



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						

