YG TAP GENERAL

TC353 SERIES

M ISO metric coarse threads DIN 13

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

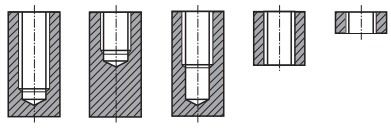
Sets of taps
Gewindebohrer-Satz

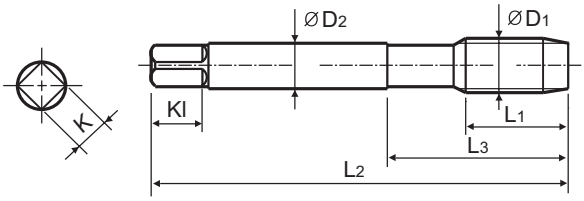
▶ This tap is a serial hand tap in set, First, Second and Bottoming.
▶ Bottoming tap of set has final internal thread dimensions only..

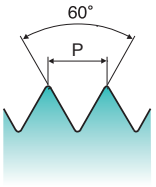
▶ Dies ist ein Handgewindebohrer im Satz mit Vor-, Mittel- und Fertigschneider.
▶ Nur der Fertigschneider kann das gewünschte Gewinde schneiden.

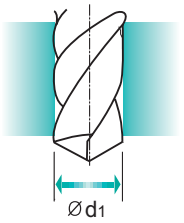


Hole type
2.0×D









Material groups VG | HSS-E | 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
M3	× 0.5	TC353209	11	40	18	3.5	2.7	6	3	2.5
M3.5	× 0.6	TC353229	13	45	21	4	3	6	3	2.9
M4	× 0.7	TC353249	13	45	21	4.5	3.4	6	3	3.3
M4.5	× 0.75	TC353269	16	50	25	6	4.9	8	3	3.7
M5	× 0.8	TC353289	16	52	26	6	4.9	8	3	4.2
M6	× 1.0	TC353319	18	56	27	6	4.9	8	3	5
M8	× 1.25	TC353369	20	63	34	6	4.9	8	3	6.8
M10	× 1.5	TC353429	22	70	38	7	5.5	8	4	8.5
M12	× 1.75	TC353509	24	80	45	9	7	10	4	10.2
M14	× 2.0	TC353549	26	80	45	11	9	12	4	12
M16	× 2.0	TC353609	27	80	45	12	9	12	4	14
M18	× 2.5	TC353659	30	95	58	14	11	14	4	15.5
M20	× 2.5	TC353709	32	95	58	16	12	15	4	17.5

▶ First with pilot guide

◎ : 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																					

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