



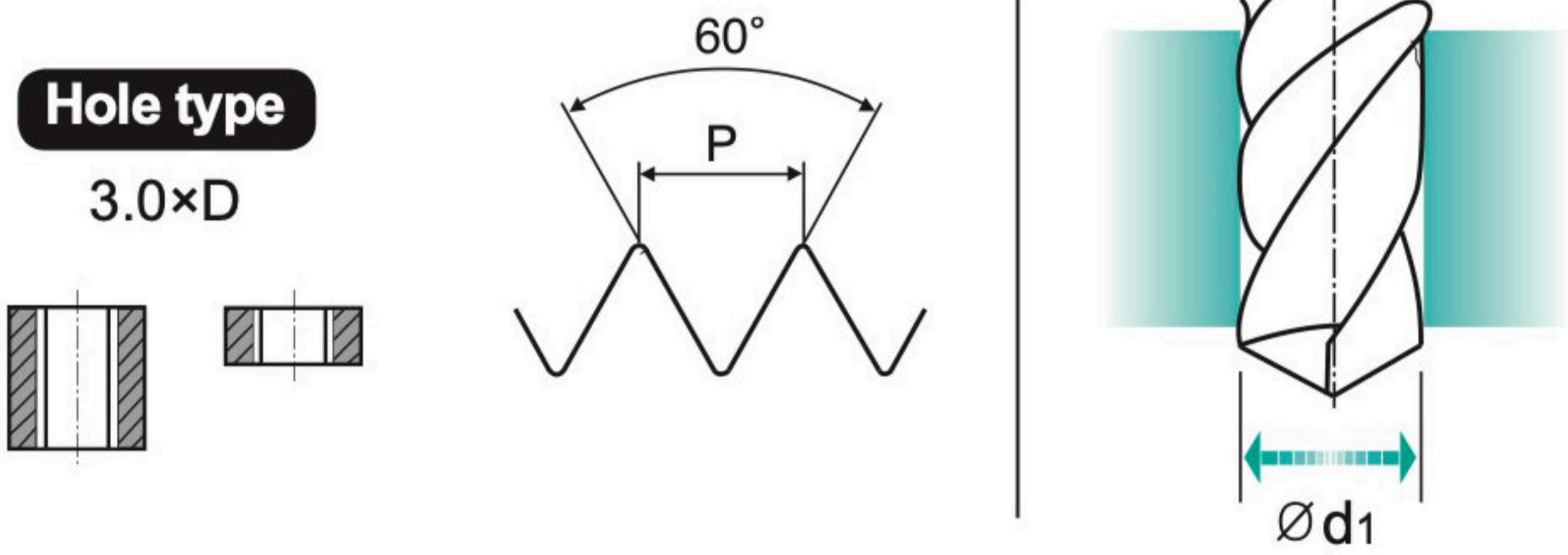
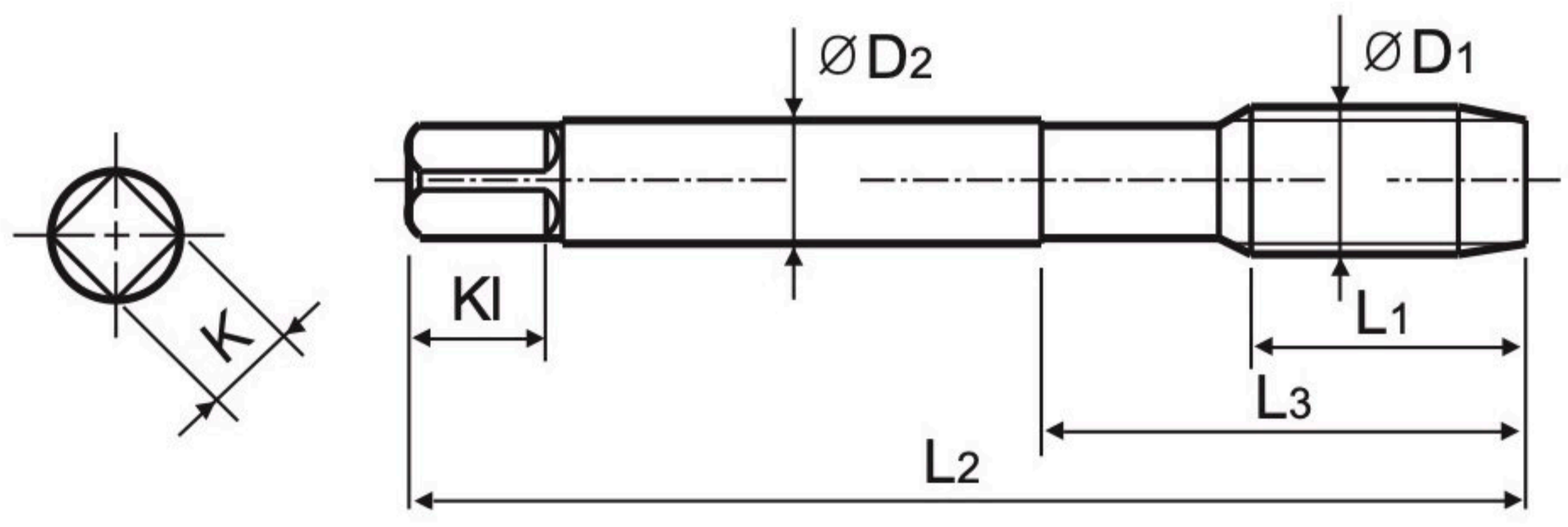
# M ISO Metric coarse threads DIN 13

- 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 Standzeit dank einer besonderen Schneidengeometrie. Von YG-1 patentiert.



Material groups  
**MU**

**HSS-E** **DIN 371/376** **6H** **60°** **B** **Vap Bright TiN** p.B131

Recommended ToolHolder  
 Plain Shank  
 TAPPING ER CHUCK  
 TAPPING CHUCK  
 ONE STEP TAPPING CHUCK

Unit : mm

SIZE	Pitch	EDP No.			Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
		Vap	Bright	TiN								
ØD1	P				L1	L2	L3	ØD2	K	KI	Z	Ød1
M24 × 3.0		<b>TB814786</b>	<b>TC814786</b>	<b>TD814786</b>	34	160	60	18	14.5	17	4	21
M27 × 3.0		<b>TB814866</b>	<b>TC814866</b>	<b>TD814866</b>	36	160	60	20	16	19	4	24
M30 × 3.5		<b>TB814946</b>	<b>TC814946</b>	<b>TD814946</b>	40	180	70	22	18	21	4	26.5
M33 × 3.5		-	<b>TC814A46</b>	<b>TD814A46</b>	40	180	70	25	20	23	4	29.5
M36 × 4.0		-	<b>TC814B36</b>	<b>TD814B36</b>	50	200	80	28	22	25	4	32.0
M39 × 4.0		-	<b>TC814C06</b>	<b>TD814C06</b>	50	200	80	32	24	27	4	35.0
M42 × 4.5		-	<b>TC814C86</b>	<b>TD814C86</b>	56	200	85	32	24	27	4	37.5
M45 × 4.5		-	<b>TC814D56</b>	<b>TD814D56</b>	58	220	85	36	29	32	4	40.5
M48 × 5.0		-	<b>TC814E26</b>	<b>TD814E26</b>	65	250	90	36	29	32	4	43.0
M52 × 5.0		-	<b>TC814F36</b>	<b>TD814F36</b>	65	250	90	40	32	35	4	47.0

- DIN 371(M2~M10) and DIN 376(M11~M52)
- The other coating(TiCN or TiAlN) is available on your request.

◎ : Excellent ○ : Good

ISO	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	
Material Description	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
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				
	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	
Material Description	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
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			◎			◎	◎	◎													