○	○	○	◎	◎	◎	○	○	◎	◎		

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	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	◎	◎	○	◎	◎	◎													

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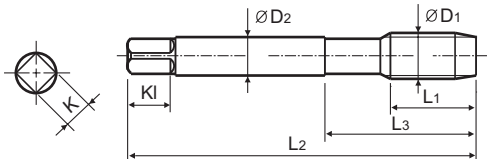
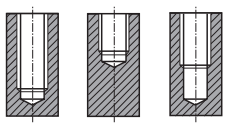
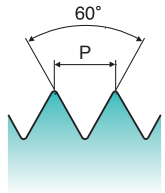
- ▶ Specially designed to prevent oversized threads and reduce gauging problems

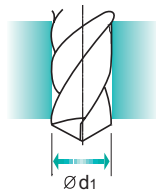
EXTENDED LENGTH



Hole type 2.5×D







Material groups **MU** | HSS PM | M/MF | D | 60° | 2P~3P | R45 | X Coating

p.7

Machine Taps

Unit: Inch

Size	Pitch	EDP No.	Limits	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter (Ød1)	
ØD1	P			L1	L2	L3	ØD2	K	Kl	Z	Inch	Metric
M20 x	2.5	**TRF29707GS**	D7	.984	7.87	3.150	.652	.489	.67	4	-	17.8
M20 x	1.5	**TRF29726GS**	D6	.591	7.87	3.150	.652	.489	.67	4	-	18.7
M22 x	2.5	**TRF29747GS**	D7	.984	7.87	3.150	.697	.523	.74	4	-	19.8
M22 x	1.5	**TRF29766GS**	D6	.591	7.87	3.150	.697	.523	.74	4	-	20.7
M24 x	3.0	**TRF29788GS**	D8	1.181	7.87	3.268	.760	.570	.74	4	27/32	-
M24 x	1.5	**TRF29806GS**	D6	.591	7.87	3.268	.760	.570	.74	4	-	22.7

◎ : Excellent ○ : Good

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	○	◎	◎	◎	◎	◎	◎	◎	○	○	○	◎	◎	◎	○	○	◎	◎		

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	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	◎	◎	○	◎	◎	◎													

X-Coating, HSS-PM

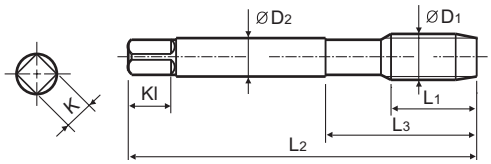
Spiral Point Taps for Multipurpose

NEW SERIES

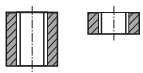
TRK30

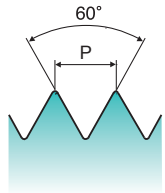
▶ High performance on various ductile materials

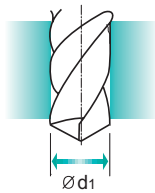
EXTENDED LENGTH



Hole type 3.0×D







Material groups **MU** | HSS PM | UNC UNF | H | 60° | 4P~5P | X Coating

p.7

Machine Taps

Unit: Inch

Size ØD1	TPI	EDP No.	Limits	Thread Length L1	Overall Length L2	Neck Length L3	Shank Diameter ØD2	Square Size K	Square Length Kl	No. of Flute Z	Tapping Drill Diameter (Ød1) Inch	Metric
#4	- 40UNC	**TRK30162GS**	H2	.335	3.15	.709	.141	.110	.19	2	-	2.3
#4	- 48UNF	**TRK30182GS**	H2	.335	3.15	.709	.141	.110	.19	2	3/32	-
#5	- 40UNC	**TRK30202GS**	H2	.374	3.94	.709	.141	.110	.19	3	-	2.6
#6	- 32UNC	**TRK30243GS**	H3	.413	4.72	.787	.141	.110	.19	3	-	2.8
#6	- 40UNF	**TRK30262GS**	H2	.413	3.94	.787	.141	.110	.19	3	-	2.9
#8	- 32UNC	**TRK30283GS**	H3	.453	4.72	.827	.168	.131	.24	3	-	3.4
#8	- 36UNF	**TRK30302GS**	H2	.453	3.94	.827	.168	.131	.24	3	-	3.5
#10	- 24UNC	**TRK30323GS**	H3	.531	4.92	.984	.194	.152	.24	3	-	3.9
#10	- 32UNF	**TRK30343GS**	H3	.531	5.91	.984	.194	.152	.24	3	-	4.1
#12	- 24UNC	**TRK30363GS**	H3	.571	4.92	1.181	.220	.165	.27	3	-	4.5
#12	- 28UNF	**TRK30383GS**	H3	.571	4.92	1.181	.220	.165	.27	3	-	4.7
1/4	- 20UNC	**TRK30405GS**	H5	.591	5.91	1.260	.255	.191	.31	3	-	5.2
1/4	- 28UNF	**TRK30424GS**	H4	.591	5.91	1.260	.255	.191	.31	3	-	5.5
5/16	- 18UNC	**TRK30445GS**	H5	.669	5.91	1.378	.318	.238	.38	3	-	6.7
5/16	- 24UNF	**TRK30464GS**	H4	.669	5.91	1.378	.318	.238	.38	3	-	7.0
3/8	- 16UNC	**TRK30485GS**	H5	.748	5.91	1.535	.381	.286	.44	3	-	8.1
3/8	- 24UNF	**TRK30504GS**	H4	.748	5.91	1.378	.381	.286	.44	3	-	8.6
7/16	- 14UNC	**TRK30525GS**	H5	.866	5.91	2.362	.323	.242	.39	3	-	9.5
7/16	- 20UNF	**TRK30545GS**	H5	.866	5.91	2.362	.323	.242	.39	3	-	10.0

▶ NEXT PAGE

◎ : Excellent ○ : Good

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	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	◎	◎	◎	◎	◎	◎	◎		

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	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	◎	◎	○	◎	◎	◎													

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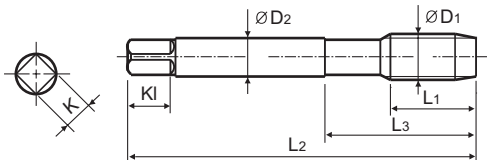
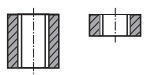
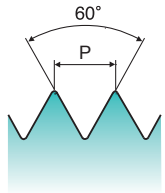
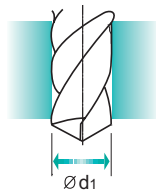
EXTENDED LENGTH



Hole type 3.0×D







Material groups **MU** | HSS PM | UNC UNF | H | 60° | 4P~5P | X Coating

p.7

Machine Taps

Unit: Inch

Size ØD1	TPI	EDP No.	Limits	Thread Length L1	Overall Length L2	Neck Length L3	Shank Diameter ØD2	Square Size K	Square Length Kl	No. of Flute Z	Tapping Drill Diameter (Ød1) Inch	Metric
1/2	- 13UNC	**TRK30565GS**	H5	.984	7.09	2.835	.367	.275	.44	3	-	11.0
1/2	- 20UNF	**TRK30585GS**	H5	.984	7.09	2.835	.367	.275	.44	3	-	11.6
9/16	- 12UNC	**TRK30605GS**	H5	.984	7.09	2.835	.429	.322	.50	3	-	12.5
9/16	- 18UNF	**TRK30625GS**	H5	.984	7.09	2.835	.429	.322	.50	3	-	13.0
5/8	- 11UNC	**TRK30645GS**	H5	1.083	7.09	2.835	.480	.360	.56	3	-	13.9
5/8	- 18UNF	**TRK30665GS**	H5	1.083	7.09	2.835	.480	.360	.56	3	-	14.6
3/4	- 10UNC	**TRK30705GS**	H5	1.201	7.87	3.150	.590	.442	.67	3	-	16.9
3/4	- 16UNF	**TRK30725GS**	H5	1.201	7.87	3.150	.590	.442	.67	3	-	17.7
7/8	- 9UNC	**TRK30746GS**	H6	1.339	7.87	3.150	.697	.523	.74	3	-	19.8
7/8	- 14UNF	**TRK30766GS**	H6	1.339	7.87	3.150	.697	.523	.74	3	-	20.5
1"	- 8UNC	**TRK30786GS**	H6	1.496	7.87	3.465	.800	.600	.80	3	-	22.7
1"	- 12UNF	**TRK30806GS**	H6	1.496	7.87	3.465	.800	.600	.80	3	-	23.5

◎ : Excellent ○ : Good

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	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	◎	◎	◎	◎	◎	◎	◎		

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	○	○	◎	◎	○	◎	◎	◎													

X-Coating, HSS-PM

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NEW SERIES

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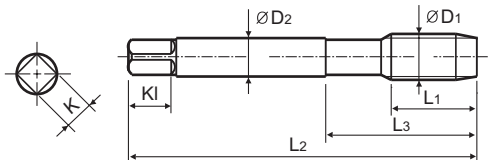
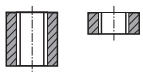
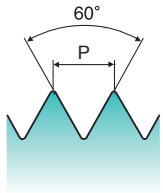
▶ High performance on various ductile materials

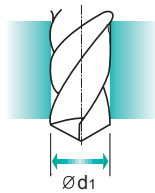
EXTENDED LENGTH



Hole type 3.0×D







Material groups **MU** | HSS PM | M/MF | D | 60° | 4P~5P | X Coating

p.7

Machine Taps

Unit: Inch

Size	Pitch	EDP No.	Limits	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter (Ød1)	
ØD1	P			L1	L2	L3	ØD2	K	Kl	Z	Inch	Metric
M3 x	0.5	**TRK29203GS**	D3	.374	3.94	.709	.141	.110	.19	3	-	2.5
M4 x	0.7	**TRK29244GS**	D4	.453	3.94	.827	.168	.191	.31	3	-	3.4
M5 x	0.8	**TRK29284GS**	D4	.531	4.92	.984	.194	.191	.31	3	-	4.3
M6 x	1.0	**TRK29315GS**	D5	.591	5.91	1.181	.255	.191	.31	3	-	5.1
M6 x	0.75	**TRK29324GS**	D4	.591	5.91	1.181	.255	.191	.31	3	-	5.3
M8 x	1.25	**TRK29365GS**	D5	.669	5.91	1.378	.318	.238	.38	3	-	6.9
M8 x	1.0	**TRK29375GS**	D5	.669	5.91	1.378	.318	.238	.38	3	-	7.1
M10 x	1.5	**TRK29426GS**	D6	.748	5.91	1.378	.381	.286	.44	3	-	8.7
M10 x	1.25	**TRK29435GS**	D5	.748	5.91	1.535	.381	.286	.44	3	-	8.9
M10 x	1.0	**TRK29445GS**	D5	.748	5.91	1.535	.381	.286	.44	3	-	9.1
M12 x	1.75	**TRK29506GS**	D6	.984	7.09	2.835	.367	.275	.44	3	-	10.5
M12 x	1.5	**TRK29516GS**	D6	.984	7.09	2.835	.367	.275	.44	3	-	10.7
M12 x	1.25	**TRK29526GS**	D6	.984	7.09	2.835	.367	.275	.44	3	-	10.9
M14 x	2.0	**TRK29547GS**	D7	.984	7.09	2.835	.429	.322	.50	3	-	12.3
M14 x	1.5	**TRK29556GS**	D6	.984	7.09	2.835	.429	.322	.50	3	-	12.7
M14 x	1.25	**TRK29566GS**	D6	.984	7.09	2.835	.429	.322	.50	3	-	12.9
M16 x	2.0	**TRK29607GS**	D7	1.083	7.09	2.835	.480	.360	.56	3	-	14.3
M16 x	1.5	**TRK29616GS**	D6	1.083	7.09	2.835	.480	.360	.56	3	-	14.7
M18 x	2.5	**TRK29657GS**	D7	1.083	7.09	2.835	.542	.406	.61	3	-	15.8
M18 x	1.5	**TRK29676GS**	D6	1.083	7.09	2.835	.542	.406	.61	3	-	16.7

▶ NEXT PAGE

◎ : Excellent ○ : Good

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	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	◎	◎	◎	◎	◎	◎	◎		

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	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	◎	◎	○	◎	◎	◎													

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X-Coating, HSS-PM

Spiral Point Taps for Multipurpose

NEW SERIES **TRK29**

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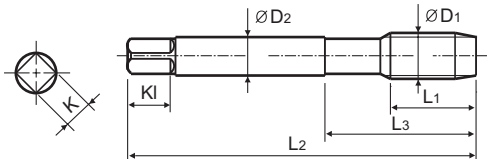
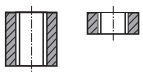
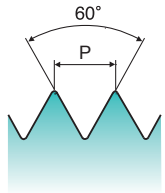
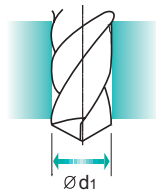
EXTENDED LENGTH



Hole type 3.0×D







Material groups **MU** | HSS PM | M/MF | D | 60° | 4P~5P | X Coating

p.7

Machine Taps

Unit: Inch

Size	Pitch	EDP No.	Limits	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter (Ød1)	
ØD1	P			L1	L2	L3	ØD2	K	Kl	Z	Inch	Metric
M20 x	2.5	**TRK29707GS**	D7	1.201	7.87	3.150	.652	.489	.67	3	-	17.8
M20 x	1.5	**TRK29726GS**	D6	1.201	7.87	3.150	.652	.489	.67	3	-	18.7
M22 x	2.5	**TRK29747GS**	D7	1.339	7.87	3.150	.697	.523	.74	3	-	19.8
M22 x	1.5	**TRK29766GS**	D6	1.339	7.87	3.150	.697	.523	.74	3	-	20.7
M24 x	3.0	**TRK29788GS**	D8	1.339	7.87	3.268	.760	.570	.74	3	27/32	-
M24 x	1.5	**TRK29806GS**	D6	1.339	7.87	3.268	.760	.570	.74	3	-	22.7

◎ : Excellent ○ : Good

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	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	◎	◎	◎	◎	◎	◎	◎		

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	○	○	◎	◎	○	◎	◎	◎													

X-Coating, HSS-PM

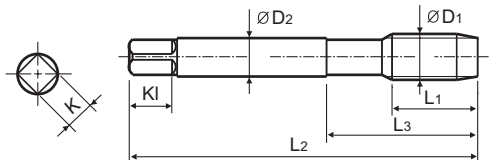
Forming Taps for Multipurpose

SERIES **TRR11**

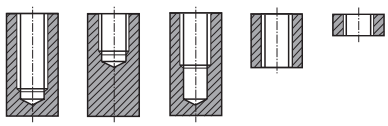
▶ High performance on various ductile materials

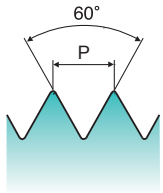
DIN/ANSI

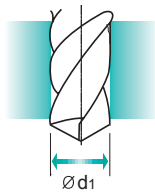
Short Chamfer



Hole type 3.0xD







Material groups **MU** | HSS PM | UNC UNF | H | 60° | 1P~2P | X Coating

p.7

Machine Taps

Unit: Inch

Size ØD1	TPI	EDP No.	Limits	Thread Length L1	Overall Length L2	Neck Length L3	Shank Diameter ØD2	Square Size K	Square Length Kl	No. of Lobe Z	Tapping Drill Diameter (Ød1) Inch	Metric
#0	80	TRR11023GS	H3	.315	1.57	.362	.141	.110	.19	4	-	1.4
#1	64	TRR11043GS	H3	.315	1.57	.370	.141	.110	.19	4	-	1.7
#2	56	TRR11083GS	H3	.386	1.77	.425	.141	.110	.19	4	-	2.0
#2	64	TRR11103GS	H3	.386	1.77	.425	.141	.110	.19	4	-	2.0
#3	48	TRR11123GS	H3	.386	1.97	.453	.141	.110	.19	4	-	2.3
#3	56	TRR11143GS	H3	.386	1.97	.453	.141	.110	.19	4	-	2.3
#4	40	TRR11165GS	H5	.299	2.21	.709	.141	.110	.19	4	#38	-
#4	48	TRR11185GS	H5	.299	2.21	.709	.141	.110	.19	4	-	2.6
#5	40	TRR11205GS	H5	.299	2.21	.709	.141	.110	.19	4	-	2.9
#5	44	TRR11225GS	H5	.299	2.21	.709	.141	.110	.19	4	-	2.9
#6	32	TRR11245GS	H5	.374	2.21	.787	.141	.110	.19	4	1/8	-
#6	40	TRR11265GS	H5	.374	2.21	.787	.141	.110	.19	4	-	3.2
#8	32	TRR11285GS	H5	.374	2.48	.827	.168	.131	.25	4	-	3.8
#8	36	TRR11305GS	H5	.374	2.48	.827	.168	.131	.25	4	#24	-
#10	24	TRR11326GS	H6	.500	2.75	.984	.194	.152	.25	5	-	4.4
#10	32	TRR11346GS	H6	.500	2.75	.984	.194	.152	.25	5	-	4.5
#12	24	TRR11367GS	H7	.500	3.15	1.142	.220	.165	.28	5	-	5.0
#12	28	TRR11387GS	H7	.500	3.15	1.142	.220	.165	.28	5	-	5.1
1/4	20	TRR11406GS	H6	.500	3.15	1.181	.255	.191	.31	5	-	5.8
1/4	28	TRR11426GS	H6	.500	3.15	1.181	.255	.191	.31	5	15/64	-

▶ NEXT PAGE

◎ : Excellent ○ : Good

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	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎						

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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X-Coating, HSS-PM

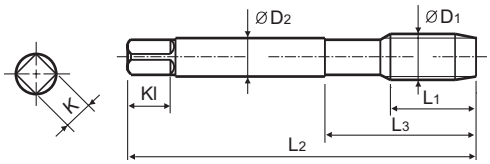
Forming Taps for Multipurpose

SERIES **TRR11**

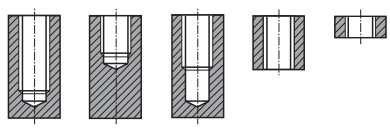
▶ High performance on various ductile materials

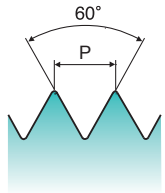
DIN/ANSI

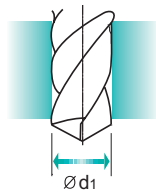
Short Chamfer



Hole type 3.0xD







Material groups **MU** | HSS PM | UNC UNF | H | 60° | 1P~2P | X Coating

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Machine Taps

Unit: Inch

Size ØD1	TPI	EDP No.	Limits	Thread Length L1	Overall Length L2	Neck Length L3	Shank Diameter ØD2	Square Size K	Square Length Kl	No. of Lobe Z	Tapping Drill Diameter (Ød1) Inch	Metric
5/16	18	TRR11447GS	H7	.555	3.54	1.378	.318	.238	.38	5	-	7.3
5/16	24	TRR11467GS	H7	.555	3.54	1.378	.318	.238	.38	5	-	7.5
3/8	16	TRR11487GS	H7	.626	3.94	1.575	.381	.286	.44	8	-	8.8
3/8	24	TRR11507GS	H7	.626	3.94	1.575	.381	.286	.44	8	-	9.0
7/16	14	TRR11528GS	H8	.713	3.94	1.693	.323	.242	.41	8	-	10.3
7/16	20	TRR11548GS	H8	.713	3.94	1.693	.323	.242	.41	8	-	10.6
1/2	13	TRR11568GS	H8	.768	4.33	1.929	.367	.275	.44	8	-	11.8
1/2	20	TRR11588GS	H8	.768	3.94	1.929	.367	.275	.44	8	-	12.1
9/16	12	TRR11600GS	H10	.835	4.33	1.969	.429	.322	.50	8	-	13.4
9/16	18	TRR11620GS	H10	.835	3.94	1.969	.429	.322	.50	8	-	13.7
5/8	11	TRR11640GS	H10	.909	4.33	2.126	.480	.360	.56	8	-	14.9
5/8	18	TRR11660GS	H10	.909	3.94	2.126	.480	.360	.56	8	-	15.3
3/4	10	TRR11700GS	H10	.799	4.92	2.441	.590	.442	.69	8	-	17.9
3/4	16	TRR11720GS	H10	.626	4.33	2.441	.590	.442	.69	8	-	18.4
7/8	9	TRR1174AGS	H11	.890	5.51	2.638	.697	.523	.75	8	-	21.0
7/8	14	TRR1176AGS	H11	.713	4.92	2.638	.697	.523	.75	8	-	21.4
1"	8	TRR1178AGS	H11	1.000	6.30	2.992	.800	.600	.81	8	-	24.0
1"	12	TRR1180AGS	H11	.835	5.51	2.992	.800	.600	.81	8	-	24.5

◎ : Excellent ○ : Good

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	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎						

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	400 Rm	1050 Rm	550	630	400	550
Recommended	◎	◎	◎	◎	◎	◎	◎	◎													

X-Coating, HSS-PM

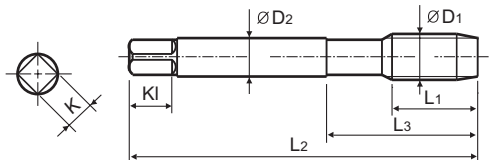
Forming Taps for Multipurpose

SERIES **TRR13**

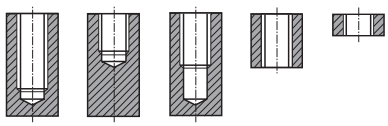
▶ High performance on various ductile materials

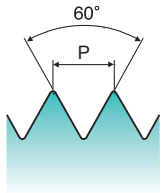
DIN/ANSI

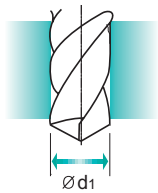
Short Chamfer



Hole type 3.0xD







Material groups **MU** | HSS PM | M/MF | D | 60° | 1P~2P | X Coating

p.7

Machine Taps

Unit: Inch

Size	Pitch	EDP No.	Limits	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Lobe	Tapping Drill Diameter (Ød1)	
ØD1	P			L1	L2	L3	ØD2	K	Kl	Z	Inch	Metric
M2 x	0.4	**TRR13135GS**	D5	.315	1.77	.362	.141	.110	.19	4	-	1.8
M2.5 x	0.45	**TRR13175GS**	D5	.354	1.97	.425	.141	.110	.19	4	-	2.3
M3 x	0.5	**TRR13205GS**	D5	.236	2.21	.709	.141	.110	.19	4	-	2.8
M3.5 x	0.6	**TRR13226GS**	D6	.283	2.21	.787	.141	.110	.19	4	-	3.2
M4 x	0.7	**TRR13246GS**	D6	.331	2.48	.827	.168	.131	.25	4	-	3.7
M4.5 x	0.75	**TRR13266GS**	D6	.354	2.75	.984	.194	.152	.25	4	-	4.2
M5 x	0.8	**TRR13287GS**	D7	.378	2.75	.984	.194	.152	.25	5	-	4.6
M6 x	1.0	**TRR13318GS**	D8	.394	3.15	1.181	.255	.191	.31	5	-	5.6
M7 x	1.0	**TRR13348GS**	D8	.394	3.15	1.181	.318	.238	.38	5	-	6.6
M8 x	1.25	**TRR13369GS**	D9	.472	3.54	1.378	.318	.238	.38	5	-	7.5
M8 x	1.0	**TRR13378GS**	D8	.472	3.54	1.378	.318	.238	.38	5	-	7.6
M10 x	1.5	**TRR13420GS**	D10	.591	3.94	1.535	.381	.286	.44	8	-	9.4
M10 x	1.25	**TRR13439GS**	D9	.591	3.94	1.535	.381	.286	.44	8	-	9.5
M12 x	1.75	**TRR1350AGS**	D11	.669	4.33	1.929	.367	.275	.44	8	-	11.2
M12 x	1.5	**TRR1351AGS**	D11	.669	3.94	1.929	.367	.275	.44	8	-	11.3
M14 x	2.0	**TRR1354BGS**	D12	.787	4.33	1.969	.429	.322	.50	8	-	13.1
M14 x	1.5	**TRR1355AGS**	D11	.787	3.94	1.969	.429	.322	.50	8	-	13.3
M16 x	2.0	**TRR1360BGS**	D12	.787	4.33	2.126	.480	.360	.56	8	-	15.1
M16 x	1.5	**TRR1361AGS**	D11	.787	3.94	2.126	.480	.360	.56	8	-	15.3

▶ NEXT PAGE

◎ : Excellent ○ : Good

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	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎						

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	400 Rm	1050 Rm	550	630	400	550
Recommended	◎	◎	◎	◎	◎	◎	◎	◎													

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X-Coating, HSS-PM

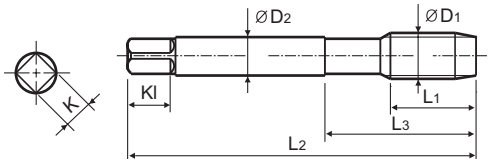
Forming Taps for Multipurpose

SERIES **TRR13**

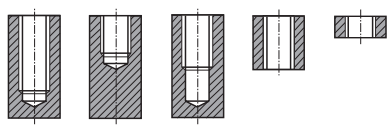
▶ High performance on various ductile materials

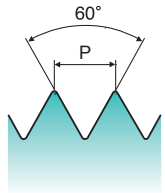
DIN/ANSI

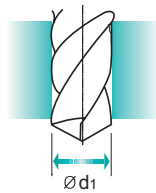
Short Chamfer



Hole type 3.0xD







Material groups **MU** | HSS PM | M/MF | D | 60° | 1P~2P | X Coating

p.7

Machine Taps

Unit: Inch

Size	Pitch	EDP No.	Limits	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Lobe	Tapping Drill Diameter (Ød1)	
ØD1	P			L1	L2	L3	ØD2	K	Kl	Z	Inch	Metric
M18 x	2.5	TRR1365BGS	D12	.787	4.92	2.165	.542	.406	.63	8	-	16.9
M18 x	1.5	TRR1367AGS	D11	.591	4.33	2.165	.542	.406	.63	8	-	17.3
M20 x	2.5	TRR1370BGS	D12	.787	5.51	2.433	.652	.489	.69	8	-	18.9
M20 x	1.5	TRR1372AGS	D11	.591	4.92	2.433	.652	.489	.69	8	-	19.3
M22 x	2.5	TRR1374BGS	D12	.787	5.51	2.654	.697	.523	.75	8	-	20.9
M22 x	1.5	TRR1376AGS	D11	.591	4.92	2.654	.697	.523	.75	8	-	21.3
M24 x	3.0	TRR1378EGS	D15	.945	6.30	2.693	.760	.570	.75	8	-	22.7
M24 x	1.5	TRR1380AGS	D11	.591	5.51	2.693	.760	.570	.75	8	-	23.3

◎ : Excellent ○ : Good

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	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎						

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	400 Rm	1050 Rm	550	630	400	550
Recommended	◎	◎	◎	◎	◎	◎	◎	◎													

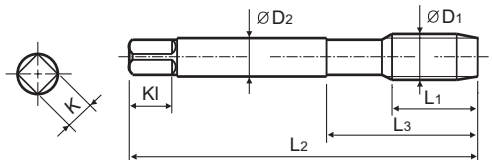
X-Coating, HSS-PM

Forming Taps for Multipurpose

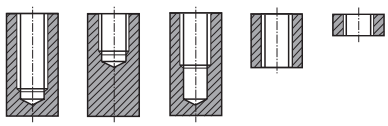
SERIES **TRR10**

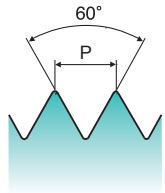
▶ High performance on various ductile materials

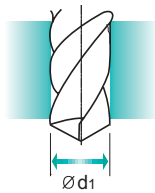
DIN/ANSI



Hole type 3.0xD







Material groups **MU** | HSS PM | UNC UNF | H | 60° | 2P~3P | X Coating

p.7

Machine Taps

Unit: Inch

Size ØD1	TPI	EDP No.	Limits	Thread Length L1	Overall Length L2	Neck Length L3	Shank Diameter ØD2	Square Size K	Square Length Kl	No. of Lobe Z	Tapping Drill Diameter (Ød1) Inch	Metric
#0	- 80	**TRR10023GS**	H3	.315	1.57	.362	.141	.110	.19	4	-	1.4
#1	- 64	**TRR10043GS**	H3	.315	1.57	.370	.141	.110	.19	4	-	1.7
#2	- 56	**TRR10082GS**	H2	.386	1.77	.425	.141	.110	.19	4	-	2.0
#2	- 56	**TRR10083GS**	H3	.386	1.77	.425	.141	.110	.19	4	-	2.0
#2	- 64	**TRR10102GS**	H2	.386	1.77	.425	.141	.110	.19	4	-	2.0
#2	- 64	**TRR10103GS**	H3	.386	1.77	.425	.141	.110	.19	4	-	2.0
#3	- 48	**TRR10122GS**	H2	.386	1.97	.453	.141	.110	.19	4	-	2.3
#3	- 48	**TRR10123GS**	H3	.386	1.97	.453	.141	.110	.19	4	-	2.3
#3	- 56	**TRR10142GS**	H2	.386	1.97	.453	.141	.110	.19	4	-	2.3
#3	- 56	**TRR10143GS**	H3	.386	1.97	.453	.141	.110	.19	4	-	2.3
#4	- 40	**TRR10163GS**	H3	.299	2.21	.709	.141	.110	.19	4	#38	-
#4	- 40	**TRR10165GS**	H5	.299	2.21	.709	.141	.110	.19	4	#38	-
#4	- 48	**TRR10183GS**	H3	.299	2.21	.709	.141	.110	.19	4	-	2.6
#4	- 48	**TRR10185GS**	H5	.299	2.21	.709	.141	.110	.19	4	-	2.6
#5	- 40	**TRR10203GS**	H3	.299	2.21	.709	.141	.110	.19	4	-	2.9
#5	- 40	**TRR10205GS**	H5	.299	2.21	.709	.141	.110	.19	4	-	2.9
#5	- 44	**TRR10223GS**	H3	.299	2.21	.709	.141	.110	.19	4	-	2.9
#5	- 44	**TRR10225GS**	H5	.299	2.21	.709	.141	.110	.19	4	-	2.9

▶ NEXT PAGE

◎ : Excellent ○ : Good

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	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎						

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	400 Rm	1050 Rm	550	630	400	550
Recommended	◎	◎	◎	◎	◎	◎	◎	◎													

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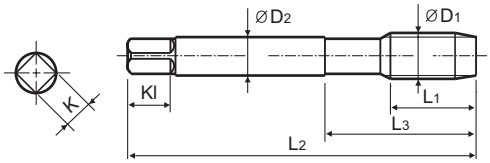
X-Coating, HSS-PM

Forming Taps for Multipurpose

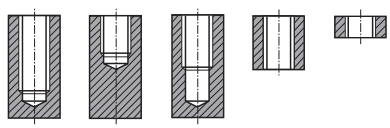
SERIES **TRR10**

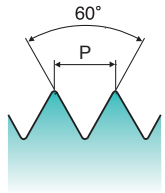
▶ High performance on various ductile materials

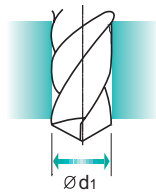
DIN/ANSI



Hole type 3.0xD







Material groups **MU** | HSS PM | UNC UNF | H | 60° | 2P~3P | X Coating

p.7

Machine Taps

Unit: Inch

Size ØD1	TPI	EDP No.	Limits	Thread Length L1	Overall Length L2	Neck Length L3	Shank Diameter ØD2	Square Size K	Square Length Kl	No. of Lobe Z	Tapping Drill Diameter (Ød1) Inch	Metric
#6 - 32		TRR10243GS	H3	.374	2.21	.787	.141	.110	.19	4	1/8	-
#6 - 32		TRR10245GS	H5	.374	2.21	.787	.141	.110	.19	4	1/8	-
#6 - 40		TRR10263GS	H3	.374	2.21	.787	.141	.110	.19	4	-	3.2
#6 - 40		TRR10265GS	H5	.374	2.21	.787	.141	.110	.19	4	-	3.2
#8 - 32		TRR10283GS	H3	.374	2.48	.827	.168	.131	.25	4	-	3.8
#8 - 32		TRR10285GS	H5	.374	2.48	.827	.168	.131	.25	4	-	3.8
#8 - 36		TRR10303GS	H3	.374	2.48	.827	.168	.131	.25	4	#24	-
#8 - 36		TRR10305GS	H5	.374	2.48	.827	.168	.131	.25	4	#24	-
#10 - 24		TRR10324GS	H4	.500	2.75	.984	.194	.152	.25	5	-	4.4
#10 - 24		TRR10326GS	H6	.500	2.75	.984	.194	.152	.25	5	-	4.4
#10 - 32		TRR10344GS	H4	.500	2.75	.984	.194	.152	.25	5	-	4.5
#10 - 32		TRR10346GS	H6	.500	2.75	.984	.194	.152	.25	5	-	4.5
#12 - 24		TRR10365GS	H5	.500	3.15	1.142	.220	.165	.28	5	-	5.0
#12 - 24		TRR10367GS	H7	.500	3.15	1.142	.220	.165	.28	5	-	5.0
#12 - 28		TRR10385GS	H5	.500	3.15	1.142	.220	.165	.28	5	-	5.1
#12 - 28		TRR10387GS	H7	.500	3.15	1.142	.220	.165	.28	5	-	5.1
1/4 - 20		TRR10404GS	H4	.500	3.15	1.181	.255	.191	.31	5	-	5.8
1/4 - 20		TRR10406GS	H6	.500	3.15	1.181	.255	.191	.31	5	-	5.8
1/4 - 28		TRR10424GS	H4	.500	3.15	1.181	.255	.191	.31	5	15/64	-
1/4 - 28		TRR10426GS	H6	.500	3.15	1.181	.255	.191	.31	5	15/64	-

▶ NEXT PAGE

◎ : Excellent ○ : Good

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	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎						

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	400 Rm	1050 Rm	550	630	400	550
Recommended	◎	◎	◎	◎	◎	◎	◎	◎													

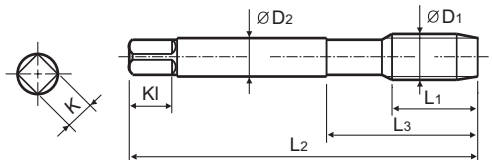
X-Coating, HSS-PM

Forming Taps for Multipurpose

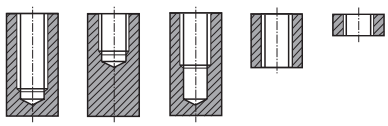
SERIES **TRR10**

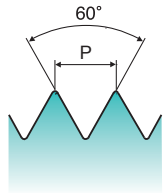
▶ High performance on various ductile materials

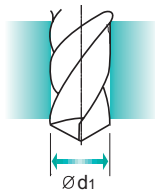
DIN/ANSI



Hole type 3.0xD







Material groups **MU** | HSS PM | UNC UNF | H | 60° | 2P~3P | X Coating

p.7

Machine Taps

Unit: Inch

Size ØD1	TPI	EDP No.	Limits	Thread Length L1	Overall Length L2	Neck Length L3	Shank Diameter ØD2	Square Size K	Square Length Kl	No. of Lobe Z	Tapping Drill Diameter (Ød1) Inch	Metric
5/16	18	**TRR10445GS**	H5	.555	3.54	1.378	.318	.238	.38	5	-	7.3
5/16	18	**TRR10447GS**	H7	.555	3.54	1.378	.318	.238	.38	5	-	7.3
5/16	24	**TRR10465GS**	H5	.555	3.54	1.378	.318	.238	.38	5	-	7.5
5/16	24	**TRR10467GS**	H7	.555	3.54	1.378	.318	.238	.38	5	-	7.5
3/8	16	**TRR10485GS**	H5	.626	3.94	1.575	.381	.286	.44	8	-	8.8
3/8	16	**TRR10487GS**	H7	.626	3.94	1.575	.381	.286	.44	8	-	8.8
3/8	24	**TRR10505GS**	H5	.626	3.94	1.575	.381	.286	.44	8	-	9.0
3/8	24	**TRR10507GS**	H7	.626	3.94	1.575	.381	.286	.44	8	-	9.0
7/16	14	**TRR10525GS**	H5	.713	3.94	1.693	.323	.242	.41	8	-	10.3
7/16	14	**TRR10528GS**	H8	.713	3.94	1.693	.323	.242	.41	8	-	10.3
7/16	20	**TRR10545GS**	H5	.713	3.94	1.693	.323	.242	.41	8	-	10.6
7/16	20	**TRR10548GS**	H8	.713	3.94	1.693	.323	.242	.41	8	-	10.6
1/2	13	**TRR10565GS**	H5	.768	4.33	1.929	.367	.275	.44	8	-	11.8
1/2	13	**TRR10568GS**	H8	.768	4.33	1.929	.367	.275	.44	8	-	11.8
1/2	20	**TRR10585GS**	H5	.768	3.94	1.929	.367	.275	.44	8	-	12.1
1/2	20	**TRR10588GS**	H8	.768	3.94	1.929	.367	.275	.44	8	-	12.1
9/16	12	**TRR10600GS**	H10	.835	4.33	1.969	.429	.322	.50	8	-	13.4
9/16	12	**TRR10607GS**	H7	.835	4.33	1.969	.429	.322	.50	8	-	13.4
9/16	18	**TRR10620GS**	H10	.835	3.94	1.969	.429	.322	.50	8	-	13.7
9/16	18	**TRR10627GS**	H7	.835	3.94	1.969	.429	.322	.50	8	-	13.7

▶ NEXT PAGE

◎ : Excellent ○ : Good

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	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎						

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	400 Rm	1050 Rm	550	630	400	550
Recommended	◎	◎	◎	◎	◎	◎	◎	◎													

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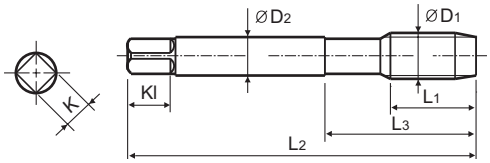
X-Coating, HSS-PM

Forming Taps for Multipurpose

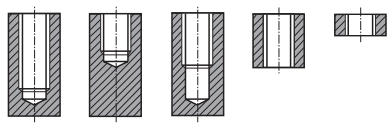
SERIES **TRR10**

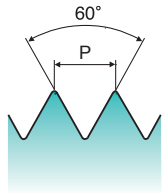
▶ High performance on various ductile materials

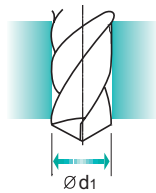
DIN/ANSI



Hole type 3.0xD







Material groups **MU** | HSS PM | UNC UNF | H | 60° | 2P~3P | X Coating

p.7

Machine Taps

Unit: Inch

Size ØD1	TPI	EDP No.	Limits	Thread Length L1	Overall Length L2	Neck Length L3	Shank Diameter ØD2	Square Size K	Square Length Kl	No. of Lobe Z	Tapping Drill Diameter (Ød1) Inch	Metric
5/8	- 11	**TRR10640GS**	H10	.909	4.33	2.126	.480	.360	.56	8	-	14.9
5/8	- 11	**TRR10647GS**	H7	.909	4.33	2.126	.480	.360	.56	8	-	14.9
5/8	- 18	**TRR10660GS**	H10	.909	3.94	2.126	.480	.360	.56	8	-	15.3
5/8	- 18	**TRR10667GS**	H7	.909	3.94	2.126	.480	.360	.56	8	-	15.3
3/4	- 10	**TRR10700GS**	H10	.799	4.92	2.441	.590	.442	.69	8	-	17.9
3/4	- 10	**TRR10707GS**	H7	.799	4.92	2.441	.590	.442	.69	8	-	17.9
3/4	- 16	**TRR10720GS**	H10	.626	4.33	2.441	.590	.442	.69	8	-	18.4
3/4	- 16	**TRR10727GS**	H7	.626	4.33	2.441	.590	.442	.69	8	-	18.4
7/8	- 9	**TRR10748GS**	H8	.890	5.51	2.638	.697	.523	.75	8	-	21.0
7/8	- 9	**TRR1074AGS**	H11	.890	5.51	2.638	.697	.523	.75	8	-	21.0
7/8	- 14	**TRR10768GS**	H8	.713	4.92	2.638	.697	.523	.75	8	-	21.4
7/8	- 14	**TRR1076AGS**	H11	.713	4.92	2.638	.697	.523	.75	8	-	21.4
1"	- 8	**TRR10788GS**	H8	1.000	6.30	2.992	.800	.600	.81	8	-	24.0
1"	- 8	**TRR1078AGS**	H11	1.000	6.30	2.992	.800	.600	.81	8	-	24.0
1"	- 12	**TRR10808GS**	H8	.835	5.51	2.992	.800	.600	.81	8	-	24.5
1"	- 12	**TRR1080AGS**	H11	.835	5.51	2.992	.800	.600	.81	8	-	24.5

◎ : Excellent ○ : Good

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	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎						

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	400 Rm	1050 Rm	550	630	400	550
Recommended	◎	◎	◎	◎	◎	◎	◎	◎													

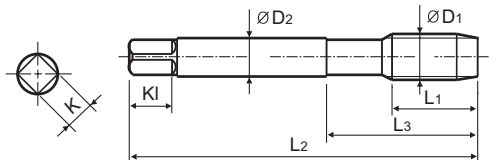
X-Coating, HSS-PM

Forming Taps for Multipurpose

SERIES **TRR12**

▶ High performance on various ductile materials

DIN/ANSI



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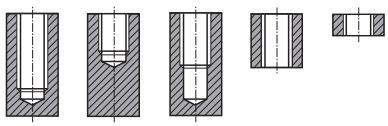

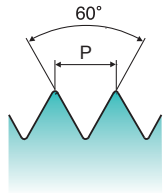

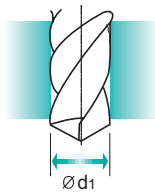

Material groups **MU** | HSS PM | M/MF | D | 60° | 2P~3P | X Coating

p.7

Machine Taps

Unit: Inch

Size	Pitch	EDP No.	Limits	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Lobe	Tapping Drill Diameter (Ød1)	
ØD1	P			L1	L2	L3	ØD2	K	Kl	Z	Inch	Metric
M2 x	0.4	TRR12133GS	D3	.315	1.77	.362	.141	.110	.19	4	-	1.8
M2 x	0.4	TRR12135GS	D5	.315	1.77	.362	.141	.110	.19	4	-	1.8
M2.5 x	0.45	TRR12173GS	D3	.354	1.97	.425	.141	.110	.19	4	-	2.3
M2.5 x	0.45	TRR12175GS	D5	.354	1.97	.425	.141	.110	.19	4	-	2.3
M3 x	0.5	TRR12203GS	D3	.236	2.21	.709	.141	.110	.19	4	-	2.8
M3 x	0.5	TRR12205GS	D5	.236	2.21	.709	.141	.110	.19	4	-	2.8
M3.5 x	0.6	TRR12224GS	D4	.283	2.21	.787	.141	.110	.19	4	-	3.2
M3.5 x	0.6	TRR12226GS	D6	.283	2.21	.787	.141	.110	.19	4	-	3.2
M4 x	0.7	TRR12244GS	D4	.331	2.48	.827	.168	.131	.25	4	-	3.7
M4 x	0.7	TRR12246GS	D6	.331	2.48	.827	.168	.131	.25	4	-	3.7
M4.5 x	0.75	TRR12264GS	D4	.354	2.75	.984	.194	.152	.25	4	-	4.2
M4.5 x	0.75	TRR12266GS	D6	.354	2.75	.984	.194	.152	.25	4	-	4.2
M5 x	0.8	TRR12284GS	D4	.378	2.75	.984	.194	.152	.25	5	-	4.6
M5 x	0.8	TRR12287GS	D7	.378	2.75	.984	.194	.152	.25	5	-	4.6
M6 x	1.0	TRR12315GS	D5	.394	3.15	1.181	.255	.191	.31	5	-	5.6
M6 x	1.0	TRR12318GS	D8	.394	3.15	1.181	.255	.191	.31	5	-	5.6
M7 x	1.0	TRR12345GS	D5	.394	3.15	1.181	.318	.238	.38	5	-	6.6
M7 x	1.0	TRR12348GS	D8	.394	3.15	1.181	.318	.238	.38	5	-	6.6

▶ NEXT PAGE

◎ : Excellent ○ : Good

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	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎						

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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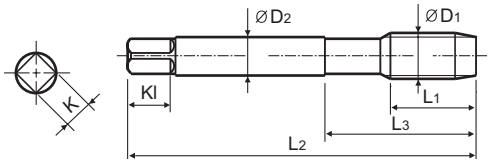
X-Coating, HSS-PM

Forming Taps for Multipurpose

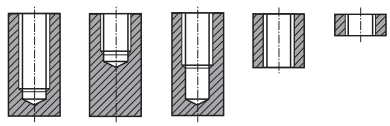
SERIES **TRR12**

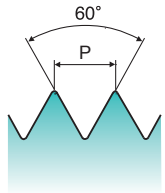
▶ High performance on various ductile materials

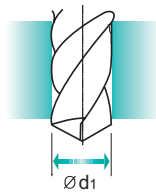
DIN/ANSI



Hole type 3.0xD







Material groups **MU** | HSS PM | M/MF | D | 60° | 2P~3P | X Coating

p.7

Machine Taps

Unit: Inch

Size ØD1	Pitch P	EDP No.	Limits	Thread Length L1	Overall Length L2	Neck Length L3	Shank Diameter ØD2	Square Size K	Square Length Kl	No. of Lobe Z	Tapping Drill Diameter (Ød1) Inch	Metric
M8	x 1.25	**TRR12365GS**	D5	.472	3.54	1.378	.318	.238	.38	5	-	7.5
M8	x 1.25	**TRR12369GS**	D9	.472	3.54	1.378	.318	.238	.38	5	-	7.5
M8	x 1.0	**TRR12375GS**	D5	.472	3.54	1.378	.318	.238	.38	5	-	7.6
M8	x 1.0	**TRR12378GS**	D8	.472	3.54	1.378	.318	.238	.38	5	-	7.6
M10	x 1.5	**TRR12420GS**	D10	.591	3.94	1.535	.381	.286	.44	8	-	9.4
M10	x 1.5	**TRR12426GS**	D6	.591	3.94	1.535	.381	.286	.44	8	-	9.4
M10	x 1.25	**TRR12435GS**	D5	.591	3.94	1.535	.381	.286	.44	8	-	9.5
M10	x 1.25	**TRR12439GS**	D9	.591	3.94	1.535	.381	.286	.44	8	-	9.5
M12	x 1.75	**TRR12506GS**	D6	.669	4.33	1.929	.367	.275	.44	8	-	11.2
M12	x 1.75	**TRR1250AGS**	D11	.669	4.33	1.929	.367	.275	.44	8	-	11.2
M12	x 1.5	**TRR12516GS**	D6	.669	3.94	1.929	.367	.275	.44	8	-	11.3
M12	x 1.5	**TRR1251AGS**	D11	.669	3.94	1.929	.367	.275	.44	8	-	11.3
M14	x 2.0	**TRR12547GS**	D7	.787	4.33	1.969	.429	.322	.50	8	-	13.1
M14	x 2.0	**TRR1254BGS**	D12	.787	4.33	1.969	.429	.322	.50	8	-	13.1
M14	x 1.5	**TRR12556GS**	D6	.787	3.94	1.969	.429	.322	.50	8	-	13.3
M14	x 1.5	**TRR1255AGS**	D11	.787	3.94	1.969	.429	.322	.50	8	-	13.3
M16	x 2.0	**TRR12607GS**	D7	.787	4.33	2.126	.480	.360	.56	8	-	15.1
M16	x 2.0	**TRR1260BGS**	D12	.787	4.33	2.126	.480	.360	.56	8	-	15.1
M16	x 1.5	**TRR12616GS**	D6	.787	3.94	2.126	.480	.360	.56	8	-	15.3
M16	x 1.5	**TRR1261AGS**	D11	.787	3.94	2.126	.480	.360	.56	8	-	15.3

▶ NEXT PAGE

◎ : Excellent ○ : Good

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	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎						

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	400 Rm	1050 Rm	550	630	400	550
Recommended	◎	◎	◎	◎	◎	◎	◎	◎													

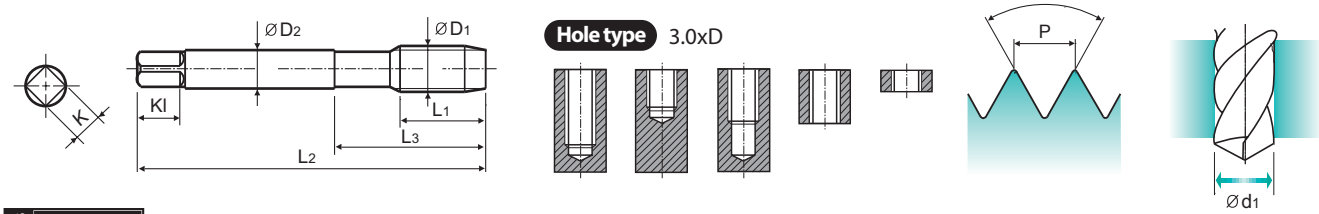
X-Coating, HSS-PM

Forming Taps for Multipurpose

SERIES **TRR12**

▶ High performance on various ductile materials

DIN/ANSI



Material groups **MU** | HSS PM | M/MF | D | 60° | 2P~3P | X Coating

p.7

Machine Taps

Unit: Inch

Size	Pitch	EDP No.	Limits	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Lobe	Tapping Drill Diameter (Ød1)	
ØD1	P			L1	L2	L3	ØD2	K	Kl	Z	Inch	Metric
M18 x	2.5	**TRR12657GS**	D7	.787	4.92	2.165	.542	.406	.63	8	-	16.9
M18 x	2.5	**TRR1265BGS**	D12	.787	4.92	2.165	.542	.406	.63	8	-	16.9
M18 x	1.5	**TRR12676GS**	D6	.591	4.33	2.165	.542	.406	.63	8	-	17.3
M18 x	1.5	**TRR1267AGS**	D11	.591	4.33	2.165	.542	.406	.63	8	-	17.3
M20 x	2.5	**TRR12707GS**	D7	.787	5.51	2.433	.652	.489	.69	8	-	18.9
M20 x	2.5	**TRR1270BGS**	D12	.787	5.51	2.433	.652	.489	.69	8	-	18.9
M20 x	1.5	**TRR12726GS**	D6	.591	4.92	2.433	.652	.489	.69	8	-	19.3
M20 x	1.5	**TRR1272AGS**	D11	.591	4.92	2.433	.652	.489	.69	8	-	19.3
M22 x	2.5	**TRR1274BGS**	D12	.787	5.51	2.654	.697	.523	.75	8	-	20.9
M22 x	1.5	**TRR1276AGS**	D11	.591	4.92	2.654	.697	.523	.75	8	-	21.3
M24 x	3.0	**TRR1278EGS**	D15	.945	6.30	2.693	.760	.570	.75	8	-	22.7
M24 x	1.5	**TRR1280AGS**	D11	.591	5.51	2.693	.760	.570	.75	8	-	23.3

◎ : Excellent ○ : Good

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	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎						

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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X-Coating, HSS-PM

Forming Taps for Multipurpose

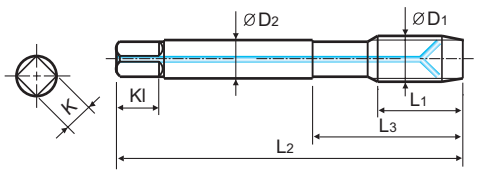
SERIES **TRR15**

▶ High performance on various ductile materials

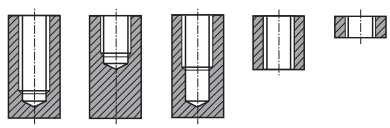
DIN/ANSI

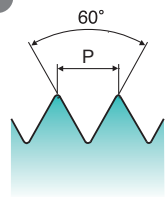
Short Chamfer

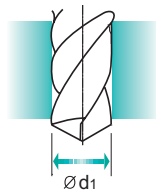
with Internal Coolant



Hole type 3.0xD







Material groups **MU** | HSS PM | UNC UNF | H | 60° | 1P~2P | X Coating

p.7

Machine Taps

Unit: Inch

Size ØD1	TPI	EDP No.	Limits	Thread Length L1	Overall Length L2	Neck Length L3	Shank Diameter ØD2	Square Size K	Square Length Kl	No. of Lobe Z	Tapping Drill Diameter (Ød1) Inch	Metric
1/4	- 20	TRR15406GSP	H6	.500	3.15	1.181	.255	.191	.31	5	-	5.8
1/4	- 28	TRR15426GSP	H6	.500	3.15	1.181	.255	.191	.31	5	15/64	-
5/16	- 18	TRR15447GSP	H7	.555	3.54	1.378	.318	.238	.38	5	-	7.3
5/16	- 24	TRR15467GSP	H7	.555	3.54	1.378	.318	.238	.38	5	-	7.5
3/8	- 16	TRR15487GSP	H7	.626	3.94	1.575	.381	.286	.44	8	-	8.8
3/8	- 24	TRR15507GSP	H7	.626	3.94	1.575	.381	.286	.44	8	-	9.0
7/16	- 14	TRR15528GSP	H8	.713	3.94	1.693	.323	.242	.41	8	-	10.3
7/16	- 20	TRR15548GSP	H8	.713	3.94	1.693	.323	.242	.41	8	-	10.6
1/2	- 13	TRR15568GSP	H8	.768	4.33	1.929	.367	.275	.44	8	-	11.8
1/2	- 20	TRR15588GSP	H8	.768	3.94	1.929	.367	.275	.44	8	-	12.1
9/16	- 12	TRR15600GSP	H10	.835	4.33	1.969	.429	.322	.50	8	-	13.4
9/16	- 18	TRR15620GSP	H10	.835	3.94	1.969	.429	.322	.50	8	-	13.7
5/8	- 11	TRR15640GSP	H10	.909	4.33	2.126	.480	.360	.56	8	-	14.9
5/8	- 18	TRR15660GSP	H10	.909	3.94	2.126	.480	.360	.56	8	-	15.3
3/4	- 10	TRR15700GSP	H10	.799	4.92	2.441	.590	.442	.69	8	-	17.9
3/4	- 16	TRR15720GSP	H10	.626	4.33	2.441	.590	.442	.69	8	-	18.4
7/8	- 9	TRR1574AGSP	H11	.890	5.51	2.638	.697	.523	.75	8	-	21.0
7/8	- 14	TRR1576AGSP	H11	.713	4.92	2.638	.697	.523	.75	8	-	21.4
1"	- 8	TRR1578AGSP	H11	1.000	6.30	2.992	.800	.600	.81	8	-	24.0
1"	- 12	TRR1580AGSP	H11	.835	5.51	2.992	.800	.600	.81	8	-	24.5

◎ : Excellent ○ : Good

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	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎						

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	400 Rm	1050 Rm	550	630	400	550
Recommended	◎	◎	◎	◎	◎	◎	◎	◎													

X-Coating, HSS-PM

Forming Taps for Multipurpose

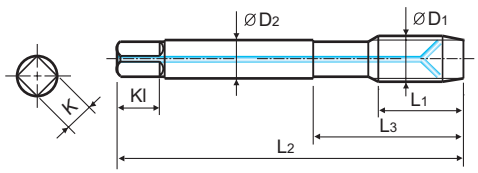
SERIES **TRR17**

▶ High performance on various ductile materials

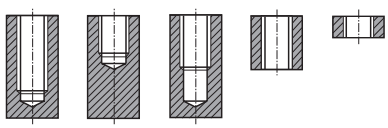
DIN/ANSI

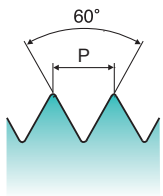
Short Chamfer

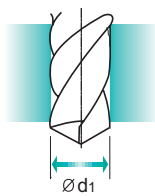
with Internal Coolant



Hole type 3.0xD







Material groups **MU** | HSS PM | M/MF | D | 60° | 1P~2P | X Coating

p.7

Machine Taps

Unit: Inch

Size	Pitch	EDP No.	Limits	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Lobe	Tapping Drill Diameter (Ød1)	
ØD1	P			L1	L2	L3	ØD2	K	Kl	Z	Inch	Metric
M6	x 1.0	TRR17318GSP	D8	.394	3.15	1.181	.255	.191	.31	5	-	5.6
M7	x 1.0	TRR17348GSP	D8	.394	3.15	1.181	.318	.238	.38	5	-	6.6
M8	x 1.25	TRR17369GSP	D9	.472	3.54	1.378	.318	.238	.38	5	-	7.5
M8	x 1.0	TRR17378GSP	D8	.472	3.54	1.378	.318	.238	.38	5	-	7.6
M10	x 1.5	TRR17420GSP	D10	.591	3.94	1.535	.381	.286	.44	8	-	9.4
M10	x 1.25	TRR17439GSP	D9	.591	3.94	1.535	.381	.286	.44	8	-	9.5
M12	x 1.75	TRR1750AGSP	D11	.669	4.33	1.929	.367	.275	.44	8	-	11.2
M12	x 1.5	TRR1751AGSP	D11	.669	3.94	1.929	.367	.275	.44	8	-	11.3
M14	x 2.0	TRR1754BGSP	D12	.787	4.33	1.969	.429	.322	.50	8	-	13.1
M14	x 1.5	TRR1755AGSP	D11	.787	3.94	1.969	.429	.322	.50	8	-	13.3
M16	x 2.0	TRR1760BGSP	D12	.787	4.33	2.126	.480	.360	.56	8	-	15.1
M16	x 1.5	TRR1761AGSP	D11	.787	3.94	2.126	.480	.360	.56	8	-	15.3
M18	x 2.5	TRR1765BGSP	D12	.787	4.92	2.165	.542	.406	.63	8	-	16.9
M18	x 1.5	TRR1767AGSP	D11	.591	4.33	2.165	.542	.406	.63	8	-	17.3
M20	x 2.5	TRR1770BGSP	D12	.787	5.51	2.433	.652	.489	.69	8	-	18.9
M20	x 1.5	TRR1772AGSP	D11	.591	4.92	2.433	.652	.489	.69	8	-	19.3
M22	x 2.5	TRR1774BGSP	D12	.787	5.51	2.654	.697	.523	.75	8	-	20.9
M22	x 1.5	TRR1776AGSP	D11	.591	4.92	2.654	.697	.523	.75	8	-	21.3
M24	x 3.0	TRR1778EGSP	D15	.945	6.30	2.693	.760	.570	.75	8	-	22.7
M24	x 1.5	TRR1780AGSP	D11	.591	5.51	2.693	.760	.570	.75	8	-	23.3

◎ : Excellent ○ : Good

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	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎						

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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X-Coating, HSS-PM

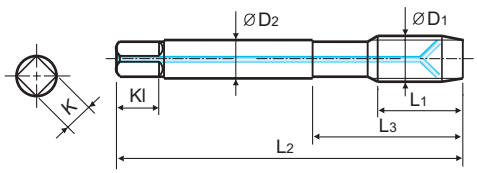
Forming Taps for Multipurpose

SERIES **TRR14**

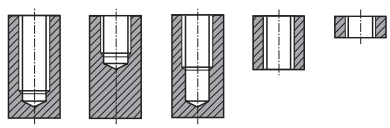
▶ High performance on various ductile materials

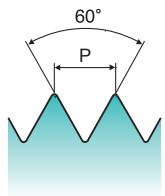
DIN/ANSI

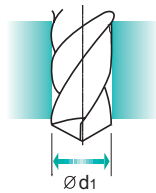
with Internal Coolant



Hole type 3.0xD







Material groups **MU** | HSS PM | UNC UNF | H | 60° | 2P~3P | X Coating

p.7

Machine Taps

Unit: Inch

Size ØD1	TPI	EDP No.	Limits	Thread Length L1	Overall Length L2	Neck Length L3	Shank Diameter ØD2	Square Size K	Square Length Kl	No. of Lobe Z	Tapping Drill Diameter (Ød1) Inch	Metric
1/4 -	20	TRR14404GSP	H4	.500	3.15	1.181	.255	.191	.31	5	-	5.8
1/4 -	20	TRR14406GSP	H6	.500	3.15	1.181	.255	.191	.31	5	-	5.8
1/4 -	28	TRR14424GSP	H4	.500	3.15	1.181	.255	.191	.31	5	15/64	-
1/4 -	28	TRR14426GSP	H6	.500	3.15	1.181	.255	.191	.31	5	15/64	-
5/16 -	18	TRR14445GSP	H5	.555	3.54	1.378	.318	.238	.38	5	-	7.3
5/16 -	18	TRR14447GSP	H7	.555	3.54	1.378	.318	.238	.38	5	-	7.3
5/16 -	24	TRR14465GSP	H5	.555	3.54	1.378	.318	.238	.38	5	-	7.5
5/16 -	24	TRR14467GSP	H7	.555	3.54	1.378	.318	.238	.38	5	-	7.5
3/8 -	16	TRR14485GSP	H5	.626	3.94	1.575	.381	.286	.44	8	-	8.8
3/8 -	16	TRR14487GSP	H7	.626	3.94	1.575	.381	.286	.44	8	-	8.8
3/8 -	24	TRR14505GSP	H5	.626	3.94	1.575	.381	.286	.44	8	-	9.0
3/8 -	24	TRR14507GSP	H7	.626	3.94	1.575	.381	.286	.44	8	-	9.0
7/16 -	14	TRR14525GSP	H5	.713	3.94	1.693	.323	.242	.41	8	-	10.3
7/16 -	14	TRR14528GSP	H8	.713	3.94	1.693	.323	.242	.41	8	-	10.3
7/16 -	20	TRR14545GSP	H5	.713	3.94	1.693	.323	.242	.41	8	-	10.6
7/16 -	20	TRR14548GSP	H8	.713	3.94	1.693	.323	.242	.41	8	-	10.6
1/2 -	13	TRR14565GSP	H5	.768	4.33	1.929	.367	.275	.44	8	-	11.8
1/2 -	13	TRR14568GSP	H8	.768	4.33	1.929	.367	.275	.44	8	-	11.8
1/2 -	20	TRR14585GSP	H5	.768	3.94	1.929	.367	.275	.44	8	-	12.1
1/2 -	20	TRR14588GSP	H8	.768	3.94	1.929	.367	.275	.44	8	-	12.1

▶ NEXT PAGE

◎ : Excellent ○ : Good

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	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎						

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	400 Rm	1050 Rm	550	630	400	550
Recommended	◎	◎	◎	◎	◎	◎	◎	◎													

X-Coating, HSS-PM

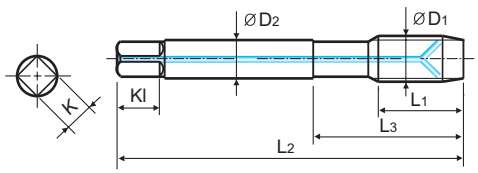
Forming Taps for Multipurpose

SERIES **TRR14**

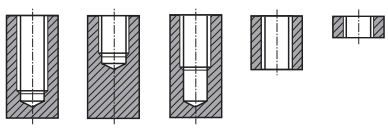
▶ High performance on various ductile materials

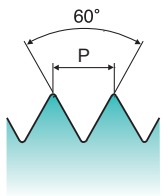
DIN/ANSI

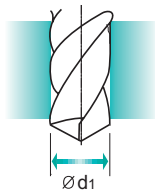
with Internal Coolant



Hole type 3.0xD







Material groups **MU** | HSS PM | UNC UNF | H | 60° | 2P~3P | X Coating

p.7

Machine Taps

Unit: Inch

Size ØD1	TPI	EDP No.	Limits	Thread Length L1	Overall Length L2	Neck Length L3	Shank Diameter ØD2	Square Size K	Square Length Kl	No. of Lobe Z	Tapping Drill Diameter (Ød1) Inch	Metric
9/16	- 12	TRR14600GSP	H10	.835	4.33	1.969	.429	.322	.50	8	-	13.4
9/16	- 12	TRR14607GSP	H7	.835	4.33	1.969	.429	.322	.50	8	-	13.4
9/16	- 18	TRR14620GSP	H10	.835	3.94	1.969	.429	.322	.50	8	-	13.7
9/16	- 18	TRR14627GSP	H7	.835	3.94	1.969	.429	.322	.50	8	-	13.7
5/8	- 11	TRR14640GSP	H10	.909	4.33	2.126	.480	.360	.56	8	-	14.9
5/8	- 11	TRR14647GSP	H7	.909	4.33	2.126	.480	.360	.56	8	-	14.9
5/8	- 18	TRR14660GSP	H10	.909	3.94	2.126	.480	.360	.56	8	-	15.3
5/8	- 18	TRR14667GSP	H7	.909	3.94	2.126	.480	.360	.56	8	-	15.3
3/4	- 10	TRR14700GSP	H10	.799	4.92	2.441	.590	.442	.69	8	-	17.9
3/4	- 10	TRR14707GSP	H7	.799	4.92	2.441	.590	.442	.69	8	-	17.9
3/4	- 16	TRR14720GSP	H10	.626	4.33	2.441	.590	.442	.69	8	-	18.4
3/4	- 16	TRR14727GSP	H7	.626	4.33	2.441	.590	.442	.69	8	-	18.4
7/8	- 9	TRR14748GSP	H8	.890	5.51	2.638	.697	.523	.75	8	-	21.0
7/8	- 9	TRR1474AGSP	H11	.890	5.51	2.638	.697	.523	.75	8	-	21.0
7/8	- 14	TRR14768GSP	H8	.713	4.92	2.638	.697	.523	.75	8	-	21.4
7/8	- 14	TRR1476AGSP	H11	.713	4.92	2.638	.697	.523	.75	8	-	21.4
1"	- 8	TRR14788GSP	H8	1.000	6.30	2.992	.800	.600	.81	8	-	24.0
1"	- 8	TRR1478AGSP	H11	1.000	6.30	2.992	.800	.600	.81	8	-	24.0
1"	- 12	TRR14808GSP	H8	.835	5.51	2.992	.800	.600	.81	8	-	24.5
1"	- 12	TRR1480AGSP	H11	.835	5.51	2.992	.800	.600	.81	8	-	24.5

◎ : Excellent ○ : Good

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	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎						

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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X-Coating, HSS-PM

Forming Taps for Multipurpose

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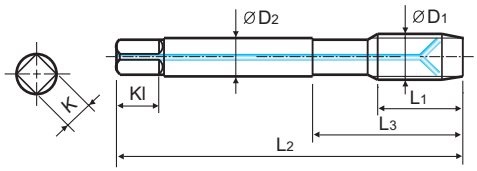
DIN/ANSI

with Internal Coolant



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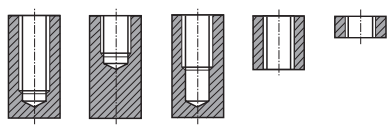

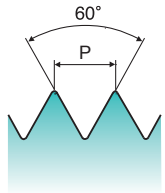

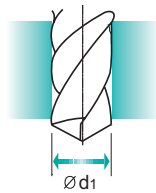

Material groups **MU** | HSS PM | M/MF | D | 60° | 2P~3P | X Coating

p.7

Machine Taps

Unit: Inch

Size ØD1	Pitch P	EDP No.	Limits	Thread Length L1	Overall Length L2	Neck Length L3	Shank Diameter ØD2	Square Size K	Square Length Kl	No. of Lobe Z	Tapping Drill Diameter (Ød1) Inch	Metric
M6	x 1.0	**TRR16315GSP**	D5	.394	3.15	1.181	.255	.191	.31	5	-	5.6
M6	x 1.0	**TRR16318GSP**	D8	.394	3.15	1.181	.255	.191	.31	5	-	5.6
M7	x 1.0	**TRR16345GSP**	D5	.394	3.15	1.181	.318	.238	.38	5	-	6.6
M7	x 1.0	**TRR16348GSP**	D8	.394	3.15	1.181	.318	.238	.38	5	-	6.6
M8	x 1.25	**TRR16365GSP**	D5	.472	3.54	1.378	.318	.238	.38	5	-	7.5
M8	x 1.25	**TRR16369GSP**	D9	.472	3.54	1.378	.318	.238	.38	5	-	7.5
M8	x 1.0	**TRR16375GSP**	D5	.472	3.54	1.378	.318	.238	.38	5	-	7.6
M8	x 1.0	**TRR16378GSP**	D8	.472	3.54	1.378	.318	.238	.38	5	-	7.6
M10	x 1.5	**TRR16420GSP**	D10	.591	3.94	1.535	.381	.286	.44	8	-	9.4
M10	x 1.5	**TRR16426GSP**	D6	.591	3.94	1.535	.381	.286	.44	8	-	9.4
M10	x 1.25	**TRR16435GSP**	D5	.591	3.94	1.535	.381	.286	.44	8	-	9.5
M10	x 1.25	**TRR16439GSP**	D9	.591	3.94	1.535	.381	.286	.44	8	-	9.5
M12	x 1.75	**TRR16506GSP**	D6	.669	4.33	1.929	.367	.275	.44	8	-	11.2
M12	x 1.75	**TRR1650AGSP**	D11	.669	4.33	1.929	.367	.275	.44	8	-	11.2
M12	x 1.5	**TRR16516GSP**	D6	.669	3.94	1.929	.367	.275	.44	8	-	11.3
M12	x 1.5	**TRR1651AGSP**	D11	.669	3.94	1.929	.367	.275	.44	8	-	11.3
M14	x 2.0	**TRR16547GSP**	D7	.787	4.33	1.969	.429	.322	.50	8	-	13.1
M14	x 2.0	**TRR1654BGSP**	D12	.787	4.33	1.969	.429	.322	.50	8	-	13.1
M14	x 1.5	**TRR16556GSP**	D6	.787	3.94	1.969	.429	.322	.50	8	-	13.3
M14	x 1.5	**TRR1655AGSP**	D11	.787	3.94	1.969	.429	.322	.50	8	-	13.3

▶ NEXT PAGE

◎ : Excellent ○ : Good

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	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎						

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	400 Rm	1050 Rm	550	630	400	550
Recommended	◎	◎	◎	◎	◎	◎	◎	◎													

X-Coating, HSS-PM

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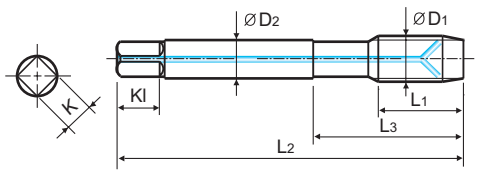
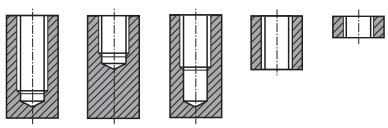
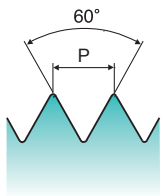
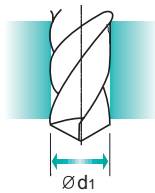


Hole type 3.0xD







Material groups **MU** | HSS PM | M/MF | D | 60° | 2P~3P | X Coating

p.7

Machine Taps

Unit: Inch

Size	Pitch	EDP No.	Limits	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Lobe	Tapping Drill Diameter (Ød1)	
ØD1	P			L1	L2	L3	ØD2	K	Kl	Z	Inch	Metric
M16 x	2.0	TRR16607GSP	D7	.787	4.33	2.126	.480	.360	.56	8	-	15.1
M16 x	2.0	TRR1660BGSP	D12	.787	4.33	2.126	.480	.360	.56	8	-	15.1
M16 x	1.5	TRR16616GSP	D6	.787	3.94	2.126	.480	.360	.56	8	-	15.3
M16 x	1.5	TRR1661AGSP	D11	.787	3.94	2.126	.480	.360	.56	8	-	15.3
M18 x	2.5	TRR16657GSP	D7	.787	4.92	2.165	.542	.406	.63	8	-	16.9
M18 x	2.5	TRR1665BGSP	D12	.787	4.92	2.165	.542	.406	.63	8	-	16.9
M18 x	1.5	TRR16676GSP	D6	.591	4.33	2.165	.542	.406	.63	8	-	17.3
M18 x	1.5	TRR1667AGSP	D11	.591	4.33	2.165	.542	.406	.63	8	-	17.3
M20 x	2.5	TRR16707GSP	D7	.787	5.51	2.433	.652	.489	.69	8	-	18.9
M20 x	2.5	TRR1670BGSP	D12	.787	5.51	2.433	.652	.489	.69	8	-	18.9
M20 x	1.5	TRR16726GSP	D6	.591	4.92	2.433	.652	.489	.69	8	-	19.3
M20 x	1.5	TRR1672AGSP	D11	.591	4.92	2.433	.652	.489	.69	8	-	19.3
M22 x	2.5	TRR16747GSP	D7	.787	5.51	2.654	.697	.523	.75	8	-	20.9
M22 x	2.5	TRR1674BGSP	D12	.787	5.51	2.654	.697	.523	.75	8	-	20.9
M22 x	1.5	TRR16766GSP	D6	.591	4.92	2.654	.697	.523	.75	8	-	21.3
M22 x	1.5	TRR1676AGSP	D11	.591	4.92	2.654	.697	.523	.75	8	-	21.3
M24 x	3.0	TRR16789GSP	D9	.945	6.30	2.693	.760	.570	.75	8	-	22.7
M24 x	3.0	TRR1678EGSP	D15	.945	6.30	2.693	.760	.570	.75	8	-	22.7
M24 x	1.5	TRR16806GSP	D6	.591	5.51	2.693	.760	.570	.75	8	-	23.3
M24 x	1.5	TRR1680AGSP	D11	.591	5.51	2.693	.760	.570	.75	8	-	23.3

◎ : Excellent ○ : Good

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	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎						

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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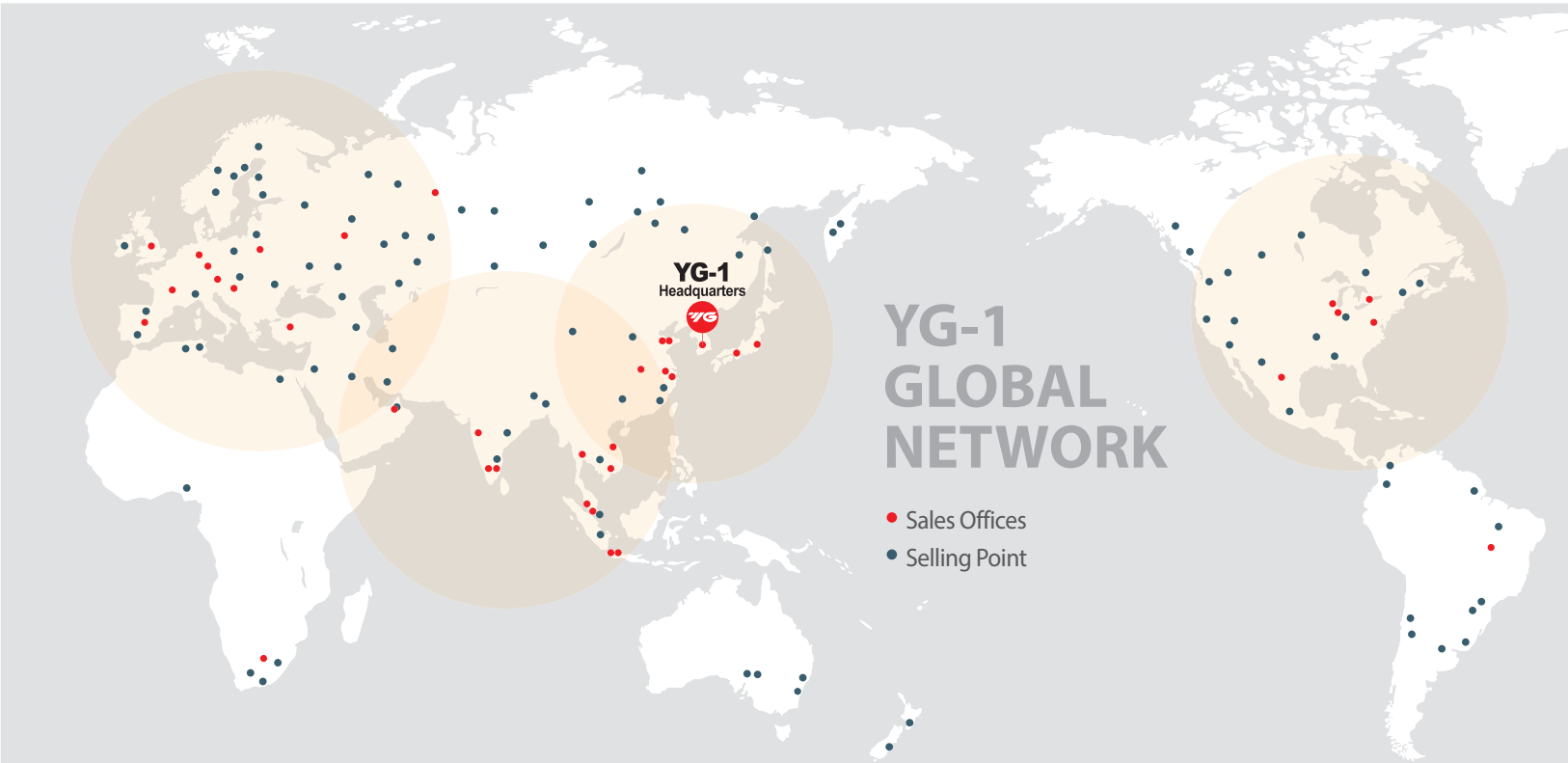

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