

### M ISO Metric coarse threads DIN 13

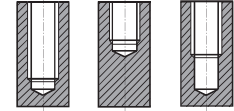
- Metrisches ISO-Gewinde DIN 13
- ISO MÉTRIQUE DIN13
- ISO Metrico passo grosso DIN 13

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

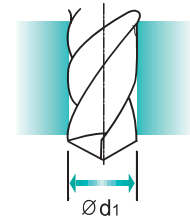
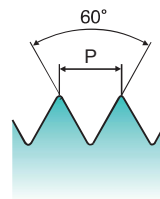
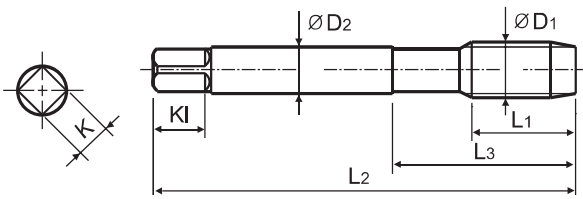
► Für vielfältigen Einsatz, genaue Gewindeprofile und lange Standzeit dank einer besonderen Schneidengeometrie. Von YG-1 patentiert.



Hole type  
2.5×D



Long Shank



HSS-E
LONG
6H
60°
C
Bright
R40

Machine taps  
Maschinengewindebohrer

Recommended Cutting Page : P.115

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	Bright	L1	L2	L3	ØD2	K	KI	Z	Ød1
M3 × 0.5		TC633206	11	100	18	3.5	2.7	6	3	2.5
M4 × 0.7		TC633246	13	125	21	4.5	3.4	6	3	3.3
M5 × 0.8		TC633286	15	140	25	6	4.9	8	3	4.2
M6 × 1		TC633316	17	160	30	6	4.9	8	3	5
M8 × 1.25		TC633366	20	180	35	6	4.9	8	3	6.8
M10 × 1.5		TC633426	22	200	39	7	5.5	8	3	8.5
M12 × 1.75		TC633506	24	220	44	9	7	10	3	10.2
M14 × 2		TC633546	26	220	44	11	9	12	3	12
M16 × 2		TC633606	27	220	44	12	9	12	3	14
M20 × 2.5		TC633706	32	280	54	16	12	15	4	17.5

\* Coating(TiN, TiCN or TiAlN) or Surface Treatment(Steam Homo) is available on your request.

◎ : Excellent ○ : Good

ISO Material Description	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		
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	21	
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	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	60	100	75	90	130	110	90	100			15	30	25	38	34	55	60	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			◎			◎	◎	◎													

	TBE06	TCE07	TDE07	TBE07	TCE08	TDE08	TBE08	TC804-IC	TC633	TC807
VDI 3323	Vc (m/min)									
1	15-20	15-20	20-25	15-20	15-20	20-25	15-20	15-20	15-20	15-20
2	15-20	15-20	20-25	15-20	15-20	20-25	15-20	15-20	15-20	15-20
3	12-18	12-18	18-24	12-18	12-18	18-24	12-18	12-18	12-18	12-18
4	10-15	10-15	15-20	10-15	10-15	15-20	10-15	10-15	10-15	10-15
5	6-10	6-10	10-14	6-10	6-10	10-14	6-10	6-10	6-10	6-10
6	10-15	10-15	15-20	10-15	10-15	15-20	10-15	10-15	10-15	10-15
7	10-15	10-15	15-20	10-15	10-15	15-20	10-15	10-15	10-15	10-15
8	6-10	6-10	10-14	6-10	6-10	10-14	6-10	6-10	6-10	6-10
9	3-5	3-5	5-7	3-5	3-5	5-7	3-5	3-5	3-5	3-5
10	3-5	3-5	5-7	3-5	3-5	5-7	3-5	3-5	3-5	3-5
11										
12	7-10	7-10	10-15	7-10	7-10	10-15	7-10	7-10	7-10	7-10
13	5-8	5-8	8-11	5-8	5-8	8-11	5-8	5-8	5-8	5-8
14	4-6	4-6	6-8	4-6	4-6	6-8	4-6	4-6	4-6	4-6
15	10-15	10-15	15-20	10-15	10-15	15-20	10-15	10-15	10-15	10-15
16	5-8	5-8	8-11	5-8	5-8	8-11	5-8	5-8	5-8	5-8
17	10-15	10-15	15-20	10-15	10-15	15-20	10-15	10-15	10-15	10-15
18	5-8	5-8	8-11	5-8	5-8	8-11	5-8	5-8	5-8	5-8
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27	8-12	8-12	12-17	8-12	8-12	12-17	8-12	8-12	8-12	8-12
28	15-20	15-20	20-25	15-20	15-20	20-25	15-20	15-20	15-20	15-20
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