



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		400	42						
	41		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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	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					
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	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	
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	27		90		○ 30-65	○ 30-65	○ 30-65	○ 30-65	○ 30-65	
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	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						

