

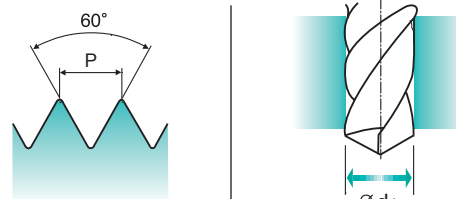
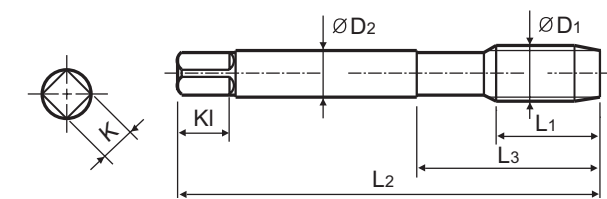
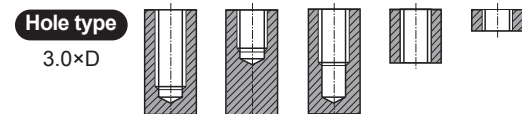
**M ISO metric coarse threads DIN 13**

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

Cold forming taps with oil grooves  
Gewindeformer mit Schmiernuten

- Suitable for threading soft materials with at least 8-10% elongation.
- The pre-drilling holes are bigger than normal sized holes.

- Geeignet zum Gewindeformen weicher Werkstoffe mit mindestens 8-10% Dehnung.
- Die Kernlochbohrungen sind größer als normale Kernlöcher.



Material groups: **GV** HSS-E DIN 371/376 6HX 60° C TiN p.B293

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	Tapping Drill Diameter
ØD1	P	TiN	L1	L2	L3	ØD2	K	KI	Ød1
M2	× 0.4	TD703136	8	45	13	2.8	2.1	5	1.83
M2.2	× 0.45	TD703156	8	45	13	2.8	2.1	5	2
*M2.3	× 0.4	TD703196	8	45	13	2.8	2.1	5	2.1
M2.5	× 0.45	TD703176	9	50	15	2.8	2.1	5	2.3
*M2.6	× 0.45	TD703496	9	50	15	2.8	2.1	5	2.4
M3	× 0.5	TD703206	11	56	18	3.5	2.7	6	2.8
M3.5	× 0.6	TD703226	12	56	20	4	3	6	3.25
M4	× 0.7	TD703246	13	63	21	4.5	3.4	6	3.7
M4.5	× 0.75	TD703266	14	70	25	6	4.9	8	4.15
M5	× 0.8	TD703286	15	70	25	6	4.9	8	4.65
M6	× 1	TD703316	17	80	30	6	4.9	8	5.55
M7	× 1	TD703346	17	80	30	7	5.5	8	6.55
M8	× 1.25	TD703366	20	90	35	8	6.2	9	7.4
M9	× 1.25	TD703396	20	90	35	9	7	10	8.4
M10	× 1.5	TD703426	22	100	39	10	8	11	9.3
M11	× 1.5	TD703466	22	100	40	8	6.2	9	10.3
M12	× 1.75	TD703506	24	110	44	9	7	10	11.2
M14	× 2	TD703546	26	110	44	11	9	12	13
M16	× 2	TD703606	27	110	44	12	9	12	15
M18	× 2.5	TD703656	30	125	50	14	11	14	16.8
M20	× 2.5	TD703706	32	140	54	16	12	15	18.8

- DIN 371(M2~M10) and DIN 376(M11~M20)
- \* 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	29	32	38	35	35	15	23	10	10	10	26	3	25	21	21
HB	125	190	250	270	300	180	275	300	350	200	240	180	180	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	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			15	30	25	38	34	400Rm	1050Rm	550	630	400	550
Recommended	◎	◎	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

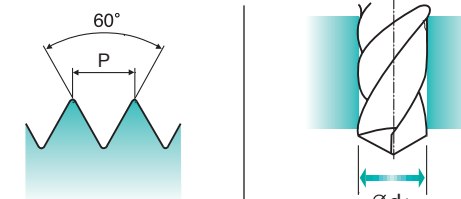
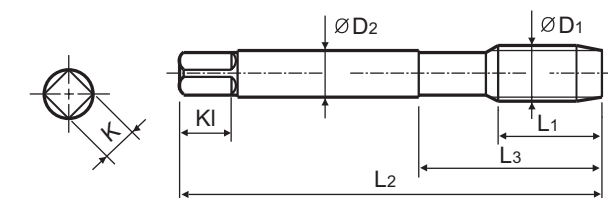
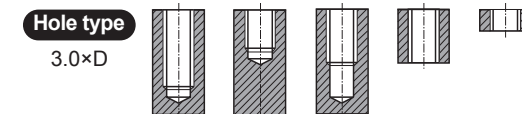
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HB	125	190	250	270	300	180	275	300	350	200	240	180	180	180	180	260	160	250	130	230
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