



M

ISO Metric coarse threads DIN 13

Metrisches ISO-Gewinde DIN 13

ISO MÉTRIQUE DIN13

ISO Metrico passo grosso DIN 13

Machine taps  
Maschinengewindebohrer

► 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 Standzeitendank einer besonderen Schneidengeometrie. Von YG-1 patentiert.

DIN 371

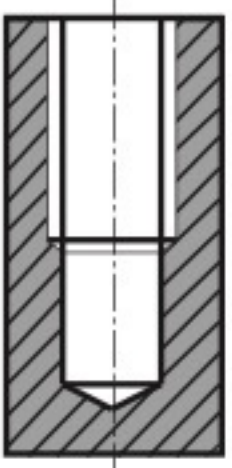
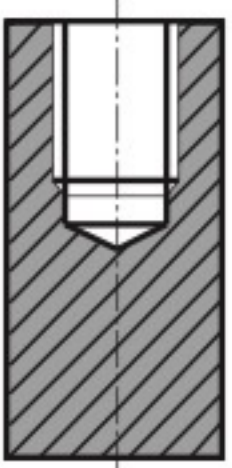
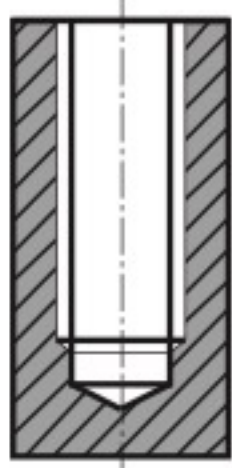


DIN 376

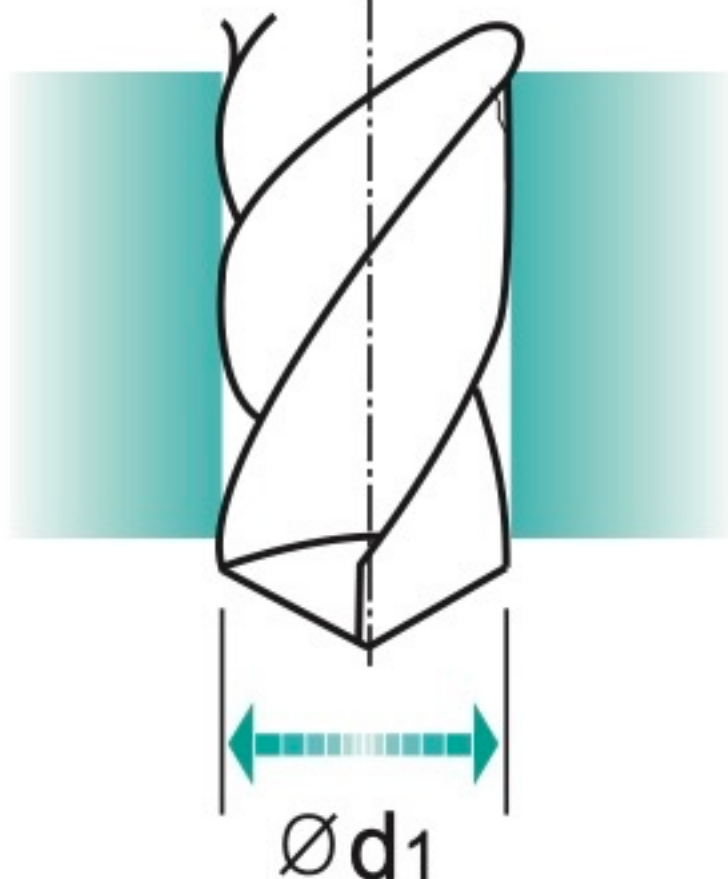
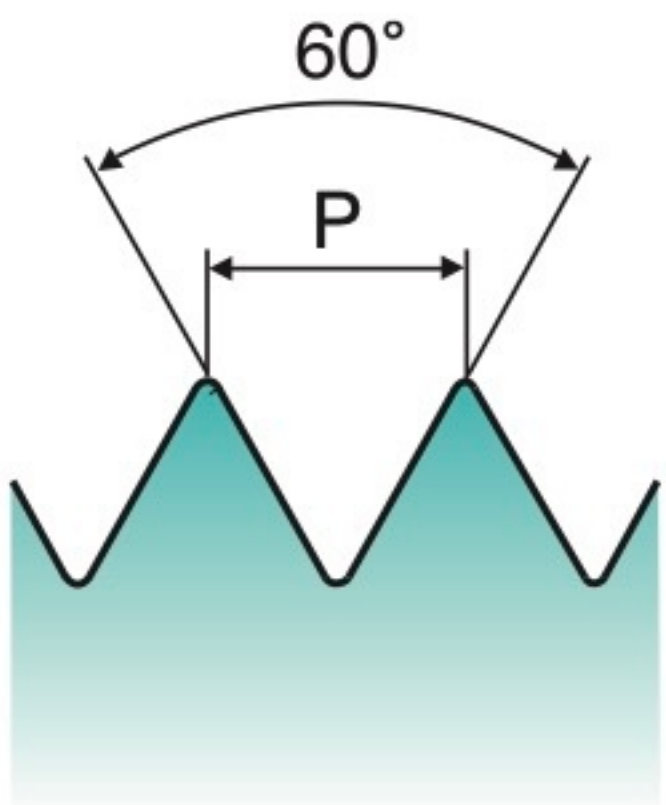
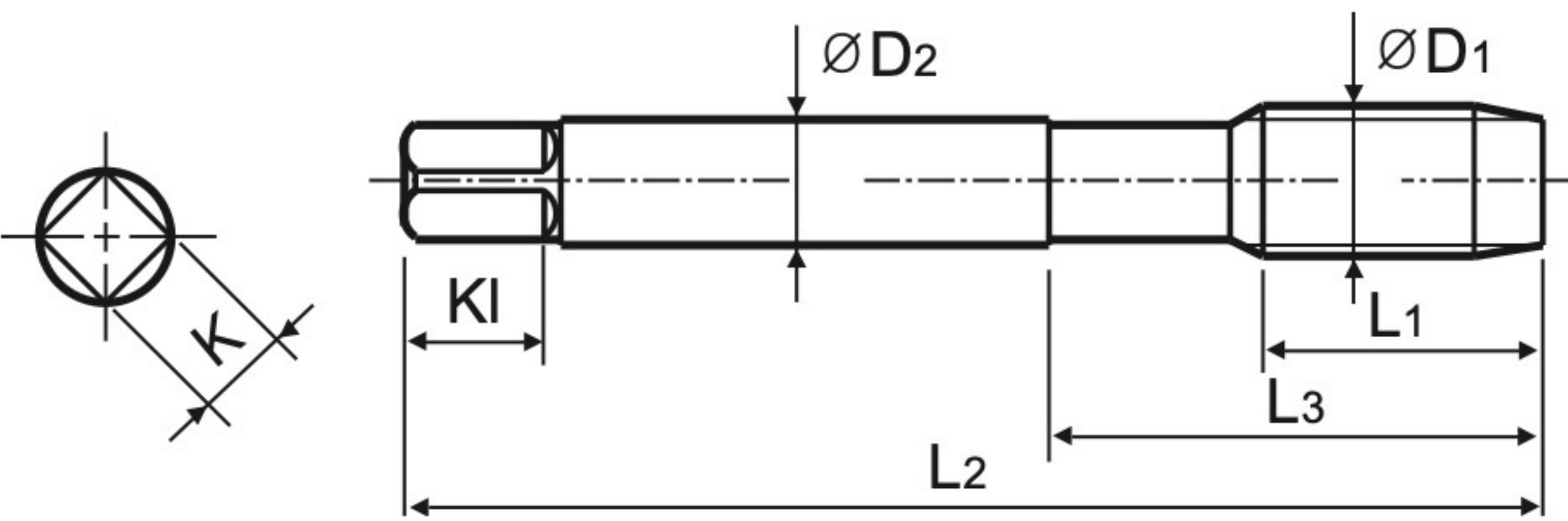


Hole type

2.5×D



Short Chamfer



Material groups

MU

HSS-E

DIN 371/376

6H

60°

E

R40

Bright



p.B130

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                    |
| M2   | × 0.4  | TC807136 | 8             | 45             | 13          | 2.8            | 2.1         | 5             | 3            | 1.6                    |
| M2.2 | × 0.45 | TC807156 | 8             | 45             | 13          | 2.8            | 2.1         | 5             | 3            | 1.75                   |
| M2.3 | × 0.4  | TC807196 | 8             | 45             | 13          | 2.8            | 2.1         | 5             | 3            | 1.9                    |
| M2.5 | × 0.45 | TC807176 | 9             | 50             | 15          | 2.8            | 2.1         | 5             | 3            | 2.05                   |
| M2.6 | × 0.45 | TC807496 | 9             | 50             | 15          | 2.8            | 2.1         | 5             | 3            | 2.1                    |
| M3   | × 0.5  | TC807206 | 6             | 56             | 18          | 3.5            | 2.7         | 6             | 3            | 2.5                    |
| M3.5 | × 0.6  | TC807226 | 7             | 56             | 20          | 4              | 3           | 6             | 3            | 2.9                    |
| M4   | × 0.7  | TC807246 | 7             | 63             | 21          | 4.5            | 3.4         | 6             | 3            | 3.3                    |
| M4.5 | × 0.75 | TC807266 | 8             | 70             | 25          | 6              | 4.9         | 8             | 3            | 3.7                    |
| M5   | × 0.8  | TC807286 | 8             | 70             | 25          | 6              | 4.9         | 8             | 3            | 4.2                    |
| M6   | × 1.0  | TC807316 | 10            | 80             | 30          | 6              | 4.9         | 8             | 3            | 5                      |
| M7   | × 1.0  | TC807346 | 10            | 80             | 30          | 7              | 5.5         | 8             | 3            | 6                      |
| M8   | × 1.25 | TC807366 | 13            | 90             | 35          | 8              | 6.2         | 9             | 3            | 6.8                    |
| M9   | × 1.25 | TC807396 | 13            | 90             | 35          | 9              | 7           | 10            | 3            | 7.8                    |
| M10  | × 1.5  | TC807426 | 15            | 100            | 39          | 10             | 8           | 11            | 3            | 8.5                    |
| M11  | × 1.5  | TC807466 | 17            | 100            | 40          | 8              | 6.2         | 9             | 3            | 9.5                    |
| M12  | × 1.75 | TC807506 | 18            | 110            | 44          | 9              | 7           | 10            | 3            | 10.2                   |
| M14  | × 2.0  | TC807546 | 20            | 110            | 44          | 11             | 9           | 12            | 3            | 12                     |
| M16  | × 2.0  | TC807606 | 20            | 110            | 44          | 12             | 9           | 12            | 3            | 14                     |
| M18  | × 2.5  | TC807656 | 25            | 125            | 50          | 14             | 11          | 14            | 4            | 15.5                   |
| M20  | × 2.5  | TC807706 | 25            | 140            | 54          | 16             | 12          | 15            | 4            | 17.5                   |
| M22  | × 2.5  | TC807746 | 25            | 140            | 54          | 18             | 14.5        | 17            | 4            | 19.5                   |
| M24  | × 3.0  | TC807786 | 30            | 160            | 60          | 18             | 14.5        | 17            | 4            | 21                     |
| M27  | × 3.0  | TC807866 | 30            | 160            | 60          | 20             | 16          | 19            | 4            | 24                     |
| M30  | × 3.5  | TC807946 | 35            | 180            | 70          | 22             | 18          | 21            | 4            | 26.5                   |

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

► Coating(TiN, TiCN or TiAlN) or Surface Treatment(Steam Homo) 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             |                     | 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                                  |                 |     |     |                |                 |                   | 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                 |
| HRc                  |                        |     |                        |     |     |                                           |     |     |     |                        | 15                                 | 30              | 25  | 38  | 34             |                 |                   | 55             | 60                  | 42                 |
| HB                   | 60                     | 100 | 75                     | 90  | 130 | 110                                       | 90  | 100 |     |                        | 200                                | 280             | 250 | 350 | 320            | 400Rm           | 1050Rm            | 550            | 630                 | 400                |
| Recommended          |                        |     | ◎                      |     |     | ◎                                         | ◎   | ◎   |     |                        |                                    |                 |     |     |                |                 |                   |                |                     |                    |