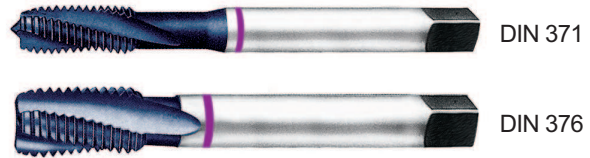
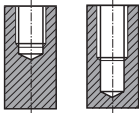


M ISO metric coarse threads DIN 13 Metrisches ISO-Gewinde DIN 13

► Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

► Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

Hole type



Material groups

Ti

HSS-PM

DIN 371/376

6H

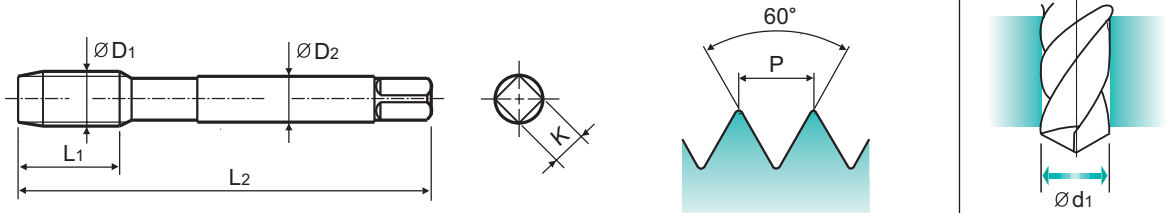
60°

C

TiAlN

R25

Machine taps
Maschinengewindebohrer



Unit : mm

| SIZE | Pitch | EDP No. | Thread Length | Overall Length | Shank Diameter | Square Size | Tapping drill diameter |
|--------|--------|-----------------|---------------|----------------|----------------|-------------|------------------------|
| ØD1 | P | | L1 | L2 | ØD2 | K | Ød1 |
| M2 | × 0.4 | TZ903136 | 8 | 45 | 2.8 | 2.1 | 1.6 |
| M2.2 | × 0.45 | TZ903156 | 8 | 45 | 2.8 | 2.1 | 1.75 |
| * M2.3 | × 0.4 | TZ903196 | 8 | 45 | 2.8 | 2.1 | 1.9 |
| M2.5 | × 0.45 | TZ903176 | 9 | 50 | 2.8 | 2.1 | 2.05 |
| * M2.6 | × 0.45 | TZ903496 | 9 | 50 | 2.8 | 2.1 | 2.1 |
| M3 | × 0.5 | TZ903206 | 6 | 56 | 3.5 | 2.7 | 2.5 |
| M3.5 | × 0.6 | TZ903226 | 7 | 56 | 4 | 3 | 2.9 |
| M4 | × 0.7 | TZ903246 | 7 | 63 | 4.5 | 3.4 | 3.3 |
| M4.5 | × 0.75 | TZ903266 | 8 | 70 | 6 | 4.9 | 3.7 |
| M5 | × 0.8 | TZ903286 | 8 | 70 | 6 | 4.9 | 4.2 |
| M6 | × 1 | TZ903316 | 10 | 80 | 6 | 4.9 | 5 |
| M7 | × 1 | TZ903346 | 10 | 80 | 7 | 5.5 | 6 |
| M8 | × 1.25 | TZ903366 | 13 | 90 | 8 | 6.2 | 6.8 |
| M9 | × 1.25 | TZ903396 | 13 | 90 | 9 | 7 | 7.8 |
| M10 | × 1.5 | TZ903426 | 15 | 100 | 10 | 8 | 8.5 |
| M11 | × 1.5 | TZ903466 | 17 | 100 | 8 | 6.2 | 9.5 |
| M12 | × 1.75 | TZ903506 | 18 | 110 | 9 | 7 | 10.2 |
| M14 | × 2 | TZ903546 | 20 | 110 | 11 | 9 | 12 |
| M16 | × 2 | TZ903606 | 20 | 110 | 12 | 9 | 14 |
| M18 | × 2.5 | TZ903656 | 25 | 125 | 14 | 11 | 15.5 |
| M20 | × 2.5 | TZ903706 | 25 | 140 | 16 | 12 | 17.5 |
| M22 | × 2.5 | TZ903746 | 25 | 140 | 18 | 14.5 | 19.5 |
| M24 | × 3 | TZ903786 | 30 | 160 | 18 | 14.5 | 21 |
| M27 | × 3 | TZ903866 | 30 | 160 | 20 | 16 | 24 |
| M30 | × 3.5 | TZ903946 | 35 | 180 | 22 | 18 | 26.5 |

► DIN 371(M2~M10) and DIN 376(M11~M30)

► * DIN profile not ISO

Unit : N/mm²

◎ : Excellent ○ : Good

| | | | | | | | | | | | | | | |
|-----------------|-------------|----------------|-----------------|------------------|------------------|-----------------|------------------|---------------|---------------|----------------|----------------|--------------------|-------------------|----------------|
| Steel < 400 | Steel < 700 | Steel < 850 | St. Alloy < 850 | St. Alloy ≤ 1200 | St. Alloy > 1200 | INOX Free < 850 | INOX Aust. < 850 | INOX < 1000 | GG Cast < 500 | GG Cast < 1000 | GGG Cast < 700 | GGG Cast < 1000 | Ti < 700 | Ti Alloy < 900 |
| | | | | ○ | | | | | | | | | ○ | ◎ |
| Ti Alloy ≤ 1300 | Ni < 500 | Ni Alloy < 900 | Ni Alloy ≤ 1400 | Cu < 350 | Cu Alloy Short | Cu Alloy Long | Cu-Al-Fe < 1500 | Al / Mg < 350 | Al Wrought | Al Si ≤ 10% | Al Si > 10% | Plastic Thermosoft | Plastic Thermoset | Plastic FRP |
| ◎ | | | | | | | | | | | | | | |