



Tapping Speeds

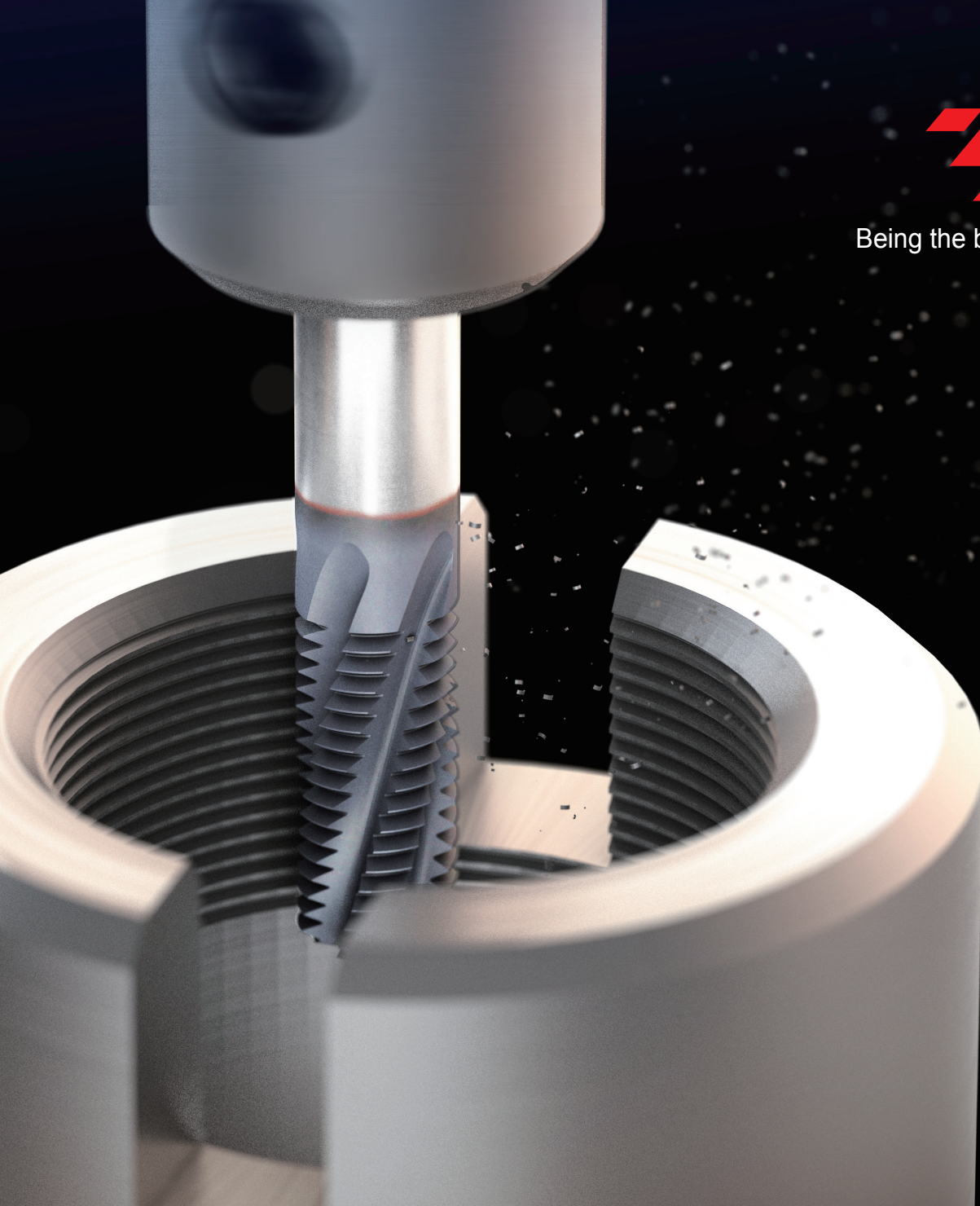


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Being the best through innovation



THREAD MILL

- Threading a Range of Hole Sizes with the Same Thread Mill in a Wide Range of Materials

SELECTION GUIDE



THREADING TOOLS

TYPE	THREAD MILL					
	without Coolant Hole	with Coolant Hole	without Coolant Hole	with Coolant Hole	with Coolant Hole & Chamfer	
HOLE TYPE						
	Blind / Through Hole	Blind / Through Hole	Blind / Through Hole	Blind / Through Hole	Blind / Through Hole	Blind / Through Hole
THREAD FORM	UN	UN	M	M	UN	M
TOOL MATERIAL	CARBIDE	CARBIDE	CARBIDE	CARBIDE	CARBIDE	CARBIDE
FLUTE TYPE	Helix		Helix		Helix	
HELIX ANGLE	R15	R15	R15	R15	R15	R15
SERIES	TE (p.B48)	L421E (p.B50)	TD (p.B51)	L421D (p.B52)	L427E (p.B53)	L427D (p.B54)
SURFACE TREATMENT / COATING	TiAIN					



Please visit globalyg1.com/mat for material search

⊙ : Excellent
○ : Good



ISO	VDI 3323	Material Description	HB	HRC	TE	L421E	TD	L421D	L427E	L427D	
P	1	Non-alloy steel	125		⊙ 250-400	⊙ 250-400	⊙ 250-400	⊙ 250-400	⊙ 250-400	⊙ 250-400	
	2		190	13	⊙ 250-370	⊙ 250-370	⊙ 250-370	⊙ 250-370	⊙ 250-370	⊙ 250-370	
	3		250	25	⊙ 250-360	⊙ 250-360	⊙ 250-360	⊙ 250-360	⊙ 250-360	⊙ 250-360	
	4		270	28	⊙ 230-330	⊙ 230-330	⊙ 230-330	⊙ 230-330	⊙ 230-330	⊙ 230-330	
	5		300	32	⊙ 230-320	⊙ 230-320	⊙ 230-320	⊙ 230-320	⊙ 230-320	⊙ 230-320	
	6	Low alloy steel	180	10	⊙ 250-360	⊙ 250-360	⊙ 250-360	⊙ 250-360	⊙ 250-360	⊙ 250-360	
	7		275	29	⊙ 230-330	⊙ 230-330	⊙ 230-330	⊙ 230-330	⊙ 230-330	⊙ 230-330	
	8		300	32	⊙ 230-320	⊙ 230-320	⊙ 230-320	⊙ 230-320	⊙ 230-320	⊙ 230-320	
	9		350	38	⊙ 200-300	⊙ 200-300	⊙ 200-300	⊙ 200-300	⊙ 200-300	⊙ 200-300	
	10		High alloyed steel, and tool steel	200	15	⊙ 230-320	⊙ 230-320	⊙ 230-320	⊙ 230-320	⊙ 230-320	⊙ 230-320
	11			325	35	⊙ 200-300	⊙ 200-300	⊙ 200-300	⊙ 200-300	⊙ 200-300	⊙ 200-300
M	12	Stainless steel	200	15	○ 200-250	○ 200-250	○ 200-250	○ 200-250	○ 200-250	○ 200-250	
	13		240	23	○ 200-250	○ 200-250	○ 200-250	○ 200-250	○ 200-250	○ 200-250	
	14		180	10	○ 150-250	○ 150-250	○ 150-250	○ 150-250	○ 150-250	○ 150-250	
K	15	Grey cast iron	180	10	⊙ 250-400	⊙ 250-400	⊙ 250-400	⊙ 250-400	⊙ 250-400	⊙ 250-400	
	16		260	26	⊙ 250-360	⊙ 250-360	⊙ 250-360	⊙ 250-360	⊙ 250-360	⊙ 250-360	
	17	Nodular cast iron	160	3	⊙ 250-400	⊙ 250-400	⊙ 250-400	⊙ 250-400	⊙ 250-400	⊙ 250-400	
	18		250	25	⊙ 230-320	⊙ 230-320	⊙ 230-320	⊙ 230-320	⊙ 230-320	⊙ 230-320	
	19		Malleable cast iron	130		⊙ 230-320	⊙ 230-320	⊙ 230-320	⊙ 230-320	⊙ 230-320	⊙ 230-320
20	230	21		⊙ 230-350	⊙ 230-350	⊙ 230-350	⊙ 230-350	⊙ 230-350	⊙ 230-350		
N	21	Aluminum-wrought alloy	60		⊙ 500-1000	⊙ 500-1000	⊙ 500-1000	⊙ 500-1000	⊙ 500-1000	⊙ 500-1000	
	22		100		⊙ 400-800	⊙ 400-800	⊙ 400-800	⊙ 400-800	⊙ 400-800	⊙ 400-800	
	23	Aluminum-cast, alloyed	75		⊙ 350-900	⊙ 350-900	⊙ 350-900	⊙ 350-900	⊙ 350-900	⊙ 350-900	
	24		90		⊙ 350-900	⊙ 350-900	⊙ 350-900	⊙ 350-900	⊙ 350-900	⊙ 350-900	
	25		130		⊙ 350-800	⊙ 350-800	⊙ 350-800	⊙ 350-800	⊙ 350-800	⊙ 350-800	
	26		110		⊙ 500-800	⊙ 500-800	⊙ 500-800	⊙ 500-800	⊙ 500-800	⊙ 500-800	
	27	Copper and Copper Alloys (Bronze / Brass)	90		⊙ 350-800	⊙ 350-800	⊙ 350-800	⊙ 350-800	⊙ 350-800	⊙ 350-800	
	28		100		⊙ 300-600	⊙ 300-600	⊙ 300-600	⊙ 300-600	⊙ 300-600	⊙ 300-600	
	29		⊙ 350-900	⊙ 350-900	⊙ 350-900	⊙ 350-900	⊙ 350-900	⊙ 350-900	⊙ 350-900	⊙ 350-900	
	30	Non Metallic Materials Duroplastic, Fiber Reinforced Plastic, Graphite, CFRP, GFRP, etc.	⊙ 350-900	⊙ 350-900	⊙ 350-900	⊙ 350-900	⊙ 350-900	⊙ 350-900	⊙ 350-900	⊙ 350-900	
S	31	Heat Resistant Super Alloys	200	15	○ 100-200	○ 100-200	○ 100-200	○ 100-200	○ 100-200	○ 100-200	
	32		280	30	○ 70-180	○ 70-180	○ 70-180	○ 70-180	○ 70-180	○ 70-180	
	33		250	25	○ 50-140	○ 50-140	○ 50-140	○ 50-140	○ 50-140	○ 50-140	
	34		350	38	○ 50-120	○ 50-120	○ 50-120	○ 50-120	○ 50-120	○ 50-120	
	35		320	34	○ 50-140	○ 50-140	○ 50-140	○ 50-140	○ 50-140	○ 50-140	
	36	Titanium Alloys	400 Rm		○ 100-250	○ 100-250	○ 100-250	○ 100-250	○ 100-250	○ 100-250	
	37		1050 Rm		○ 60-140	○ 60-140	○ 60-140	○ 60-140	○ 60-140	○ 60-140	
H	38	Hardened steel	550	55							
	39		630	60							
	40	Chilled Cast Iron	400	42							
	41	Hardened Cast Iron	550	55							

THREAD MILL

Miniature		without Coolant Hole	with Coolant Hole	without Coolant Hole	with Coolant Hole	without Coolant Hole	with Coolant Hole
Blind / Through Hole	Blind / Through Hole	Blind / Through Hole	Blind / Through Hole	Blind / Through Hole	Blind / Through Hole	Blind / Through Hole	Blind / Through Hole
UN	M	NPT	NPT	NPTF	NPTF	NPS	NPS
CARBIDE	CARBIDE	CARBIDE	CARBIDE	CARBIDE	CARBIDE	CARBIDE	CARBIDE
Helix		Helix		Helix		Helix	
R15	R15	R15	R15	R15	R15	R15	R15
L12DE (p.B55)	L12DD (p.B56)	TF (p.B57)	L621F (p.B58)	TG (p.B59)	L621G (p.B60)	L121K (p.B61)	L421K (p.B62)

TIAlN



⊙ 220-380	⊙ 220-380	⊙ 250-400	⊙ 250-400	⊙ 250-400	⊙ 250-400	⊙ 250-400	⊙ 250-400	1
⊙ 220-380	⊙ 220-380	⊙ 250-370	⊙ 250-370	⊙ 250-370	⊙ 250-370	⊙ 250-370	⊙ 250-370	2
⊙ 220-380	⊙ 220-380	⊙ 250-360	⊙ 250-360	⊙ 250-360	⊙ 250-360	⊙ 250-360	⊙ 250-360	3
⊙ 220-350	⊙ 220-350	⊙ 230-330	⊙ 230-330	⊙ 230-330	⊙ 230-330	⊙ 230-330	⊙ 230-330	4
⊙ 220-300	⊙ 220-300	⊙ 230-320	⊙ 230-320	⊙ 230-320	⊙ 230-320	⊙ 230-320	⊙ 230-320	5
⊙ 220-350	⊙ 220-350	⊙ 250-360	⊙ 250-360	⊙ 250-360	⊙ 250-360	⊙ 250-360	⊙ 250-360	6
⊙ 220-350	⊙ 220-350	⊙ 230-330	⊙ 230-330	⊙ 230-330	⊙ 230-330	⊙ 230-330	⊙ 230-330	7
⊙ 200-300	⊙ 200-300	⊙ 230-320	⊙ 230-320	⊙ 230-320	⊙ 230-320	⊙ 230-320	⊙ 230-320	8
⊙ 200-300	⊙ 200-300	⊙ 200-300	⊙ 200-300	⊙ 200-300	⊙ 200-300	⊙ 200-300	⊙ 200-300	9
⊙ 220-350	⊙ 220-350	⊙ 230-320	⊙ 230-320	⊙ 230-320	⊙ 230-320	⊙ 230-320	⊙ 230-320	10
⊙ 220-350	⊙ 220-350	⊙ 200-300	⊙ 200-300	⊙ 200-300	⊙ 200-300	⊙ 200-300	⊙ 200-300	11
○ 200-250	○ 200-250	○ 200-250	○ 200-250	○ 200-250	○ 200-250	○ 200-250	○ 200-250	12
○ 200-250	○ 200-250	○ 200-250	○ 200-250	○ 200-250	○ 200-250	○ 200-250	○ 200-250	13
○ 180-220	○ 180-220	○ 150-250	○ 150-250	○ 150-250	○ 150-250	○ 150-250	○ 150-250	14
⊙ 300-500	⊙ 300-500	⊙ 250-400	⊙ 250-400	⊙ 250-400	⊙ 250-400	⊙ 250-400	⊙ 250-400	15
⊙ 300-500	⊙ 300-500	⊙ 250-360	⊙ 250-360	⊙ 250-360	⊙ 250-360	⊙ 250-360	⊙ 250-360	16
⊙ 280-450	⊙ 280-450	⊙ 250-400	⊙ 250-400	⊙ 250-400	⊙ 250-400	⊙ 250-400	⊙ 250-400	17
⊙ 250-400	⊙ 250-400	⊙ 230-320	⊙ 230-320	⊙ 230-320	⊙ 230-320	⊙ 230-320	⊙ 230-320	18
⊙ 250-400	⊙ 250-400	⊙ 230-320	⊙ 230-320	⊙ 230-320	⊙ 230-320	⊙ 230-320	⊙ 230-320	19
⊙ 280-450	⊙ 280-450	⊙ 230-350	⊙ 230-350	⊙ 230-350	⊙ 230-350	⊙ 230-350	⊙ 230-350	20
⊙ 400-1000	⊙ 400-1000	⊙ 500-1000	⊙ 500-1000	⊙ 500-1000	⊙ 500-1000	⊙ 500-1000	⊙ 500-1000	21
⊙ 400-900	⊙ 400-900	⊙ 400-800	⊙ 400-800	⊙ 400-800	⊙ 400-800	⊙ 400-800	⊙ 400-800	22
⊙ 300-900	⊙ 300-900	⊙ 350-900	⊙ 350-900	⊙ 350-900	⊙ 350-900	⊙ 350-900	⊙ 350-900	23
⊙ 300-900	⊙ 300-900	⊙ 350-900	⊙ 350-900	⊙ 350-900	⊙ 350-900	⊙ 350-900	⊙ 350-900	24
⊙ 350-800	⊙ 350-800	⊙ 350-800	⊙ 350-800	⊙ 350-800	⊙ 350-800	⊙ 350-800	⊙ 350-800	25
⊙ 400-700	⊙ 400-700	⊙ 500-800	⊙ 500-800	⊙ 500-800	⊙ 500-800	⊙ 500-800	⊙ 500-800	26
⊙ 350-700	⊙ 350-700	⊙ 350-800	⊙ 350-800	⊙ 350-800	⊙ 350-800	⊙ 350-800	⊙ 350-800	27
⊙ 300-600	⊙ 300-600	⊙ 300-600	⊙ 300-600	⊙ 300-600	⊙ 300-600	⊙ 300-600	⊙ 300-600	28
⊙ 350-700	⊙ 350-700	⊙ 350-900	⊙ 350-900	⊙ 350-900	⊙ 350-900	⊙ 350-900	⊙ 350-900	29
⊙ 350-700	⊙ 350-700	⊙ 350-900	⊙ 350-900	⊙ 350-900	⊙ 350-900	⊙ 350-900	⊙ 350-900	30
○ 150-250	○ 150-250	○ 100-200	○ 100-200	○ 100-200	○ 100-200	○ 100-200	○ 100-200	31
○ 130-200	○ 130-200	○ 70-180	○ 70-180	○ 70-180	○ 70-180	○ 70-180	○ 70-180	32
○ 100-160	○ 100-160	○ 50-140	○ 50-140	○ 50-140	○ 50-140	○ 50-140	○ 50-140	33
○ 100-160	○ 100-160	○ 50-120	○ 50-120	○ 50-120	○ 50-120	○ 50-120	○ 50-120	34
○ 120-180	○ 120-180	○ 50-140	○ 50-140	○ 50-140	○ 50-140	○ 50-140	○ 50-140	35
○ 80-200	○ 80-200	○ 100-250	○ 100-250	○ 100-250	○ 100-250	○ 100-250	○ 100-250	36
○ 80-120	○ 80-120	○ 60-140	○ 60-140	○ 60-140	○ 60-140	○ 60-140	○ 60-140	37
								38
								39
								40
								41

THREAD MILL

SYNCHRO TAP

COMBO TAP

YG TAP BLUE RING

YG TAP STEEL

YG TAP INOX

YG TAP CAST IRON

YG TAP ALU

YG TAP Ti Ni

YG TAP HARDENED STEEL

YG TAP GENERAL

YG TAP FORMING

STI TAP

PIPE TAP

TECHNICAL DATA



Being the best through innovation

HSS-PM

SYNCHRO TAP

- High Speed Tapping with Rigid CNC Machines

SELECTION GUIDE



THREADING TOOLS

SYNCHRO TAP

HOLE TYPE		Max. 2.5xD Blind Hole		Max. 3.0xD Through Hole	
TOOL MATERIAL		HSS-PM	HSS-PM	HSS-PM	HSS-PM
FLUTE TYPE		Spiral Flute		Spiral Point	
SPIRAL FLUTE ANGLE		R45	R45	-	-
SERIES	M				
	M/MF		TTS61 (p.B70)		TTS62 (p.B73)
	UNC				
	UNC/UNF	TTS65 (p.B68)		TTS66 (p.B71)	
	UNC/UNF/UNS				
	UNC/UN8				
	NPT				
	NPTF				
NPS/NPSF					
SURFACE TREATMENT / COATING		TiN		TiN	



Please visit globalyg1.com/mat for material search

⊙ : Excellent
○ : Good



ISO	VDI 3323	Material Description	HB	HRC	⊙	○	⊙	○	⊙	○	
P	1	Non-alloy steel	125		⊙	79-148	⊙	79-148	⊙	79-148	
	2		190	13	⊙	79-148	⊙	79-148	⊙	79-148	
	3		250	25	⊙	79-148	⊙	79-148	⊙	79-148	
	4		270	28	⊙	66-128	⊙	66-128	⊙	66-128	
	5		300	32							
	6	Low alloy steel	180	10	⊙	66-128	⊙	66-128	⊙	66-128	
	7		275	29	⊙	66-128	⊙	66-128	⊙	66-128	
	8		300	32							
	9		350	38							
	10		High alloyed steel, and tool steel	200	15						
	11			325	35						
M	12	Stainless steel	200	15	⊙	39-98	⊙	39-98	⊙	39-98	
	13		240	23	⊙	39-98	⊙	39-98	⊙	39-98	
	14		180	10	○	39-60	○	39-60	○	39-60	
K	15	Grey cast iron	180	10	○	98-148	○	98-148	○	98-148	
	16		260	26							
	17	Nodular cast iron	160	3	⊙	82-148	⊙	82-148	⊙	82-148	
	18		250	25							
	19	Malleable cast iron	130								
	20		230	21							
N	21	Aluminum-wrought alloy	60								
	22		100								
	23	Aluminum-cast, alloyed	75		⊙	148-197	⊙	148-197	⊙	148-197	
	24		90		⊙	148-197	⊙	148-197	⊙	148-197	
	25		130		⊙	82-118	⊙	82-118	⊙	82-118	
	26		110		⊙	98-148	⊙	98-148	⊙	98-148	
	27		90								
	28		100		○	82-118	○	82-118	○	82-118	
	29		Non Metallic Materials Duroplastic, Fiber Reinforced Plastic, Graphite, CFRP, GFRP, etc.								
	30										
S	31	Heat Resistant Super Alloys	200	15							
	32		280	30							
	33		250	25							
	34		350	38							
	35		320	34							
	36	Titanium Alloys	400 Rm								
	37		1050 Rm								
H	38	Hardened steel	550	55							
	39		630	60							
	40	Chilled Cast Iron	400	42							
	41	Hardened Cast Iron	550	55							



Being the best through innovation

HSS-E

COMBO TAP

- HSS-E Taps for Multipurpose

SELECTION GUIDE



THREADING TOOLS

HOLE TYPE		COMBO TAP					
FORM TYPE		Standard					
TOOL MATERIAL		HSS-E	HSS-E	HSS-E	HSS-E	HSS-E	HSS-E
FLUTE TYPE		Spiral Flute					
SPIRAL FLUTE ANGLE		R40	R40	R40	R40	R40	R40
M	USCTI 302A						
M/MF	USCTI 302A				T5 (p.B90)	T5-S (p.B90)	T5-C (p.B90)
	DIN Length-ANSI Shank						
UNC	USCTI Long Shank						
UNC/UNF	USCTI 302						
	USCTI 302A	T2 (p.B86)	T2-S (p.B86)	T2-C (p.B86)			
	DIN Length-ANSI Shank						
SURFACE TREATMENT / COATING		Bright	Steam Oxide	TiCN	Bright	Steam Oxide	TiCN



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◎ : Excellent
○ : Good



ISO	VDI 3323	Material Description	HB	Hrc													
P	1	Non-alloy steel	125		○	25-50	○	25-50	○	50-80	○	25-50	○	25-50	○	50-80	
	2		190	13	◎	25-50	◎	25-50	◎	50-80	◎	25-50	◎	25-50	◎	50-80	
	3		250	25	◎	25-50	◎	25-50	◎	50-80	◎	25-50	◎	25-50	◎	50-80	
	4		270	28	◎	6-30	◎	6-30	◎	10-35	◎	6-30	◎	6-30	◎	10-35	
	5		300	32	◎	6-30	◎	6-30	◎	10-35	◎	6-30	◎	6-30	◎	10-35	
	6	Low alloy steel	180	10	◎	6-30	◎	6-30	◎	10-35	◎	6-30	◎	6-30	◎	10-35	
	7		275	29	◎	6-30	◎	6-30	◎	10-35	◎	6-30	◎	6-30	◎	10-35	
	8		300	32	◎	6-30	◎	6-30	◎	10-35	◎	6-30	◎	6-30	◎	10-35	
	9		350	38	◎	6-30	◎	6-30	◎	10-35	◎	6-30	◎	6-30	◎	10-35	
	10		High alloyed steel, and tool steel	200	15	○	6-30	○	6-30	○	10-35	○	6-30	○	6-30	○	10-35
	11			325	35												
M	12	Stainless steel	200	15	◎	12-35	◎	12-35	◎	20-50	◎	12-35	◎	12-35	◎	20-50	
	13		240	23	◎	12-35	◎	12-35	◎	20-50	◎	12-35	◎	12-35	◎	20-50	
	14		180	10	◎	12-15	◎	12-15	◎	12-15	◎	12-15	◎	12-15	◎	12-15	
K	15	Grey cast iron	180	10	◎	35-50	◎	35-50	◎	50-65	◎	35-50	◎	35-50	◎	50-65	
	16		260	26	◎	35-50	◎	35-50	◎	50-65	◎	35-50	◎	35-50	◎	50-65	
	17	Nodular cast iron	160	3	◎	12-45	◎	12-45	◎	25-55	◎	12-45	◎	12-45	◎	25-55	
	18		250	25	◎	12-45	◎	12-45	◎	25-55	◎	12-45	◎	12-45	◎	25-55	
	19		Malleable cast iron	130													
20	230	21															
N	21	Aluminum-wrought alloy	60														
	22		100														
	23		75		◎	40-65	◎	40-65	◎	45-90	◎	40-65	◎	40-65	◎	45-90	
	24	Aluminum-cast, alloyed	90														
	25		130														
	26	Copper and Copper Alloys (Bronze / Brass)	110		◎	30-65	◎	30-65	◎	30-65	◎	30-65	◎	30-65	◎	30-65	
	27		90		◎	30-65	◎	30-65	◎	30-65	◎	30-65	◎	30-65	◎	30-65	
	28		100		◎	30-65	◎	30-65	◎	30-65	◎	30-65	◎	30-65	◎	30-65	
	29																
	30	Non Metallic Materials Duroplastic, Fiber Reinforced Plastic, Graphite, CFRP, GFRP, etc.															
S	31	Heat Resistant Super Alloys	200	15													
	32		280	30													
	33		250	25													
	34		350	38													
	35		320	34													
	36	Titanium Alloys	400 Rm														
	37		1050 Rm														
H	38	Hardened steel	550	55													
	39		630	60													
	40	Chilled Cast Iron	400	42													
	41	Hardened Cast Iron	550	55													



Being the best through innovation

HSS-PM

YG TAP BLUE RING

- For Steels & Stainless Steels up to 35HRc

SELECTION GUIDE



THREADING TOOLS

YG TAP BLUE RING



HOLE TYPE		Max. 2.5xD Blind Hole					
TOOL MATERIAL		HSS-PM	HSS-PM	HSS-PM	HSS-PM	HSS-PM	HSS-PM
FLUTE TYPE		Spiral Flute		Spiral Flute		Spiral Flute	
SPIRAL FLUTE ANGLE		R40	R40	R40	R40	R40	R40
SERIES	M						
	M/MF			BH (p.B119)	BM (p.B119)		
	UNC						
	UNC/UNF	BB (p.B116)	BI (p.B116)			BF (p.B120)	BK (p.B120)
	UNC/UNF/UNS						
	UNC/UN8						
	NPT						
	NPTF						
NPS/NPSF							
SURFACE TREATMENT / COATING		Steam Oxide	HardSlick	Steam Oxide	HardSlick	Steam Oxide	HardSlick



Please visit globalyg1.com/mat for material search

⊙ : Excellent
○ : Good

ISO	VDI 3323	Material Description	HB	Hrc	1	2	3	4	5	6
P	1	Non-alloy steel	125		○ 25-50	○ 50-80	○ 25-50	○ 50-80	○ 25-50	○ 50-80
	2		190	13	⊙ 25-50	⊙ 50-80	⊙ 25-50	⊙ 50-80	⊙ 25-50	⊙ 50-80
	3		250	25	⊙ 25-50	⊙ 50-80	⊙ 25-50	⊙ 50-80	⊙ 25-50	⊙ 50-80
	4		270	28	⊙ 6-30	⊙ 10-35	⊙ 6-30	⊙ 10-35	⊙ 6-30	⊙ 10-35
	5		300	32	⊙ 6-30	⊙ 10-35	⊙ 6-30	⊙ 10-35	⊙ 6-30	⊙ 10-35
	6	Low alloy steel	180	10	⊙ 6-30	⊙ 10-35	⊙ 6-30	⊙ 10-35	⊙ 6-30	⊙ 10-35
	7		275	29	⊙ 6-30	⊙ 10-35	⊙ 6-30	⊙ 10-35	⊙ 6-30	⊙ 10-35
	8		300	32	⊙ 6-30	⊙ 10-35	⊙ 6-30	⊙ 10-35	⊙ 6-30	⊙ 10-35
	9		350	38	⊙ 6-30	⊙ 10-35	⊙ 6-30	⊙ 10-35	⊙ 6-30	⊙ 10-35
	10		High alloyed steel, and tool steel	200	15					
	11	325		35						
M	12	Stainless steel	200	15	⊙ 12-35	⊙ 20-50	⊙ 12-35	⊙ 20-50	⊙ 12-35	⊙ 20-50
	13		240	23	⊙ 12-35	⊙ 20-50	⊙ 12-35	⊙ 20-50	⊙ 12-35	⊙ 20-50
	14		180	10	⊙ 12-15	⊙ 12-15	⊙ 12-15	⊙ 12-15	⊙ 12-15	⊙ 12-15
K	15	Grey cast iron	180	10						
	16		260	26						
	17	Nodular cast iron	160	3						
	18		250	25						
	19		Malleable cast iron	130						
20	230	21								
N	21	Aluminum-wrought alloy	60		○ 50-60	○ 50-60	○ 50-60	○ 50-60	○ 50-60	○ 50-60
	22		100		○ 50-60	○ 50-60	○ 50-60	○ 50-60	○ 50-60	○ 50-60
	23		75							
	24	Aluminum-cast, alloyed	90							
	25		130							
	26		110		○ 50-60	○ 65-100	○ 50-60	○ 65-100	○ 50-60	○ 65-100
	27	Copper and Copper Alloys (Bronze / Brass)	90		○ 30-65	○ 30-65	○ 30-65	○ 30-65	○ 30-65	○ 30-65
	28		100							
	29		Non Metallic Materials							
	30	Duroplastic, Fiber Reinforced Plastic, Graphite, CFRP, GFRP, etc.								
S	31	Heat Resistant Super Alloys	200	15						
	32		280	30						
	33		250	25						
	34		350	38						
	35		320	34						
	36	Titanium Alloys	400 Rm							
	37		1050 Rm							
H	38	Hardened steel	550	55						
	39		630	60						
	40	Chilled Cast Iron	400	42						
	41	Hardened Cast Iron	550	55						



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HSS-E

YG TAP STEEL

- For carbon and alloy steel

SELECTION GUIDE



THREADING TOOLS

YG TAP STEEL



HOLE TYPE		Max. 2.5xD Blind Hole						
TOOL MATERIAL		HSS-E	HSS-E	HSS-E	HSS-E	HSS-E	HSS-E	
FLUTE TYPE		Spiral Flute						
SPIRAL FLUTE ANGLE		R45	R45	R45	R45	R45	R45	
SERIES	M							
	M/MF			BU (p.B138)	BV (p.B138)	E2 (p.B140)	E4 (p.B140)	E5 (p.B140)
	UNC							
	UNC/UNF	D3 (p.B134)	E0 (p.B134)					
	UNC/UNF/UNS							
	UNC/UN8							
	NPT							
	NPTF							
NPS/NPSF								
SURFACE TREATMENT / COATING		Steam Oxide	HardSlick	Steam Oxide	HardSlick	Steam Oxide	TiCN	HardSlick



Please visit globalyg1.com/mat for material search

◎ : Excellent
○ : Good

ISO	VDI 3323	Material Description	HB	HRc								
P	1	Non-alloy steel	125									
	2		190	13	◎ 25-50	◎ 50-80	◎ 25-50	◎ 50-80	◎ 25-50	◎ 50-80	◎ 50-80	
	3		250	25	◎ 25-50	◎ 50-80	◎ 25-50	◎ 50-80	◎ 25-50	◎ 50-80	◎ 50-80	
	4		270	28	◎ 6-30	◎ 10-35	◎ 6-30	◎ 10-35	◎ 6-30	◎ 10-35	◎ 10-35	
	5	300	32	◎ 6-30	◎ 10-35	◎ 6-30	◎ 10-35	◎ 6-30	◎ 10-35	◎ 10-35		
	6	Low alloy steel	180	10	◎ 6-30	◎ 10-35	◎ 6-30	◎ 10-35	◎ 6-30	◎ 10-35	◎ 10-35	
	7		275	29	◎ 6-30	◎ 10-35	◎ 6-30	◎ 10-35	◎ 6-30	◎ 10-35	◎ 10-35	
	8		300	32	◎ 6-30	◎ 10-35	◎ 6-30	◎ 10-35	◎ 6-30	◎ 10-35	◎ 10-35	
	9		350	38	○ 6-30	○ 10-35	○ 6-30	○ 10-35	○ 6-30	○ 10-35	○ 10-35	
	10		High alloyed steel, and tool steel	200	15	○ 6-30	○ 10-35	○ 6-30	○ 10-35	○ 6-30	○ 10-35	○ 10-35
	11			325	35	○ 6-30	○ 10-35	○ 6-30	○ 10-35	○ 6-30	○ 10-35	○ 10-35
12	Stainless steel			200	15	○ 12-35	○ 20-50	○ 12-35	○ 20-50	○ 12-35	○ 20-50	○ 20-50
13		240	23	○ 12-35	○ 20-50	○ 12-35	○ 20-50	○ 12-35	○ 20-50	○ 20-50		
14		180	10	○ 12-15	○ 12-15	○ 12-15	○ 12-15	○ 12-15	○ 12-15	○ 12-15		
K	15	Grey cast iron	180	10								
	16		260	26								
	17	Nodular cast iron	160	3								
	18		250	25								
	19		Malleable cast iron	130								
20	230	21										
N	21	Aluminum-wrought alloy	60									
	22		100									
	23		75									
	24	Aluminum-cast, alloyed	90									
	25		130									
	26		110									
	27	Copper and Copper Alloys (Bronze / Brass)	90									
	28		100									
	29											
	30	Non Metallic Materials Duroplastic, Fiber Reinforced Plastic, Graphite, CFRP, GFRP, etc.										
S	31	Heat Resistant Super Alloys	200	15								
	32		280	30								
	33		250	25	○ 10-12	○ 10-12	○ 10-12	○ 10-12	○ 10-12	○ 10-12	○ 10-12	
	34		350	38								
	35		320	34								
	36	Titanium Alloys	400 Rm									
	37		1050 Rm									
H	38	Hardened steel	550	55								
	39		630	60								
	40	Chilled Cast Iron	400	42								
	41	Hardened Cast Iron	550	55								



Being the best through innovation

HSS-PM & HSS-E

YG TAP INOX

- For Stainless Steels

SELECTION GUIDE



THREADING TOOLS

		YG TAP INOX				
HOLE TYPE		Max. 2.5xD Blind Hole				
TOOL MATERIAL		HSS-PM	HSS-PM	HSS-PM	HSS-PM	HSS-E
FLUTE TYPE		Spiral Flute				
SPIRAL FLUTE ANGLE		R45	R45	R45	R45	R45
SERIES	M					
	M/MF					
	UNC					
	UNC/UNF	G7 (p.B154)	G8 (p.B154)	G9 (p.B154)	H0 (p.B154)	B1 (p.B155)
	UNC/UNF/UNS					
	UNC/UN8					
	NPT					
	NPTF					
NPS/NPSF						
SURFACE TREATMENT / COATING		TiN	TiN	HardSlick	HardSlick	Bright



Please visit globalyg1.com/mat for material search

⊙ : Excellent
○ : Good



ISO	VDI 3323	Material Description	HB	HRC						
P	1	Non-alloy steel	125		○ 50-80	○ 50-80	○ 50-80	○ 50-80	○ 25-50	
	2		190	13	⊙ 50-80	⊙ 50-80	⊙ 50-80	⊙ 50-80	⊙ 25-50	
	3		250	25	⊙ 50-80	⊙ 50-80	⊙ 50-80	⊙ 50-80	⊙ 25-50	
	4		270	28	⊙ 10-35	⊙ 10-35	⊙ 10-35	⊙ 10-35	⊙ 6-30	
	5		300	32						
	6	Low alloy steel	180	10	⊙ 10-35	⊙ 10-35	⊙ 10-35	⊙ 10-35	⊙ 6-30	
	7		275	29						
	8		300	32						
	9		350	38						
	10		High alloyed steel, and tool steel	200	15					
	11			325	35					
M	12	Stainless steel	200	15	⊙ 20-50	⊙ 20-50	⊙ 20-50	⊙ 20-50	⊙ 12-35	
	13		240	23	⊙ 20-50	⊙ 20-50	⊙ 20-50	⊙ 20-50	⊙ 12-35	
	14		180	10	⊙ 12-15	⊙ 12-15	⊙ 12-15	⊙ 12-15	⊙ 12-15	
K	15	Grey cast iron	180	10						
	16		260	26						
	17	Nodular cast iron	160	3						
	18		250	25						
	19		Malleable cast iron	130						
20	230	21								
N	21	Aluminum-wrought alloy	60		○ 50-65	○ 50-65	○ 50-65	○ 50-65	○ 50-65	
	22		100							
	23		75							
	24	Aluminum-cast, alloyed	90							
	25		130							
	26	Copper and Copper Alloys (Bronze / Brass)	110		○ 30-65	○ 30-65	○ 30-65	○ 30-65	○ 30-65	
	27		90		○ 30-65	○ 30-65	○ 30-65	○ 30-65	○ 30-65	
	28		100							
	29									
	30	Non Metallic Materials Duroplastic, Fiber Reinforced Plastic, Graphite, CFRP, GFRP, etc.								
S	31	Heat Resistant Super Alloys	200	15						
	32		280	30						
	33		250	25						
	34		350	38						
	35		320	34						
	36	Titanium Alloys	400 Rm							
	37		1050 Rm							
H	38	Hardened steel	550	55						
	39		630	60						
	40	Chilled Cast Iron	400	42						
	41	Hardened Cast Iron	550	55						

SELECTION GUIDE



THREADING TOOLS

YG TAP INOX



HOLE TYPE		Max. 3.0xD Through Hole				
TOOL MATERIAL		HSS-PM	HSS-PM	HSS-PM	HSS-PM	HSS-PM
FLUTE TYPE		Spiral Point				
SPIRAL FLUTE ANGLE		-	-	-	-	-
SERIES	M					
	M/MF					
	UNC					
	UNC/UNF	M0 (p.B161)	M1 (p.B161)	M2 (p.B161)	M3 (p.B161)	I0 (p.B162)
	UNC/UNF/UNS					
	UNC/UN8					
	NPT					
	NPTF					
NPS/NPSF						
SURFACE TREATMENT / COATING		TiN	TiN	HardSlick	HardSlick	Steam Oxide



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⊙ : Excellent
○ : Good

ISO	VDI 3323	Material Description	HB	HRC	TiN	TiN	HardSlick	HardSlick	Steam Oxide	
P	1	Non-alloy steel	125		○ 50-80	○ 50-80	○ 50-80	○ 50-80	○ 25-50	
	2		190	13	⊙ 50-80	⊙ 50-80	⊙ 50-80	⊙ 50-80	⊙ 25-50	
	3		250	25	⊙ 50-80	⊙ 50-80	⊙ 50-80	⊙ 50-80	⊙ 25-50	
	4		270	28	⊙ 10-35	⊙ 10-35	⊙ 10-35	⊙ 10-35	⊙ 6-30	
	5		300	32						
	6	Low alloy steel	180	10	⊙ 10-35	⊙ 10-35	⊙ 10-35	⊙ 10-35	⊙ 6-30	
	7		275	29						
	8		300	32						
	9		350	38						
	10		High alloyed steel, and tool steel	200	15					
	11			325	35					
M	12	Stainless steel	200	15	⊙ 20-50	⊙ 20-50	⊙ 20-50	⊙ 20-50	⊙ 12-35	
	13		240	23	⊙ 20-50	⊙ 20-50	⊙ 20-50	⊙ 20-50	⊙ 12-35	
	14		180	10	⊙ 12-15	⊙ 12-15	⊙ 12-15	⊙ 12-15	⊙ 12-15	
K	15	Grey cast iron	180	10						
	16		260	26						
	17	Nodular cast iron	160	3						
	18		250	25						
	19		Malleable cast iron	130						
20	230	21								
N	21	Aluminum-wrought alloy	60		○ 50-65	○ 50-65	○ 50-65	○ 50-65	○ 50-65	
	22		100							
	23		75							
	24	Aluminum-cast, alloyed	90							
	25		130							
	26	Copper and Copper Alloys (Bronze / Brass)	110		○ 30-65	○ 30-65	○ 30-65	○ 30-65	○ 30-65	
	27		90		○ 30-65	○ 30-65	○ 30-65	○ 30-65	○ 30-65	
	28		100							
	29		Non Metallic Materials							
	30	Duroplastic, Fiber Reinforced Plastic, Graphite, CFRP, GFRP, etc.								
S	31	Heat Resistant Super Alloys	200	15						
	32		280	30						
	33		250	25						
	34		350	38						
	35		320	34						
	36	Titanium Alloys	400 Rm							
	37		1050 Rm							
H	38	Hardened steel	550	55						
	39		630	60						
	40		400	42						
	41		550	55						



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SOLID CARBIDE & HSS-PM

YG TAP CAST IRON

- For Cast Iron or Similar Work Materials



Being the best through innovation

HSS-E

YG TAP ALU

- For long-chipping Aluminum Wrought Alloys

SELECTION GUIDE



THREADING TOOLS

		YG TAP CAST IRON				YG TAP ALU	
HOLE TYPE		Max. 3.0xD Through Hole				Max. 2.5xD Blind Hole	
TOOL MATERIAL		HSS-PM	HSS-PM	HSS-PM	Carbide	HSS-E	HSS-E
FLUTE TYPE		Straight Flute				Spiral Flute	
SPIRAL FLUTE ANGLE		-	-	-	-	R50	R50
SERIES	M						
	M/MF	TR (p.B174)	TR-A (p.B177)	TR-R (p.B177)			
	UNC						
	UNC/UNF	TR (p.B173)	TR-A (p.B175)	TR-R (p.B175)	TOC01 (p.B178)	CO (p.B181)	D8 (p.B181)
	UNC/UNF/UNS						
	UNC/UN8						
	NPT						
	NPTF						
NPS/NPSF							
SURFACE TREATMENT / COATING		TiAIN	TiAIN	TiAIN	Bright	Bright	HardSlick



Please visit globalyg1.com/mat for material search

⊙ : Excellent
○ : Good



ISO	VDI 3323	Material Description	HB	HRc							
P	1	Non-alloy steel	125								
	2		190	13							
	3		250	25							
	4		270	28							
	5		300	32							
	6	Low alloy steel	180	10							
	7		275	29							
	8		300	32							
	9		350	38							
	10		High alloyed steel, and tool steel	200	15						
	11	325		35							
M	12	Stainless steel	200	15							
	13		240	23							
	14		180	10							
K	15	Grey cast iron	180	10	⊙ 50-65	⊙ 50-65	⊙ 50-65	⊙ 35-50			
	16		260	26	⊙ 50-65	⊙ 50-65	⊙ 50-65	⊙ 35-50			
	17	Nodular cast iron	160	3	⊙ 25-55	⊙ 25-55	⊙ 25-55	⊙ 12-45			
	18		250	25	⊙ 25-55	⊙ 25-55	⊙ 25-55	⊙ 12-45			
	19		Malleable cast iron	130		○ 25-55	○ 25-55	○ 25-55	○ 12-45		
	20			230	21	○ 25-55	○ 25-55	○ 25-55	○ 12-45		
N	21	Aluminum-wrought alloy	60					○ 50-65	⊙ 50-65	⊙ 50-65	
	22		100					⊙ 50-65	⊙ 50-65	⊙ 50-65	
	23		75		⊙ 45-90	⊙ 45-90	⊙ 45-90	○ 40-65	⊙ 40-65	⊙ 45-90	
	24	Aluminum-cast, alloyed	90		○ 45-90	○ 45-90	○ 45-90	○ 40-65	○ 40-65	○ 45-90	
	25		130								
	26	Copper and Copper Alloys (Bronze / Brass)	110								
	27		90								
	28		100								
	29	Non Metallic Materials Duroplastic, Fiber Reinforced Plastic, Graphite, CFRP, GFRP, etc.									
	30										
S	31	Heat Resistant Super Alloys	200	15							
	32		280	30							
	33		250	25							
	34		350	38							
	35		320	34							
	36	Titanium Alloys	400 Rm								
	37		1050 Rm								
H	38	Hardened steel	550	55							
	39		630	60							
	40	Chilled Cast Iron	400	42							
	41	Hardened Cast Iron	550	55							



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YG TAP ALU

- For long-chipping Aluminum Wrought Alloys



Being the best through innovation

HSS-PM

YG TAP Ti / Ni

- For Heat Resistant Super Alloys and Titanium Alloys



Being the best through innovation

HSS-PM

YG TAP HARDENED STEEL

- For Hardened Steels Applications

SELECTION GUIDE



THREADING TOOLS

YG TAP HARDENED STEEL

HOLE TYPE	Max. 2.5xD Blind Hole			Max. 3.0xD Through Hole		
	HSS-PM	HSS-PM	HSS-PM	HSS-PM	HSS-PM	HSS-PM
TOOL MATERIAL	HSS-PM	HSS-PM	HSS-PM	HSS-PM	HSS-PM	HSS-PM
FLUTE TYPE	Spiral Flute			Spiral Flute		
SPIRAL FLUTE ANGLE	R15	R15	R15	R15	R15	R15
SERIES	M					
	M/MF			TQ858 (p.B195)	TK858 (p.B195)	TR858 (p.B195)
	UNC					
	UNC/UNF	H6 (p.B194)	H7 (p.B194)	H8 (p.B194)		
	UNC/UNF/UNS					
	UNC/UN8					
	NPT					
	NPTF					
NPS/NPSF						
SURFACE TREATMENT / COATING	Bright	TiCN	HardSlick	Steam Oxide	TiCN	HardSlick



Please visit globalyg1.com/mat for material search

⊙ : Excellent
○ : Good

ISO	VDI 3323	Material Description	HB	HRC						
P	1	Non-alloy steel	125							
	2		190	13						
	3		250	25						
	4		270	28						
	5		300	32						
	6	Low alloy steel	180	10						
	7		275	29	○ 6-30	○ 10-35	○ 10-35	○ 6-30	○ 10-35	○ 10-35
	8		300	32	○ 6-30	○ 10-35	○ 10-35	○ 6-30	○ 10-35	○ 10-35
	9		350	38	⊙ 6-30	⊙ 10-35	⊙ 10-35	⊙ 6-30	⊙ 10-35	⊙ 10-35
	10		High alloyed steel, and tool steel	200	15	⊙ 6-12	⊙ 6-12	⊙ 6-12	⊙ 6-12	⊙ 6-12
	11	325		35	⊙ 6-12	⊙ 6-12	⊙ 6-12	⊙ 6-12	⊙ 6-12	⊙ 6-12
M	12	Stainless steel	200	15						
	13		240	23						
	14		180	10						
K	15	Grey cast iron	180	10						
	16		260	26						
	17	Nodular cast iron	160	3						
	18		250	25						
	19		Malleable cast iron	130						
20	230	21								
N	21	Aluminum-wrought alloy	60							
	22		100							
	23		75							
	24	Aluminum-cast, alloyed	90							
	25		130							
	26		110							
	27	Copper and Copper Alloys (Bronze / Brass)	90							
	28		100							
	29									
	30	Non Metallic Materials Duroplastic, Fiber Reinforced Plastic, Graphite, CFRP, GFRP, etc.								
S	31	Heat Resistant Super Alloys	200	15						
	32		280	30						
	33		250	25						
	34		350	38						
	35		320	34						
	36	Titanium Alloys	400 Rm							
	37		1050 Rm							
H	38	Hardened steel	550	55						
	39		630	60						
	40	Chilled Cast Iron	400	42						
	41	Hardened Cast Iron	550	55						



Being the best through innovation

HSS-E & HSS

YG TAP GENERAL

- For General Purpose Through and Blind Hole Applications

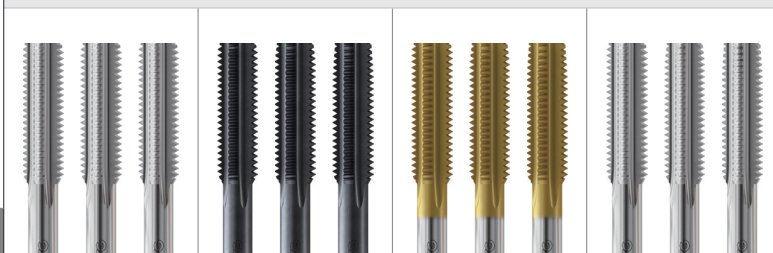
SELECTION GUIDE



THREADING TOOLS

HOLE TYPE		Max. 2.0xD Blind /Through Hole			
TOOL MATERIAL		HSS	HSS	HSS	HSS
FLUTE TYPE		Straight Flute			
SPIRAL FLUTE ANGLE		-	-	-	-
SERIES	M				
	M/MF				T7315 (p.B224)
	UNC				
	UNC/UNF				
	UNC/UNF/UNS	T7316/T7A16/T7B16 (p.B212/B217/B218)	T6316 (p.B220)	T8316 (p.B222)	
	UNC/UN8				
	NPT				
NPTF					
NPS/NPSF					
SURFACE TREATMENT / COATING		Bright	Steam Oxide	TiN	Bright

HAND TAP



Please visit globalyg1.com/mat for material search

⊙ : Excellent
○ : Good

ISO	VDI 3323	Material Description	HB	HRC	⊙	○	⊙	○
P	1	Non-alloy steel	125		○	25-50	○	25-50
	2		190	13	○	25-50	○	25-50
	3		250	25	○	25-50	○	25-50
	4		270	28				
	5		300	32				
	6	Low alloy steel	180	10	○	6-30	○	6-30
	7		275	29				
	8		300	32				
	9		350	38				
	10		High alloyed steel, and tool steel	200	15			
	11	325		35				
M	12	Stainless steel	200	15	○	12-35	○	12-35
	13		240	23				
	14		180	10				
K	15	Grey cast iron	180	10				
	16		260	26				
	17	Nodular cast iron	160	3	○	12-45	○	12-45
	18		250	25	○	12-45	○	12-45
	19		Malleable cast iron	130				
20	230	21						
N	21	Aluminum-wrought alloy	60		○	50-65	○	50-65
	22		100		○	50-65	○	50-65
	23		75		○	40-65	○	40-65
	24	Aluminum-cast, alloyed	90					
	25		130					
	26		110		○	50-60	○	50-60
	27	Copper and Copper Alloys (Bronze / Brass)	90		○	30-65	○	30-65
	28		100					
	29							
	30	Non Metallic Materials Duroplastic, Fiber Reinforced Plastic, Graphite, CFRP, GFRP, etc.						
S	31	Heat Resistant Super Alloys	200	15				
	32		280	30				
	33		250	25				
	34		350	38				
	35		320	34				
	36	Titanium Alloys	400 Rm					
	37		1050 Rm					
H	38	Hardened steel	550	55				
	39		630	60				
	40	Chilled Cast Iron	400	42				
	41	Hardened Cast Iron	550	55				

YG TAP GENERAL



HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS
Straight Flute									
-	-	-	-	left hand	left hand	-	-	-	-
T6315 (p.B225)	T8315 (p.B226)		T7B15 (p.B228)		T7A15 (p.B230)		T7616 (p.B231)	T6616 (p.B231)	T8616 (p.B231)
		T7326 (p.B227)		T7336 (p.B229)					
Steam Oxide	TiN	Bright	Bright	Bright	Bright	Bright	Bright	Steam Oxide	TiN
HAND TAP					Pulley Tap				
○ 25-50	○ 50-80	○ 25-50	○ 25-50	○ 25-50	○ 25-50	○ 25-50	◎ 25-50	◎ 25-50	◎ 50-80
○ 25-50	○ 50-80	○ 25-50	○ 25-50	○ 25-50	○ 25-50	○ 25-50	◎ 25-50	◎ 25-50	◎ 50-80
○ 25-50	○ 50-80	○ 25-50	○ 25-50	○ 25-50	○ 25-50	○ 25-50	◎ 25-50	◎ 25-50	◎ 50-80
○ 6-30	○ 10-35	○ 6-30	○ 6-30	○ 6-30	○ 6-30	○ 6-30	◎ 6-30	◎ 6-30	◎ 10-35
○ 12-35	○ 20-50	○ 12-35	○ 12-35	○ 12-35	○ 12-35	○ 12-35	○ 12-35	○ 12-35	○ 20-50
○ 12-45	○ 25-55	○ 12-45	○ 12-45	○ 12-45	○ 12-45	○ 12-45	○ 12-45	○ 12-45	○ 25-55
○ 12-45	○ 25-55	○ 12-45	○ 12-45	○ 12-45	○ 12-45	○ 12-45	○ 12-45	○ 12-45	○ 25-55
○ 50-65	○ 50-65	○ 50-65	○ 50-65	○ 50-65	○ 50-65	○ 50-65	○ 50-65	○ 50-65	○ 50-65
○ 50-65	○ 50-65	○ 50-65	○ 50-65	○ 50-65	○ 50-65	○ 50-65	○ 50-65	○ 50-65	○ 50-65
○ 40-65	○ 45-90	○ 40-65	○ 40-65	○ 40-65	○ 40-65	○ 40-65	○ 40-65	○ 40-65	○ 45-90
○ 50-60	○ 65-100	○ 50-60	○ 50-60	○ 50-60	○ 50-60	○ 50-60	○ 50-60	○ 50-60	○ 65-100
○ 30-65	○ 30-65	○ 30-65	○ 30-65	○ 30-65	○ 30-65	○ 30-65	○ 30-65	○ 30-65	○ 30-65

- M
- M/MF
- UNC
- UNC/UNF
- UNC/UNF/UNS
- UNC/UNB
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- NPTF
- NPS/NPSF
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- THREAD MILL
- SYNCHRO TAP
- COMBO TAP
- YG TAP BLUE RING
- YG TAP STEEL
- YG TAP INOX
- YG TAP CAST IRON
- YG TAP ALU
- YG TAP Ti Ni
- YG TAP HARDENED STEEL
- YG TAP GENERAL
- YG TAP FORMING
- STI TAP
- PIPE TAP
- TECHNICAL DATA

SELECTION GUIDE



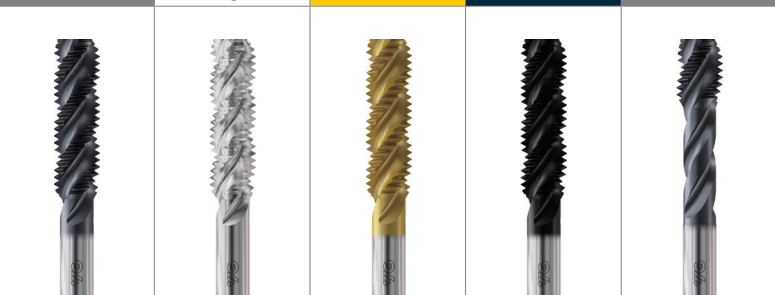
THREADING TOOLS

		YG TAP GENERAL				
HOLE TYPE		Max. 2.5xD Blind Hole				
TOOL MATERIAL		HSS-E	HSS-E	HSS-E	HSS-E	HSS-E
FLUTE TYPE		Spiral Flute				
SPIRAL FLUTE ANGLE		R45	R45	R45	R45	R50
SERIES	M					
	M/MF					
	UNC					
	UNC/UNF	C2 (p.B232)	C3 (p.B232)	C4 (p.B232)	D9 (p.B232)	F4 (p.B234)
	UNC/UNF/UNS					
	UNC/UN8					
	NPT					
	NPTF					
NPS/NPSF						
SURFACE TREATMENT / COATING		Steam Oxide	Bright	TiN	HardSlick	Steam Oxide



Please visit globalyg1.com/mat for material search









◎ : Excellent
○ : Good



ISO	VDI 3323	Material Description	HB	HRC	Steam Oxide	Bright	TiN	HardSlick	Steam Oxide	
P	1	Non-alloy steel	125		◎ 25-50	◎ 25-50	◎ 50-80	◎ 50-80	◎ 25-50	
	2		190	13	◎ 25-50	◎ 25-50	◎ 50-80	◎ 50-80	◎ 25-50	
	3		250	25	◎ 25-50	◎ 25-50	◎ 50-80	◎ 50-80	◎ 25-50	
	4		270	28	○ 6-30	○ 6-30	○ 10-35	○ 10-35	○ 6-30	
	5		300	32	○ 6-30	○ 6-30	○ 10-35	○ 10-35	○ 6-30	
	6	Low alloy steel	180	10	◎ 6-30	◎ 6-30	◎ 10-35	◎ 10-35	◎ 6-30	
	7		275	29	○ 6-30	○ 6-30	○ 10-35	○ 10-35	○ 6-30	
	8		300	32	○ 6-30	○ 6-30	○ 10-35	○ 10-35	○ 6-30	
	9		350	38						
	10		High alloyed steel, and tool steel	200	15					
	11			325	35					
M	12	Stainless steel	200	15	○ 12-35	○ 12-35	○ 20-50	○ 20-50	○ 12-35	
	13		240	23	○ 12-35	○ 12-35	○ 20-50	○ 20-50	○ 12-35	
	14		180	10						
K	15	Grey cast iron	180	10						
	16		260	26						
	17	Nodular cast iron	160	3	○ 12-45	○ 12-45	○ 25-55	○ 25-55	○ 12-45	
	18		250	25	○ 12-45	○ 12-45	○ 25-55	○ 25-55	○ 12-45	
	19		Malleable cast iron	130						
20	230	21								
N	21	Aluminum-wrought alloy	60							
	22		100							
	23		75		○ 40-65	○ 40-65	○ 45-90	○ 45-90	○ 40-65	
	24	Aluminum-cast, alloyed	90		○ 40-65	○ 40-65	○ 45-90	○ 45-90	○ 40-65	
	25		130							
	26	Copper and Copper Alloys (Bronze / Brass)	110		○ 50-60	○ 50-60	○ 65-100	○ 65-100	○ 50-60	
	27		90		○ 30-65	○ 30-65	○ 30-65	○ 30-65	○ 30-65	
	28		100							
	29	Non Metallic Materials Duroplastic, Fiber Reinforced Plastic, Graphite, CFRP, GFRP, etc.								
	30									
S	31	Heat Resistant Super Alloys	200	15						
	32		280	30						
	33		250	25						
	34		350	38						
	35		320	34						
	36	Titanium Alloys	400 Rm							
	37		1050 Rm							
H	38	Hardened steel	550	55						
	39		630	60						
	40	Chilled Cast Iron	400	42						
	41	Hardened Cast Iron	550	55						

YG TAP GENERAL



HSS-E	HSS-E	HSS-E	HSS-E	HSS-E	HSS-E	HSS-E	HSS-E	
Spiral Flute								
R50	R50	R50	R50	R50	R45	R45	R45	
		G4 (p.B236)	G5 (p.B236)	G6 (p.B236)				M
F8 (p.B234)	F6 (p.B234)				G0 (p.B237)	G1 (p.B237)	G2 (p.B237)	M/MF
								UNC
								UNC/UNF
								UNC/UNF/UNS
								UNC/UN8
								NPT
								NPTF
								NPS/NPSF
TiN	HardSlick	Bright	TiCN	HardSlick	Bright	TiN	HardSlick	
								
◎ 50-80	◎ 50-80	◎ 25-50	◎ 50-80	◎ 50-80	◎ 25-50	◎ 50-80	◎ 50-80	1
◎ 50-80	◎ 50-80	◎ 25-50	◎ 50-80	◎ 50-80	◎ 25-50	◎ 50-80	◎ 50-80	2
◎ 50-80	◎ 50-80	◎ 25-50	◎ 50-80	◎ 50-80	◎ 25-50	◎ 50-80	◎ 50-80	3
○ 10-35	○ 10-35	○ 6-30	○ 10-35	○ 10-35	○ 6-30	○ 10-35	○ 10-35	4
◎ 10-35	◎ 10-35	◎ 6-30	◎ 10-35	◎ 10-35	◎ 6-30	◎ 10-35	◎ 10-35	5
◎ 10-35	◎ 10-35	◎ 6-30	◎ 10-35	◎ 10-35	◎ 6-30	◎ 10-35	◎ 10-35	6 P
○ 10-35	○ 10-35	○ 6-30	○ 10-35	○ 10-35	○ 6-30	○ 10-35	○ 10-35	7
○ 10-35	○ 10-35	○ 6-30	○ 10-35	○ 10-35	○ 6-30	○ 10-35	○ 10-35	8
								9
								10
								11
○ 20-50	○ 20-50	○ 12-35	○ 20-50	○ 20-50	○ 12-35	○ 20-50	○ 20-50	12
○ 20-50	○ 20-50	○ 12-35	○ 20-50	○ 20-50	○ 12-35	○ 20-50	○ 20-50	13 M
								14
								15
○ 25-55	○ 25-55	○ 12-45	○ 25-55	○ 25-55	○ 12-45	○ 25-55	○ 25-55	16
○ 25-55	○ 25-55	○ 12-45	○ 25-55	○ 25-55	○ 12-45	○ 25-55	○ 25-55	17 K
								18
								19
								20
								21
○ 45-90	○ 45-90	○ 40-65	○ 45-90	○ 45-90	○ 40-65	○ 45-90	○ 45-90	22
○ 45-90	○ 45-90	○ 40-65	○ 45-90	○ 45-90	○ 40-65	○ 45-90	○ 45-90	23
								24
○ 65-100	○ 65-100	○ 50-60	○ 65-100	○ 50-60	○ 65-100	○ 65-100	○ 50-60	25 N
○ 30-65	○ 30-65	○ 30-65	○ 30-65	○ 30-65	○ 30-65	○ 30-65	○ 30-65	26
								27
								28
								29
								30
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								34 S
								35
								36
								37
								38
								39 H
								40
								41

THREAD MILL

SYNCHRO TAP

COMBO TAP

YG TAP BLUE RING

YG TAP STEEL

YG TAP INOX

YG TAP CAST IRON

YG TAP ALU

YG TAP Ti Ni

YG TAP HARDENED STEEL

YG TAP GENERAL

YG TAP FORMING

STI TAP

PIPE TAP

TECHNICAL DATA

SELECTION GUIDE



THREADING TOOLS



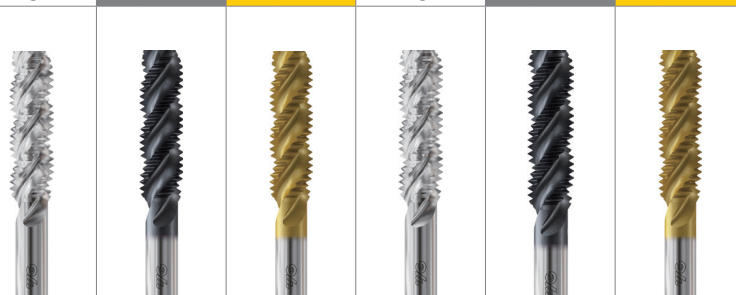
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⊙ : Excellent
○ : Good

YG TAP GENERAL



HOLE TYPE		Max. 2.5xD Blind Hole					
TOOL MATERIAL		HSS	HSS	HSS	HSS	HSS	HSS
FLUTE TYPE		Spiral Flute					
SPIRAL FLUTE ANGLE		R50	R50	R50	R50	R50	R50
SERIES	M						
	M/MF						
	UNC						
	UNC/UNF	T7A96 (p.B239)	T6A96 (p.B239)	T8A96 (p.B239)	T7295 (p.B240)	T6295 (p.B240)	T8295 (p.B240)
	UNC/UNF/UNS						
	UNC/UN8						
	NPT						
	NPTF						
NPS/NPSF							
SURFACE TREATMENT / COATING		Bright	Steam Oxide	TiN	Bright	Steam Oxide	TiN



ISO	VDI 3323	Material Description	HB	Hrc						
P	1	Non-alloy steel	125		⊙ 25-50	⊙ 25-50	⊙ 50-80	⊙ 25-50	⊙ 25-50	⊙ 50-80
	2		190	13	⊙ 25-50	⊙ 25-50	⊙ 50-80	⊙ 25-50	⊙ 25-50	⊙ 50-80
	3		250	25	⊙ 25-50	⊙ 25-50	⊙ 50-80	⊙ 25-50	⊙ 25-50	⊙ 50-80
	4		270	28	○ 6-30	○ 6-30	○ 10-35	○ 6-30	○ 6-30	○ 10-35
	5	300	32	○ 6-30	○ 6-30	○ 10-35	○ 6-30	○ 6-30	○ 10-35	
	6	Low alloy steel	180	10	⊙ 6-30	⊙ 6-30	⊙ 10-35	⊙ 6-30	⊙ 6-30	⊙ 10-35
	7		275	29	○ 6-30	○ 6-30	○ 10-35	○ 6-30	○ 6-30	○ 10-35
	8		300	32	○ 6-30	○ 6-30	○ 10-35	○ 6-30	○ 6-30	○ 10-35
	9		350	38						
	10		High alloyed steel, and tool steel	200	15					
	11	325		35						
M	12	Stainless steel	200	15	○ 12-35	○ 12-35	○ 20-50	○ 12-35	○ 12-35	○ 20-50
	13		240	23	○ 12-35	○ 12-35	○ 20-50	○ 12-35	○ 12-35	○ 20-50
	14		180	10						
K	15	Grey cast iron	180	10						
	16		260	26						
	17	Nodular cast iron	160	3	○ 12-45	○ 12-45	○ 25-55	○ 12-45	○ 12-45	○ 25-55
	18		250	25	○ 12-45	○ 12-45	○ 25-55	○ 12-45	○ 12-45	○ 25-55
	19		Malleable cast iron	130						
20	230	21								
N	21	Aluminum-wrought alloy	60							
	22		100							
	23		75		○ 40-65	○ 40-65	○ 45-90	○ 40-65	○ 40-65	○ 45-90
	24	Aluminum-cast, alloyed	90		○ 40-65	○ 40-65	○ 45-90	○ 40-65	○ 40-65	○ 45-90
	25		130							
	26	Copper and Copper Alloys (Bronze / Brass)	110		○ 50-60	○ 65-100	○ 50-60	○ 50-60	○ 65-100	○ 50-60
	27		90		○ 30-65	○ 30-65	○ 30-65	○ 30-65	○ 30-65	○ 30-65
	28		100							
	29	Non Metallic Materials Duroplastic, Fiber Reinforced Plastic, Graphite, CFRP, GFRP, etc.								
	30									
S	31	Heat Resistant Super Alloys	200	15						
	32		280	30						
	33		250	25						
	34		350	38						
	35		320	34						
	36	Titanium Alloys	400 Rm							
	37		1050 Rm							
H	38	Hardened steel	550	55						
	39		630	60						
	40	Chilled Cast Iron	400	42						
	41	Hardened Cast Iron	550	55						

SELECTION GUIDE



THREADING TOOLS

YG TAP GENERAL

HOLE TYPE		Max. 3.0xD Through Hole				
TOOL MATERIAL		HSS-E	HSS-E	HSS-E	HSS-E	HSS-E
FLUTE TYPE		Spiral Point				
SPIRAL FLUTE ANGLE		-	-	-	-	-
SERIES	M					
	M/MF					
	UNC					
	UNC/UNF	I9 (p.B243)	J0 (p.B243)	J1 (p.B243)	J7 (p.B243)	K9 (p.B245)
	UNC/UNF/UNS					
	UNC/UN8					
	NPT					
	NPTF					
NPS/NPSF						
SURFACE TREATMENT / COATING		Steam Oxide	Bright	TiN	HardSlick	Bright



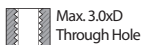
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⊙ : Excellent
○ : Good



ISO	VDI 3323	Material Description	HB	HRC	Steam Oxide	Bright	TiN	HardSlick	Bright	
P	1	Non-alloy steel	125		⊙ 25-50	⊙ 25-50	⊙ 50-80	⊙ 50-80	⊙ 25-50	
	2		190	13	⊙ 25-50	⊙ 25-50	⊙ 50-80	⊙ 50-80	⊙ 25-50	
	3		250	25	⊙ 25-50	⊙ 25-50	⊙ 50-80	⊙ 50-80	⊙ 25-50	
	4		270	28	○ 6-30	○ 6-30	○ 10-35	○ 10-35	○ 6-30	
	5		300	32	○ 6-30	○ 6-30	○ 10-35	○ 10-35	○ 6-30	
	6	Low alloy steel	180	10	⊙ 6-30	⊙ 6-30	⊙ 10-35	⊙ 10-35	⊙ 6-30	
	7		275	29	○ 6-30	○ 6-30	○ 10-35	○ 10-35	○ 6-30	
	8		300	32	○ 6-30	○ 6-30	○ 10-35	○ 10-35	○ 6-30	
	9		350	38						
	10		High alloyed steel, and tool steel	200	15					
	11			325	35					
M	12	Stainless steel	200	15	○ 12-35	○ 12-35	○ 20-50	○ 20-50	○ 12-35	
	13		240	23	○ 12-35	○ 12-35	○ 20-50	○ 20-50	○ 12-35	
	14		180	10						
K	15	Grey cast iron	180	10						
	16		260	26						
	17	Nodular cast iron	160	3	○ 12-45	○ 12-45	○ 25-55	○ 25-55	○ 12-45	
	18		250	25	○ 12-45	○ 12-45	○ 25-55	○ 25-55	○ 12-45	
	19		Malleable cast iron	130						
20	230	21								
N	21	Aluminum-wrought alloy	60							
	22		100							
	23		75		○ 40-65	○ 40-65	○ 45-90	○ 45-90	○ 40-65	
	24	Aluminum-cast, alloyed	90		○ 40-65	○ 40-65	○ 45-90	○ 45-90	○ 40-65	
	25		130							
	26	Copper and Copper Alloys (Bronze / Brass)	110		○ 50-60	○ 50-60	○ 65-100	○ 65-100	○ 50-60	
	27		90		○ 30-65	○ 30-65	○ 30-65	○ 30-65	○ 30-65	
	28		100							
	29	Non Metallic Materials Duroplastic, Fiber Reinforced Plastic, Graphite, CFRP, GFRP, etc.								
	30									
S	31	Heat Resistant Super Alloys	200	15						
	32		280	30						
	33		250	25						
	34		350	38						
	35		320	34						
	36	Titanium Alloys	400 Rm							
	37		1050 Rm							
H	38	Hardened steel	550	55						
	39		630	60						
	40	Chilled Cast Iron	400	42						
	41	Hardened Cast Iron	550	55						

YG TAP GENERAL



HSS-E	HSS-E	HSS-E	HSS-E	HSS-E	HSS-E	HSS-E	HSS-E
Spiral Point							
-	-	-	-	-	-	-	-
L0 (p.B245)	L1 (p.B245)	L7 (p.B247)	L8 (p.B247)	L9 (p.B247)	L3 (p.B248)	L4 (p.B248)	L5 (p.B248)
TiN	HardSlick	Bright	TiCN	HardSlick	Bright	TiN	HardSlick
◎ 50-80	◎ 50-80	◎ 25-50	◎ 50-80	◎ 50-80	◎ 25-50	◎ 50-80	◎ 50-80
◎ 50-80	◎ 50-80	◎ 25-50	◎ 50-80	◎ 50-80	◎ 25-50	◎ 50-80	◎ 50-80
◎ 50-80	◎ 50-80	◎ 25-50	◎ 50-80	◎ 50-80	◎ 25-50	◎ 50-80	◎ 50-80
○ 10-35	○ 10-35	○ 6-30	○ 10-35	○ 10-35	○ 6-30	○ 10-35	○ 10-35
○ 10-35	○ 10-35	○ 6-30	○ 10-35	○ 10-35	○ 6-30	○ 10-35	○ 10-35
◎ 10-35	◎ 10-35	◎ 6-30	◎ 10-35	◎ 10-35	◎ 6-30	◎ 10-35	◎ 10-35
○ 10-35	○ 10-35	○ 6-30	○ 10-35	○ 10-35	○ 6-30	○ 10-35	○ 10-35
○ 10-35	○ 10-35	○ 6-30	○ 10-35	○ 10-35	○ 6-30	○ 10-35	○ 10-35
○ 20-50	○ 20-50	○ 12-35	○ 20-50	○ 20-50	○ 12-35	○ 20-50	○ 20-50
○ 20-50	○ 20-50	○ 12-35	○ 20-50	○ 20-50	○ 12-35	○ 20-50	○ 20-50
○ 25-55	○ 25-55	○ 12-45	○ 25-55	○ 25-55	○ 12-45	○ 25-55	○ 25-55
○ 25-55	○ 25-55	○ 12-45	○ 25-55	○ 25-55	○ 12-45	○ 25-55	○ 25-55
○ 45-90	○ 45-90	○ 40-65	○ 45-90	○ 45-90	○ 40-65	○ 45-90	○ 45-90
○ 45-90	○ 45-90	○ 40-65	○ 45-90	○ 45-90	○ 40-65	○ 45-90	○ 45-90
○ 65-100	○ 65-100	○ 50-60	○ 65-100	○ 65-100	○ 50-60	○ 65-100	○ 65-100
○ 30-65	○ 30-65	○ 30-65	○ 30-65	○ 30-65	○ 30-65	○ 30-65	○ 30-65

M
M/MF
UNC
UNC/UNF
UNC/UNF/UNS
UNC/UN8
NPT
NPTF
NPS/NPSF

THREAD MILL

SYNCHRO TAP

COMBO TAP

YG TAP BLUE RING

YG TAP STEEL

YG TAP INOX

YG TAP CAST IRON

YG TAP ALU

YG TAP Ti Ni

YG TAP HARDENED STEEL

YG TAP GENERAL

YG TAP FORMING

STI TAP

PIPE TAP

TECHNICAL DATA

1
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3
4
5
6 P
7
8
9
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11
12
13 M
14
15
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17 K
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19
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23
24
25 N
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34 S
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39 H
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41

SELECTION GUIDE



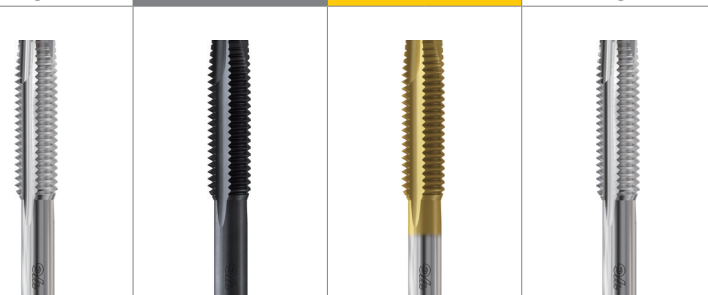
THREADING TOOLS

		YG TAP GENERAL			
HOLE TYPE		Max. 3.0xD Through Hole			
TOOL MATERIAL		HSS	HSS	HSS	HSS
FLUTE TYPE		Spiral Point			
SPIRAL FLUTE ANGLE		-	-	-	-
SERIES	M				
	M/MF				
	UNC				
	UNC/UNF	T7216 (p.B250)	T6216 (p.B250)	T8216 (p.B250)	T7C16 (p.B254)
	UNC/UNF/UNS				
	UNC/UN8				
	NPT				
	NPTF				
NPS/NPSF					
SURFACE TREATMENT / COATING		Bright	Steam Oxide	TiN	Bright



Please visit globalyg1.com/mat for material search

⊙ : Excellent
○ : Good



ISO	VDI 3323	Material Description	HB	HRC	Bright	Steam Oxide	TiN	Bright
P	1	Non-alloy steel	125		⊙ 25-50	⊙ 25-50	⊙ 50-80	⊙ 25-50
	2		190	13	⊙ 25-50	⊙ 25-50	⊙ 50-80	⊙ 25-50
	3		250	25	⊙ 25-50	⊙ 25-50	⊙ 50-80	⊙ 25-50
	4		270	28	○ 6-30	○ 6-30	○ 10-35	○ 6-30
	5	300	32	○ 6-30	○ 6-30	○ 10-35	○ 6-30	
	6	Low alloy steel	180	10	⊙ 6-30	⊙ 6-30	⊙ 10-35	⊙ 6-30
	7		275	29	○ 6-30	○ 6-30	○ 10-35	○ 6-30
	8		300	32	○ 6-30	○ 6-30	○ 10-35	○ 6-30
	9		350	38				
	10		High alloyed steel, and tool steel	200	15			
	11	325		35				
M	12	Stainless steel	200	15	○ 12-35	○ 12-35	○ 20-50	○ 12-35
	13		240	23	○ 12-35	○ 12-35	○ 20-50	○ 12-35
	14		180	10				
K	15	Grey cast iron	180	10				
	16		260	26				
	17	Nodular cast iron	160	3	○ 12-45	○ 12-45	○ 25-55	○ 12-45
	18		250	25	○ 12-45	○ 12-45	○ 25-55	○ 12-45
	19		Malleable cast iron	130				
20	230	21						
N	21	Aluminum-wrought alloy	60					
	22		100					
	23	Aluminum-cast, alloyed	75		○ 40-65	○ 40-65	○ 45-90	○ 40-65
	24		90		○ 40-65	○ 40-65	○ 45-90	○ 40-65
	25		130					
	26		Copper and Copper Alloys (Bronze / Brass)	110		○ 50-60	○ 50-60	○ 65-100
	27	90		○ 30-65	○ 30-65	○ 30-65	○ 30-65	
	28	100						
	29	Non Metallic Materials Duroplastic, Fiber Reinforced Plastic, Graphite, CFRP, GFRP, etc.						
	30							
S	31	Heat Resistant Super Alloys	200	15				
	32		280	30				
	33		250	25				
	34		350	38				
	35		320	34				
	36	Titanium Alloys	400 Rm					
	37		1050 Rm					
H	38	Hardened steel	550	55				
	39		630	60				
	40	Chilled Cast Iron	400	42				
	41	Hardened Cast Iron	550	55				

YG TAP GENERAL



HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	
Spiral Point								
-	-	-	-	-	-	-	-	
		T7217 (p.B255)	T6217 (p.B255)	T8217 (p.B255)				
T6C16 (p.B254)	T8C16 (p.B254)				T7226 (p.B256)	T6226 (p.B256)	T8226 (p.B256)	
Steam Oxide	TiN	Bright	Steam Oxide	TiN	Bright	Steam Oxide	TiN	
◎ 25-50	◎ 50-80	◎ 25-50	◎ 25-50	◎ 50-80	◎ 25-50	◎ 25-50	◎ 50-80	1
◎ 25-50	◎ 50-80	◎ 25-50	◎ 25-50	◎ 50-80	◎ 25-50	◎ 25-50	◎ 50-80	2
◎ 25-50	◎ 50-80	◎ 25-50	◎ 25-50	◎ 50-80	◎ 25-50	◎ 25-50	◎ 50-80	3
○ 6-30	○ 10-35	○ 6-30	○ 6-30	○ 10-35	○ 6-30	○ 6-30	○ 10-35	4
◎ 6-30	◎ 10-35	◎ 6-30	◎ 6-30	◎ 10-35	◎ 6-30	◎ 6-30	◎ 10-35	5
◎ 6-30	◎ 10-35	◎ 6-30	◎ 6-30	◎ 10-35	◎ 6-30	◎ 6-30	◎ 10-35	6
○ 6-30	○ 10-35	○ 6-30	○ 6-30	○ 10-35	○ 6-30	○ 6-30	○ 10-35	7
○ 6-30	○ 10-35	○ 6-30	○ 6-30	○ 10-35	○ 6-30	○ 6-30	○ 10-35	8
								9
								10
								11
○ 12-35	○ 20-50	○ 12-35	○ 12-35	○ 20-50	○ 12-35	○ 12-35	○ 20-50	12
○ 12-35	○ 20-50	○ 12-35	○ 12-35	○ 20-50	○ 12-35	○ 12-35	○ 20-50	13
								14
								15
○ 12-45	○ 25-55	○ 12-45	○ 12-45	○ 25-55	○ 12-45	○ 12-45	○ 25-55	16
○ 12-45	○ 25-55	○ 12-45	○ 12-45	○ 25-55	○ 12-45	○ 12-45	○ 25-55	17
								18
								19
								20
								21
○ 40-65	○ 45-90	○ 40-65	○ 40-65	○ 45-90	○ 40-65	○ 40-65	○ 45-90	22
○ 40-65	○ 45-90	○ 40-65	○ 40-65	○ 45-90	○ 40-65	○ 40-65	○ 45-90	23
								24
○ 50-60	○ 65-100	○ 50-60	○ 50-60	○ 65-100	○ 50-60	○ 50-60	○ 65-100	25
○ 30-65	○ 30-65	○ 30-65	○ 30-65	○ 30-65	○ 30-65	○ 30-65	○ 30-65	26
								27
								28
								29
								30
								31
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								40
								41

THREAD MILL

SYNCHRO TAP

COMBO TAP

YG TAP BLUE RING

YG TAP STEEL

YG TAP INOX

YG TAP CAST IRON

YG TAP ALU

YG TAP TiNi

YG TAP HARDENED STEEL

YG TAP GENERAL

YG TAP FORMING

STI TAP

PIPE TAP

TECHNICAL DATA

SELECTION GUIDE



THREADING TOOLS

SERIES	HOLE TYPE
	TOOL MATERIAL
	FLUTE TYPE
	SPIRAL FLUTE ANGLE
	M
	M/MF
	UNC
	UNC/UNF
	UNC/UNF/UNS
	UNC/UN8
NPT	
NPTF	
NPS/NPSF	
SURFACE TREATMENT / COATING	

YG TAP GENERAL



HSS	HSS	HSS	HSS
Spiral Point			
-	-	-	-
T7B17 (p.B257)	T6B17 (p.B257)	T8B17 (p.B257)	
			T7236 (p.B258)
Bright	Steam Oxide	TiN	Bright
			Pulley Tap



Please visit globalyg1.com/mat for material search

⊙ : Excellent
○ : Good

ISO	VDI 3323	Material Description	HB	HRC					
P	1	Non-alloy steel	125		⊙ 25-50	⊙ 25-50	⊙ 50-80	⊙ 25-50	
	2		190	13	⊙ 25-50	⊙ 25-50	⊙ 50-80	⊙ 25-50	
	3		250	25	⊙ 25-50	⊙ 25-50	⊙ 50-80	⊙ 25-50	
	4		270	28	○ 6-30	○ 6-30	○ 10-35	○ 6-30	
	5		300	32	○ 6-30	○ 6-30	○ 10-35	○ 6-30	
	6	Low alloy steel	180	10	⊙ 6-30	⊙ 6-30	⊙ 10-35	⊙ 6-30	
	7		275	29	○ 6-30	○ 6-30	○ 10-35	○ 6-30	
	8		300	32	○ 6-30	○ 6-30	○ 10-35	○ 6-30	
	9		350	38					
	10		High alloyed steel, and tool steel	200	15				
	11			325	35				
M	12	Stainless steel	200	15	○ 12-35	○ 12-35	○ 20-50	○ 12-35	
	13		240	23	○ 12-35	○ 12-35	○ 20-50	○ 12-35	
	14		180	10					
K	15	Grey cast iron	180	10					
	16		260	26					
	17	Nodular cast iron	160	3	○ 12-45	○ 12-45	○ 25-55	○ 12-45	
	18		250	25	○ 12-45	○ 12-45	○ 25-55	○ 12-45	
	19		Malleable cast iron	130					
20	230	21							
N	21	Aluminum-wrought alloy	60						
	22		100						
	23		75		○ 40-65	○ 40-65	○ 45-90	○ 40-65	
	24	Aluminum-cast, alloyed	90		○ 40-65	○ 40-65	○ 45-90	○ 40-65	
	25		130						
	26		Copper and Copper Alloys (Bronze / Brass)	110		○ 50-60	○ 50-60	○ 65-100	○ 50-60
	27			90		○ 30-65	○ 30-65	○ 30-65	○ 30-65
	28	100							
	29	Non Metallic Materials Duroplastic, Fiber Reinforced Plastic, Graphite, CFRP, GFRP, etc.							
	30								
S	31	Heat Resistant Super Alloys	200	15					
	32		280	30					
	33		250	25					
	34		350	38					
	35		320	34					
	36	Titanium Alloys	400 Rm						
	37		1050 Rm						
H	38	Hardened steel	550	55					
	39		630	60					
	40	Chilled Cast Iron	400	42					
	41	Hardened Cast Iron	550	55					



Being the best through innovation

HSS-PM, HSS-E & HSS

YG TAP FORMING

- For Forming Ductile Materials

SELECTION GUIDE



THREADING TOOLS

		YG TAP FORMING			
HOLE TYPE					
TOOL MATERIAL		HSS-PM	HSS-E	HSS-E	HSS-E
FLUTE TYPE		-			
SPIRAL FLUTE ANGLE		-	-	-	-
SERIES	M				
	M/MF				
	UNC				
	UNC/UNF	TKR03 (p.B266)	ZF (p.B268)	Z0 (p.B269)	Z1 (p.B269)
	UNC/UNF/UNS				
	UNC/UN8				
	NPT				
	NPTF				
NPS/NPSF					
SURFACE TREATMENT / COATING		TiCN	Bright	Bright	TiN



Please visit globalyg1.com/mat for material search

◎ : Excellent
○ : Good



ISO	VDI 3323	Material Description	HB	HRC	TiCN	Bright	Bright	TiN	
P	1	Non-alloy steel	125		◎ 50-80	◎ 25-50	◎ 25-50	◎ 50-80	
	2		190	13	◎ 50-80	◎ 25-50	◎ 25-50	◎ 50-80	
	3		250	25	◎ 50-80		◎ 25-50	◎ 50-80	
	4		270	28					
	5		300	32	◎ 10-35		◎ 6-30	◎ 10-35	
	6	Low alloy steel	180	10					
	7		275	29					
	8		300	32					
	9		350	38					
	10		High alloyed steel, and tool steel	200	15				
	11			325	35				
M	12	Stainless steel	200	15	◎ 20-50	◎ 12-35	◎ 12-35	◎ 20-50	
	13		240	23	◎ 20-50	◎ 12-35	◎ 12-35	◎ 20-50	
	14		180	10	○ 12-15	○ 12-15	○ 12-15	○ 12-15	
K	15	Grey cast iron	180	10					
	16		260	26					
	17	Nodular cast iron	160	3					
	18		250	25					
	19		Malleable cast iron	130					
20	230	21							
N	21	Aluminum-wrought alloy	60		◎ 50-65	◎ 50-65	◎ 50-65	◎ 50-65	
	22		100		◎ 50-65	◎ 50-65	◎ 50-65	◎ 50-65	
	23		75		○ 45-90	○ 40-65	○ 40-65	○ 45-90	
	24	Aluminum-cast, alloyed	90		○ 45-90	○ 40-65	○ 40-65	○ 45-90	
	25		130						
	26	Copper and Copper Alloys (Bronze / Brass)	110		◎ 30-65		◎ 30-65	◎ 30-65	
	27		90		◎ 30-65		◎ 30-65	◎ 30-65	
	28		100						
	29		Non Metallic Materials						
	30	Duroplastic, Fiber Reinforced Plastic, Graphite, CFRP, GFRP, etc.							
S	31	Heat Resistant Super Alloys	200	15					
	32		280	30					
	33		250	25					
	34		350	38					
	35		320	34					
	36	Titanium Alloys	400 Rm						
	37		1050 Rm						
H	38	Hardened steel	550	55					
	39		630	60					
	40	Chilled Cast Iron	400	42					
	41	Hardened Cast Iron	550	55					

YG TAP FORMING



HSS-E	HSS-E	HSS-E	HSS-E	HSS-E	HSS-E	HSS-E
-	-	-	-	-	-	-
-	-	-	-	-	-	Z8 (p.B274)
Z2 (p.B269)	Z3 (p.B269)	Z4 (p.B272)	Z5 (p.B272)	Z6 (p.B272)	Z7 (p.B272)	Z8 (p.B274)
Bright	TiN	Bright	TiN	Bright	TiN	Bright
⊙ 25-50	⊙ 50-80	⊙ 25-50	⊙ 50-80	⊙ 25-50	⊙ 50-80	⊙ 25-50
⊙ 25-50	⊙ 50-80	⊙ 25-50	⊙ 50-80	⊙ 25-50	⊙ 50-80	⊙ 25-50
⊙ 25-50	⊙ 50-80	⊙ 25-50	⊙ 50-80	⊙ 25-50	⊙ 50-80	⊙ 25-50
⊙ 6-30	⊙ 10-35	⊙ 6-30	⊙ 10-35	⊙ 6-30	⊙ 10-35	⊙ 6-30
⊙ 12-35	⊙ 20-50	⊙ 12-35	⊙ 20-50	⊙ 12-35	⊙ 20-50	⊙ 12-35
⊙ 12-35	⊙ 20-50	⊙ 12-35	⊙ 20-50	⊙ 12-35	⊙ 20-50	⊙ 12-35
○ 12-15	○ 12-15	○ 12-15	○ 12-15	○ 12-15	○ 12-15	○ 12-15
⊙ 50-65	⊙ 50-65	⊙ 50-65	⊙ 50-65	⊙ 50-65	⊙ 50-65	⊙ 50-65
⊙ 50-65	⊙ 50-65	⊙ 50-65	⊙ 50-65	⊙ 50-65	⊙ 50-65	⊙ 50-65
○ 40-65	○ 45-90	○ 40-65	○ 45-90	○ 40-65	○ 45-90	○ 40-65
○ 40-65	○ 45-90	○ 40-65	○ 45-90	○ 40-65	○ 45-90	○ 40-65
⊙ 30-65	⊙ 30-65	⊙ 30-65	⊙ 30-65	⊙ 30-65	⊙ 30-65	⊙ 30-65
⊙ 30-65	⊙ 30-65	⊙ 30-65	⊙ 30-65	⊙ 30-65	⊙ 30-65	⊙ 30-65

THREAD MILL

SYNCHRO TAP

COMBO TAP

YG TAP BLUE RING

YG TAP STEEL

YG TAP INOX

YG TAP CAST IRON

YG TAP ALU

YG TAP Ti Ni

YG TAP HARDENED STEEL

YG TAP GENERAL

YG TAP FORMING

STI TAP

PIPE TAP

TECHNICAL DATA

YG TAP FORMING



Max. 3.0xD
Blind / Through Hole

HSS-E	HSS	HSS	HSS	HSS	HSS	HSS
-	-	-	-	-	-	-
ZD (p.B274)						
	T7R01 (p.B275)	T8R01 (p.B275)	THR01 (p.B275)	T7R02 (p.B276)	T8R02 (p.B276)	THR02 (p.B276)
TiCN	Bright	TiN	TiCN	Bright	TiN	TiCN
⊙ 50-80	⊙ 25-50	⊙ 50-80	⊙ 50-80	⊙ 25-50	⊙ 50-80	⊙ 50-80
⊙ 50-80	⊙ 25-50	⊙ 50-80	⊙ 50-80	⊙ 25-50	⊙ 50-80	⊙ 50-80
⊙ 50-80	⊙ 25-50	⊙ 50-80	⊙ 50-80	⊙ 25-50	⊙ 50-80	⊙ 50-80
⊙ 10-35	⊙ 6-30	⊙ 10-35	⊙ 10-35	⊙ 6-30	⊙ 10-35	⊙ 10-35
⊙ 20-50	⊙ 12-35	⊙ 20-50	⊙ 20-50	⊙ 12-35	⊙ 20-50	⊙ 20-50
⊙ 20-50	⊙ 12-35	⊙ 20-50	⊙ 20-50	⊙ 12-35	⊙ 20-50	⊙ 20-50
○ 12-15	○ 12-15	○ 12-15	○ 12-15	○ 12-15	○ 12-15	○ 12-15
⊙ 50-65	⊙ 50-65	⊙ 50-65	⊙ 50-65	⊙ 50-65	⊙ 50-65	⊙ 50-65
⊙ 50-65	⊙ 50-65	⊙ 50-65	⊙ 50-65	⊙ 50-65	⊙ 50-65	⊙ 50-65
○ 45-90	○ 40-65	○ 45-90	○ 45-90	○ 40-65	○ 45-90	○ 45-90
○ 45-90	○ 40-65	○ 45-90	○ 45-90	○ 40-65	○ 45-90	○ 45-90
⊙ 30-65	⊙ 30-65	⊙ 30-65	⊙ 30-65	⊙ 30-65	⊙ 30-65	⊙ 30-65
⊙ 30-65	⊙ 30-65	⊙ 30-65	⊙ 30-65	⊙ 30-65	⊙ 30-65	⊙ 30-65

M
M/MF
UNC
UNC/UNF
UNC/UNF/ANS
UNC/UNF/8
NPT
NPTF
NPS/NPSF

THREAD
MILL

SYNCHRO
TAP

COMBO
TAP

YG TAP
BLUE RING

YG TAP
STEEL

YG TAP
INOX

YG TAP
CAST IRON

YG TAP
ALU

YG TAP
Ti Ni

YG TAP
HARDENED
STEEL

YG TAP
GENERAL

YG TAP
FORMING

STI TAP

PIPE TAP

TECHNICAL
DATA

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Being the best through innovation

HSS-E & HSS

SCREW THREAD INSERT TAP

- For Tapping STI Threads

SELECTION GUIDE



THREADING TOOLS



Please visit globalyg1.com/mat for material search

◎ : Excellent
○ : Good

SCREW THREAD INSERT TAP

HOLE TYPE	Max. 2.5xD Blind Hole			Max. 3.0xD Through Hole	
	HSS-E	HSS	HSS	HSS-E	HSS
TOOL MATERIAL	HSS-E	HSS	HSS	HSS-E	HSS
FLUTE TYPE	Spiral Flute			Spiral Point	
SPIRAL FLUTE ANGLE	R40	R50	R50	-	-
SERIES	M				
	M/MF			T7425 (p.B283)	
	UNC				
	UNC/UNF	ST/SI (p.B280)	T7406 (p.B281)		ST/SI (p.B284)
	UNC/UNF/UNS				T7436 (p.B285)
	UNC/UN8				
	NPT				
	NPTF				
SURFACE TREATMENT / COATING	HardSlick	Bright	Bright	HardSlick	Bright



ISO	VDI 3323	Material Description	HB	HRC	◎	○	◎	○	◎	○	
P	1	Non-alloy steel	125		◎	○	◎	○	◎	○	
	2		190	13	◎	○	◎	○	◎	○	
	3		250	25	◎	○	◎	○	◎	○	
	4		270	28	○	○	○	○	○	○	
	5		300	32							
	6	Low alloy steel	180	10	◎	○	○	○	◎	○	
	7		275	29							
	8		300	32							
	9		350	38							
	10		High alloyed steel, and tool steel	200	15						
	11			325	35						
M	12	Stainless steel	200	15							
	13		240	23							
	14		180	10							
K	15	Grey cast iron	180	10	○	○	○	○	○	○	
	16		260	26	○	○	○	○	○	○	
	17	Nodular cast iron	160	3							
	18		250	25							
	19		Malleable cast iron	130							
20	230	21									
N	21	Aluminum-wrought alloy	60		○	○	○	○	○	○	
	22		100		○	○	○	○	○	○	
	23	Aluminum-cast, alloyed	75		○	○	○	○	○	○	
	24		90		○	○	○	○	○	○	
	25		130								
	26		Copper and Copper Alloys (Bronze / Brass)	110							
	27			90							
	28			100							
	29		Non Metallic Materials Duroplastic, Fiber Reinforced Plastic, Graphite, CFRP, GFRP, etc.								
	30										
S	31	Heat Resistant Super Alloys	200	15							
	32		280	30							
	33		250	25							
	34		350	38							
	35		320	34							
	36	Titanium Alloys	400 Rm								
	37		1050 Rm								
H	38	Hardened steel	550	55							
	39		630	60							
	40	Chilled Cast Iron	400	42							
	41	Hardened Cast Iron	550	55							



Being the best through innovation

HSS-E & HSS

SCREW THREAD INSERT TAP

- For Tapping STI Threads



Being the best through innovation

HSS-E & HSS

PIPE TAP

- For Tapping National Pipe Threads

SCREW THREAD INSERT TAP **PIPE TAP**



HSS HSS-E HSS-E HSS-E HSS-E HSS-E HSS-E HSS-E HSS-E

Spiral Point Straight Flute Spiral Flute

- - - R15 R15 R15 R15 R15 R15

T7415 (p.B287) **T7405** (p.B290)

T7426 (p.B288)

Q1 (p.B296) **Q0** (p.B296) **Q6** (p.B296) **Q9** (p.B297) **R0** (p.B297) **R1** (p.B297)

Bright Bright Bright Bright Steam Oxide HardSlick Bright TiN HardSlick



○ 25-50 ○ 25-50 ○ 25-50 ○ 15-40 ○ 15-40 ○ 15-40 ◎ 15-40 ◎ 15-40 ◎ 15-40

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○ 50-65 ○ 50-65 ○ 50-65

○ 40-65 ○ 40-65 ○ 40-65 ○ 20-35 ○ 20-35 ○ 20-35

○ 40-65 ○ 40-65 ○ 40-65

M M/MF UNC UNC/UNF UNC/UNF/UNS UNC/UN8 NPT NPTF NPS/NPSF

SYNCHRO TAP COMBO TAP YG TAP BLUE RING YG TAP STEEL YG TAP INOX YG TAP CAST IRON YG TAP ALU YG TAP Ti Ni YG TAP HARDENED STEEL YG TAP GENERAL YG TAP FORMING STI TAP PIPE TAP TECHNICAL DATA

1 2 3 4 5 6 P 7 8 9 10 11 12 13 M 14 15 16 17 K 18 19 20 21 22 23 24 25 N 26 27 28 29 30 31 32 33 34 S 35 36 37 38 39 H 40 41

SELECTION GUIDE



THREADING TOOLS



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◎ : Excellent
○ : Good

ISO	VDI 3323	Material Description	HB	HRC	Bright	TiN	HardSlick	Nitrided Steam Oxide
P	1	Non-alloy steel	125		◎ 15-40	◎ 15-40	◎ 15-40	◎ 15-40
	2		190	13	◎ 15-40	◎ 15-40	◎ 15-40	◎ 15-40
	3		250	25	◎ 10-25	◎ 10-25	◎ 10-25	◎ 10-25
	4		270	28	○ 10-20	○ 10-20	○ 10-20	○ 10-20
	5	300	32	○ 10-20	○ 10-20	○ 10-20	○ 10-20	
	6	Low alloy steel	180	10	◎ 10-25	◎ 10-25	◎ 10-25	◎ 10-25
	7		275	29	○ 10-25	○ 10-25	○ 10-25	○ 10-25
	8		300	32	○ 10-25	○ 10-25	○ 10-25	○ 10-25
	9		350	38				
	10		High alloyed steel, and tool steel	200	15			
	11	325		35				
M	12	Stainless steel	200	15				
	13		240	23				
	14		180	10				
K	15	Grey cast iron	180	10	○ 15-50	○ 15-50	○ 15-50	○ 15-50
	16		260	26	○ 15-50	○ 15-50	○ 15-50	○ 15-50
	17	Nodular cast iron	160	3	◎ 15-50	◎ 15-50	◎ 15-50	◎ 15-50
	18		250	25	◎ 15-50	◎ 15-50	◎ 15-50	◎ 15-50
	19		Malleable cast iron	130				
20	230	21						
N	21	Aluminum-wrought alloy	60					
	22		100					
	23	Aluminum-cast, alloyed	75					
	24		90					
	25		130					
	26		110					
	27	Copper and Copper Alloys (Bronze / Brass)	90					
	28		100					
	29		Non Metallic Materials Duroplastic, Fiber Reinforced Plastic, Graphite, CFRP, GFRP, etc.					
	30							
S	31	Heat Resistant Super Alloys	200	15				
	32		280	30				
	33		250	25				
	34		350	38				
	35		320	34				
	36	Titanium Alloys	400 Rm					
	37		1050 Rm					
H	38	Hardened steel	550	55				
	39		630	60				
	40	Chilled Cast Iron	400	42				
	41	Hardened Cast Iron	550	55				

PIPE TAP



HOLE TYPE	Max. 2.0xD Blind/Through Hole			
TOOL MATERIAL	HSS-E	HSS-E	HSS-E	HSS-E
FLUTE TYPE	Straight Flute			
SPIRAL FLUTE ANGLE	-	-	-	-
SERIES	M			
	M/MF			
	UNC			
	UNC/UNF			
	UNC/UNF/UNS			
	UNC/UN8			
	NPT			
	NPTF	R7 (p.B298)	R8 (p.B298)	R9 (p.B298)
NPS/NPSF				
SURFACE TREATMENT / COATING	Bright	TiN	HardSlick	Nitrided Steam Oxide



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