PRIME TAP

TRE30 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

- ▶ High performance on various ductile materials
- ▶ Specially designed to prevent oversized threads and reduce gauging problems

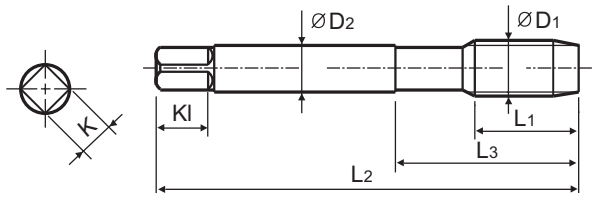
- ▶ Ausgezeichnete Leistung bei verschiedenen Werkstoffen.
- ▶ Speziell entwickelt, um zu gro ß e Gewindedurchmesser zu vermeiden und Messprobleme zu reduzieren.

DIN 371

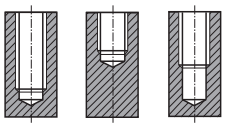


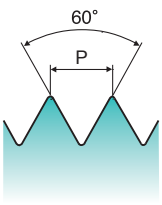
DIN 376

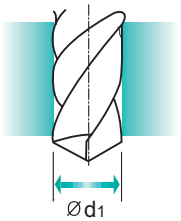




Hole type
2.5×D







Material groups **MU**

HSS PM | DIN 371/376 | 6HX | 60° | C | R45 | X Coating

p.B88

Recommended ToolHolder

Plain Shank
SYNCHRO TAPPING CHUCK
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	X-Coating	L1	L2	L3	ØD2	K	Kl	Z	Ød1
M2	x 0.4	TRE30136GS	3.2	45.0	13.0	2.8	2.1	5.0	2	1.6
M2.5	x 0.45	TRE30176GS	3.6	50.0	15.0	2.8	2.1	5.0	2	2.1
M3	x 0.5	TRE30206GS	4.0	56.0	18.0	3.5	2.7	6.0	3	2.5
M3.5	x 0.6	TRE30226GS	4.8	56.0	20.0	4.0	3.0	6.0	3	2.9
M4	x 0.7	TRE30246GS	5.6	63.0	21.0	4.5	3.4	6.0	3	3.3
M5	x 0.8	TRE30286GS	6.4	70.0	25.0	6.0	4.9	8.0	3	4.2
M6	x 1.0	TRE30316GS	8.0	80.0	30.0	6.0	4.9	8.0	3	5.0
M7	x 1.0	TRE30346GS	10.0	80.0	30.0	7.0	5.5	8.0	3	6.0
M8	x 1.25	TRE30366GS	13.0	90.0	35.0	8.0	6.2	9.0	3	6.8
M9	x 1.25	TRE30396GS	13.0	90.0	35.0	9.0	7.0	10.0	3	7.8
M10	x 1.5	TRE30426GS	15.0	100.0	39.0	10.0	8.0	11.0	3	8.5
M12	x 1.75	TRE30506GS	18.0	110.0	44.0	9.0	7.0	10.0	3	10.3
M14	x 2.0	TRE30546GS	20.0	110.0	44.0	11.0	9.0	12.0	3	12.0
M16	x 2.0	TRE30606GS	20.0	110.0	44.0	12.0	9.0	12.0	3	14.0
M18	x 2.5	TRE30656GS	25.0	125.0	50.0	14.0	11.0	14.0	4	15.5
M20	x 2.5	TRE30706GS	25.0	140.0	54.0	16.0	12.0	15.0	4	17.5
M22	x 2.5	TRE30746GS	25.0	140.0	54.0	18.0	14.5	17.0	4	19.5
M24	x 3.0	TRE30786GS	30.0	160.0	60.0	18.0	14.5	17.0	4	21.0

▶ DIN 371(M2~M10) and DIN 376(M12~M24)

◎ : 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	○	○	◎	◎	○	◎	◎	◎													