

YE-PP25

METRIC



HSS & HSS-E
PIPE TAP

For Tapping Parallel and Taper Pipe Threads
in a Variety of Materials

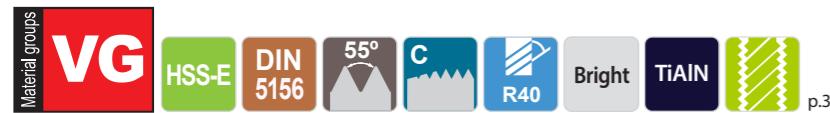
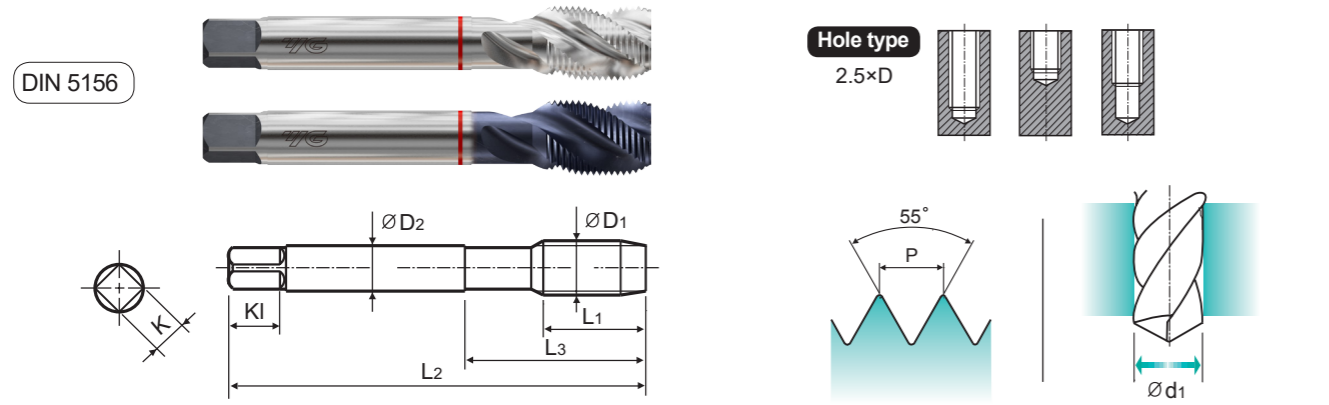


G(BSP) Whitworth PIPE THREADS DIN ISO 228/1

SERIES

 Bright **TC729**
 TiAIN **TY729**

▶ Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.


Machine taps

* (NEW SERIES) Unit : mm

SIZE	TPI	EDP No.		Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
		Bright	TiAIN								
ØD1				L1	L2	L3	ØD2	K	KI	Z	Ød1
G1/8 - 28		TC729200	* TY729200	20	90	36	7	5.5	8	3	8.8
G1/4 - 19		TC729400	* TY729400	22	100	40	11	9	12	3	11.8
G3/8 - 19		TC729480	* TY729480	22	100	40	12	9	12	3	15.25
G1/2 - 14		TC729560	* TY729560	25	125	50	16	12	15	4	19
G3/4 - 14		TC729700	* TY729700	28	140	54	20	16	19	4	24.5
G1 - 11		TC729780	* TY729780	30	160	60	25	20	23	4	30.75

◎ : Excellent ○ : Good

ISO	P										M				K						
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel				Stainless steel		Grey cast iron		Nodular cast iron		Malleable cast iron
Material Description	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	
HRC	13	25	28	32	38	10	29	32	38	15	35	15	23	10	10	26	3	25	3	25	
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230	
Recommended	◎	◎	◎	◎	◎	○	○	◎	◎	◎	○	○	○	○	○	○	○	○	○	○	

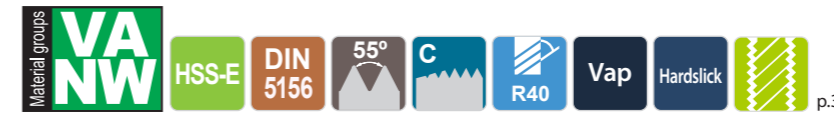
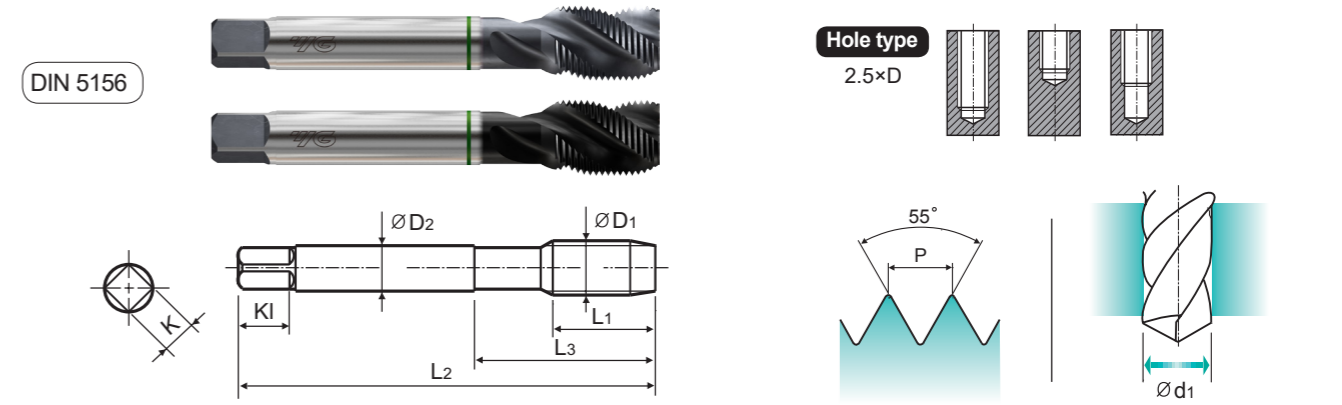
ISO	N					S					H										
	Aluminum-wrought alloy		Aluminum-cast, alloyed		Copper and Copper Alloys (Bronze / Brass)	Non Metallic Materials		Heat Resistant Super Alloys			Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron					
Material Description	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRC	15	30	25	38	34	15	30	25	38	34	200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
HB	60	100	75	90	130	110	90	100													
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

G(BSP) Whitworth PIPE THREADS DIN ISO 228/1

SERIES

 Vap **TB514**
 Hardslick **TC514-HAR**

▶ Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.


Machine taps

* (NEW SERIES) Unit : mm

SIZE	TPI	EDP No.		Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
		Vap	Hardslick								
ØD1				L1	L2	L3	ØD2	K	KI	Z	Ød1
G1/8 - 28		TB514200	* TC514200HAR	20	90	36	7	5.5	8	3	8.8
G1/4 - 19		TB514400	* TC514400HAR	22	100	40	11	9	12	3	11.8
G3/8 - 19		TB514480	* TC514480HAR	22	100	40	12	9	12	3	15.25
G1/2 - 14		TB514560	* TC514560HAR	25	125	50	16	12	15	4	19
G3/4 - 14		TB514700	* TC514700HAR	28	140	54	20	16	19	4	24.5
G1 - 11		TB514780	* TC514780HAR	30	160	60	25	20	23	4	30.75

◎ : Excellent ○ : Good

ISO	P										M				K						
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel				Stainless steel		Grey cast iron		Nodular cast iron		Malleable cast iron
Material Description	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	
HRC	13	25	28	32	38	10	29	32	38	15	35	15	23	10	10	26	3	25	3	25	
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230	
Recommended	◎	◎	◎	◎	◎	○	○	◎	◎	◎	○	○	○	○	○	○	○	○	○	○	

ISO	N					S					H										
	Aluminum-wrought alloy		Aluminum-cast, alloyed		Copper and Copper Alloys (Bronze / Brass)	Non Metallic Materials		Heat Resistant Super Alloys			Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron					
Material Description	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRC	15	30	25	38	34	15	30	25	38	34	200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
HB	60	100	75	90	130	110	90	100													
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

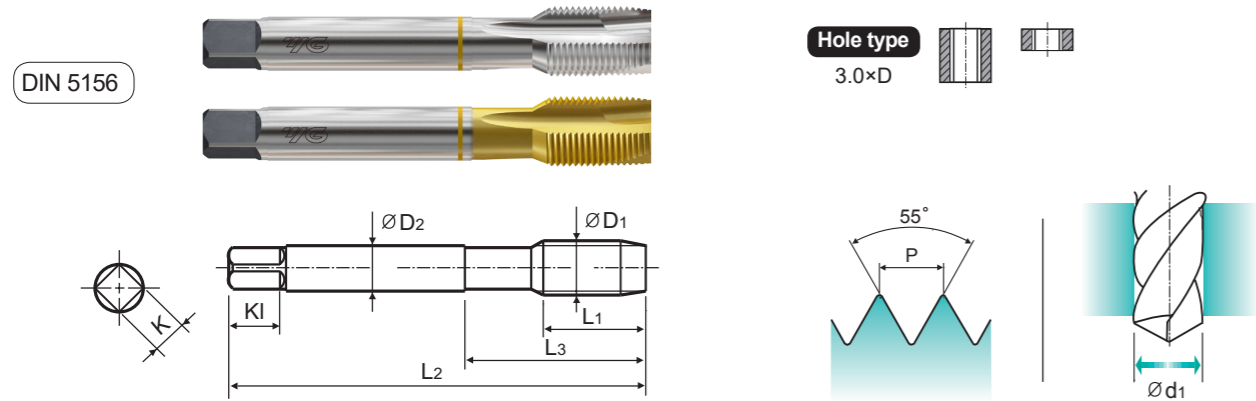
G(BSP) Whitworth PIPE THREADS

DIN ISO 228/1

SERIES

 Bright **TC727**
 TiN **TD727**

▶ Suitable for tapping through holes due to special flute geometry and excellent chip evacuation.


Machine taps

* (NEW SERIES) Unit : mm

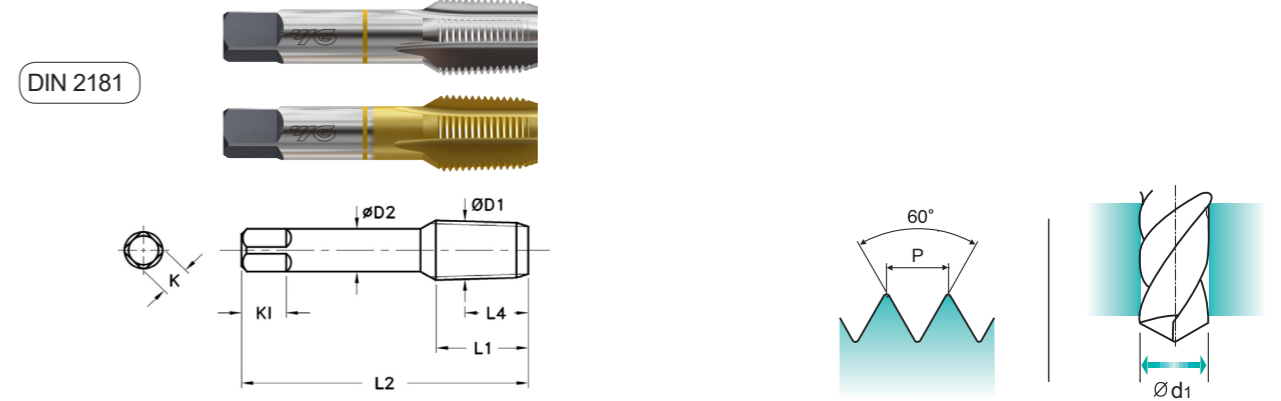
SIZE	TPI	EDP No.		Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
		Bright	TiN								
ØD1				L1	L2	L3	ØD2	K	KI	Z	Ød1
G1/8 - 28		TC727200	* TD727200	20	90	36	7	5.5	8	3	8.8
G1/4 - 19		TC727400	* TD727400	22	100	40	11	9	12	3	11.8
G3/8 - 19		TC727480	* TD727480	22	100	40	12	9	12	3	15.25
G1/2 - 14		TC727560	* TD727560	25	125	50	16	12	15	4	19
G3/4 - 14		TC727700	* TD727700	28	140	54	20	16	19	4	24.5
G1 - 11		TC727780	* TD727780	30	160	60	25	20	23	4	30.75

NPT ANSI/ASME B1.20.1

SERIES

 Bright **TCM01**
 TiN **TDM01**

▶ Suitable for tapping tapered holes due to special flute geometry and excellent chip evacuation.


Machine taps

* (NEW SERIES) Unit : mm

SIZE	TPI	EDP No.		Thread Length	Overall Length	Projection Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
		Bright	TiN								
ØD1				L1	L2	L4	ØD2	K	KI	Z	Ød1
NPT1/16 - 27		* TCM01020	* TDM01020	14	56	12	6	4.9	8	4	6.15
NPT1/8 - 27		* TCM01200	* TDM01200	14	63	12.05	7	5.5	8	4	8.43
NPT1/4 - 18		* TCM01400	* TDM01400	21	63	17.45	11	9	12	4	11.13
NPT3/8 - 18		* TCM01480	* TDM01480	21	70	17.65	12	9	12	4	14.27
NPT1/2 - 14		* TCM01560	* TDM01560	27	80	22.85	16	12	15	4	17.86
NPT3/4 - 14		* TCM01700	* TDM01700	27	100	22.95	20	16	19	5	23.01
NPT1 - 11-1/2		* TCM01780	* TDM01780	32	110	27.4	25	20	23	5	28.98

◎ : Excellent ○ : Good

ISO	P										M				K						
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel				Stainless steel		Grey cast iron		Nodular cast iron		Malleable cast iron
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	30	10	29	32	38	15	35	15	23	10	10	26	3	25	19	21	
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230	
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	

ISO	N					S							H								
	Aluminum-wrought alloy		Aluminum-cast, alloyed		Copper and Copper Alloys (Bronze / Brass)	Non Metallic Materials			Heat Resistant Super Alloys				Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron				
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	15	30	25	38	34	200	280	250	350	320	400 Rm	1050 Rm	55	60	42	55
HB	60	100	75	90	130	110	90	100										550	630	400	550
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

◎ : Excellent ○ : Good

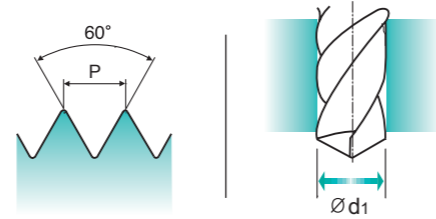
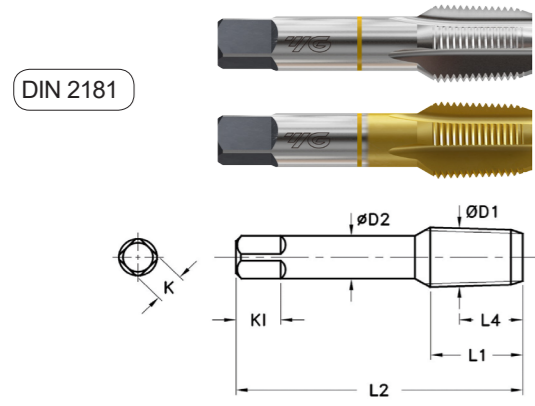
ISO	P										M				K						
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel				Stainless steel		Grey cast iron		Nodular cast iron		Malleable cast iron
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	
HRC	13	25	28	32	30	10	29	32	38	15	35	15	23	10	10	26	3	25	19	21	
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230	
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	

ISO	N					S							H								
	Aluminum-wrought alloy		Aluminum-cast, alloyed		Copper and Copper Alloys (Bronze / Brass)	Non Metallic Materials			Heat Resistant Super Alloys				Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron				
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	15	30	25	38	34	200	280	250	350	320	400 Rm	1050 Rm	55	60	42	55
HB	60	100	75	90	130	110	90	100										550	630	400	550
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

NPTF ANSI B1.20.3

SERIES
Bright **TCM02**
TiN **TDM02**

► Suitable for tapping tapered holes due to special flute geometry and excellent chip evacuation.


Machine taps

* (NEW SERIES) Unit : mm

SIZE	TPI	EDP No.		Thread Length	Overall Length	Projection Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
		Bright	TiN								
ØD1				L1	L2	L4	ØD2	K	KI	Z	Ød1
NPTF1/16 - 27		* TCM02020	* TDM02020	14	56	12	6	4.9	8	4	6.15
NPTF1/8 - 27		* TCM02200	* TDM02200	14	63	12.05	7	5.5	8	4	8.43
NPTF1/4 - 18		* TCM02400	* TDM02400	21	63	17.45	11	9	12	4	11.13
NPTF3/8 - 18		* TCM02480	* TDM02480	21	70	17.65	12	9	12	4	14.27
NPTF1/2 - 14		* TCM02560	* TDM02560	27	80	22.85	16	12	15	4	17.86
NPTF3/4 - 14		* TCM02700	* TDM02700	27	100	22.95	20	16	19	5	23.01
NPTF1 - 11-1/2		* TCM02780	* TDM02780	32	110	27.4	25	20	23	5	28.98

◎ : Excellent ○ : Good

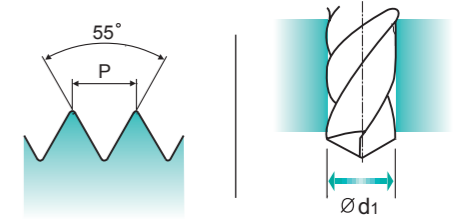
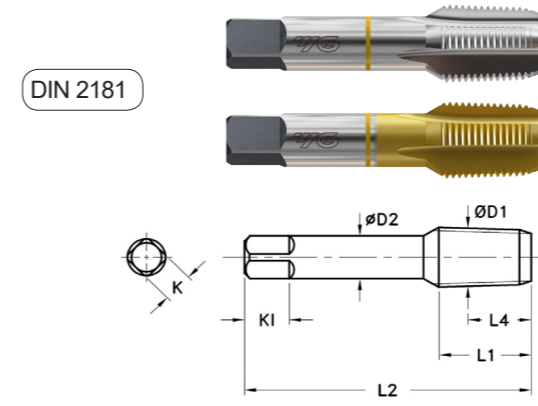
ISO	P										M				K						
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel				Stainless steel		Grey cast iron		Nodular cast iron		Malleable cast iron
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	
HRC	13	25	28	32	30	10	29	32	38	15	35	15	23	10	10	26	3	25	19	21	
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230	
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	

ISO	N					S							H								
	Aluminum-wrought alloy		Aluminum-cast, alloyed		Copper and Copper Alloys (Bronze / Brass)	Non Metallic Materials			Heat Resistant Super Alloys				Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron				
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	15	30	25	38	34	200	280	250	350	320	400 Rm	1050 Rm	55	60	42	55
HB	60	100	75	90	130	110	90	100										550	630	400	550
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

BSPT(Rc) DIN EN10226-2, ISO 7-1

SERIES
Bright **TCM03**
TiN **TDM03**

► Suitable for tapping tapered holes due to special flute geometry and excellent chip evacuation.


Machine taps

* (NEW SERIES) Unit : mm

SIZE	TPI	EDP No.		Thread Length	Overall Length	Projection Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
		Bright	TiN								
ØD1				L1	L2	L4	ØD2	K	KI	Z	Ød1
Rc1/16 - 28		* TCM03020	* TDM03020	14	56	10.1	6	4.9	8	4	6.2
Rc1/8 - 28		* TCM03200	* TDM03200	14	63	10.1	7	5.5	8	4	8.2
Rc1/4 - 19		* TCM03400	* TDM03400	21	63	15	11	9	12	4	11
Rc3/8 - 19		* TCM03480	* TDM03480	21	70	15.4	12	9	12	4	14.5
Rc1/2 - 14		* TCM03560	* TDM03560	27	80	20.5	16	12	15	4	18
Rc3/4 - 14		* TCM03700	* TDM03700	27	100	21.8	20	16	19	5	23.5
Rc1 - 11		* TCM03780	* TDM03780	32	110	26	25	20	23	5	29.5

◎ : Excellent ○ : Good

ISO	P										M				K						
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel				Stainless steel		Grey cast iron		Nodular cast iron		Malleable cast iron
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	30	10	29	32	38	15	35	15	23	10	10	26	3	25	19	21	
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230	
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	

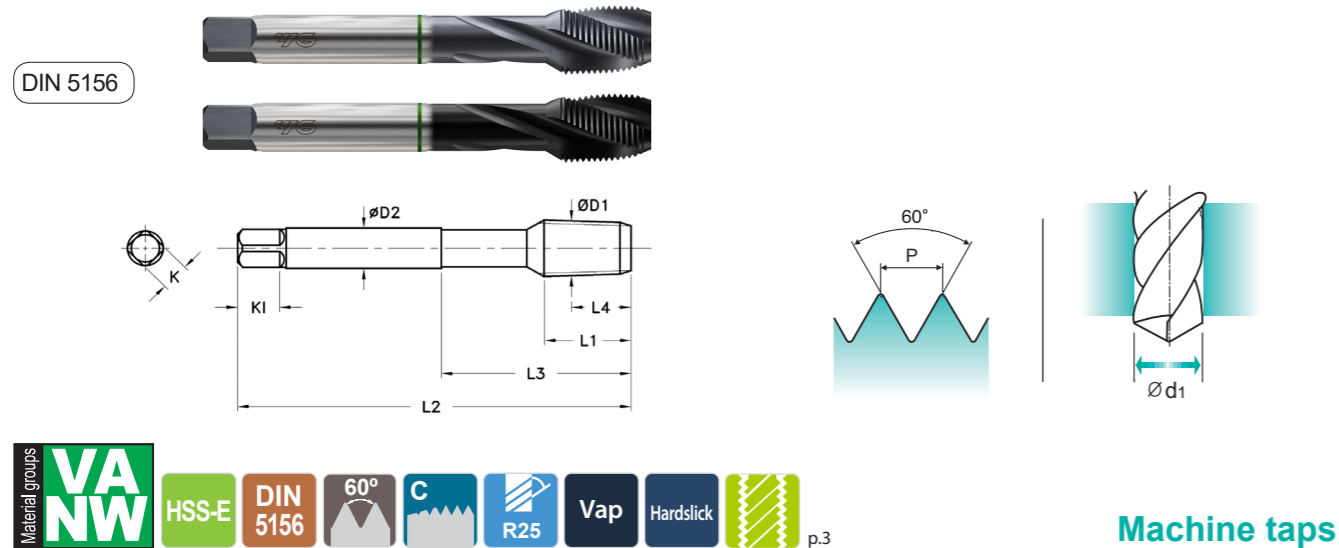
ISO	N					S							H								
	Aluminum-wrought alloy		Aluminum-cast, alloyed		Copper and Copper Alloys (Bronze / Brass)	Non Metallic Materials			Heat Resistant Super Alloys				Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron				
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRC	15	30	25	38	34	15	30	25	38	34	200	280	250	350	320	400 Rm	1050 Rm	55	60	42	55
HB	60	100	75	90	130	110	90	100										550	630	400	550
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

NPT ANSI/ASME B1.20.1

SERIES

 Vap **TBM04**
 Hardslick **TCM04-HAR**

▶ Suitable for tapping tapered holes due to special flute geometry and excellent chip evacuation.


Machine taps

* (NEW SERIES) Unit : mm

SIZE	TPI	EDP No.		Thread Length	Overall Length	Neck Length	Projection Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
		Vap	Hardslick	L1	L2	L3	L4	ØD2	K	KI	Z	Ød1
NPT1/16 - 27		*TBM04020	*TCM04020HAR	14	90	45	12	6	4.9	8	3	6.15
NPT1/8 - 27		*TBM04200	*TCM04200HAR	14	90	45	12.05	7	5.5	8	3	8.43
NPT1/4 - 18		*TBM04400	*TCM04400HAR	21	100	50	17.45	11	9	12	3	11.13
NPT3/8 - 18		*TBM04480	*TCM04480HAR	21	110	55	17.65	12	9	12	3	14.27
NPT1/2 - 14		*TBM04560	*TCM04560HAR	27	125	65	22.85	16	12	15	4	17.86
NPT3/4 - 14		*TBM04700	*TCM04700HAR	27	140	75	22.95	20	16	19	4	23.01
NPT1 - 11-1/2		*TBM04780	*TCM04780HAR	32	160	85	27.4	25	20	23	4	28.98

ISO	P										M				K						
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel				Stainless steel		Grey cast iron	Nodular cast iron	Malleable cast iron		
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	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											
	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																						

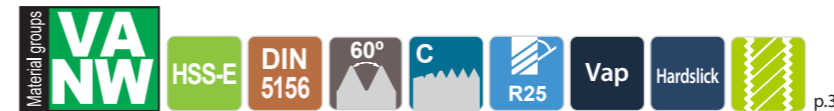
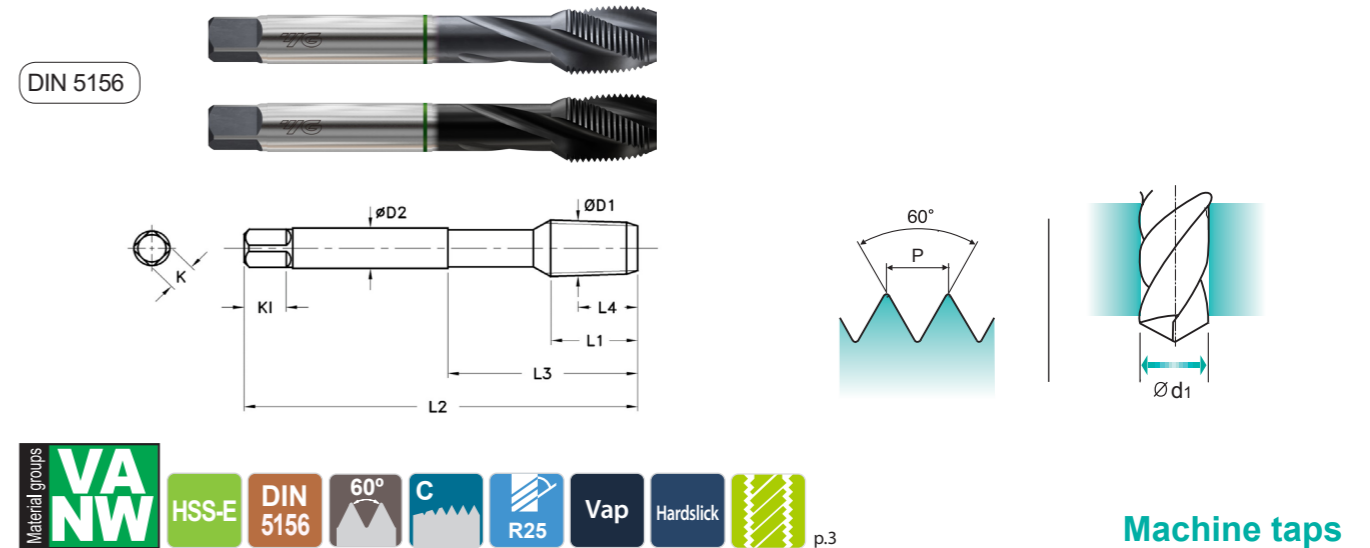
◎ : Excellent ○ : Good

NPTF ANSI B1.20.3

SERIES

 Vap **TBM05**
 Hardslick **TCM05-HAR**

▶ Suitable for tapping tapered holes due to special flute geometry and excellent chip evacuation.


Machine taps

* (NEW SERIES) Unit : mm

SIZE	TPI	EDP No.		Thread Length	Overall Length	Neck Length	Projection Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
		Vap	Hardslick	L1	L2	L3	L4	ØD2	K	KI	Z	Ød1
NPTF1/16- 27		*TBM05020	*TCM05020HAR	14	90	45	12	6	4.9	8	3	6.15
NPTF1/8 - 27		*TBM05200	*TCM05200HAR	14	90	45	12.05	7	5.5	8	3	8.43
NPTF1/4 - 18		*TBM05400	*TCM05400HAR	21	100	50	17.45	11	9	12	3	11.13
NPTF3/8 - 18		*TBM05480	*TCM05480HAR	21	110	55	17.65	12	9	12	3	14.27
NPTF1/2 - 14		*TBM05560	*TCM05560HAR	27	125	65	22.85	16	12	15	4	17.86
NPTF3/4 - 14		*TBM05700	*TCM05700HAR	27	140	75	22.95	20	16	19	4	23.01
NPTF1 - 11-1/2		*TBM05780	*TCM05780HAR	32	160	85	27.4	25	20	23	4	28.98

ISO	P										M				K						
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel				Stainless steel		Grey cast iron	Nodular cast iron	Malleable cast iron		
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	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											
	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																						

◎ : Excellent ○ : Good

BSPT(Rc) DIN EN10226-2, ISO 7-1

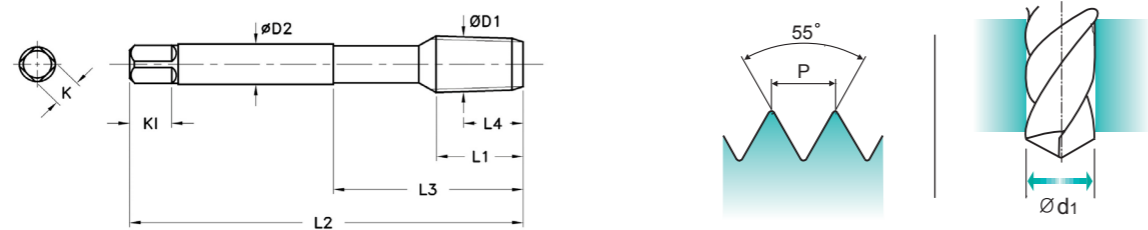
SERIES

Vap **TBM06**
Hardslick **TCM06-HAR**

► Suitable for tapping tapered holes due to special flute geometry and excellent chip evacuation.



DIN 5156



Machine taps

* (NEW SERIES) Unit : mm

SIZE	TPI	EDP No.		Thread Length	Overall Length	Neck Length	Projection Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
		Vap	Hardslick	L1	L2	L3	L4	ØD2	K	KI	Z	Ød1
Rc1/16	- 28	*TBM06020	*TCM06020HAR	14	90	45	10.1	6	4.9	8	3	6.2
Rc1/8	- 28	*TBM06200	*TCM06200HAR	14	90	45	10.1	7	5.5	8	3	8.2
Rc1/4	- 19	*TBM06400	*TCM06400HAR	21	100	50	15	11	9	12	3	11
Rc3/8	- 19	*TBM06480	*TCM06480HAR	21	110	55	15.4	12	9	12	3	14.5
Rc1/2	- 14	*TBM06560	*TCM06560HAR	27	125	65	20.5	16	12	15	4	18
Rc3/4	- 14	*TBM06700	*TCM06700HAR	27	140	75	21.8	20	16	19	4	23.5
Rc1	- 11	*TBM06780	*TCM06780HAR	32	160	85	26	25	20	23	4	29.5

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AFRICA

- EGYPT
- SOUTH AFRICA

◎ : Excellent ○ : Good

ISO	P										M				K						
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel				Stainless steel		Grey cast iron		Nodular cast iron		Malleable cast iron
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	30	10	29	32	38	15	35	15	23	10	10	26	3	25	21	21	
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230	
Recommended	◎	◎									◎	◎									

ISO	N					S										H						
	Aluminum-wrought alloy		Aluminum-cast, alloyed		Copper and Copper Alloys (Bronze / Brass)	Non Metallic Materials		Heat Resistant Super Alloys						Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron			
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	15	30	25	38	34	400 Rm	1050 Rm	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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