



MF

ISO Metric fine threads DIN 13

- Metrisches ISO-Feingewinde DIN 13
- ISO MÉTRIQUE PAS FINS 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.

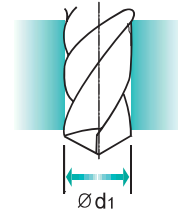
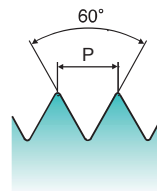
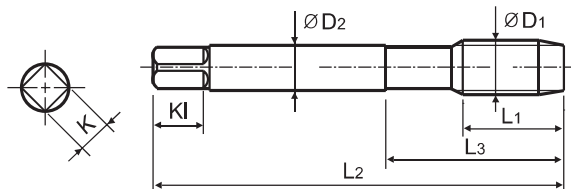
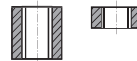
► Für rostfreie stähle, genaue Gewindeprofile und lange Standzeit dank einer besonderen Schneidengeometrie. Von YG-1 patentiert.

DIN 374



Hole type

3.0×D



HSS-E

DIN 374

6H



Vap

Machine taps
Maschinengewindebohrer

Recommended Cutting Page : P.117

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
M14 × 1.5		TB438556	22	100	40	11	9	12	3	12.5
M14 × 1.25		TB438566	22	100	40	11	9	12	3	12.8
M14 × 1.0		TB438576	22	100	40	11	9	12	3	13
M16 × 1.5		TB438616	22	100	40	12	9	12	3	14.5
M16 × 1		TB438626	18	100	40	12	9	12	3	15
M18 × 1.5		TB438676	25	110	44	14	11	14	4	16.5
M18 × 1		TB438686	20	110	44	14	11	14	4	17
M20 × 1.5		TB438726	25	125	50	16	12	15	4	18.5
M20 × 1		TB438736	20	125	50	16	12	15	4	19
M22 × 1.5		TB438766	25	125	50	18	14.5	17	4	20.5
M22 × 1		TB438776	20	125	50	18	14.5	17	4	21
M24 × 2		TB438796	27	140	54	18	14.5	17	4	22
M24 × 1.5		TB438806	27	140	54	18	14.5	17	4	22.5
M26 × 1.5		TB438856	28	140	54	18	14.5	17	4	24.5
M27 × 2		TB438876	28	140	54	20	16	19	4	25
M27 × 1.5		TB438886	28	140	54	20	16	19	4	25.5
M28 × 1.5		TB438916	28	140	54	20	16	19	4	26.5
M30 × 2		TB438966	30	150	57	22	18	21	4	28
M30 × 1.5		TB438976	30	150	57	22	18	21	4	28.5

* 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				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					
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						
Material Description	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								○															