

YOUR 'GO-TO' TAP SOURCE

HIGH-PERFORMANCE
TAP CATALOGUE

Introducing the **YG-1** Canada **GT** ('Go-To') High Performance Tap Catalogue with a handy **Guide to Tapping Applications**.

Purchasing Taps can be confusing—there are so many options available to you. **YG-1** Canada introduces you to a new kind of catalogue—taking the anxiety and guesswork out of selecting the right tap with the correct cutting geometry.

By answering these 4 simple questions:

- | | |
|----------------------------------|----------------------------|
| 1 - Bottoming (spiral flute)? | 3 - Material being tapped? |
| 2 - Through hole (spiral point)? | 4 - Hardness of material? |

the new **YG-1 Guide to Tapping Applications** shows you at a glance which Tap to "Go-To" for *your* application.

YG-1 Canada also makes special Taps—call us with your special Taps needs!

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GT



SPIRAL FLUTED TAPS MODIFIED BOTTOMING STYLE

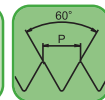
for Stainless Steels up to 28HRc and Steels up to 30HRc



B0 Series | ANSI

HSSE-V3

UNC
UNF



STEAM
OXIDE

STEAM OXIDE

EDP No.		Size	Thread Per Inch		No. of Flutes	Thread Limit
Korea	USA		UNC	UNF		
B0082	B0082	2	56		2	H2
B0162	B0162	4	40		2	H2
B0202	B0202	5	40		3	H2
B0203	B0203				3	H3
B0243	B0243	6	32		3	H3
B0283	B0283	8	32		3	H3
B0323	B0323	10	24		3	H3
B0343	B0343			32	3	H3
B0403	B0403	1/4	20		3	H3
B0405	B0405				3	H5
B0423	B0423			28	3	H3
B0443	B0443	5/16	18		3	H3
B0445	B0445				3	H5
B0463	B0463			24	3	H3
B0483	B0483	3/8	16		3	H3
B0485	B0485				3	H5
B0503	B0503			24	3	H3
B0523	B0523	7/16	14		3	H3
B0525	B0525				3	H5
B0543	B0543			20	3	H3
B0545	B0545				3	H5
B0563	B0563	1/2	13		3	H3
B0565	B0565				3	H5
B0583	B0583			20	3	H3
B0603	B0603	9/16	12		3	H3
B0623	B0623			18	3	H3
B0625	B0625				3	H5
B0643	B0643	5/8	11		4	H3
B0645	B0645				4	H5
B0663	B0663			18	4	H3
B0665	B0665				4	H5
B0703	B0703	3/4	10		4	H3
B0705	B0705				4	H5
B0723	B0723			16	4	H3
B0725	B0725				4	H5
B0744	B0744	7/8	9		4	H4
B0746	B0746				4	H6
B0764	B0764			14	4	H4
B0766	B0766				4	H6
B0784	B0784	1	8		4	H4
B0786	B0786				4	H6
B0804	B0804			12	4	H4
B0806	B0806				4	H6
B0824	B0824	1-1/8	7		4	H4
B0864	B0864	1-1/4	7		4	H4
B0904	B0904	1-3/8	6		4	H4
B0944	B0944	1-1/2	6		4	H4

CUTTING APPLICATIONS

Materials Main Group	Sub-Group	Condition	Hardness (HRc)	Cutting Speed (SFM)
Stainless steel	200Series	Annealed	<28	20-35
	300Series	Annealed	<28	20-35
	17-4, 15-5	Annealed	<25	10-15
	AM286	Annealed	<25	15-25
	400Series	Annealed	<28	20-35
Low carbon steel	1010	Normalized	<20	25-50
	1018			
	1035			
Medium carbon steel	1030, 1035	Normalized	<28	20-40
	1038, 1040, 1045, 1050			
High carbon steel	1065, 1070	Normalized	<30	15-25
	1080, 1090, 1095, 1561, 1572			
High strength steel	4140, 4340	Normalized	<30	15-25
Tool steel	A-2, D-2, H-13, P-20	Annealed	<30	15-25
Aluminum	Cast, wrought	-	-	30-90
Magnesium	-	-	-	40-80
Copper	-	-	-	50-60
Brass	-	-	-	30-65
Zinc	-	-	-	25-65

TiN Coated (B2 Series) and Hardslick Coated (D2 Series) Taps available on request, see YU13 Catalog or contact us for details.

SPIRAL POINTED TAPS PLUG STYLE

for Stainless Steels up to 28HRc and Steels up to 30HRc

GT



HSSE-V3

UNC
UNFSTEAM
OXIDE

I0 Series | ANSI

CUTTING APPLICATIONS

Materials Main Group	Sub-Group	Condition	Hardness (HRc)	Cutting Speed (SFM)
Stainless steel	200Series	Annealed	<28	20-35
	300Series	Annealed	<28	20-35
	17-4, 15-5	Annealed	<25	10-15
	AM286	Annealed	<25	15-25
	400Series	Annealed	<28	20-35
Low carbon steel	1010	Normalized	<20	25-50
	1018			
	1035			
Medium carbon steel	1030, 1035	Normalized	<28	20-40
	1038, 1040			
	1045, 1050			
High carbon steel	1065, 1070	Normalized	<30	15-25
	1080, 1090			
	1095, 1561			
	1572			
High strength steel	4140, 4340	Normalized	<30	15-25
Tool steel	A-2, D-2 H-13, P-20	Annealed	<30	15-25
Aluminum	Cast, wrought	-	-	30-90
Magnesium	-	-	-	40-80
Copper	-	-	-	50-60
Brass	-	-	-	30-65
Zinc	-	-	-	25-65

STEAM OXIDE

EDP No.		Size	Thread Per Inch		No. of Flutes	Thread Limit
Korea	USA		UNC	UNF		
I0082	I0082	2	56		2	H2
I0162	I0162	4	40		2	H2
I0202	I0202	5	40		3	H2
I0203	I0203				3	H3
I0243	I0243	6	32		3	H3
I0283	I0283	8	32		3	H3
I0323	I0323	10	24		3	H3
I0343	I0343			32	3	H3
I0403	I0403	1/4	20		3	H3
I0405	I0405				3	H5
I0423	I0423			28	3	H3
I0443	I0443	5/16	18		3	H3
I0445	I0445				3	H5
I0463	I0463			24	3	H3
I0483	I0483	3/8	16		3	H3
I0485	I0485				3	H5
I0503	I0503			24	3	H3
I0523	I0523	7/16	14		3	H3
I0525	I0525				3	H5
I0543	I0543			20	3	H3
I0545	I0545				3	H5
I0563	I0563	1/2	13		3	H3
I0565	I0565				3	H5
I0583	I0583			20	3	H3
I0603	I0603	9/16	12		3	H3
I0623	I0623			18	3	H3
I0643	I0643	5/8	11		3	H3
I0645	I0645				3	H5
I0665	I0665			18	3	H5
I0703	I0703	3/4	10		3	H3
I0705	I0705				3	H5
I0725	I0725			16	3	H5
I0744	I0744	7/8	9		3	H4
I0746	I0746				3	H6
I0766	I0766			14	3	H6
I0784	I0784	1	8		3	H4
I0786	I0786				3	H6
I0806	I0806			12	3	H6
T1266824	-	1-1/8	7		4	H4
T1266844	-			12	4	H4
T1266864	-	1-1/4	7		4	H4
T1266884	-			12	4	H4
T1266904	-	1-3/8	6		4	H4
T1266924	-			12	4	H4
T1266944	-	1-1/2	6		4	H4
T1266964	-			12	4	H4

TiN Coated (I2 Series) and Hardslick Coated (J2 Series) Taps available on request, see YU13 Catalog or contact us for details.

GT-S

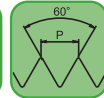
SPIRAL FLUTED TAPS MODIFIED BOTTOMING STYLE

for Steels up to 38HRc



D3 Series | ANSI

HSSE-V3

UNC
UNFSTEAM
OXIDE**STEAM OXIDE**

EDP No.		Size	Thread Per Inch		No. of Flutes	Thread Limit
Korea	USA		UNC	UNF		
T1159082	D3082	2	56		2	H2
T1159162	D3162	4	40		2	H2
T1159202	D3202	5	40		3	H2
T1159243	D3243	6	32		3	H3
T1159283	D3283	8	32		3	H3
T1159323	D3323	10	24		3	H3
T1159343	D3343			32	3	H3
T1159403	D3403	1/4	20		3	H3
T1159405	D3405				3	H5
T1159423	D3423			28	3	H3
T1159425	D3425				3	H5
T1159443	D3443	5/16	18		3	H3
T1159445	D3445				3	H5
T1159463	D3463			24	3	H3
T1159465	D3465				3	H5
T1159483	D3483	3/8	16		3	H3
T1159485	D3485				3	H5
T1159503	D3503			24	3	H3
T1159505	D3505				3	H5
T1159523	D3523	7/16	14		3	H3
T1159525	D3525				3	H5
T1159543	D3543			20	3	H3
T1159545	D3545				3	H5
T1159563	D3563	1/2	13		3	H3
T1159565	D3565				3	H5
T1159583	D3583			20	3	H3
T1159585	D3585				3	H5
T1159605	D3605	9/16	12		3	H5
T1159625	D3625			18	3	H5
T1159643	D3643	5/8	11		4	H3
T1159645	D3645				4	H5
T1159663	D3663			18	4	H3
T1159665	D3665				4	H5
T1159703	D3703	3/4	10		4	H3
T1159705	D3705				4	H5
T1159723	D3723			16	4	H3
T1159725	D3725				4	H5
T1159784	D3784	1	8		4	H4
T1159786	D3786				4	H6
T1159804	D3804			12	4	H4
T1159806	D3806				4	H6
T1159824	D3824	1-1/8	7		4	H4
T1159864	D3864	1-1/4	7		4	H4
T1159904	D3904	1-3/8	6		4	H4
T1159944	D3944	1-1/2	6		4	H4

Hardslick Coated (E0 Series) Taps available on request, see YU13 Catalog or contact us for details.

CUTTING APPLICATIONS

Materials Main Group	Sub-Group	Condition	Hardness (HRc)	Cutting Speed (SFM)
Medium carbon steel	1030, 1035 1038, 1040 1045, 1050	Normalized	<28	20-40
High carbon steel	1065, 1070 1080, 1090 1095, 1561 1572	Normalized	<32	15-25
High strength steel	4140, 4340	Normalized	<38	15-25
Tool steel	A-2, D-2 H-13, P-20	Annealed	<38	15-25
Stainless steel	200Series 300Series 17-4, 15-5 AM286	Annealed Annealed Annealed Annealed	<28 <28 <25 <25	20-35 20-35 15-25 15-25

SPIRAL POINTED TAPS PLUG STYLE

for Steels up to 38Hrc

GT-S



HSSE-V3

UNC
UNFSTEAM
OXIDE

J3 Series | ANSI

CUTTING APPLICATIONS

Materials Main Group	Sub-Group	Condition	Hardness (Hrc)	Cutting Speed (SFM)
Medium carbon steel	1030, 1035 1038, 1040 1045, 1050	Normalized	<28	20-40
High carbon steel	1065, 1070 1080, 1090 1095, 1561 1572	Normalized	<32	15-25
High strength steel	4140, 4340	Normalized	<38	15-25
Tool steel	A-2, D-2 H-13, P-20	Annealed	<38	15-25
Stainless steel	200Series 300Series 17-4, 15-5 AM286	Annealed	<28	20-35
		Annealed	<28	20-35
		Annealed	<25	15-25
		Annealed	<25	15-25

STEAM OXIDE

EDP No.		Size	Thread Per Inch		No. of Flutes	Thread Limit
Korea	USA		UNC	UNF		
T1259082	J3082	2	56		2	H2
T1259162	J3162	4	40		2	H2
T1259202	J3202	5	40		3	H2
T1259243	J3243	6	32		3	H3
T1259283	J3283	8	32		3	H3
T1259323	J3323	10	24		3	H3
T1259343	J3343			32	3	H3
T1259403	J3403	1/4	20		3	H3
T1259405	J3405				3	H5
T1259423	J3423			28	3	H3
T1259425	J3425				3	H5
T1259443	J3443	5/16	18		3	H3
T1259445	J3445				3	H5
T1259463	J3463			24	3	H3
T1259465	J3465				3	H5
T1259483	J3483	3/8	16		3	H3
T1259485	J3485				3	H5
T1259503	J3503			24	3	H3
T1259505	J3505				3	H5
T1259523	J3523	7/16	14		3	H3
T1259525	J3525				3	H5
T1259543	J3543			20	3	H3
T1259545	J3545				3	H5
T1259563	J3563	1/2	13		3	H3
T1259565	J3565				3	H5
T1259583	J3583			20	3	H3
T1259585	J3585				3	H5
T1259605	J3605	9/16	12		3	H5
T1259625	J3625			18	3	H5
T1259643	J3643	5/8	11		3	H3
T1259645	J3645				3	H5
T1259663	J3663			18	3	H3
T1259665	J3665				3	H5
T1259703	J3703	3/4	10		3	H3
T1259705	J3705				3	H5
T1259723	J3723			16	3	H3
T1259725	J3725				3	H5
T1259784	J3784	1	8		3	H4
T1259786	J3786				3	H6
T1259804	J3804			12	3	H4
T1259806	J3806				3	H6
T1259824	J3824	1-1/8	7		4	H4
T1259864	J3864	1-1/4	7		4	H4
T1259904	J3904	1-3/8	6		4	H4
T1259944	J3944	1-1/2	6		4	H4

Hardslick Coated (D2 Series) Taps available on request, see YU13 Catalog or contact us for details.

Super-B
YG

SPIRAL FLUTED TAPS MODIFIED BOTTOMING STYLE

for Steels and Stainless Steels up to 35HRC



BB & BI Series | ANSI



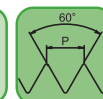
**BF & BK | DIN Length
ANSI Shank**

**ANSI
LENGTH** **DIN LENGTH
ANSI SHANK**

EDP No.				Size	Thread Per Inch		No. of Flutes	Thread Limit
Steam Oxide	Hardslick Coated	Steam Oxide	Hardslick Coated		UNC	UNF		
BB082	BI082	BF082	BK082	2	56		2	H2
BB162	BI162	BF162	BK162	4	40		2	H2
BB202	BI202	BF202	BK202	5	40		3	H2
BB243	BI243	BF243	BK243	6	32		3	H3
BB283	BI283	BF283	BK283	8	32		3	H3
BB323	BI323	BF323	BK323	10	24		3	H3
BB343	BI343	BF343	BK343			32	3	H3
BB403	BI403	BF403	BK403	1/4	20		3	H3
BB405	BI405	BF405	BK405				3	H5
BB423	BI423	BF423	BK423			28	3	H3
BB424	BI424	BF424	BK424				3	H4
BB445	BI445	BF445	BK445	5/16	18		3	H5
BB464	BI464	BF464	BK464			24	3	H4
BB485	BI485	BF485	BK485	3/8	16		3	H5
BB504	BI504	BF504	BK504			24	3	H4
BB525	BI525	BF525	BK525	7/16	14		3	H5
BB545	BI545	BF545	BK545			20	3	H5
BB565	BI565	BF565	BK565	1/2	13		3	H5
BB585	BI585	BF585	BK585			20	3	H5
BB605	BI605	BF605	BK605	9/16	12		3	H5
BB625	BI625	BF625	BK625			18	3	H5
BB645	BI645	BF645	BK645	5/8	11		4	H5
BB665	BI665	BF665	BK665			18	4	H5
BB705	BI705	BF705	BK705	3/4	10		4	H5
BB725	BI725	BF725	BK725			16	4	H5
BB746	BI746	BF746	BK746	7/8	9		4	H6
BB766	BI766	BF766	BK766			14	4	H6
BB786	BI786	BF786	BK786	1	8		4	H6
BB806	BI806	BF806	BK806			12	4	H6
BB836	BI836	BF836	BK836	1-1/8	8		4	H6
BB876	BI876	BF876	BK876	1-1/4	8		4	H6
BB916	BI916	BF916	BK916	1-3/8	8		4	H6
BB956	BI956	BF956	BK956	1-1/2	8		4	H6

Super
HSS
Premium
Powdered
Metal

UNC
UNF



STEAM
OXIDE

HARDSLICK
COATED

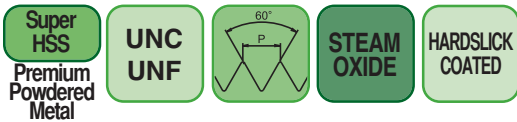
CUTTING APPLICATIONS

Materials Main Group	Sub-Group	Condition	Hardness (HRc)	Cutting Speed (SFM)
Stainless steel	200Series 300Series	Annealed Annealed	<35	20-35
Low carbon steel	1010 1018 1035	Normalized	<20	30-80
Medium carbon steel	1030, 1035 1038, 1040 1045, 1050	Normalized	<20	20-50
High carbon steel	1065, 1070 1080, 1090 1095, 1561 1572	Normalized	<35	15-35
High strength steel	4140, 4340	Normalized	<35	15-25
Tool steel	A-2, D-2 H-13, P-20	Annealed	<35	15-25
Aluminum	Cast, wrought	-	-	30-90
Magnesium	-	-	-	40-80
Copper	-	-	-	50-60
Brass	-	-	-	30-65
Zinc	-	-	-	30-80

SPIRAL POINTED TAPS PLUG STYLE

for Steels and Stainless Steels up to 35HRc

Super-B
Y/G



CUTTING APPLICATIONS

Materials Main Group	Sub-Group	Condition	Hardness (HRc)	Cutting Speed (SFM)
Stainless steel	200Series 300Series	Annealed Annealed	<35	20-35
Low carbon steel	1010 1018 1035	Normalized	<20	30-80
Medium carbon steel	1030, 1035 1038, 1040 1045, 1050	Normalized	<20	20-50
High carbon steel	1065, 1070 1080, 1090 1095, 1561 1572	Normalized	<35	15-35
High strength steel	4140, 4340	Normalized	<35	15-25
Tool steel	A-2, D-2 H-13, P-20	Annealed	<35	15-25
Aluminum	Cast, wrought	-	-	30-90
Magnesium	-	-	-	40-80
Copper	-	-	-	50-60
Brass	-	-	-	30-65
Zinc	-	-	-	30-80



M(& O1 Series | ANSI



N4 & O5 | DIN Length
ANSI Shank

ANSI LENGTH DIN LENGTH ANSI SHANK

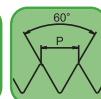
EDP No.				Size	Thread Per Inch		No. of Flutes	Thread Limit
Steam Oxide	Hardsllick Coated	Steam Oxide	Hardsllick Coated		UNC	UNF		
M9082	O1082	N4082	O5082	2	56		2	H2
M9162	O1162	N4162	O5162	4	40		2	H2
M9202	O1202	N4202	O5202	5	40		3	H2
M9243	O1243	N4243	O5243	6	32		3	H3
M9283	O1283	N4283	O5283	8	32		3	H3
M9323	O1323	N4323	O5323	10	24		3	H3
M9343	O1343	N4343	O5343			32	3	H3
M9403	O1403	N4403	O5403	1/4	20		3	H3
M9405	O1405	N4405	O5405				3	H5
M9423	O1423	N4423	O5423			28	3	H3
M9445	O1445	N4445	O5445	5/16	18		3	H5
M9464	O1464	N4464	O5464			24	3	H4
M9485	O1485	N4485	O5485	3/8	16		3	H5
M9504	O1504	N4504	O5504			24	3	H4
M9525	O1525	N4525	O5525	7/16	14		3	H5
M9545	O1545	N4545	O5545			20	3	H5
M9565	O1565	N4565	O5565	1/2	13		3	H5
M9585	O1585	N4585	O5585			20	3	H5
M9605	O1605	N4605	O5605	9/16	12		3	H5
M9625	O1625	N4625	O5625			18	3	H5
M9645	O1645	N4645	O5645	5/8	11		3	H5
M9665	O1665	N4665	O5665			18	3	H5
M9705	O1705	N4705	O5705	3/4	10		3	H5
M9725	O1725	N4725	O5725			16	3	H5
M9746	O1746	N4746	O5746	7/8	9		3	H6
M9766	O1766	N4766	O5766			14	3	H6
M9786	O1786	N4786	O5786	1	8		3	H6
M9806	O1806	N4806	O5806			12	3	H6
M9836	O1836	N4836	O5836	1-1/8	8		4	H6
M9876	O1876	N4876	O5876	1-1/4	8		4	H6
M9916	O1916	N4916	O5916	1-3/8	8		4	H6
M9956	O1956	N4956	O5956	1-1/2	8		4	H6

GT-HS


SPIRAL FLUTED TAPS MODIFIED BOTTOMING STYLE

for Steels and Stainless Steels up to 45HRc


H7 & H8 Series | ANSI
P-HSS
 Powdered
 Metal

**UNC
UNF**

**HARDSLICK
COATED**
**TICN
COATED**

EDP No.		Size	Thread Per Inch		No. of Flutes	Thread Limit
TICN	Hardslick Coated		UNC	UNF		
H7082	H8082	2	56		3	H2
H7162	H8162	4	40		3	H2
H7202	H8202	5	40		3	H2
H7243	H8243	6	32		3	H3
H7283	H8283	8	32		3	H3
H7323	H8323	10	24		3	H3
H7343	H8343			32	3	H3
H7405	H8405	1/4	20		3	H5
H7424	H8424			28	3	H4
H7445	H8445	5/16	18		3	H5
H7464	H8464			24	3	H4
H7485	H8485	3/8	16		3	H5
H7504	H8504			24	3	H4
H7525	H8525	7/16	14		3	H5
H7545	H8545			20	3	H5
H7565	H8565	1/2	13		3	H5
H7585	H8585			20	3	H5
H7645	H8645	5/8	11		4	H5
H7665	H8665			18	4	H5
H7705	H8705	3/4	10		4	H5
H7725	H8725			16	4	H5

Bright Finish (H6 Series) Taps available on request, see YU13 Catalog or contact us for details.

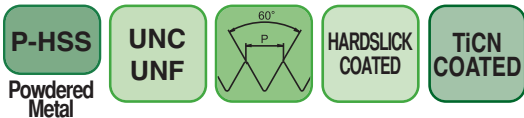
CUTTING APPLICATIONS

Materials Main Group	Sub-Group	Condition	Hardness (HRc)	Cutting Speed (SFM)
Stainless steel	300Series	Hardened	<45	12-22
	17-4, 15-5	Hardened	<45	10-15
	AM286	Hardened	<45	10-20
	400Series	Hardened	<45	12-22
High strength steel	4140, 4340	Hardened	<45	15-20
Tool steel	A-2, D-2 H-13, P-20	Hardened	<45	10-18
Nickel-based alloys	Inconel 7-18, Waspalloy, Hastelloy, Monel	Hardened Normalized Normalized Normalized	<45	8-15
Titanium	Comm Pure 6AL-4V	Annealed Hardened	15-20 35-42	8-15
Bronze	Aluma Phosphor		<44	25-60

SPIRAL POINTED TAPS PLUG STYLE

for Steels and Stainless Steels up to 45HRc

GT-HS



M6 & M7 Series | ANSI

CUTTING APPLICATIONS

Materials Main Group	Sub-Group	Condition	Hardness (HRc)	Cutting Speed (SFM)
Stainless steel	300Series	Hardened	<45	12-22
	17-4, 15-5	Hardened	<45	10-15
	AM286	Hardened	<45	10-20
	400Series	Hardened	<45	12-22
High strength steel	4140, 4340	Hardened	<45	15-20
Tool steel	A-2, D-2 H-13, P-20	Hardened	<45	10-18
Nickel-based alloys	Inconel 7-18, Waspalloy, Hastelloy, Monel	Hardened Normalized Normalized	<45	8-15
Titanium	Comm Pure 6AL-4V	Annealed Hardened	15-20 35-42	8-15
Bronze	Aluma Phosphor		<44	25-60

EDP No.		Size	Thread Per Inch		No. of Flutes	Thread Limit
TiCN	Hardsllick Coated		UNC	UNF		
M6082	M7082	2	56		2	H2
M6162	M7162	4	40		2	H2
M6202	M7202	5	40		3	H2
M6243	M7243	6	32		3	H3
M6283	M7283	8	32		3	H3
M6323	M7323	10	24		3	H3
M6343	M7343			32	3	H3
M6405	M7405	1/4	20		3	H5
M6424	M7424			28	3	H4
M6445	M7445	5/16	18		3	H5
M6464	M7464			24	3	H4
M6485	M7485	3/8	16		3	H5
M6504	M7504			24	3	H4
M6525	M7525	7/16	14		3	H5
M6545	M7545			20	3	H5
M6565	M7565	1/2	13		3	H5
M6585	M7585			20	3	H5
M6605	M7605	9/16	12		3	H5
M6625	M7625			18	3	H5
M6645	M7645	5/8	11		3	H5
M6665	M7665			18	3	H5
M6705	M7705	3/4	10		3	H5
M6725	M7725			16	3	H5

Bright Finish (M5 Series) Taps available on request, see YU13 Catalog or contact us for details.

GT-Ti


SPIRAL FLUTED TAPS MODIFIED BOTTOMING STYLE

for Titanium Alloys and Nickel-Based Alloys up to 44HRc


B3 & D6 Series | ANSI
P-HSS
 Powdered
 Metal

**UNC
UNF**

**STEAM
OXIDE**
**HARDSLICK
COATED**

EDP No.		Size	Thread Per Inch		No. of Flutes	Thread Limit
Steam Oxide	Hardslick Coated		UNC	UNF		
B3082	D6082	2	56		3	H2
B3162	D6162	4	40		3	H2
B3202	D6202	5	40		3	H2
B3243	D6243	6	32		3	H3
B3283	D6283	8	32		3	H3
B3323	D6323	10	24		3	H3
B3343	D6343			32	3	H3
B3403	D6403	1/4	20		3	H3
B3405	D6405				3	H5
B3423	D6423			28	3	H3
B3424	D6424				3	H4
B3443	D6443	5/16	18		3	H3
B3445	D6445				3	H5
B3463	D6463			24	3	H3
B3483	D6483	3/8	16		3	H3
B3485	D6485				3	H5
B3503	D6503			24	3	H3
B3504	D6504				3	H4
B3523	D6523	7/16	14		3	H3
B3525	D6525				3	H5
B3543	D6543			20	3	H3
B3545	D6545				3	H5
B3563	D6563	1/2	13		3	H3
B3565	D6565				3	H5
B3583	D6583			20	3	H3
B3585	D6585				3	H5
B3603	D6603	9/16	12		3	H3
B3605	D6605				3	H5
B3623	D6623			18	3	H3
B3625	D6625				3	H5
B3643	D6643	5/8	11		4	H3
B3645	D6645				4	H5
B3663	D6663			18	4	H3
B3665	D6665				4	H5
B3703	D6703	3/4	10		4	H3
B3705	D6705				4	H5
B3723	D6723			16	4	H3
B3725	D6725				4	H5

TiN Coated (H9 Series) and TiCN Coated (B5 Series) Taps available on request, see YU13 Catalog or contact us for details.

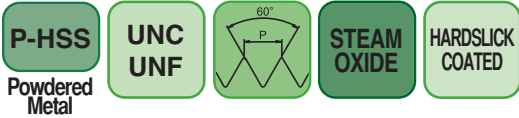
CUTTING APPLICATIONS

Materials Main Group	Sub-Group	Condition	Hardness (HRc)	Cutting Speed (SFM)
Nickel- based alloys	Inconel 718, Waspalloy, Hastelloy, Monel	Hardened	<44	3-15
		Hardened		8-15
		Hardened		8-15
		Hardened		8-15
Titanium	Comm Pure 6AL-4V		<44	8-15

SPIRAL POINTED TAPS PLUG STYLE

for Titanium Alloys and Nickel-Based Alloys up to 44HRC

GT-Ti
YG



I3 & J6 Series | ANSI

CUTTING APPLICATIONS

Materials Main Group	Sub-Group	Condition	Hardness (HRC)	Cutting Speed (SFM)
Nickel-based alloys	Inconel 718, Waspalloy, Hastelloy, Monel	Hardened Hardened Hardened Hardened	<44	3-15 8-15 8-15 8-15
Titanium	Comm Pure 6AL-4V		<44	8-15

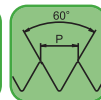
EDP No.		Size	Thread Per Inch		No. of Flutes	Thread Limit
Steam Oxide	Hardsllick Coated		UNC	UNF		
I3082	J6082	2	56		2	H2
I3162	J6162	4	40		2	H2
I3202	J6202	5	40		3	H2
I3243	J6243	6	32		3	H3
I3283	J6283	8	32		3	H3
I3323	J6323	10	24		3	H3
I3343	J6343			32	3	H3
I3403	J6403	1/4	20		3	H3
I3405	J6405				3	H5
I3423	J6423			28	3	H3
I3424	J6424				3	H4
I3443	J6443	5/16	18		3	H3
I3445	J6445				3	H5
I3463	J6463			24	3	H3
I3483	J6483	3/8	16		3	H3
I3485	J6485				3	H5
I3503	J6503			24	3	H3
I3504	J6504				3	H4
I3523	J6523	7/16	14		3	H3
I3525	J6525				3	H5
I3543	J6543			20	3	H3
I3545	J6545				3	H5
I3563	J6563	1/2	13		3	H3
I3565	J6565				3	H5
I3583	J6583			20	3	H3
I3585	J6585				3	H5
I3603	J6603	9/16	12		3	H3
I3605	J6605				3	H5
I3623	J6623			18	3	H3
I3625	J6625				3	H5
I3643	J6643	5/8	11		3	H3
I3645	J6645				3	H5
I3663	J6663			18	3	H3
I3665	J6665				3	H5
I3703	J6703	3/4	10		3	H3
I3705	J6705				3	H5
I3723	J6723			16	3	H3
I3725	J6725				3	H5

TiN Coated (M8 Series) and TiCN Coated (I5 Series) Taps available on request, see YU13 Catalog or contact us for details.

GT-AI


SPIRAL FLUTED TAPS MODIFIED BOTTOMING STYLE

for Aluminum Alloys or Die Cast Aluminum


C0 & D8 Series | ANSI
HSSE-V3
**UNC
UNF**

**BRIGHT
FINISH**
**HARDSLICK
COATED**

EDP No.		Size	Thread Per Inch		No. of Flutes	Thread Limit
Bright Finish	Hardslick Coated		UNC	UNF		
C0162	D8162	4	40		2	H2
C0242	D8242	6	32		2	H2
C0243	D8243				2	H3
C0283	D8283	8	32		2	H3
C0323	D8323	10	24		2	H3
C0343	D8343			32	2	H3
C0403	D8403	1/4	20		2	H3
C0405	D8405				2	H5
C0423	D8423			28	2	H3
C0443	D8443	5/16	18		2	H3
C0445	D8445				2	H5
C0463	D8463			24	2	H3
C0465	D8465				2	H5
C0483	D8483	3/8	16		2	H3
C0485	D8485				2	H5
C0503	D8503			24	2	H3
C0505	D8505				2	H5

CUTTING APPLICATIONS

Materials Main Group	Sub-Group	Condition	Hardness (HRc)	Cutting Speed (SFM)
Aluminum	Cast, Wrought, Low silicon <9%	-	-	30-90

TAPER PIPE TAPS : SPIRAL FLUTED | STRAIGHT FLUTED | INTERRUPTED NPT/F

Pipe
YG



Q1 Series | ANSI

for Steels and Stainless Steels

EDP No. Bright Finish	Size	Thread Per Inch	No. of Flutes
Q1020	1/16	27	4
Q1200	1/8(Lg)	27	4
Q1210	1/8(Sm)	27	4
Q1400	1/4	18	4
Q1480	3/8	18	4
Q1560	1/2	14	4
Q1700	3/4	14	4
Q1780	1	11-1/2	4
Q1860	1-1/4	11-1/2	5
Q1960	1-1/2	11-1/2	7
Q1D20	2	11-1/2	7

These Taps meet both NPT and NPTF Standards. Steam Oxide (Q0 Series) and Hardslick Coated (Q6 Series) Taps available on request, see YU13 Catalog or contact us for details.



Q9 Series | ANSI

for Cast Irons and Steels

EDP No. Bright Finish	Size	Thread Per Inch	No. of Flutes
Q9020	1/16	27	4
Q9200	1/8(Lg)	27	4
Q9210	1/8(Sm)	27	4
Q9400	1/4	18	4
Q9480	3/8	18	4
Q9560	1/2	14	4
Q9700	3/4	14	4
Q9780	1	11-1/2	4
Q9860	1-1/4	11-1/2	5
Q9960	1-1/2	11-1/2	7
Q9D20	2	11-1/2	7

These Taps meet both NPT and NPTF Standards. TiCN Coated (R0 Series) and Hardslick Coated (R1 Series) Taps available on request, see YU13 Catalog or contact us for details.



R7 Series | ANSI

for Cast Irons and Steels

EDP No. Bright Finish	Size	Thread Per Inch	No. of Flutes
R7020	1/16	27	4
R7200	1/8(Lg)	27	4
R7210	1/8(Sm)	27	4
R7400	1/4	18	4
R7480	3/8	18	4
R7560	1/2	14	4
R7700	3/4	14	4
R7780	1	11-1/2	4
R7860	1-1/4	11-1/2	5
R7960	1-1/2	11-1/2	7
R7D20	2	11-1/2	7

These Taps meet both NPT and NPTF Standards. Steam Oxide (S0 Series), TiCN Coated (R8 Series) and Hardslick Coated (R9 Series) Taps available on request, see YU13 Catalog or contact us for details.



S1 Series | ANSI

for Cast Irons and Steels

EDP No. Bright Finish	Size	Thread Per Inch	No. of Flutes
S1020	1/16	27	5
S1200	1/8(Lg)	27	5
S1210	1/8(Sm)	27	5
S1400	1/4	18	5
S1480	3/8	18	5
S1560	1/2	14	5
S1700	3/4	14	5
S1780	1	11-1/2	5

These Taps meet both NPT and NPTF Standards. TiCN Coated (S2 Series) Taps available on request, see YU13 Catalog or contact us for details.

PLEASE NOTE: Pipe Taps should be run at 50% of cutting speeds of regular taps.

Forming
YG

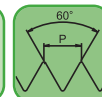
FORMING TAPS PLUG & BOTTOMING STYLES



Z1 & Z3 Series | ANSI

HSSE-V3

UNC
UNF



TiN
COATED

TiN COATED

EDP No.		Size	Thread Per Inch		Thread Limit
Plug	Bottoming		UNC	UNF	
Z1163	Z3163	4	40		H3
Z1165	Z3165				H5
Z1185	Z3185			48	H5
Z1203	Z3203	5	40		H3
Z1205	Z3205				H5
Z1225	Z3225			44	H5
Z1243	Z3243	6	32		H3
Z1245	Z3245				H5
Z1265	Z3265			40	H5
Z1283	Z3283	8	32		H3
Z1285	Z3285				H5
Z1305	Z3305			36	H5
Z1324	Z3324	10	24		H4
Z1326	Z3326				H6
Z1344	Z3344			32	H4
Z1346	Z3346				H6
Z1404	Z3404	1/4	20		H4
Z1406	Z3406				H6
Z1424	Z3424			28	H4
Z1426	Z3426				H6
Z1445	Z3445	5/16	18		H5
Z1447	Z3447				H7
Z1465	Z3465			24	H5
Z1467	Z3467				H7
Z1485	Z3485	3/8	16		H5
Z1487	Z3487				H7
Z1505	Z3505			24	H5
Z1507	Z3507				H7
Z1528	Z3528	7/16	14		H8
Z1548	Z3548			20	H8
Z1568	Z3568	1/2	13		H8
Z1588	Z3588			20	H8

Bright Finish in Plug (Z0 Series) and Bottoming (Z2 Series) style Taps available on request, see YU13 Catalog or contact us for details.

CUTTING APPLICATIONS

Materials Main Group	Sub-Group	Condition	Hardness (HRc)	Cutting Speed (SFM)
Stainless Steel	304 316	Normalized	<25	20-35
Low carbon steel	1010 1018	Normalized	10-20	25-50
Medium carbon steel	1030, 1035 1038, 1040 1045, 1050	Normalized	<20	20-40
Aluminum	Cast, wrought	Annealed	-	30-90
Magnesium	-	-	-	40-80
Copper	-	-	-	50-60
Brass	-	-	-	50-60
Zinc	-	-	-	30-80

FORMING TAPS WITH OIL GROOVE : PLUG & BOTTOMING STYLES

Forming
YG



METRIC ZA & ZB Series | ANSI



Z5 & Z7 Series | ANSI

TiN COATED

EDP No.		Size	Pitch	Thread Limit
Plug	Bottoming			
ZA205	ZB205	M3	0.5	D5
ZA246	ZB246	M4	0.7	D6
ZA287	ZB287	M5	0.8	D7
ZA318	ZB318	M6	1.0	D8
ZA369	ZB369	M8	1.25	D9
ZA420	ZB420	M10	1.5	D10
ZA50A	ZB50A	M12	1.75	D11

Bright Finish or TiCN in Plug (Z8 or ZC) and Bottoming (Z9 or ZD) style Taps available on request, see YU13 Catalog or contact us for details.

TiN COATED

EDP No.		Size	Thread Per Inch		Thread Limit
Plug	Bottoming		UNC	UNF	
Z5163	Z7163	4	40		H3
Z5165	Z7165				H5
Z5185	Z7185			48	H5
Z5203	Z7203	5	40		H3
Z5205	Z7205				H5
Z5225	Z7225			44	H5
Z5243	Z7243	6	32		H3
Z5245	Z7245				H5
Z5265	Z7265			40	H5
Z5283	Z7283	8	32		H3
Z5285	Z7285				H5
Z5305	Z7305			36	H5
Z5324	Z7324	10	24		H4
Z5326	Z7326				H6
Z5344	Z7344			32	H4
Z5346	Z7346				H6
Z5404	Z7404	1/4	20		H4
Z5406	Z7406				H6
Z5424	Z7424			28	H4
Z5426	Z7426				H6
Z5445	Z7445	5/16	18		H5
Z5447	Z7447				H7
Z5465	Z7465			24	H5
Z5467	Z7467				H7
Z5485	Z7485	3/8	16		H5
Z5487	Z7487				H7
Z5505	Z7505			24	H5
Z5507	Z7507				H7
Z5528	Z7528	7/16	14		H8
Z5548	Z7548			20	H8
Z5568	Z7568	1/2	13		H8
Z5588	Z7588			20	H8

Bright Finish in Plug (Z4 Series) and Bottoming (Z6 Series) style Taps available on request, see YU13 Catalog or contact us for details.

CUTTING APPLICATIONS

Materials Main Group	Sub-Group	Condition	Hardness (HRc)	Cutting Speed (SFM)
Stainless Steel	304 316	Normalized	<25	20-35
Low carbon steel	1010 1018	Normalized	10-20	25-50
Medium carbon steel	1030, 1035 1038, 1040 1045, 1050	Normalized	<20	20-40
Aluminum	Cast, wrought	Annealed	-	30-90
Magnesium	-	-	-	40-80
Copper	-	-	-	50-60
Brass	-	-	-	50-60
Zinc	-	-	-	30-80

Hand
YG

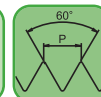
HAND TAPS : TAPER, PLUG & BOTTOMING STYLES for Multi-Purpose



A3/A5/A7 Series | ANSI

HSS-V

UNC
UNF



BRIGHT
FINISH

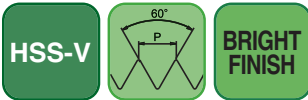
BRIGHT FINISH

EDP No.			Size	Thread Per Inch		No. of Flutes	Thread Limit
Taper	Plug	Bottoming		UNC	UNF		
A3082	A5082	A7082	2	56		3	H2
A3162	A5162	A7162	4	40		3	H2
A3202	A5202	A7202	5	40		3	H2
A3243	A5243	A7243	6	32		3	H3
A3262	A5262	A7262			40	3	H2
A3283	A5283	A7283	8	32		4	H3
A3323	A5323	A7323	10	24		4	H3
A3343	A5343	A7343			32	4	H3
A3403	A5403	A7403	1/4	20		4	H3
A3423	A5423	A7423			28	4	H3
A3443	A5443	A7443	5/16	18		4	H3
A3463	A5463	A7463			24	4	H3
A3483	A5483	A7483	3/8	16		4	H3
A3503	A5503	A7503			24	4	H3
A3523	A5523	A7523	7/16	14		4	H3
A3543	A5543	A7543			20	4	H3
A3563	A5563	A7563	1/2	13		4	H3
A3583	A5583	A7583			20	4	H3
A3603	A5603	A7603	9/16	12		4	H3
A3623	A5623	A7623			18	4	H3
A3643	A5643	A7643	5/8	11		4	H3
A3663	A5663	A7663			18	4	H3
A3703	A5703	A7703	3/4	10		4	H3
A3723	A5723	A7723			16	4	H3
A3744	A5744	A7744	7/8	9		4	H4
A3764	A5764	A7764			14	4	H4
A3784	A5784	A7784	1	8		4	H4
A3804	A5804	A7804			12	4	H4

HAND TAPS : PLUG & BOTTOMING STYLES

for Multi-Purpose

Hand
YG



METRIC

A6 & A9 Series | ANSI

BRIGHT FINISH

EDP No.		Size	Pitch	No. of Flutes	Thread Limit
Plug	Bottoming				
A6097	A9098	M1.6	0.35	3	D3
A6137	A9138	M2	0.4	3	D3
A6177	A9178	M2.5	0.45	3	D3
A6207	A9208	M3	0.5	3	D3
A6227	A9228	M3.5	0.6	3	D4
A6247	A9248	M4	0.7	4	D4
A6267	A9268	M4.5	0.75	4	D4
A6287	A9288	M5	0.8	4	D4
A6317	A9318	M6	1.0	4	D5
A6347	A9348	M7	1.0	4	D5
A6367	A9368	M8	1.25	4	D5
A6427	A9428	M10	1.5	4	D6
A6507	A9508	M12	1.75	4	D6
A6547	A9548	M14	2.0	4	D7
A6607	A9608	M16	2.0	4	D7
A6657	A9658	M18	2.5	4	D7
A6707	A9708	M20	2.5	4	D7
A6787	A9788	M24	3.0	4	D8
A6947	A9948	M30	3.5	4	D9
A6B37	A9B38	M36	4.0	4	D9

GT



SPIRAL FLUTED TAPS MODIFIED BOTTOMING STYLE

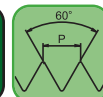
for Stainless Steels up to 28HRc and Steels up to 30HRc



BS & T1 Series | ANSI

METRIC

HSSE-V3

STEAM
OXIDEE6 Series | DIN Length
ANSI Shank

METRIC

STEAM OXIDE

EDP No.		Size	Pitch	No. of Flutes	Thread Limit
ANSI	DIN Length ANSI Shank				
BS203	E6203	M3	0.5	3	D3
BS224	E6224	M3.5	0.6	3	D4
BS244	E6244	M4	0.7	3	D4
BS284	E6284	M5	0.8	3	D4
BS315	E6315	M6	1.0	3	D5
BS345	E6345	M7	1.0	3	D5
BS365	E6365	M8	1.25	3	D5
BS375	E6375	M8	1.0	3	D5
BS426	E6426	M10	1.5	3	D6
BS435	E6435	M10	1.25	3	D5
BS506	E6506	M12	1.75	3	D6
BS525	E6525	M12	1.25	3	D5
BS547	E6547	M14	2.0	3	D7
BS556	E6556	M14	1.5	3	D6
BS607	E6607	M16	2.0	3	D7
BS616	E6616	M16	1.5	3	D6
BS657	E6657	M18	2.5	4	D7
BS676	E6676	M18	1.5	4	D6

STEAM OXIDE

EDP No.		Size	Pitch	No. of Flutes	Thread Limit
ANSI					
T1185706		M20	2.5	4	D6
T1185725		M20	1.5	4	D5
T1185746		M22	2.5	4	D6
T1185766		M22	1.5	4	D6
T1185787		M24	3.0	4	D7
T1185805		M24	1.5	4	D7
T1185867		M27	3.0	4	D7
T1185887		M27	1.5	4	D7
T1185947		M30	3.5	4	D7
T1185977		M30	1.5	4	D7

Hardslick Coated ANSI (BT Series) and TiCN or Hardslick Coated DIN Length / ANSI Shank (E8 or E9 Series) Taps available on request, see YU13 Catalog or contact us for details.

CUTTING APPLICATIONS

Materials Main Group	Sub-Group	Condition	Hardness (HRc)	Cutting Speed (SFM)
Stainless steel	200Series	Annealed	<28	20-35
	300Series	Annealed	<28	20-35
	17-4, 15-5	Annealed	<25	10-15
	AM286	Annealed	<25	15-25
	400Series	Annealed	<28	20-35
Low carbon steel	1010	Normalized	<20	25-50
	1018			
	1035			
Medium carbon steel	1030, 1035	Normalized	<28	20-40
	1038, 1040 1045, 1050			
High carbon steel	1065, 1070	Normalized	<30	15-25
	1080, 1090 1095, 1561 1572			
High strength steel	4140, 4340	Normalized	<30	15-25
Tool steel	A-2, D-2 H-13, P-20	Annealed	<30	15-25
Aluminum	Cast, wrought	-	-	30-90
Magnesium	-	-	-	40-80
Copper	-	-	-	50-60
Brass	-	-	-	30-65
Zinc	-	-	-	25-65

SPIRAL POINTED TAPS PLUG STYLE

for Stainless Steels up to 28HRc and Steels up to 30HRc

GT



CUTTING APPLICATIONS

Materials Main Group	Sub-Group	Condition	Hardness (HRc)	Cutting Speed (SFM)
Stainless steel	200Series	Annealed	<28	20-35
	300Series	Annealed	<28	20-35
	17-4, 15-5	Annealed	<25	10-15
	AM286	Annealed	<25	15-25
	400Series	Annealed	<28	20-35
Low carbon steel	1010	Normalized	<20	25-50
	1018			
	1035			
Medium carbon steel	1030, 1035	Normalized	<28	20-40
	1038, 1040			
	1045, 1050			
High carbon steel	1065, 1070	Normalized	<30	15-25
	1080, 1090			
	1095, 1561 1572			
High strength steel	4140, 4340	Normalized	<30	15-25
Tool steel	A-2, D-2 H-13, P-20	Annealed	<30	15-25
Aluminum	Cast, wrought	-	-	30-90
Magnesium	-	-	-	40-80
Copper	-	-	-	50-60
Brass	-	-	-	30-65
Zinc	-	-	-	25-65



METRIC

O9 & T1 Series | ANSI



METRIC

K3 Series | DIN Length
ANSI Shank

STEAM OXIDE

EDP No.		Size	Pitch	No. of Flutes	Thread Limit
ANSI	DIN Length ANSI Shank				
O9203	K3203	M3	0.5	3	D3
O9224	K3224	M3.5	0.6	3	D4
O9244	K3244	M4	0.7	3	D4
O9284	K3284	M5	0.8	3	D4
O9315	K3315	M6	1.0	3	D5
O9345	K3345	M7	1.0	3	D5
O9365	K3365	M8	1.25	3	D5
O9375	K3375	M8	1.0	3	D5
O9426	K3426	M10	1.5	3	D6
O9435	K3435	M10	1.25	3	D5
O9506	K3506	M12	1.75	3	D6
O9525	K3525	M12	1.25	3	D5
O9547	K3547	M14	2.0	3	D7
O9556	K3556	M14	1.5	3	D6
O9607	K3607	M16	2.0	3	D7
O9616	K3616	M16	1.5	3	D6
O9657	K3657	M18	2.5	3	D7
O9676	K3676	M18	1.5	3	D6

STEAM OXIDE

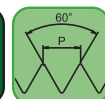
EDP No.		Size	Pitch	No. of Flutes	Thread Limit
ANSI					
T1235707		M20	2.5	3	D7
T1235725		M20	1.5	3	D5
T1235746		M22	2.5	3	D6
T1235766		M22	1.5	3	D6
T1235787		M24	3.0	3	D7
T1235805		M24	1.5	3	D5
T1235867		M27	3.0	4	D7
T1235887		M27	1.5	4	D7
T1235947		M30	3.5	4	D7
T1235977		M30	1.5	4	D7

Hardslick Coated ANSI (IA Series) and TiCN or Hardslick Coated DIN Length / ANSI Shank (K5 or K6 Series) Taps available on request, see YU13 Catalog or contact us for details.

GT-S


SPIRAL FLUTED TAPS MODIFIED BOTTOMING STYLE

for Steels up to 38HRc


BU Series | ANSI
METRIC
HSSE-V3

**STEAM
OXIDE**

**E2 Series | DIN Length
ANSI Shank**
METRIC

STEAM OXIDE

EDP No.		Size	Pitch	No. of Flutes	Thread Limit
ANSI	DIN Length ANSI Shank				
BU203	E2203	M3	0.5	3	D3
BU224	E2224	M3.5	0.6	3	D4
BU244	E2244	M4	0.7	3	D4
BU284	E2284	M5	0.8	3	D4
BU315	E2315	M6	1.0	3	D5
BU345	E2345	M7	1.0	3	D5
BU365	E2365	M8	1.25	3	D5
BU375	E2375	M8	1.0	3	D5
BU426	E2426	M10	1.5	3	D6
BU435	E2435	M10	1.25	3	D5
BU506	E2506	M12	1.75	3	D6
BU525	E2525	M12	1.25	3	D5
BU547	E2547	M14	2.0	3	D7
BU556	E2556	M14	1.5	3	D6
BU607	E2607	M16	2.0	3	D7
BU616	E2616	M16	1.5	3	D6
BU657	E2657	M18	2.5	4	D7
BU676	E2676	M18	1.5	4	D6

Hardslick Coated ANSI (BV Series) and TiCN or Hardslick Coated DIN Length / ANSI Shank (E4 or E5 Series) Taps available on request, see YU13 Catalog or contact us for details.

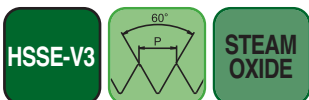
CUTTING APPLICATIONS

Materials Main Group	Sub-Group	Condition	Hardness (HRc)	Cutting Speed (SFM)
Medium carbon steel	1030, 1035 1038, 1040 1045, 1050	Normalized	<28	20-40
High carbon steel	1065, 1070 1080, 1090 1095, 1561 1572	Normalized	<32	15-25
High strength steel	4140, 4340	Normalized	<38	15-25
Tool steel	A-2, D-2 H-13, P-20	Annealed	<38	15-25
Stainless steel	200Series 300Series 17-4, 15-5 AM286	Annealed Annealed Annealed Annealed	<28 <28 <25 <25	20-35 20-35 15-25 15-25

SPIRAL POINTED TAPS PLUG STYLE

for Steels up to 38HRC

GT-S

**METRIC**

IB Series | ANSI

**METRIC**J9 Series | DIN Length
ANSI Shank

CUTTING APPLICATIONS

Materials Main Group	Sub-Group	Condition	Hardness (HRC)	Cutting Speed (SFM)
Medium carbon steel	1030, 1035 1038, 1040 1045, 1050	Normalized	<28	20-40
High carbon steel	1065, 1070 1080, 1090 1095, 1561 1572	Normalized	<32	15-25
High strength steel	4140, 4340	Normalized	<38	15-25
Tool steel	A-2, D-2 H-13, P-20	Annealed	<38	15-25
Stainless steel	200Series 300Series 17-4, 15-5 AM286	Annealed Annealed Annealed Annealed	<28 <28 <25 <25	20-35 20-35 15-25 15-25

STEAM OXIDE

EDP No.		Size	Pitch	No. of Flutes	Thread Limit
ANSI	DIN Length ANSI Shank				
IB203	J9203	M3	0.5	3	D3
IB224	J9224	M3.5	0.6	3	D4
IB244	J9244	M4	0.7	3	D4
IB284	J9284	M5	0.8	3	D4
IB315	J9315	M6	1.0	3	D5
IB345	J9345	M7	1.0	3	D5
IB365	J9365	M8	1.25	3	D5
IB375	J9375	M8	1.0	3	D5
IB426	J9426	M10	1.5	3	D6
IB435	J9435	M10	1.25	3	D5
IB506	J9506	M12	1.75	3	D6
IB525	J9525	M12	1.25	3	D5
IB547	J9547	M14	2.0	3	D7
IB556	J9556	M14	1.5	3	D6
IB607	J9607	M16	2.0	3	D7
IB616	J9616	M16	1.5	3	D6
IB657	J9657	M18	2.5	4	D7
IB676	J9676	M18	1.5	4	D6

Hardslick Coated ANSI (IC Series) and TiCN or Hardslick Coated DIN Length / ANSI Shank (K7 or K2 Series) Taps available on request, see YU13 Catalog or contact us for details.

Super-B
YG

SPIRAL FLUTED TAPS MODIFIED BOTTOMING STYLE

for Steels and Stainless Steels up to 35HRc

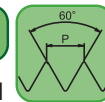


BH & BM Series | ANSI **METRIC**



BD & B0 | DIN Length
ANSI Shank **METRIC**

Super
HSS
Premium
Powdered
Metal



STEAM
OXIDE

HARDSLICK
COATED

CUTTING APPLICATIONS

Materials Main Group	Sub-Group	Condition	Hardness (HRc)	Cutting Speed (SFM)
Stainless steel	200Series 300Series	Annealed Annealed	<35	20-35
Low carbon steel	1010 1018 1035	Normalized	<20	30-80
Medium carbon steel	1030, 1035 1038, 1040 1045, 1050	Normalized	<20	20-50
High carbon steel	1065, 1070 1080, 1090 1095, 1561 1572	Normalized	<35	15-35
High strength steel	4140, 4340	Normalized	<35	15-25
Tool steel	A-2, D-2 H-13, P-20	Annealed	<35	15-25
Aluminum	Cast, wrought	-	-	30-90
Magnesium	-	-	-	40-80
Copper	-	-	-	50-60
Brass	-	-	-	30-65
Zinc	-	-	-	30-80

ANSI
LENGTH

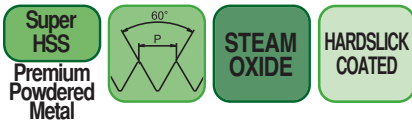
DIN LENGTH
ANSI SHANK

EDP No.				Size	Pitch	No. of Flutes	Thread Limit
Steam Oxide	Hardslick Coated	Steam Oxide	Hardslick Coated				
BH203	BM203	BD203	BO203	M3	0.5	3	D3
BH224	BM224	BD224	BO224	M3.5	0.6	3	D4
BH244	BM244	BD244	BO244	M4	0.7	3	D4
BH284	BM284	BD284	BO284	M5	0.8	3	D4
BH315	BM315	BD315	BO315	M6	1.0	3	D5
BH345	BM345	BD345	BO345	M7	1.0	3	D5
BH365	BM365	BD365	BO365	M8	1.25	3	D5
BH375	BM375	BD375	BO375	M8	1.0	3	D5
BH426	BM426	BD426	BO426	M10	1.5	3	D6
BH435	BM435	BD435	BO435	M10	1.25	3	D5
BH506	BM506	BD506	BO506	M12	1.75	3	D6
BH525	BM525	BD525	BO525	M12	1.25	3	D5
BH547	BM547	BD547	BO547	M14	2.0	3	D7
BH556	BM556	BD556	BO556	M14	1.5	3	D6
BH607	BM607	BD607	BO607	M16	2.0	3	D7
BH616	BM616	BD616	BO616	M16	1.5	3	D6
BH657	BM657	BD657	BO657	M18	2.5	4	D7
BH676	BM676	BD676	BO676	M18	1.5	4	D6

SPIRAL POINTED TAPS PLUG STYLE

for Steels and Stainless Steels up to 35HRc

Super-B
Y/G



CUTTING APPLICATIONS

Materials Main Group	Sub-Group	Condition	Hardness (HRc)	Cutting Speed (SFM)
Stainless steel	200Series 300Series	Annealed Annealed	<35	20-35
Low carbon steel	1010 1018 1035	Normalized	<20	30-80
Medium carbon steel	1030, 1035 1038, 1040 1045, 1050	Normalized	<20	20-50
High carbon steel	1065, 1070 1080, 1090 1095, 1561 1572	Normalized	<35	15-35
High strength steel	4140, 4340	Normalized	<35	15-25
Tool steel	A-2, D-2 H-13, P-20	Annealed	<35	15-25
Aluminum	Cast, wrought	-	-	30-90
Magnesium	-	-	-	40-80
Copper	-	-	-	50-60
Brass	-	-	-	30-65
Zinc	-	-	-	30-80



METRIC N7 & N8 Series | ANSI



METRIC N3 & O3 | DIN Length
ANSI Shank

ANSI LENGTH DIN LENGTH
ANSI SHANK

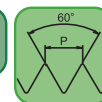
EDP No.				Size	Pitch	No. of Flutes	Thread Limit
Steam Oxide	Hardslick Coated	Steam Oxide	Hardslick Coated				
N7203	N8203	N3203	O3203	M3	0.5	3	D3
N7224	N8224	N3224	O3224	M3.5	0.6	3	D4
N7244	N8244	N3244	O3244	M4	0.7	3	D4
N7284	N8284	N3284	O3284	M5	0.8	3	D4
N7315	N8315	N3315	O3315	M6	1.0	3	D5
N7345	N8345	N3345	O3345	M7	1.0	3	D5
N7365	N8365	N3365	O3365	M8	1.25	3	D5
N7375	N8375	N3375	O3375	M8	1.0	3	D5
N7426	N8426	N3426	O3426	M10	1.5	3	D6
N7435	N8435	N3435	O3435	M10	1.25	3	D5
N7506	N8506	N3506	O3506	M12	1.75	3	D6
N7525	N8525	N3525	O3525	M12	1.25	3	D5
N7547	N8547	N3547	O3547	M14	2.0	3	D7
N7556	N8556	N3556	O3556	M14	1.5	3	D6
N7607	N8607	N3607	O3607	M16	2.0	3	D7
N7616	N8616	N3616	O3616	M16	1.5	3	D6
N7657	N8657	N3657	O3657	M18	2.5	3	D7
N7676	N8676	N3676	O3676	M18	1.5	3	D6

GT-HS


SPIRAL FLUTED TAPS MODIFIED BOTTOMING STYLE & SPIRAL POINTED TAPS PLUG STYLE for Steel and Stainless Steel up to 45HRc



TK Series | ANSI

METRIC
P-HSS
 Powdered
 Metal

TiCN
 COATED
TiCN

EDP No.	Size	Pitch	No. of Flutes	Thread Limit
ANSI				
TK858203	M3	0.5	3	D3
TK858244	M4	0.7	3	D4
TK858284	M5	0.8	3	D4
TK858315	M6	1.0	3	D5
TK858365	M8	1.25	3	D5
TK858426	M10	1.5	3	D6
TK858506	M12	1.75	3	D6

CUTTING APPLICATIONS

Materials Main Group	Sub-Group	Condition	Hardness (HRc)	Cutting Speed (SFM)
Stainless steel	300Series	Hardened	<45	12-22
	17-4, 15-5	Hardened	<45	10-15
	AM286	Hardened	<45	10-20
	400Series	Hardened	<45	12-22
High strength steel	4140, 4340	Hardened	<45	15-20
Tool steel	A-2, D-2 H-13, P-20	Hardened	<45	10-18
Nickel-based alloys	Inconel 7-18, Waspalloy, Hastelloy, Monel	Hardened Normalized Normalized	<45	8-15
Titanium	Comm Pure 6AL-4V	Annealed Hardened	15-20 35-42	8-15
Bronze	Aluma Phosphor		<44	25-60



TK Series | ANSI

METRIC**TiCN**

EDP No.	Size	Pitch	No. of Flutes	Thread Limit
ANSI				
TK808203	M3	0.5	3	D3
TK808244	M4	0.7	3	D4
TK808284	M5	0.8	3	D4
TK808315	M6	1.0	3	D5
TK808365	M8	1.25	3	D5
TK808426	M10	1.5	3	D6
TK808506	M12	1.75	3	D6