

ISO metric coarse threads DIN 13

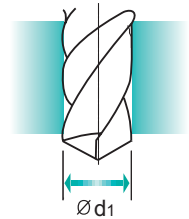
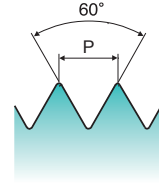
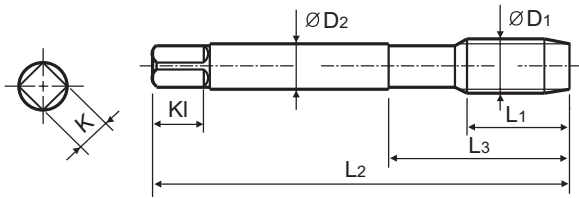
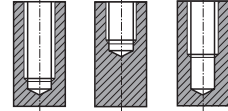
- M** **Metrisches ISO-Gewinde DIN 13**
- ISO MÉTRIQUE DIN13**
- ISO Metrico passo grosso DIN 13**

► Suitable for threading blind holes due to excellent chip evacuation of tempered steels or similar work materials.

► Geeignet zum Gewinden von Sacklöchern dank ausgezeichneter Spanabfuhr von angelassenen Stählen oder ähnlichen Werkstoffen.



Hole type
2.5×D



Material groups **VG** **HSS-E** **DIN 371/376** **6H** **60°** **C** **Vap** **R40**

Machine taps
Maschinengewindebohrer

Recommended Cutting Page : P.189

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	K1	Z	Ød1
M2 × 0.4		TB312136	8	45	13	2.8	2.1	5	3	1.6
M2.2 × 0.45		TB312156	8	45	13	2.8	2.1	5	3	1.75
*M2.3 × 0.4		TB312196	8	45	13	2.8	2.1	5	3	1.9
M2.5 × 0.45		TB312176	9	50	15	2.8	2.1	5	3	2.05
*M2.6 × 0.45		TB312496	9	50	15	2.8	2.1	5	3	2.1
M3 × 0.5		TB312206	6	56	18	3.5	2.7	6	3	2.5
M3.5 × 0.6		TB312226	7	56	20	4	3	6	3	2.9
M4 × 0.7		TB312246	7	63	21	4.5	3.4	6	3	3.3
M4.5 × 0.75		TB312266	8	70	25	6	4.9	8	3	3.7
M5 × 0.8		TB312286	8	70	25	6	4.9	8	3	4.2
M6 × 1		TB312316	10	80	30	6	4.9	8	3	5
M7 × 1		TB312346	10	80	30	7	5.5	8	3	6
M8 × 1.25		TB312366	13	90	35	8	6.2	9	3	6.8
M9 × 1.25		TB312396	13	90	35	9	7	10	3	7.8
M10 × 1.5		TB312426	15	100	39	10	8	11	3	8.5
M11 × 1.5		TB312466	17	100	40	8	6.2	12	3	9.5
M12 × 1.75		TB312506	18	110	44	9	7	10	3	10.2
M14 × 2		TB312546	20	110	44	11	9	12	3	12
M16 × 2		TB312606	20	110	44	12	9	12	3	14
M18 × 2.5		TB312656	25	125	50	14	11	14	4	15.5
M20 × 2.5		TB312706	25	140	54	16	12	15	4	17.5
M22 × 2.5		TB312746	25	140	54	18	14.5	17	4	19.5
M24 × 3		TB312786	30	160	60	18	14.5	17	4	21
M27 × 3		TB312866	30	160	60	20	16	19	4	24
M30 × 3.5		TB312946	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	P										M				K					
Material Description	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	10	29	32	38	15	35	15	23	10	10	26	3	25		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				
Material Description	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			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550
Recommended											○					○					



RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDKONDITIONEN

ISO	VDI 3323	Material Description	HB	HRC	Vc (m/min)													
					TQ823	TR823	TC312 TC413 TC174 TC184	TD312 TD413 TD174	TB312	TY312	TB913	TQ863	TR863	TC422 TC263 TC244 TC254	TD422 TD263 TD244	TE422	TY422	
P	1	Non-alloy steel	125															
	2		190	13	15-20	15-20	15-20	20-25	15-20	20-25	15-20	15-20	15-20	15-20	15-20	20-25	20-25	
	3		250	25	12-18	12-18	12-18	18-24	12-18	18-24	12-18	12-18	12-18	12-18	12-18	18-24	18-24	
	4		270	28	10-15	10-15	10-15	15-20	10-15	15-20	10-15	10-15	10-15	10-15	10-15	15-20	15-20	
	5		300	32	6-10	6-10	6-10	10-14	6-10	10-14	6-10	6-10	6-10	6-10	6-10	10-14	10-14	
	6	Low alloy steel	180	10	10-15	10-15	10-15	15-20	10-15	15-20	10-15	10-15	10-15	10-15	10-15	15-20	15-20	
	7		275	29	10-15	10-15	10-15	15-20	10-15	15-20	10-15	10-15	10-15	10-15	10-15	15-20	15-20	
	8		300	32	6-10	6-10	6-10	10-14	6-10	10-14	6-10	6-10	6-10	6-10	6-10	10-14	10-14	
	9		350	38	3-5	3-5	3-5	5-7	3-5	5-7	3-5	3-5	3-5	3-5	3-5	5-7	5-7	
	10		High alloyed steel, and tool steel	200	15	3-5	3-5	3-5	5-7	3-5	5-7	3-5	3-5	3-5	3-5	3-5	5-7	5-7
	11			325	35													
M	12	Stainless steel	200	15								7-10	7-10	7-10	7-10	10-15	10-15	
	13		240	23								5-8	5-8	5-8	5-8	8-11	8-11	
	14		180	10	4-6	4-6	4-6	6-8	4-6	6-8	4-6	4-6	4-6	4-6	4-6	6-8	6-8	
K	15	Grey cast iron	180	10														
	16		260	26														
	17	Nodular cast iron	160	3														
	18		250	25														
	19		Malleable cast iron	130														
20	230	21																
N	21	Aluminum-wrought alloy	60															
	22		100															
	23	Aluminum-cast, alloyed	75															
	24		90															
	25		130															
	26		110															
	27		Copper and Copper Alloys (Bronze / Brass)	90														
	28			100														
	29			Non Metallic Materials														
	30																	
S	31	Heat Resistant Super Alloys	200	15	10-15	10-15	10-15	15-20	10-15	15-20	10-15	10-15	10-15	10-15	10-15	15-20	15-20	
	32		280	30														
	33		250	25														
	34		350	38														
	35		320	34														
	36	Titanium Alloys	400Rm		10-15	10-15	10-15	15-20	10-15	15-20	10-15	10-15	10-15	10-15	10-15	15-20	15-20	
	37		1050Rm															
H	38	Hardened steel	550	55														
	39		630	60														
	40	Chilled Cast Iron	400	42														
	41	Hardened Cast Iron	550	55														

SURFACE TREATMENT AND COATING

The applied High Speed Steels holds a grant of good wear resistance and toughness. Therefore YG-1 normally delivers taps with bright and unfinished surface. For certain materials, various surface treatments provide higher advantage in machining.

STEAM TEMPERED - Vap

Steam Tempered is a Fe₃O₄-oxyd-coating which reduces friction between the tool and workpiece, also preventing cold welding.

NITRIDING - NI

Recommend surface treatment for machining materials that affect wear abrasion, such as grey cast iron, alu-alloys with high Si-percentages (more than 10%).

Below are the various surface treatments for excellent finish surfaces suitable for many applications. The surface treatments are produced and developed within the company.

TiN-COATING

TiN-coating yields a hardness of approx. 2,300 HV and also a heat resistant up to approx. 600°C. The current coating is an excellent all-round coating for normal applications.

Colour : Golden Coefficient of friction against steel : 0.4

TiCN-COATING

TiCN takes place of TiN when the conditions require the coating to have a different hardness and toughness.

The TiCN brings advantages for machining very difficult steels or cutting interrupted bores.

The TiCN-coating has a hardness of approx. 3,000 HV, but is heat resistance only holds up to approx. 400°C, meaning that the TiCN needs an excellent cooling system for a long service life.

Colour : Blue-Grey Coefficient of friction against steel : 0.4

TiAlN-COATING

A special coating for machining abrasive materials such as grey cast iron, alu-alloys with silicon, fiber reinforced plastics, etc., or machining at high temperatures with insufficient cooling, or at high speeds ≥ 600 m/min. TiAlN has a hardness of approx. 3,000 HV and is heat resistant up to approx. 800°C.

Colour : Violet-Grey Coefficient of friction against steel : 0.4

Hardslick-COATING

Hardslick combines the advantages of an extremely hard, thermally stable TiAlN-coating with the sliding and lubricating properties of an outer WC/C(Tungsten carbide/carbon)-coating in a novel way. The Hardslick coating has a hardness of approx. 3,000 HV and is temperature-resistant up to approx. 800°C.

Colour : Violet-Grey Coefficient of friction against steel : 0.2

SELECTION GUIDE



HSS-E & HSS-PM YG TAP STEEL

For Steel Materials but also other
Long Chip Forming Materials



Please visit
globalyg1.com/mat
for material search

◎ : Excellent ○ : Good

Recommended cutting conditions : P.189

HOLE TYPE		Max. 2.5xD Blind Hole				
TOOL MATERIAL		HSS-PM		HSS-E		
CHAMFER LEAD ACC. TO DIN2197		C	C	C	C	
FLUTE TYPE		Spiral Flute	Spiral Flute	Spiral Flute	Spiral Flute	
SPIRAL FLUTE ANGLE		R40	R40	R40	R40	
SERIES	M	DIN371/376	TQ823 (P.166)	TR823 (P.167)	TC312 (P.168)	TD312 (P.169)
		DIN352				
		DIN357/LONG				
	MF	DIN374			TC413 (P.172)	TD413 (P.173)
		DIN2181				
	UNC	DIN371/376			TC174 (P.174)	TD174 (P.175)
		DIN351				
	UNF	DIN371/374			TC184 (P.176)	
		DIN2181				
	BSW	DIN2182/2183				
		DIN351				
	G(BSP)	DIN5156/5157				
	EG-M	DIN371/376				
	EG-UNC	DIN371/376				
EG-UNF	DIN371/374					
SURFACE TREATMENT		VAP	Bright	Bright	TIN	
MODEL						

ISO	VDI 3323	Material Description	Composition / Structure / Heat Treatment		HB	HRc				
P	1	Non-alloy steel	About 0.15% C	Annealed	125					
	2		About 0.45% C	Annealed	190	13	○	○	○	○
	3		About 0.45% C	Quenched & Tempered	250	25	○	○	○	○
	4		About 0.75% C	Annealed	270	28	○	○	○	○
	5	About 0.75% C	Quenched & Tempered	300	32	◎	◎	◎	◎	
	6	Low alloy steel		Annealed	180	10	○	○	○	○
	7		Quenched & Tempered	275	29	○	○	○	○	
	8		Quenched & Tempered	300	32	◎	◎	◎	◎	
	9		Quenched & Tempered	350	38	◎	◎	◎	◎	
	10		High alloyed steel, and tool steel	Annealed	200	15	○	○	○	○
	11		Quenched & Tempered	325	35					
M	12	Stainless steel	Ferritic / Martensitic	Annealed	200	15				
	13		Martensitic	Quenched & Tempered	240	23				
	14		Austenitic	180	10	○	○	○	○	
K	15	Grey cast iron	Pearlitic / ferritic		180	10				
	16		Pearlitic (Martensitic)		260	26				
	17	Nodular cast iron	Ferritic		160	3				
	18		Pearlitic		250	25				
	19		Ferritic		130					
20	Malleable cast iron	Pearlitic		230	21					
N	21	Aluminum-wrought alloy	Not Curable		60					
	22		Curable Hardened		100					
	23	Aluminum-cast, alloyed	≤ 12% Si, Not Curable		75					
	24		≤ 12% Si, Curable Hardened		90					
	25		> 12% Si, Not Curable		130					
	26		Cutting Alloys, PB>1%		110					
	27	Copper and Copper Alloys (Bronze / Brass)	CuZn, CuSnZn (Brass)		90					
	28		CuSn, lead-free copper and electrolytic copper		100					
	29	Non Metallic Materials	Duroplastic, Fiber Reinforced Plastic							
	30		Rubber, Wood, etc.							
S	31	Heat Resistant Super Alloys	Fe Based	Annealed	200	15	○	○	○	○
	32		Cured	280	30					
	33		Annealed	250	25					
	34		Ni or Co Based	Cured	350	38				
	35		Cast	320	34					
	36	Titanium Alloys	Pure Titanium		400 Rm		○	○	○	○
37		Alpha + Beta Alloys	Hardened	1050 Rm						
H	38	Hardened steel		Hardened	550	55				
	39			Hardened	630	60				
	40	Chilled Cast Iron		Cast	400	42				
	41	Hardened Cast Iron		Hardened	550	55				

