

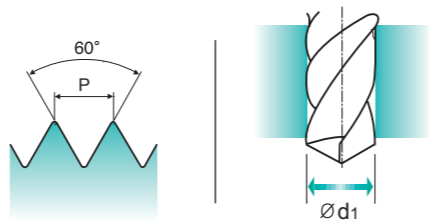
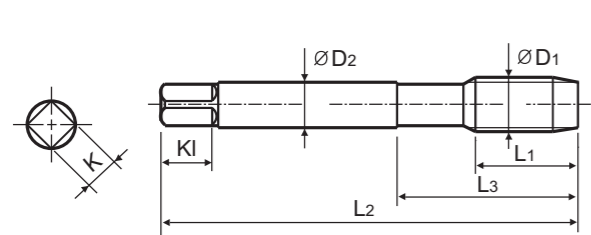
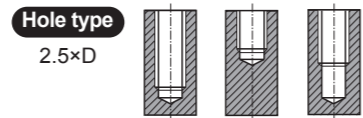
M ISO metric coarse threads DIN 13

- 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: **VG** HSS-E DIN 371/376 6H 60° C R40 Bright p.B197

Recommended ToolHolder: Plain Shank TAPPING ER CHUCK D215-228 ONE STEP TAPPING CHUCK D221-228

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	K1	Z	Ød1
M2	× 0.4	TC312136	8	45	13	2.8	2.1	5	3	1.6
M2.2	× 0.45	TC312156	8	45	13	2.8	2.1	5	3	1.75
*M2.3	× 0.4	TC312196	8	45	13	2.8	2.1	5	3	1.9
M2.5	× 0.45	TC312176	9	50	15	2.8	2.1	5	3	2.05
*M2.6	× 0.45	TC312496	9	50	15	2.8	2.1	5	3	2.1
M3	× 0.5	TC312206	6	56	18	3.5	2.7	6	3	2.5
M3.5	× 0.6	TC312226	7	56	20	4	3	6	3	2.9
M4	× 0.7	TC312246	7	63	21	4.5	3.4	6	3	3.3
M4.5	× 0.75	TC312266	8	70	25	6	4.9	8	3	3.7
M5	× 0.8	TC312286	8	70	25	6	4.9	8	3	4.2
M6	× 1	TC312316	10	80	30	6	4.9	8	3	5
M7	× 1	TC312346	10	80	30	7	5.5	8	3	6
M8	× 1.25	TC312366	13	90	35	8	6.2	9	3	6.8
M9	× 1.25	TC312396	13	90	35	9	7	10	3	7.8
M10	× 1.5	TC312426	15	100	39	10	8	11	3	8.5
M11	× 1.5	TC312466	17	100	40	8	6.2	9	3	9.5
M12	× 1.75	TC312506	18	110	44	9	7	10	3	10.2
M14	× 2	TC312546	20	110	44	11	9	12	3	12
M16	× 2	TC312606	20	110	44	12	9	12	3	14
M18	× 2.5	TC312656	25	125	50	14	11	14	4	15.5
M20	× 2.5	TC312706	25	140	54	16	12	15	4	17.5
M22	× 2.5	TC312746	25	140	54	18	14.5	17	4	19.5
M24	× 3	TC312786	30	160	60	18	14.5	17	4	21
M27	× 3	TC312866	30	160	60	20	16	19	4	24
M30	× 3.5	TC312946	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	15	30	25	38	34	15	30	25	38	34	15	30	25	38	34	42	55	
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550	550	
Recommended	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	

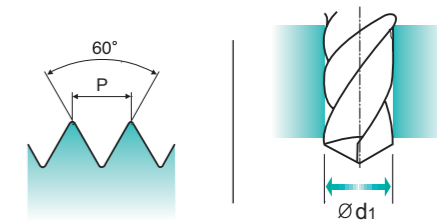
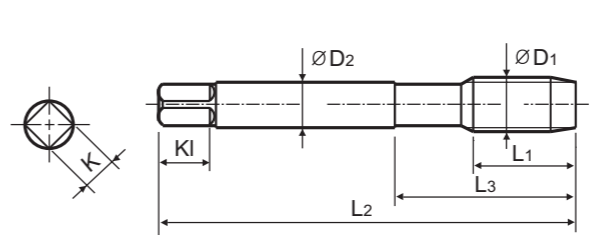
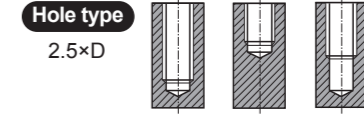
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*M2.6	× 0.45	TD312496	9	50	15	2.8	2.1	5	3	2.1
M3	× 0.5	TD312206	6	56	18	3.5	2.7	6	3	2.5
M3.5	× 0.6	TD312226	7	56	20	4	3	6	3	2.9
M4	× 0.7	TD312246	7	63	21	4.5	3.4	6	3	3.3
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M5	× 0.8	TD312286	8	70	25	6	4.9	8	3	4.2
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M27	× 3	TD312866	30	160	60	20	16	19	4	24
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HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230		
Recommended	○	○	○	◎	○	○	◎	◎	○	○	○	○	○	○	○	○	○	○	○	○		

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HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550	550	
Recommended	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	