

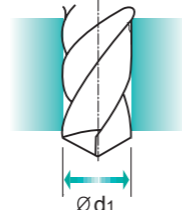
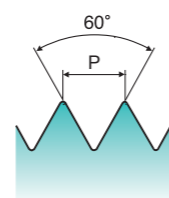
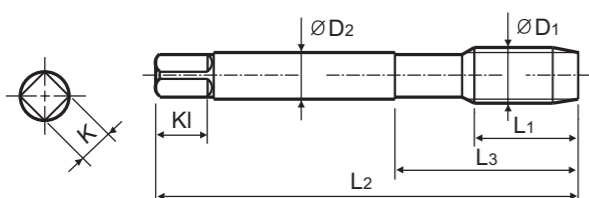
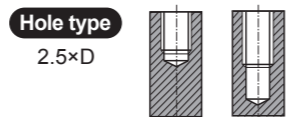
M ISO metric coarse threads DIN 13

- Metrisches ISO-Gewinde DIN 13
- ISO MÉTRIQUE DIN13
- ISO Metrico passo grosso DIN 13

Machine taps
Maschinengewindebohrer

► Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

► Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.



Material groups: **Ti**, HSS PM, DIN 371/376, 6H, 60°, C, R25, Bright, p.B276

Recommended ToolHolder: Plain Shank TAPPING ER CHUCK D215-220, TAPPING CHUCK D221-228, ONE STEP TAPPING CHUCK D211-213

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	TM903136	8	45	13	2.8	2.1	5	3	1.6
M2.2	× 0.45	TM903156	8	45	13	2.8	2.1	5	3	1.75
*M2.3	× 0.4	TM903196	8	45	13	2.8	2.1	5	3	1.9
M2.5	× 0.45	TM903176	9	50	15	2.8	2.1	5	3	2.05
*M2.6	× 0.45	TM903496	9	50	15	2.8	2.1	5	3	2.1
M3	× 0.5	TM903206	6	56	18	3.5	2.7	6	3	2.5
M3.5	× 0.6	TM903226	7	56	20	4	3	6	3	2.9
M4	× 0.7	TM903246	7	63	21	4.5	3.4	6	3	3.3
M4.5	× 0.75	TM903266	8	70	25	6	4.9	8	3	3.7
M5	× 0.8	TM903286	8	70	25	6	4.9	8	3	4.2
M6	× 1	TM903316	10	80	30	6	4.9	8	3	5
M7	× 1	TM903346	10	80	30	7	5.5	8	3	6
M8	× 1.25	TM903366	13	90	35	8	6.2	9	3	6.8
M9	× 1.25	TM903396	13	90	35	9	7	10	3	7.8
M10	× 1.5	TM903426	15	100	39	10	8	11	3	8.5
M11	× 1.5	TM903466	17	100	40	8	6.2	9	3	9.5
M12	× 1.75	TM903506	18	110	44	9	7	10	3	10.2
M14	× 2	TM903546	20	110	44	11	9	12	3	12
M16	× 2	TM903606	20	110	44	12	9	12	3	14
M18	× 2.5	TM903656	25	125	50	14	11	14	4	15.5
M20	× 2.5	TM903706	25	140	54	16	12	15	4	17.5
M22	× 2.5	TM903746	25	140	54	18	14.5	17	4	19.5
M24	× 3	TM903786	30	160	60	18	14.5	17	4	21
M27	× 3	TM903866	30	160	60	20	16	19	4	24
M30	× 3.5	TM903946	35	180	70	22	18	21	4	26.5

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

► * DIN profile not ISO

◎ : Excellent ○ : Good

ISO Material Description	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	
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	30	10	29	32	38	15	35	15	23	10	10	26	3	25	21	21		
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230		
Recommended							○	○	○													

ISO Material Description	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
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											○						◎						

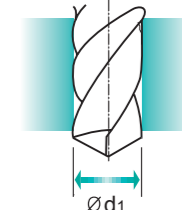
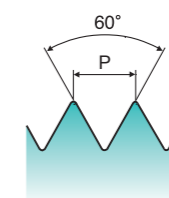
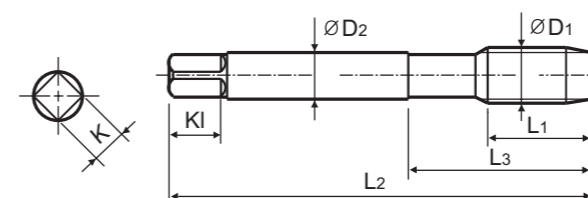
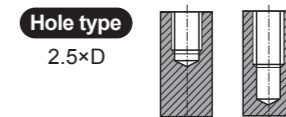
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