SCREW THREAD INSERT TAP

TC909 SERIES

EG-M

ISO metric coarse threads for Screw Thread insert

Metrisches ISO Regelgew.f.Gew. Drahteins
ISO MÉTRIQUE DIN13 POUR FILETS RAPPORTÉS
ISO Metrico passo grosso per Helicoil

Machine taps
Maschinengewindebohrer

▶ Wire insert threads are used for increasing fastening strength in soft materials.

▶ Gewinde mit Drahteinsätzen werden verwendet um größere Drehmomente in weichen Werkstoffen zu erreichen.

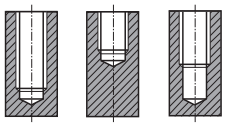
DIN 371

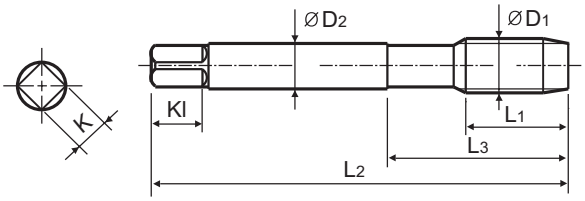


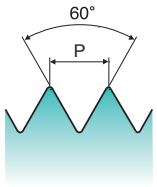
DIN 376

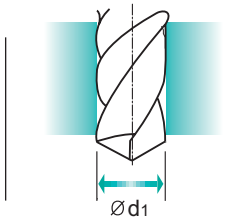


Hole type
2.5×D









Material groups **Al**

HSS-E | DIN 371/376 | 6H Mod. | 60° | C | R40 | Bright

p.B326

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
M2.5	× 0.45	TC909176	6	56	18	3.5	2.7	6	3	2.65
M3	× 0.5	TC909206	5	63	21	4.5	3.4	6	3	3.15
M3.5	× 0.6	TC909226	8	70	25	6	4.9	8	3	3.7
M4	× 0.7	TC909246	8	70	25	6	4.9	8	3	4.2
M5	× 0.8	TC909286	8	80	30	6	4.9	8	3	5.25
M6	× 1.0	TC909316	10	90	35	8	6.2	9	3	6.3
M8	× 1.25	TC909366	16	100	39	10	8	11	3	8.4
M10	× 1.5	TC909426	15	110	44	9	7	10	3	10.4
M12	× 1.75	TC909506	20	110	44	11	9	12	3	12.5
M14	× 2.0	TC909546	22	110	44	12	9	12	3	14.5
M16	× 2.0	TC909606	25	125	50	14	11	14	4	16.5
M18	× 2.5	TC909656	27	140	54	18	14.5	17	4	18.75
M20	× 2.5	TC909706	30	160	60	18	14.5	17	4	20.75

▶ DIN 371(M2.5~M8) and DIN 376(M10~M20)

◎ : 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	◎	◎	◎	◎			◎														