

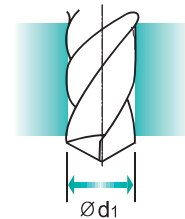
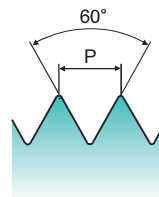
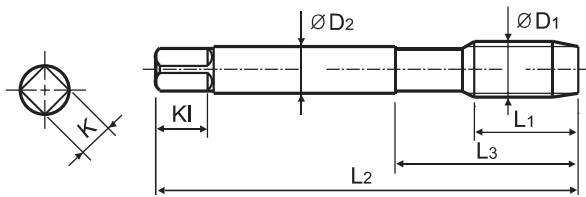
M ISO metric coarse threads DIN 13



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

► Suitable for through hole in more cutting speed than other taps due to thick web.

► Geeignet für Durchgangslöcher in höherer Schnittgeschwindigkeit als bei anderen Gewindebohrern dank größerer Kerndicke.



Material groups: **HR** HSS-E DIN 371/376 6H 60° B TiAlN

Machine taps
Maschinengewindebohrer

Recommended Cutting Page : P.201

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	TiAlN	L1	L2	L3	ØD2	K	KI	Z	Ød1
M2 × 0.4		TY283136	8	45	13	2.8	2.1	5	3	1.6
M2.2 × 0.45		TY283156	8	45	13	2.8	2.1	5	3	1.75
*M2.3 × 0.4		TY283196	8	45	13	2.8	2.1	5	3	1.9
M2.5 × 0.45		TY283176	9	50	15	2.8	2.1	5	3	2.05
*M2.6 × 0.45		TY283496	9	50	15	2.8	2.1	5	3	2.1
M3 × 0.5		TY283206	11	56	18	3.5	2.7	6	3	2.5
M3.5 × 0.6		TY283226	12	56	20	4	3	6	3	2.9
M4 × 0.7		TY283246	13	63	21	4.5	3.4	6	3	3.3
M4.5 × 0.75		TY283266	14	70	25	6	4.9	8	3	3.7
M5 × 0.8		TY283286	15	70	25	6	4.9	8	3	4.2
M6 × 1		TY283316	17	80	30	6	4.9	8	3	5
M7 × 1		TY283346	17	80	30	7	5.5	8	3	6
M8 × 1.25		TY283366	20	90	35	8	6.2	9	3	6.8
M9 × 1.25		TY283396	20	90	35	9	7	10	3	7.8
M10 × 1.5		TY283426	22	100	39	10	8	11	3	8.5
M11 × 1.5		TY283466	22	100	40	8	6.2	9	3	9.5
M12 × 1.75		TY283506	24	110	44	9	7	10	3	10.2
M14 × 2		TY283546	26	110	44	11	9	12	3	12
M16 × 2		TY283606	27	110	44	12	9	12	3	14
M18 × 2.5		TY283656	30	125	50	14	11	14	4	15.5
M20 × 2.5		TY283706	32	140	54	16	12	15	4	17.5
M22 × 2.5		TY283746	32	140	54	18	14.5	17	4	19.5
M24 × 3		TY283786	34	160	60	18	14.5	17	4	21
M27 × 3		TY283866	36	160	60	20	16	19	4	24
M30 × 3.5		TY283946	40	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	T0997-TIC	T0999-TIC	TC313 TB313 TY313	TC283 TY283
					Vc (m/min)			
P	1	Non-alloy steel	125					
	2		190	13				
	3		250	25				
	4		270	28				
	5		300	32				
	6	Low alloy steel	180	10				
	7		275	29			10-15	10-15
	8		300	32			6-10	6-10
	9		350	38	5-8	5-8	3-5	3-5
	10	High alloyed steel, and tool steel	200	15				
	11		325	35				
M	12	Stainless steel	200	15				
	13		240	23				
	14		180	10			4-6	4-6
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					
	22		100					
	23	Aluminum- cast, alloyed	75					
	24		90					
	25		130					
	26		110			25-35	25-35	
	27	Copper and Copper Alloys (Bronze / Brass)	90					
	28		100					
	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	3-7	3-7		
	39		630	60	3-7	3-7		
	40	Chilled Cast Iron	400	42	3-7	3-7		
	41	Hardened Cast Iron	550	55	3-7	3-7		

THREAD
MILLS

SYNCHRO
TAPS

COMBO
TAPS

YG TAP
GENERAL

YG TAP
STEEL

YG TAP
HARDENED

YG TAP
INOX

YG TAP
CAST
IRON

YG TAP
ALU

YG TAP
Ti Ni

YG TAP
FORMING

NUT TAPS

STI TAPS

PIPE TAPS

TECHNICAL
DATA