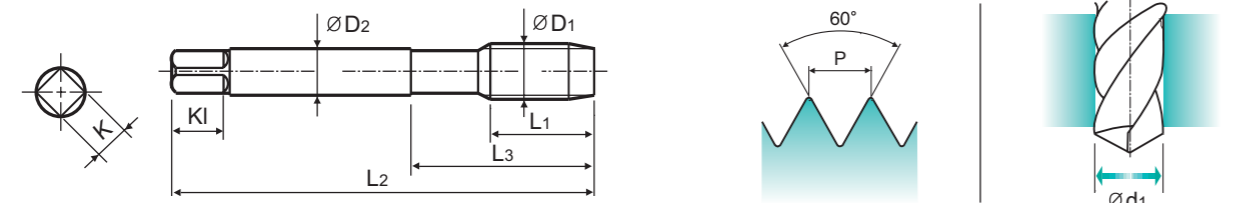


M ISO metric coarse threads DIN 13

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

▶ Carbide tap can increase tool life longer than HSS taps due to higher hardness. Suitable for hardened steels (HRc50~60)

▶ VHM-Gewindebohrer ermöglichen aufgrund ihrer höheren Härte bessere Standzeiten als HSS-Gewindebohrer. Geeignet für gehärtete Stähle (HRc50~60)



Material groups: **HR** CARBIDE DIN 371/376 6HX 60° C TICN p.B209

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	TiCN	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M3	× 0.5	T0997206TIC	11	56	18	3.5	2.7	6	4	2.55
M4	× 0.7	T0997246TIC	13	63	21	4.5	3.4	6	4	3.4
M5	× 0.8	T0997286TIC	15	70	25	6	4.9	8	4	4.3
M6	× 1	T0997316TIC	17	80	30	6	4.9	8	5	5.1
M8	× 1.25	T0997366TIC	20	90	35	8	6.2	9	5	6.9
M10	× 1.5	T0997426TIC	22	100	39	10	8	11	5	8.6
M12	× 1.75	T0997506TIC	24	110	-	9	7	12	5	10.4
M14	× 2	T0997546TIC	26	110	-	11	9	12	6	12.2
M16	× 2	T0997606TIC	27	110	-	12	9	12	6	14.2
M18	× 2.5	T0997656TIC	30	125	-	14	11	14	6	15.7
M20	× 2.5	T0997706TIC	32	140	-	16	12	15	6	17.7

▶DIN 371(M3~M10) and DIN 376(M12~M20)

◎ : 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		
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	38	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									○											

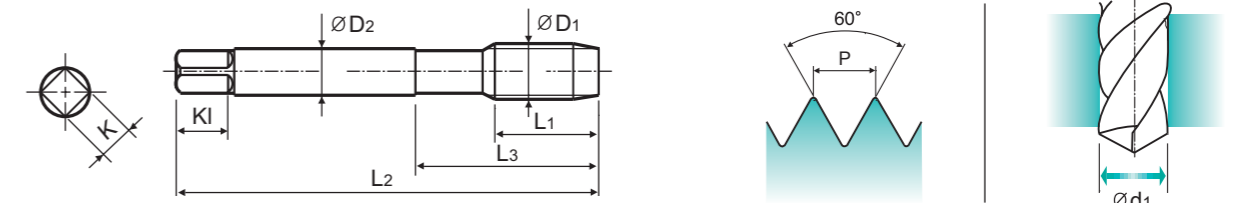
ISO	N					S					H										
	Aluminum-wrought alloy		Aluminum-cast, alloyed		Copper and Copper Alloys (Bronze / Brass)	Non Metallic Materials		Heat Resistant Super Alloys			Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron						
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550
Recommended																		◎	◎	◎	◎

M ISO metric coarse threads DIN 13

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Recommended																		◎	◎	◎	◎