# YG TAP INOX

**TB123** SERIES

# MF ISO metric fine threads DIN 13

Metrisches ISO-Feingewinde DIN 13
ISO MÉTRIQUE PAS FINS DIN13
ISO Metrico passo fine DIN 13

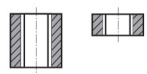
Machine taps
Maschinengewindebohrer

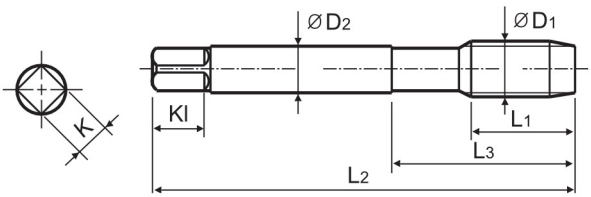
▶ Suitable for through hole in more cutting speed than other taps due to thick web.

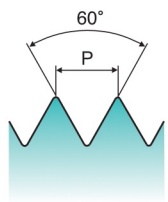
▶ Geeignet für Durchgangslöcher in höherer Schnittgeschwindigkeit als bei anderen Gewindebohrern dank größerer Kerndicke.

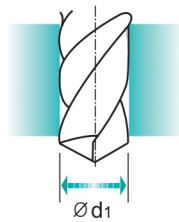
DIN 374

**Hole type**
3.0×D






Material groups VA NW | HSS-E | DIN 374 | 6HX | 60° | B | Vap

p.B193

Recommended ToolHolder: PlainShank — TAPPINGERCHUCK, TAPPINGCHUCK, ONESTEPTAPPINGCHUCK

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 | Kl | Z | Ød1 |
| M4 | × 0.5 | **TB123256** | 10 | 63 | 21 | 2.8 | 2.1 | 5 | 3 | 3.5 |
| M5 | × 0.5 | **TB123296** | 11 | 70 | 25 | 3.5 | 2.7 | 6 | 3 | 4.5 |
| M6 | × 0.75 | **TB123326** | 13 | 80 | 30 | 4.5 | 3.4 | 6 | 3 | 5.2 |
| M6 | × 0.5 | **TB123336** | 13 | 80 | 30 | 4.5 | 3.4 | 6 | 3 | 5.5 |
| M7 | × 0.75 | **TB123356** | 14 | 80 | 30 | 5.5 | 4.3 | 7 | 3 | 6.2 |
| M8 | × 1.0 | **TB123376** | 17 | 90 | 36 | 6 | 4.9 | 8 | 3 | 7 |
| M8 | × 0.75 | **TB123386** | 14 | 80 | 30 | 6 | 4.9 | 8 | 3 | 7.2 |
| M10 | × 1.25 | **TB123436** | 22 | 100 | 40 | 7 | 5.5 | 8 | 3 | 8.8 |
| M10 | × 1.0 | **TB123446** | 18 | 90 | 36 | 7 | 5.5 | 8 | 3 | 9 |
| M10 | × 0.75 | **TB123456** | 18 | 90 | 36 | 7 | 5.5 | 8 | 3 | 9.2 |
| M12 | × 1.5 | **TB123516** | 22 | 100 | 40 | 9 | 7 | 10 | 4 | 10.5 |
| M12 | × 1.25 | **TB123526** | 22 | 100 | 40 | 9 | 7 | 10 | 3 | 10.8 |
| M12 | × 1.0 | **TB123536** | 18 | 100 | 40 | 9 | 7 | 10 | 3 | 11 |
| M14 | × 1.5 | **TB123556** | 22 | 100 | 40 | 11 | 9 | 12 | 3 | 12.5 |
| M14 | × 1.25 | **TB123566** | 22 | 100 | 40 | 11 | 9 | 12 | 3 | 12.8 |
| M16 | × 1.5 | **TB123616** | 22 | 100 | 40 | 12 | 9 | 12 | 3 | 14.5 |
| M18 | × 1.5 | **TB123676** | 25 | 110 | 44 | 14 | 11 | 14 | 4 | 16.5 |
| M20 | × 1.5 | **TB123726** | 25 | 125 | 50 | 16 | 12 | 15 | 4 | 18.5 |
| M22 | × 1.5 | **TB123766** | 25 | 125 | 50 | 18 | 14.5 | 17 | 4 | 20.5 |
| M24 | × 1.5 | **TB123806** | 27 | 140 | 54 | 18 | 14.5 | 17 | 4 | 22.5 |

◎ : 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 | 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 | | | | | | | | | | | ○ | | | | | ○ | | | | | |