# MF ISO Metric Fine Threads DIN 13

MMetrisches ISO-Feingewinde DIN 13
ISO MÉTRIQUE PAS FINS DIN13
ISO Metrico passo fine DIN 13

Machine taps
Maschinengewindebohrer

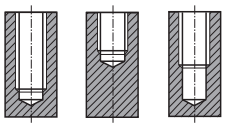
- ▶ High performance on various ductile materials
- ▶ Specially designed to prevent oversized threads and reduce gauging problems

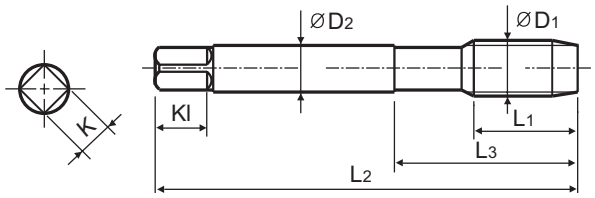
- ▶ Ausgezeichnete Leistung bei verschiedenen Werkstoffen.
- ▶ Speziell entwickelt, um zu gro ß e Gewindedurchmesser zu vermeiden und Messprobleme zu reduzieren.

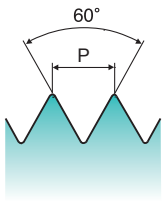
DIN 374

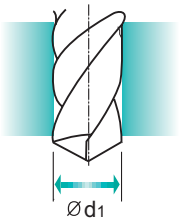


**Hole type**
2.5×D






Material groups **MU**

HSS PM | DIN 374 | 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 |
| M4 x | 0.5 | TRE31256GS | 5.6 | 63.0 | 21.0 | 2.8 | 2.1 | 5.0 | 3 | 3.5 |
| M4 x | 0.35 | TRE31696GS | 5.6 | 63.0 | 21.0 | 2.8 | 2.1 | 5.0 | 3 | 3.7 |
| M5 x | 0.5 | TRE31296GS | 6.4 | 70.0 | 25.0 | 3.5 | 2.7 | 6.0 | 3 | 4.5 |
| M6 x | 0.75 | TRE31326GS | 8.0 | 80.0 | 30.0 | 4.5 | 3.4 | 6.0 | 3 | 5.3 |
| M6 x | 0.5 | TRE31336GS | 8.0 | 80.0 | 30.0 | 4.5 | 3.4 | 6.0 | 3 | 5.5 |
| M8 x | 1.0 | TRE31376GS | 10.0 | 90.0 | 36.0 | 6.0 | 4.9 | 8.0 | 3 | 7.0 |
| M8 x | 0.75 | TRE31386GS | 10.0 | 80.0 | 30.0 | 6.0 | 4.9 | 8.0 | 3 | 7.3 |
| M9 x | 1.0 | TRE31406GS | 10.0 | 90.0 | 36.0 | 7.0 | 5.5 | 8.0 | 3 | 8.0 |
| M9 x | 0.75 | TRE31416GS | 10.0 | 80.0 | 30.0 | 7.0 | 5.5 | 8.0 | 3 | 8.3 |
| M10 x | 1.25 | TRE31436GS | 13.0 | 100.0 | 40.0 | 7.0 | 5.5 | 8.0 | 3 | 8.8 |
| M10 x | 1.0 | TRE31446GS | 10.0 | 90.0 | 36.0 | 7.0 | 5.5 | 8.0 | 3 | 9.0 |
| M10 x | 0.75 | TRE31456GS | 10.0 | 90.0 | 36.0 | 7.0 | 5.5 | 8.0 | 3 | 9.3 |
| M12 x | 1.5 | TRE31516GS | 15.0 | 100.0 | 40.0 | 9.0 | 7.0 | 10.0 | 3 | 10.5 |
| M12 x | 1.25 | TRE31526GS | 15.0 | 100.0 | 40.0 | 9.0 | 7.0 | 10.0 | 3 | 10.8 |
| M12 x | 1.0 | TRE31536GS | 15.0 | 100.0 | 40.0 | 9.0 | 7.0 | 10.0 | 3 | 11.0 |
| M14 x | 1.5 | TRE31556GS | 15.0 | 100.0 | 40.0 | 11.0 | 9.0 | 12.0 | 3 | 12.5 |
| M14 x | 1.25 | TRE31566GS | 15.0 | 100.0 | 40.0 | 11.0 | 9.0 | 12.0 | 3 | 12.8 |
| M14 x | 1.0 | TRE31576GS | 15.0 | 100.0 | 40.0 | 11.0 | 9.0 | 12.0 | 3 | 13.0 |
| M16 x | 1.5 | TRE31616GS | 15.0 | 100.0 | 40.0 | 12.0 | 9.0 | 12.0 | 3 | 14.5 |
| M16 x | 1.0 | TRE31626GS | 15.0 | 100.0 | 40.0 | 12.0 | 9.0 | 12.0 | 3 | 15.0 |

▶ NEXT PAGE

◎ : 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 | ○ | ○ | ◎ | ◎ | ○ | ◎ | ◎ | ◎ | | | | | | | | | | | | | |

# PRIME TAP

**TRE31 SERIES**

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ISO MÉTRIQUE PAS FINS DIN13
ISO Metrico passo fine DIN 13

Machine taps
Maschinengewindebohrer

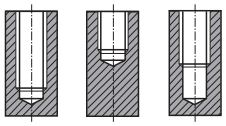
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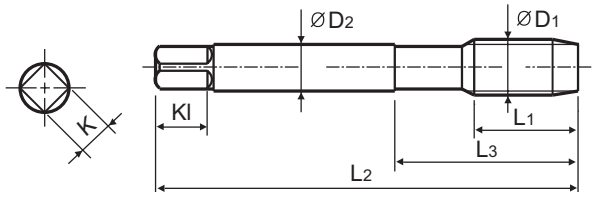
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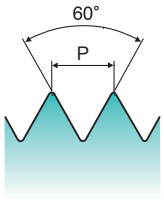
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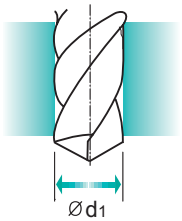


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Unit : mm

| 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 |
| M18 x | 2.0 | TRE31666GS | 20.0 | 125.0 | 50.0 | 14.0 | 11.0 | 14.0 | 4 | 16.0 |
| M18 x | 1.5 | TRE31676GS | 15.0 | 110.0 | 44.0 | 14.0 | 11.0 | 14.0 | 4 | 16.5 |
| M18 x | 1.0 | TRE31686GS | 15.0 | 110.0 | 44.0 | 14.0 | 11.0 | 14.0 | 4 | 17.0 |
| M20 x | 2.0 | TRE31716GS | 20.0 | 140.0 | 54.0 | 16.0 | 12.0 | 15.0 | 4 | 18.0 |
| M20 x | 1.5 | TRE31726GS | 15.0 | 125.0 | 50.0 | 16.0 | 12.0 | 15.0 | 4 | 18.5 |
| M20 x | 1.0 | TRE31736GS | 15.0 | 125.0 | 50.0 | 16.0 | 12.0 | 15.0 | 4 | 19.0 |
| M22 x | 2.0 | TRE31756GS | 20.0 | 140.0 | 54.0 | 18.0 | 14.5 | 17.0 | 4 | 20.0 |
| M22 x | 1.5 | TRE31766GS | 15.0 | 125.0 | 50.0 | 18.0 | 14.5 | 17.0 | 4 | 20.5 |
| M22 x | 1.0 | TRE31776GS | 15.0 | 125.0 | 50.0 | 18.0 | 14.5 | 17.0 | 4 | 21.0 |
| M24 x | 2.0 | TRE31796GS | 20.0 | 140.0 | 54.0 | 18.0 | 14.5 | 17.0 | 4 | 22.0 |
| M24 x | 1.5 | TRE31806GS | 15.0 | 140.0 | 54.0 | 18.0 | 14.5 | 17.0 | 4 | 22.5 |
| M24 x | 1.0 | TRE31816GS | 15.0 | 140.0 | 54.0 | 18.0 | 14.5 | 17.0 | 4 | 23.0 |

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| HB | 60 | 100 | 75 | 90 | 130 | 110 | 90 | 100 | | | 200 | 280 | 250 | 350 | 320 | 400 Rm | 1050 Rm | 550 | 630 | 400 | 550 |
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