YG TAP INOX

Vap **TB914 SERIES**
TiCN **TI914 SERIES**

M ISO metric coarse threads DIN 13

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

Machine taps
Maschinengewindebohrer

- With recessed threads for machine tapping of deep blind holes.
- Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

- Mit abgesetztem Gewinde zum Schneiden von tiefen Sacklochgewinden.
- Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

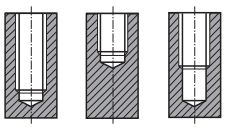
DIN 371

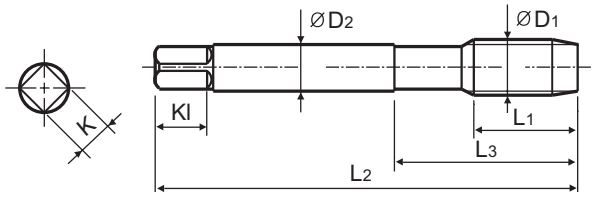


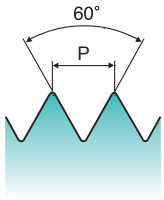
DIN 376

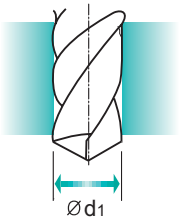


Hole type
2.5×D









Material groups **VA NW** | HSS-E | DIN 371/376 | 6H | 60° | C | R40 | Vap TiCN

p.B193

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	Vap	TiCN	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M2	× 0.4	TB914136	TI914136	8	45	13	2.8	2.1	5	3	1.6
M2.2	× 0.45	TB914156	TI914156	8	45	13	2.8	2.1	5	3	1.75
*M2.3	× 0.4	TB914196	TI914196	8	45	13	2.8	2.1	5	3	1.9
M2.5	× 0.45	TB914176	TI914176	9	50	15	2.8	2.1	5	3	2.05
*M2.6	× 0.45	TB914496	TI914496	9	50	15	2.8	2.1	5	3	2.1
M3	× 0.5	TB914206	TI914206	6	56	18	3.5	2.7	6	3	2.5
M3.5	× 0.6	TB914226	TI914226	7	56	20	4	3	6	3	2.9
M4	× 0.7	TB914246	TI914246	7	63	21	4.5	3.4	6	3	3.3
M4.5	× 0.75	TB914266	TI914266	8	70	25	6	4.9	8	3	3.7
M5	× 0.8	TB914286	TI914286	8	70	25	6	4.9	8	3	4.2
M6	× 1.0	TB914316	TI914316	10	80	30	6	4.9	8	3	5
M7	× 1.0	TB914346	TI914346	10	80	30	7	5.5	8	3	6
M8	× 1.25	TB914366	TI914366	13	90	35	8	6.2	9	3	6.8
M9	× 1.25	TB914396	TI914396	13	90	35	9	7	10	3	7.8
M10	× 1.5	TB914426	TI914426	15	100	39	10	8	11	3	8.5
M11	× 1.5	TB914466	TI914466	17	100	40	8	6.2	9	3	9.5
M12	× 1.75	TB914506	TI914506	18	110	44	9	7	10	3	10.2
M12	× 1.75	TB914506F4	TI914506F4	18	110	44	9	7	10	4	10.2
M14	× 2.0	TB914546	TI914546	20	110	44	11	9	12	3	12
M14	× 2.0	TB914546F4	TI914546F4	20	110	44	11	9	12	4	12
M16	× 2.0	TB914606	TI914606	20	110	44	12	9	12	3	14
M16	× 2.0	TB914606F4	TI914606F4	20	110	44	12	9	12	4	14
M18	× 2.5	TB914656	TI914656	25	125	50	14	11	14	4	15.5
M20	× 2.5	TB914706	TI914706	25	140	54	16	12	15	4	17.5
M22	× 2.5	TB914746	TI914746	25	140	54	18	14.5	17	4	19.5
M24	× 3.0	TB914786	TI914786	30	160	60	18	14.5	17	4	21
M27	× 3.0	TB914866	TI914866	30	160	60	20	16	19	4	24
M30	× 3.5	TB914946	TI914946	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											○					○					