

M ISO metric coarse threads DIN 13

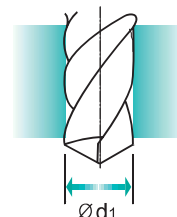
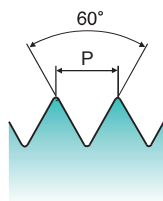
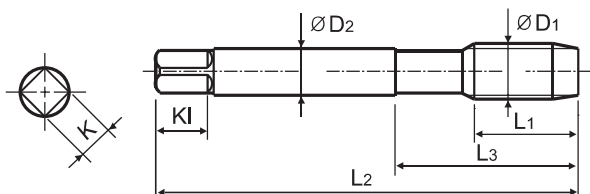
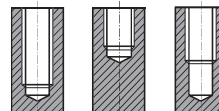
- Metrisches ISO-Gewinde DIN 13
- ISO MÉTRIQUE DIN13
- ISO Metrico passo grosso DIN 13

▶ With recessed threads for machine tapping of deep blind holes.
 ▶ Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

▶ Mit abgesetztem Gewinde zum Schneiden von tiefen Sacklochgewinden.
 ▶ Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.



Hole type
2.5×D



Machine taps
Maschinengewindebohrer

Recommended Cutting Page : P.225

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	Hardslick	L1	L2	L3	ØD2	K	KI	Z	Ød1
M2 × 0.4		TCH14136	8	45	13	2.8	2.1	5	3	1.6
M2.2 × 0.45		TCH14156	8	45	13	2.8	2.1	5	3	1.75
*M2.3 × 0.4		TCH14196	8	45	13	2.8	2.1	5	3	1.9
M2.5 × 0.45		TCH14176	9	50	15	2.8	2.1	5	3	2.05
*M2.6 × 0.45		TCH14496	9	50	15	2.8	2.1	5	3	2.1
M3 × 0.5		TCH14206	6	56	18	3.5	2.7	6	3	2.5
M3.5 × 0.6		TCH14226	7	56	20	4	3	6	3	2.9
M4 × 0.7		TCH14246	7	63	21	4.5	3.4	6	3	3.3
M4.5 × 0.75		TCH14266	8	70	25	6	4.9	8	3	3.7
M5 × 0.8		TCH14286	8	70	25	6	4.9	8	3	4.2
M6 × 1		TCH14316	10	80	30	6	4.9	8	3	5
M7 × 1		TCH14346	10	80	30	7	5.5	8	3	6
M8 × 1.25		TCH14366	13	90	35	8	6.2	9	3	6.8
M9 × 1.25		TCH14396	13	90	35	9	7	10	3	7.8
M10 × 1.5		TCH14426	15	100	39	10	8	11	3	8.5
M11 × 1.5		TCH14466	17	100	40	8	6.2	9	3	9.5
M12 × 1.75		TCH14506	18	110	44	9	7	10	3	10.2
M14 × 2		TCH14546	20	110	44	11	9	12	3	12
M16 × 2		TCH14606	20	110	44	12	9	12	3	14
M18 × 2.5		TCH14656	25	125	50	14	11	14	4	15.5
M20 × 2.5		TCH14706	25	140	54	16	12	15	4	17.5
M22 × 2.5		TCH14746	25	140	54	18	14.5	17	4	19.5
M24 × 3		TCH14786	30	160	60	18	14.5	17	4	21
M27 × 3		TCH14866	30	160	60	20	16	19	4	24
M30 × 3.5		TCH14946	35	180	70	22	18	21	4	26.5

▶ DIN 371(M2~M10) and DIN 376(M11~M30)

▶ * DIN profile not ISO

◎ : 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
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											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											○						○				

ISO	VDI 3323	Material Description	HB	HRc	Vc (m/min)													
					TB711	TQ813	TR813	TB914 TB183 TB904 TB924	TI914	TBE15	TBE16	TBE17	TBE18	TCH14	TQ853	TR853	TB623 TB123 TB264 TB274	TCH23
P	1	Non-alloy steel	125		15-20	15-20	15-20	15-20	20-25	15-20	15-20	15-20	15-20	20-25	15-20	15-20	15-20	20-25
	2		190	13	15-20	15-20	15-20	15-20	20-25	15-20	15-20	15-20	15-20	20-25	15-20	15-20	15-20	20-25
	3		250	25		12-18	12-18	12-18	18-24	12-18	12-18	12-18	12-18	18-24	12-18	12-18	12-18	18-24
	4		270	28		10-15	10-15	10-15	15-20	10-15	10-15	10-15	10-15	15-20	10-15	10-15	10-15	15-20
	5		300	32														
	6	Low alloy steel	180	10		10-15	10-15	10-15	15-20	10-15	10-15	10-15	10-15	15-20	10-15	10-15	10-15	15-20
	7		275	29														
	8		300	32														
	9		350	38														
	10	High alloyed steel, and tool steel	200	15														
	11		325	35														
M	12	Stainless steel	200	15	7-10	7-10	7-10	7-10	10-13	7-10	7-10	7-10	7-10	10-13	7-10	7-10	7-10	10-13
	13		240	23	5-8	5-8	5-8	5-8	8-11	5-8	5-8	5-8	5-8	8-11	5-8	5-8	5-8	8-11
	14		180	10	4-6	4-6	4-6	4-6	6-8	4-6	4-6	4-6	4-6	6-8	4-6	4-6	4-6	6-8
K	15	Grey cast iron	180	10														
	16		260	26														
	17	Nodular cast iron	160	3														
	18		250	25														
	19	Malleable cast iron	130															
20	230		21															
N	21	Aluminum-wrought alloy	60		10-15													
	22		100															
	23	Aluminum-cast, alloyed	75															
	24		90															
	25		130															
	26		110															
	27	Copper and Copper Alloys (Bronze / Brass)	90															
	28		100		15-20													
	29	Non Metallic Materials																
	30																	
S	31	Heat Resistant Super Alloys	200	15		10-15	10-15	10-15	15-20	10-15	10-15	10-15	10-15	15-20	10-15	10-15	10-15	15-20
	32		280	30														
	33		250	25														
	34		350	38														
	35		320	34														
	36	Titanium Alloys	400Rm			10-15	10-15	10-15	15-20	10-15	10-15	10-15	10-15	15-20	10-15	10-15	10-15	15-20
	37		1050Rm															
H	38	Hardened steel	550	55														
	39		630	60														
	40	Chilled Cast Iron	400	42														
	41	Hardened Cast Iron	550	55														