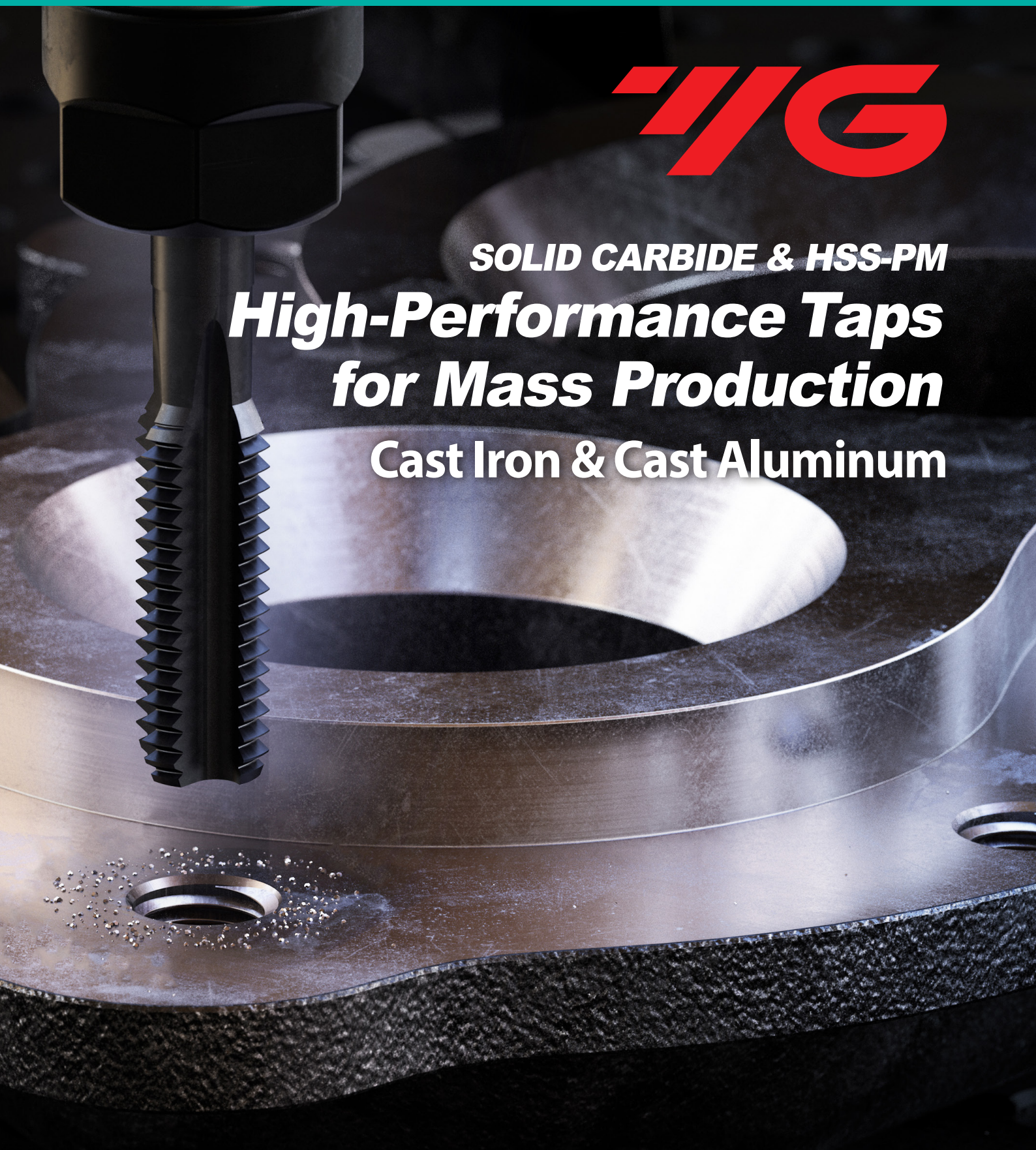
YE-YTC26 EUROPE



YG

SOLID CARBIDE & HSS-PM

High-Performance Taps for Mass Production

Cast Iron & Cast Aluminum

High-Performance Taps for Mass Production

Cast Iron & Cast Aluminum

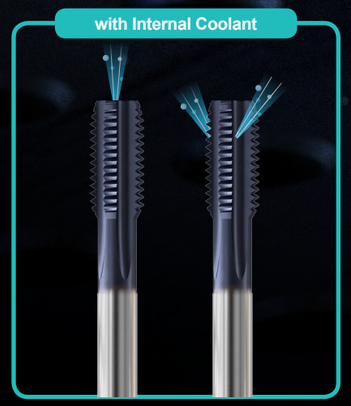
NEW PORTFOLIO!

EXPANSION Carbide and HSS-PM
Straight Flute Taps for Metric and G(BSP)

FEATURE

- **HSS-PM and Solid Carbide Substrates :** Engineered for higher spindle speeds and extended tool life.
- **TiAlN Coating :** Premium coating that delivers excellent heat and wear resistance.
- **Radial or Axial Internal Coolant Options :** Available with or without internal coolant holes.

Optimize performance by delivering coolant directly to the cutting zone for even higher speeds and longer tool life.



Entry Chamfer Options :
Standard short
and extra-short chamfer
styles available
for close clearance tapping
applications.

GUIDE TO ICONS

Working Material
Material groups GG
K Cast Iron
N Cast Aluminum

Surface Treatment
Bright TiAlN

Tool Raw Material
CARBIDE HSS PM

Standard of Tools
DIN 371/376 DIN 374 DIN 5156

Chamfer Lead
C Form C (Chamfer Lead 2-3 Thread)
E Form E (Chamfer Lead 1.5-2 Thread)

Class of Thread
6HX

Thread Angle
60° 55°

Cutting Condition

SELECTION GUIDE

SOLID CARBIDE & HSS-PM

High-Performance Taps for Mass Production

Cast Iron & Cast Aluminum

Please visit globalyg1.com/mat for material search

◎ : Excellent ○ : Good

HOLE TYPE			Max. 2.5xD Blind / Through Hole	Max. 2.5xD Blind Hole	Max. 2.0xD Blind / Through Hole	Max. 2.0xD Blind / Through Hole	Max. 2.0xD Blind / Through Hole	Max. 2.5xD Blind Hole	Max. 2.5xD Blind Hole	Max. 2.5xD Blind / Through Hole	
TOOL MATERIAL			CARBIDE			HSS-PM					
CHAMFER LEAD ACC. TO DIN2197			C	E	C	C	E	C	E	C	
FLUTE TYPE			Straight Flute Tap			Straight Flute Tap					
SERIES	M	DIN371/376	**T0B04** (p.6)	**T0B01** (p.7)	**T0993** (p.8)	**TRB10** (p.9)	**TRB06** (p.10)	**TRB19** (p.11)	**TRB13** (p.12)	**TRB23** (p.13)	
	MF	DIN374	**T0B05** (p.14)	**T0B02** (p.15)	-	**TRB11** (p.16)	**TRB07** (p.17)	**TRB20** (p.18)	**TRB14** (p.19)	**TRB24** (p.20)	
	G(BSP)	DIN5156	-	-	-	**TRB12** (p.21)	**TRB08** (p.22)	**TRB22** (p.23)	**TRB18** (p.24)	**TRB25** (p.25)	
SURFACE TREATMENT / COATING			TiAlN		Bright	TiAlN					
MODEL											

ISO	VDI 3323	Material Description	Composition / Structure / Heat Treatment		HB	HRc	Recommended cutting conditions Vc (m/min.)						
P	1	Non-alloy steel	About 0.15% C	Annealed	125							1	P
	2		About 0.45% C	Annealed	190	13						2	
	3		About 0.45% C	Quenched & tempered	250	25						3	
	4		About 0.75% C	Annealed	270	28						4	
	5		About 0.75% C	Quenched & tempered	300	32						5	
	6	Low alloy steel		Annealed	180	10						6	
	7			Quenched & tempered	275	29						7	
	8			Quenched & tempered	300	32						8	
	9			Quenched & tempered	350	38						9	
	10	High alloyed steel, and tool steel		Annealed	200	15						10	
	11			Quenched & Tempered	325	35						11	
M	12	Stainless steel	Ferritic / Martensitic	Annealed	200	15						12	M
	13		Martensitic	Quenched & Tempered	240	23						13	
	14			Austenitic	180	10						14	
K	15	Grey cast iron	Pearlitic / ferritic		180	10	◎ (15-50)	◎ (15-50)	◎ (10-15)	◎ (15-20)	◎ (15-20)	◎ (15-30)	◎ (15-30)	◎ (15-30)	15	K
	16		Pearlitic (Martensitic)		260	26	◎ (10-30)	◎ (10-30)	◎ (5-8)	◎ (8-11)	◎ (8-11)	◎ (8-16)	◎ (8-16)	◎ (8-16)	16	
	17	Nodular cast iron	Ferritic		160	3	◎ (15-50)	◎ (15-50)	◎ (10-18)	◎ (15-20)	◎ (15-20)	◎ (15-30)	◎ (15-30)	◎ (15-30)	17	
	18		Pearlitic		250	25	◎ (10-30)	◎ (10-30)	◎ (5-8)	◎ (8-11)	◎ (8-11)	◎ (8-16)	◎ (8-16)	◎ (8-16)	18	
	19	Malleable cast iron	Ferritic		130		○ (15-50)	○ (15-50)	○ (10-15)	○ (15-20)	○ (15-20)	○ (15-30)	○ (15-30)	○ (15-30)	19	
	20		Pearlitic		230	21	○ (10-30)	○ (10-30)	○ (5-8)	○ (8-11)	○ (8-11)	○ (8-16)	○ (8-16)	○ (8-16)	20	
N	21	Aluminum-wrought alloy	Not Curable		60										21	N
	22		Curable	Hardened	100										22	
	23	Aluminum-cast, alloyed	≤ 12% Si, Not Curable		75		◎ (15-50)	◎ (15-50)	◎ (15-20)	◎ (15-20)	◎ (15-20)	◎ (15-30)	◎ (15-30)	◎ (15-30)	23	
	24		≤ 12% Si, Curable	Hardened	90										24	
	25		> 12% Si, Not Curable		130		◎ (10-40)	◎ (10-40)	◎ (10-15)	◎ (10-15)	◎ (10-15)	◎ (10-20)	◎ (10-20)	◎ (10-20)	25	
	26	Copper and Copper Alloys (Bronze / Brass)	Cutting Alloys, PB>1%		110										26	
	27		CuZn, CuSnZn (Brass)		90		◎ (12-40)	◎ (12-40)	○ (12-16)	◎ (12-16)	◎ (12-16)	◎ (12-24)	◎ (12-24)	◎ (12-24)	27	
	28		CuSn, lead-free copper and electrolytic copper		100										28	
	29	Non Metallic Materials	Duroplastic, Fiber Reinforced Plastic												29	
	30		Rubber, Wood, etc.												30	
S	31	Heat Resistant Super Alloys	Fe Based	Annealed	200	15									31	S
	32			Cured	280	30									32	
	33		Ni or Co Based	Annealed	250	25									33	
	34			Cured	350	38									34	
	35			Cast	320	34									35	
	36	Titanium Alloys	Pure Titanium		400 Rm										36	
	37		Alpha + Beta Alloys	Hardened	1050 Rm										37	
H	38	Hardened steel		Hardened	550	55									38	H
	39			Hardened	630	60									39	
	40	Chilled Cast Iron		Cast	400	42	◎ (3-15)	◎ (3-15)	◎ (3-5)						40	
	41	Hardened Cast Iron		Hardened	550	55									41	

M CARBIDE YG TAP CAST IRON with Oil Hole
ISO Metric Coarse Threads - DIN 13

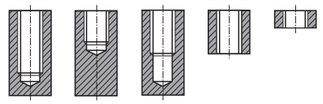
SERIES **T0B04**

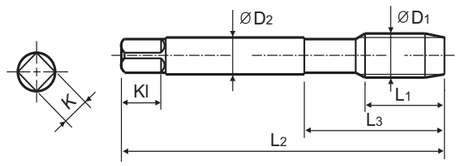
▶ Carbide tap can increase tool life longer than HSS taps due to higher hardness.
Suitable for Cast Iron and Cast Aluminum.

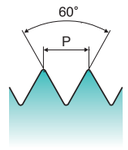
DIN 371

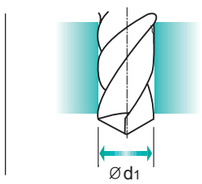
DIN 376

Hole type
2.5×D









Material groups **GG** | CARBIDE | DIN 371/376 | 6HX | 60° | C | TiAlN | p.4

Machine Taps

Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1	P	TiAlN	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M5	x 0.8	**T0B04286TIAP**	15	70	25	6	4.9	8	3	4.2
M6	x 1.0	**T0B04316TIAP**	17	80	30	6	4.9	8	4	5
M8	x 1.25	**T0B04366TIAP**	20	90	35	8	6.2	9	4	6.75
M10	x 1.5	**T0B04426TIAP**	22	100	39	10	8	11	4	8.5
M12	x 1.75	**T0B04506TIAP**	24	110	44	9	7	10	4	10.25

▶ DIN 371(up to M10) and DIN 376(above M10)

◎ : 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			◎		○		◎													◎	

M CARBIDE YG TAP CAST IRON with Oil Hole
ISO Metric Coarse Threads - DIN 13

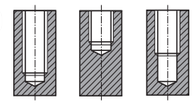
SERIES **T0B01**

▶ Carbide tap can increase tool life longer than HSS taps due to higher hardness.
Suitable for Cast Iron and Cast Aluminum.

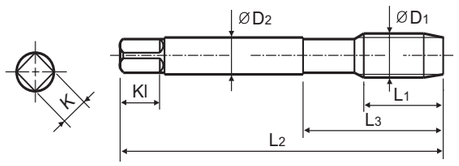
DIN 371

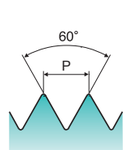
DIN 376

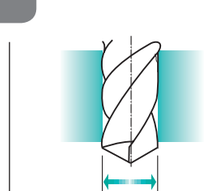
Hole type
2.5×D



Short Chamfer







Material groups **GG** | CARBIDE | DIN 371/376 | 6HX | 60° | E | TiAlN | p.4

Machine Taps

Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1	P	TiAlN	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M5	x 0.8	**T0B01286TIA**	15	70	25	6	4.9	8	3	4.2
M6	x 1.0	**T0B01316TIA**	17	80	30	6	4.9	8	4	5
M8	x 1.25	**T0B01366TIA**	20	90	35	8	6.2	9	4	6.75
M10	x 1.5	**T0B01426TIA**	22	100	39	10	8	11	4	8.5
M12	x 1.75	**T0B01506TIA**	24	110	44	9	7	10	4	10.25

▶ DIN 371(up to M10) and DIN 376(above M10)

◎ : 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			◎		◎		◎													◎	

M CARBIDE YG TAP CAST IRON
ISO Metric Coarse Threads - DIN 13

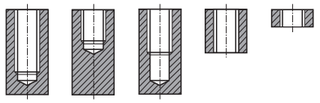
SERIES **T0993**

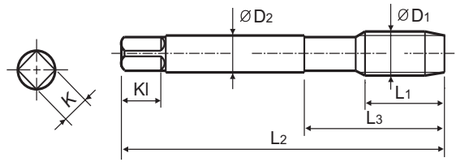
▶ Carbide tap can increase tool life longer than HSS taps due to higher hardness.
Suitable for Cast Iron and Cast Aluminum.

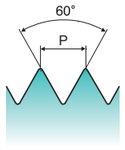
DIN 371

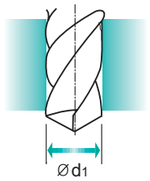
DIN 376

Hole type 2.0×D









Material groups **GG** | CARBIDE | DIN 371/376 | 6HX | 60° | C | Bright | p.4

Machine Taps

Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1	P	Bright	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M3	x 0.5	**T0993206**	11	56	18	3.5	2.7	6	3	2.5
M3.5	x 0.6	**T0993226**	12	56	20	4	3	6	3	2.9
M4	x 0.7	**T0993246**	13	63	21	4.5	3.4	6	3	3.3
M5	x 0.8	**T0993286**	15	70	25	6	4.9	8	4	4.2
M6	x 1.0	**T0993316**	17	80	30	6	4.9	8	4	5
M8	x 1.25	**T0993366**	20	90	35	8	6.2	9	4	6.8
M10	x 1.5	**T0993426**	22	100	39	10	8	11	4	8.5
M12	x 1.75	**T0993506**	24	110	44	9	7	10	4	10.2
M14	x 2.0	**T0993546**	26	110	44	11	9	12	4	12
M16	x 2.0	**T0993606**	27	110	44	12	9	12	4	14
M18	x 2.5	**T0993656**	30	125	50	14	11	14	4	15.5
M20	x 2.5	**T0993706**	32	140	54	16	12	15	4	17.5

▶ DIN 371(up to M10) and DIN 376(above M10)

◎ : 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			◎		◎		○													◎	

M HSS-PM YG TAP CAST IRON
ISO Metric Coarse Threads - DIN 13

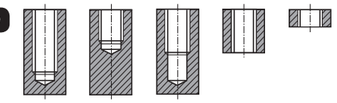
SERIES **TRB10**

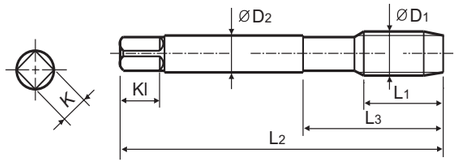
▶ HSS-PM versatile solution with advanced geometry, ensuring stable performance in Cast Iron and Cast Aluminum.

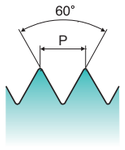
DIN 371

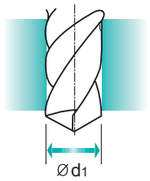
DIN 376

Hole type 2.0×D









Material groups **GG** | HSS PM | DIN 371/376 | 6HX | 60° | C | TiAlN | p.5

Machine Taps

Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1	P	TiAlN	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M3	x 0.5	**TRB10206TIA**	11	56	18	3.5	2.7	6	3	2.5
M4	x 0.7	**TRB10246TIA**	13	63	21	4.5	3.4	6	3	3.3
M5	x 0.8	**TRB10286TIA**	15	70	25	6	4.9	8	3	4.2
M6	x 1.0	**TRB10316TIA**	17	80	30	6	4.9	8	4	5
M8	x 1.25	**TRB10366TIA**	20	90	35	8	6.2	9	4	6.75
M10	x 1.5	**TRB10426TIA**	22	100	39	10	8	11	4	8.5
M12	x 1.75	**TRB10506TIA**	24	110	44	9	7	10	4	10.25
M14	x 2.0	**TRB10546TIA**	26	110	44	11	9	12	5	12
M16	x 2.0	**TRB10606TIA**	27	110	44	12	9	12	5	14
M18	x 2.5	**TRB10656TIA**	30	125	50	14	11	14	5	15.5
M20	x 2.5	**TRB10706TIA**	32	140	54	16	12	15	5	17.5

▶ DIN 371(up to M10) and DIN 376(above M10)

◎ : Excellent ○ : Good

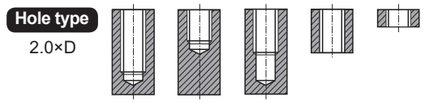
ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	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			◎		◎		◎														

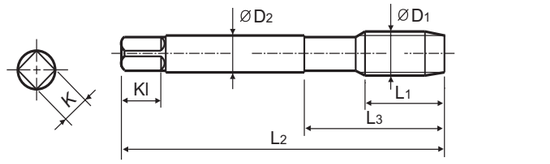
M HSS-PM YG TAP CAST IRON
ISO Metric Coarse Threads - DIN 13

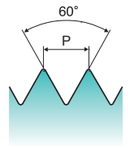
SERIES **TRB06**

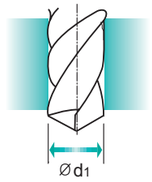
▶ HSS-PM versatile solution with advanced geometry, ensuring stable performance in Cast Iron and Cast Aluminum.



Short Chamfer







Material groups **GG** | HSS PM | DIN 371/376 | 6HX | 60° | E | TiAlN | p.5

Machine Taps

Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1	P	TiAlN	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M3	x 0.5	**TRB06206TIA**	11	56	18	3.5	2.7	6	3	2.5
M4	x 0.7	**TRB06246TIA**	13	63	21	4.5	3.4	6	3	3.3
M5	x 0.8	**TRB06286TIA**	15	70	25	6	4.9	8	3	4.2
M6	x 1.0	**TRB06316TIA**	17	80	30	6	4.9	8	4	5
M8	x 1.25	**TRB06366TIA**	20	90	35	8	6.2	9	4	6.75
M10	x 1.5	**TRB06426TIA**	22	100	39	10	8	11	4	8.5
M12	x 1.75	**TRB06506TIA**	24	110	44	9	7	10	4	10.25
M14	x 2.0	**TRB06546TIA**	26	110	44	11	9	12	5	12
M16	x 2.0	**TRB06606TIA**	27	110	44	12	9	12	5	14
M18	x 2.5	**TRB06656TIA**	30	125	50	14	11	14	5	15.5
M20	x 2.5	**TRB06706TIA**	32	140	54	16	12	15	5	17.5

▶ DIN 371(up to M10) and DIN 376(above M10)

◎ : Excellent ○ : Good

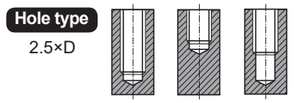
ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	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															◎	◎	◎	◎	○	○

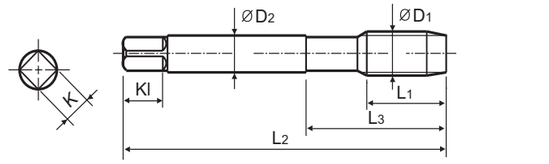
ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	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			◎		○		◎														

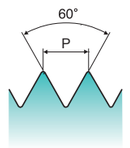
M HSS-PM YG TAP CAST IRON with Oil Hole
ISO Metric Coarse Threads - DIN 13

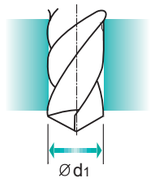
SERIES **TRB19**

▶ HSS-PM versatile solution with advanced geometry, ensuring stable performance in Cast Iron and Cast Aluminum.









Material groups **GG** | HSS PM | DIN 371/376 | 6HX | 60° | C | TiAlN | p.5

Machine Taps

Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1	P	TiAlN	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M5	x 0.8	**TRB19286TIA**	15	70	25	6	4.9	8	3	4.2
M6	x 1.0	**TRB19316TIA**	17	80	30	6	4.9	8	4	5
M8	x 1.25	**TRB19366TIA**	20	90	35	8	6.2	9	4	6.75
M10	x 1.5	**TRB19426TIA**	22	100	39	10	8	11	4	8.5
M12	x 1.75	**TRB19506TIA**	24	110	44	9	7	10	4	10.25
M14	x 2.0	**TRB19546TIA**	26	110	44	11	9	12	5	12
M16	x 2.0	**TRB19606TIA**	27	110	44	12	9	12	5	14
M18	x 2.5	**TRB19656TIA**	30	125	50	14	11	14	5	15.5
M20	x 2.5	**TRB19706TIA**	32	140	54	16	12	15	5	17.5

▶ DIN 371(up to M10) and DIN 376(above M10)

◎ : Excellent ○ : Good

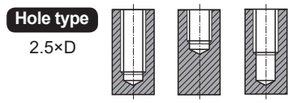
ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	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			◎		◎		◎														

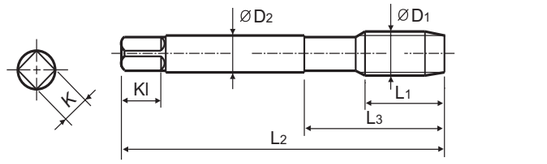
M HSS-PM YG TAP CAST IRON with Oil Hole
ISO Metric Coarse Threads - DIN 13

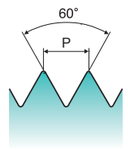
SERIES **TRB13**

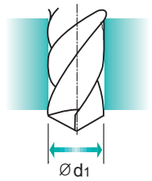
▶ HSS-PM versatile solution with advanced geometry, ensuring stable performance in Cast Iron and Cast Aluminum.



Short Chamfer







Material groups **GG** | HSS PM | DIN 371/376 | 6HX | 60° | E | TiAlN | p.5

Machine Taps

Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1	P	TiAlN	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M5	x 0.8	**TRB13286TIA**	15	70	25	6	4.9	8	3	4.2
M6	x 1.0	**TRB13316TIA**	17	80	30	6	4.9	8	4	5
M8	x 1.25	**TRB13366TIA**	20	90	35	8	6.2	9	4	6.75
M10	x 1.5	**TRB13426TIA**	22	100	39	10	8	11	4	8.5
M12	x 1.75	**TRB13506TIA**	24	110	44	9	7	10	4	10.25
M14	x 2.0	**TRB13546TIA**	26	110	44	11	9	12	5	12
M16	x 2.0	**TRB13606TIA**	27	110	44	12	9	12	5	14
M18	x 2.5	**TRB13656TIA**	30	125	50	14	11	14	5	15.5
M20	x 2.5	**TRB13706TIA**	32	140	54	16	12	15	5	17.5

▶ DIN 371(up to M10) and DIN 376(above M10)

◎ : Excellent ○ : Good

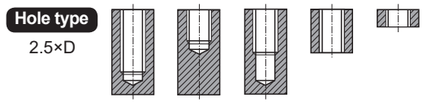
ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	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															◎	◎	◎	◎	○	○

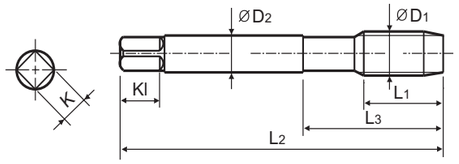
ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	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			◎		○		◎														

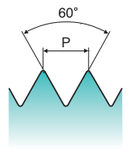
M HSS-PM YG TAP CAST IRON with Oil Hole
ISO Metric Coarse Threads - DIN 13

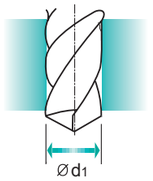
SERIES **TRB23**

▶ HSS-PM versatile solution with advanced geometry, ensuring stable performance in Cast Iron and Cast Aluminum.









Material groups **GG** | HSS PM | DIN 371/376 | 6HX | 60° | C | TiAlN | p.5

Machine Taps

Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1	P	TiAlN	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M5	x 0.8	**TRB23286TIAP**	15	70	25	6	4.9	8	3	4.2
M6	x 1.0	**TRB23316TIAP**	17	80	30	6	4.9	8	4	5
M8	x 1.25	**TRB23366TIAP**	20	90	35	8	6.2	9	4	6.75
M10	x 1.5	**TRB23426TIAP**	22	100	39	10	8	11	4	8.5
M12	x 1.75	**TRB23506TIAP**	24	110	44	9	7	10	4	10.25
M14	x 2.0	**TRB23546TIAP**	26	110	44	11	9	12	5	12
M16	x 2.0	**TRB23606TIAP**	27	110	44	12	9	12	5	14
M18	x 2.5	**TRB23656TIAP**	30	125	50	14	11	14	5	15.5
M20	x 2.5	**TRB23706TIAP**	32	140	54	16	12	15	5	17.5

▶ DIN 371(up to M10) and DIN 376(above M10)

◎ : 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			◎		○		◎														

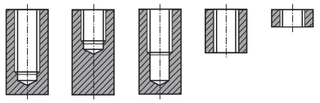
MF CARBIDE YG TAP CAST IRON with Oil Hole
ISO Metric Fine Threads - DIN 13

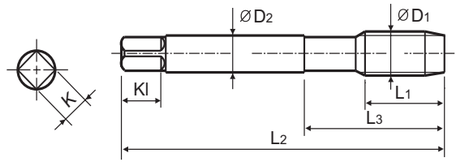
SERIES **T0B05**

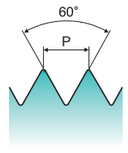
▶ Carbide tap can increase tool life longer than HSS taps due to higher hardness.
Suitable for Cast Iron and Cast Aluminum.

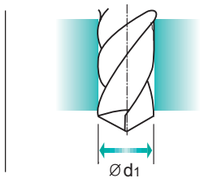
DIN 374

Hole type
2.5×D









Material groups **GG** | CARBIDE | DIN 374 | 6HX | 60° | C | TiAlN | p.4

Machine Taps

Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1	P	TiAlN	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M8	x 1.0	**T0B05376TIAP**	17	90	36	6	4.9	8	4	7
M8	x 0.75	**T0B05386TIAP**	14	80	30	6	4.9	8	4	7.25
M10	x 1.25	**T0B05436TIAP**	22	100	40	7	5.5	8	4	8.75
M10	x 1.0	**T0B05446TIAP**	18	90	36	7	5.5	8	4	9
M12	x 1.5	**T0B05516TIAP**	22	100	40	9	7	10	4	10.5
M12	x 1.25	**T0B05526TIAP**	22	100	40	9	7	10	4	10.75
M12	x 1.0	**T0B05536TIAP**	18	100	40	9	7	10	4	11

◎ : 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			◎		◎		◎													◎	

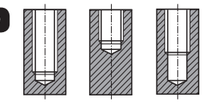
MF CARBIDE YG TAP CAST IRON with Oil Hole
ISO Metric Fine Threads - DIN 13

SERIES **T0B02**

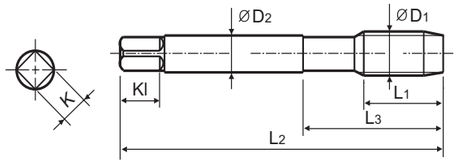
▶ Carbide tap can increase tool life longer than HSS taps due to higher hardness.
Suitable for Cast Iron and Cast Aluminum.

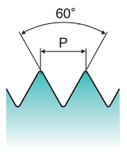
DIN 374

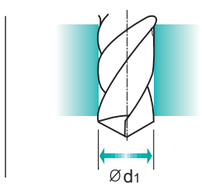
Hole type
2.5×D



Short Chamfer







Material groups **GG** | CARBIDE | DIN 374 | 6HX | 60° | E | TiAlN | p.4

Machine Taps

Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1	P	TiAlN	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M8	x 1.0	**T0B02376TIA**	17	90	36	6	4.9	8	4	7
M8	x 0.75	**T0B02386TIA**	14	80	30	6	4.9	8	4	7.25
M10	x 1.25	**T0B02436TIA**	22	100	40	7	5.5	8	4	8.75
M10	x 1.0	**T0B02446TIA**	18	90	36	7	5.5	8	4	9
M12	x 1.5	**T0B02516TIA**	22	100	40	9	7	10	4	10.5
M12	x 1.25	**T0B02526TIA**	22	100	40	9	7	10	4	10.75
M12	x 1.0	**T0B02536TIA**	18	100	40	9	7	10	4	11

◎ : 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			◎		◎		◎													◎	

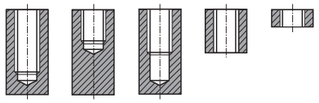
MF HSS-PM YG TAP CAST IRON
ISO Metric Fine Threads - DIN 13

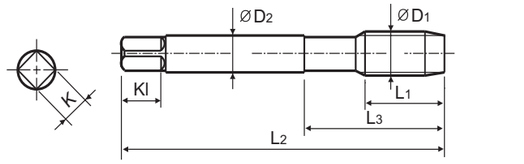
SERIES **TRB11**

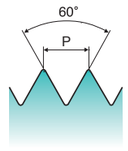
▶ HSS-PM versatile solution with advanced geometry, ensuring stable performance in Cast Iron and Cast Aluminum.

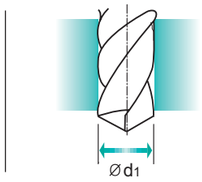
DIN 374

Hole type
2.0×D









Material groups **GG** | HSS PM | DIN 374 | 6HX | 60° | C | TiAlN | p.5

Machine Taps

Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1	P	TiAlN	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M8	x 1.0	**TRB11376TIA**	17	90	36	6	4.9	8	4	7
M8	x 0.75	**TRB11386TIA**	14	80	30	6	4.9	8	4	7.25
M10	x 1.25	**TRB11436TIA**	22	100	40	7	5.5	8	4	8.75
M10	x 1.0	**TRB11446TIA**	18	90	36	7	5.5	8	4	9
M12	x 1.5	**TRB11516TIA**	22	100	40	9	7	10	4	10.5
M12	x 1.25	**TRB11526TIA**	22	100	40	9	7	10	4	10.75
M12	x 1.0	**TRB11536TIA**	18	100	40	9	7	10	4	11
M14	x 1.5	**TRB11556TIA**	22	100	40	11	9	12	5	12.5
M14	x 1.25	**TRB11566TIA**	22	100	40	11	9	12	5	12.75
M14	x 1.0	**TRB11576TIA**	18	100	40	11	9	12	5	13
M16	x 1.5	**TRB11616TIA**	22	100	40	12	9	12	5	14.5
M16	x 1.0	**TRB11626TIA**	18	100	40	12	9	12	5	15
M18	x 1.5	**TRB11676TIA**	25	110	44	14	11	14	5	16.5
M20	x 1.5	**TRB11726TIA**	25	125	50	16	12	15	5	18.5
M22	x 1.5	**TRB11766TIA**	25	125	50	18	14.5	17	5	20.5
M24	x 1.5	**TRB11806TIA**	27	140	54	18	14.5	17	5	22.5

◎ : 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			◎		○		◎														

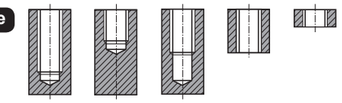
MF HSS-PM YG TAP CAST IRON
ISO Metric Fine Threads - DIN 13

SERIES **TRB07**

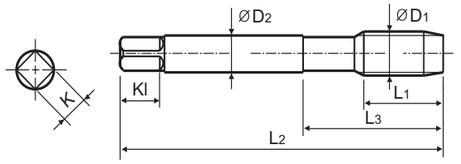
▶ HSS-PM versatile solution with advanced geometry, ensuring stable performance in Cast Iron and Cast Aluminum.

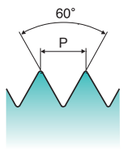
DIN 374

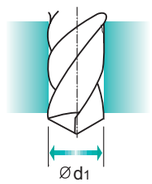
Hole type
2.0×D



Short Chamfer







Material groups **GG** | HSS PM | DIN 374 | 6HX | 60° | E | TiAlN | p.5

Machine Taps

Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1	P	TiAlN	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M8	x 1.0	**TRB07376TIA**	17	90	36	6	4.9	8	4	7
M8	x 0.75	**TRB07386TIA**	14	80	30	6	4.9	8	4	7.25
M10	x 1.25	**TRB07436TIA**	22	100	40	7	5.5	8	4	8.75
M10	x 1.0	**TRB07446TIA**	18	90	36	7	5.5	8	4	9
M12	x 1.5	**TRB07516TIA**	22	100	40	9	7	10	4	10.5
M12	x 1.25	**TRB07526TIA**	22	100	40	9	7	10	4	10.75
M12	x 1.0	**TRB07536TIA**	18	100	40	9	7	10	4	11
M14	x 1.5	**TRB07556TIA**	22	100	40	11	9	12	5	12.5
M14	x 1.25	**TRB07566TIA**	22	100	40	11	9	12	5	12.75
M14	x 1.0	**TRB07576TIA**	18	100	40	11	9	12	5	13
M16	x 1.5	**TRB07616TIA**	22	100	40	12	9	12	5	14.5
M16	x 1.0	**TRB07626TIA**	18	100	40	12	9	12	5	15
M18	x 1.5	**TRB07676TIA**	25	110	44	14	11	14	5	16.5
M20	x 1.5	**TRB07726TIA**	25	125	50	16	12	15	5	18.5
M22	x 1.5	**TRB07766TIA**	25	125	50	18	14.5	17	5	20.5
M24	x 1.5	**TRB07806TIA**	27	140	54	18	14.5	17	5	22.5

◎ : 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			◎		○		◎														

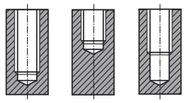
MF HSS-PM YG TAP CAST IRON with Oil Hole
ISO Metric Fine Threads - DIN 13

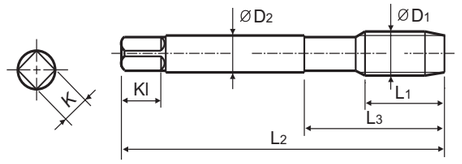
SERIES **TRB20**

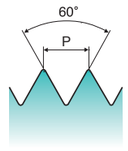
▶ HSS-PM versatile solution with advanced geometry, ensuring stable performance in Cast Iron and Cast Aluminum.

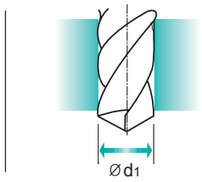
DIN 374

Hole type
2.5×D









Material groups **GG** | HSS PM | DIN 374 | 6HX | 60° | C | TiAlN | p.5

Machine Taps

Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1	P	TiAlN	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M8	x 1.0	**TRB20376TIA**	17	90	36	6	4.9	8	4	7
M8	x 0.75	**TRB20386TIA**	14	80	30	6	4.9	8	4	7.25
M10	x 1.25	**TRB20436TIA**	22	100	40	7	5.5	8	4	8.75
M10	x 1.0	**TRB20446TIA**	18	90	36	7	5.5	8	4	9
M12	x 1.5	**TRB20516TIA**	22	100	40	9	7	10	4	10.5
M12	x 1.25	**TRB20526TIA**	22	100	40	9	7	10	4	10.75
M12	x 1.0	**TRB20536TIA**	18	100	40	9	7	10	4	11
M14	x 1.5	**TRB20556TIA**	22	100	40	11	9	12	5	12.5
M14	x 1.25	**TRB20566TIA**	22	100	40	11	9	12	5	12.75
M14	x 1.0	**TRB20576TIA**	18	100	40	11	9	12	5	13
M16	x 1.5	**TRB20616TIA**	22	100	40	12	9	12	5	14.5
M16	x 1.0	**TRB20626TIA**	18	100	40	12	9	12	5	15
M18	x 1.5	**TRB20676TIA**	25	110	44	14	11	14	5	16.5
M20	x 1.5	**TRB20726TIA**	25	125	50	16	12	15	5	18.5
M22	x 1.5	**TRB20766TIA**	25	125	50	18	14.5	17	5	20.5
M24	x 1.5	**TRB20806TIA**	27	140	54	18	14.5	17	5	22.5

◎ : 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			◎		○		◎														

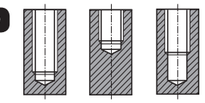
MF HSS-PM YG TAP CAST IRON with Oil Hole
ISO Metric Fine Threads - DIN 13

SERIES **TRB14**

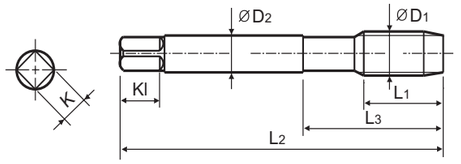
▶ HSS-PM versatile solution with advanced geometry, ensuring stable performance in Cast Iron and Cast Aluminum.

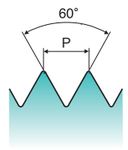
DIN 374

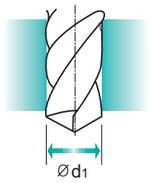
Hole type
2.5×D



Short Chamfer







Material groups **GG** | HSS PM | DIN 374 | 6HX | 60° | E | TiAlN | p.5

Machine Taps

Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1	P	TiAlN	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M8	x 1.0	**TRB14376TIA**	17	90	36	6	4.9	8	4	7
M8	x 0.75	**TRB14386TIA**	14	80	30	6	4.9	8	4	7.25
M10	x 1.25	**TRB14436TIA**	22	100	40	7	5.5	8	4	8.75
M10	x 1.0	**TRB14446TIA**	18	90	36	7	5.5	8	4	9
M12	x 1.5	**TRB14516TIA**	22	100	40	9	7	10	4	10.5
M12	x 1.25	**TRB14526TIA**	22	100	40	9	7	10	4	10.75
M12	x 1.0	**TRB14536TIA**	18	100	40	9	7	10	4	11
M14	x 1.5	**TRB14556TIA**	22	100	40	11	9	12	5	12.5
M14	x 1.25	**TRB14566TIA**	22	100	40	11	9	12	5	12.75
M14	x 1.0	**TRB14576TIA**	18	100	40	11	9	12	5	13
M16	x 1.5	**TRB14616TIA**	22	100	40	12	9	12	5	14.5
M16	x 1.0	**TRB14626TIA**	18	100	40	12	9	12	5	15
M18	x 1.5	**TRB14676TIA**	25	110	44	14	11	14	5	16.5
M20	x 1.5	**TRB14726TIA**	25	125	50	16	12	15	5	18.5
M22	x 1.5	**TRB14766TIA**	25	125	50	18	14.5	17	5	20.5
M24	x 1.5	**TRB14806TIA**	27	140	54	18	14.5	17	5	22.5

◎ : Excellent ○ : Good

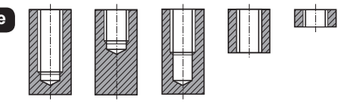
ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	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															◎	◎	◎	◎	○	○

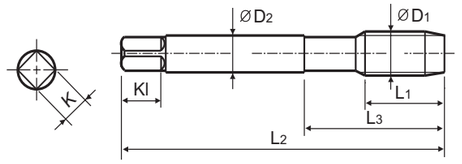
ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	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			◎		○		◎														

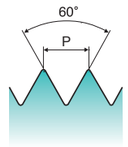
MF HSS-PM YG TAP CAST IRON with Oil Hole
ISO Metric Fine Threads - DIN 13

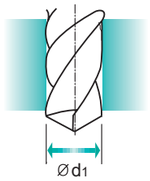
SERIES **TRB24**

▶ HSS-PM versatile solution with advanced geometry, ensuring stable performance in Cast Iron and Cast Aluminum.









Material groups **GG** | HSS PM | DIN 374 | 6HX | 60° | C | TiAlN | p.5

Machine Taps

Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1	P	TiAlN	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M8	x 1.0	**TRB24376TIAP**	17	90	36	6	4.9	8	4	7
M8	x 0.75	**TRB24386TIAP**	14	80	30	6	4.9	8	4	7.25
M10	x 1.25	**TRB24436TIAP**	22	100	40	7	5.5	8	4	8.75
M10	x 1.0	**TRB24446TIAP**	18	90	36	7	5.5	8	4	9
M12	x 1.5	**TRB24516TIAP**	22	100	40	9	7	10	4	10.5
M12	x 1.25	**TRB24526TIAP**	22	100	40	9	7	10	4	10.75
M12	x 1.0	**TRB24536TIAP**	18	100	40	9	7	10	4	11
M14	x 1.5	**TRB24556TIAP**	22	100	40	11	9	12	5	12.5
M14	x 1.25	**TRB24566TIAP**	22	100	40	11	9	12	5	12.75
M14	x 1.0	**TRB24576TIAP**	18	100	40	11	9	12	5	13
M16	x 1.5	**TRB24616TIAP**	22	100	40	12	9	12	5	14.5
M16	x 1.0	**TRB24626TIAP**	18	100	40	12	9	12	5	15
M18	x 1.5	**TRB24676TIAP**	25	110	44	14	11	14	5	16.5
M20	x 1.5	**TRB24726TIAP**	25	125	50	16	12	15	5	18.5
M22	x 1.5	**TRB24766TIAP**	25	125	50	18	14.5	17	5	20.5
M24	x 1.5	**TRB24806TIAP**	27	140	54	18	14.5	17	5	22.5

◎ : Excellent ○ : Good

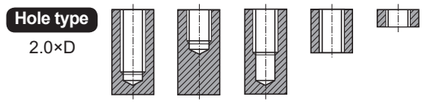
ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	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															◎	◎	◎	◎	○	○

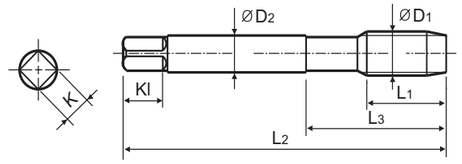
ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	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			◎		◎		◎														

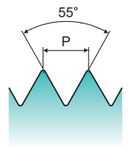
G(BSP) HSS-PM YG TAP CAST IRON
Whitworth Pipe Threads DIN ISO 228/1

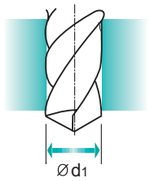
SERIES **TRB12**

▶ HSS-PM versatile solution with advanced geometry, ensuring stable performance in Cast Iron and Cast Aluminum.









Material groups **GG** | HSS PM | DIN 5156 | 55° | C | TiAlN | p.5

Machine Taps

Unit : mm

SIZE	TPI	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1		TiAlN	L1	L2	L3	ØD2	K	Kl	Z	Ød1
G1/16	- 28	**TRB12020TIA**	20	90	36	6	4.9	8	4	6.8
G1/8	- 28	**TRB12200TIA**	20	90	36	7	5.5	8	4	8.8
G1/4	- 19	**TRB12400TIA**	22	100	48	11	9	12	5	11.8
G3/8	- 19	**TRB12480TIA**	22	100	52	12	9	12	5	15.25
G1/2	- 14	**TRB12560TIA**	25	125	70	16	12	15	5	19
G3/4	- 14	**TRB12700TIA**	28	140	82	20	16	19	5	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			◎		◎		◎														

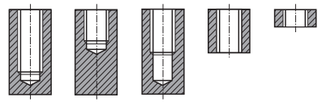
G(BSP) HSS-PM YG TAP CAST IRON
Whitworth Pipe Threads DIN ISO 228/1

SERIES **TRB08**

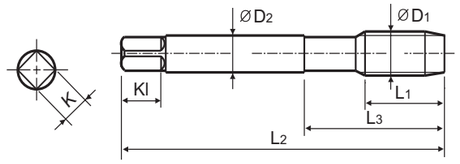
▶ HSS-PM versatile solution with advanced geometry, ensuring stable performance in Cast Iron and Cast Aluminum.

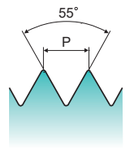
DIN 5156

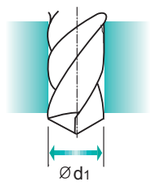
Hole type 2.0×D



Short Chamfer







Material groups **GG** | HSS PM | DIN 5156 | 55° | E | TiAlN | p.5

Machine Taps

Unit : mm

SIZE	TPI	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1		TiAlN	L1	L2	L3	ØD2	K	Kl	Z	Ød1
G1/16	- 28	**TRB08020TIA**	20	90	36	6	4.9	8	4	6.8
G1/8	- 28	**TRB08200TIA**	20	90	36	7	5.5	8	4	8.8
G1/4	- 19	**TRB08400TIA**	22	100	48	11	9	12	5	11.8
G3/8	- 19	**TRB08480TIA**	22	100	52	12	9	12	5	15.25
G1/2	- 14	**TRB08560TIA**	25	125	70	16	12	15	5	19
G3/4	- 14	**TRB08700TIA**	28	140	82	20	16	19	5	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			◎		○		◎														

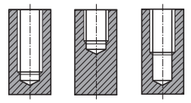
G(BSP) HSS-PM YG TAP CAST IRON with Oil Hole
Whitworth Pipe Threads DIN ISO 228/1

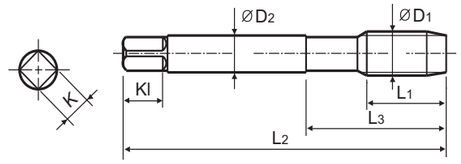
SERIES **TRB22**

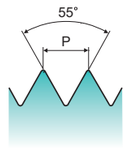
▶ HSS-PM versatile solution with advanced geometry, ensuring stable performance in Cast Iron and Cast Aluminum.

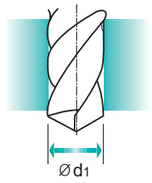
DIN 5156

Hole type 2.5×D









Material groups **GG** | HSS PM | DIN 5156 | 55° | C | TiAlN | p.5

Machine Taps

Unit : mm

SIZE	TPI	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1		TiAlN	L1	L2	L3	ØD2	K	Kl	Z	Ød1
G1/16	- 28	**TRB22020TIA**	20	90	36	6	4.9	8	4	6.8
G1/8	- 28	**TRB22200TIA**	20	90	36	7	5.5	8	4	8.8
G1/4	- 19	**TRB22400TIA**	22	100	48	11	9	12	5	11.8
G3/8	- 19	**TRB22480TIA**	22	100	52	12	9	12	5	15.25
G1/2	- 14	**TRB22560TIA**	25	125	70	16	12	15	5	19

◎ : 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			◎		◎		◎														

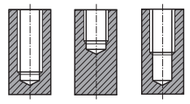
G(BSP) HSS-PM YG TAP CAST IRON with Oil Hole Whitworth Pipe Threads DIN ISO 228/1

SERIES **TRB18**

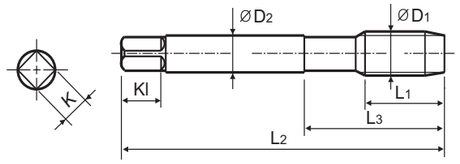
▶ HSS-PM versatile solution with advanced geometry, ensuring stable performance in Cast Iron and Cast Aluminum.

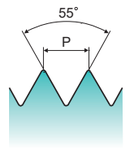
DIN 5156

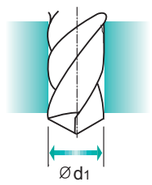
Hole type
2.5×D



Short Chamfer







Material groups **GG** | HSS PM | DIN 5156 | 55° | E | TiAlN | p.5

Machine Taps

Unit : mm

SIZE	TPI	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1		TiAlN	L1	L2	L3	ØD2	K	Kl	Z	Ød1
G1/16	- 28	**TRB18020TIA**	20	90	36	6	4.9	8	4	6.8
G1/8	- 28	**TRB18200TIA**	20	90	36	7	5.5	8	4	8.8
G1/4	- 19	**TRB18400TIA**	22	100	48	11	9	12	5	11.8
G3/8	- 19	**TRB18480TIA**	22	100	52	12	9	12	5	15.25
G1/2	- 14	**TRB18560TIA**	25	125	70	16	12	15	5	19

◎ : 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			◎		○		◎														

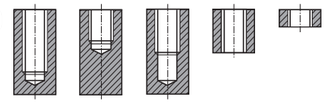
G(BSP) HSS-PM YG TAP CAST IRON with Oil Hole Whitworth Pipe Threads DIN ISO 228/1

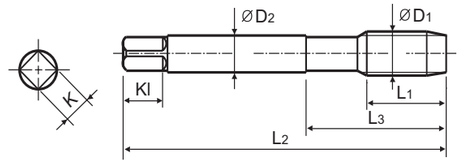
SERIES **TRB25**

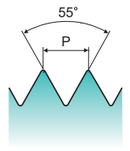
▶ HSS-PM versatile solution with advanced geometry, ensuring stable performance in Cast Iron and Cast Aluminum.

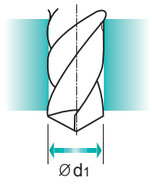
DIN 5156

Hole type
2.5×D









Material groups **GG** | HSS PM | DIN 5156 | 55° | C | TiAlN | p.5

Machine Taps

Unit : mm

SIZE	TPI	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1		TiAlN	L1	L2	L3	ØD2	K	Kl	Z	Ød1
G1/16	- 28	**TRB25020TIAP**	20	90	36	6	4.9	8	4	6.8
G1/8	- 28	**TRB25200TIAP**	20	90	36	7	5.5	8	4	8.8
G1/4	- 19	**TRB25400TIAP**	22	100	48	11	9	12	5	11.8
G3/8	- 19	**TRB25480TIAP**	22	100	52	12	9	12	5	15.25
G1/2	- 14	**TRB25560TIAP**	25	125	70	16	12	15	5	19

◎ : 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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