



Leading Through Innovation



HSS-E

YG TAP CHIP BREAKER

YG Gewindebohrer Chip Breaker

- TiN Coated Tap with Chip Breaker for Steel Materials
- TiN-beschichteter Gewindebohrer mit Spanbrecher für Stahlwerkstoffe

SELECTION GUIDE



HSS-E
YG TAP
CHIP BREAKER



© : Excellent ○ : Good
Recommended cutting conditions : p.B169

HOLE TYPE	Max. 2.0xD Blind Hole		
TOOL MATERIAL	HSS-E		
CHAMFER LEAD ACC. TO DIN2197	C	E	C
FLUTE TYPE	Spiral Flute		
SPIRAL FLUTE ANGLE	R15		

SERIES	M	DIN371/376	TDE24 (p.B163)	TDE26 (p.B165)	TDE28 (p.B167)
	MF	DIN374	TDE25 (p.B164)	TDE27 (p.B166)	TDE29 (p.B168)
SURFACE TREATMENT		TiN			



ISO	VDI 3323	Material Description	Composition / Structure / Heat Treatment	HB	HRC	○	○	○
P	1	Non-alloy steel	About 0.15% C Annealed	125		○	○	○
	2		About 0.45% C Annealed	190	13	○	○	○
	3		About 0.45% C Quenched & Tempered	250	25	○	○	○
	4		About 0.75% C Annealed	270	28			
	5		About 0.75% C Quenched & Tempered	300	32			
	6	Low alloy steel	Annealed	180	10	○	○	○
	7		Quenched & Tempered	275	29	○	○	○
	8		Quenched & Tempered	300	32	○	○	○
	9		Quenched & Tempered	350	38	○	○	○
	10		High alloyed steel, and tool steel	Annealed	200	15	○	○
	11	Quenched & Tempered		325	35	○	○	○
M	12	Stainless steel	Ferritic / Martensitic Annealed	200	15			
	13		Martensitic Quenched & Tempered	240	23			
	14		Austenitic	180	10			
K	15	Grey cast iron	Pearlitic / ferritic	180	10			
	16		Pearlitic (Martensitic)	260	26			
	17	Nodular cast iron	Ferritic	160	3			
	18		Pearlitic	250	25			
	19		Ferritic	130				
	20	Malleable cast iron	Pearlitic	230	21			
N	21	Aluminum-wrought alloy	Not Curable	60				
	22		Curable Hardened	100				
	23		≤ 12% Si, Not Curable	75				
	24	Aluminum-cast, alloyed	≤ 12% Si, Curable Hardened	90				
	25		> 12% Si, Not Curable	130				
	26	Copper and Copper Alloys (Bronze / Brass)	Cutting Alloys, PB>1%	110				
	27		CuZn, CuSnZn (Brass)	90				
	28		CuSn, lead-free copper and electrolytic copper	100				
	29		Non Metallic Materials	Duroplastic, Fiber Reinforced Plastic				
	30	Rubber, Wood, etc.						
S	31	Heat Resistant Super Alloys	Fe Based Annealed	200	15			
	32		Cured	280	30			
	33		Annealed	250	25			
	34		Ni or Co Based Cured	350	38			
	35		Cast	320	34			
36	Titanium Alloys	Pure Titanium	400 Rm					
37		Alpha + Beta Alloys Hardened	1050 Rm					
H	38	Hardened steel	Hardened	550	55			
	39		Hardened	630	60			
	40	Hardened Cast Iron	Cast	400	42			
	41		Hardened	550	55			

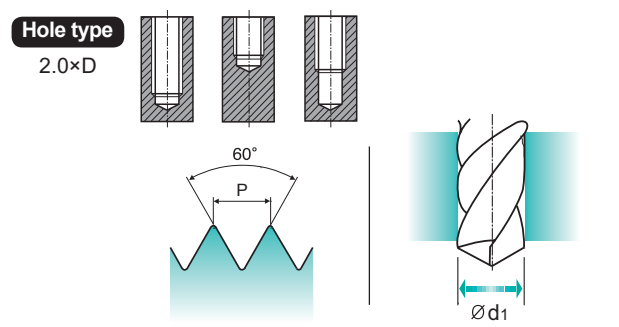
YG TAP
CHIP BREAKER

TDE24 SERIES

ISO Metric Coarse Threads DIN 13
 ● Metrisches ISO-Gewinde DIN 13
 ● ISO MÉTRIQUE DIN13
 ● ISO Metrico passo grosso DIN 13

Machine taps
Maschinengewindebohrer

- ▶ Solving the productivity problem caused by long chips.
- ▶ Particularly suitable for machining non-alloy steel, low alloy steel, high alloy steel, and tool steel
- ▶ Lösung des durch lange Späne verursachten Produktivitätsproblems
- ▶ Besonders geeignet für die Bearbeitung von unlegiertem Stahl, niedriglegiertem Stahl, hochlegiertem Stahl und Werkzeugstahl



HSS-E DIN 371/376 6H 60° C R15° TiN p.B169

Plain Shank Recommended ToolHolder SYNCHRO TAPPING CHUCK

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1	P	TiN	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M4 × 0.7		TDE24246R	7	63	21	4.5	3.4	6	3	3.3
M5 × 0.8		TDE24286R	8	70	25	6	4.9	8	3	4.2
M6 × 1.0		TDE24316R	10	80	30	6	4.9	8	3	5.0
M8 × 1.25		TDE24366R	13	90	35	8	6.2	9	3	6.8
M10 × 1.5		TDE24426R	15	100	39	10	8.0	11	3	8.5
M12 × 1.75		TDE24506R	18	110	44	9	7.0	10	3	10.3
M14 × 2.0		TDE24546R	20	110	44	11	9.0	12	3	12.0
M16 × 2.0		TDE24606R	20	110	44	12	9.0	12	3	14.0
M18 × 2.5		TDE24656R	25	125	50	14	11.0	14	4	15.5
M20 × 2.5		TDE24706R	25	140	54	16	12.0	15	4	17.5

▶ DIN 371 (M4-M10) and DIN 376 (M12-M20)

© : Excellent ○ : Good

ISO	P									M				K						
	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel		Grey cast iron	Nodular cast iron	Malleable cast iron				
Material Description	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRC	125	130	135	140	145	150	155	160	165	170	175	180	185	190	195	200	205	210	215	220
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

ISO	N					S					H										
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)		Non Metallic Materials			Heat Resistant Super Alloys			Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron			
Material Description	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRC	60	60	60	60	60	60	60	60	60	60	60	60	60	60	60	60	60	60	60	60	60
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

YG TAP CHIP BREAKER

TDE25 SERIES

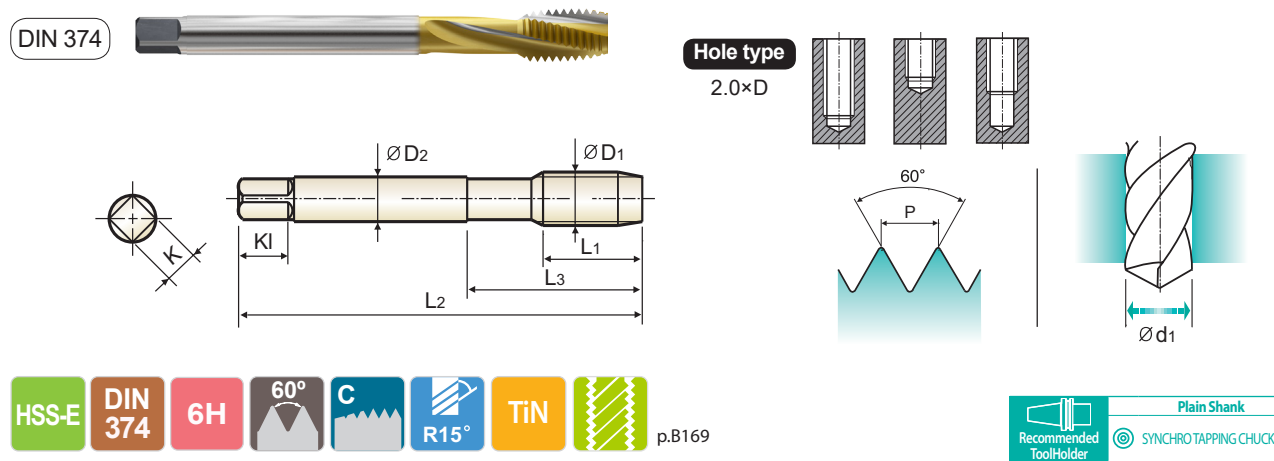
MF ISO Metric Fine Threads DIN 13

● Metrisches ISO-Feingewinde DIN 13
● ISO MÉTRIQUE PAS FINS DIN13
● ISO Metrico passo fine DIN 13

Machine taps
Maschinengewindebohrer

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- ▶ Besonders geeignet für die Bearbeitung von unlegiertem Stahl, niedriglegiertem Stahl, hochlegiertem Stahl und Werkzeugstahl



Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1	P	TiN	L1	L2	L3	ØD2	K	KI	Z	Ød1
M8	× 1.0	TDE25376R	10	90	36	6	4.9	8	3	7.0
M10	× 1.25	TDE25436R	16	100	40	7	5.5	8	3	8.8
M10	× 1.0	TDE25446R	10	90	36	7	5.5	8	3	9.0
M12	× 1.5	TDE25516R	15	100	40	9	7.0	10	3	10.5
M12	× 1.25	TDE25526R	15	100	40	9	7.0	10	3	10.8
M14	× 1.5	TDE25556R	15	100	40	11	9.0	12	3	12.5
M16	× 1.5	TDE25616R	15	100	40	12	9.0	12	3	14.5
M18	× 1.5	TDE25676R	17	110	44	14	11.0	14	4	16.5
M20	× 1.5	TDE25726R	17	125	50	16	12.0	15	4	18.5

◎ : Excellent ○ : Good

ISO Material Description	P										M				K					
	Non-alloy steel					Low alloy steel					High alloy steel, and tool steel		Stainless steel		Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRC	13	25	28	32	30	29	32	38	35	35	15	23	10	10	26	3	25	21	21	21
HB	125	190	250	270	300	180	275	300	350	200	240	180	260	160	250	130	230	230	230	230
Recommended	○	◎	◎	○	○	○	◎	◎	○	○	○	○	○	○	○	○	○	○	○	○

ISO Material Description	N										S						H				
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys				Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron		
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRC	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

YG TAP CHIP BREAKER

TDE26 SERIES

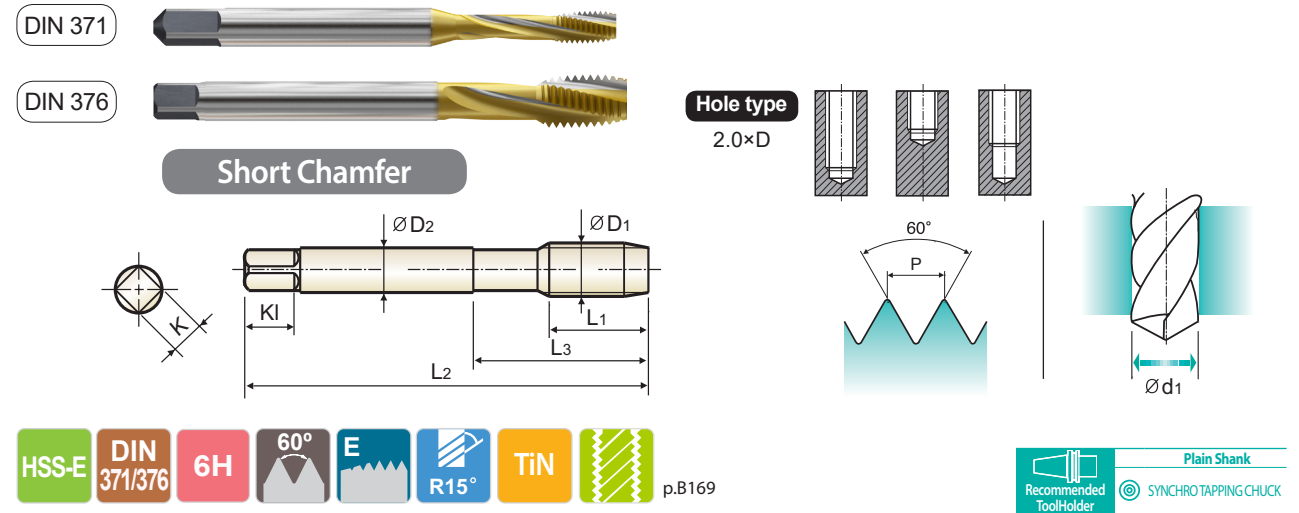
M ISO Metric Coarse Threads DIN 13

● Metrisches ISO-Gewinde DIN 13
● ISO MÉTRIQUE DIN13
● ISO Metrico passo grosso DIN 13

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Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1	P	TiN	L1	L2	L3	ØD2	K	KI	Z	Ød1
M4	× 0.7	TDE26246R	7	63	21	4.5	3.4	6	3	3.3
M5	× 0.8	TDE26286R	8	70	25	6	4.9	8	3	4.2
M6	× 1.0	TDE26316R	10	80	30	6	4.9	8	3	5.0
M8	× 1.25	TDE26366R	13	90	35	8	6.2	9	3	6.8
M10	× 1.5	TDE26426R	15	100	39	10	8.0	11	3	8.5
M12	× 1.75	TDE26506R	18	110	44	9	7.0	10	3	10.3
M14	× 2.0	TDE26546R	20	110	44	11	9.0	12	3	12.0
M16	× 2.0	TDE26606R	20	110	44	12	9.0	12	3	14.0
M18	× 2.5	TDE26656R	25	125	50	14	11.0	14	4	15.5
M20	× 2.5	TDE26706R	25	140	54	16	12.0	15	4	17.5

▶ DIN 371(M4-M10) and DIN 376(M12-M20)

◎ : Excellent ○ : Good

ISO Material Description	P										M				K					
	Non-alloy steel					Low alloy steel					High alloy steel, and tool steel		Stainless steel		Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRC	13	25	28	32	30	29	32	38	35	35	15	23	10	10	26	3	25	21	21	21
HB	125	190	250	270	300	180	275	300	350	200	240	180	260	160	250	130	230	230	230	230
Recommended	○	◎	◎	○	○	○	◎	◎	○	○	○	○	○	○	○	○	○	○	○	○

ISO Material Description	N										S						H				
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys				Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron		
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRC	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

YG TAP CHIP BREAKER

TDE27 SERIES

MF ISO Metric Fine Threads DIN 13

- Metrisches ISO-Feingewinde DIN 13
- ISO MÉTRIQUE PAS FINS DIN13
- ISO Metrico passo fine DIN 13

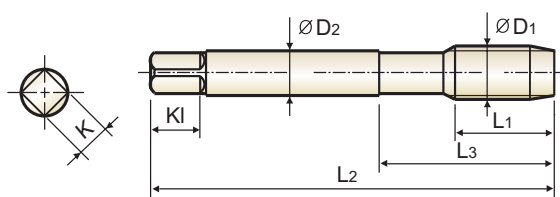
Machine taps
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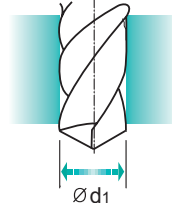
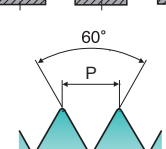
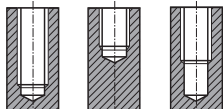
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Short Chamfer



Hole type
2.0×D



HSS-E DIN 374 6H 60° E R15° TiN p.B169

Plain Shank Recommended ToolHolder SYNCHRO TAPPING CHUCK

Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1	P	TiN	L1	L2	L3	ØD2	K	KI	Z	Ød1
M8	× 1.0	TDE27376R	10	90	36	6	4.9	8	3	7.0
M10	× 1.25	TDE27436R	16	100	40	7	5.5	8	3	8.8
M10	× 1.0	TDE27446R	10	90	36	7	5.5	8	3	9.0
M12	× 1.5	TDE27516R	15	100	40	9	7.0	10	3	10.5
M12	× 1.25	TDE27526R	15	100	40	9	7.0	10	3	10.8
M14	× 1.5	TDE27556R	15	100	40	11	9.0	12	3	12.5
M16	× 1.5	TDE27616R	15	100	40	12	9.0	12	3	14.5
M18	× 1.5	TDE27676R	17	110	44	14	11.0	14	4	16.5
M20	× 1.5	TDE27726R	17	125	50	16	12.0	15	4	18.5

◎ : Excellent ○ : Good

ISO	P										M				K					
	Non-alloy steel					Low alloy steel					High alloy steel, and tool steel		Stainless steel		Grey cast iron	Nodular cast iron		Malleable cast iron		
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRC	13	25	28	32	30	10	29	32	38	15	35	15	23	10	10	26	3	25	21	
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	○	◎	◎	○	◎	◎	○	○	○	○	○	○	○	○	○	○	○	○	○	○

ISO	N					S					H										
	Aluminum-wrought alloy		Aluminum-cast, alloyed		Copper and Copper Alloys (Bronze / Brass)	Non Metallic Materials	Heat Resistant Super Alloys					Titanium Alloys	Hardened steel	Chilled Cast Iron	Hardened Cast Iron						
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRC	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550
Recommended																					

YG TAP CHIP BREAKER

TDE28 SERIES

M ISO Metric Coarse Threads DIN 13

- Metrisches ISO-Gewinde DIN 13
- ISO MÉTRIQUE DIN13
- ISO Metrico passo grosso DIN 13

Machine taps
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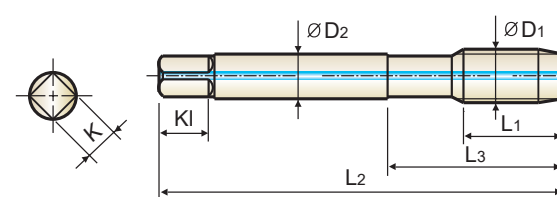
DIN 371



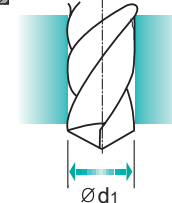
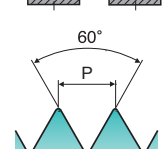
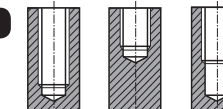
DIN 376



with Internal Coolant



Hole type
2.0×D



HSS-E DIN 371/376 6H 60° C R15° TiN p.B169

Plain Shank Recommended ToolHolder SYNCHRO TAPPING CHUCK

Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1	P	TiN	L1	L2	L3	ØD2	K	KI	Z	Ød1
M6	× 1.0	TDE28316R	10	80	30	6	4.9	8	3	5.0
M8	× 1.25	TDE28366R	13	90	35	8	6.2	9	3	6.8
M10	× 1.5	TDE28426R	15	100	39	10	8.0	11	3	8.5
M12	× 1.75	TDE28506R	18	110	44	9	7.0	10	3	10.3
M14	× 2.0	TDE28546R	20	110	44	11	9.0	12	3	12.0
M16	× 2.0	TDE28606R	20	110	44	12	9.0	12	3	14.0
M18	× 2.5	TDE28656R	25	125	50	14	11.0	14	4	15.5
M20	× 2.5	TDE28706R	25	140	54	16	12.0	15	4	17.5

► DIN 371(M6-M10) and DIN 376(M12-M20)

◎ : Excellent ○ : Good

ISO	P										M				K					
	Non-alloy steel					Low alloy steel					High alloy steel, and tool steel		Stainless steel		Grey cast iron	Nodular cast iron		Malleable cast iron		
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRC	13	25	28	32	30	10	29	32	38	15	35	15	23	10	10	26	3	25	21	
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	○	◎	◎	○	◎	◎	○	○	○	○	○	○	○	○	○	○	○	○	○	○

ISO	N					S					H										
	Aluminum-wrought alloy		Aluminum-cast, alloyed		Copper and Copper Alloys (Bronze / Brass)	Non Metallic Materials	Heat Resistant Super Alloys					Titanium Alloys	Hardened steel	Chilled Cast Iron	Hardened Cast Iron						
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRC	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550
Recommended																					

YG TAP CHIP BREAKER

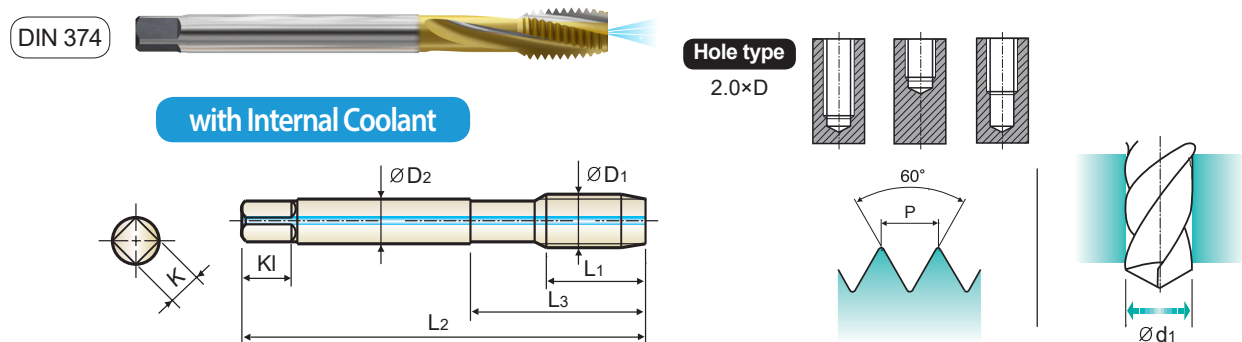
TDE29 SERIES

MF ISO Metric Fine Threads DIN 13

Metrisches ISO-Feingewinde DIN 13
 ISO MÉTRIQUE PAS FINS DIN 13
 ISO Metrico passo fine DIN 13

Machine taps
Maschinengewindebohrer

- ▶ Solving the productivity problem caused by long chips.
- ▶ Particularly suitable for machining non-alloy steel, low alloy steel, high alloy steel, and tool steel
- ▶ Lösung des durch lange Späne verursachten Produktivitätsproblems
- ▶ Besonders geeignet für die Bearbeitung von unlegiertem Stahl, niedriglegiertem Stahl, hochlegiertem Stahl und Werkzeugstahl



HSS-E DIN 374 6H 60° C R15° TiN p.B169

Plain Shank
 Recommended ToolHolder
 SYNCHRO TAPPING CHUCK

Unit : mm

SIZE	Pitch	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1	P	TiN	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M8 × 1.0		TDE29376R	10	90	36	6	4.9	8	3	7.0
M10 × 1.25		TDE29436R	16	100	40	7	5.5	8	3	8.8
M10 × 1.0		TDE29446R	10	90	36	7	5.5	8	3	9.0
M12 × 1.5		TDE29516R	15	100	40	9	7.0	10	3	10.5
M12 × 1.25		TDE29526R	15	100	40	9	7.0	10	3	10.8
M14 × 1.5		TDE29556R	15	100	40	11	9.0	12	3	12.5
M16 × 1.5		TDE29616R	15	100	40	12	9.0	12	3	14.5
M18 × 1.5		TDE29676R	17	110	44	14	11.0	14	4	16.5
M20 × 1.5		TDE29726R	17	125	50	16	12.0	15	4	18.5

◎ : Excellent ○ : Good

ISO	P										M				K					
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel		Stainless steel		Grey cast iron	Nodular cast iron		Malleable cast iron		
Material Description	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc	13	25	28	32	30	10	29	32	38	15	35	15	23	10	10	26	3	25	130	21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	○	◎	◎	○	◎	◎	◎	○	○	○	○	○	○	○	○	○	○	○	○	○

ISO	N										S						H				
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys				Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron		
Material Description	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550
Recommended	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

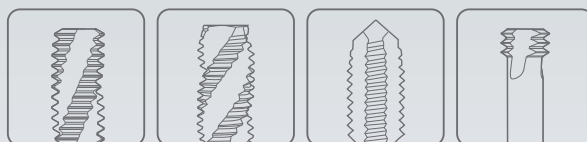
YG TAP CHIP BREAKER

RECOMMENDED CUTTING CONDITIONS EMPFOLHENE SCHNEIDKONDITIONEN

ISO	VDI 3323	Material Description	HB	HRc	TDE24	TDE25	TDE26	TDE27	TDE28	TDE29
					Vc (m/min.)					
P	1	Non-alloy steel	125		7-12	7-12	7-12	7-12	7-12	7-12
	2		190	13	7-12	7-12	7-12	7-12	7-12	7-12
	3		250	25	4-8	4-8	4-8	4-8	4-8	4-8
	6	Low alloy steel	180	10	7-12	7-12	7-12	7-12	7-12	7-12
	7		275	29	7-12	7-12	7-12	7-12	7-12	7-12
	8		300	32	4-8	4-8	4-8	4-8	4-8	4-8
	9		350	38	4-8	4-8	4-8	4-8	4-8	4-8
	10		High alloyed steel, and tool steel	200	15	6-9	6-9	6-9	6-9	6-9
	11	325		35	4-8	4-8	4-8	4-8	4-8	4-8



Global Cutting Tool Leader **YG-1**



THREADING