MF ISO metric fine threads DIN 13

Metrisches ISO-Gewinde DIN 13
ISO MÉTRIQUE PAS FINS DIN13
ISO Metrico passo fine DIN 13

Sets of taps
Gewindebohrer-Satz

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

▶ Handgewindebohrersatz mit Vor- und Fertigschneider.
▶ Nur der Fertigschneider kann das gewünschte Gewinde schneiden.

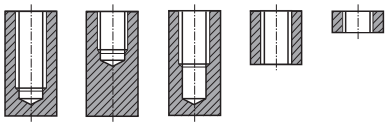
First

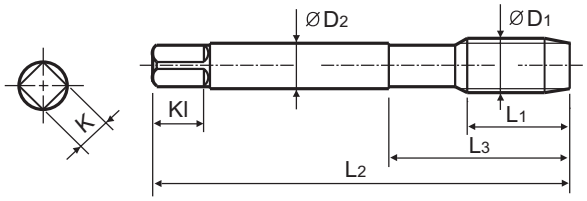


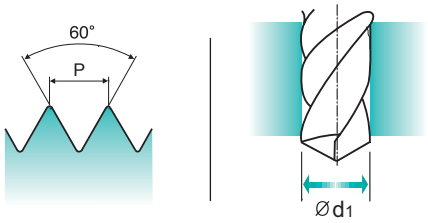
Bottoming



Hole type
2.0×D







Material groups **GS** | HSS | DIN 2181 | 6H | 60° | I/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
M3	× 0.35	T7309219	9	40	18	3.5	2.7	6	3	2.65
M4	× 0.5	T7309259	10	45	18	4.5	3.4	6	3	3.5
M5	× 0.5	T7309299	13	52	22	6	4.9	8	3	4.5
M6	× 0.75	T7309329	14	56	24	6	4.9	8	3	5.2
M6	× 0.5	T7309339	13	56	24	6	4.9	8	3	5.5
M7	× 0.75	T7309359	14	56	27	6	4.9	8	3	6.2
M8	× 1.0	T7309379	17	63	27	6	4.9	8	3	7
M8	× 0.75	T7309389	14	63	27	6	4.9	8	3	7.2
M8	× 0.5	T7309939	14	63	27	6	4.9	8	3	7.5
M9	× 1.0	T7309409	17	63	27	7	5.5	8	4	8
M10	× 1.25	T7309439	22	70	32	7	5.5	8	4	8.8
M10	× 1.0	T7309449	18	63	27	7	5.5	8	4	9
M10	× 0.75	T7309459	18	63	27	7	5.5	8	4	9.2
M11	× 1.0	T7309479	18	63	27	8	6.2	9	4	10
M12	× 1.5	T7309519	20	70	32	9	7	10	4	10.5
M12	× 1.25	T7309529	20	70	32	9	7	10	4	10.8
M12	× 1.0	T7309539	18	70	32	9	7	10	4	11
M13	× 1.5	T7309N19	20	70	32	11	9	12	4	11.5
M13	× 1.0	T7309N29	18	70	32	11	9	12	4	12
M14	× 1.5	T7309559	20	70	32	11	9	12	4	12.5
M14	× 1.25	T7309569	20	70	32	11	9	12	4	12.8
M14	× 1.0	T7309579	18	70	32	11	9	12	4	13
M15	× 1.5	T7309589	20	70	32	12	9	12	4	13.5
M15	× 1.0	T7309599	18	70	32	12	9	12	4	14
M16	× 1.5	T7309619	20	70	32	12	9	12	4	14.5

▶ 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	400 Rm	1050 Rm	550	630	400	550
Recommended					○	○	○														

YG TAP GENERAL

T7309 SERIES

MF ISO metric fine threads DIN 13

Metrisches ISO-Feingewinde DIN 13
ISO MÉTRIQUE PAS FINS DIN13
ISO Metrico passo fine DIN 13

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Gewindebohrer-Satz

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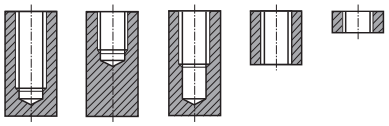
First

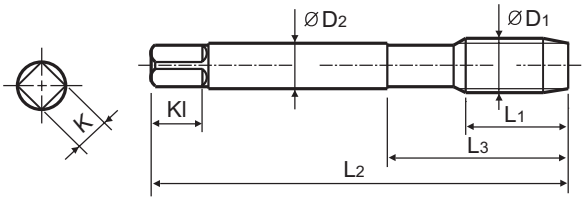


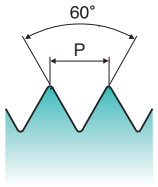
Bottoming

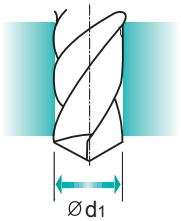


Hole type
2.0×D









Material groups GS | HSS | DIN 2181 | 6H | 60° | I/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
M16 × 1.0		T7309629	18	70	32	12	9	12	4	15
M18 × 2.0		T7309669	22	80	35	14	11	14	4	16
M18 × 1.5		T7309679	22	80	35	14	11	14	4	16.5
M18 × 1.0		T7309689	18	80	35	14	11	14	4	17
M20 × 2.0		T7309719	22	80	35	16	12	15	4	18
M20 × 1.5		T7309729	22	80	35	16	12	15	4	18.5
M20 × 1.0		T7309739	18	80	35	16	12	15	4	19
M22 × 2.0		T7309759	22	80	35	18	14.5	17	4	20
M22 × 1.5		T7309769	22	80	35	18	14.5	17	4	20.5
M22 × 1.0		T7309779	18	80	35	18	14.5	17	4	21
M24 × 2.0		T7309799	22	90	40	18	14.5	17	4	22
M24 × 1.5		T7309809	22	90	40	18	14.5	17	4	22.5
M24 × 1.0		T7309819	18	90	40	18	14.5	17	4	23
M25 × 1.5		T7309839	22	90	40	18	14.5	17	4	23.5
M25 × 1.0		T7309849	18	90	40	18	14.5	17	4	24
M26 × 1.5		T7309859	22	90	40	18	14.5	17	4	24.5
M26 × 1.0		T7309N59	18	90	40	18	14.5	17	4	25
M27 × 2.0		T7309879	22	90	40	20	16	19	4	25
M27 × 1.5		T7309889	22	90	40	20	16	19	4	25.5
M27 × 1.0		T7309899	18	90	40	20	16	19	4	26
M28 × 2.0		T7309909	22	90	40	20	16	19	4	26
M28 × 1.5		T7309919	22	90	40	20	16	19	4	26.5
M30 × 2.0		T7309969	22	90	40	22	18	21	4	28
M30 × 1.5		T7309979	22	90	40	22	18	21	4	28.5
M30 × 1.0		T7309989	18	90	40	22	18	21	4	29

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HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	○	○	○	○		○	○										○	○		

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Recommended					○	○	○														

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