M ISO metric coarse threads DIN 13

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

Sets of taps
Gewindebohrer -Satz

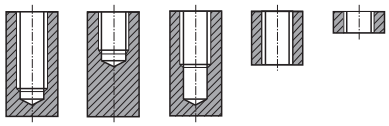
▶ This tap is a serial hand tap in set, First, Second and Bottoming.
▶ Bottoming tap of set has final internal thread dimensions only.

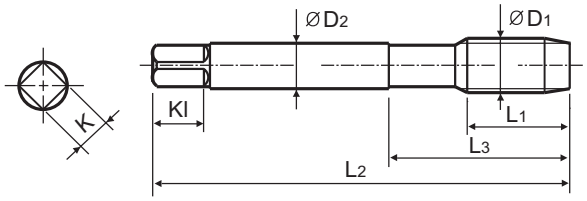
▶ Dies ist ein Handgewindebohrer im Satz mit Vor-, Mittel- und Fertigschneider.
▶ Nur der Fertigschneider kann das gewünschte Gewinde schneiden

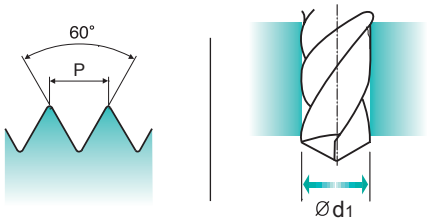
First
Second
Bottoming



Hole type
2.0×D







Material groups GS | HSS | DIN 352 | 6H | 60° | I/II/III | Bright

p.B309

Recommended ToolHolder
Plain Shank
TAPPING ER CHUCK
TAPPING CHUCK
ONE STEP TAPPING CHUCK

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	Bright	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M2	× 0.4	T7109139	8	36	13	2.8	2.1	5	3	1.6
M2.2	× 0.45	T7109159	9	36	13	2.8	2.1	5	3	1.75
*M2.3	× 0.4	T7109199	9	36	13	2.8	2.1	5	3	1.9
M2.5	× 0.45	T7109179	9	40	15	2.8	2.1	5	3	2.05
*M2.6	× 0.45	T7109499	9	40	15	2.8	2.1	5	3	2.1
M3	× 0.5	T7109209	11	40	18	3.5	2.7	6	3	2.5
M3.5	× 0.6	T7109229	13	45	21	4	3	6	3	2.9
M4	× 0.7	T7109249	13	45	21	4.5	3.4	6	3	3.3
M4.5	× 0.75	T7109269	16	50	25	6	4.9	8	3	3.7
M5	× 0.8	T7109289	16	52	26	6	4.9	8	3	4.2
M5.5	× 0.9	T7109N69	18	56	27	6	4.9	8	3	4.6
M6	× 1.0	T7109319	18	56	27	6	4.9	8	3	5
M7	× 1.0	T7109349	18	56	28.5	6	4.9	8	3	6
M8	× 1.25	T7109369	20	63	34	6	4.9	8	3	6.8
M9	× 1.25	T7109399	20	63	34	7	5.5	8	4	7.8
M10	× 1.5	T7109429	22	70	38	7	5.5	8	4	8.5
M11	× 1.5	T7109469	22	70	38	8	6.2	9	4	9.5
M12	× 1.75	T7109509	24	80	45	9	7	10	4	10.2
M14	× 2.0	T7109549	26	80	45	11	9	12	4	12
M16	× 2.0	T7109609	27	80	45	12	9	12	4	14
M18	× 2.5	T7109659	30	95	58	14	11	14	4	15.5
M20	× 2.5	T7109709	32	95	58	16	12	15	4	17.5

▶ *DIN profile not ISO

▶ NEXT PAGE

◎ : 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					○	○	○														

YG TAP GENERAL

T7109 SERIES

M ISO metric coarse threads DIN 13

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

Sets of taps
Gewindebohrer-Satz

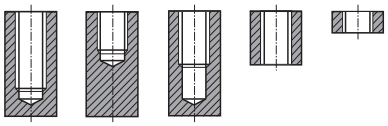
▶ This tap is a serial hand tap in set, First, Second and Bottoming.
▶ Bottoming tap of set has final internal thread dimensions only.

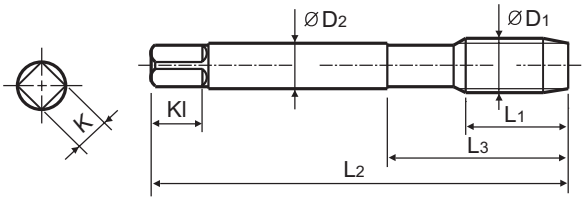
▶ Dies ist ein Handgewindebohrer im Satz mit Vor-, Mittel- und Fertigschneider.
▶ Nur der Fertigschneider kann das gewünschte Gewinde schneiden.

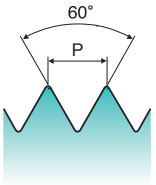
First
Second
Bottoming

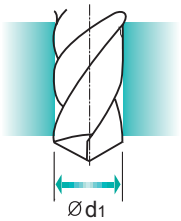


Hole type
2.0×D









Material groups GS | HSS | DIN 352 | 6H | 60° | I/II/III | Bright

p.B309

Recommended ToolHolder
Plain Shank
TAPPING ER CHUCK
TAPPING CHUCK
ONE STEP TAPPING CHUCK

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	Bright	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M22	× 2.5	T7109749	32	100	62	18	14.5	17	4	19.5
M24	× 3.0	T7109789	34	110	69	18	14.5	17	4	21
M27	× 3.0	T7109869	36	110	69	20	16	19	4	24
M30	× 3.5	T7109949	40	125	77	22	18	21	4	26.5
M33	× 3.5	T7109A49	40	125	77	25	20	23	4	29.5
M36	× 4.0	T7109B39	50	150	88	28	22	25	4	32
M39	× 4.0	T7109C09	50	150	88	32	24	27	4	35
M42	× 4.5	T7109C89	56	150	88	32	24	27	4	37.5
M45	× 4.5	T7109D59	58	160	93	36	29	32	4	40.5
M48	× 5.0	T7109E29	65	180	102	36	29	32	4	43
M52	× 5.0	T7109F39	65	180	102	40	32	35	4	47

▶ *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					○	○	○														

phone:+82-32-526-0909, www.yg1.solutions, E-mail:yg1@yg1.solutions
YG-1 CO., LTD.