

New Product Announcement

June 1st, 2025_NPAT 2501

TAP
PRIME

Premium HSS-PM
High Performance Multipurpose
Forming Taps

DIN
STANDARD





New Product Announcement Prime Forming Tap

Prime Forming Tap

For CNC Machining in Various Ductile Materials

Prime Forming Tap is YG-1's the latest addition to the prime tap family for high performance form tapping across a range of materials including carbon and alloy steels, ductile irons, aluminum, and stainless steel

Value Proposition

- The Prime Forming Tap is the ideal solution for advanced manufacturing where high performance meets versatility. Made from premium powdered metal high-speed steel and finished with our proprietary X-Coating. Prime Forming Tap ensures long tool life and excellent thread quality. Prime Forming Tap's highly engineered geometry offers greater productivity and consistent gauging while producing the strongest threads of all patting methods.

Product Features

- **HSS-PM Material:** Powdered metal technology for higher spindle speeds, and longer tool life.
- **X-Coating:** YG-1's high performance coating for high heat and wear resistance
- **Radial Internal Coolant:** Prime Forming Tap is available with radial internal coolant holes as a standard option. Achieve even higher spindle speeds and even greater tool life by directing coolant to the work zone.
- **Entry Taper: Standard short and extra short entry chamfer available.** Improved thread forming in work hardening materials and options for close clearance threading applications.





New Product Announcement

Prime Tap X-Coating Forming

Work Material

◎ : Excellent ○ : Good

ISO	P										M				K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed 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	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			
Material Description	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											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550
Recommended	◎	◎	◎	◎	◎	◎	◎	◎													

Target Customers

- Solution for end users seeking high performance taps capable of working in a range of ductile materials.
- Especially effective for end users with modern CNC equipment looking for productivity gains with consistent gauging and excellent thread finish.

Sales Strategy

- Prime Forming Tap uses YG-1’s innovative design to offer .
- Recommend Prime Tap Forming confidently to customers currently using competitive HSS-PM forming taps, emphasizing the unmatched performance-to-value ratio that YG-1 provides.
- Prime Tap is the tap for customers who demand versatility with improved tool life and consistent performance.



New Product Announcement

Prime Tap X-Coating Forming

Product Line Summary

● DIN

Series	Flute Type	Thread Type	Coolant	Size Range	Chamfer	Class of Thread	Sku#
TRQ10~GS	Forming	M	Without Coolant	M3~M24	Form C	6HX	16
TRQ11~GS		MF		M6~M24	Form C	6HX	23
TRQ12~GS		M		M3~M16	Form E	6HX	12
TRQ13~GS		MF		M8~M16	Form E	6HX	12
TRQ14~GS		M		M3~M24	Form C	6GX	16
TRQ15~GS		MF		M6~M24	Form C	6GX	23
TRQ16~GS		M		M3~M16	Form C	7GX	12
TRQ17~GS		G(BSP)		G1/16~G1"	Form C	-	7
TRQ18~GS		UNC		#4~1"	Form C	2BX	16
TRQ19~GS		UNF		#4~1"	Form C	2BX	16
TRQ20~GSP		M	Radial Coolant	M5~M24	Form C	6HX	11
TRQ21~GSP		MF		M6~M24	Form C	6HX	23
TRQ22~GSP		M		M5~M16	Form E	6HX	7
TRQ23~GSP		MF		M8~M16	Form E	6HX	12
TRQ24~GSP		M		M5~M16	Form C	6GX	7
TRQ25~GSP		MF		M6~M16	Form C	6GX	15

Marketing Materials

<Promotion Video>



Coming soon, by June.

<New Prime Catalog>



Coming soon,
by September.

*The official launch date is June 5th.



New Product Announcement

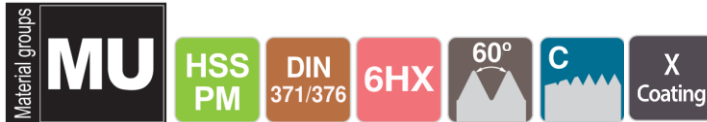
Prime Tap X-Coating Forming

EDP No. List

HSS-PM PRIME TAP FORMING

METRIC COARSE

TRQ10 SERIES



EDP No.	Size/dimensions
TRQ10206GS	M3X0.5 6HX 56.0L
TRQ10226GS	M3.5X0.6 6HX 56.0L
TRQ10246GS	M4X0.7 6HX 63.0L
TRQ10286GS	M5X0.8 6HX 70.0L
TRQ10316GS	M6X1.0 6HX 80.0L
TRQ10346GS	M7X1.0 6HX 80.0L
TRQ10366GS	M8X1.25 6HX 90.0L
TRQ10396GS	M9X1.25 6HX 90.0L
TRQ10426GS	M10X1.5 6HX 100.0L
TRQ10506GS	M12X1.75 6HX 110.0L
TRQ10546GS	M14X2.0 6HX 110.0L
TRQ10606GS	M16X2.0 6HX 110.0L
TRQ10656GS	M18X2.5 6HX 125.0L
TRQ10706GS	M20X2.5 6HX 140.0L
TRQ10746GS	M22X2.5 6HX 140.0L
TRQ10786GS	M24X3.0 6HX 160.0L

► DIN371(M3~M10) and DIN376(M12~M24)

◎ : Excellent ○ : Good

ISO	P										M				K						
Material Description	Non-alloy steel					Low alloy steel				High alloyed 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	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				
Material Description	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											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550
Recommended	◎	◎	◎	◎	◎	◎	◎	◎													



New Product Announcement

Prime Tap X-Coating Forming

EDP No. List

HSS-PM PRIME TAP FORMING

METRIC FINE

TRQ11 SERIES



EDP No.	Size/dimensions
TRQ11326GS	M6X0.75 6HX 80.0L
TRQ11336GS	M6X0.5 6HX 80.0L
TRQ11376GS	M8X1.0 6HX 90.0L
TRQ11386GS	M8X0.75 6HX 80.0L
TRQ11436GS	M10X1.25 6HX 100.0L
TRQ11446GS	M10X1.0 6HX 90.0L
TRQ11456GS	M10X0.75 6HX 90.0L
TRQ11516GS	M12X1.5 6HX 100.0L
TRQ11526GS	M12X1.25 6HX 100.0L
TRQ11536GS	M12X1.0 6HX 100.0L
TRQ11556GS	M14X1.5 6HX 100.0L
TRQ11566GS	M14X1.25 6HX 100.0L
TRQ11576GS	M14X1.0 6HX 100.0L
TRQ11616GS	M16X1.5 6HX 100.0L
TRQ11626GS	M16X1.0 6HX 100.0L
TRQ11666GS	M18X2.0 6HX 125.0L
TRQ11676GS	M18X1.5 6HX 110.0L
TRQ11686GS	M18X1.0 6HX 110.0L
TRQ11716GS	M20X2.0 6HX 140.0L
TRQ11726GS	M20X1.5 6HX 125.0L
TRQ11736GS	M20X1.0 6HX 125.0L
TRQ11766GS	M22X1.5 6HX 125.0L
TRQ11806GS	M24X1.5 6HX 140.0L

◎: Excellent ○: Good

ISO	P										M				K							
Material Description	Non-alloy steel					Low alloy steel					High alloyed 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	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				
Material Description	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											15	30	25	38	34			55	60	42	55	
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550	
Recommended	◎	◎	◎	◎	◎	◎	◎	◎														



New Product Announcement

Prime Tap X-Coating Forming

EDP No. List

HSS-PM PRIME TAP FORMING

METRIC COARSE

TRQ12 SERIES



EDP No.	Size/dimensions
TRQ12206GS	M3X0.5 6HX 56.0L
TRQ12226GS	M3.5X0.6 6HX 56.0L
TRQ12246GS	M4X0.7 6HX 63.0L
TRQ12286GS	M5X0.8 6HX 70.0L
TRQ12316GS	M6X1.0 6HX 80.0L
TRQ12346GS	M7X1.0 6HX 80.0L
TRQ12366GS	M8X1.25 6HX 90.0L
TRQ12396GS	M9X1.25 6HX 90.0L
TRQ12426GS	M10X1.5 6HX 100.0L
TRQ12506GS	M12X1.75 6HX 110.0L
TRQ12546GS	M14X2.0 6HX 110.0L
TRQ12606GS	M16X2.0 6HX 110.0L

► DIN371(M3~M10) and DIN376(M12~M16)

◎: Excellent ○: Good

ISO	P										M				K								
Material Description	Non-alloy steel					Low alloy steel				High alloyed 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	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						
Material Description	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											15	30	25	38	34			55	60	42	55		
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550		
Recommended	◎	◎	◎	◎	◎	◎	◎	◎															



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Prime Tap X-Coating Forming

EDP No. List

HSS-PM PRIME TAP FORMING

METRIC FINE

TRQ13 SERIES



EDP No.	Size/dimensions
TRQ13376GS	M8X1.0 6HX 90.0L
TRQ13386GS	M8X0.75 6HX 80.0L
TRQ13436GS	M10X1.25 6HX 100.0L
TRQ13446GS	M10X1.0 6HX 90.0L
TRQ13516GS	M12X1.5 6HX 100.0L
TRQ13526GS	M12X1.25 6HX 100.0L
TRQ13536GS	M12X1.0 6HX 100.0L
TRQ13556GS	M14X1.5 6HX 100.0L
TRQ13566GS	M14X1.25 6HX 100.0L
TRQ13576GS	M14X1.0 6HX 100.0L
TRQ13616GS	M16X1.5 6HX 100.0L
TRQ13626GS	M16X1.0 6HX 100.0L

◎ : Excellent ○ : Good

ISO	P										M				K						
Material Description	Non-alloy steel					Low alloy steel				High alloyed 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	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				
Material Description	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	
HRC											15	30	25	38	34			55	60	42	
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	
Recommended	◎	◎	◎	◎	◎	◎	◎	◎													



New Product Announcement

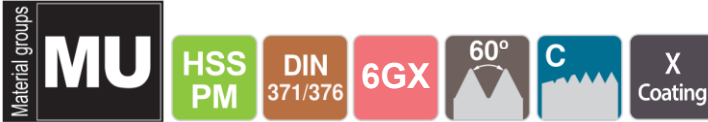
Prime Tap X-Coating Forming

EDP No. List

HSS-PM PRIME TAP FORMING

METRIC COARSE

TRQ14 SERIES



EDP No.	Size/dimensions
TRQ14206GS	M3X0.5 6GX 56.0L
TRQ14226GS	M3.5X0.6 6GX 56.0L
TRQ14246GS	M4X0.7 6GX 63.0L
TRQ14286GS	M5X0.8 6GX 70.0L
TRQ14316GS	M6X1.0 6GX 80.0L
TRQ14346GS	M7X1.0 6GX 80.0L
TRQ14366GS	M8X1.25 6GX 90.0L
TRQ14396GS	M9X1.25 6GX 90.0L
TRQ14426GS	M10X1.5 6GX 100.0L
TRQ14506GS	M12X1.75 6GX 110.0L
TRQ14546GS	M14X2.0 6GX 110.0L
TRQ14606GS	M16X2.0 6GX 110.0L
TRQ14656GS	M18X2.5 6GX 125.0L
TRQ14706GS	M20X2.5 6GX 140.0L
TRQ14746GS	M22X2.5 6GX 140.0L
TRQ14786GS	M24X3.0 6GX 160.0L

► DIN371(M3~M10) and DIN376(M12~M24)

◎ : Excellent ○ : Good

ISO	P										M				K						
Material Description	Non-alloy steel					Low alloy steel				High alloyed 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	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				
Material Description	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											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550
Recommended	◎	◎	◎	◎	◎	◎	◎	◎													



New Product Announcement

Prime Tap X-Coating Forming

EDP No. List

HSS-PM PRIME TAP FORMING

METRIC FINE

TRQ15 SERIES



EDP No.	Size/dimensions
TRQ15326GS	M6X0.75 6GX 80.0L
TRQ15336GS	M6X0.5 6GX 80.0L
TRQ15376GS	M8X1.0 6GX 90.0L
TRQ15386GS	M8X0.75 6GX 80.0L
TRQ15436GS	M10X1.25 6GX 100.0L
TRQ15446GS	M10X1.0 6GX 90.0L
TRQ15456GS	M10X0.75 6GX 90.0L
TRQ15516GS	M12X1.5 6GX 100.0L
TRQ15526GS	M12X1.25 6GX 100.0L
TRQ15536GS	M12X1.0 6GX 100.0L
TRQ15556GS	M14X1.5 6GX 100.0L
TRQ15566GS	M14X1.25 6GX 100.0L
TRQ15576GS	M14X1.0 6GX 100.0L
TRQ15616GS	M16X1.5 6GX 100.0L
TRQ15626GS	M16X1.0 6GX 100.0L
TRQ15666GS	M18X2.0 6GX 125.0L
TRQ15676GS	M18X1.5 6GX 110.0L
TRQ15686GS	M18X1.0 6GX 110.0L
TRQ15716GS	M20X2.0 6GX 140.0L
TRQ15726GS	M20X1.5 6GX 125.0L
TRQ15736GS	M20X1.0 6GX 125.0L
TRQ15766GS	M22X1.5 6GX 125.0L
TRQ15806GS	M24X1.5 6GX 140.0L

◎ : Excellent ○ : Good

ISO	P										M				K							
Material Description	Non-alloy steel					Low alloy steel				High alloyed 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	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					
Material Description	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											15	30	25	38	34			55	60	42	55	
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550	
Recommended	◎	◎	◎	◎	◎	◎	◎	◎														



New Product Announcement

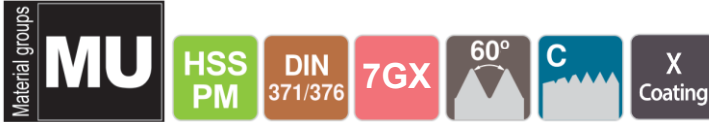
Prime Tap X-Coating Forming

EDP No. List

HSS-PM PRIME TAP FORMING

METRIC COARSE

TRQ16 SERIES



EDP No.	Size/dimensions
TRQ16206GS	M3X0.5 7GX 56.0L
TRQ16226GS	M3.5X0.6 7GX 56.0L
TRQ16246GS	M4X0.7 7GX 63.0L
TRQ16286GS	M5X0.8 7GX 70.0L
TRQ16316GS	M6X1.0 7GX 80.0L
TRQ16346GS	M7X1.0 7GX 80.0L
TRQ16366GS	M8X1.25 7GX 90.0L
TRQ16396GS	M9X1.25 7GX 90.0L
TRQ16426GS	M10X1.5 7GX 100.0L
TRQ16506GS	M12X1.75 7GX 110.0L
TRQ16546GS	M14X2.0 7GX 110.0L
TRQ16606GS	M16X2.0 7GX 110.0L

► DIN371(M3~M10) and DIN376(M12~M16)

◎ : Excellent ○ : Good

ISO	P										M				K						
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron		
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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			
Material Description	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											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550
Recommended	◎	◎	◎	◎	◎	◎	◎	◎													



New Product Announcement

Prime Tap X-Coating Forming

EDP No. List

HSS-PM PRIME TAP FORMING G(BSP) PIPE THREADS

TRQ17 SERIES



EDP No.	Size/dimensions
TRQ17020GS	G1/16-28 90.0L
TRQ17200GS	G1/8-28 90.0L
TRQ17400GS	G1/4-19 100.0L
TRQ17480GS	G3/8-19 100.0L
TRQ17560GS	G1/2-14 125.0L
TRQ17700GS	G3/4-14 140.0L
TRQ17780GS	G1"-11 160.0L

◎ : Excellent ○ : Good

ISO	P										M				K						
Material Description	Non-alloy steel					Low alloy steel				High alloyed 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	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				
Material Description	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											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550
Recommended	◎	◎	◎	◎	◎	◎	◎	◎													



New Product Announcement

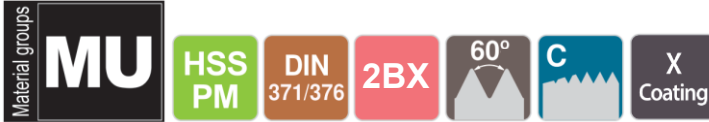
Prime Tap X-Coating Forming

EDP No. List

HSS-PM PRIME TAP FORMING UNC

TRQ18

SERIES



EDP No.	Size/dimensions
TRQ18162GS	#4-40UNC 2BX 56.0L
TRQ18202GS	#5-40UNC 2BX 56.0L
TRQ18242GS	#6-32UNC 2BX 56.0L
TRQ18282GS	#8-32UNC 2BX 63.0L
TRQ18322GS	#10-24UNC 2BX 70.0L
TRQ18362GS	#12-24UNC 2BX 80.0L
TRQ18402GS	1/4-20UNC 2BX 80.0L
TRQ18442GS	5/16-18UNC 2BX 90.0L
TRQ18482GS	3/8-16UNC 2BX 100.0L
TRQ18522GS	7/16-14UNC 2BX 100.0L
TRQ18562GS	1/2-13UNC 2BX 110.0L
TRQ18602GS	9/16-12UNC 2BX 110.0L
TRQ18642GS	5/8-11UNC 2BX 110.0L
TRQ18702GS	3/4-10UNC 2BX 125.0L
TRQ18742GS	7/8-9UNC 2BX 140.0L
TRQ18782GS	1"-8UNC 2BX 160.0L

► DIN371(#4~3/8) and DIN376(7/16~1")

◎ : Excellent ○ : Good

ISO	P										M				K						
Material Description	Non-alloy steel					Low alloy steel				High alloyed 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	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			
Material Description	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											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550
Recommended	◎	◎	◎	◎	◎	◎	◎	◎													



New Product Announcement

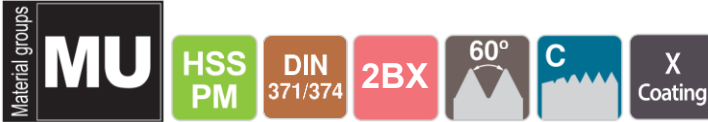
Prime Tap X-Coating Forming

EDP No. List

HSS-PM PRIME TAP FORMING

UNF

TRQ19 SERIES



EDP No.	Size/dimensions
TRQ19182GS	#4-48UNF 2BX 56.0L
TRQ19222GS	#5-44UNF 2BX 56.0L
TRQ19262GS	#6-40UNF 2BX 56.0L
TRQ19302GS	#8-36UNF 2BX 63.0L
TRQ19342GS	#10-32UNF 2BX 70.0L
TRQ19382GS	#12-28UNF 2BX 80.0L
TRQ19422GS	1/4-28UNF 2BX 80.0L
TRQ19462GS	5/16-24UNF 2BX 90.0L
TRQ19502GS	3/8-24UNF 2BX 100.0L
TRQ19542GS	7/16-20UNF 2BX 100.0L
TRQ19582GS	1/2-20UNF 2BX 100.0L
TRQ19622GS	9/16-18UNF 2BX 100.0L
TRQ19662GS	5/8-18UNF 2BX 100.0L
TRQ19722GS	3/4-16UNF 2BX 110.0L
TRQ19762GS	7/8-14UNF 2BX 125.0L
TRQ19802GS	1"-12UNF 2BX 140.0L

► DIN371(#4~3/8) and DIN376(7/16~1")

◎ : Excellent ○ : Good

ISO	P										M				K						
Material Description	Non-alloy steel					Low alloy steel				High alloyed 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	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			
Material Description	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											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550
Recommended	◎	◎	◎	◎	◎	◎	◎	◎													



New Product Announcement

Prime Tap X-Coating Forming

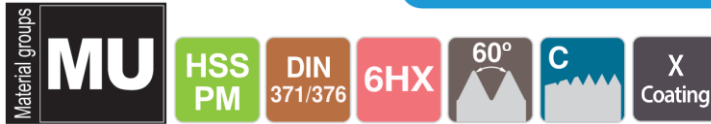
EDP No. List

HSS-PM PRIME TAP FORMING

METRIC COARSE

with Internal Coolant

TRQ20 SERIES



EDP No.	Size/dimensions
TRQ20286GSP	M5X0.8 6HX 70.0L
TRQ20316GSP	M6X1.0 6HX 80.0L
TRQ20366GSP	M8X1.25 6HX 90.0L
TRQ20426GSP	M10X1.5 6HX 100.0L
TRQ20506GSP	M12X1.75 6HX 110.0L
TRQ20546GSP	M14X2.0 6HX 110.0L
TRQ20606GSP	M16X2.0 6HX 110.0L
TRQ20656GSP	M18X2.5 6HX 125.0L
TRQ20706GSP	M20X2.5 6HX 140.0L
TRQ20746GSP	M22X2.5 6HX 140.0L
TRQ20786GSP	M24X3.0 6HX 160.0L

► DIN371(M3~M10) and DIN376(M12~M24)

◎ : Excellent ○ : Good

ISO	P										M				K						
Material Description	Non-alloy steel					Low alloy steel				High alloyed 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	12	13	25	28	32	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			
Material Description	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	15	30	25	38	34	40	41	55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550
Recommended	◎	◎	◎	◎	◎	◎	◎	◎													



New Product Announcement

Prime Tap X-Coating Forming

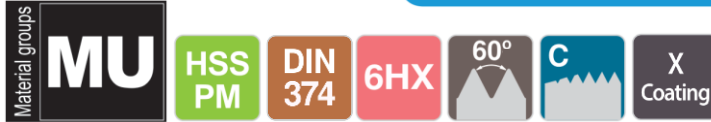
EDP No. List

HSS-PM PRIME TAP FORMING

METRIC FINE

with Internal Coolant

TRQ21 SERIES



EDP No.	Size/dimensions
TRQ21326GSP	M6X0.75 6HX 80.0L
TRQ21336GSP	M6X0.5 6HX 80.0L
TRQ21376GSP	M8X1.0 6HX 90.0L
TRQ21386GSP	M8X0.75 6HX 80.0L
TRQ21436GSP	M10X1.25 6HX 100.0L
TRQ21446GSP	M10X1.0 6HX 90.0L
TRQ21456GSP	M10X0.75 6HX 90.0L
TRQ21516GSP	M12X1.5 6HX 100.0L
TRQ21526GSP	M12X1.25 6HX 100.0L
TRQ21536GSP	M12X1.0 6HX 100.0L
TRQ21556GSP	M14X1.5 6HX 100.0L
TRQ21566GSP	M14X1.25 6HX 100.0L
TRQ21576GSP	M14X1.0 6HX 100.0L
TRQ21616GSP	M16X1.5 6HX 100.0L
TRQ21626GSP	M16X1.0 6HX 100.0L
TRQ21666GSP	M18X2.0 6HX 125.0L
TRQ21676GSP	M18X1.5 6HX 110.0L
TRQ21686GSP	M18X1.0 6HX 110.0L
TRQ21716GSP	M20X2.0 6HX 140.0L
TRQ21726GSP	M20X1.5 6HX 125.0L
TRQ21736GSP	M20X1.0 6HX 125.0L
TRQ21766GSP	M22X1.5 6HX 125.0L
TRQ21806GSP	M24X1.5 6HX 140.0L

◎ : Excellent ○ : Good

ISO	P										M				K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed 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	125	13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25	21	
HB	190	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎						
ISO	N										S						H			
Material Description	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
HRc	60	100	75	90	130	110	90	100			15	30	25	38	34			55	60	42
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400
Recommended	◎	◎	◎	◎	◎	◎	◎	◎												



New Product Announcement

Prime Tap X-Coating Forming

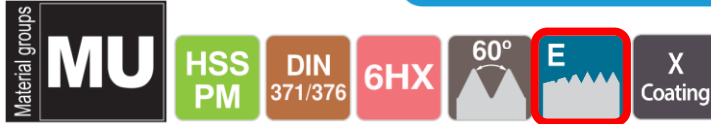
EDP No. List

HSS-PM PRIME TAP FORMING

METRIC COARSE

with Internal Coolant

TRQ22 SERIES



EDP No.	Size/dimensions
TRQ22286GSP	M5X0.8 6HX 70.0L
TRQ22316GSP	M6X1.0 6HX 80.0L
TRQ22366GSP	M8X1.25 6HX 90.0L
TRQ22426GSP	M10X1.5 6HX 100.0L
TRQ22506GSP	M12X1.75 6HX 110.0L
TRQ22546GSP	M14X2.0 6HX 110.0L
TRQ22606GSP	M16X2.0 6HX 110.0L

► DIN371(M5~M10) and DIN376(M12~M16)

◎: Excellent ○: Good

ISO	P										M				K						
Material Description	Non-alloy steel					Low alloy steel				High alloyed 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	23	25	28	32	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			
Material Description	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	60	100	75	90	130	110	90	100			15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550
Recommended	◎	◎	◎	◎	◎	◎	◎	◎													



New Product Announcement

Prime Tap X-Coating Forming

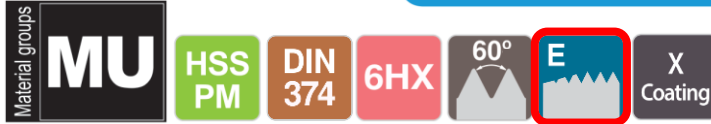
EDP No. List

HSS-PM PRIME TAP FORMING

METRIC FINE

with Internal Coolant

TRQ23 SERIES



EDP No.	Size/dimensions
TRQ23376GSP	M8X1.0 6HX 90.0L
TRQ23386GSP	M8X0.75 6HX 80.0L
TRQ23436GSP	M10X1.25 6HX 100.0L
TRQ23446GSP	M10X1.0 6HX 90.0L
TRQ23516GSP	M12X1.5 6HX 100.0L
TRQ23526GSP	M12X1.25 6HX 100.0L
TRQ23536GSP	M12X1.0 6HX 100.0L
TRQ23556GSP	M14X1.5 6HX 100.0L
TRQ23566GSP	M14X1.25 6HX 100.0L
TRQ23576GSP	M14X1.0 6HX 100.0L
TRQ23616GSP	M16X1.5 6HX 100.0L
TRQ23626GSP	M16X1.0 6HX 100.0L

◎ : Excellent ○ : Good

ISO	P										M				K						
Material Description	Non-alloy steel					Low alloy steel				High alloyed 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	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			
Material Description	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											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550
Recommended	◎	◎	◎	◎	◎	◎	◎	◎													



New Product Announcement

Prime Tap X-Coating Forming

EDP No. List

HSS-PM PRIME TAP FORMING

METRIC COARSE

with Internal Coolant

TRQ24 SERIES



EDP No.	Size/dimensions
TRQ24286GSP	M5X0.8 6GX 70.0L
TRQ24316GSP	M6X1.0 6GX 80.0L
TRQ24366GSP	M8X1.25 6GX 90.0L
TRQ24426GSP	M10X1.5 6GX 100.0L
TRQ24506GSP	M12X1.75 6GX 110.0L
TRQ24546GSP	M14X2.0 6GX 110.0L
TRQ24606GSP	M16X2.0 6GX 110.0L

► DIN371(M5~M10) and DIN376(M12~M16)

◎: Excellent ○: Good

ISO	P										M				K						
Material Description	Non-alloy steel					Low alloy steel				High alloyed 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	12	13	25	28	32	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			
Material Description	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	15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550
Recommended	◎	◎	◎	◎	◎	◎	◎	◎													



New Product Announcement

Prime Tap X-Coating Forming

EDP No. List

HSS-PM PRIME TAP FORMING

METRIC FINE

with Internal Coolant

TRQ25 SERIES



EDP No.	Size/dimensions
TRQ25326GSP	M6X0.75 6GX 80.0L
TRQ25336GSP	M6X0.5 6GX 80.0L
TRQ25376GSP	M8X1.0 6GX 90.0L
TRQ25386GSP	M8X0.75 6GX 80.0L
TRQ25436GSP	M10X1.25 6GX 100.0L
TRQ25446GSP	M10X1.0 6GX 90.0L
TRQ25456GSP	M10X0.75 6GX 90.0L
TRQ25516GSP	M12X1.5 6GX 100.0L
TRQ25526GSP	M12X1.25 6GX 100.0L
TRQ25536GSP	M12X1.0 6GX 100.0L
TRQ25556GSP	M14X1.5 6GX 100.0L
TRQ25566GSP	M14X1.25 6GX 100.0L
TRQ25576GSP	M14X1.0 6GX 100.0L
TRQ25616GSP	M16X1.5 6GX 100.0L
TRQ25626GSP	M16X1.0 6GX 100.0L

◎: Excellent ○: Good																			
ISO	P										M				K				
Material Description	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel				Stainless steel		Grey cast iron		Nodular cast iron
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19
HRc	13	25	28	32	300	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
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎					
ISO	N										S					H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39
HRc	60	100	75	90	130	110	90	100			15	30	25	38	34	400Rm	1050Rm	55	60
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630
Recommended	◎	◎	◎	◎	◎	◎	◎	◎											



New Product Announcement

Prime Tap X-Coating Forming

RECOMMENDED CUTTING CONDITIONS

ISO	VDI 3323	Material Description	HB	HRC	PRIME FORMING TAP			PRIME FORMING TAP with Internal Coolant		
					Recommend	Vc (mm/min.)		Recommend	Vc (mm/min.)	
						Min.	Max.		Min.	Max.
P	1	Non-alloy steel	125		◎	15	40	◎	15	45
P	2		190	13	◎	15	30	◎	15	35
P	3		250	25	◎	15	30	◎	15	35
P	4		270	28	◎	15	30	◎	15	35
P	5		300	32	◎	15	30	◎	15	35
P	6	Low alloy steel	180	10	◎	15	30	◎	15	35
P	7		275	29	◎	15	30	◎	15	35
P	8		300	32	◎	5	20	◎	5	22
P	9		350	38	◎	5	20	◎	5	22
P	10	High alloyed steel, and tool steel	200	15	◎	5	15	◎	5	17
P	11		325	35	◎	5	15	◎	5	17
M	12	Stainless steel	200	15	◎	5	15	◎	5	17
M	13		240	23	◎	5	15	◎	5	17
M	14		180	10	◎	3	9	◎	3	10
K	15	Grey cast iron	180	10						
K	16		260	26						
K	17	Nodular cast iron	160	3						
K	18		250	25						
K	19	Malleable cast iron	130							
K	20		230	21						
N	21	Aluminum-wrought alloy	60		◎	20	50	◎	20	55
N	22		100		◎	20	50	◎	20	55
N	23	Aluminum-cast, alloyed	75		◎	20	40	◎	20	45
N	24		90		◎	20	40	◎	20	45
N	25		130		◎	20	40	◎	20	45
N	26	Copper and Copper Alloys (Bronze / Brass)	110		◎	10	30	◎	10	35
N	27		90		◎	10	30	◎	10	35
N	28		100		◎	10	30	◎	10	35
N	29	Non Metallic Materials								
N	30									
S	31	Heat Resistant Super Alloys	200	15						
S	32		280	30						
S	33		250	25						
S	34		350	38						
S	35		320	34						
S	36	Titanium Alloys	400 Rm							
S	37		1050 Rm							
H	38	Hardened steel	550	55						
H	39		630	60						
H	40	Chilled Cast Iron	400	42						
H	41	Hardened Cast Iron	550	55						