



ISO Metric coarse threads DIN 13



Metrisches ISO-Gewinde DIN 13

ISO MÉTRIQUE DIN13

ISO Metrico passo grosso DIN 13

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

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

DIN 371

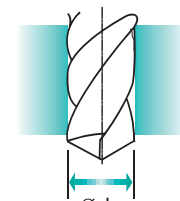
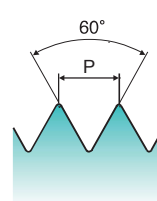
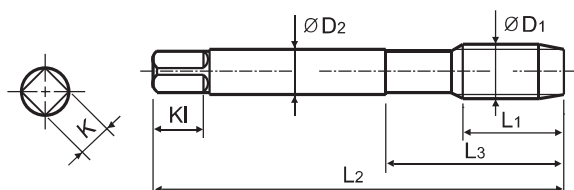
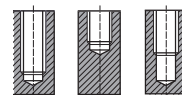


DIN 376



Hole type

2.5×D



up to M12

over M12

HSS-PM

HSS-E

DIN 371/376

6H

60°

C

Vap

R45

Machine taps
Maschinen-
gewindebohrer

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
ØD1	P	Vap	L1	L2	L3	ØD2	K	KI	Z	Ød1
M2 × 0.4		TQ744136	8	45	13	2.8	2.1	5	2	1.6
M2.2 × 0.45		TQ744156	8	45	13	2.8	2.1	5	2	1.75
M2.3 × 0.4		TQ744196	8	45	13	2.8	2.1	5	2	1.9
M2.5 × 0.45		TQ744176	9	50	15	2.8	2.1	5	2	2.05
M2.6 × 0.45		TQ744496	9	50	15	2.8	2.1	5	2	2.1
M3 × 0.5		TQ744206	6	56	18	3.5	2.7	6	3	2.5
M3.5 × 0.6		TQ744226	7	56	20	4	3	6	3	2.9
M4 × 0.7		TQ744246	7	63	21	4.5	3.4	6	3	3.3
M4.5 × 0.75		TQ744266	8	70	25	6	4.9	8	3	3.7
M5 × 0.8		TQ744286	8	70	25	6	4.9	8	3	4.2
M6 × 1		TQ744316	10	80	30	6	4.9	8	3	5
M7 × 1		TQ744346	10	80	30	7	5.5	8	3	6
M8 × 1.25		TQ744366	13	90	35	8	6.2	9	3	6.8
M9 × 1.25		TQ744396	13	90	35	9	7	10	3	7.8
M10 × 1.5		TQ744426	15	100	39	10	8	11	3	8.5
M11 × 1.5		TQ744466	17	100	40	8	6.2	9	3	9.5
M12 × 1.75		TQ744506	18	110	44	9	7	10	3	10.2
M14 × 2		TB744546	20	110	44	11	9	12	3	12
M16 × 2		TB744606	20	110	44	12	9	12	3	14
M18 × 2.5		TB744656	25	125	50	14	11	14	4	15.5
M20 × 2.5		TB744706	25	140	54	16	12	15	4	17.5
M22 × 2.5		TB744746	25	140	54	18	14.5	17	4	19.5
M24 × 3		TB744786	30	160	60	18	14.5	17	4	21
M27 × 3		TB744866	30	160	60	20	16	19	4	24
M30 × 3.5		TB744946	35	180	70	22	18	21	4	26.5

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

► HSS-PM(M2~M12/TQ744) and HSS-E(M14~M30/TB744)

* Coating(TiN, TiCN or TiAlN) is available on your request.

◎ : Excellent ○ : Good

ISO	P										M					K				
Material Description	Non-alloy steel					Low alloy steel					High alloyed steel and tool steel					Stainless steel				
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	32	10	29	32	38	15	35	15	23	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	N										S									
Material Description	Aluminum-wrought alloy					Aluminum-cast, alloyed					Copper and Copper Alloys (Bronze / Brass)					Non Metallic Materials				
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40
HRc	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400
Recommended																				