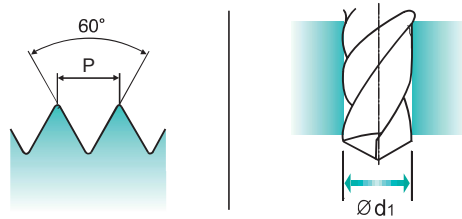
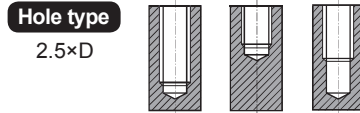
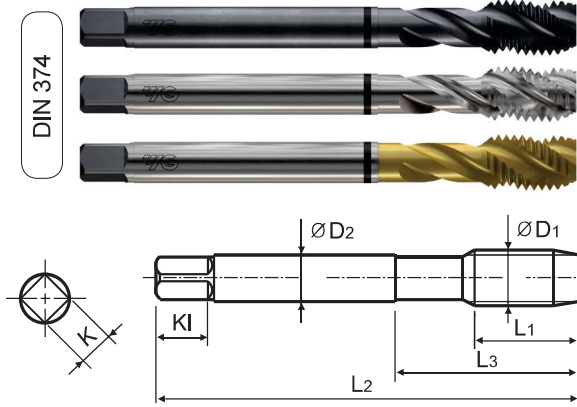


# MF ISO Metric fine threads DIN 13

- Metrisches ISO-Feingewinde DIN 13
- ISO MÉTRIQUE PAS FINS DIN13
- ISO Metrico passo fine 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 374 6H 60° C Vap Bright TiN R40

Machine taps  
Maschinengewindebohrer

Recommended Cutting Page : P.114

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								
M4 × 0.5		TB844256	TC844256	TD844256	5	63	21	2.8	2.1	5	3	3.5
M5 × 0.5		TB844296	TC844296	TD844296	5	70	25	3.5	2.7	6	3	4.5
M6 × 0.75		TB844326	TC844326	TD844326	8	80	30	4.5	3.4	6	3	5.2
M6 × 0.5		TB844336	TC844336	TD844336	5	80	30	4.5	3.4	6	3	5.5
M7 × 0.75		TB844356	TC844356	TD844356	10	80	30	5.5	4.3	7	3	6.2
M8 × 1		TB844376	TC844376	TD844376	10	90	36	6	4.9	8	3	7
M8 × 0.75		TB844386	TC844386	TD844386	8	80	30	6	4.9	8	3	7.2
M10 × 1.25		TB844436	TC844436	TD844436	16	100	40	7	5.5	8	3	8.8
M10 × 1		TB844446	TC844446	TD844446	10	90	36	7	5.5	8	3	9
M10 × 0.75		TB844456	TC844456	TD844456	10	90	36	7	5.5	8	3	9.2
M12 × 1.5		TB844516	TC844516	TD844516	15	100	40	9	7	10	3	10.5
M12 × 1.25		TB844526	TC844526	TD844526	15	100	40	9	7	10	3	10.8
M12 × 1		TB844536	TC844536	TD844536	11	100	40	9	7	10	3	11
M14 × 1.5		TB844556	TC844556	TD844556	15	100	40	11	9	12	3	12.5
M14 × 1.25		TB844566	TC844566	TD844566	15	100	40	11	9	12	3	12.8
M14 × 1		TB844576	TC844576	TD844576	11	100	40	11	9	12	3	13
M16 × 1.5		TB844616	TC844616	TD844616	15	100	40	12	9	12	3	14.5
M16 × 1		TB844626	TC844626	TD844626	12	100	40	12	9	12	3	15
M18 × 1.5		TB844676	TC844676	TD844676	17	110	44	14	11	14	4	16.5
M18 × 1		TB844686	TC844686	TD844686	13	110	44	14	11	14	4	17
M20 × 1.5		TB844726	TC844726	TD844726	17	125	50	16	12	15	4	18.5
M20 × 1		TB844736	TC844736	TD844736	14	125	50	16	12	15	4	19
M22 × 1.5		TB844766	TC844766	TD844766	17	125	50	18	14.5	17	4	20.5
M22 × 1		TB844776	TC844776	TD844776	14	125	50	18	14.5	17	4	21

\* The other coating(TiCN or TiAlN) is available on your request.

► NEXT PAGE

◎ : 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	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230	
Recommended	○	◎	◎	◎	◎	◎	◎	◎	◎	○	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	

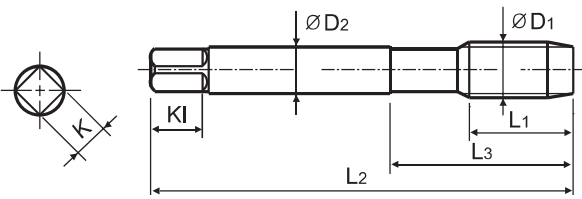
  

ISO	N					S										H					
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron	
Material Description	21	22	23	24	25	26	27	28	29	30	31	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	100	75	90	130	110	90	100			15	30	25	38	34			55	60	42	55
Recommended	◎	◎	◎	◎	◎	◎	◎	◎			◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

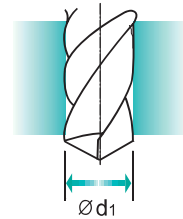
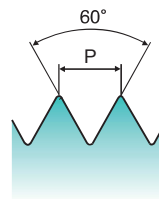
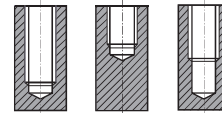
**MF** ISO Metric fine threads DIN 13  
 ● Metrisches ISO-Feingewinde DIN 13  
 ○ ISO MÉTRIQUE PAS FINS DIN13  
 ○ ISO Metrico passo fine DIN 13

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Hole type  
2.5×D



Material groups **MU** HSS-E DIN 374 6H 60° C Vap Bright TiN R40

Machine taps  
Maschinengewindebohrer

Recommended Cutting Page : P.114

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								
ØD1	P				L1	L2	L3	ØD2	K	KI	Z	Ød1
M24 × 2		TB844796	TC844796	TD844796	20	140	54	18	14.5	17	4	22
M24 × 1.5		TB844806	TC844806	TD844806	20	140	54	18	14.5	17	4	22.5
M26 × 1.5		TB844856	TC844856	TD844856	20	140	54	18	14.5	17	4	24.5
M27 × 2		TB844876	TC844876	TD844876	20	140	54	20	16	19	4	25
M27 × 1.5		TB844886	TC844886	TD844886	20	140	54	20	16	19	4	25.5
M28 × 1.5		TB844916	TC844916	TD844916	20	140	54	20	16	19	4	26.5
M30 × 2		TB844966	TC844966	TD844966	22	150	57	22	18	21	4	28
M30 × 1.5		TB844976	TC844976	TD844976	22	150	57	22	18	21	4	28.5

\* 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	TC804	TD804	TB804	TCE05	TDE05	TBE05	TCE06	TDE06
					TC844	TD844	TB844	TCE09	TDE09			
					TC824	TD824	TB824	TCE01	TDE01			
					TC864	TD864	TB864	TCE02	TDE02			
					Vc (m/min)							
P	1	Non-alloy steel	125		15-20	20-25	15-20	15-20	20-25	15-20	15-20	20-25
	2		190	13	15-20	20-25	15-20	15-20	20-25	15-20	15-20	20-25
	3		250	25	12-18	18-24	12-18	12-18	18-24	12-18	12-18	18-24
	4		270	28	10-15	15-20	10-15	10-15	15-20	10-15	10-15	15-20
	5		300	32	6-10	10-14	6-10	6-10	10-14	6-10	6-10	10-14
	6	Low alloy steel	180	10	10-15	15-20	10-15	10-15	15-20	10-15	10-15	15-20
	7		275	29	10-15	15-20	10-15	10-15	15-20	10-15	10-15	15-20
	8		300	32	6-10	10-14	6-10	6-10	10-14	6-10	6-10	10-14
	9		350	38	3-5	5-7	3-5	3-5	5-7	3-5	3-5	5-7
	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	10-15	7-10	7-10	10-15	7-10	7-10	10-15
	13		240	23	5-8	8-11	5-8	5-8	8-11	5-8	5-8	8-11
	14		180	10	4-6	6-8	4-6	4-6	6-8	4-6	4-6	6-8
K	15	Grey cast iron	180	10	10-15	15-20	10-15	10-15	15-20	10-15	10-15	15-20
	16		260	26	5-8	8-11	5-8	5-8	8-11	5-8	5-8	8-11
	17	Nodular cast iron	160	3	10-15	15-20	10-15	10-15	15-20	10-15	10-15	15-20
	18		250	25	5-8	8-11	5-8	5-8	8-11	5-8	5-8	8-11
	19	Malleable cast iron	130									
20	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	20-25
	24		90									
	25		130									
	26		110		25-35	35-40	25-35	25-35	35-40	25-35	25-35	35-40
	27	Copper and Copper Alloys (Bronze / Brass)	90		8-12	12-17	8-12	8-12	12-17	8-12	8-12	12-17
	28		100		15-20	20-25	15-20	15-20	20-25	15-20	15-20	20-25
	29											
	30	Non Metallic Materials										
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								