YG TAP CAST IRON

TD821 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

▶ Suitable for tapping cast iron or similar work materials.

▶ Geeignet zum Gewindeschneiden von Guss oder ähnlichen Werkstoffen

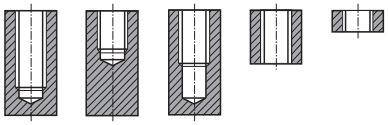
DIN 371

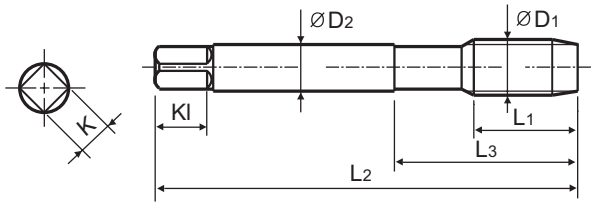


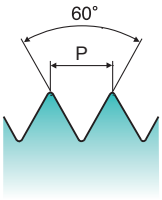
DIN 376

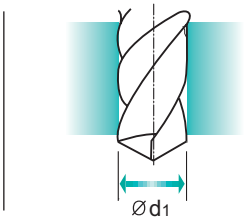


Hole type
2.0×D









Material groups **GG**

HSS-E | DIN 371/376 | 6HX | 60° | C | TiN

p.B205

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	TiN	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M2	× 0.4	TD821136	8	45	13	2.8	2.1	5	3	1.6
M2.2	× 0.45	TD821156	8	45	13	2.8	2.1	5	3	1.75
*M2.3	× 0.4	TD821196	8	45	13	2.8	2.1	5	3	1.9
M2.5	× 0.45	TD821176	9	50	15	2.8	2.1	5	3	2.05
*M2.6	× 0.45	TD821496	9	50	15	2.8	2.1	5	3	2.1
M3	× 0.5	TD821206	11	56	18	3.5	2.7	6	3	2.5
M3.5	× 0.6	TD821226	12	56	20	4	3	6	3	2.9
M4	× 0.7	TD821246	13	63	21	4.5	3.4	6	3	3.3
M4.5	× 0.75	TD821266	14	70	25	6	4.9	8	3	3.7
M5	× 0.8	TD821286	15	70	25	6	4.9	8	4	4.2
M6	× 1.0	TD821316	17	80	30	6	4.9	8	4	5
M7	× 1.0	TD821346	17	80	30	7	5.5	8	4	6
M8	× 1.25	TD821366	20	90	35	8	6.2	9	4	6.8
M9	× 1.25	TD821396	20	90	35	9	7	10	4	7.8
M10	× 1.5	TD821426	22	100	39	10	8	11	4	8.5
M11	× 1.5	TD821466	22	100	40	8	6.2	9	4	9.5
M12	× 1.75	TD821506	24	110	44	9	7	10	4	10.2
M14	× 2.0	TD821546	26	110	44	11	9	12	4	12
M16	× 2.0	TD821606	27	110	44	12	9	12	4	14
M18	× 2.5	TD821656	30	125	50	14	11	14	4	15.5
M20	× 2.5	TD821706	32	140	54	16	12	15	4	17.5
M22	× 2.5	TD821746	32	140	54	18	14.5	17	4	19.5
M24	× 3.0	TD821786	34	160	60	18	14.5	17	4	21
M27	× 3.0	TD821866	36	160	60	20	16	19	4	24
M30	× 3.5	TD821946	40	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							◎														