

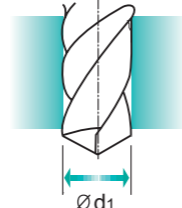
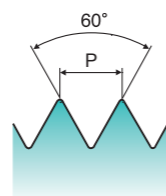
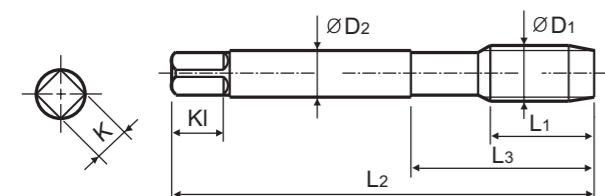
**M ISO metric coarse threads DIN 13**

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

Machine taps  
Maschinengewindebohrer

► Suitable for 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.



Material groups: **VA NW** HSS-E DIN 371/376 6HX 60° B Hardslick p.B233

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	Hardslick	L1	L2	L3	ØD2	K	KI	Z	Ød1
M2	× 0.4	TCH23136	8	45	13	2.8	2.1	5	3	1.6
M2.2	× 0.45	TCH23156	8	45	13	2.8	2.1	5	3	1.75
*M2.3	× 0.4	TCH23196	8	45	13	2.8	2.1	5	3	1.9
M2.5	× 0.45	TCH23176	9	50	15	2.8	2.1	5	3	2.05
*M2.6	× 0.45	TCH23496	9	50	15	2.8	2.1	5	3	2.1
M3	× 0.5	TCH23206	11	56	18	3.5	2.7	6	3	2.5
M3.5	× 0.6	TCH23226	12	56	20	4	3	6	3	2.9
M4	× 0.7	TCH23246	13	63	21	4.5	3.4	6	3	3.3
M4.5	× 0.75	TCH23266	14	70	25	6	4.9	8	3	3.7
M5	× 0.8	TCH23286	15	70	25	6	4.9	8	3	4.2
M6	× 1	TCH23316	17	80	30	6	4.9	8	3	5
M7	× 1	TCH23346	17	80	30	7	5.5	8	3	6
M8	× 1.25	TCH23366	20	90	35	8	6.2	9	3	6.8
M9	× 1.25	TCH23396	20	90	35	9	7	10	3	7.8
M10	× 1.5	TCH23426	22	100	39	10	8	11	3	8.5
M11	× 1.5	TCH23466	22	100	40	8	6.2	9	3	9.5
M12	× 1.75	TCH23506	24	110	44	9	7	10	4	10.2
M14	× 2	TCH23546	26	110	44	11	9	12	4	12
M16	× 2	TCH23606	27	110	44	12	9	12	4	14
M18	× 2.5	TCH23656	30	125	50	14	11	14	4	15.5
M20	× 2.5	TCH23706	32	140	54	16	12	15	4	17.5
M22	× 2.5	TCH23746	32	140	54	18	14.5	17	4	19.5
M24	× 3	TCH23786	34	160	60	18	14.5	17	4	21
M27	× 3	TCH23866	36	160	60	20	16	19	4	24
M30	× 3.5	TCH23946	40	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	55	60	42	55	42	55	
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550	
Recommended											○											

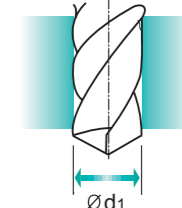
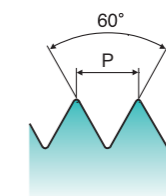
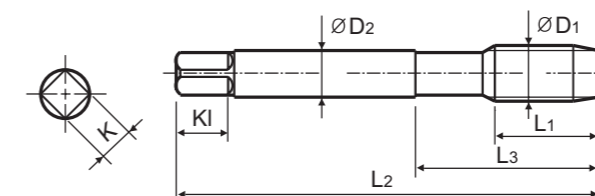
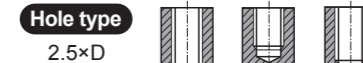
**MF ISO metric fine threads DIN 13**

- Metrisches ISO-Feingewinde DIN 13
- ISO MÉTRIQUE PAS FINS 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: **VA NW** HSS-E DIN 374 6H 60° C R40 Vap p.B233

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	Vap	L1	L2	L3	ØD2	K	KI	Z	Ød1
M4	× 0.5	TB183256	5	63	21	2.8	2.1	5	3	3.5
M5	× 0.5	TB183296	5	70	25	3.5	2.7	6	3	4.5
M6	× 0.75	TB183326	8	80	30	4.5	3.4	6	3	5.2
M6	× 0.5	TB183336	5	80	30	4.5	3.4	6	3	5.5
M7	× 0.75	TB183356	10	80	30	5.5	4.3	7	3	6.2
M8	× 1	TB183376	10	90	36	6	4.9	8	3	7
M8	× 0.75	TB183386	8	80	30	6	4.9	8	3	7.2
M10	× 1.25	TB183436	16	100	40	7	5.5	8	3	8.8
M10	× 1	TB183446	10	90	36	7	5.5	8	3	9
M10	× 0.75	TB183456	10	90	36	7	5.5	8	3	9.2
M12	× 1.5	TB183516	15	100	40	9	7	10	3	10.5
M12	× 1.25	TB183526	15	100	40	9	7	10	3	10.8
M12	× 1	TB183536	11	100	40	9	7	10	3	11
M14	× 1.5	TB183556	15	100	40	11	9	12	3	12.5
M14	× 1.25	TB183566	15	100	40	11	9	12	3	12.8
M16	× 1.5	TB183616	15	100	40	12	9	12	3	14.5
M18	× 1.5	TB183676	17	110	44	14	11	14	4	16.5
M20	× 1.5	TB183726	17	125	50	16	12	15	4	18.5
M22	× 1.5	TB183766	17	125	50	18	14.5	17	4	20.5
M24	× 1.5	TB183806	20	140	54	18	14.5	17	4	22.5

◎ : 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	55	60	42	55	42	55	
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550	
Recommended											○											