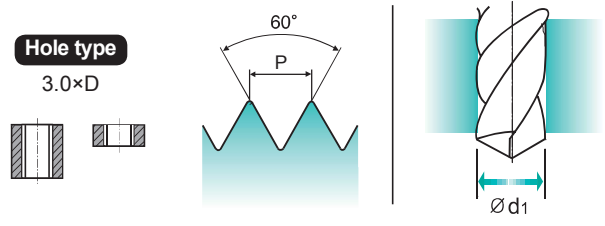
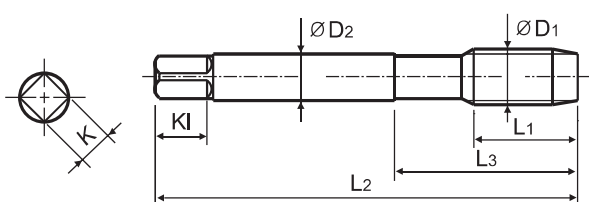


M ISO Metric coarse threads DIN 13

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

► For using multi-purpose and correct thread profiles & long tool life due to special tap geometry. YG-1 company has a patent.

► Für vielfältigen Einsatz, genaue Gewindeprofile und lange Standzeit dank einer besonderen Schneidengeometrie. Von YG-1 patentiert.



Material groups **MU** HSS-E DIN 371/376 6H 60° B Vap Bright TiN

Machine taps
Maschinengewindebohrer

Recommended Cutting Page : P.116

Unit : mm

SIZE	Pitch	EDP No.			Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
		Vap	Bright	TiN								
M2 × 0.4		TB814136	TC814136	TD814136	8	45	13	2.8	2.1	5	3	1.6
M2.2 × 0.45		TB814156	TC814156	TD814156	8	45	13	2.8	2.1	5	3	1.75
M2.3 × 0.4		TB814196	TC814196	TD814196	8	45	13	2.8	2.1	5	3	1.9
M2.5 × 0.45		TB814176	TC814176	TD814176	9	50	15	2.8	2.1	5	3	2.05
M2.6 × 0.45		TB814496	TC814496	TD814496	9	50	15	2.8	2.1	5	3	2.1
M3 × 0.5		TB814206	TC814206	TD814206	11	56	18	3.5	2.7	6	3	2.5
M3.5 × 0.6		TB814226	TC814226	TD814226	12	56	20	4	3	6	3	2.9
M4 × 0.7		TB814246	TC814246	TD814246	13	63	21	4.5	3.4	6	3	3.3
M4.5 × 0.75		TB814266	TC814266	TD814266	14	70	25	6	4.9	8	3	3.7
M5 × 0.8		TB814286	TC814286	TD814286	15	70	25	6	4.9	8	3	4.2
M6 × 1		TB814316	TC814316	TD814316	17	80	30	6	4.9	8	3	5
M7 × 1		TB814346	TC814346	TD814346	17	80	30	7	5.5	8	3	6
M8 × 1.25		TB814366	TC814366	TD814366	20	90	35	8	6.2	9	3	6.8
M9 × 1.25		TB814396	TC814396	TD814396	20	90	35	9	7	10	3	7.8
M10 × 1.5		TB814426	TC814426	TD814426	22	100	39	10	8	11	3	8.5
M11 × 1.5		TB814466	TC814466	TD814466	22	100	40	8	6.2	9	3	9.5
M12 × 1.75		TB814506	TC814506	TD814506	24	110	44	9	7	10	3	10.2
M14 × 2		TB814546	TC814546	TD814546	26	110	44	11	9	12	3	12
M16 × 2		TB814606	TC814606	TD814606	27	110	44	12	9	12	3	14
M18 × 2.5		TB814656	TC814656	TD814656	30	125	50	14	11	14	4	15.5
M20 × 2.5		TB814706	TC814706	TD814706	32	140	54	16	12	15	4	17.5
M22 × 2.5		TB814746	TC814746	TD814746	32	140	54	18	14.5	17	4	19.5
M24 × 3		TB814786	TC814786	TD814786	34	160	60	18	14.5	17	4	21
M27 × 3		TB814866	TC814866	TD814866	36	160	60	20	16	19	4	24
M30 × 3.5		TB814946	TC814946	TD814946	40	180	70	22	18	21	4	26.5

► DIN 371(M2~M10) and DIN 376(M11~M30)
* The other coating(TiCN or TiAlN) is available on your request.

◎ : 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																								
HRC																								
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																					
HRC																					
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550
Recommended			◎			◎	◎	◎													

THREAD
MILLSSYNCHRO
TAPSCOMBO
TAPSYG TAP
GENERALYG TAP
STEELYG TAP
HARDENEDYG TAP
INOXYG TAP
CAST
IRONYG TAP
ALUYG TAP
Ti NiYG TAP
FORMING

NUT TAPS

STI TAPS

PIPE TAPS

TECHNICAL
DATA

ISO	VDI 3323	Material Description	HB	HRc	Vc (m/min)								
					TB744 TB754 TQ744 TQ754	TC814 TC854 TC834 TC874	TD814 TD854 TD834 TD874	TB814 TB854 TB834 TB874	TCJ05 TCJ09 TCJ01 TCJ02	TDJ05 TDJ09 TDJ01 TDJ02	TBJ05	TCJ06	
P	1	Non-alloy steel	125			15-20	20-25	15-20	15-20	20-25	15-20	15-20	
	2		190	13	15-20	15-20	20-25	15-20	15-20	20-25	15-20	15-20	
	3		250	25		12-18	18-24	12-18	12-18	18-24	12-18	12-18	
	4		270	28	10-15	10-15	15-20	10-15	10-15	15-20	10-15	10-15	
	5		300	32		6-10	10-14	6-10	6-10	10-14	6-10	6-10	
	6	Low alloy steel	180	10	10-15	10-15	15-20	10-15	10-15	15-20	10-15	10-15	
	7		275	29	10-15	10-15	15-20	10-15	10-15	15-20	10-15	10-15	
	8		300	32		6-10	10-14	6-10	6-10	10-14	6-10	6-10	
	9		350	38		3-5	5-7	3-5	3-5	5-7	3-5	3-5	
	10		High alloyed steel, and tool steel	200	15		3-5	5-7	3-5	3-5	5-7	3-5	3-5
	11			325	35								
M	12	Stainless steel	200	15	7-10	7-10	10-15	7-10	7-10	10-15	7-10	7-10	
	13		240	23	5-8	5-8	8-11	5-8	5-8	8-11	5-8	5-8	
	14		180	10	4-6	4-6	6-8	4-6	4-6	6-8	4-6	4-6	
K	15	Grey cast iron	180	10		10-15	15-20	10-15	10-15	15-20	10-15	10-15	
	16		260	26		5-8	8-11	5-8	5-8	8-11	5-8	5-8	
	17	Nodular cast iron	160	3		10-15	15-20	10-15	10-15	15-20	10-15	10-15	
	18		250	25		5-8	8-11	5-8	5-8	8-11	5-8	5-8	
	19		130										
20	Malleable cast iron	230	21										
N	21	Aluminum- wrought alloy	60										
	22		100										
	23	Aluminum- cast, alloyed	75			15-20	20-25	15-20	15-20	20-25	15-20	15-20	
	24		90										
	25		130										
	26		110			25-35	35-40	25-35	25-35	35-40	25-35	25-35	
	27		90			8-12	12-17	8-12	8-12	12-17	8-12	8-12	
	28		100			15-20	15-20	20-25	15-20	15-20	20-25	15-20	15-20
	29		Non Metallic Materials										
	30												
S	31	Heat Resistant Super Alloys	200	15									
	32		280	30									
	33		250	25									
	34		350	38									
	35		320	34									
	36		Titanium Alloys	400 Rm									
	37	1050 Rm											
H	38	Hardened steel	550	55									
	39		630	60									
	40	Chilled Cast Iron	400	42									
	41	Hardened Cast Iron	550	55									