

EUROPE



COMBO

SPIRAL FLUTE
GUN POINT

TAP



 YG-1 CO., LTD.

TEST RESULT AGAINST COMPETITOR'S COMBO TAP

● TEST I - M8 x 1.25

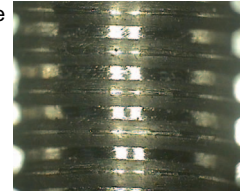
Test Condition

- Work Material : Carbon Steels(S45C)
- Tapping Depth : 20 mm
- Coolant : Water Soluble
- Vc : 10.0m/min

YG-1(Total Tapping 204 Holes)

Surface Roughness of Work Piece

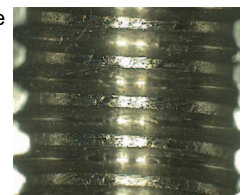
204 Hole ▶



COMPITITOR A (Total Tapping 159 Holes)

Surface Roughness of Work Piece

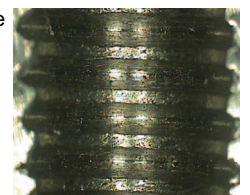
159 Hole ▶



COMPITITOR B (Total Tapping 204 Holes)

Surface Roughness of Work Piece

204 Hole ▶



● TEST II - M10 x 1.5

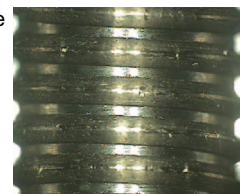
Test Condition

- Work Material : Carbon Steels(S45C)
- Tapping Depth : 25mm
- Coolant : Water Soluble
- Vc : 10.0m/min

YG-1(Total Tapping 216 Holes)

Surface Roughness of Work Piece

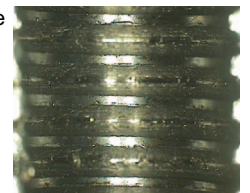
216 Hole ▶



COMPITITOR A (Total Tapping 99 Holes)

Surface Roughness of Work Piece

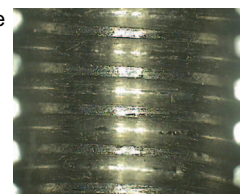
99 Hole ▶



COMPITITOR B (Total Tapping 196 Holes)

Surface Roughness of Work Piece

196 Hole ▶



RECOMMENDED TAPPING SPEEDS

Work Materials		Spiral Flute	Tapping Speed	Gun point	Tapping Speed
		TC814,TC834	(m/min)	TC804,TC824	(m/min)
Steels	Structure steels	●	15 ~ 20	●	15 ~ 20
	Plain carbon steels	●	12 ~ 18	●	12 ~ 18
	Alloy steels up to 850N/mm ²	●	10 ~ 15	●	10 ~ 15
	Hardened & Tempered steels up to 1,200N/mm ²	○	6 ~ 10	○	6 ~ 10
Stainless steels	Free machining	●	7 ~ 10	●	7 ~ 10
	Austenitic	●	5 ~ 8	●	5 ~ 8
Cast iron	Grey Cast irons up to 500N/mm ²	○	10 ~ 15	○	10 ~ 15
	Malleable Cast irons up to 700N/mm ²	○	10 ~ 15	○	10 ~ 15
	Nodular graphite up to 700N/mm ²	○	10 ~ 15	○	10 ~ 15
Aluminum	Alloyed Aluminum, Si<10%	○	15 ~ 20	○	15 ~ 20
	Alloyed Aluminum, Si>10%	●	10 ~ 15	●	10 ~ 15
Titanium	Unalloyed Titanium	●	10 ~ 15	●	10 ~ 15
	Alloyed Titanium up to 900N/mm ²	○	8 ~ 12	○	8 ~ 12
Nickel	Unalloyed Nickel	●	8 ~ 12	●	8 ~ 12
	Alloyed Nickel up to 900N/mm ²	○	10 ~ 15	○	10 ~ 15
Copper	Unalloyed Copper	●	8 ~ 12	●	8 ~ 12
	Long chipping Copper	●	15 ~ 20	●	15 ~ 20
Brass	Long chipping Brass	●	15 ~ 20	●	15 ~ 20
Bronze	Long chipping Bronze	●	15 ~ 20	●	15 ~ 20

● : RECOMMENDED
○ : SUITABLE

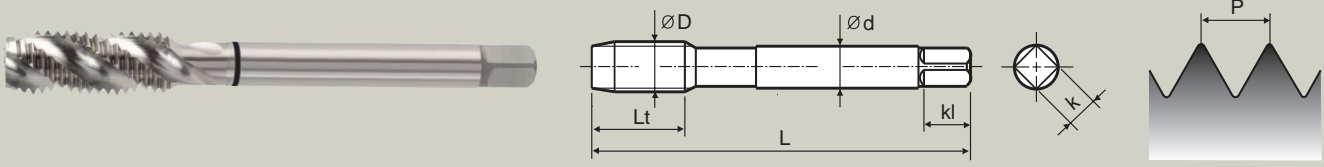
**International
patent**

FEATURES OF COMBO TAP

1. Thread configuration with a special design. (International patent)
 - * Prevents over-feeding, thin thread and pitch diameter oversize.
2. Flute geometry with special design.
 - * Better chip evacuation.
 - * Prevents chip clogging.
 - * Improves thread quality.
3. Applicable for wide applications.
 - * Blind and through holes.
4. Excellent performance on various materials.
 - * Carbon Steels, Alloyed Steels, Tool Steel etc.

ISO Metric coarse threads DIN13

SPIRAL FLUTE TAPS for Multi Purpose



SPIRAL FLUTE TAPS ♦ **TC804**



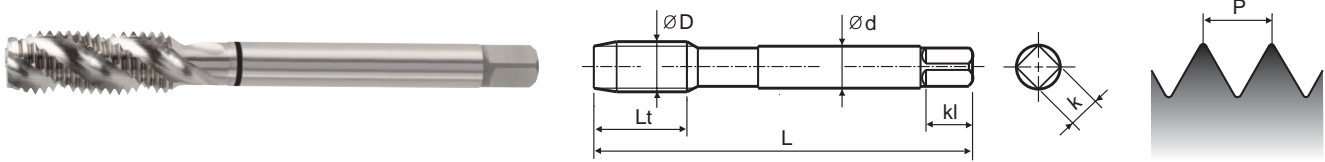
Unit : mm

SIZE		Pitch	Limit	EDP No.	Overall Length	Thread Length	Shank Diameter	Square Size
D	P	L			Lt	d	k	
M2	x 0.4	6H	TC804136	45.0	8.0	2.8	2.1	
M2.2	x 0.45	6H	TC804156	45.0	8.0	2.8	2.1	
M2.3	x 0.4	6H	TC804196	45.0	8.0	2.8	2.1	
M2.5	x 0.45	6H	TC804176	50.0	9.0	2.8	2.1	
M2.6	x 0.45	6H	TC804496	50.0	9.0	2.8	2.1	
M3	x 0.5	6H	TC804206	56.0	6.0	3.5	2.7	
M3.5	x 0.6	6H	TC804226	56.0	7.0	4.0	3.0	
M4	x 0.7	6H	TC804246	63.0	7.0	4.5	3.4	
M4.5	x 0.75	6H	TC804266	70.0	8.0	6.0	4.9	
M5	x 0.8	6H	TC804286	70.0	8.0	6.0	4.9	
M6	x 1.0	6H	TC804316	80.0	10.0	6.0	4.9	
M7	x 1.0	6H	TC804346	80.0	10.0	7.0	5.5	
M8	x 1.25	6H	TC804366	90.0	13.0	8.0	6.2	
M9	x 1.25	6H	TC804396	90.0	13.0	9.0	7.0	
M10	x 1.5	6H	TC804426	100.0	15.0	10.0	8.0	
M11	x 1.5	6H	TC804466	100.0	15.0	8.0	6.2	
M12	x 1.75	6H	TC804506	110.0	18.0	9.0	7.0	
M14	x 2.0	6H	TC804546	110.0	20.0	11.0	9.0	
M16	x 2.0	6H	TC804606	110.0	20.0	12.0	9.0	
M18	x 2.5	6H	TC804656	125.0	25.0	14.0	11.0	
M20	x 2.5	6H	TC804706	140.0	25.0	16.0	12.0	
M22	x 2.5	6H	TC804746	140.0	25.0	18.0	14.5	
M24	x 3.0	6H	TC804786	160.0	30.0	18.0	14.5	
M27	x 3.0	6H	TC804866	160.0	30.0	20.0	16.0	
M30	x 3.5	6H	TC804946	180.0	35.0	22.0	18.0	

► DIN371 (M2~M10) and DIN376 (M11~M30)

ISO Metric fine threads DIN13

SPIRAL FLUTE TAPS for Multi Purpose



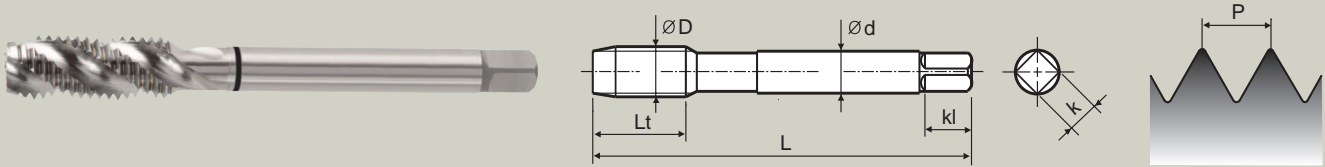
SPIRAL FLUTE TAPS ♦ **TC804**



Unit : mm

SIZE		Pitch	Limit	EDP No.	Overall Length	Thread Length	Shank Diameter	Square Size
D	P	L			Lt	d	k	
M4	x 0.5	6H	TC804256	63.0	5.0	2.8	2.1	
M5	x 0.5	6H	TC804296	70.0	5.0	3.5	2.7	
M6	x 0.75	6H	TC804326	80.0	8.0	4.5	3.4	
M6	x 0.5	6H	TC804336	80.0	5.0	4.5	3.4	
M7	x 0.75	6H	TC804356	80.0	10.0	5.5	4.3	
M8	x 1.0	6H	TC804376	90.0	10.0	6.0	4.9	
M8	x 0.75	6H	TC804386	80.0	8.0	6.0	4.9	
M10	x 1.25	6H	TC804436	100.0	16.0	7.0	5.5	
M10	x 1.0	6H	TC804446	90.0	10.0	7.0	5.5	
M10	x 0.75	6H	TC804456	90.0	10.0	7.0	5.5	
M12	x 1.5	6H	TC804516	100.0	15.0	9.0	7.0	
M12	x 1.25	6H	TC804526	100.0	15.0	9.0	7.0	
M12	x 1.0	6H	TC804536	100.0	11.0	9.0	7.0	
M14	x 1.5	6H	TC804556	100.0	15.0	11.0	9.0	
M14	x 1.25	6H	TC804566	100.0	15.0	11.0	9.0	
M14	x 1.0	6H	TC804576	100.0	11.0	11.0	9.0	
M16	x 1.5	6H	TC804616	100.0	15.0	12.0	9.0	
M16	x 1.0	6H	TC804626	100.0	12.0	12.0	9.0	
M18	x 1.5	6H	TC804676	110.0	17.0	14.0	11.0	
M18	x 1.0	6H	TC804686	110.0	13.0	14.0	11.0	
M20	x 1.5	6H	TC804726	125.0	17.0	16.0	12.0	
M20	x 1.0	6H	TC804736	125.0	14.0	16.0	12.0	
M22	x 1.5	6H	TC804766	125.0	17.0	18.0	14.5	
M22	x 1.0	6H	TC804776	125.0	14.0	18.0	14.5	
M24	x 2.0	6H	TC804796	140.0	20.0	18.0	14.5	
M24	x 1.5	6H	TC804806	140.0	20.0	18.0	14.5	
M26	x 1.5	6H	TC804856	140.0	20.0	18.0	14.5	
M27	x 2.0	6H	TC804876	140.0	20.0	20.0	16.0	
M27	x 1.5	6H	TC804886	140.0	20.0	20.0	16.0	
M28	x 1.5	6H	TC804916	140.0	20.0	20.0	16.0	
M30	x 2.0	6H	TC804966	150.0	22.0	22.0	18.0	
M30	x 1.5	6H	TC804976	150.0	22.0	22.0	18.0	

Unified coarse threads SPIRAL FLUTE TAPS for Multi Purpose



SPIRAL FLUTE TAPS ♦ TC824



DIN371/376

Unit : mm

SIZE	TPI	Limit	EDP No.	Overall Length	Thread Length	Shank Diameter	Square Size
D				L	Lt	d	k
#4	- 40 UNC	2B	TC824162	56.0	6.0	3.5	2.7
#5	- 40 UNC	2B	TC824202	56.0	7.0	3.5	2.7
#6	- 32 UNC	2B	TC824242	56.0	7.0	4.0	3.0
#8	- 32 UNC	2B	TC824282	63.0	8.0	4.5	3.4
#10	- 24 UNC	2B	TC824322	70.0	10.0	6.0	4.9
#12	- 24 UNC	2B	TC824362	80.0	10.0	6.0	4.9
1/4	- 20 UNC	2B	TC824402	80.0	13.0	7.0	5.5
5/16	- 18 UNC	2B	TC824442	90.0	14.0	8.0	6.2
3/8	- 16 UNC	2B	TC824482	100.0	16.0	9.0	7.0
7/16	- 14 UNC	2B	TC824522	100.0	17.0	8.0	6.2
1/2	- 13 UNC	2B	TC824562	110.0	20.0	9.0	7.0
9/16	- 12 UNC	2B	TC824602	110.0	20.0	11.0	9.0
5/8	- 11 UNC	2B	TC824642	110.0	22.0	12.0	9.0
3/4	- 10 UNC	2B	TC824702	125.0	25.0	14.0	11.0
7/8	- 9 UNC	2B	TC824742	140.0	27.0	18.0	14.5
1"	- 8 UNC	2B	TC824782	160.0	30.0	20.0	16.0

► DIN371 (#4~3/8) and DIN376 (7/16~1")

DIN371/374

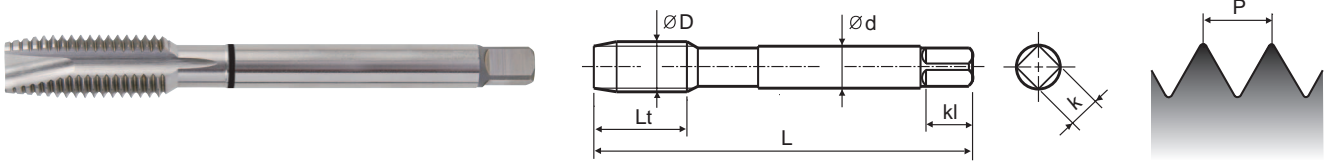
Unit : mm

SIZE	TPI	Limit	EDP No.	Overall Length	Thread Length	Shank Diameter	Square Size
D				L	Lt	d	k
#4	- 48 UNF	2B	TC824182	56.0	6.0	3.5	2.7
#5	- 44 UNF	2B	TC824222	56.0	7.0	3.5	2.7
#6	- 40 UNF	2B	TC824262	56.0	7.0	4.0	3.0
#8	- 36 UNF	2B	TC824302	63.0	8.0	4.5	3.4
#10	- 32 UNF	2B	TC824342	70.0	10.0	6.0	4.9
#12	- 28 UNF	2B	TC824382	80.0	10.0	6.0	4.9
1/4	- 28 UNF	2B	TC824422	80.0	10.0	7.0	5.5
5/16	- 24 UNF	2B	TC824462	90.0	10.0	8.0	6.2
3/8	- 24 UNF	2B	TC824502	100.0	10.0	9.0	7.0
7/16	- 20 UNF	2B	TC824542	100.0	13.0	8.0	6.2
1/2	- 20 UNF	2B	TC824582	100.0	13.0	9.0	7.0
9/16	- 18 UNF	2B	TC824622	100.0	15.0	11.0	9.0
5/8	- 18 UNF	2B	TC824662	100.0	15.0	12.0	9.0
3/4	- 16 UNF	2B	TC824722	110.0	17.0	14.0	11.0
7/8	- 14 UNF	2B	TC824762	125.0	17.0	18.0	14.5
1"	- 12 UNF	2B	TC824802	140.0	20.0	20.0	16.0

► DIN371 (#4~3/8) and DIN374 (7/16~1")

ISO Metric coarse threads DIN13

GUN POINT TAPS for Multi Purpose



GUN POINT TAPS ♦ **TC814**



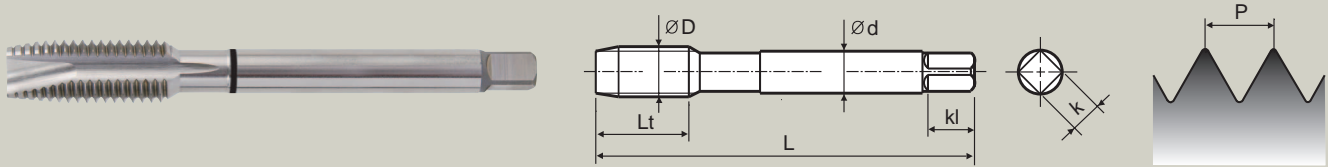
Unit : mm

SIZE		Pitch	Limit	EDP No.	Overall Length	Thread Length	Shank Diameter	Square Size
D	P	L			Lt	d	k	
M2	x 0.4	6H	TC814136	45.0	8.0	2.8	2.1	
M2.2	x 0.45	6H	TC814156	45.0	8.0	2.8	2.1	
M2.3	x 0.4	6H	TC814196	45.0	8.0	2.8	2.1	
M2.5	x 0.45	6H	TC814176	50.0	9.0	2.8	2.1	
M2.6	x 0.45	6H	TC814496	50.0	9.0	2.8	2.1	
M3	x 0.5	6H	TC814206	56.0	11.0	3.5	2.7	
M3.5	x 0.6	6H	TC814226	56.0	12.0	4.0	3.0	
M4	x 0.7	6H	TC814246	63.0	13.0	4.5	3.4	
M4.5	x 0.75	6H	TC814266	70.0	14.0	6.0	4.9	
M5	x 0.8	6H	TC814286	70.0	15.0	6.0	4.9	
M6	x 1.0	6H	TC814316	80.0	17.0	6.0	4.9	
M7	x 1.0	6H	TC814346	80.0	17.0	7.0	5.5	
M8	x 1.25	6H	TC814366	90.0	20.0	8.0	6.2	
M9	x 1.25	6H	TC814396	90.0	20.0	9.0	7.0	
M10	x 1.5	6H	TC814426	100.0	22.0	10.0	8.0	
M11	x 1.5	6H	TC814466	100.0	22.0	8.0	6.2	
M12	x 1.75	6H	TC814506	110.0	24.0	9.0	7.0	
M14	x 2.0	6H	TC814546	110.0	26.0	11.0	9.0	
M16	x 2.0	6H	TC814606	110.0	27.0	12.0	9.0	
M18	x 2.5	6H	TC814656	125.0	30.0	14.0	11.0	
M20	x 2.5	6H	TC814706	140.0	32.0	16.0	12.0	
M22	x 2.5	6H	TC814746	140.0	32.0	18.0	14.5	
M24	x 3.0	6H	TC814786	160.0	34.0	18.0	14.5	
M27	x 3.0	6H	TC814866	160.0	36.0	20.0	16.0	
M30	x 3.5	6H	TC814946	180.0	40.0	22.0	18.0	

► DIN371 (M2~M10) and DIN376 (M11~M30)

ISO Metric fine threads DIN13

GUN POINT TAPS for Multi Purpose



GUN POINT TAPS ♦ TC814

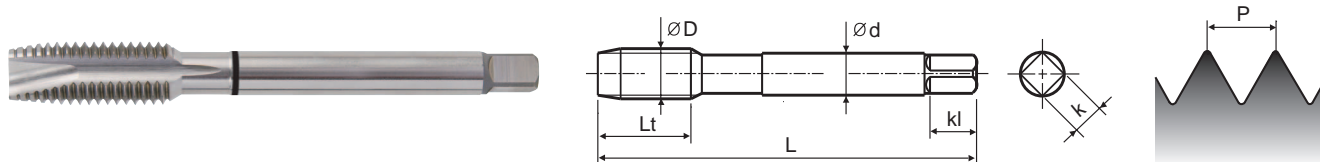


Unit : mm

SIZE		Pitch		Limit	EDP No.	Overall Length	Thread Length	Shank Diameter	Square Size
D	P	L	Lt			d	k		
M4	x 0.5	6H	TC814256	63.0	10.0	2.8	2.1		
M5	x 0.5	6H	TC814296	70.0	11.0	3.5	2.7		
M6	x 0.75	6H	TC814326	80.0	13.0	4.5	3.4		
M6	x 0.5	6H	TC814336	80.0	13.0	4.5	3.4		
M7	x 0.75	6H	TC814356	80.0	14.0	5.5	4.3		
M8	x 1.0	6H	TC814376	90.0	17.0	6.0	4.9		
M8	x 0.75	6H	TC814386	80.0	14.0	6.0	4.9		
M10	x 1.25	6H	TC814436	100.0	22.0	7.0	5.5		
M10	x 1.0	6H	TC814446	90.0	18.0	7.0	5.5		
M10	x 0.75	6H	TC814456	90.0	18.0	7.0	5.5		
M12	x 1.5	6H	TC814516	100.0	22.0	9.0	7.0		
M12	x 1.25	6H	TC814526	100.0	22.0	9.0	7.0		
M12	x 1.0	6H	TC814536	100.0	18.0	9.0	7.0		
M14	x 1.5	6H	TC814556	100.0	22.0	11.0	9.0		
M14	x 1.25	6H	TC814566	100.0	22.0	11.0	9.0		
M14	x 1.0	6H	TC814576	100.0	18.0	11.0	9.0		
M16	x 1.5	6H	TC814616	100.0	22.0	12.0	9.0		
M16	x 1.0	6H	TC814626	100.0	18.0	12.0	9.0		
M18	x 1.5	6H	TC814676	110.0	25.0	14.0	11.0		
M18	x 1.0	6H	TC814686	110.0	20.0	14.0	11.0		
M20	x 1.5	6H	TC814726	125.0	25.0	16.0	12.0		
M20	x 1.0	6H	TC814736	125.0	20.0	16.0	12.0		
M22	x 1.5	6H	TC814766	125.0	25.0	18.0	14.5		
M22	x 1.0	6H	TC814776	125.0	20.0	18.0	14.5		
M24	x 2.0	6H	TC814796	140.0	27.0	18.0	14.5		
M24	x 1.5	6H	TC814806	140.0	27.0	18.0	14.5		
M26	x 1.5	6H	TC814856	140.0	28.0	18.0	14.5		
M27	x 2.0	6H	TC814876	140.0	28.0	20.0	16.0		
M27	x 1.5	6H	TC814886	140.0	28.0	20.0	16.0		
M28	x 1.5	6H	TC814916	140.0	28.0	20.0	16.0		
M30	x 2.0	6H	TC814966	150.0	30.0	22.0	18.0		
M30	x 1.5	6H	TC814976	150.0	30.0	22.0	18.0		

Unified coarse threads

GUN POINT TAPS for Multi Purpose



GUN POINT TAPS ♦ **TC834**



DIN371/376

Unit : mm

SIZE	TPI	Limit	EDP No.	Overall Length	Thread Length	Shank Diameter	Square Size
D				L	Lt	d	k
#4	- 40 UNC	2B	TC834162	56.0	11.0	3.5	2.7
#5	- 40 UNC	2B	TC834202	56.0	11.0	3.5	2.7
#6	- 32 UNC	2B	TC834242	56.0	12.0	4.0	3.0
#8	- 32 UNC	2B	TC834282	63.0	13.0	4.5	3.4
#10	- 24 UNC	2B	TC834322	70.0	15.0	6.0	4.9
#12	- 24 UNC	2B	TC834362	80.0	16.0	6.0	4.9
1/4	- 20 UNC	2B	TC834402	80.0	17.0	7.0	5.5
5/16	- 18 UNC	2B	TC834442	90.0	20.0	8.0	6.2
3/8	- 16 UNC	2B	TC834482	100.0	22.0	9.0	7.0
7/16	- 14 UNC	2B	TC834522	100.0	22.0	8.0	6.2
1/2	- 13 UNC	2B	TC834562	110.0	25.0	9.0	7.0
9/16	- 12 UNC	2B	TC834602	110.0	26.0	11.0	9.0
5/8	- 11 UNC	2B	TC834642	110.0	27.0	12.0	9.0
3/4	- 10 UNC	2B	TC834702	125.0	30.0	14.0	11.0
7/8	- 9 UNC	2B	TC834742	140.0	32.0	18.0	14.5
1"	- 8 UNC	2B	TC834782	160.0	36.0	20.0	16.0

▶ DIN371 (#4~3/8) and DIN376 (7/16~1")

DIN371/374

Unit : mm

SIZE	TPI	Limit	EDP No.	Overall Length	Thread Length	Shank Diameter	Square Size
D				L	Lt	d	k
#4	- 48 UNF	2B	TC834182	56.0	11.0	3.5	2.7
#5	- 44 UNF	2B	TC834222	56.0	11.0	3.5	2.7
#6	- 40 UNF	2B	TC834262	56.0	12.0	4.0	3.0
#8	- 36 UNF	2B	TC834302	63.0	13.0	4.5	3.4
#10	- 32 UNF	2B	TC834342	70.0	15.0	6.0	4.9
#12	- 28 UNF	2B	TC834382	80.0	16.0	6.0	4.9
1/4	- 28 UNF	2B	TC834422	80.0	17.0	7.0	5.5
5/16	- 24 UNF	2B	TC834462	90.0	17.0	8.0	6.2
3/8	- 24 UNF	2B	TC834502	100.0	18.0	9.0	7.0
7/16	- 20 UNF	2B	TC834542	100.0	22.0	8.0	6.2
1/2	- 20 UNF	2B	TC834582	100.0	22.0	9.0	7.0
9/16	- 18 UNF	2B	TC834622	100.0	22.0	11.0	9.0
5/8	- 18 UNF	2B	TC834662	100.0	22.0	12.0	9.0
3/4	- 16 UNF	2B	TC834722	110.0	25.0	14.0	11.0
7/8	- 14 UNF	2B	TC834762	125.0	26.0	18.0	14.5
1"	- 12 UNF	2B	TC834802	140.0	28.0	20.0	16.0

▶ DIN371 (#4~3/8) and DIN374 (7/16~1")

DRILL SIZES BEFORE TAPPING

Unit : mm

Metric-ISO threads coarse pitch				Metric-ISO threads fine pitch				Metric-ISO threads fine pitch			
M	Pitch mm.	Maximun core dia. mm.	Drill size mm.	MF	Pitch mm.	Maximun core dia. mm.	Drill size mm.	MF	Pitch mm.	Maximun core dia. mm.	Drill size mm.
1	0,25	0,785	0,75	2,5	0,35	2,221	2,15	25	2,00	23,210	23,00
1,1	0,25	0,885	0,85	3	0,35	2,271	2,65	26	1,50	24,676	24,50
1,2	0,25	0,985	0,95	3,5	0,35	3,221	3,15	27	1,00	26,153	26,00
1,4	0,30	1,160	1,10	4	0,50	3,599	3,50	27	1,50	25,676	25,50
1,6	0,35	1,321	1,25	4,5	0,50	4,099	4,00	27	2,00	25,210	25,00
1,7	0,35	1,346	1,30	5	0,50	4,599	4,50	28	1,00	27,153	27,00
1,8	0,35	1,521	1,45	5,5	0,50	5,099	5,00	28	1,50	26,676	26,50
2	0,40	1,679	1,60	6	0,75	5,378	5,20	28	2,00	26,210	26,00
2,2	0,45	1,838	1,75	7	0,75	6,378	6,20	30	1,00	29,153	29,00
2,3	0,40	1,920	1,90	8	0,75	7,378	7,20	30	1,50	28,676	28,50
2,5	0,45	2,138	2,05	8	1,00	7,153	7,00	30	2,00	28,210	28,00
2,6	0,45	2,176	2,10	9	0,75	8,378	8,20	30	3,00	27,252	27,00
3	0,50	2,599	2,50	9	1,00	8,153	8,00	32	1,50	30,675	30,50
3,5	0,60	3,010	2,90	10	0,75	9,378	9,20	32	2,00	30,210	30,00
4	0,70	3,422	3,30	10	1,00	9,153	9,00	33	1,50	31,676	31,50
4,5	0,75	3,878	3,70	10	1,25	8,912	8,80	33	2,00	31,210	31,00
5	0,80	4,334	4,20	11	0,75	10,378	10,20	33	3,00	30,252	30,00
6	1,00	5,153	5,00	11	1,00	10,153	10,00	35	1,50	33,676	33,50
7	1,00	6,153	6,00	12	1,00	11,153	11,00	36	1,50	34,676	34,50
8	1,25	6,912	6,80	12	1,25	10,912	10,80	36	2,00	34,210	34,00
9	1,25	7,912	7,80	12	1,50	10,676	10,50	36	3,00	33,252	33,00
10	1,50	8,676	8,50	14	1,00	13,153	13,00	38	1,50	36,676	36,50
11	1,50	9,676	9,50	14	1,25	12,912	12,80	39	1,50	37,676	37,50
12	1,75	10,441	10,20	14	1,50	12,676	12,50	39	2,00	37,210	37,00
14	2,00	12,210	12,00	15	1,00	14,153	14,00	39	3,00	36,252	36,00
16	2,00	14,210	14,00	15	1,50	13,676	13,50	40	1,50	38,676	38,50
18	2,50	15,744	15,50	16	1,00	15,153	15,00	40	2,00	38,210	38,00
20	2,50	17,744	17,50	16	1,50	14,676	14,50	40	3,00	37,252	37,00
22	2,50	19,744	19,50	17	1,00	16,153	16,00	42	1,50	40,676	40,50
24	3,00	21,252	21,00	17	1,50	15,676	15,50	42	2,00	40,210	40,00
27	3,00	24,252	24,00	18	1,00	17,153	17,00	42	3,00	39,252	39,00
30	3,50	26,771	26,50	18	1,50	16,676	16,50	45	1,50	43,676	43,50
33	3,50	29,771	29,50	18	2,00	16,210	16,00	45	2,00	43,210	43,00
36	4,00	32,270	32,00	20	1,00	19,153	19,00	45	3,00	42,252	42,00
39	4,00	35,270	35,00	20	1,50	18,676	18,50	48	1,50	46,676	46,50
42	4,50	37,799	37,50	20	2,00	18,210	18,00	48	2,00	46,210	46,00
45	4,50	40,799	40,50	22	1,00	21,153	21,00	48	3,00	45,252	45,00
48	5,00	43,297	43,00	22	1,50	20,676	20,50	50	1,50	48,676	48,50
52	5,00	47,297	47,00	22	2,00	20,210	20,00	50	2,00	48,210	48,00
56	5,50	50,796	50,50	24	1,00	23,153	23,00	50	3,00	47,252	47,00
60	5,50	54,796	54,50	24	1,50	22,676	22,50	52	1,50	50,676	50,50
64	6,00	58,305	58,00	24	2,00	22,210	22,00	52	2,00	50,210	50,00
68	6,00	62,305	62,00	25	1,00	24,153	24,00	52	3,00	49,252	49,00
				25	1,50	23,676	23,50				

DRILL SIZES BEFORE TAPPING

Unit : mm

American Unified coarse threads				American Unifiedfine threads			
UNC	T.P.I	Maximun core dia. mm.	Drill size mm.	UNF	T.P.I	Maximun core dia. mm.	Drill size mm.
1	64	1,585	1,50	0	80	1,306	1,30
2	56	1,872	1,80	1	72	1,613	1,60
3	48	2,146	2,10	2	64	1,913	1,90
4	40	2,385	2,30	3	56	2,197	2,10
5	40	2,697	2,60	4	48	2,459	2,40
6	32	2,896	2,85	5	44	2,741	2,70
8	32	3,528	3,50	6	40	3,012	3,00
10	24	3,950	3,90	8	36	3,597	3,50
12	24	4,590	4,50	10	32	4,168	4,10
1/4"	20	5,250	5,20	12	28	4,717	4,70
5/16"	18	6,680	6,60	1/4"	28	5,563	5,50
3/8"	16	8,082	8,00	5/16"	24	6,995	6,90
7/16"	14	9,441	9,40	3/8"	24	8,565	8,50
1/2"	13	10,881	10,75	7/16"	20	9,947	9,90
9/16"	12	12,301	12,25	1/2"	20	11,524	11,50
5/8"	11	13,693	13,50	9/16"	18	12,969	12,90
3/4"	10	16,624	16,50	5/8"	18	14,554	14,50
7/8"	9	19,520	19,50	3/4"	16	17,546	17,50
1"	8	22,344	22,25	7/8"	14	20,493	20,50
1 1/8"	7	25,082	25,00	1"	12	23,363	23,25
1 1/4"	7	28,258	28,25	1 1/8"	12	26,538	26,50
1 3/8"	6	30,851	30,75	1 1/4"	12	29,713	29,50
1 1/2"	6	34,026	34,00	1 3/8"	12	32,888	32,70
1 3/4"	5	39,560	39,50	1 1/2"	12	36,063	36,00
2"	4,5	45,367	45,25				

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