

M

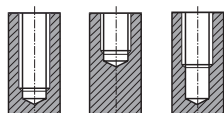
ISO Metric coarse threads DIN 13

Metrisches ISO-Gewinde DIN 13

► For stainless steels and correct thread profiles & long tool life due to special tap geometry. YG-1 company has a patent.

► Für rostfreie stähle, genaue Gewindeprofile und lange Standzeit dank einer besonderen Schneidengeometrie. Von YG-1 patentiert.

Hole type



Material groups
VA

up to M12

over M12

HSS-PM

HSS-E

DIN 371/376

6H

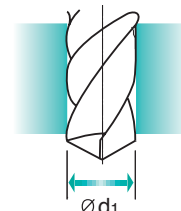
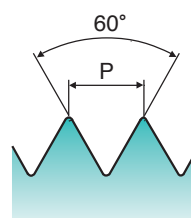
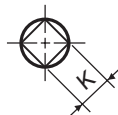
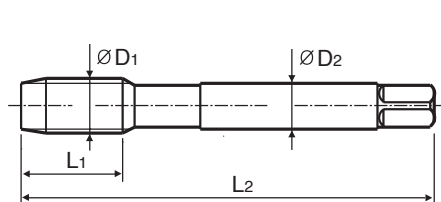
60°

C

Vap

R45

Machine taps
Maschinen-
gewindebohrer



Unit : mm

SIZE ØD1	Pitch P	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping Drill Diameter Ød1
M2	× 0.4	TQ744136	8	45	2.8	2.1	1.6
M2.2	× 0.45	TQ744156	8	45	2.8	2.1	1.75
M2.3	× 0.4	TQ744196	8	45	2.8	2.1	1.9
M2.5	× 0.45	TQ744176	9	50	2.8	2.1	2.05
M2.6	× 0.45	TQ744496	9	50	2.8	2.1	2.1
M3	× 0.5	TQ744206	6	56	3.5	2.7	2.5
M3.5	× 0.6	TQ744226	7	56	4	3	2.9
M4	× 0.7	TQ744246	7	63	4.5	3.4	3.3
M4.5	× 0.75	TQ744266	8	70	6	4.9	3.7
M5	× 0.8	TQ744286	8	70	6	4.9	4.2
M6	× 1.0	TQ744316	10	80	6	4.9	5
M7	× 1.0	TQ744346	10	80	7	5.5	6
M8	× 1.25	TQ744366	13	90	8	6.2	6.8
M9	× 1.25	TQ744396	13	90	9	7	7.8
M10	× 1.5	TQ744426	15	100	10	8	8.5
M11	× 1.5	TQ744466	17	100	8	6.2	9.5
M12	× 1.75	TQ744506	18	110	9	7	10.2
M14	× 2.0	TB744546	20	110	11	9	12
M16	× 2.0	TB744606	20	110	12	9	14
M18	× 2.5	TB744656	25	125	14	11	15.5
M20	× 2.5	TB744706	25	140	16	12	17.5
M22	× 2.5	TB744746	25	140	18	14.5	18.5
M24	× 3.0	TB744786	30	160	18	14.5	21
M27	× 3.0	TB744866	30	160	20	16	24
M30	× 3.5	TB744946	35	180	22	18	26.5

► DIN371 (M2~M10) and DIN376 (M11~M30)

► HSS-PM(M2~M12/TQ744) and HSS-E(M14~M30/TB744)

* Coating(TiN, TiCN or TiAlN) is available on your request.

Unit : N/mm²

◎ : Excellent ○ : Good

Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
○	○	○	○	○	○	◎	◎	◎	◎	◎	◎	◎	◎	◎
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
○	○	○	○	○	○	○	○	○	○	○	○	○	○	○



MACHINE TAPS

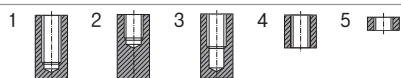
RECOMMENDATION TABLE



USE

◎ = EXCELLENT

○ = GOOD



MATERIAL GROUPS

MU MU MU

DIN 371/376	M	EDP No. (Page)	TC804 (p.375)	TD804 (p.375)	TC804-IC (p.378)
DIN 371/376	EG-M	EDP No. (Page)			
DIN 352	M	EDP No. (Page)			
DIN 374	MF	EDP No. (Page)	TC844 (p.376)	TD844 (p.376)	
DIN 371/376	UNC	EDP No. (Page)	TC824 (p.384)	TD824 (p.384)	
DIN 371/376	EG-UNC	EDP No. (Page)			
DIN 371/374	UNF	EDP No. (Page)	TC864 (p.385)	TD864 (p.385)	
DIN 371/376	EG-UNF	EDP No. (Page)			
DIN 2182/2183	BSW	EDP No. (Page)			
DIN 357/5156	M/G(BSP)	EDP No. (Page)			
LONG	M	EDP No. (Page)			
SURFACE TREATMENT / COATING			Bright	TiN	Bright
SPIRAL FLUTE ANGLE			R40	R40	R40
CHAMFER LEAD ACC. DIN 2197			C	C	C
HOLE TYPE			1-2-3	1-2-3	1-2-3

COOLANT

A = Cutting Oil
T = Oil Emulsion
X = Cutting Oil/Oil Emulsion
S = Dry
Z = Dry/Oil Emulsion

HARDNESS	TENSILE STRENGTH	CHIP	CUTTING SPEED	COOLANT			
HB	Rm N/mm²		Vc m/min				
< 120	< 400	Extra long	15-20	T			
< 200	< 700	Medium/long	15-20	T			
< 250	< 850	Long	12-18	T			
< 250	< 850	Long	10-15	X			
< 350	≤ 1,200	Long	6-10	X			
> 350	> 1,200	Long	3-5	A			
< 250	< 850	Medium	7-10	A			
< 250	< 850	Long	5-8	A			
< 300	< 1,100	Long	4-6	A			
< 150	< 500	Extra short	10-15	X			
< 300	< 1,000	Extra short	5-8	T			
< 200	< 700	Short	10-15	X			
< 300	< 1,000	Short	5-8	X			
< 200	< 700	Extra long	10-15	T			
< 270	< 900	Medium/Short	8-12	A			
< 350	≤ 1,300	Medium/Short	4-6	A			
< 150	< 500	Extra long	8-12	A			
< 270	< 900	Long	10-15	A			
< 410	≤ 1,400	Long	2-4	A			
< 100	< 350	Extra long	8-12	T			
< 200	< 700	Medium/Short	25-35	T			
< 200	< 700	Long	15-20	T			
< 470	< 1,500	Short	3-5	A			
< 100	< 350	Extra long	10-15	T			
< 150	< 500	Medium	25-35	T			
< 120	< 400	Medium/Short	15-20	T			
< 120	< 400	Short	10-15	T			
		Extra long	20-30	T			
		Short	8-12	Z			
		Extra short	5-7	Z			

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CUTTING SPEED TABLE

CUTTING SPEED TABLE SCHNITTGESCHWINDIGKEITSTABELLE

Cutting Speeds m/min. into revolutions per minute

TOOL R.P.M.(rev/min)																
Tool Dia.	Cutting Speed (m/min)															
	1	2	3	4	5	6	8	10	12	15	20	25	30	40	50	60
1	318	637	955	1274	1592	1910	2548	3185	3822	4777	6396	7962	9554	12739	15924	19108
2	159	318	478	637	796	955	1274	1592	1911	2388	3185	3981	4777	6369	7962	9554
3	106	212	318	425	531	637	849	1062	1274	1592	2123	2654	3185	4246	5308	6369
4	80	159	239	318	398	478	637	796	955	1194	1592	1990	2389	3185	3981	4777
5	64	127	191	255	318	382	510	637	764	955	1274	1592	1911	2548	3185	3822
6	53	106	159	212	265	318	425	531	637	796	1062	1327	1592	2123	2653	3185
8	40	80	119	159	199	239	318	398	478	597	796	955	1194	1592	1990	2388
10	31	64	96	127	159	191	255	318	382	478	637	796	955	1274	1592	1911
12	26	53	80	106	133	159	212	265	318	398	531	663	796	1062	1327	1592
14	23	45	68	91	114	136	182	227	273	341	455	569	682	910	1137	1365
16	20	40	60	80	100	119	159	199	239	299	398	498	597	796	995	1194
18	18	35	53	71	88	106	142	177	212	265	354	442	531	708	885	1062
20	16	32	48	64	80	96	127	159	191	239	318	398	478	637	796	955
25	13	25	38	51	64	76	102	127	153	191	255	318	382	510	637	764
30	11	21	32	42	53	64	85	106	127	159	212	265	318	425	531	637
35	9	18	27	36	45	55	73	91	109	136	182	227	273	364	455	546
40	8	16	24	32	40	48	64	80	96	119	159	199	239	318	398	478

RPM = rev/min

V = m/min

D = Dia.(mm)

$$V = \frac{RPM \cdot \pi \cdot D}{1000}$$

$$RPM = \frac{1000 \cdot V}{\pi \cdot D}$$