



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							