

**YG SPIRAL POINT TAPS**

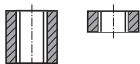
**TC127 SERIES**

**M ISO metric coarse threads DIN 13**  
**Metrisches ISO-Gewinde DIN 13**

► Suitable for through hole in more cutting speed than other taps due to thick web.

► Geeignet für Durchgangslöcher in höherer Schnittgeschwindigkeit als bei anderen Gewindebohrern dank größerer Kerndicke.

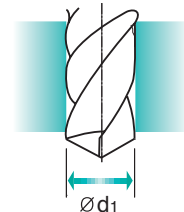
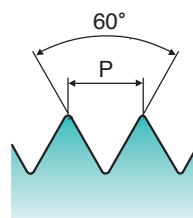
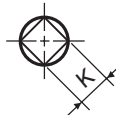
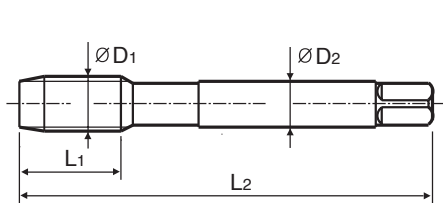
Hole type



DIN 371



Machine taps  
Maschinengewindebohrer



Unit : mm

| SIZE   | Pitch  | EDP No.  | Thread Length | Overall Length | Shank Diameter | Square Size | Tapping Drill Diameter |
|--------|--------|----------|---------------|----------------|----------------|-------------|------------------------|
| ØD1    | P      |          | L1            | L2             | ØD2            | K           | Ød1                    |
| M2     | × 0.4  | TC127136 | 8             | 45             | 2.8            | 2.1         | 1.6                    |
| M2.2   | × 0.45 | TC127156 | 8             | 45             | 2.8            | 2.1         | 1.75                   |
| * M2.3 | × 0.4  | TC127196 | 8             | 45             | 2.8            | 2.1         | 1.9                    |
| M2.5   | × 0.45 | TC127176 | 9             | 50             | 2.8            | 2.1         | 2.05                   |
| * M2.6 | × 0.45 | TC127496 | 9             | 50             | 2.8            | 2.1         | 2.1                    |
| M3     | × 0.5  | TC127206 | 11            | 56             | 3.5            | 2.7         | 2.5                    |
| M3.5   | × 0.6  | TC127226 | 12            | 56             | 4              | 3           | 2.9                    |
| M4     | × 0.7  | TC127246 | 13            | 63             | 4.5            | 3.4         | 3.3                    |
| M4.5   | × 0.75 | TC127266 | 14            | 70             | 6              | 4.9         | 3.7                    |
| M5     | × 0.8  | TC127286 | 15            | 70             | 6              | 4.9         | 4.2                    |
| M6     | × 1    | TC127316 | 17            | 80             | 6              | 4.9         | 5                      |
| M7     | × 1    | TC127346 | 17            | 80             | 7              | 5.5         | 6                      |
| M8     | × 1.25 | TC127366 | 20            | 90             | 8              | 6.2         | 6.8                    |
| M9     | × 1.25 | TC127396 | 20            | 90             | 9              | 7           | 7.8                    |
| M10    | × 1.5  | TC127426 | 22            | 100            | 10             | 8           | 8.5                    |
| M11    | × 1.5  | TC127466 | 22            | 100            | 11             | 9           | 9.5                    |
| M12    | × 1.75 | TC127506 | 24            | 110            | 12             | 9           | 10.2                   |

► \* DIN profile not ISO

Unit : N/mm²

◎ : Excellent ○ : Good

|                 |             |                |                 |                  |                  |                 |                  |               |               |                |                |                    |                   |                |
|-----------------|-------------|----------------|-----------------|------------------|------------------|-----------------|------------------|---------------|---------------|----------------|----------------|--------------------|-------------------|----------------|
| Steel < 400     | Steel < 700 | Steel < 850    | St. Alloy < 850 | St. Alloy ≤ 1200 | St. Alloy > 1200 | INOX Free < 850 | INOX Aust. < 850 | INOX < 1000   | GG Cast < 500 | GG Cast < 1000 | GGG Cast < 700 | GGG Cast < 1000    | Ti < 700          | Ti Alloy < 900 |
| ○               | ○           | ○              | ○               | ○                | ○                | ○               | ○                | ○             | ○             | ○              | ◎              | ◎                  | ○                 | ○              |
| Ti Alloy ≤ 1300 | Ni < 500    | Ni Alloy < 900 | Ni Alloy ≤ 1400 | Cu < 350         | Cu Alloy Short   | Cu Alloy Long   | Cu-Al-Fe < 1500  | Al / Mg < 350 | Al Wrought    | Al Si ≤ 10%    | Al Si > 10%    | Plastic Thermosoft | Plastic Thermoset | Plastic FRP    |
| ○               | ○           | ○              | ○               | ○                | ○                | ◎               | ○                | ○             | ○             | ○              | ◎              | ○                  | ○                 | ○              |



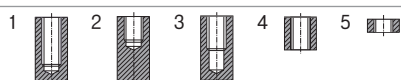
# MACHINE TAPS

## RECOMMENDATION TABLE

### USE

⊙ = EXCELLENT

○ = GOOD


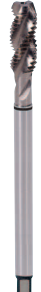




















| MATERIAL GROUPS             |          |                | MU            | MU            | MU               |
|-----------------------------|----------|----------------|---------------|---------------|------------------|
| DIN 371/376                 | M        | EDP No. (Page) | TC804 (p.375) | TD804 (p.375) | TC804-IC (p.378) |
| DIN 371/376                 | EG-M     | EDP No. (Page) |               |               |                  |
| DIN 352                     | M        | EDP No. (Page) |               |               |                  |
| DIN 374                     | MF       | EDP No. (Page) | TC844 (p.376) | TD844 (p.376) |                  |
| DIN 371/376                 | UNC      | EDP No. (Page) | TC824 (p.384) | TD824 (p.384) |                  |
| DIN 371/376                 | EG-UNC   | EDP No. (Page) |               |               |                  |
| DIN 371/374                 | UNF      | EDP No. (Page) | TC864 (p.385) | TD864 (p.385) |                  |
| DIN 371/376                 | EG-UNF   | EDP No. (Page) |               |               |                  |
| DIN 2182/2183               | BSW      | EDP No. (Page) |               |               |                  |
| DIN 357/5156                | M/G(BSP) | EDP No. (Page) |               |               |                  |
| LONG                        | M        | EDP No. (Page) |               |               |                  |
| SURFACE TREATMENT / COATING |          |                | Bright        | TiN           | Bright           |
| SPIRAL FLUTE ANGLE          |          |                | R40           | R40           | R40              |
| CHAMFER LEAD ACC. DIN 2197  |          |                | C             | C             | C                |
| HOLE TYPE                   |          |                | 1-2-3         | 1-2-3         | 1-2-3            |

### COOLANT

- A = Cutting Oil
- T = Oil Emulsion
- X = Cutting Oil/Oil Emulsion
- S = Dry
- Z = Dry/Oil Emulsion

| MATERIAL GROUPS           | LIST OF MATERIALS    | HARDNESS                                   | TENSILE STRENGTH | CHIP         | CUTTING SPEED | COOLANT | COOLANT | COOLANT | COOLANT | COOLANT |
|---------------------------|----------------------|--|------------------|--------------|---------------|---------|---------|---------|---------|---------|
|                           |                      |  |                  |              |               |         |         |         |         |         |
| 10. STEELS                | 11 Steel < 400       | Magnetic soft steels                       | < 120 < 400      | Extra long   | 15-20         | T       | ⊙       | ⊙       | ⊙       | ⊙       |
|                           | 12 Steel < 700       | Structure steels                           | < 200 < 700      | Medium/long  | 15-20         | T       | ⊙       | ⊙       | ⊙       | ⊙       |
|                           | 13 Steel < 850       | Plain carbon steels                        | < 250 < 850      | Long         | 12-18         | T       | ⊙       | ⊙       | ⊙       | ⊙       |
|                           | 14 St. Alloy < 850   | Alloy steels                               | < 250 < 850      | Long         | 10-15         | X       | ⊙       | ⊙       | ⊙       | ⊙       |
|                           | 15 St. Alloy ≤ 1,200 | Alloy steels, Hardened steels              | < 350 ≤ 1,200    | Long         | 6-10          | X       | ⊙       | ⊙       | ⊙       | ⊙       |
|                           | 16 St. Alloy > 1,200 | Alloy steels, Hardened steels              | > 350 > 1,200    | Long         | 3-5           | A       |         |         |         |         |
| 20. STAINLESS STEELS      | 21 INOX Free < 850   | Free machining                             | < 250 < 850      | Medium       | 7-10          | A       | ⊙       | ⊙       | ⊙       | ⊙       |
|                           | 22 INOX Aust.< 850   | Austenitic                                 | < 250 < 850      | Long         | 5-8           | A       | ⊙       | ⊙       | ⊙       | ⊙       |
|                           | 23 INOX < 1,100      | Ferritic, Ferritic+Austenitic, Martensitic | < 300 < 1,100    | Long         | 4-6           | A       | ⊙       | ⊙       | ⊙       | ⊙       |
| 30. CAST IRON             | 31 GG Cast < 500     | Grey cast iron                             | < 150 < 500      | Extra short  | 10-15         | X       | ⊙       | ⊙       | ⊙       | ⊙       |
|                           | 32 GG Cast < 1,000   | Grey cast iron                             | < 300 < 1,000    | Extra short  | 5-8           | T       | ⊙       | ⊙       | ⊙       | ⊙       |
|                           | 33 GGG Cast < 700    | Nodular graphite, Malleable cast iron      | < 200 < 700      | Short        | 10-15         | X       | ⊙       | ⊙       | ⊙       | ⊙       |
|                           | 34 GGG Cast < 1,000  | Nodular graphite, Malleable cast iron      | < 300 < 1,000    | Short        | 5-8           | X       | ⊙       | ⊙       | ⊙       | ⊙       |
| 40. TITANIUM              | 41 Ti < 700          | Titanium, Unalloyed                        | < 200 < 700      | Extra long   | 10-15         | T       | ⊙       | ⊙       | ⊙       | ⊙       |
|                           | 42 Ti Alloy < 900    | Titanium, Alloyed                          | < 270 < 900      | Medium/Short | 8-12          | A       | ○       | ○       | ○       | ○       |
|                           | 43 Ti Alloy ≤ 1,300  | Titanium, Alloyed                          | < 350 ≤ 1,300    | Medium/Short | 4-6           | A       |         |         |         |         |
| 50. NICKEL                | 51 Ni < 500          | Nickel, Unalloyed                          | < 150 < 500      | Extra long   | 8-12          | A       | ⊙       | ⊙       | ⊙       | ⊙       |
|                           | 52 Ni Alloy < 900    | Nickel, Alloyed                            | < 270 < 900      | Long         | 10-15         | A       | ○       | ○       | ○       | ○       |
|                           | 53 Ni Alloy ≤ 1,400  | Nickel, Alloyed                            | < 410 ≤ 1,400    | Long         | 2-4           | A       |         |         |         |         |
| 60. COPPER, BRASS, BRONZE | 61 Cu < 350          | Copper, Unalloyed                          | < 100 < 350      | Extra long   | 8-12          | T       | ⊙       | ⊙       | ⊙       | ⊙       |
|                           | 62 Cu Alloy (Short)  | Short chip Brass, Bronze, Copper           | < 200 < 700      | Medium/Short | 25-35         | T       | ⊙       | ⊙       | ⊙       | ⊙       |
|                           | 63 Cu Alloy (Long)   | Long chip Brass, Bronze, Copper            | < 200 < 700      | Long         | 15-20         | T       | ⊙       | ⊙       | ⊙       | ⊙       |
|                           | 64 Cu-Al-Fe < 1,500  | Cu-Al-Fe alloys                            | < 470 < 1,500    | Short        | 3-5           | A       |         |         |         |         |
| 70. ALUMINUM              | 71 Al/Mg < 350       | Aluminum, Magnesium, Unalloyed             | < 100 < 350      | Extra long   | 10-15         | T       |         |         |         |         |
|                           | 72 Al Wrought        | Aluminum, Alloyed Si < 0.5%                | < 150 < 500      | Medium       | 25-35         | T       | ⊙       | ⊙       | ⊙       | ⊙       |
|                           | 73 Al (Si ≤ 10%)     | Aluminum, Alloyed, Si ≤ 10%                | < 120 < 400      | Medium/Short | 15-20         | T       | ⊙       | ⊙       | ⊙       | ⊙       |
|                           | 74 Al (Si > 10%)     | Aluminum, Alloyed, Si > 10%                | < 120 < 400      | Short        | 10-15         | T       | ⊙       | ⊙       | ⊙       | ⊙       |
| 80. PLASTICS              | 81 Thermosoft.       | Thermoplastics                             |                  | Extra long   | 20-30         | T       |         |         |         |         |
|                           | 82 Thermoset.        | Thermosetting Plastics                     |                  | Short        | 8-12          | Z       |         |         |         |         |
|                           | 83 FRP               | Fiber Reinforced Plastics                  |                  | Extra short  | 5-7           | Z       |         |         |         |         |

| MU   | MU   | VA   | VA   | MU   | MU   | MU   | MU   | VA   | VA   | GS   | GS   | GS   | GS  | GS   | GS   | GS   | GS   | GS   | GS   |
|--|--|--|--|--|--|--|--|--|--|--|--|--|---|--|--|--|--|--|--|
| TC807 (p.379)  |  | TQ744 (p.381)  | TB744 (p.381)  | TC814 (p.386)  | TD814 (p.386)  | TC814-IC (p.389)   |  | TQ428 (p.391)  | TB428 (p.391)  | TTS31 (p.400)  | TTS33 (p.450)  | TKS35 (p.493)  | TTS37 (p.509)   | TC127 (p.452)  | TC227 (p.453)  | TD127 (p.454)  | TD227 (p.455)  | TC463 (p.494)  | TC211 (p.402)  |
|  |  |  |  |  |  |  |  |  |  |  |  |  |   | TC122 (p.451)  |  |  |  |  |  |
|  |  | TQ754 (p.382)  | TB754 (p.382)  | TC854 (p.387)  | TD854 (p.387)  |  |  | TQ438 (p.392)  | TB438 (p.392)  |  |  |  |   | TC222 (p.476)  |  | TD222 (p.478)  |  | TC473 (p.502)  |  |
|  |  |  |  | TC834 (p.394)  | TD834 (p.394)  |  |  |  |  |  |  |  |   | TC214 (p.483)  |  |  |  | TC424 (p.504)  |  |
|  |  |  |  | TC874 (p.395)  | TD874 (p.395)  |  |  |  |  |  |  |  |   | TC234 (p.487)  |  |  |  |  |  |
|  |  |  |  |  |  |  |  |  |  |  |  |  |   | TC224 (p.490)  |  |  |  |  |  |
|  |  |  |  |  |  |  |  |  |  |  |  |  |   | TC727 (p.548)  |  |  |  | TC803 (p.524)  |  |
|  | TC633 (p.380)  |  |  |  |  |  | TC445 (p.390)  |  |  |  |  |  |   |  |  |  |  |  |  |
| Bright   | Bright   | Vap  | Vap  | Bright   | TiN  | Bright   | Bright   | Vap  | Vap  | TiN  | TiN  | TiCN   | TiN   | Bright   | Bright   | TiN  | TiN  | Bright   | Bright   |
| R40  | R40  | R45  | R45  |  |  |  |  |  |  | R45  |  |  |   |  |  |  |  |  | L20  |
| E  | C  | C  | C  | B  | B  | B  | B  | B  | B  | C  | B  | C  | C   | B  | B  | B  | B  | C/Long   | C  |
| 1-2-3  | 1-2-3  | 1-2-3  | 1-2-3  | 4-5  | 4-5  | 4-5  | 4-5  | 4-5  | 4-5  | 2-3  | 4-5  | 1-2-3<br>4-5   | 1-2-3<br>4-5  | 4-5  | 4-5  | 4-5  | 4-5  | 1-2-3<br>4-5   | 4-5  |
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|  |  |  |  |  |  |  |  |  |  | <b>Synchro Type</b>  |  |  |   |  |  |  |  |  |  |
|  |  |  |  |  |  |  |  |  |  | Applicable to 2-3 times faster cutting speed than minimum general GS Taps cutting speeds |  |  |   |  |  |  |  |  |  |
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# CUTTING SPEED TABLE

## CUTTING SPEED TABLE **SCHNITTGESCHWINDIGKEITSTABELLE** Cutting Speeds m/min. into revolutions per minute

| TOOL R.P.M.(rev/min) |                       |     |     |      |      |      |      |      |      |      |      |      |      |       |       |       |
|----------------------|-----------------------|-----|-----|------|------|------|------|------|------|------|------|------|------|-------|-------|-------|
| Tool Dia.            | Cutting Speed (m/min) |     |     |      |      |      |      |      |      |      |      |      |      |       |       |       |
|                      | 1                     | 2   | 3   | 4    | 5    | 6    | 8    | 10   | 12   | 15   | 20   | 25   | 30   | 40    | 50    | 60    |
| 1                    | 318                   | 637 | 955 | 1274 | 1592 | 1910 | 2548 | 3185 | 3822 | 4777 | 6396 | 7962 | 9554 | 12739 | 15924 | 19108 |
| 2                    | 159                   | 318 | 478 | 637  | 796  | 955  | 1274 | 1592 | 1911 | 2388 | 3185 | 3981 | 4777 | 6369  | 7962  | 9554  |
| 3                    | 106                   | 212 | 318 | 425  | 531  | 637  | 849  | 1062 | 1274 | 1592 | 2123 | 2654 | 3185 | 4246  | 5308  | 6369  |
| 4                    | 80                    | 159 | 239 | 318  | 398  | 478  | 637  | 796  | 955  | 1194 | 1592 | 1990 | 2389 | 3185  | 3981  | 4777  |
| 5                    | 64                    | 127 | 191 | 255  | 318  | 382  | 510  | 637  | 764  | 955  | 1274 | 1592 | 1911 | 2548  | 3185  | 3822  |
| 6                    | 53                    | 106 | 159 | 212  | 265  | 318  | 425  | 531  | 637  | 796  | 1062 | 1327 | 1592 | 2123  | 2653  | 3185  |
| 8                    | 40                    | 80  | 119 | 159  | 199  | 239  | 318  | 398  | 478  | 597  | 796  | 955  | 1194 | 1592  | 1990  | 2388  |
| 10                   | 31                    | 64  | 96  | 127  | 159  | 191  | 255  | 318  | 382  | 478  | 637  | 796  | 955  | 1274  | 1592  | 1911  |
| 12                   | 26                    | 53  | 80  | 106  | 133  | 159  | 212  | 265  | 318  | 398  | 531  | 663  | 796  | 1062  | 1327  | 1592  |
| 14                   | 23                    | 45  | 68  | 91   | 114  | 136  | 182  | 227  | 273  | 341  | 455  | 569  | 682  | 910   | 1137  | 1365  |
| 16                   | 20                    | 40  | 60  | 80   | 100  | 119  | 159  | 199  | 239  | 299  | 398  | 498  | 597  | 796   | 995   | 1194  |
| 18                   | 18                    | 35  | 53  | 71   | 88   | 106  | 142  | 177  | 212  | 265  | 354  | 442  | 531  | 708   | 885   | 1062  |
| 20                   | 16                    | 32  | 48  | 64   | 80   | 96   | 127  | 159  | 191  | 239  | 318  | 398  | 478  | 637   | 796   | 955   |
| 25                   | 13                    | 25  | 38  | 51   | 64   | 76   | 102  | 127  | 153  | 191  | 255  | 318  | 382  | 510   | 637   | 764   |
| 30                   | 11                    | 21  | 32  | 42   | 53   | 64   | 85   | 106  | 127  | 159  | 212  | 265  | 318  | 425   | 531   | 637   |
| 35                   | 9                     | 18  | 27  | 36   | 45   | 55   | 73   | 91   | 109  | 136  | 182  | 227  | 273  | 364   | 455   | 546   |
| 40                   | 8                     | 16  | 24  | 32   | 40   | 48   | 64   | 80   | 96   | 119  | 159  | 199  | 239  | 118   | 398   | 478   |

RPM = rev/min

V = m/min

D = Dia.(mm)

$$V = \frac{RPM \cdot \pi \cdot D}{1000}$$

$$RPM = \frac{1000 \cdot V}{\pi \cdot D}$$