



THREADING TOOLS

# APPLICATION SELECTION GUIDE

- ★ : Best
- ◎ : Better
- : Good
- VO : Value Option

### Machine Type Definition

- S: Synchronous Tapping Cycle with Synchronous or Rigid Holders
- C: CNC Machine, Any Tapping Cycle with All Holders Types
- A: All Tapping Machines with All Holder Types

ISO	VDI 3323	Material Description	HB	HRc	Synchro Tap	Prime Tap	Combo Tap	Blue Ring	YG Tap Steel	YG Tap INOX	YG Tap Cast Iron	YG Tap ALU	YG Tap Ti/Ni	YG Tap Hardened
					S	C	A	C	A	A	A	A	A	A
P	1	Carbon Steel	125		★ SP	★	◎			○				
	2, 3, 4		190 - 270	13 - 26	★ SP	★	○	◎	VO					
	5		300	30		★	○	◎	VO					
	6, 7	Low Alloy Steel	180 - 275	10 - 26	★ SP	★	○	◎	VO					
	8, 9		300 - 350	30 - 36		★	○	◎	VO					
	10	High Alloy & Tools Steel	200	15			◎		○					★
	11		325	33										★
M	12, 13, 14	Stainless Steel	180 - 240	10 - 21	★ SP	★	○	◎		VO				
K	15, 16	Grey Cast Iron	180 - 260	10 - 24	◎ ST		○				★			
	17, 18	Ductile Iron	160 - 250	3 - 23	★ SP	◎	○							
	19 - 20	Malleable Iron	130 - 230	10 - 23	○ ST						◎			
N	21, 22	Wrought Aluminum	60 - 100					○		◎		★		
	23, 24, 25	Cast Aluminum	75 - 130		◎ SP	○	VO				★			
	26, 27, 28	Copper (& Alloys), Bronze	90 - 110		○ SP	★	◎			VO				
S	31, 32, 33	Heat Resistant Super Alloys	200 - 280	15 - 27					○				◎	
	34, 35		320 - 350	32 - 36									○	
	36	Titanium Alloys	120										◎	
	37		320	34									○	
H	38	Hardened Steel	550	53										○
	40	Chilled Cast Iron	400	41									○	

SP: Spiral Point Tap

SF: Spiral Flute Tap

ST: Straight Flute Tap