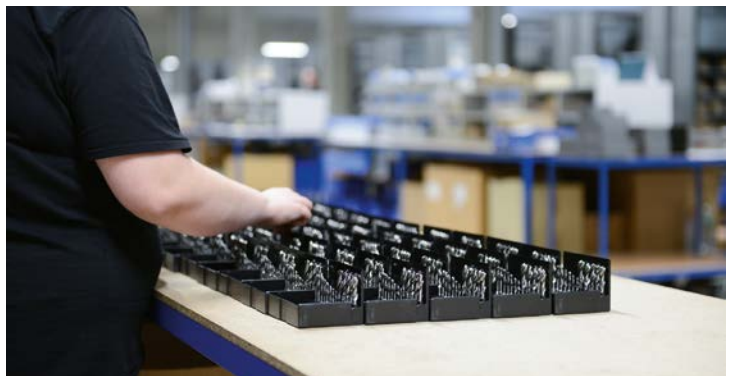
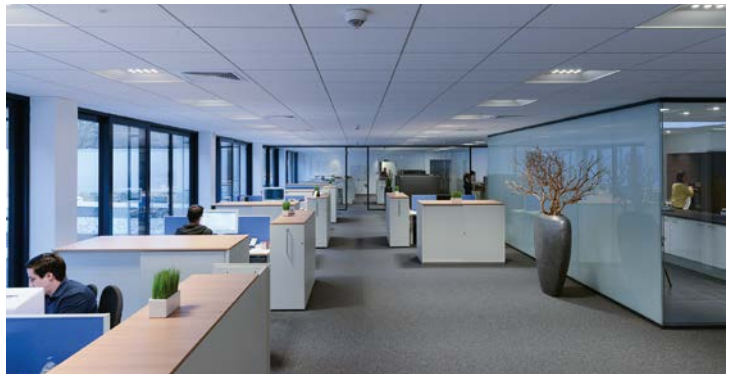


VÖLKE

THREADING SOLUTIONS ■ ■ ■



■ ■ ■ ■ ■ ■ ■ ■ VD 2020



Follow us! VÖLKE on:





SINCE 1915
VÖLKE THREADING SOLUTIONS
– WORLDWIDE COMPETENCE IN
THREAD-CUTTING TOOLS

Based on the experience of more than 100 years in the production of thread cutting tools VÖLKE has developed into a worldwide leading manufacturer of standard thread cutting tools, all available from stock.

As a family business we are able to react flexibly and quickly to future challenges. The families Völkel (Remscheid) and Carrington (Birmingham) are committed to the long-term and sustainable implementation and the compliance of these promises.

DAL 1915
VÖLKE THREADING SOLUTIONS
– COMPETENTI A LIVELLO MONDIALE NEGLI
UTENSILI PER FILETTARE

Grazie a una esperienza più di 100 anni nel campo della filettatura VÖLKE si attese come uno dei leader di mercato nell'offerta di utensili per filettare sempre disponibili a magazzino.

Siamo una azienda familiare in grado di reagire rapidamente e in modo flessibile alle sfide che il mercato ci pone. Le famiglie Völkel (Remscheid) e Carrington (Birmingham) si impegnano per la realizzazione e il mantenimento di progetti durevoli e a lungo termine.

because available ■ because reliable ■ because you ■

because available ■

... because you rely on a availability of more than 99% on all catalogue items

- more than 12.000 articles available on a daily basis
- article in catalogue with an availability of more than 99 %
- dispatch of small orders on the same day
- special dimensions from 1 to 110 mm

...poiché si può contare su una capacità di spedizione immediata di oltre 99% degli articoli a catalogo

- oltre 12.000 prodotti subito disponibili
- disponibilità di magazzino di oltre il 99% di tutti gli articoli a catalogo
- spedizione in giornata
- misure piene e mezze da 1 mm a 110 mm

because reliable ■

... because we keep our promises and you benefit from a guaranteed constant good quality for the industry

- guaranteed constant, good quality for the industry
- high process and service quality
- central: final control, qualitymanagement, storage, picking and distribution

...poiché manteniamo le promesse e potete contare su una qualità e un servizio sempre costante

- potete contare su un livello di qualità uniforme a livello industriale
- elevata qualità di processo e di servizio
- Sede centrale: controllo finale del prodotto, sicurezza della qualità, immagazzinamento, ordinativi, distribuzione

because you ■

... because you are our priority and we offer an attractive package for a successful and profitable cooperation.

...poiché per noi siete il punto centrale e vi offriamo quindi una collaborazione completa ed efficiente.



Die Stocks - Tap Wrenches
Porta-utensili



9 - 13



Hand Taps
Maschi a mano

15 - 43



Short Machine Taps
Maschi macchina corti

45 - 59



HexTap, Bits and Combined Taps
HexTap, utensili con attacco esagonale
e maschi combinati con punte

61 - 73



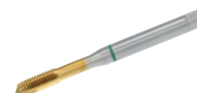
Machine Taps
Maschi a macchina

75 - 132



Machine Taps with coloured ring
Maschi a macchina con collarini colorati

133 - 155



Fluteless (Forming) Taps
Maschi a rulare

157 - 162



Machine Nut Taps
Maschi a macchina per dadi

163 - 165



Round Dies and Hexagon Die Nuts
Filiere e filiere esagonali

169 - 218



Tap & Die Sets
Assortimento

219 - 244



Technical Information
Informazioni tecniche

245 - 258



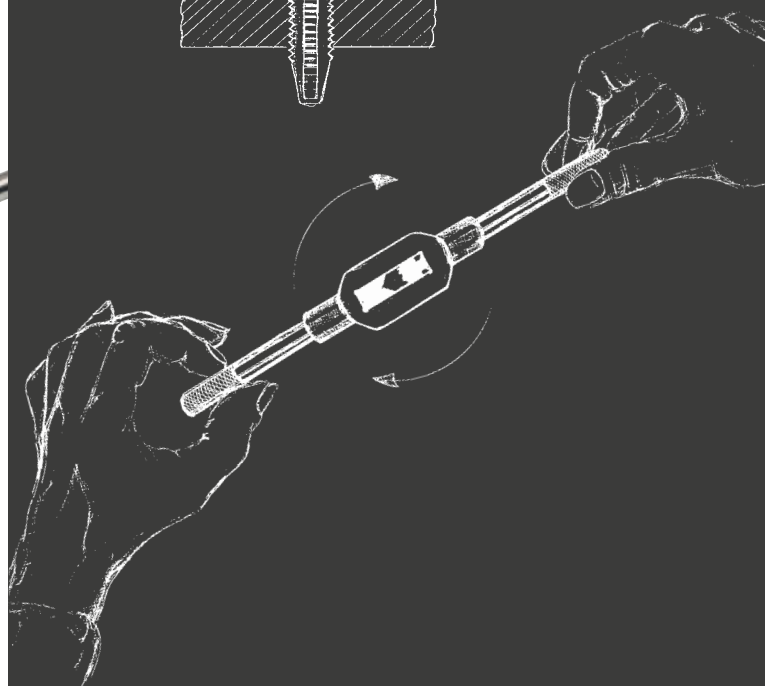
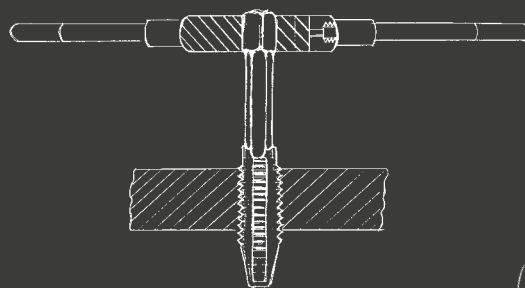
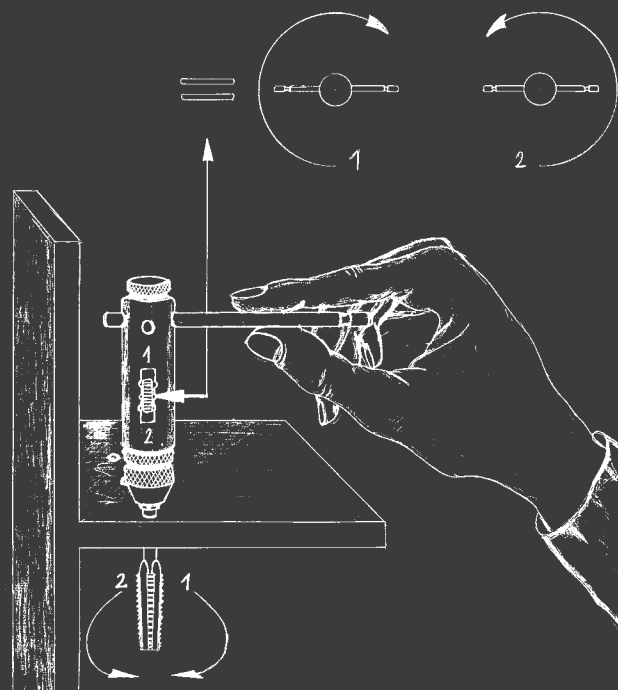
INDEX	M	MF	BSW	BSF	BA	W DIN 477	UNC	UNF	UNEF	UN UNS	UN-8	UN-12
Hand Taps Maschi a mano	16 35	20 37	26	27	28		29	30	31			
Hand Taps - LH Maschi a mano - LH	39	40	41				42	42				
Short Machine Taps Maschi macchina corti	46	49	50			50	51	51				
Combined Taps Maschi combinati con punte	69 73		73				70	70				
HexTap HexTap	63	64										
Machine Taps Maschi a macchina	77	92	99				101	103	107	109	105	105
Machine Taps - LH Maschi a macchina - LH	119	122	128				130	130				
Machine Taps with oversize Maschi a macchina - tolleranza maggiorata	88											
Machine Taps with coloured ring Maschi a macchina con collarini colorati	138 146 148	145 147					145 147 149	145 147				
Fluteless Taps Maschi a rulare	159											
Fluteless Taps with oversize - 6G Maschi a rulare – 6G	162											
Machine Nut Taps Maschi a macchina per dadi	164											
Round Dies Filiere	170 190 193 197	173 191 194 198	179	179	180		181	182	183			
Round Dies - LH Filiere - LH	201	202	205				206	206				
Hexagon Die Nuts Filiere esagonali	208	209	211	211			212	212			213	
Hexagon Die Nuts - LH Filiere esagonali - LH	217											
Tap & Die Sets Assortimento	220 223 226	220 223	224 233	224			225 237	225 237				
INDEX	M	MF	BSW	BSF	BA	W DIN 477	UNC	UNF	UNEF	UN UNS	UN-8	UN-12



INDEX	G BSP	Rc BSPT	Rp BSPP	PG	Tr	NPT	NPTF	NPS	Rd	FG	BSC	Vg
Hand Taps Maschi a mano	32 38			33	34							
Hand Taps - LH Maschi a mano - LH	43											
Short Machine Taps Maschi macchina corti	52	53	54	55		56	58	59				
Combined Taps Maschi combinati con punte												
HexTap HexTap	68											
Machine Taps Maschi a macchina	111	113				114			115	116	117	118
Machine Taps - LH Maschi a macchina - LH	132											
Machine Taps with oversize Maschi a macchina - tolleranza maggiorata												
Machine Taps with coloured ring Maschi a macchina con collarini colorati	145 147											
Fluteless Taps Maschi a rulare												
Fluteless Taps with oversize - 6G Maschi a rulare – 6G												
Machine Nut Taps Maschi a macchina per dadi					165							
Round Dies Filieri	184 192 196 200	185		186		187	187			188	188	189
Round Dies - LH Filieri - LH	207											
Hexagon Die Nuts Filieri esagonali	214	215				216						
Hexagon Die Nuts - LH Filieri esagonali - LH	218											
Tap & Die Sets Assortimento	220 224					225						
INDEX	G BSP	Rc BSPT	Rp BSPP	PG	Tr	NPT	NPTF	NPS	Rd	FG	BSC	Vg



DIE STOCKS - TAP WRENCHES PORTA-UTENSILI





DIE STOCKS - TAP WRENCHES PORTA-UTENSILI

		Zinc die cast pressoprodotto di zinco	Steel esecuzione acciaio	Inch misura pollice
Tap Holder with Ratchet Giramaschi con mandrino			10	
Adjustable Tap Wrenches Giramaschi regolabili		12	12	
Die Stocks Portafilieri		11	11	10
Tap Extensions Prolunghe per maschi	13			

because available ■ because reliable ■ because you ■



Tap Holder with Ratchet

for right- and left-hand-turn


all steel quality

Giramaschi con mandrino

per uso fisso, destro e sinistro

esecuzione acciaio



No.	for Taps	Square mm	Length mm	Weight kg		Art.-No.
1	M 3-10 1/8-3/8	2.4-5.5	85	0,165	10	10001
2	M 5-12 7/32-1/2	4.5-8.0	100	0,310	10	10002
10	M 3-10 1/8-3/8	2.4-5.5	250	0,250	10	10010
20	M 5-12 7/32-1/2	4.5-8.0	300	0,440	10	10020

Jaws and Spring for No. 1 und 10	10	10091
Jaws and Spring for No. 2 und 20	10	10092


Die Stocks

Inch - with 3 screws

Portafiliera misura

pollice con 3 vite



Ø	mm	inch/pollice	Length mm	Weight kg		Art.-No.
13/16"	20.6 x 6.35	13/16 x 1/4	200	0,060	5	15520
1"	25.4 x 9.5	1" x 3/8	224	0,100	5	15525
1.5/16"	33.4 x 11.1	1.5/16 x 7/16	270	0,180	5	15533
1.1/2"	38.1 x 12.7	1.1/2 x 1/2	315	0,320	5	15538
2"	50.8 x 15.9	2" x 5/8	560	0,900	1	15550
2.1/4"	57.1 x 17.5	2.1/4 x 11/16	560	0,900	1	15557
2.1/2"	63.5 x 19.0	2.1/2 x 3/4	630	1,400	1	15563
3"	76.2 x 22.2	3" x 7/8	900	2,200	1	15576
3.1/2"	88.9 x 25.4	3.1/2" x 1"	900	3,300	1	15588
4"	101.6 x 25.4	4" x 1"	1000	3,600	1	15599

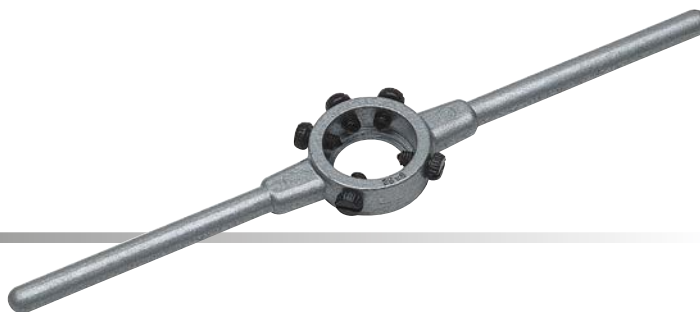



Die Stocks

DIN 225 (DIN EN 22568), Zinc die cast

Portafilieri

DIN 225 (DIN EN 22568), pressogetto di zinco



Ø x mm	for round Dies DIN 223 (DIN EN 22568)			Length mm	Weight kg		Art.-No.
16 x 5	M	1-2.6	BSW 1/16-3/32	160	0,050	5	15001
20 x 5	M	3-4	BSW 1/8-5/32	200	0,065	5	15002
20 x 7	M	4.5-6	BSW 3/16-1/4	200	0,065	5	15003
25 x 9	M	7-9	BSW 5/16	224	0,105	5	15004
30 x 11	M	10-11	BSW 3/8-7/16	280	0,190	5	15005
38 x 10	Mf	12-15	G 1/4	315	0,340	5	15006
38 x 14	M	12-14	BSW 1/2-9/16	315	0,340	5	15007
45 x 14	Mf	16-20	G 3/8-1/2	450	0,650	1	15008
45 x 18	M	16-20	BSW 5/8-13/16	450	0,650	1	15009
55 x 16	Mf	22-26	G 5/8-3/4	560	0,900	1	15010
55 x 22	M	22-24	BSW 7/8-1"	560	0,900	1	15011
65 x 18	Mf	27-36	G 7/8-1"	630	1,400	1	15012
65 x 25	M	27-36	BSW 1.1/8-1.3/8	630	1,400	1	15013


Die Stocks

DIN 225 (DIN EN 22568), **STEEL**

Portafilieri

DIN 225 (DIN EN 22568), **esecuzione acciaio**



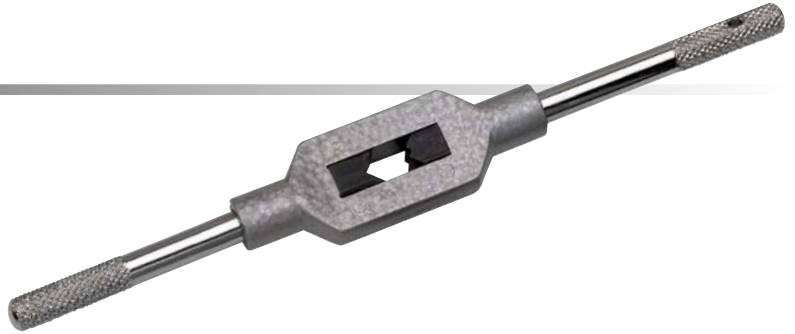
Ø x mm	for round Dies DIN 223 (DIN EN 22568)			Length mm	Weight kg		Art.-No.
45 x 18	M	16-20	BSW 5/8-13/16	450	0,650	1	15209
55 x 22	M	22-24	BSW 7/8-1"	560	0,900	1	15211
65 x 25	M	27-36	BSW 1.1/8-1.3/8	630	1,400	1	15213
75 x 20	Mf	38-42	G 1.1/8-1.1/4	800	2,250	1	15214
75 x 30	M	38-42	BSW 1.1/2-1.5/8	800	2,100	1	15215
90 x 22	Mf	45-52	G 1.3/8-1.5/8	900	3,200	1	15216
90 x 36	M	45-52	BSW 1.3/4-2"	900	3,000	1	15217
105 x 22	Mf	54-63	G 1.3/4-2"	975	3,500	1	15218
105 x 36	M	54-63	BSW 2.1/4"-2.1/2"	975	3,500	1	15219
120 x 22	Mf	64-71	G 2.1/4-2.3/4	956	3,170	1	15220
120 x 36	M	64-71	BSW 2.3/4"	956	3,910	1	15221
130 x 25			G 3"	966	3,505	1	15222
130 x 36				966	4,025	1	15223
140 x 22				976	3,620	1	15224
150 x 25			G 3.1/2"	986	3,950	1	15226
160 x 25			G 4"	996	4,115	1	15228

Adjustable Tap Wrenches

DIN 1814 Zinc die cast

Giramaschi regolabili

DIN 1814, lega leggera



No.	for Taps			Square mm	Length mm	Weight kg		Art.-No.
0	M 1-8	1/16-1/4		2.0-5.0	130	0,050	5	13000
1	M 1-10	1/16-3/8	G 1/8	2.0-6.3	176	0,095	5	13010
1.1/2	M 1-12	1/16-1/2	G 1/8	2.1-8.0	176	0,120	5	13015
2	M 4-12	5/32-1/2	G 1/8	3.0-9.0	280	0,285	5	13020
3	M 5-20	7/32-3/4	G 1/8-1/2	4.9-12	380	0,660	1	13030
4	M 11-27	7/16-1"	G 1/4-3/4	5.5-16	505	1,500	1	13040
5 L	M 13-32	1/2 -1.1/4	G 1/4-1"	7-20	700	1,800	1	13050

Adjustable Tap Wrenches

DIN 1814, **STEEL**

Giramaschi regolabili

DIN 1814, **esecuzione acciaio**



No.	for Taps			Square mm	Length mm	Weight kg		Art.-No.
0	M 1-8	1/16-1/4		2.0-5.0	130	0,050	5	14000
1	M 1-10	1/16-3/8		2.0-6.3	176	0,106	5	14010
1.1/2	M 1-12	1/16-1/2	G 1/8	2.1-8.0	176	0,104	5	14015
2	M 4-12	5/32-1/2	G 1/8	3.0-9.0	280	0,300	5	14020
3	M 5-20	7/32-3/4	G 1/8-1/2	4.9-12	380	0,700	1	14030
4	M 11-27	7/16-1"	G 1/4-3/4	5.5-16	500	1,410	1	14040
5	M 13-32	1/2-1.1/4	G 1/4-1"	7-20	700	1,650	1	14050
6	M 18-42	3/4-1.1/2	G 1/2-1.1/4	11-24	1000	3,250	1	14060
7	M 27-52	1.1/8-2"	G 3/4-1.3/4	16-32	1250	3,700	1	14070
8	M 27-64	1.1/8"-3"	G 3/4-3"	16-40	1250	9,100	1	14080
9	M 39-110		G 1 1/4-4"	22-50	1300	10,260	1	14090



Tap Extensions

DIN 377, Squares according to DIN 10

Prolunghe per maschi

DIN 377, Quadro in base a DIN 10



Square mm	L1	for DIN 352	Art.-No.
2.1	60	M 1-2.6	14521
2.4	70		14524
2.7	80	M 3	14527
3.0	90	M 3.5	14530
3.4	95	M 4	14534
3.8	100		14538
4.3	105		14543
4.9	110	M 4.5-8	14549
5.5	115	M 9-10	14555
6.2	120	M 11	14562
7.0	125	M 12	14570
8.0	125		14580
9.0	130	M 14-16	14590
10.0	140		14610
11.0	150	M 18	14611
12.0	155	M 20	14612
13.0	165		14613
14.5	175	M 22-24	14614
16.0	180	M 27	14616
18.0	200	M 30	14618
20.0	220	M 33	14620
22.0	220	M 36	14622
24.0	235	M 39-42	14624
26.0	250		14626
29.0	265	M 45-48	14629
32.0	285	M 52	14632



HAND TAPS MASCHI A MANO



Nr. 1

Rougher, 6-8 Threads Lead
Sgrossatore, Imbocco a 6-8 spire



Nr. 2

Intermediate, 4-5 Threads Lead
Intermedio, Imbocco a 4-5 spire



Nr. 3

Finisher, 2-3 Threads Lead
Finitore, Imbocco a 2-3 spire



NON-SERIAL FORM VERSIONE CONICA

Nr. 1 - Form A

Finisher, 6-8 Threads Lead
Finitore, Imbocco a 6-8 spire



Nr. 2 - Form D

Finisher, 4-5 Threads Lead
Finitore, Imbocco a 4-5 spire



Nr. 3 - Form C

Finisher, 2-3 Threads Lead
Finitore, Imbocco a 2-3 spire





HAND TAPS MASCHI A MANO

	HSS-G	HSS-E	HSS-G Left Hand/Sinistra
M	16	35	39
Mf	20	37	40
BSW	26		41
BSF	27		
BA	28		
UNC	29		42
UNF	30		42
UNEF	31		
G (BSP)	32	38	43
PG	33		
Tr	34		

Application HSS-G:

- for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

Applicazione HSS-G:

- e per uso universale
- Materiali con buona truciolabilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati

Application HSS-E:

- high cutting ability
- abrasive material
- steels up to 1200 N/mm²
- and general use

Applicazione HSS-E:

- elevata durata
- Materiali di difficile truciolabilità
- Acciaio R fino a 1.200 N/mm²
- E per uso universale

because available ■ because reliable ■ because you ■



Hand Taps

metric ISO-thread DIN 13

Maschi a mano

filettatura metrica ISO DIN 13



DIN 352

HSS-G

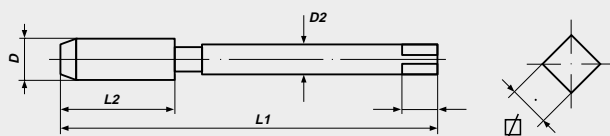
Tol. ISO2/6H

M

Nominal Diameter D	L 1	L 2	D 2	☒	Art.-No.
M 1 x 0.25	32	5.5	2.5	2.1	27302
M 1.1 x 0.25	32	5.5	2.5	2.1	27304
M 1.2 x 0.25	32	5.5	2.5	2.1	27306
M 1.4 x 0.3	32	7.0	2.5	2.1	27308
M 1.6 x 0.35	32	8.0	2.5	2.1	27310
M 1.7 x 0.35	32	8.0	2.5	2.1	27312
M 1.8 x 0.35	32	8.0	2.5	2.1	27314
M 2 x 0.4	36	8.0	2.8	2.1	27316
M 2.2 x 0.45	36	9.0	2.8	2.1	27318
M 2.3 x 0.4	36	9.0	2.8	2.1	27320
M 2.5 x 0.45	40	9.0	2.8	2.1	27322
M 2.6 x 0.45	40	9.0	2.8	2.1	27324
M 3 x 0.5	40	11.0	3.5	2.7	27326
M 3.5 x 0.6	45	13.0	4.0	3.0	27328
M 4 x 0.7	45	13.0	4.5	3.4	27330
M 4.5 x 0.75	50	16.0	6.0	4.9	27332
M 5 x 0.8	50	16.0	6.0	4.9	27334
M 5.5 x 0.9	50	18.0	6.0	4.9	27336
M 6 x 1.0	50	19.0	6.0	4.9	27338
M 7 x 1.0	50	19.0	6.0	4.9	27340
M 8 x 1.25	56	22.0	6.0	4.9	27342
M 9 x 1.25	63	22.0	7.0	5.5	27344
M 10 x 1.5	70	24.0	7.0	5.5	27346
M 11 x 1.5	70	24.0	8.0	6.2	27348
M 12 x 1.75	75	29.0	9.0	7.0	27350
M 14 x 2.0	80	30.0	11.0	9.0	27354
M 15 x 2.0	80	32.0	12.0	9.0	27356
M 16 x 2.0	80	32.0	12.0	9.0	27358
M 18 x 2.5	95	40.0	14.0	11.0	27362
M 20 x 2.5	95	40.0	16.0	12.0	27366
M 22 x 2.5	100	40.0	18.0	14.5	27370
M 24 x 3.0	110	50.0	18.0	14.5	27374
M 27 x 3.0	110	50.0	20.0	16.0	27376
M 30 x 3.5	125	56.0	22.0	18.0	27378
M 33 x 3.5	125	56.0	25.0	20.0	27380
M 36 x 4.0	150	63.0	28.0	22.0	27382
M 39 x 4.0	150	63.0	32.0	24.0	27384
M 42 x 4.5	150	63.0	32.0	24.0	27386
M 45 x 4.5	160	70.0	36.0	29.0	27388
M 48 x 5.0	180	75.0	36.0	29.0	27390
M 52 x 5.0	180	75.0	40.0	32.0	27392
M 56 x 5.5	200	85.0	45.0	35.0	27394
M 60 x 5.5	200	85.0	45.0	35.0	27396
M 64 x 6.0	220	90.0	50.0	39.0	27398
M 68 x 6.0	220	90.0	50.0	39.0	27399

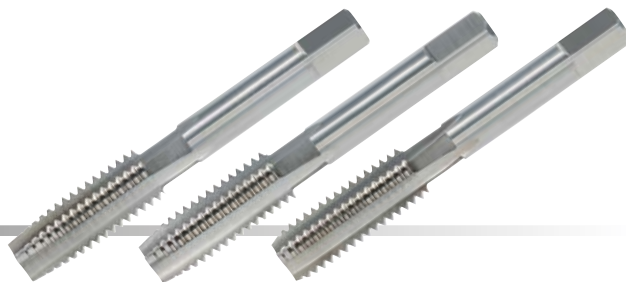
How to order/esempio come ordinare:

M3 = 27326
M3, No. 1 = 27326-1
M3, No. 2 = 27326-2
M3, No. 3 = 27326-3



Hand Taps, *non-serial form* metric ISO-thread DIN 13

Maschi a mano, *versione conica* filettatura metrica ISO DIN 13



DIN 352

HSS-G

Tol. ISO2/6H

M

Nominal Diameter D	L 1	L 2	D 2	☐	Art.-No.
M 2 x 0.4	36	8	2.8	2.1	27616
M 2.5 x 0.45	40	9	2.8	2.1	27622
M 3 x 0.5	40	11	3.5	2.7	27626
M 4 x 0.7	45	13	4.5	3.4	27630
M 5 x 0.8	50	16	6.0	4.9	27634
M 6 x 1.0	50	19	6.0	4.9	27638
M 8 x 1.25	56	22	6.0	4.9	27642
M 9 x 1.25	63	22	7.0	5.5	27644
M 10 x 1.5	70	24	7.0	5.5	27646
M 11 x 1.5	70	24	8.0	6.2	27648
M 12 x 1.75	75	29	9.0	7.0	27650
M 13 x 1.75	75	29	9.0	7.0	27652
M 14 x 2.0	80	30	11.0	9.0	27654
M 16 x 2.0	80	32	12.0	9.0	27658
M 18 x 2.5	95	40	14.0	11.0	27662
M 19 x 2.5	95	40	14.0	11.0	27664
M 20 x 2.5	95	40	16.0	12.0	27666
M 22 x 2.5	100	40	18.0	14.5	27670
M 24 x 3.0	110	50	18.0	14.5	27674
M 27 x 3.0	110	50	20.0	16.0	27676
M 30 x 3.5	125	56	22.0	18.0	27678
M 33 x 3.5	125	56	25.0	20.0	27680
M 36 x 4.0	150	63	28.0	22.0	27682
M 39 x 4.0	150	63	32.0	24.0	27684
M 42 x 4.5	150	63	32.0	24.0	27686
M 3 x 0.6	40	11	3.5	2.7	27627
M 4 x 0.75	45	13	4.5	3.4	27631
M 5 x 0.9	50	16	6.0	4.9	27635

Application:

for general use

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

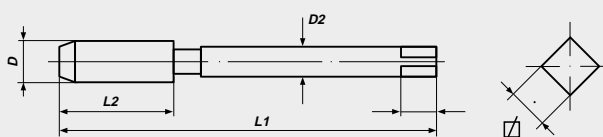
How to order/esempio come ordinare:

M3	=	27626
M3, No. 1	=	27626-1
M3, No. 2	=	27626-2
M3, No. 3	=	27626-3

Applicazione:

per uso universale

- Materiali con buona truciabilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- Fori passanti e ciechi
- Uso manuale



**Hand Taps, *non-serial form***

metric ISO-thread DIN 13

Maschi a mano, *versione conica*

filettatura metrica ISO DIN 13

**ISO 529****HSS-G****Tol. ISO2/6H****M**

Nominal Diameter D	L 1	L 2	D 2	☒	Art.-No.
M 3 x 0.5	48	11	3.15	2.5	80426
M 4 x 0.7	53	13	4.0	3.15	80430
M 5 x 0.8	58	16	5.0	4.0	80434
M 6 x 1.0	66	19	6.3	5.0	80438
M 8 x 1.25	72	22	8.0	6.3	80442
M 10 x 1.5	80	24	10.0	8.0	80446
M 12 x 1.75	89	29	9.0	7.1	80450
M 14 x 2.0	95	30	11.2	9.0	80454
M 16 x 2.0	102	32	12.5	10.0	80458
M 18 x 2.5	110	37	14.0	11.2	80462
M 20 x 2.5	112	37	14.0	11.2	80466
M 22 x 2.5	118	38	16.0	12.5	80470
M 24 x 3.0	130	45	18.0	14.0	80474

Application:**for general use**

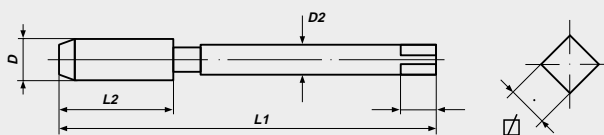
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

Applicazione:**per uso universale**

- Materiali con buona trucidabilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- Fori passanti e ciechi
- Uso manuale

How to order/esempio come ordinare:

M3 = 80426
M3, No. 1 = 80426-1
M3, No. 2 = 80426-2
M3, No. 3 = 80426-3





Hand Taps

metric-fine ISO-thread DIN 13

Maschi a mano

filettatura metrica fine ISO DIN 13



DIN 2181

HSS-G

Tol. ISO2/6H

Mf

Nominal Diameter D	L 1	L 2	D 2	☒	Art.-No.
M 2.5 x 0.35	40	9	2.8	2.1	26304
M 2.6 x 0.35	40	9	2.8	2.1	26305
M 3 x 0.35	40	9	3.5	2.7	26308
M 3.5 x 0.35	45	10	4.0	3.0	26309
M 4 x 0.35	45	10	4.5	3.4	26310
M 4 x 0.5	45	10	4.5	3.4	26312
M 4.5 x 0.5	50	12	6.0	4.9	26313
M 5 x 0.5	50	12	6.0	4.9	26314
M 5 x 0.75	50	12	6.0	4.9	26316
M 5.5 x 0.5	50	12	6.0	4.9	26315
M 6 x 0.5	50	14	6.0	4.9	26317
M 6 x 0.75	50	14	6.0	4.9	26318
M 7 x 0.5	50	14	6.0	4.9	26319
M 7 x 0.75	50	14	6.0	4.9	26320
M 8 x 0.5	50	19	6.0	4.9	26322
M 8 x 0.75	50	19	6.0	4.9	26324
M 8 x 1.0	56	22	6.0	4.9	26326
M 9 x 0.5	56	19	7.0	5.5	26327
M 9 x 0.75	56	19	7.0	5.5	26328
M 9 x 1.0	63	20	7.0	5.5	26330
M 10 x 0.5	63	20	7.0	5.5	26331
M 10 x 0.75	63	20	7.0	5.5	26332
M 10 x 1.0	63	20	7.0	5.5	26336
M 10 x 1.25	70	24	7.0	5.5	26338
M 11 x 0.75	63	20	8.0	6.2	26339
M 11 x 1.0	63	20	8.0	6.2	26340
M 11 x 1.25	63	22	8.0	6.2	26342
M 12 x 0.5	70	22	9.0	7.0	26345
M 12 x 0.75	70	22	9.0	7.0	26343
M 12 x 1.0	70	22	9.0	7.0	26344
M 12 x 1.25	70	22	9.0	7.0	26346
M 12 x 1.5	70	22	9.0	7.0	26348
M 13 x 0.5	70	22	11.0	9.0	26347
M 13 x 0.75	70	22	11.0	9.0	26349
M 13 x 1.0	70	22	11.0	9.0	26350
M 13 x 1.5	70	22	11.0	9.0	26351
M 14 x 0.5	70	22	11.0	9.0	26355



Application:

for general use

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

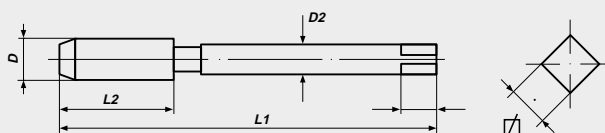
How to order/esempio come ordinare:

M3 x 0.35 = 26308
M3 x 0.35, No. 1 = 26308-1
M3 x 0.35, No. 2 = 26308-2

Applicazione:

per uso universale

- Materiali con buona truciabilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- Fori passanti e ciechi
- Uso manuale





Hand Taps

metric-fine ISO-thread DIN 13

Maschi a mano

filettatura metrica fine ISO DIN 13

**DIN 2181****HSS-G****Tol. ISO2/6H****Mf**

Nominal Diameter D	L 1	L 2	D 2	☒	Art.-No.
M 14 x 0.75	70	22	11.0	9.0	26352
M 14 x 1.0	70	22	11.0	9.0	26353
M 14 x 1.25	70	22	11.0	9.0	26354
M 14 x 1.5	70	22	11.0	9.0	26356
M 15 x 0.75	70	22	12.0	9.0	26357
M 15 x 1.0	70	22	12.0	9.0	26358
M 15 x 1.5	70	22	12.0	9.0	26360
M 16 x 0.5	70	22	12.0	9.0	26361
M 16 x 0.75	70	22	12.0	9.0	26363
M 16 x 1.0	70	22	12.0	9.0	26362
M 16 x 1.25	70	22	12.0	9.0	26364
M 16 x 1.5	70	22	12.0	9.0	26366
M 17 x 1.0	70	22	12.0	9.0	26368
M 17 x 1.5	70	22	12.0	9.0	26369
M 18 x 0.5	80	22	14.0	11.0	26367
M 18 x 0.75	80	22	14.0	11.0	26373
M 18 x 1.0	80	22	14.0	11.0	26370
M 18 x 1.25	80	22	14.0	11.0	26371
M 18 x 1.5	80	22	14.0	11.0	26372
M 18 x 2.0	80	22	14.0	11.0	26374
M 19 x 1.0	80	22	14.0	11.0	26375
M 19 x 1.5	80	22	14.0	11.0	26376
M 20 x 0.5	80	22	16.0	12.0	26377
M 20 x 0.75	80	22	16.0	12.0	26379
M 20 x 1.0	80	22	16.0	12.0	26378
M 20 x 1.25	80	22	16.0	12.0	26380
M 20 x 1.5	80	22	16.0	12.0	26384
M 20 x 2.0	80	22	16.0	12.0	26386
M 21 x 1.0	80	22	16.0	12.0	26387
M 21 x 1.5	80	22	16.0	12.0	26388
M 22 x 0.5	80	22	18.0	14.5	26389
M 22 x 0.75	80	22	18.0	14.5	26391
M 22 x 1.0	80	22	18.0	14.5	26390
M 22 x 1.25	80	22	18.0	14.5	26392
M 22 x 1.5	80	22	18.0	14.5	26394
M 22 x 2.0	80	22	18.0	14.5	26396
M 23 x 1.0	80	22	18.0	14.5	26397
M 23 x 1.5	80	22	18.0	14.5	26398
M 24 x 0.5	90	22	18.0	14.5	26501
M 24 x 0.75	90	22	18.0	14.5	26503
M 24 x 1.0	90	22	18.0	14.5	26500
M 24 x 1.25	90	22	18.0	14.5	26502
M 24 x 1.5	90	22	18.0	14.5	26504
M 24 x 2.0	90	22	18.0	14.5	26506
M 25 x 1.0	90	22	18.0	14.5	26507
M 25 x 1.5	90	22	18.0	14.5	26508
M 26 x 1.0	90	22	18.0	14.5	26510
M 26 x 1.5	90	22	18.0	14.5	26512
M 26 x 2.0	90	22	18.0	14.5	26514
M 27 x 1.0	90	22	20.0	16.0	26516



Hand Taps

metric-fine ISO-thread DIN 13

Maschi a mano

filettatura metrica fine ISO DIN 13



DIN 2181

HSS-G

Tol. ISO2/6H

Mf

Nominal Diameter D	L 1	L 2	D 2	☑	Art.-No.
M 27 x 1.5	90	22	20.0	16.0	26517
M 27 x 2.0	90	22	20.0	16.0	26518
M 28 x 1.0	90	22	20.0	16.0	26520
M 28 x 1.5	90	22	20.0	16.0	26522
M 28 x 2.0	90	22	20.0	16.0	26524
M 29 x 1.5	90	22	22.0	18.0	26526
M 30 x 1.0	90	22	22.0	18.0	26528
M 30 x 1.5	90	22	22.0	18.0	26530
M 30 x 2.0	90	22	22.0	18.0	26532
M 30 x 2.5	125	56	22.0	18.0	26533
M 30 x 3.0	125	56	22.0	18.0	26534
M 32 x 1.0	90	22	22.0	18.0	26539
M 32 x 1.5	90	22	22.0	18.0	26536
M 32 x 2.0	90	22	22.0	18.0	26535
M 32 x 3.0	125	56	22.0	18.0	26537
M 33 x 1.5	100	25	25.0	20.0	26538
M 33 x 2.0	100	25	25.0	20.0	26540
M 33 x 3.0	125	56	25.0	20.0	26542
M 34 x 1.0	100	25	28.0	22.0	26543
M 34 x 1.5	100	25	28.0	22.0	26544
M 34 x 2.0	125	40	28.0	22.0	26546
M 35 x 1.0	100	25	28.0	22.0	26547
M 35 x 1.5	100	25	28.0	22.0	26548
M 35 x 2.0	125	40	28.0	22.0	26549
M 36 x 1.0	100	25	28.0	22.0	26551
M 36 x 1.5	100	25	28.0	22.0	26550
M 36 x 2.0	125	40	28.0	22.0	26552
M 36 x 3.0	125	40	28.0	22.0	26554
M 37 x 1.5	100	25	28.0	22.0	26553
M 38 x 1.0	100	25	28.0	22.0	26555
M 38 x 1.5	100	25	28.0	22.0	26556
M 38 x 2.0	125	40	28.0	22.0	26557
M 38 x 3.0	125	40	28.0	22.0	26559
M 39 x 1.5	110	25	32.0	24.0	26558
M 39 x 2.0	125	40	32.0	24.0	26560
M 39 x 3.0	125	40	32.0	24.0	26562
M 40 x 1.0	110	25	32.0	24.0	26563
M 40 x 1.5	110	25	32.0	24.0	26564
M 40 x 2.0	125	40	32.0	24.0	26566
M 40 x 3.0	125	40	32.0	24.0	26568
M 42 x 1.0	110	25	32.0	24.0	26569
M 42 x 1.5	110	25	32.0	24.0	26570
M 42 x 2.0	125	40	32.0	24.0	26572
M 42 x 3.0	125	40	32.0	24.0	26574
M 44 x 1.5	110	25	36.0	29.0	26571
M 44 x 2.0	125	40	36.0	29.0	26573
M 45 x 1.0	110	25	36.0	29.0	26575
M 45 x 1.5	110	25	36.0	29.0	26576
M 45 x 2.0	125	40	36.0	29.0	26578
M 45 x 3.0	125	40	36.0	29.0	26580





Hand Taps

metric-fine ISO-thread DIN 13

Maschi a mano

filettatura metrica fine ISO DIN 13

**DIN 2181****HSS-G****Tol. ISO2/6H****Mf**

Nominal Diameter D	L 1	L 2	D 2	☒	Art.-No.
M 46 x 1.5	140	40	36	29.0	26581
M 48 x 1.0	140	40	36	29.0	26583
M 48 x 1.5	140	40	36	29.0	26582
M 48 x 2.0	140	40	36	29.0	26584
M 48 x 3.0	140	40	36	29.0	26586
M 50 x 1.5	140	40	36	29.0	26588
M 50 x 2.0	140	40	36	29.0	26590
M 50 x 3.0	140	40	36	29.0	26592
M 52 x 1.5	140	40	40	32.0	26594
M 52 x 2.0	140	40	40	32.0	26596
M 52 x 3.0	140	40	40	32.0	26598
M 54 x 1.0	140	32	40	32.0	28118
M 54 x 1.5	140	32	40	32.0	28001
M 54 x 2.0	140	36	40	32.0	28002
M 54 x 3.0	140	40	40	32.0	28003
M 54 x 4.0	180	50	40	32.0	28004
M 55 x 1.5	140	32	40	32.0	28005
M 55 x 2.0	140	36	40	32.0	28006
M 55 x 3.0	140	40	40	32.0	28007
M 55 x 4.0	180	50	40	32.0	28008
M 56 x 1.0	140	32	40	32.0	28119
M 56 x 1.5	140	32	40	32.0	28009
M 56 x 2.0	140	36	40	32.0	28010
M 56 x 3.0	140	40	40	32.0	28011
M 56 x 4.0	180	50	40	32.0	28012
M 58 x 1.0	160	32	45	35.0	28120
M 58 x 1.5	160	32	45	35.0	28013
M 58 x 2.0	160	36	45	35.0	28014
M 58 x 3.0	160	40	45	35.0	28015
M 58 x 4.0	200	55	45	35.0	28016
M 60 x 1.5	160	34	45	35.0	28017
M 60 x 2.0	160	36	45	35.0	28018
M 60 x 3.0	160	40	45	35.0	28019
M 60 x 4.0	200	55	45	35.0	28020
M 62 x 1.5	160	34	50	39.0	28021
M 62 x 2.0	160	36	50	39.0	28022
M 62 x 3.0	180	45	50	39.0	28023
M 62 x 4.0	220	55	50	39.0	28024
M 63 x 1.5	160	32	50	39.0	28025
M 64 x 1.5	160	34	50	39.0	28026
M 64 x 2.0	160	36	50	39.0	28027
M 64 x 3.0	180	45	50	39.0	28028
M 64 x 4.0	220	60	50	39.0	28029
M 65 x 1.5	160	34	50	39.0	28030
M 65 x 2.0	160	36	50	39.0	28031
M 65 x 3.0	180	45	50	39.0	28032
M 65 x 4.0	220	60	50	39.0	28033
M 68 x 1.5	160	36	50	39.0	28034
M 68 x 2.0	160	40	50	39.0	28035
M 68 x 3.0	180	50	50	39.0	28036



Hand Taps

metric-fine ISO-thread DIN 13

Maschi a mano

filettatura metrica fine ISO DIN 13



DIN 2181

HSS-G

Tol. ISO2/6H

Mf

Nominal Diameter D	L 1	L 2	D 2	☑	Art.-No.
M 68 x 4.0	220	60	50	39.0	28037
M 70 x 1.5	160	36	50	39.0	28038
M 70 x 2.0	160	40	50	39.0	28039
M 70 x 3.0	200	50	50	39.0	28040
M 70 x 4.0	240	60	50	39.0	28041
M 72 x 1.5	160	36	50	39.0	28042
M 72 x 2.0	160	40	50	39.0	28043
M 72 x 3.0	200	50	50	39.0	28044
M 72 x 4.0	240	60	50	39.0	28045
M 74 x 1.5	160	36	50	39.0	28046
M 74 x 2.0	160	40	50	39.0	28047
M 74 x 3.0	200	50	50	39.0	28048
M 74 x 4.0	240	60	50	39.0	28049
M 75 x 1.5	160	36	50	39.0	28050
M 75 x 2.0	160	40	50	39.0	28051
M 75 x 3.0	200	50	50	39.0	28052
M 75 x 4.0	240	60	50	39.0	28053
M 76 x 1.5	160	36	50	39.0	28054
M 76 x 2.0	160	40	50	39.0	28055
M 76 x 3.0	220	50	50	39.0	28056
M 76 x 4.0	260	60	50	39.0	28057
M 78 x 1.5	160	36	50	39.0	28058
M 78 x 2.0	160	40	50	39.0	28059
M 78 x 3.0	220	55	50	39.0	28060
M 78 x 4.0	260	65	50	39.0	28061
M 80 x 1.5	160	36	50	39.0	28062
M 80 x 2.0	160	40	50	39.0	28063
M 80 x 3.0	220	55	50	39.0	28064
M 80 x 4.0	260	65	50	39.0	28065
M 82 x 1.5	160	36	50	39.0	28066
M 82 x 2.0	160	40	50	39.0	28067
M 82 x 3.0	220	55	50	39.0	28068
M 82 x 4.0	260	65	50	39.0	28069
M 84 x 1.5	160	36	50	39.0	28070
M 84 x 2.0	160	40	50	39.0	28071
M 84 x 3.0	220	55	50	39.0	28072
M 84 x 4.0	260	65	50	39.0	28073
M 85 x 1.5	160	36	50	39.0	28074
M 85 x 2.0	160	40	50	39.0	28075
M 85 x 3.0	220	55	50	39.0	28076
M 85 x 4.0	260	65	50	39.0	28077
M 86 x 1.5	160	36	50	39.0	28078
M 86 x 2.0	160	40	50	39.0	28079
M 86 x 3.0	220	55	50	39.0	28080
M 86 x 4.0	260	65	50	39.0	28081
M 88 x 1.5	160	38	50	39.0	28082
M 88 x 2.0	160	40	50	39.0	28083
M 88 x 3.0	220	55	50	39.0	28084
M 88 x 4.0	260	65	50	39.0	28085
M 90 x 1.5	160	38	50	39.0	28086



Mf

Nominal Diameter D	L 1	L 2	D 2	☑	Art.-No.
M 90 x 2.0	160	40	50	39.0	28087
M 90 x 3.0	220	55	50	39.0	28088
M 90 x 4.0	260	65	50	39.0	28089
M 92 x 1.5	180	40	56	44.0	28090
M 92 x 2.0	180	45	56	44.0	28091
M 92 x 3.0	240	60	56	44.0	28092
M 92 x 4.0	280	70	56	44.0	28093
M 95 x 1.5	180	40	56	44.0	28094
M 95 x 2.0	180	45	56	44.0	28095
M 95 x 3.0	240	60	56	44.0	28096
M 95 x 4.0	280	70	56	44.0	28097
M 96 x 1.5	180	40	56	44.0	28098
M 96 x 2.0	180	45	56	44.0	28099
M 96 x 3.0	240	60	56	44.0	28100
M 96 x 4.0	280	70	56	44.0	28101
M 98 x 1.5	180	40	56	44.0	28102
M 98 x 2.0	180	45	56	44.0	28103
M 98 x 3.0	240	60	56	44.0	28104
M 98 x 4.0	280	70	56	44.0	28105
M 100 x 1.5	180	45	56	44.0	28106
M 100 x 2.0	180	50	56	44.0	28107
M 100 x 3.0	240	65	56	44.0	28108
M 100 x 4.0	280	75	56	44.0	28109
M 105 x 1.5	180	45	56	44.0	28110
M 105 x 2.0	180	50	56	44.0	28111
M 105 x 3.0	240	65	56	44.0	28112
M 105 x 4.0	280	75	56	44.0	28113
M 110 x 1.5	180	45	56	44.0	28114
M 110 x 2.0	180	50	56	44.0	28115
M 110 x 3.0	240	65	56	44.0	28116
M 110 x 4.0	280	75	56	44.0	28117



Hand Taps

Whitworth-thread BS 84

Maschi a mano

filettatura Whitworth BS 84



≈ **DIN 352** **HSS-G** **Tol. med**

BSW

Nominal Diameter D	L 1	L 2	D 2	☐	Art.-No.
BSW 1/16 x 60	36	10	2.5	2.1	22302
BSW 3/32 x 48	36	10	2.8	2.1	22304
BSW 1/8 x 40	40	12	3.5	2.7	22306
BSW 5/32 x 32	45	14	4.5	3.4	22308
BSW 3/16 x 24	50	18	6.0	4.9	22310
BSW 7/32 x 24	50	18	6.0	4.9	22312
BSW 1/4 x 20	50	19	6.0	4.9	22314
BSW 5/16 x 18	56	22	6.0	4.9	22316
BSW 3/8 x 16	70	24	7.0	5.5	22318
BSW 7/16 x 14	70	24	8.0	6.2	22320
BSW 1/2 x 12	75	29	9.0	7.0	22322
BSW 9/16 x 12	80	30	11.0	9.0	22324
BSW 5/8 x 11	80	32	12.0	9.0	22326
BSW 3/4 x 10	95	40	14.0	11.0	22330
BSW 7/8 x 9	100	40	18.0	14.5	22334
BSW 1" x 8	110	50	18.0	14.5	22338
BSW 1.1/8 x 7	132	56	22.0	18.0	22342
BSW 1.1/4 x 7	132	56	22.0	18.0	22346
BSW 1.3/8 x 6	150	63	28.0	22.0	22350
BSW 1.1/2 x 6	150	63	32.0	24.0	22354
BSW 1.5/8 x 5	160	70	32.0	24.0	22358
BSW 1.3/4 x 5	160	70	36.0	29.0	22362
BSW 1.7/8 x 4.1/2	190	80	36.0	29.0	22366
BSW 2" x 4.1/2	190	80	40.0	32.0	22370
BSW 2.1/4 x 4	220	80	45.0	35.0	22372
BSW 2.1/2 x 4	220	80	50.0	39.0	22374
BSW 2.3/4 x 3.1/2	240	80	50.0	39.0	22376
BSW 3" x 3.1/2	260	80	50.0	39.0	22378

Application:

for general use

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

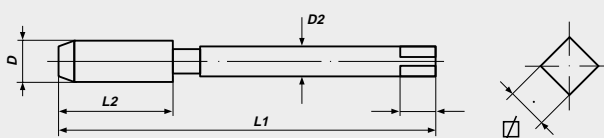
How to order/esempio come ordinare:

BSW 1/8 = 22306
BSW 1/8, No. 1 = 22306-1
BSW 1/8, No. 2 = 22306-2
BSW 1/8, No. 3 = 22306-3

Applicazione:

per uso universale

- Materiali con buona truciabilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- Fori passanti e ciechi
- Uso manuale





Hand Taps

British-Standard-Fine-thread BS 84

Maschi a mano

filettatura Whitworth fine BS 84



≈ DIN 2181 HSS-G Tol. med

BSF

Nominal Diameter D	L 1	L 2	D 2	☑	Art.-No.
BSF 3/16 x 32	50	14	6.0	4.9	22710
BSF 1/4 x 26	50	18	6.0	4.9	22714
BSF 5/16 x 22	56	22	6.0	4.9	22716
BSF 3/8 x 20	63	22	7.0	5.5	22718
BSF 7/16 x 18	63	22	8.0	6.2	22720
BSF 1/2 x 16	75	24	9.0	7.0	22722
BSF 9/16 x 16	80	28	11.0	9.0	22724
BSF 5/8 x 14	80	28	12.0	9.0	22726
BSF 3/4 x 12	95	32	14.0	11.0	22730
BSF 7/8 x 11	100	36	18.0	14.5	22734
BSF 1" x 10	110	40	18.0	14.5	22738

Application:

for general use

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

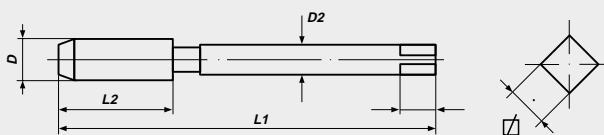
How to order/esempio come ordinare:

BSF 1/4 = 22714
BSF 1/4, No. 1 = 22714-1
BSF 1/4, No. 3 = 22714-3

Applicazione:

per uso universale

- Materiali con buona trucioidibilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- Fori passanti e ciechi
- Uso manuale





Hand Taps

Unified Coarse thread ANSI B 1.1

Maschi a mano

filettatura unificata, serie grossa ANSI B1.1



≈ **DIN 352** **HSS-G** **Tol. 2B**

UNC

Nominal Diameter D	L 1	L 2	D 2	☐	Art.-No.
UNC Nr. 1 x 64	32	10	2.5	2.1	23301
UNC Nr. 2 x 56	36	11	2.8	2.1	23302
UNC Nr. 3 x 48	36	11	2.8	2.1	23303
UNC Nr. 4 x 40	40	12	3.5	2.7	23304
UNC Nr. 5 x 40	40	12	3.5	2.7	23305
UNC Nr. 6 x 32	45	14	4.0	3.0	23306
UNC Nr. 8 x 32	45	14	4.5	3.4	23308
UNC Nr. 10 x 24	50	16	6.0	4.9	23310
UNC Nr. 12 x 24	50	18	6.0	4.9	23312
UNC 1/4 x 20	50	19	6.0	4.9	23314
UNC 5/16 x 18	56	22	6.0	4.9	23316
UNC 3/8 x 16	70	24	7.0	5.5	23318
UNC 7/16 x 14	70	24	8.0	6.2	23320
UNC 1/2 x 13	75	29	9.0	7.0	23322
UNC 9/16 x 12	80	30	11.0	9.0	23324
UNC 5/8 x 11	80	32	12.0	9.0	23326
UNC 3/4 x 10	95	40	14.0	11.0	23330
UNC 7/8 x 9	100	40	18.0	14.5	23334
UNC 1" x 8	110	50	18.0	14.5	23338
UNC 1.1/8 x 7	132	56	22.0	18.0	23342
UNC 1.1/4 x 7	132	56	22.0	18.0	23346
UNC 1.3/8 x 6	150	63	28.0	22.0	23350
UNC 1.1/2 x 6	150	63	32.0	24.0	23354
UNC 1.5/8 x 5	160	70	32.0	24.0	23358
UNC 1.3/4 x 5	160	70	36.0	29.0	23362
UNC 1.7/8 x 4.1/2	190	80	36.0	29.0	23366
UNC 2" x 4.1/2	190	80	40.0	32.0	23370
UNC 2.1/4 x 4.1/2	220	80	45.0	35.0	23372
UNC 2.1/2 x 4	220	80	50.0	39.0	23374
UNC 2.3/4 x 4	240	80	50.0	39.0	23376
UNC 3" x 4	260	80	50.0	39.0	23378

Application:

for general use

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

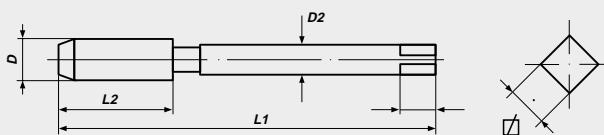
How to order/esempio come ordinare:

UNC 1/4 = 23314
UNC 1/4, No. 1 = 23314-1
UNC 1/4, No. 2 = 23314-2
UNC 1/4, No. 3 = 23314-3

Applicazione:

per uso universale

- Materiali con buona truciabilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- Fori passanti e ciechi
- Uso manuale



Hand Taps

Unified Fine thread ANSI B 1.1

Maschi a mano

filettatura unificata, serie fina ANSI B1.1



≈ **DIN 2181** **HSS-G** **Tol. 2B**

UNF

Nominal Diameter D	L 1	L 2	D 2	☒	Art.-No.
UNF Nr. 0 x 80	28	8	2.5	2.1	24300
UNF Nr. 1 x 72	32	9	2.8	2.1	24301
UNF Nr. 2 x 64	32	10	2.8	2.1	24302
UNF Nr. 3 x 56	32	10	2.8	2.1	24303
UNF Nr. 4 x 48	36	11	3.5	2.7	24304
UNF Nr. 5 x 44	36	11	3.5	2.7	24305
UNF Nr. 6 x 40	40	12	4.5	3.4	24306
UNF Nr. 8 x 36	40	12	4.5	3.4	24308
UNF Nr. 10 x 32	45	14	6.0	4.9	24310
UNF Nr. 12 x 28	50	14	6.0	4.9	24312
UNF 1/4 x 28	50	18	6.0	4.9	24314
UNF 5/16 x 24	56	22	6.0	4.9	24316
UNF 3/8 x 24	63	22	7.0	5.5	24318
UNF 7/16 x 20	63	22	8.0	6.2	24320
UNF 1/2 x 20	75	24	9.0	7.0	24322
UNF 9/16 x 18	80	28	11.0	9.0	24324
UNF 5/8 x 18	80	28	12.0	9.0	24326
UNF 3/4 x 16	95	32	14.0	11.0	24330
UNF 7/8 x 14	100	36	18.0	14.5	24334
UNF 1" x 12	110	40	18.0	14.5	24338
UNF 1" x 14	110	40	18.0	14.5	24340
UNF 1.1/8 x 12	110	50	22.0	18.0	24342
UNF 1.1/4 x 12	132	56	22.0	18.0	24346
UNF 1.3/8 x 12	132	56	28.0	22.0	24350
UNF 1.1/2 x 12	150	63	32.0	24.0	24354

Application:

for general use

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

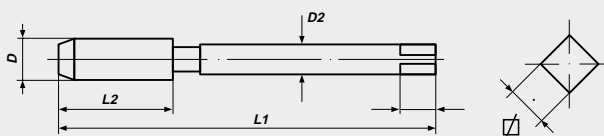
How to order/esempio come ordinare:

UNF 1/4 = 24314
UNF 1/4, No. 1 = 24314-1
UNF 1/4, No. 3 = 24314-3

Applicazione:

per uso universale

- Materiali con buona truciabilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- Fori passanti e ciechi
- Uso manuale





Hand Taps, *non-serial form*

Unified Extra Fine thread ANSI B 1.1

Maschi a mano, *versione conica*

filettatura unificata, serie extra-fina ANSI B1.1



ISO 529

HSS-G

Tol. 2B

UNEF

Nominal Diameter D	L 1	L 2	D 2	☒	Art.-No.
UNEF 1/4 x 32	66	19	6.3	5.0	83821
UNEF 5/16 x 32	72	22	8.0	6.3	83822
UNEF 3/8 x 32	80	24	10.0	8.0	83823
UNEF 7/16 x 28	85	25	8.0	6.3	83824
UNEF 1/2 x 28	89	29	9.0	7.1	83825
UNEF 9/16 x 24	95	30	11.2	9.0	83826
UNEF 5/8 x 24	102	32	12.5	10.0	83827
UNEF 3/4 x 20	112	37	14.0	11.2	83829
UNEF 7/8 x 20	118	38	16.0	12.5	83831
UNEF 1" x 20	130	45	16.0	14.0	83833

Application:

for general use

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

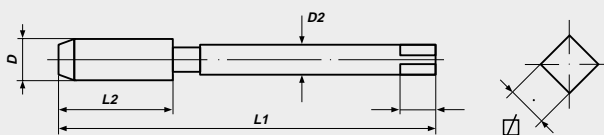
How to order/esempio come ordinare:

UNEF 1/4 = 83821
 UNEF 1/4, No. 1 = 83821-1
 UNEF 1/4, No. 2 = 83821-2
 UNEF 1/4, No. 3 = 83821-3

Applicazione:

per uso universale

- Materiali con buona truciabilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- Fori passanti e ciechi
- Uso manuale





Hand Taps

Pipe-thread DIN ISO 228

Maschi a mano

filettatura per tubi gas DIN ISO 228



DIN 5157 HSS-G

G (BSP)

Nominal Diameter D	L 1	L 2	D 2	☒	Art.-No.
G 1/8 x 28	63	20	7	5.5	25312
G 1/4 x 19	70	22	11	9.0	25314
G 3/8 x 19	70	22	12	9.0	25316
G 1/2 x 14	80	22	16	12.0	25318
G 5/8 x 14	80	22	18	14.5	25320
G 3/4 x 14	90	22	20	16.0	25322
G 7/8 x 14	90	22	22	18.0	25324
G 1" x 11	100	25	25	20.0	25326
G 1.1/8 x 11	125	40	28	22.0	25330
G 1.1/4 x 11	125	40	32	24.0	25334
G 1.3/8 x 11	140	40	36	29.0	25338
G 1.1/2 x 11	140	40	36	29.0	25342
G 1.5/8 x 11	140	40	40	32.0	25346
G 1.3/4 x 11	140	40	40	32.0	25350
G 2" x 11	160	40	45	35.0	25354
G 2.1/4 x 11	160	40	50	39.0	25358
G 2.1/2 x 11	160	40	50	39.0	25362
G 2.3/4 x 11	160	40	50	39.0	25366
G 3" x 11	160	40	50	39.0	25370
G 3.1/2 x 11	180	45	56	44.0	25374
G 4" x 11	180	45	56	44.0	25378

Application:

for general use

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

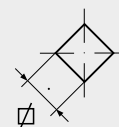
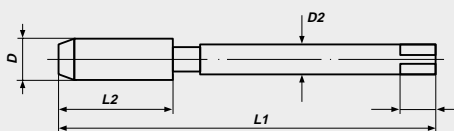
How to order/esempio come ordinare:

G 1/4 = 25314
G 1/4, No. 1 = 25314-1
G 1/4, No. 2 = 25314-2

Applicazione:

per uso universale

- Materiali con buona trucidibilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- Fori passanti e ciechi
- Uso manuale





Hand Taps

armoured tube thread DIN 40 430

Maschi a mano

filettatura per tubi corazzati DIN 40 430



DIN 40432 HSS-G

PG

Nominal Diameter D	L 1	L 2	D 2	☒	Art.-No.
PG 7 x 20	70	22	9.0	7.0	25707
PG 9 x 18	70	22	12.0	9.0	25709
PG 11 x 18	80	22	14.0	11.0	25711
PG 13.5 x 18	80	22	16.0	12.0	25713
PG 16 x 18	80	22	18.0	14.5	25716
PG 21 x 16	90	22	22.0	18.0	25721
PG 29 x 16	100	25	28.0	22.0	25729
PG 36 x 16	140	40	36.0	29.0	25736
PG 42 x 16	140	40	40.0	32.0	25742
PG 48 x 16	160	40	45.0	35.0	25748

Application:

for general use

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

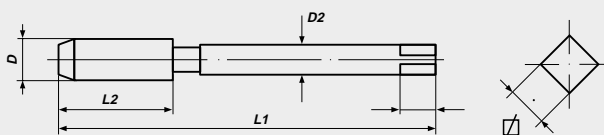
How to order/esempio come ordinare:

PG 7 = 25707
PG 7, No. 1 = 25707-1
PG 7, No. 2 = 25707-2

Applicazione:

per uso universale

- Materiali con buona truciabilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- Fori passanti e ciechi
- Uso manuale





Hand Taps

trapezoidal thread DIN 103

Maschi a mano

filettatura trapeziodale metrica ISO 103



HSS-G

Tol. 7H

Tr

Nominal Diameter D	L 1	L 2	D 2	☐	Art.-No.
Tr 10 x 2	90	34	7	5.5	25108
Tr 10 x 3	100	40	7	5.5	25112
Tr 12 x 3	110	40	8	6.2	25116
Tr 14 x 3	130	45	10	8.0	25120
Tr 14 x 4	130	55	10	8.0	25124
Tr 16 x 4	140	55	11	9.0	25128
Tr 18 x 4	150	55	12	9.0	25132
Tr 20 x 4	160	55	14	11.0	25136
Tr 22 x 5	175	65	16	12.0	25140
Tr 24 x 5	190	65	18	14.5	25144
Tr 26 x 5	210	70	20	16.0	25148
Tr 28 x 5	220	70	22	18.0	25152
Tr 30 x 6	240	80	22	18.0	25156
Tr 32 x 6	255	80	25	20.0	25160

Application:

for general use

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

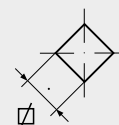
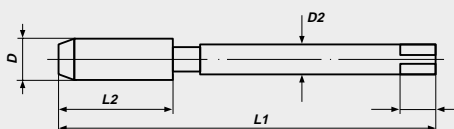
How to order/esempio come ordinare:

Tr 10x2 = 25108
 Tr 10x2, No. 1 = 25108-1
 Tr 10x2, No. 2 = 25108-2
 Tr 10x2, No. 3 = 25108-3

Applicazione:

per uso universale

- Materiali con buona trucidibilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- Fori passanti e ciechi
- Uso manuale





Hand Taps

metric ISO-thread DIN 13

Maschi a mano

filettatura metrica ISO DIN 13

**DIN 352****HSS-E****Tol. ISO2/6H****M**

Nominal Diameter D	L 1	L 2	D 2	☒	Art.-No.
M 3 x 0.5	40	11	3.5	2.7	57326
M 4 x 0.7	45	13	4.5	3.4	57330
M 5 x 0.8	50	16	6.0	4.9	57334
M 6 x 1.0	50	19	6.0	4.9	57338
M 8 x 1.25	56	22	6.0	4.9	57342
M 10 x 1.5	70	24	7.0	5.5	57346
M 12 x 1.75	75	29	9.0	7.0	57350
M 14 x 2.0	80	30	11.0	9.0	57354
M 16 x 2.0	80	32	12.0	9.0	57358
M 18 x 2.5	95	40	14.0	11.0	57362
M 20 x 2.5	95	40	16.0	12.0	57366
M 22 x 2.5	100	40	18.0	14.5	57370
M 24 x 3.0	110	50	18.0	14.5	57374
M 27 x 3.0	110	50	20.0	16.0	57376
M 30 x 3.5	125	56	22.0	18.0	57378

Application:

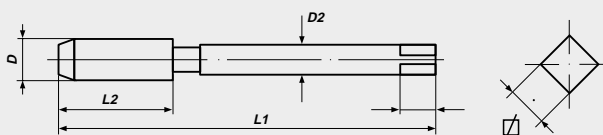
- high cutting ability
- abrasive material
- steels up to 1200 N/mm²
- and general use

Applicazione:

- elevata durata
- materiali di difficile truciolabilità
- Acciaio R fino a 1.200 N/mm²
- e per uso universale

How to order/esempio come ordinare:

M3 = 57326
M3, No. 1 = 57326-1
M3, No. 2 = 57326-2
M3, No. 3 = 57326-3





Hand Taps

metric-fine ISO-thread DIN 13

Maschi a mano

filettatura metrica ISO DIN 13

**DIN 2181****HSS-E****Tol. ISO2/6H****Mf**

Nominal Diameter D	L 1	L 2	D 2	☑	Art.-No.
M 6 x 0.75	50	14	6.0	4.9	56318
M 8 x 0.75	50	19	6.0	4.9	56324
M 8 x 1.0	56	22	6.0	4.9	56326
M 10 x 1.0	63	20	7.0	5.5	56336
M 10 x 1.25	70	24	7.0	5.5	56338
M 12 x 1.0	70	22	9.0	7.0	56344
M 12 x 1.25	70	22	9.0	7.0	56346
M 12 x 1.5	70	22	9.0	7.0	56348
M 14 x 1.25	70	22	11.0	9.0	56354
M 14 x 1.5	70	22	11.0	9.0	56356
M 16 x 1.5	70	22	12.0	9.0	56366
M 18 x 1.5	80	22	14.0	11.0	56372
M 18 x 2.0	80	22	14.0	11.0	56374
M 20 x 1.5	80	22	16.0	12.0	56384
M 20 x 2.0	80	22	16.0	12.0	56386
M 22 x 1.5	80	22	18.0	14.5	56394
M 22 x 2.0	80	22	18.0	14.5	56396
M 24 x 1.5	90	22	18.0	14.5	56504

Application:

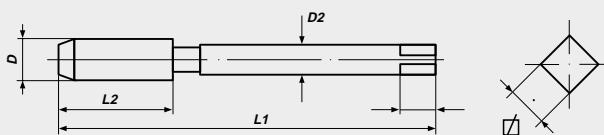
- high cutting ability
- abrasive material
- steels up to 1200 N/mm²
- and general use

Applicazione:

- elevata durata
- materiali di difficile truciolabilità
- Acciaio R fino a 1.200 N/mm²
- e per uso universale

How to order / esempio come ordinare:

M 6 x 0.75 = 56318
M 6 x 0.75, No. 1 = 56318-1
M 6 x 0.75, No. 2 = 56318-2





Hand Taps

Pipe-thread DIN ISO 228

Maschi a mano

filettatura per tubi gas DIN ISO 228



DIN 5157

HSS-E

G (BSP)

Nominal Diameter D	L 1	L 2	D 2	☐	Art.-No.
G 1/8 x 28	63	20	7.0	5.5	55312
G 1/4 x 19	70	22	11.0	9.0	55314
G 3/8 x 19	70	22	12.0	9.0	55316
G 1/2 x 14	80	22	16.0	12.0	55318
G 3/4 x 14	90	22	20.0	16.0	55322
G 1" x 11	100	25	25.0	20.0	55326

Application:

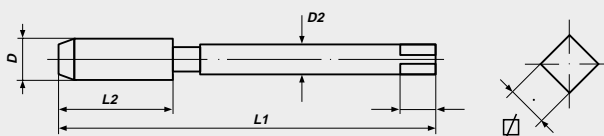
- high cutting ability
- abrasive material
- steels up to 1200 N/mm²
- and general use

Applicazione:

- elevata durata
- materiali di difficile truciolabilità
- Acciaio R fino a 1.200 N/mm²
- e per uso universale

How to order/esempio come ordinare:

G 1/4 = 55314
G 1/4, No. 1 = 55314-1
G 1/4, No. 2 = 55314-2



**Hand Taps, *Left Hand***

metric ISO-thread DIN 13

Maschi a mano, *filetto sinistro*

filettatura metrica fine ISO DIN 13

**DIN 352****HSS-G****Tol. ISO2/6H****M**

Nominal Diameter D	L 1	L 2	D 2	☒	Art.-No.
M 3 x 0.5	40	11	3.5	2.7	27026
M 4 x 0.7	45	13	4.5	3.4	27030
M 5 x 0.8	50	16	6.0	4.9	27034
M 6 x 1.0	50	19	6.0	4.9	27038
M 8 x 1.25	56	22	6.0	4.9	27042
M 10 x 1.5	70	24	7.0	5.5	27046
M 12 x 1.75	75	29	9.0	7.0	27050
M 14 x 2.0	80	30	11.0	9.0	27054
M 16 x 2.0	80	32	12.0	9.0	27058
M 18 x 2.5	95	40	14.0	11.0	27062
M 20 x 2.5	95	40	16.0	12.0	27066
M 22 x 2.5	100	40	18.0	14.5	27070
M 24 x 3.0	110	50	18.0	14.5	27074
M 27 x 3.0	110	50	20.0	16.0	27076
M 30 x 3.5	125	56	22.0	18.0	27078
M 33 x 3.5	125	56	25.0	20.0	27080
M 36 x 4.0	150	63	28.0	22.0	27082
M 39 x 4.0	150	63	32.0	24.0	27084
M 42 x 4.5	150	63	32.0	24.0	27086
M 45 x 4.5	160	70	36.0	29.0	27088
M 48 x 5.0	180	75	36.0	29.0	27090
M 52 x 5.0	180	75	40.0	32.0	27092

Application:**for general use**

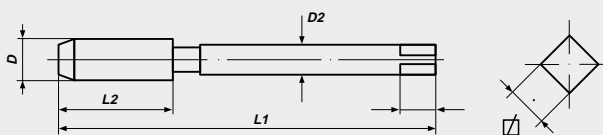
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

Applicazione:**per uso universale**

- Materiali con buona trucidabilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- Fori passanti e ciechi
- Uso manuale

How to order/esempio come ordinare:

M3 = 27026
M3, No. 1 = 27026-1
M3, No. 2 = 27026-2
M3, No. 3 = 27026-3





Hand Taps, *Left Hand*
metric-fine ISO-thread DIN 13

Maschi a mano, *filetto sinistro*
filettatura metrica fine ISO DIN 13



DIN 2181 HSS-G Tol. ISO2/6H

Mf

Nominal Diameter D	L 1	L 2	D 2	☒	Art.-No.
M 6 x 0.75	50	14	6.0	4.9	26007
M 8 x 0.75	50	19	6.0	4.9	26010
M 8 x 1.0	56	22	6.0	4.9	26011
M 10 x 1.0	63	20	7.0	5.5	26015
M 10 x 1.25	70	24	7.0	5.5	26016
M 12 x 1.0	70	22	9.0	7.0	26020
M 12 x 1.25	70	22	9.0	7.0	26021
M 12 x 1.5	70	22	9.0	7.0	26022
M 14 x 1.25	70	22	11.0	9.0	26027
M 14 x 1.5	70	22	11.0	9.0	26028
M 16 x 1.0	70	22	12.0	9.0	26031
M 16 x 1.5	70	22	12.0	9.0	26033
M 18 x 1.5	80	22	14.0	11.0	26036
M 20 x 1.5	80	22	16.0	12.0	26040
M 22 x 1.5	80	22	18.0	14.5	26045
M 24 x 1.5	90	22	18.0	14.5	26050
M 24 x 2.0	90	22	18.0	14.5	26051
M 30 x 1.5	90	22	22.0	18.0	26063
M 30 x 2.0	90	22	22.0	18.0	26064

Application:

for general use

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

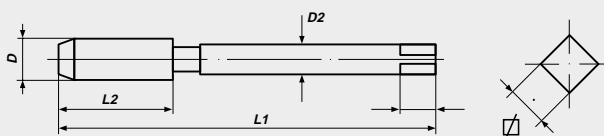
How to order/esempio come ordinare:

M 6 x 0.75 = 26007
M 6 x 0.75, No. 1 = 26007-1
M 6 x 0.75, No. 2 = 26007-2

Applicazione:

per uso universale

- Materiali con buona truciabilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- Fori passanti e ciechi
- Uso manuale





Hand Taps, *Left Hand*

Whitworth-thread BS 84

Maschi a mano, *filetto sinistro*

filettatura Whitworth BS 84



≈ DIN 352 HSS-G Tol. med

BSW

Nominal Diameter D	L 1	L 2	D 2	☑	Art.-No.
BSW 1/8 x 40	40	12	3.5	2.7	22006
BSW 5/32 x 32	45	14	4.5	3.4	22008
BSW 3/16 x 24	50	18	6.0	4.9	22010
BSW 1/4 x 20	50	19	6.0	4.9	22014
BSW 5/16 x 18	56	22	6.0	4.9	22016
BSW 3/8 x 16	70	24	7.0	5.5	22018
BSW 7/16 x 14	70	24	8.0	6.2	22020
BSW 1/2 x 12	75	29	9.0	7.0	22022
BSW 9/16 x 12	80	30	11.0	9.0	22024
BSW 5/8 x 11	80	32	12.0	9.0	22026
BSW 3/4 x 10	95	40	14.0	11.0	22030
BSW 7/8 x 9	100	40	18.0	14.5	22034
BSW 1" x 8	110	50	18.0	14.5	22038

Application:

for general use

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

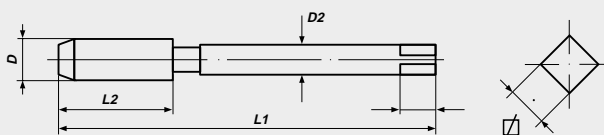
How to order/esempio come ordinare:

BSW 1/8 = 22006
BSW 1/8, No. 1 = 22006-1
BSW 1/8, No. 2 = 22006-2
BSW 1/8, No. 3 = 22006-3

Applicazione:

per uso universale

- Materiali con buona trucidabilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- Fori passanti e ciechi
- Uso manuale





Hand Taps, *Left Hand*

Unified thread ANSI B 1.1

Maschi a mano, *filetto sinistro*

filettatura unificata ANSI B1.1



≈ **DIN 352** **HSS-G** **Tol. 2B**

UNC / UNF

Nominal Diameter D	L 1	L 2	D 2	☐	Art.-No.
-----------------------	-----	-----	-----	---	----------

UNC 3-pcs

UNC	Nr. 6 x 32	45	14	4.0	3.0	23006
UNC	Nr. 8 x 32	45	14	4.5	3.4	23008
UNC	Nr. 10 x 24	50	16	6.0	4.9	23010
UNC	Nr. 12 x 24	50	18	6.0	4.9	23012
UNC	1/4 x 20	50	19	6.0	4.9	23014
UNC	5/16 x 18	56	22	6.0	4.9	23016
UNC	3/8 x 16	70	24	7.0	5.5	23018
UNC	7/16 x 14	70	24	8.0	6.2	23020
UNC	1/2 x 13	75	29	9.0	7.0	23022
UNC	9/16 x 12	80	30	11.0	9.0	23024
UNC	5/8 x 11	80	32	12.0	9.0	23026
UNC	3/4 x 10	95	40	14.0	11.0	23030
UNC	7/8 x 9	100	40	18.0	14.5	23034
UNC	1" x 8	110	50	18.0	14.5	23038

UNF 2-pcs

UNF	Nr. 10 x 32	45	14	6.0	4.9	24010
UNF	1/4 x 28	50	18	6.0	4.9	24014
UNF	5/16 x 24	56	22	6.0	4.9	24016
UNF	3/8 x 24	63	22	7.0	5.5	24018
UNF	7/16 x 20	63	22	8.0	6.2	24020
UNF	1/2 x 20	75	24	9.0	7.0	24022
UNF	9/16 x 18	80	28	11.0	9.0	24024
UNF	5/8 x 18	80	28	12.0	9.0	24026
UNF	3/4 x 16	95	32	14.0	11.0	24030
UNF	7/8 x 14	100	36	18.0	14.5	24034
UNF	1" x 12	110	40	18.0	14.5	24038

Application:

for general use

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

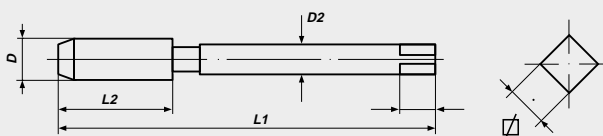
How to order/esempio come ordinare:

UNC 1/4 = 23014
 UNC 1/4, No. 1 = 23014-1
 UNC 1/4, No. 2 = 23014-2
 UNC 1/4, No. 3 = 23014-3

Applicazione:

per uso universale

- Materiali con buona truciabilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- Fori passanti e ciechi
- Uso manuale



**Hand Taps, *Left Hand***

Pipe-thread DIN ISO 228

Maschi a mano, *filetto sinistro*

filettatura per tubi gas DIN ISO 228

**DIN 5157****HSS-G****G (BSP)**

Nominal Diameter D	L 1	L 2	D 2	▣	Art.-No.
G 1/8 x 28	63	20	7.0	5.5	25012
G 1/4 x 19	70	22	11.0	9.0	25014
G 3/8 x 19	70	22	12.0	9.0	25016
G 1/2 x 14	80	22	16.0	12.0	25018
G 5/8 x 14	80	22	18.0	14.5	25020
G 3/4 x 14	90	22	20.0	16.0	25022
G 1" x 11	100	25	25.0	20.0	25026
G 1.1/8 x 11	125	40	28.0	22.0	25030
G 1.1/4 x 11	125	40	32.0	24.0	25034
G 1.3/8 x 11	140	40	36.0	29.0	25038
G 1.1/2 x 11	140	40	36.0	29.0	25042
G 1.3/4 x 11	140	40	40.0	32.0	25050
G 2" x 11	160	40	45.0	35.0	25054

Application:**for general use**

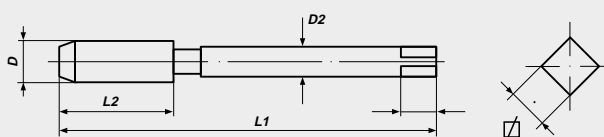
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

How to order/esempio come ordinare:

G 1/4 = 25014
G 1/4, No. 1 = 25014-1
G 1/4, No. 2 = 25014-2

Applicazione:**per uso universale**

- Materiali con buona truciabilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- Fori passanti e ciechi
- Uso manuale





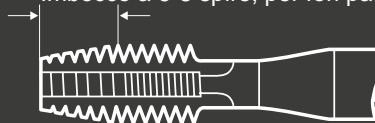
SHORT MACHINE TAPS MASCHI A MACCHINA CORTI



for thread cutting by hand and machine
per uso manuale e con macchina

Form A

6-8 Threads Lead, for short through holes
Imbocco a 6-8 spire, per fori passanti corti



Form B

4-5 Threads Lead with Spiral Point for through holes
Imbocco a 4-5 spire con imbocco corretto, per tutti i fori passanti



Form C

2-3 Threads Lead, for blind holes
Imbocco a 2-3 spire, per fori ciechi



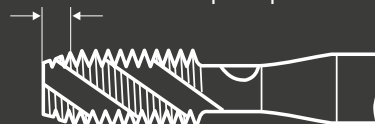
Form D

4-5 Threads Lead, for through and blind holes
Imbocco a 4-5 spire, per fori passante e ciechi



Form C/35° RSP

2-3 Threads Lead, 35° Spiral Flute, for blind holes
Imbocco a 2-3 spire spirale destra a 35°, per fori ciechi



Form B-AZ

4-5 Threads Lead with Spiral Point and interrupted threads
for through holes
Imbocco a 4-5 spire e denti alternati per fori passanti





SHORT MACHINE TAPS MASCHI A MACCHINA CORTI

	Form C	Form D	Form B	35° RSP	B-AZ
M			46	46	46
M (ISO 529)			47	48	47
Mf		49			
BSW		50			
W (DIN 477)	50				
UNC		51			
UNF		51			
G (BSP)		52			
Rc (BSPT)	53		53	53	
Rp (BSPP)	54			54	
PG		55			
NPT	56		56	56	
NPT - LH	57				
NPTF			58	58	
NPS	59			59	

because available ■ because reliable ■ because you ■

Short Machine Taps

metric ISO-thread DIN 13

Maschi a macchina corti

filettatura metrica ISO DIN 13



DIN 352 HSS-E Tol. ISO2/6H

M

Nominal Diameter D	L 1	L 2	D 2	☐	Art.-No.
-----------------------	-----	-----	-----	---	----------

Spiral Point / Forma B con imbocco corretto

M 3 x 0.5	40	11	3.5	2.7	61526
M 4 x 0.7	45	13	4.5	3.4	61530
M 5 x 0.8	48	16	6.0	4.9	61534
M 6 x 1.0	50	19	6.0	4.9	61538
M 8 x 1.25	56	22	6.0	4.9	61542
M 10 x 1.5	70	24	7.0	5.5	61546
M 12 x 1.75	75	29	9.0	7.0	61550
M 14 x 2.0	80	30	11.0	9.0	61554
M 16 x 2.0	80	32	12.0	9.0	61558
M 18 x 2.5	95	40	14.0	11.0	61562
M 20 x 2.5	95	40	16.0	12.0	61566
M 22 x 2.5	100	40	18.0	14.5	61570
M 24 x 3.0	110	50	18.0	14.5	61574

35° Spiral Flute / Forma C, spirale destra a 35°

M 3 x 0.5	40	11	3.5	2.7	61726
M 4 x 0.7	45	13	4.5	3.4	61730
M 5 x 0.8	48	16	6.0	4.9	61734
M 6 x 1.0	50	19	6.0	4.9	61738
M 8 x 1.25	56	22	6.0	4.9	61742
M 10 x 1.5	70	24	7.0	5.5	61746
M 12 x 1.75	75	29	9.0	7.0	61750

with interrupted threads / Forma B, con denti alternati

M 3 x 0.5	40	11	3.5	2.7	61926
M 4 x 0.7	45	13	4.5	3.4	61930
M 5 x 0.8	48	16	6.0	4.9	61934
M 6 x 1.0	50	19	6.0	4.9	61938
M 8 x 1.25	56	22	6.0	4.9	61942
M 10 x 1.5	70	24	7.0	5.5	61946
M 12 x 1.75	75	29	9.0	7.0	61950

Application:

for general use

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for thread cutting by hand and machine

Spiral Point: for through holes

Spiral Flute: for blind holes

Form B-AZ: for through holes

Applicazione:

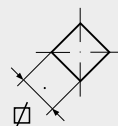
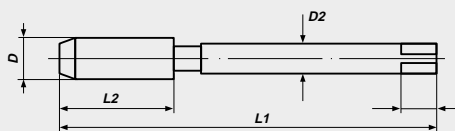
per uso universale

- Materiali con buona trucidibilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per uso manuale e con macchina

Forma B: per fori passanti

35° RSP: per fori ciechi

Forma B-AZ: per fori passanti





Machine Taps

metric ISO-thread DIN 13

Maschi a macchina corti

filettatura metrica ISO DIN 13

**ISO 529****Form B****HSS-G****Tol. ISO2/6H****M**

Nominal Diameter D	L 1	L 2	D 2	Ø	Art.-No.
M 2 x 0.4	41.0	8.0	2.50	2.00	80516
M 2.5 x 0.45	44.5	9.5	2.80	2.24	80522
M 2.6 x 0.45	44.5	9.5	2.90	2.24	80524
M 3 x 0.5	48.0	11.0	3.15	2.50	80526
M 3.5 x 0.6	50.0	13.0	3.55	2.80	80528
M 4 x 0.7	53.0	13.0	4.00	3.15	80530
M 5 x 0.8	58.0	16.0	5.00	4.00	80534
M 6 x 1.0	66.0	19.0	6.30	5.00	80538
M 8 x 1.25	72.0	22.0	8.00	6.30	80542
M 10 x 1.5	80.0	24.0	10.00	8.00	80546
M 12 x 1.75	89.0	29.0	9.00	7.10	80550
M 14 x 2.0	95.0	30.0	11.20	9.00	80554
M 16 x 2.0	102.0	32.0	12.50	10.00	80558
M 18 x 2.5	110.0	37.0	14.00	11.20	80562
M 20 x 2.5	112.0	37.0	14.00	11.20	80566
M 22 x 2.5	118.0	38.0	16.00	12.50	80570
M 24 x 3.0	130.0	45.0	18.00	14.00	80574
M 27 x 3.0	135.0	45.0	20.00	16.00	80576
M 30 x 3.5	138.0	48.0	20.00	16.00	80578

with interrupted threads / con denti alternati

M 3 x 0.5	48.0	11.0	3.15	2.50	80926
M 4 x 0.7	53.0	13.0	4.00	3.15	80930
M 5 x 0.8	58.0	16.0	5.00	4.00	80934
M 6 x 1.0	66.0	19.0	6.30	5.00	80938
M 7 x 1.0	66.0	19.0	7.10	5.60	80940
M 8 x 1.25	72.0	22.0	8.00	6.30	80942
M 10 x 1.5	80.0	24.0	10.0	8.00	80946
M 12 x 1.75	89.0	29.0	9.00	7.10	80950
M 14 x 2.0	95.0	30.0	11.20	9.00	80954
M 16 x 2.0	102.0	32.0	12.50	10.00	80958
M 18 x 2.5	110.0	37.0	14.00	11.20	80962
M 20 x 2.5	112.0	37.0	14.00	11.20	80966
M 22 x 2.5	118.0	38.0	16.00	12.50	80970
M 24 x 3.0	130.0	45.0	18.00	14.00	80974

Application:

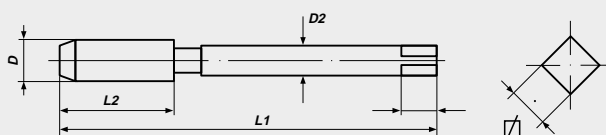
for general use

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through holes
- for thread cutting by hand and machine

Applicazione:

per uso universale

- Materiali con buona truciabilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per fori passanti
- per uso manuale e con macchina





Machine Taps

metric ISO-thread DIN 13

Maschi a macchina corti

filettatura metrica ISO DIN 13



ISO 529

Form C/35°RSP

HSS-G

Tol. ISO2/6H

M

Nominal Diameter D	L 1	L 2	D 2	☐	Art.-No.
M 2.5 x 0.45	44.5	9.5	2.80	2.24	80722
M 2.6 x 0.45	44.5	9.5	2.90	2.24	80724
M 3 x 0.5	48.0	11.0	3.15	2.50	80726
M 4 x 0.7	53.0	13.0	4.00	3.15	80730
M 5 x 0.8	58.0	16.0	5.00	4.00	80734
M 6 x 1.0	66.0	19.0	6.30	5.00	80738
M 8 x 1.25	72.0	22.0	8.00	6.30	80742
M 10 x 1.5	80.0	24.0	10.00	8.00	80746
M 12 x 1.75	89.0	29.0	9.00	7.10	80750
M 14 x 2.0	95.0	30.0	11.20	9.00	80754
M 16 x 2.0	102.0	32.0	12.50	10.00	80758
M 18 x 2.5	110.0	37.0	14.00	11.20	80762
M 20 x 2.5	112.0	37.0	14.00	11.20	80766
M 22 x 2.5	118.0	38.0	16.00	12.50	80770
M 24 x 3.0	130.0	45.0	18.00	14.00	80774
M 27 x 3.0	135.0	45.0	20.00	16.00	80776
M 30 x 3.5	138.0	48.0	20.00	16.00	80778

Application:

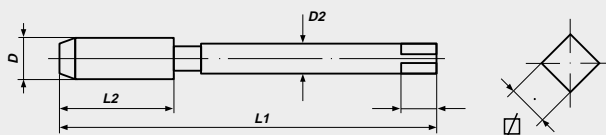
for general use

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through holes
- for thread cutting by hand and machine

Applicazione:

per uso universale

- Materiali con buona trucidabilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per fori ciechi
- per uso manuale e con macchina





Short Machine Taps

metric-fine ISO-thread DIN 13

Maschi a macchina corti

filettatura metrica fine ISO DIN 13

**DIN 2181****Form D****HSS-G****Tol. ISO2/6H****Mf**

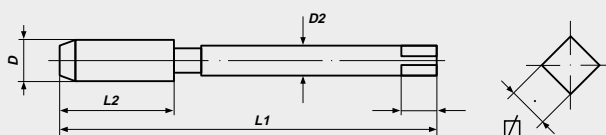
Nominal Diameter D	L 1	L 2	D 2	Ø	Art.-No.
M 6 x 0.75	50	14	6.0	4.9	66318
M 8 x 0.75	50	19	6.0	4.9	66324
M 8 x 1.0	56	22	6.0	4.9	66326
M 9 x 0.75	56	19	7.0	5.5	66328
M 9 x 1.0	63	20	7.0	5.5	66330
M 10 x 0.75	63	20	7.0	5.5	66332
M 10 x 1.0	63	20	7.0	5.5	66336
M 10 x 1.25	70	24	7.0	5.5	66338
M 12 x 0.5	70	22	9.0	7.0	66345
M 12 x 0.75	70	22	9.0	7.0	66343
M 12 x 1.0	70	22	9.0	7.0	66344
M 12 x 1.25	70	22	9.0	7.0	66346
M 12 x 1.5	70	22	9.0	7.0	66348
M 13 x 1.0	70	22	11.0	9.0	66350
M 13 x 1.5	70	22	11.0	9.0	66351
M 14 x 1.0	70	22	11.0	9.0	66353
M 14 x 1.25	70	22	11.0	9.0	66354
M 14 x 1.5	70	22	11.0	9.0	66356
M 15 x 1.5	70	22	12.0	9.0	66360
M 16 x 1.5	70	22	12.0	9.0	66366
M 18 x 1.0	80	22	14.0	11.0	66370
M 18 x 1.5	80	22	14.0	11.0	66372
M 20 x 1.5	80	22	16.0	12.0	66384
M 20 x 2.0	80	22	16.0	12.0	66386
M 22 x 1.5	80	22	18.0	14.5	66394
M 22 x 2.0	80	22	18.0	14.5	66396
M 24 x 1.5	90	22	18.0	14.5	66504
M 24 x 2.0	90	22	18.0	14.5	66506
M 25 x 1.5	90	22	18.0	14.5	66508
M 26 x 1.5	90	22	18.0	14.5	66512
M 27 x 1.5	90	22	20.0	16.0	66517
M 28 x 1.5	90	22	20.0	16.0	66522
M 30 x 1.5	90	22	22.0	18.0	66530
M 30 x 2.0	90	22	22.0	18.0	66532
M 32 x 1.5	90	22	22.0	18.0	66536

Application:**for general use**

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through holes
- for thread cutting by hand and machine

Applicazione:**per uso universale**

- Materiali con buona truciabilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per fori passanti
- per uso manuale e con macchina





Short Machine Taps

Whitworth-thread BS 84

Maschi a macchina corti

filettatura Whitworth BS 84



≈ **DIN 352** **Form D** **HSS-G** **Tol. med.**

BSW

Nominal Diameter S	L 1	L 2	D 2	☑	Art.-No.
BSW 1/8 x 40	40	12	3.5	2.7	62306
BSW 3/16 x 24	50	18	6.0	4.9	62310
BSW 1/4 x 20	50	19	6.0	4.9	62314
BSW 5/16 x 18	56	22	6.0	4.9	62316
BSW 3/8 x 16	70	24	7.0	5.5	62318
BSW 7/16 x 14	70	24	8.0	6.2	62320
BSW 1/2 x 12	75	29	9.0	7.0	62322
BSW 9/16 x 12	80	30	11.0	9.0	62324
BSW 5/8 x 11	80	32	12.0	9.0	62326
BSW 3/4 x 10	95	40	14.0	11.0	62330
BSW 7/8 x 9	100	40	18.0	14.5	62334
BSW 1" x 8	110	50	18.0	14.5	62338

Short Machine Taps

tapered Whitworth screw thread for gas cylinders

taper 3:25, DIN 477

Maschi a macchina corti

filettatura Whitworth conica per bombola di gas

cono 3:25, DIN 477



≈ **DIN 352** **Form C** **HSS-G**

W

Nominal Diameter S	L 1	L 2	D 2	☑	Art.-No.
W 19,8 x 14	90	32	16	12	62397
W 28,8 x 14	100	40	20	16	62398
W 31,3 x 14	110	40	22	18	62399



Short Machine Taps

Unified Coarse and Fine thread ANSI B 1.1

Maschi macchina corti

filettatura unificata, serie grossa e fina ANSI B1.1



≈ **DIN 352** **Form D** **HSS-G** **Tol. 2B**

UNC / UNF

Nominal Diameter S	L 1	L 2	D 2	☐	Art.-No.
-----------------------	-----	-----	-----	---	----------

UNC

UNC 1/4 x 20	50	19	6.0	4.9	63314
UNC 5/16 x 18	56	22	6.0	4.9	63316
UNC 3/8 x 16	70	24	7.0	5.5	63318
UNC 7/16 x 14	70	24	8.0	6.2	63320
UNC 1/2 x 13	75	29	9.0	7.0	63322
UNC 9/16 x 12	80	30	11.0	9.0	63324
UNC 5/8 x 11	80	32	12.0	9.0	63326
UNC 3/4 x 10	95	40	14.0	11.0	63330
UNC 7/8 x 9	100	40	18.0	14.5	63334
UNC 1" x 8	110	50	18.0	14.5	63338

UNF

UNF 1/4 x 28	50	18	6.0	4.9	64314
UNF 5/16 x 24	56	22	6.0	4.9	64316
UNF 3/8 x 24	63	22	7.0	5.5	64318
UNF 7/16 x 20	63	22	8.0	6.2	64320
UNF 1/2 x 20	75	24	9.0	7.0	64322
UNF 9/16 x 18	80	28	11.0	9.0	64324
UNF 5/8 x 18	80	28	12.0	9.0	64326
UNF 3/4 x 16	95	32	14.0	11.0	64330
UNF 7/8 x 14	100	36	18.0	14.5	64334
UNF 1" x 12	110	40	18.0	14.5	64338

Application:

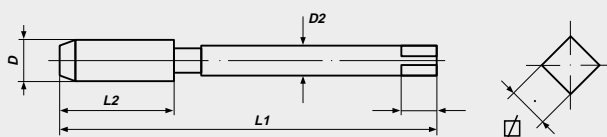
for general use

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through holes
- for thread cutting by hand and machine

Applicazione:

per uso universale

- Materiali con buona trucidibilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per fori passanti
- per uso manuale e con macchina





Short Machine Taps

Pipe-thread DIN ISO 228

Maschi a macchina corti

filettatura per tubi gas DIN ISO 228



DIN 5157

Form D

HSS-G

G (BSP)

Nominal Diameter S	L 1	L 2	D 2	□	Art.-No.
G 1/8 x 28	63	20	7	5.5	65312
G 1/4 x 19	70	22	11	9.0	65314
G 3/8 x 19	70	22	12	9.0	65316
G 1/2 x 14	80	22	16	12.0	65318
G 3/4 x 14	90	22	20	16.0	65322
G 1" x 11	100	25	25	20.0	65326
G 1.1/4 x 11	125	40	32	24.0	65334
G 1.1/2 x 11	140	40	36	29.0	65342
G 1.3/4 x 11	140	40	40	32.0	65350
G 2" x 11	160	40	45	35.0	65354
G 2.1/4 x 11	160	40	50	39.0	65358
G 2.1/2 x 11	160	40	50	39.0	65362
G 2.3/4 x 11	160	40	50	39.0	65366
G 3" x 11	160	40	50	39.0	65370
G 3.1/2 x 11	180	45	56	44.0	65374
G 4" x 11	180	45	56	44.0	65378

Application:

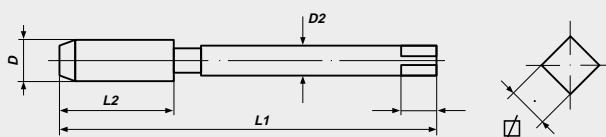
for general use

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through holes
- for thread cutting by hand and machine

Applicazione:

per uso universale

- Materiali con buona truciabilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per fori passanti
- per uso manuale e con macchina





Short Machine Taps

tapered pipe thread, taper 1:16, con. 55°

Maschi a macchina corti

filettatura conica per tubi, cono 1:16



HSS-G / HSSE

Rc (BSPT)

Nominal Diameter S	L 1	L 2	D 2	Ø	Art.-No.
-----------------------	-----	-----	-----	---	----------

Form C, HSS-G

PT 1/8 x 28	65	19.0	7.0	5.5	63712
PT 1/4 x 19	70	25.0	11.0	9.0	63714
PT 3/8 x 19	75	26.0	12.0	9.0	63716
PT 1/2 x 14	80	31.0	16.0	12.0	63718
PT 5/8 x 14	90	32.0	18.0	14.5	63720
PT 3/4 x 14	100	33.0	20.0	16.0	63722
PT 1" x 11	110	38.0	25.0	20.0	63726

Form B, HSSE, Spiral Point / con imbocco corretto

PT 1/16 x 28	55	17.5	8.0	6.0	97502
PT 1/8 x 28	55	19.0	8.0	6.0	97506
PT 1/4 x 19	62	28.0	11.0	9.0	97514
PT 3/8 x 19	65	28.0	14.0	11.0	97518
PT 1/2 x 14	80	35.0	18.0	14.0	97522
PT 3/4 x 14	85	35.0	23.0	17.0	97530
PT 1" x 11	95	45.0	26.0	21.0	97538
PT 1.1/4 x 11	105	45.0	32.0	26.0	97546
PT 1.1/2 x 11	110	45.0	38.0	29.0	97554
PT 2" x 11	120	50.0	46.0	35.0	97570

Form C, HSSE, 35° Spiral Flute / spirale destra a 35°

PT 1/16 x 28	55	17.5	8.0	6.0	97702
PT 1/8 x 28	55	19.0	8.0	6.0	97706
PT 1/4 x 19	62	28.0	11.0	9.0	97714
PT 3/8 x 19	65	28.0	14.0	11.0	97718
PT 1/2 x 14	80	35.0	18.0	14.0	97722
PT 3/4 x 14	85	35.0	23.0	17.0	97730
PT 1" x 11	95	45.0	26.0	21.0	97738
PT 1.1/4 x 11	105	45.0	32.0	26.0	97746
PT 1.1/2 x 11	110	45.0	38.0	29.0	97754
PT 2" x 11	120	50.0	46.0	35.0	97770

Application:

for general use

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for thread cutting by hand and machine

Form C: for through and blind holes

Spiral Point: for through holes

Spiral Flute: for blind holes

Applicazione:

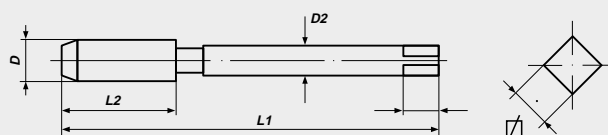
per uso universale

- Materiali con buona trucidibilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per uso manuale e con macchina

Forma C: per fori passanti e ciechi

Forma B: per fori passanti

35° RSP: per fori ciechi





Short Machine Taps

Pipe-thread ISO 7-1 (DIN EN 10226-1)

Maschi a macchina corti

filettatura cilindrica per tubi ISO 7-1 (DIN EN 10226-1)



HSS-G

Rp (BSPP)

Nominal Diameter S	L 1	L 2	D 2	☐	Art.-No.
-----------------------	-----	-----	-----	---	----------

Form C

PS 1/16 x 28	55	19	6.5	5.0	95402
PS 1/8 x 28	55	19	8.0	6.0	95406
PS 1/4 x 19	62	28	11.0	9.0	95414
PS 3/8 x 19	65	28	14.0	11.0	95418
PS 1/2 x 14	80	35	18.0	14.0	95422
PS 3/4 x 14	85	35	23.0	17.0	95430
PS 1" x 11	95	45	26.0	21.0	95438
PS 1.1/4 x 11	105	45	32.0	26.0	95446
PS 1.1/2 x 11	110	45	38.0	29.0	95454
PS 2" x 11	120	50	46.0	35.0	95470

Form C, 35° Spiral Flute / spirale destra a 35°

PS 1/16 x 28	55	19	6.5	5.0	95702
PS 1/8 x 28	55	19	8.0	6.0	95706
PS 1/4 x 19	62	28	11.0	9.0	95714
PS 3/8 x 19	65	28	14.0	11.0	95718
PS 1/2 x 14	80	35	18.0	14.0	95722
PS 3/4 x 14	85	35	23.0	17.0	95730
PS 1" x 11	95	45	26.0	21.0	95738
PS 1.1/4 x 11	105	45	32.0	26.0	95746
PS 1.1/2 x 11	110	45	38.0	29.0	95754
PS 2" x 11	120	50	46.0	35.0	95770

Application:

for general use

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for thread cutting by hand and machine

Form C: for through and blind holes

Spiral Flute: for blind holes

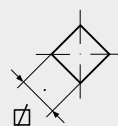
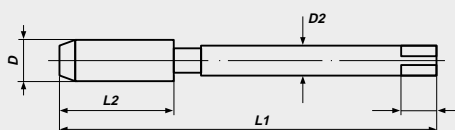
Applicazione:

per uso universale

- Materiali con buona truciabilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per uso manuale e con macchina

Forma C: per fori passanti e ciechi

35° RSP: per fori ciechi





Short Machine Taps

armoured tube thread DIN 40 430

Maschi a macchina corti

filettatura per tubi corazzati DIN 40 430

**DIN 40432****Form D****HSS-G****PG**

Nominal Diameter S	L 1	L 2	D 2	Ø	Art.-No.
PG 7 x 20	70	22	9.0	7.0	65707
PG 9 x 18	70	22	12.0	9.0	65709
PG 11 x 18	80	22	14.0	11.0	65711
PG 13.5 x 18	80	22	16.0	12.0	65713
PG 16 x 18	80	22	18.0	14.5	65716
PG 21 x 16	90	22	22.0	18.0	65721
PG 29 x 16	100	25	28.0	22.0	65729
PG 36 x 16	140	40	36.0	29.0	65736
PG 42 x 16	140	40	40.0	32.0	65742
PG 48 x 16	160	40	45.0	35.0	65748

Application:

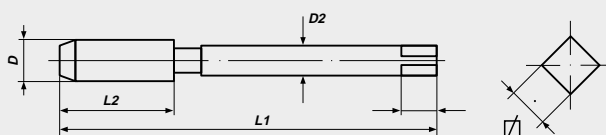
for general use

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through holes
- for thread cutting by hand and machine

Applicazione:

per uso universale

- Materiali con buona trucidibilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per fori passanti
- per uso manuale e con macchina





Short Machine Taps

american tapered pipe thread, taper 1:16

Maschi a macchina corti

filettatura americana conica per tubi, cono 1:16



HSS-G

NPT

Nominal Diameter S	L 1	L 2	D 2	☐	Art.-No.
-----------------------	-----	-----	-----	---	----------

Form C

NPT 1/16 x 27	65	19	7	5.5	63510
NPT 1/8 x 27	65	19	7	5.5	63512
NPT 1/4 x 18	70	25	11	9.0	63514
NPT 3/8 x 18	75	26	12	9.0	63516
NPT 1/2 x 14	80	31	16	12.0	63518
NPT 3/4 x 14	100	33	20	16.0	63522
NPT 1" x 11.5	110	38	25	20.0	63526
NPT 1.1/4 x 11.5	125	41	32	24.0	63534
NPT 1.1/2 x 11.5	140	42	36	29.0	63542
NPT 2" x 11.5	160	44	36	29.0	63554

Form B, Spiral Point / con imbocco corretto

NPT 1/16 x 27	55	17.5	8.0	6.0	98502
NPT 1/8 x 27	55	19.0	8.0	6.0	98506
NPT 1/4 x 18	62	28.0	11.0	9.0	98514
NPT 3/8 x 18	65	28.0	14.0	11.0	98518
NPT 1/2 x 14	80	35.0	18.0	14.0	98522
NPT 3/4 x 14	85	35.0	23.0	17.0	98530
NPT 1" x 11.5	95	45.0	26.0	21.0	98538
NPT 1.1/4 x 11.5	105	45.0	32.0	26.0	98546
NPT 1.1/2 x 11.5	110	45.0	38.0	29.0	98554
NPT 2" x 11.5	120	50.0	46.0	35.0	98570

Form C, 35° Spiral Flute / spirale destra a 35°

NPT 1/16 x 27	55	17.5	8.0	6.0	98702
NPT 1/8 x 27	55	19.0	8.0	6.0	98706
NPT 1/4 x 18	62	28.0	11.0	9.0	98714
NPT 3/8 x 18	65	28.0	14.0	11.0	98718
NPT 1/2 x 14	80	35.0	18.0	14.0	98722
NPT 3/4 x 14	85	35.0	23.0	17.0	98730
NPT 1" x 11.5	95	45.0	26.0	21.0	98738
NPT 1.1/4 x 11.5	105	45.0	32.0	26.0	98746
NPT 1.1/2 x 11.5	110	45.0	38.0	29.0	98754
NPT 2" x 11.5	120	50.0	46.0	35.0	98770

Application:

for general use

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for thread cutting by hand and machine

Form C: for through and blind holes

Spiral Point: for through holes

Spiral Flute: for blind holes

Applicazione:

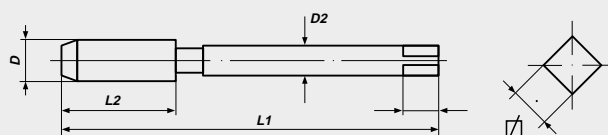
per uso universale

- Materiali con buona trucidibilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per uso manuale e con macchina

Forma C: per fori passanti e ciechi

Forma B: per fori passanti

35° RSP: per fori ciechi



**Short Machine Taps, *Left Hand***

american tapered pipe thread, taper 1:16

Maschi a macchina corti, *filetto sinistro*

filettatura americana conica per tubi, cono 1:16

**Form C****HSS-G****NPT**

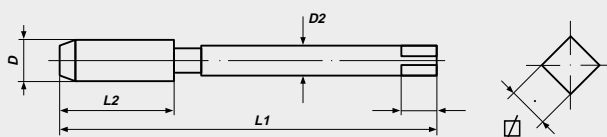
Nominal Diameter S	L 1	L 2	D 2	Ø	Art.-No.
NPT 1/8 x 27	65	19	7	5.5	63002
NPT 1/4 x 18	70	25	11	9.0	63003
NPT 3/8 x 18	75	26	12	9.0	63004
NPT 1/2 x 14	80	31	16	12.0	63005
NPT 3/4 x 14	100	33	20	16.0	63007
NPT 1" x 11.5	110	38	25	20.0	63009
NPT 1.1/4 x 11.5	125	41	32	24.0	63011
NPT 1.1/2 x 11.5	140	42	36	29.0	63013

Application:**for general use**

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for thread cutting by hand and machine

Form C: for through and blind holes**Applicazione:****per uso universale**

- Materiali con buona trucidibilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per uso manuale e con macchina

Forma C: per fori passanti e ciechi



Short Machine Taps

american tapered pipe thread, taper 1:16

Maschi a macchina corti

filettatura americana conica per tubi, cono 1:16



HSS-E

NPTF

Nominal Diameter S	L 1	L 2	D 2	☐	Art.-No.
-----------------------	-----	-----	-----	---	----------

Form B, Spiral Point / con imbocco corretto

NPTF 1/16 x 27	55	19	6.5	5.0	98571
NPTF 1/8 x 27	55	19	8.0	6.0	98572
NPTF 1/4 x 18	62	28	11.0	9.0	98574
NPTF 3/8 x 18	65	28	14.0	11.0	98576
NPTF 1/2 x 14	80	35	18.0	14.0	98578
NPTF 3/4 x 14	85	35	23.0	17.0	98580
NPTF 1" x 11.5	95	45	26.0	21.0	98582
NPTF 1.1/4 x 11.5	105	45	32.0	26.0	98584
NPTF 1.1/2 x 11.5	110	45	38.0	29.0	98586
NPTF 2" x 11.5	120	50	46.0	35.0	98588

Form C, 35° Spiral Flute / spirale destra a 35°

NPTF 1/8 x 27	55	19	8.0	6.0	98772
NPTF 1/4 x 18	62	28	11.0	9.0	98774
NPTF 3/8 x 18	65	28	14.0	11.0	98776
NPTF 1/2 x 14	80	35	18.0	14.0	98778
NPTF 3/4 x 14	85	35	23.0	17.0	98780
NPTF 1" x 11.5	95	45	26.0	21.0	98782

Application:

for general use

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for thread cutting by hand and machine

Spiral Point: for through holes

Spiral Flute: for blind holes

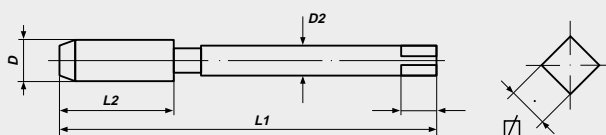
Applicazione:

per uso universale

- Materiali con buona trucidibilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per uso manuale e con macchina

Forma B: per fori passanti

35° RSP: per fori ciechi





Short Machine Taps

american straight pipe thread

Maschi a macchina corti

filettatura americana cilindrica per tubi



HSS-E

NPS

Nominal Diameter S	L 1	L 2	D 2	Ø	Art.-No.
-----------------------	-----	-----	-----	---	----------

Form C

NPS 1/16 x 27	54	17.5	8.0	6.0	99402
NPS 1/8 x 27	55	19.0	8.0	6.0	99406
NPS 1/4 x 18	62	28.0	11.0	9.0	99414
NPS 3/8 x 18	65	28.0	14.0	11.0	99418
NPS 1/2 x 14	80	35.0	18.0	14.0	99422
NPS 3/4 x 14	85	35.0	23.0	17.0	99430
NPS 1" x 11.5	95	45.0	26.0	21.0	99438
NPS 1.1/4 x 11.5	105	45.0	32.0	26.0	99446
NPS 1.1/2 x 11.5	110	45.0	38.0	29.0	99454
NPS 2" x 11.5	120	50.0	46.0	35.0	99470

Form C, 35° Spiral Flute / spirale destra a 35°

NPS 1/16 x 27	54	17.5	8.0	6.0	99702
NPS 1/8 x 27	55	19.0	8.0	6.0	99706
NPS 1/4 x 18	62	28.0	11.0	9.0	99714
NPS 3/8 x 18	65	28.0	14.0	11.0	99718
NPS 1/2 x 14	80	35.0	18.0	14.0	99722
NPS 3/4 x 14	85	35.0	23.0	17.0	99730
NPS 1" x 11.5	95	45.0	26.0	21.0	99738
NPS 1.1/4 x 11.5	105	45.0	32.0	26.0	99746
NPS 1.1/2 x 11.5	110	45.0	38.0	29.0	99754
NPS 2" x 11.5	120	50.0	46.0	35.0	99770

Application:

for general

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for thread cutting by hand and machine

Form C: for through and blind holes

Spiral Flute: for blind holes

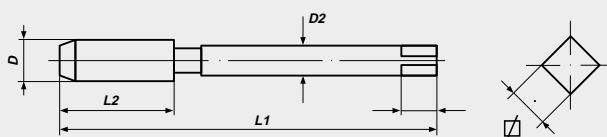
Applicazione:

per uso universale

- Materiali con buona truciabilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per uso manuale e con macchina

Forma C: per fori passanti e ciechi

35° RSP: per fori ciechi





HEX TAP DS



Benefit:

- Pilot for exact alignment
- Rougher and Finisher combined in one tool
- Use in awkward places
- For making new threads
- For cleaning and repairing damaged threads

Vantaggi:

- Imbocco corretto per un perfetto centraggio
- Sgrossatore e finitore in un unico utensile
- Impiego in luoghi di difficile accesso
- per la realizzazione di un nuovo filetto
- Per la riparazione di filetti danneggiati





BIT EDITION EDIZIONE BIT

	M	Mf	UNC UNF	UN	BSW	G(BSP)
HexTap	63	64 - 67		68		68
Combined Bits Maschi combinati	69		70			
TriBit ²	71					
Drill Bits Punte elicoidale con attacco esagonale 1/4"	71-72					
Countersink Bits Frese per svasare con attacco esagonale 1/4	72					
Combined Machine Tap Maschi combinati con punte	73				73	



because available ■ because reliable ■ because you ■



HexTap S

Technical Information:

VÖLKEL-Threading-Bits have been designed for thread cutting using battery-powered screwdriver drills and electric hand drills with right-hand and left-hand rotation. But they are also suitable for thread cutting by hand or in a stationary drilling machine. Your battery-powered screwdriver drill should have a minimum power of 7.5 Volts. Take care that the tool and the axis of the hole are exactly aligned and use a suitable cutting oil.

The following technical data apply for thread cutting using battery-powered screwdriver drills and electric hand drills:



HexTap S

Informazioni tecniche:

I maschi corti tipo bits Völkel sono concepiti per uso con avvitatori a batteria e trapani elettrici a mano con rotazione destra e sinistra, ma possono anche essere utilizzati per la filettatura a mano o con trapani a colonna. Adatti per uso con avvitatori a batteria con tensione minima pari a 7,5 V. Necessari per un buon utilizzo sono il corretto centraggio del maschio con il foro e l'impiego di un adeguato olio da taglio. Per la maschiatura con avvitatori a batteria e trapani elettrici a mano possono essere impiegati i seguenti parametri tecnici:

Dimensions/Dimensione	M 3	M 4	M 5	M 6	M 8	M 10
Core hole dia./Diametro del Preforo Ø	2,5 mm	3,3 mm	4,2 mm	5,0 mm	6,8 mm	8,5 mm
RPM/ Giri/min	Lowest setting (0 - 450 RPM)/minima regolazione					
Torque/Valore di serraggio	Maximum setting/massima regolazione					

HexTap DS

Application:

for general use

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

Rougher piloted

Sgrossatore con guida

Hexagon Hole for Ratchet or Hexagon Keys

esagono interno per cricchetti o chiavi per viti



Finisher/Bottoming
finitore

External Hexagon for Open-End Wrench
esagono esterno per chiavi a forchetta

Benefit:

Pilot for exact alignment
Rougher and Finisher combined in one tool
Use in awkward places
For making new threads
For cleaning and repairing damaged threads

Vantaggi:

Imbocco corretto per un perfetto centraggio
Sgrossatore e finitore in un unico utensile
Impiego in luoghi di difficile accesso
per la realizzazione di un nuovo filetto
Per la riparazione di filetti danneggiati





HexTap S

Threading-Bit, 1/4" Hexagon Shank
metric ISO-thread DIN 13

HexTap S

maschi con attacco esagonale 1/4"
filettatura metrica ISO DIN 13



HSS-G

Tol. ISO2/6H

M

Size	Typ	L 1	L 2	SW1	Art.-No.
M 3	S	33.0	11	1/4"	67026
M 3.5	S	33.5	10	1/4"	67028
M 4	S	35.0	12	1/4"	67030
M 4.5	S	35.0	12	1/4"	67032
M 5	S	36.0	15	1/4"	67034
M 5.5	S	35.0	15	1/4"	67036
M 6	S	39.0	18	1/4"	67038
M 7	S	37.5	16	1/4"	67040
M 8	S	40.0	19	1/4"	67042
M 9	S	40.5	18	1/4"	67044
M 10	S	41.0	21	1/4"	67046

HexTap DS

Double Ended Tap, Multi-Drive
metric ISO-thread DIN 13

HexTap DS

maschi doppio, Multi-Drive
filettatura metrica ISO DIN 13



HSS-G

Tol. ISO2/6H

M

Size	Typ	L 1	L 2	SW1	SW2	Art.-No.
M 11	DS	70	22	8	4	67048
M 12	DS	70	22	8	4	67050
M 14	DS	70	22	10	4	67051
M 16	DS	70	22	10	4	67052
M 18	DS	80	24	13	5	67053
M 20	DS	80	24	13	6	67054
M 22	DS	80	24	15	6	67055
M 24	DS	90	27	15	8	67056
M 27	DS	90	27	19	8	67057
M 30	DS	90	27	19	10	67058
M 33	DS	100	29	24	10	67059
M 36	DS	100	29	24	10	67060
M 39	DS	110	32	27	12	67061
M 42	DS	110	27	27	12	67062
M 45	DS	110	27	32	17	67063
M 48	DS	140	42	32	17	67064
M 52	DS	140	42	36	19	67065



HexTap S

Threading-Bit, 1/4" Hexagon Shank
metric-fine ISO-thread DIN 13

HexTap S

maschi con attacco esagonale 1/4"
filettatura metrica fine ISO DIN 13

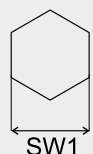
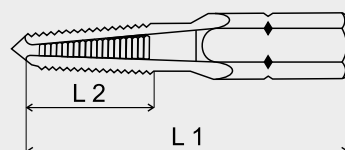
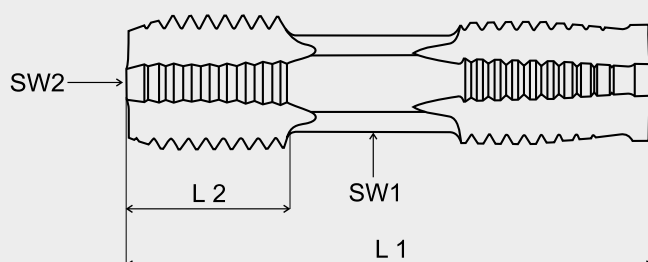


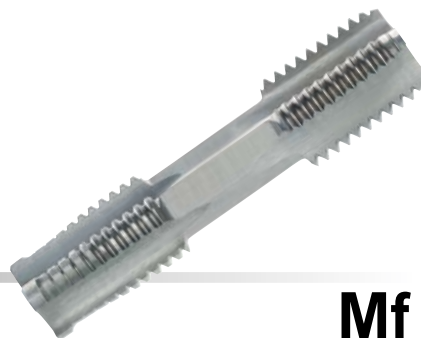
HSS-G

Tol. ISO2/6H

Mf

Size	Typ	L 1	L 2	SW1	Art.-No.
M 3 x 0.35	S	33.0	11	1/4"	67700
M 3.5 x 0.35	S	33.5	10	1/4"	67701
M 4 x 0.35	S	35.0	12	1/4"	67702
M 4 x 0.5	S	35.0	12	1/4"	67703
M 4.5 x 0.5	S	35.0	12	1/4"	67704
M 5 x 0.5	S	36.0	15	1/4"	67705
M 5 x 0.75	S	36.0	15	1/4"	67706
M 5.5 x 0.5	S	35.0	15	1/4"	67707
M 6 x 0.5	S	39.0	18	1/4"	67708
M 6 x 0.75	S	39.0	18	1/4"	67709
M 7 x 0.5	S	37.5	16	1/4"	67710
M 7 x 0.75	S	37.5	16	1/4"	67711
M 8 x 0.5	S	40.0	19	1/4"	67712
M 8 x 0.75	S	40.0	19	1/4"	67713
M 8 x 1.0	S	40.0	19	1/4"	67714
M 9 x 0.5	S	40.5	18	1/4"	67715
M 9 x 0.75	S	40.5	18	1/4"	67716
M 9 x 1.0	S	40.5	18	1/4"	67717
M 10 x 0.5	S	41.0	21	1/4"	67718
M 10 x 0.75	S	41.0	21	1/4"	67719
M 10 x 1.0	S	41.0	21	1/4"	67720
M 10 x 1.25	S	41.0	21	1/4"	67721



**HexTap DS**Double Ended Tap, Multi-Drive
metric-fine ISO-thread DIN 13**HexTap DS**maschi doppio, Multi-Drive
filettatura metrica fine ISO DIN 13**HSS-G****Tol. ISO2/6H****Mf**

Size	Typ	L 1	L 2	SW1	SW2	Art.-No.
M 11 x 0.75	DS	70	22	8	4	67722
M 11 x 1.0	DS	70	22	8	4	67723
M 11 x 1.25	DS	70	22	8	4	67724
M 12 x 0.5	DS	70	22	8	4	67725
M 12 x 0.75	DS	70	22	8	4	67726
M 12 x 1	DS	70	22	8	4	67727
M 12 x 1.25	DS	70	22	8	4	67728
M 12 x 1.5	DS	70	22	8	4	67729
M 13 x 0.5	DS	70	22	10	4	67730
M 13 x 0.75	DS	70	22	10	4	67731
M 13 x 1.0	DS	70	22	10	4	67732
M 13 x 1.5	DS	70	22	8	4	67733
M 14 x 0.5	DS	70	22	10	4	67734
M 14 x 0.75	DS	70	22	10	4	67735
M 14 x 1.0	DS	70	22	10	4	67736
M 14 x 1.25	DS	70	22	10	4	67737
M 14 x 1.5	DS	70	22	10	4	67738
M 15 x 0.75	DS	70	22	12	4	67739
M 15 x 1.0	DS	70	22	12	4	67740
M 15 x 1.5	DS	70	22	10	4	67741
M 16 x 0.5	DS	70	22	12	4	67742
M 16 x 0.75	DS	70	22	12	4	67743
M 16 x 1	DS	70	22	12	4	67744
M 16 x 1.25	DS	70	22	12	4	67745
M 16 x 1.5	DS	70	22	12	4	67746
M 17 x 1.0	DS	80	24	13	5	67747
M 17 x 1.5	DS	80	24	13	5	67748
M 18 x 0.5	DS	80	24	13	5	67749
M 18 x 0.75	DS	80	24	13	5	67750
M 18 x 1.0	DS	80	24	13	5	67751
M 18 x 1.25	DS	80	24	13	5	67752
M 18 x 1.5	DS	80	24	13	5	67753
M 18 x 2.0	DS	80	24	13	5	67754
M 19 x 1.0	DS	80	24	15	6	67755
M 19 x 1.5	DS	80	24	15	6	67756
M 20 x 0.5	DS	80	24	15	6	67757
M 20 x 0.75	DS	80	24	15	6	67758
M 20 x 1.0	DS	80	24	15	6	67759
M 20 x 1.25	DS	80	24	15	6	67760
M 20 x 1.5	DS	80	24	15	6	67761
M 20 x 2.0	DS	80	24	15	6	67762
M 21 x 1.0	DS	80	24	15	6	67763
M 21 x 1.5	DS	80	24	15	6	67764
M 22 x 0.5	DS	80	24	17	6	67765
M 22 x 0.75	DS	80	24	17	6	67766
M 22 x 1.0	DS	80	24	17	6	67767
M 22 x 1.25	DS	80	24	17	6	67768
M 22 x 1.5	DS	80	24	17	6	67769
M 22 x 2.0	DS	80	24	17	6	67770



HexTap DS

Double Ended Tap, Multi-Drive
metric-fine ISO-thread DIN 13

HexTap DS

maschi doppio, Multi-Drive
filettatura metrica fine ISO DIN 13



HSS-G

Tol. ISO2/6H

Mf

Size	Typ	L 1	L 2	SW1	SW2	Art.-No.
M 23 x 1.0	DS	80	24	17	6	67771
M 23 x 1.5	DS	80	24	17	6	67772
M 24 x 0.5	DS	80	24	19	8	67773
M 24 x 0,75	DS	80	24	19	8	67774
M 24 x 1.0	DS	80	24	19	8	67775
M 24 x 1,25	DS	80	24	19	8	67776
M 24 x 1.5	DS	90	27	19	8	67777
M 24 x 2.0	DS	90	27	17	8	67778
M 25 x 1.0	DS	90	27	19	8	67779
M 25 x 1.5	DS	90	27	19	8	67780
M 26 x 1.0	DS	90	27	19	8	67781
M 26 x 1.5	DS	90	27	19	8	67782
M 26 x 2.0	DS	90	27	19	8	67783
M 27 x 1.0	DS	90	27	19	8	67784
M 27 x 1.5	DS	90	27	19	8	67785
M 27 x 2.0	DS	90	27	19	8	67786
M 28 x 1.0	DS	90	27	19	8	67787
M 28 x 1.5	DS	90	27	19	8	67788
M 28 x 2.0	DS	90	27	19	8	67789
M 29 x 1.5	DS	90	27	19	8	67790
M 30 x 1.0	DS	90	27	24	10	67791
M 30 x 1.5	DS	90	27	24	10	67792
M 30 x 2.0	DS	90	27	24	10	67793
M 30 x 2.5	DS	90	27	22	10	67794
M 30 x 3.0	DS	90	27	22	10	67795
M 32 x 1.0	DS	90	27	24	10	67796
M 32 x 1.5	DS	90	27	24	10	67797
M 32 x 2.0	DS	90	27	24	10	67798
M 32 x 3.0	DS	90	27	24	10	67799
M 33 x 1.5	DS	100	29	24	10	67800
M 33 x 2.0	DS	100	29	24	10	67801
M 33 x 3.0	DS	100	29	24	10	67802
M 34 x 1.0	DS	100	29	27	10	67803
M 34 x 1.5	DS	100	29	27	10	67804
M 34 x 2.0	DS	100	29	27	10	67805
M 35 x 1.0	DS	100	29	27	10	67806
M 35 x 1.5	DS	100	29	27	10	67807
M 35 x 2.0	DS	100	29	27	10	67808
M 36 x 1.0	DS	100	29	27	10	67809
M 36 x 1.5	DS	100	29	27	10	67810
M 36 x 2.0	DS	100	29	27	10	67811
M 36 x 3.0	DS	100	29	27	10	67812
M 37 x 1.5	DS	100	29	27	10	67813
M 38 x 1.0	DS	110	32	27	12	67814
M 38 x 1.5	DS	110	32	27	12	67815
M 38 x 2.0	DS	110	32	27	12	67816
M 38 x 3.0	DS	110	32	27	12	67817
M 39 x 1.5	DS	110	32	32	12	67818
M 39 x 2.0	DS	110	32	27	12	67819



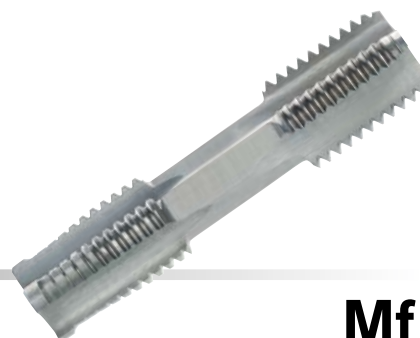


HexTap DS

Double Ended Tap, Multi-Drive

HexTap DS

maschi doppio, Multi-Drive



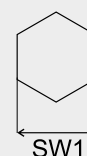
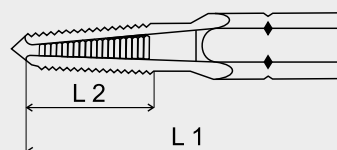
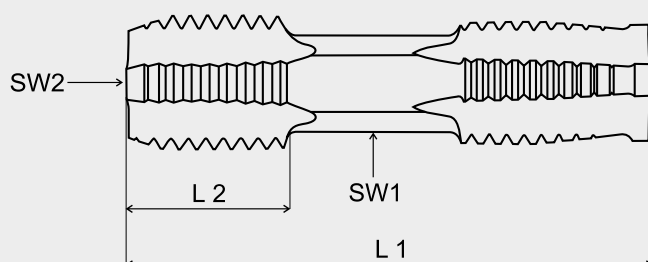
HSS-G

Mf Tol. ISO2/6H

UN Tol. 2B

Mf

Size	Typ	L 1	L 2	SW1	SW2	Art.-No.
M 39 x 3.0	DS	110	32	27	12	67820
M 40 x 1.0	DS	110	32	32	12	67821
M 40 x 1.5	DS	110	32	32	12	67822
M 40 x 2.0	DS	110	32	32	12	67823
M 40 x 3.0	DS	110	32	27	12	67824
M 42 x 1.0	DS	110	32	32	12	67825
M 42 x 1.5	DS	110	27	32	12	67828
M 42 x 2.0	DS	110	27	32	12	67826
M 42 x 3.0	DS	110	27	32	12	67827
M 44 x 1.5	DS	110	27	36	12	67829
M 44 x 2.0	DS	110	27	36	12	67830
M 45 x 1.0	DS	110	27	36	17	67831
M 45 x 1.5	DS	110	27	36	17	67832
M 45 x 2.0	DS	110	27	36	17	67833
M 45 x 3.0	DS	110	27	36	17	67834
M 46 x 1.5	DS	110	27	36	17	67835
M 48 x 1.0	DS	140	45	36	17	67836
M 48 x 1.5	DS	140	45	36	17	67837
M 48 x 2.0	DS	140	45	36	17	67838
M 48 x 3.0	DS	140	45	36	17	67839
M 50 x 1.5	DS	140	42	41	17	67840
M 50 x 2.0	DS	140	42	41	17	67841
M 50 x 3.0	DS	140	42	36	17	67842
M 52 x 1.5	DS	140	42	41	19	67843
M 52 x 2.0	DS	140	42	41	19	67844
M 52 x 3.0	DS	140	42	41	19	67845
M 63 x 1.5	DS	160	47	50	19	67846





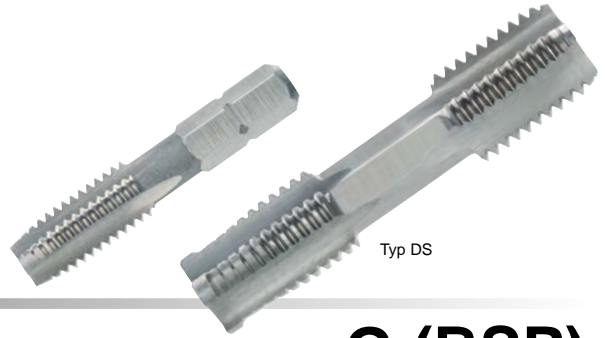
HexTap S

Threading-Bit, 1/4" Hexagon Shank
Pipe-thread DIN ISO 228

HexTap S

maschi con attacco esagonale 1/4"
filettatura per tubi gas DIN ISO 228

Typ S



Typ DS

HSS-G

G (BSP)

Size	Typ	L 1	L 2	SW1	Art.-No.
G 1/8	S	40,5	17	1/4"	67870
G 1/4	DS	70	22	8	67871
G 3/8	DS	70	22	12	67872
G 1/2	DS	80	24	15	67873
G 3/4	DS	90	27	19	67874
G 1"	DS	100	29	24	67875
G 1.1/4	DS	110	27	32	67876
G 1.1/2	DS	140	42	36	67877
G 2"	DS	160	47	41	67878

HexTap DS

Double Ended Tap, Multi-Drive
Pipe-thread DIN ISO 228

HexTap DS

maschi doppio, Multi-Drive
filettatura per tubi gas DIN ISO 228



HSS-G

UN

Size	Typ	L 1	L 2	SW1	SW2	Art.-No.
UN 1" x 8	DS	90	27	19	8	67901
UN 1.1/8 x 8	DS	90	27	19	8	67902
UN 1.1/4 x 8	DS	90	27	24	10	67903
UN 1.3/8 x 8	DS	100	29	27	10	67904
UN 1.1/2 x 8	DS	110	32	27	12	67905
UN 1.5/8 x 8	DS	110	32	32	12	67906
UN 1.3/4 x 8	DS	110	27	36	17	67907
UN 1.7/8 x 8	DS	140	45	36	17	67908
UN 2" x 8	DS	140	42	36	17	67909



Combined Bits

for Drilling, Tapping and Deburring in one operation
with 1/4" Hexagon Drive (Bit)

Maschi a macchina combinati

per forare, maschiare e svasare velocemente in un'unica operazione
con attacco esagonale 1/4"



HSS-G

ToI. ISO2/6H

M

Nominal Diameter D	D 1	L 1	⬡	Art.-No.
M 3 x 0.5	2.5	36	1/4"	67226
M 4 x 0.7	3.3	39	1/4"	67230
M 5 x 0.8	4.2	41	1/4"	67234
M 6 x 1.0	5.0	44	1/4"	67238
M 8 x 1.25	6.8	50	1/4"	67242
M 10 x 1.5	8.5	59	1/4"	67246

TIN

M 3 x 0.5	2.5	36	1/4"	67210
M 4 x 0.7	3.3	39	1/4"	67211
M 5 x 0.8	4.2	41	1/4"	67212
M 6 x 1.0	5.0	44	1/4"	67213
M 8 x 1.25	6.8	50	1/4"	67214
M 10 x 1.5	8.5	59	1/4"	67215

Technical Information:

VÖLKEL-Combined-Bits have been designed for drilling, tapping and deburring in one operation using battery-powered screwdriver drills and electric hand drills with right-hand and left-hand rotation, but they are also suitable for thread cutting in a stationary drilling machine. The Combined Bit is suitable for universal use in materials of medium mechanical strength, non ferrous metals and thermoplastics (up to 600 N/mm² tensile strength). It is possible with this tool to produce through threads up to a maximum threaded depth of 1 x D. They are especially useful for mounting and small batch production. Take care that the tool and the axis of the hole are exactly aligned and use a suitable cutting oil.

The following technical data apply for using battery-powered screwdriver and electric hand drills:

Informazioni tecniche:

I bits combinati Völkel sono concepiti per uso con trapani a batteria e a mano a rotazione destra e sinistra, ma sono adatti anche per un uso con trapani a colonna. Questi utensili sono utilizzati per la lavorazione dell'acciaio, metalli non ferrosi e plastiche (fino a 600 Nm² di resistenza). Adatti per la maschiatura di fori passanti con una profondità massima di 1xD. Sono particolarmente utilizzati nei lavori di montaggio e nella produzione di piccole serie. Necessari per un buon utilizzo sono il corretto centraggio del maschio con il foro e l'impiego di un adeguato olio da taglio. Per la maschiatura con trapani a batteria e a mano possono essere impiegati i seguenti parametri tecnici:

Dimensions/Dimensione	M 3	M 4	M 5	M 6	M 8	M 10
Core hole dia./ Diametro del Preforo Ø	2,5 mm	3,3 mm	4,2 mm	5,0 mm	6,8 mm	8,5 mm
max. RPM/Max n° giri (UpMgiri/m)	1600 UpM	1200 UpM	950 UpM	800 UpM	600 UpM	450 UpM



TriBit²

One Box for all occasions
Drilling, Tapping, Deburring
Combined and specific tools

TriBit²


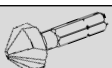

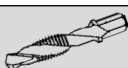
una cassetta in ogni caso
foratura, filettare, sbarbare
utensili combinato e speciale



HSS-G

Tol. ISO2/6H

M

Nominal Diameter D					Art.-No.
M 3 x 0.5	2.5 mm	6.3 mm	M 3	M 3	67403
M 4 x 0.7	3.3 mm	8.3 mm	M 4	M 4	67404
M 5 x 0.8	4.2 mm	10.4 mm	M 5	M 5	67405
M 6 x 1.0	5.0 mm	12.4 mm	M 6	M 6	67406
M 8 x 1.25	6.8 mm	16.5 mm	M 8	M 8	67408
M 10 x 1.5	8.5 mm	20.5 mm	M 10	M 10	67410

Wood Drill Bits


with 1/4" Hexagon Drive

Punte per legna

con attacco esagonale 1/4"



HSS-G

Nominal Diameter D	L 1	S 2		Art.-No.
3.0 mm	38	16	1/4"	67630
4.0 mm	44	20	1/4"	67640
5.0 mm	50	26	1/4"	67650
6.0 mm	50	26	1/4"	67660
8.0 mm	51	32	1/4"	67680
10.0 mm	54	38	1/4"	67698



Drill Bits

with 1/4" Hexagon Drive

Punte elicoidale

con attacco esagonale 1/4"



HSS-G

M

Nominal Diameter D	L 1	S 2	⬡	Art.-No.
1.0 mm	32	7	1/4"	67110
1.5 mm	32	10	1/4"	67115
2.0 mm	34	12	1/4"	67120
2.5 mm (M3)	36	14	1/4"	67125
3.0 mm	38	16	1/4"	67130
3.3 mm (M4)	40	18	1/4"	67133
3.5 mm	40	18	1/4"	67135
4.0 mm	44	20	1/4"	67140
4.2 mm (M5)	45	20	1/4"	67142
4.5 mm	46	24	1/4"	67145
5.0 mm (M6)	50	26	1/4"	67150
5.5 mm	50	26	1/4"	67155
6.0 mm	50	26	1/4"	67160
6.5 mm	50	30	1/4"	67165
6.8 mm (M8)	50	30	1/4"	67168
7.0 mm	50	30	1/4"	67170
7.5 mm	51	32	1/4"	67175
8.0 mm	51	32	1/4"	67180
8.5 mm (M10)	53	33	1/4"	67185
9.0 mm	53	33	1/4"	67190
9.5 mm	54	38	1/4"	67195
10.0 mm	54	38	1/4"	67198
10.2 mm (M12)	54	38	1/4"	67199

Countersink Bits

90° - 3 Flutes

with 1/4" Hexagon Drive

Frese per svasare

90° - 3 taglienti

con attacco esagonale 1/4"



HSS

Nominal Diameter D	L 1	⬡	Art.-No.
6.3 mm	31	1/4"	67306
8.3 mm	31	1/4"	67308
10.4 mm	34	1/4"	67310
12.4 mm	35	1/4"	67312
16.5 mm	40	1/4"	67316
20.5 mm	41	1/4"	67320



Combined Machine Tap

metric ISO-thread DIN 13

Maschi combinati con punte

filettatura metrica ISO DIN 13



HSS-E

Nominal Diameter	L 1	S 1	L 2	D 1	D 2	☒	Art.-No.
D							

M	Tol. ISO2/6H							
M 3 x 0.5	56	16	11	2.5	3.0	2.4	37026	
M 4 x 0.7	63	18	14	3.3	4.0	3.0	37030	
M 5 x 0.8	71	20	18	4.2	5.0	3.8	37034	
M 6 x 1.0	80	22	22	5.0	6.0	4.9	37038	
M 8 x 1.25	95	26	25	6.8	8.0	6.2	37042	
M 10 x 1.5	106	30	31	8.5	10.0	8.0	37046	
M 12 x 1.75	115	32	35	10.2	12.0	9.0	37050	

SET

M 3 - 12	M 3-4-5-6-8-10-12						47837
----------	-------------------	--	--	--	--	--	-------

BSW	Tol. med.							
BSW 1/8 x 40	56	16	11	2.6	3.0	2.4	70006	
BSW 5/32 x 32	63	18	14	3.2	4.0	3.0	70008	
BSW 3/16 x 24	71	20	18	3.7	5.0	3.8	70010	
BSW 1/4 x 20	80	22	22	5.1	6.0	4.9	70014	
BSW 5/16 x 18	95	26	25	6.5	8.0	6.2	70016	
BSW 3/8 x 16	106	30	31	7.9	10.0	8.0	70018	
BSW 1/2 x 12	115	32	35	10.5	12.0	9.0	70022	

SET

BSW 1/8 - 1/2	BSW 1/8-5/32-3/16-1/4-5/16-3/8-1/2						47870
---------------	------------------------------------	--	--	--	--	--	-------

Application:

The Combined Tap enables the user to produce the tapping drill hole and the through thread in one operation without any tool changing.

The tool incorporates a twist drill before the thread-tapping part. It is possible with this tool to produce through threads up to a maximum threaded depth of 2 x D.

The Combined Tap is suitable for universal use in materials of medium mechanical strength:

non-alloyed and alloyed steel sorts up to 600 N/mm², malleable cast iron, nodulized graphite cast iron, copper, brass, aluminium, aluminium-magnesium and zinc alloys, red bronze, electron metal, pressure-cast zinc.

It is sensible to use this tool on machines possessing an RPM switchover facility for drilling and tapping.

The feed rate must be adapted to the particular operation required - drilling or tapping.

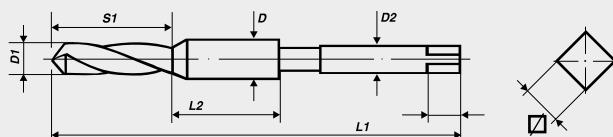
Tapping chucks with pressure compensation may not be used.

Applicazioni:

Combinazione di maschio con punta per forare e maschiare velocemente in un'unica operazione, senza cambiare l'utensile. Una punta elicoidale precede il maschio.

Possono essere realizzati unicamente filetti per fori passanti con profondità massima pari a 2xD. I maschi combinati possono essere utilizzati per uso universale su materiali di media resistenza: acciai legati e non legati fino a 600 N/mm², ghisa, ghisa sferoidale, rame, ottone, alluminio, leghe di alluminio e magnesio, leghe di zinco, ghisa rossa, elektron e ghisa pressofusa allo zinco.

La velocità di taglio e l'avanzamento dovranno essere adattati secondo l'operazione svolta, foratura o maschiatura. Pertanto questi utensili vanno impiegati su macchine a velocità variabile con possibilità di regolazione dei numeri di giri. Non utilizzare con mandrini a compensazione di pressione.





MACHINE TAPS HSS-E MASCHI A MACCHINA HSS-E

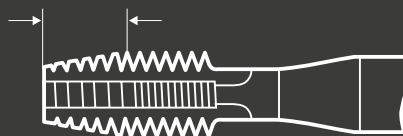


Through hole
per fori passanti



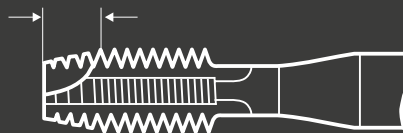
Form A

6-8 Threads Lead
Imbocco a 6-8 spire



Form B

4-5 Threads Lead with Spiral Point
Imbocco a 4-5 spire con imbocco corretto



Form B-AZ

4-5 Threads Lead, Spiral Point with interrupted threads
Imbocco a 4-5 spire con imbocco corretto e denti alternati per fori passanti

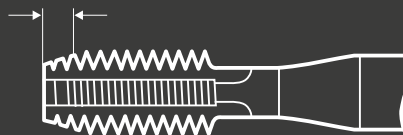


Blind hole
per fori ciechi



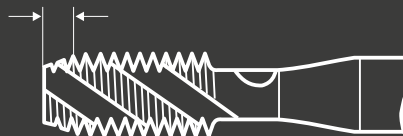
Form C

2-3 Threads Lead
Imbocco a 2-3 spire



Form C/RSP

2-3 Threads Lead, 35° Spiral Flute
Imbocco a 2-3 spire spirale destra a 35°





MACHINE TAPS HSS-E MASCHI A MACCHINA HSS-E

	Form A	Form C	Form B	15° RSP	35° RSP	B-AZ	TwinBox
M	78	79	80	84	82	85	77
M - extra long			86		87		
M - 6G - 7G - +0,1 - 4H			88		90		
M - LH		119	120		121		
Mf		92	93		96		
Mf - LH			122		125		
BSW			99		100		
BSW - LH			128		129		
UNC			101		102		
UNC - LH			130		131		
UNF			103		104		
UNF - LH			130		131		
8 - UN / 12 - UN			105		106		
UNEF			107		108		
UN / UNS			109				
G (BSP)		110	111		112		
G (BSP) - LH		132					
Rc (BSPT)		113					
NPT		114					
Rd		115					
FG		116					
BSC		117					
Vg		118					

because available ■ because reliable ■ because you ■



RECOMMENDED APPLICATION OF MACHINE TAPS

APPLICAZIONE RACCOMANDATA PER MASCHI A MACCHINA

Art.-No. M	373/383	374/384	375/385	376/386	377/387	379/389
Art.-No. Mf		394	395		397	
Art.-No. BSW			705/715		707/717	
Art.-No. UNC			745/755		747/757	
Art.-No. UNF			765/775		767/777	
Art.-No. G (BSP)		784	785		787	
Form/Forma	A	C	B	15°RSP	35°RSP	B-AZ
Typ of hole/Tipo di fori						
Material/Materiale						
Structural Steel up to 500N/mm ² Acciaio da costruzione a 500 N/mm ²	○	○	○	○	○	○
Structural Steel over 500 N/mm ² Acciaio da costruzione da 500 N/mm ²	○	○	○	○	○	
Free-cutting Steel Acciaio automatici			○		○	
Cementation Steel, heat treatable Steel Acciaio da cementazione, Acciai bonificato			○		○	○
Tool Steel Acciaio utensili			○		○	
Stainless Steel Acciaio inossidabile			○		○	○
Cast Steel Ghisa acciai			○	○	○	
Cast Iron, spheroidal graphite Iron Ghisa grigia / Ghisa sferoidale		○				
Malleable Cast Iron Ghisa temprata	○	○	○	○	○	
Brass, short-chipping Ottone, truciolo corto		○				
Brass, long-chipping Ottone, truciolo lungo			○	○	○	
Bronzes Bronzo			○		○	
Copper Rame			○	○	○	
Al-alloys, short-chipping Alluminio, truciolo corto		○	○		○	
Al-alloys, long-chipping Alluminio, truciolo lungo			○	○	○	○
Zinc Alloys Leghe forgiate			○	○	○	
Magnesium Alloys Leghe di magnesio		○	○		○	○
Thermoplastics Materiali plastici, materiali termoplastici			○		○	
Thermosetting Plastics Materiali plastici, materiali termodurenti		○				



Standard TwinBox

Machine Tap + Twist Drill
metric ISO-thread DIN 13

TwinBox Standard

Maschi a macchina + punte
filettatura metrica ISO DIN 13



DIN 371/376

HSS-E

Tol. ISO2/6H

M

Nominal Diameter D			Art.-No.
-----------------------	---	---	----------

Form B, Spiral Point / con imbocco corretto

M	3 x 0.5	DIN 371	2.5 mm	37590
M	4 x 0.7	DIN 371	3.3 mm	37591
M	5 x 0.8	DIN 371	4.2 mm	37592
M	6 x 1.0	DIN 371	5.0 mm	37593
M	8 x 1.25	DIN 371	6.8 mm	37594
M	10 x 1.5	DIN 371	8.5 mm	37595
M	12 x 1.75	DIN 376	10.2 mm	38596
M	14 x 2.0	DIN 376	12.0 mm	38597
M	16 x 2.0	DIN 376	14.0 mm	38598

Form C, Spiral Flute / spirale destra a 35°

M	3 x 0.5	DIN 371	2.5 mm	37790
M	4 x 0.7	DIN 371	3.3 mm	37791
M	5 x 0.8	DIN 371	4.2 mm	37792
M	6 x 1.0	DIN 371	5.0 mm	37793
M	8 x 1.25	DIN 371	6.8 mm	37794
M	10 x 1.5	DIN 371	8.5 mm	37795
M	12 x 1.75	DIN 376	10.2 mm	38796
M	14 x 2.0	DIN 376	12.0 mm	38797
M	16 x 2.0	DIN 376	14.0 mm	38798

Application:

for general use

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- Spiral Point for through holes
- Spiral Flute for blind holes

HSS-G Twist Drills DIN 338, type N
bright finish, profile ground

Applicazione:

per uso universale

- Materiali con buona truciabilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- Forma B per fori passanti
- 35° per fori ciechi

HSS-G punte DIN 338, tipo N
Superficie lucida, rettificata



Machine Taps

metric ISO-thread DIN 13

Maschi a macchina

filettatura metrica ISO DIN 13

DIN 371

DIN 376



DIN 371/376

Form A

HSS-E

Tol. ISO2/6H

M

Nominal Diameter D	L 1	L 2	D 2	☒	Art.-No.
DIN 371					
M 2 x 0.4	45	8	2.8	2.1	37316
M 2.3 x 0.4	45	9	2.8	2.1	37318
M 2.5 x 0.45	50	9	2.8	2.1	37322
M 2.6 x 0.45	50	9	2.8	2.1	37324
M 3 x 0.5	56	11	3.5	2.7	37326
M 4 x 0.7	63	13	4.5	3.4	37330
M 5 x 0.8	70	16	6.0	4.9	37334
M 6 x 1.0	80	19	6.0	4.9	37338
M 8 x 1.25	90	22	8.0	6.2	37342
M 10 x 1.5	100	24	10.0	8.0	37346
DIN 376					
M 2 x 0.4	45	8	1.4	—	38316
M 3 x 0.5	56	11	2.2	—	38326
M 4 x 0.7	63	13	2.8	2.1	38330
M 5 x 0.8	70	16	3.5	2.7	38334
M 6 x 1.0	80	19	4.5	3.4	38338
M 8 x 1.25	90	22	6.0	4.9	38342
M 10 x 1.5	100	24	7.0	5.5	38346
M 12 x 1.75	110	29	9.0	7.0	38350
M 14 x 2.0	110	30	11.0	9.0	38354
M 16 x 2.0	110	32	12.0	9.0	38358
M 18 x 2.5	125	34	14.0	11.0	38362
M 20 x 2.5	140	34	16.0	12.0	38366
M 22 x 2.5	140	34	18.0	14.5	38370
M 24 x 3.0	160	38	18.0	14.5	38374
M 27 x 3.0	160	38	20.0	16.0	38376
M 30 x 3.5	180	45	22.0	18.0	38378

SET

M 3 - 12 M 3-4-5-6-8-10 (DIN 371), M 12 (DIN 376) 47813

Application:

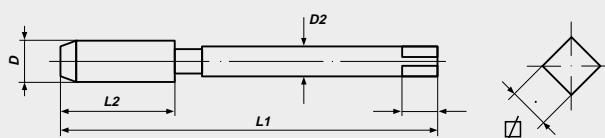
for general use

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through holes

Applicazione:

per uso universale

- Materiali con buona truciabilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per fori passanti





Machine Taps

metric ISO-thread DIN 13

Maschi a macchina

filettatura metrica ISO DIN 13

DIN 371

DIN 376

**DIN 371/376****Form C****HSS-E****Tol. ISO2/6H****M**

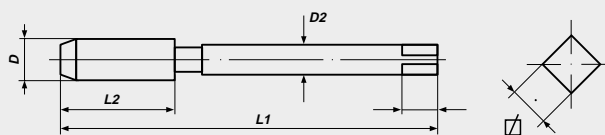
Nominal Diameter D	L 1	L 2	D 2	Ø	Art.-No.
DIN 371					
M 2 x 0.4	45	8	2.8	2.1	37416
M 2.3 x 0.4	45	9	2.8	2.1	37418
M 2.5 x 0.45	50	9	2.8	2.1	37422
M 2.6 x 0.45	50	9	2.8	2.1	37424
M 3 x 0.5	56	11	3.5	2.7	37426
M 3.5 x 0.6	56	13	4.0	3.0	37428
M 4 x 0.7	63	13	4.5	3.4	37430
M 5 x 0.8	70	16	6.0	4.9	37434
M 6 x 1.0	80	19	6.0	4.9	37438
M 7 x 1.0	80	19	7.0	5.5	37440
M 8 x 1.25	90	22	8.0	6.2	37442
M 10 x 1.5	100	24	10.0	8.0	37446
DIN 376					
M 3 x 0.5	56	11	2.2	—	38426
M 4 x 0.7	63	13	2.8	2.1	38430
M 5 x 0.8	70	16	3.5	2.7	38434
M 6 x 1.0	80	19	4.5	3.4	38438
M 8 x 1.25	90	22	6.0	4.9	38442
M 10 x 1.5	100	24	7.0	5.5	38446
M 11 x 1.5	100	24	8.0	6.2	38448
M 12 x 1.75	110	29	9.0	7.0	38450
M 14 x 2.0	110	30	11.0	9.0	38454
M 16 x 2.0	110	32	12.0	9.0	38458
M 18 x 2.5	125	34	14.0	11.0	38462
M 20 x 2.5	140	34	16.0	12.0	38466
M 22 x 2.5	140	34	18.0	14.5	38470
M 24 x 3.0	160	38	18.0	14.5	38474
M 27 x 3.0	160	38	20.0	16.0	38476
M 30 x 3.5	180	45	22.0	18.0	38478
M 33 x 3.5	180	50	25.0	20.0	38480
M 36 x 4.0	200	56	28.0	22.0	38482
M 39 x 4.0	200	60	32.0	24.0	38484
M 42 x 4.5	200	60	32.0	24.0	38486
M 45 x 4.5	220	65	36.0	29.0	38488
M 48 x 5.0	250	70	36.0	29.0	38490
M 52 x 5.0	250	70	40.0	32.0	38492
SET					
M 3 - 12	M 3-4-5-6-8-10 (DIN 371), M 12 (DIN 376)				47814

Application:**for general use**

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes

Applicazione:**per uso universale**

- Materiali con buona trucidibilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per fori passanti e ciechi



Machine Taps

metric ISO-thread DIN 13

Maschi a macchina

filettatura metrica ISO DIN 13



DIN 371

Form B

HSS-E

Tol. ISO2/6H

M

Nominal Diameter D	L 1	L 2	D 2	☒	Art.-No.
M 1 x 0.25	40	5	2.5	2.1	37502
M 1.1 x 0.25	40	5	2.5	2.1	37504
M 1.2 x 0.25	40	5	2.5	2.1	37506
M 1.4 x 0.3	40	7	2.5	2.1	37508
M 1.6 x 0.35	40	8	2.5	2.1	37510
M 1.7 x 0.35	40	8	2.5	2.1	37512
M 1.8 x 0.35	40	8	2.5	2.1	37514
M 2 x 0.4	45	8	2.8	2.1	37516
M 2.5 x 0.45	50	9	2.8	2.1	37522
M 3 x 0.5	56	11	3.5	2.7	37526
M 3.5 x 0.6	56	13	4.0	3.0	37528
M 4 x 0.7	63	13	4.5	3.4	37530
M 5 x 0.8	70	16	6.0	4.9	37534
M 6 x 1.0	80	19	6.0	4.9	37538
M 7 x 1.0	80	19	7.0	5.5	37540
M 8 x 1.25	90	22	8.0	6.2	37542
M 10 x 1.5	100	24	10.0	8.0	37546

TIN

M 3 x 0.5	56	11	3.5	2.7	31526
M 4 x 0.7	63	13	4.5	3.4	31530
M 5 x 0.8	70	16	6.0	4.9	31534
M 6 x 1.0	80	19	6.0	4.9	31538
M 8 x 1.25	90	22	8.0	6.2	31542
M 10 x 1.5	100	24	10.0	8.0	31546

VAP

M 3 x 0.5	56	11	3.5	2.7	31570
M 4 x 0.7	63	13	4.5	3.4	31571
M 5 x 0.8	70	16	6.0	4.9	31572
M 6 x 1.0	80	19	6.0	4.9	31573
M 8 x 1.25	90	22	8.0	6.2	31574
M 10 x 1.5	100	24	10.0	8.0	31575

Application:

for general use

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through holes

TIN-coating:

- improved resistance to wear and abrasion
- excellent anti-friction properties
- faster cutting speeds possible

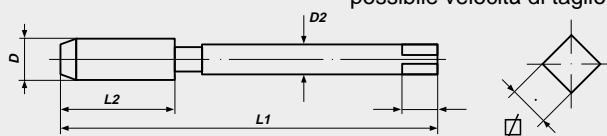
Applicazione:

per uso universale

- Materiali con buona trucidibilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per fori passanti

rivestimento TIN

- migliore resistenza all' abrasione e alla rottura
- eccellente uniformità
- possibile velocità di taglio superiore





Machine Taps

metric ISO-thread DIN 13

Maschi a macchina

filettatura metrica ISO DIN 13

**DIN 376****Form B****HSS-E****Tol. ISO2/6H****M**

Nominal Diameter D	L 1	L 2	D 2	☒	Art.-No.
M 3 x 0.5	56	11	2.2	—	38526
M 4 x 0.7	63	13	2.8	2.1	38530
M 5 x 0.8	70	16	3.5	2.7	38534
M 6 x 1.0	80	19	4.5	3.4	38538
M 8 x 1.25	90	22	6.0	4.9	38542
M 9 x 1.25	90	22	7.0	5.5	38544
M 10 x 1.5	100	24	7.0	5.5	38546
M 12 x 1.75	110	29	9.0	7.0	38550
M 14 x 2.0	110	30	11.0	9.0	38554
M 16 x 2.0	110	32	12.0	9.0	38558
M 18 x 2.5	125	34	14.0	11.0	38562
M 20 x 2.5	140	34	16.0	12.0	38566
M 22 x 2.5	140	34	18.0	14.5	38570
M 24 x 3.0	160	38	18.0	14.5	38574
M 27 x 3.0	160	38	20.0	16.0	38576
M 30 x 3.5	180	45	22.0	18.0	38578
M 33 x 3.5	180	50	25.0	20.0	38580
M 36 x 4.0	200	56	28.0	22.0	38582
M 39 x 4.0	200	60	32.0	24.0	38584
M 42 x 4.5	200	60	32.0	24.0	38586
M 45 x 4.5	220	65	36.0	29.0	38588
M 48 x 5.0	250	70	36.0	29.0	38590
M 52 x 5.0	250	70	40.0	32.0	38592

TIN

M 12 x 1.75	110	29	9.0	7.0	31550
M 14 x 2.0	110	30	11.0	9.0	31554
M 16 x 2.0	110	32	12.0	9.0	31558
M 18 x 2.5	125	34	14.0	11.0	31562
M 20 x 2.5	140	34	16.0	12.0	31566

VAP

M 12 x 1.75	110	29	9.0	7.0	31576
M 14 x 2.0	110	30	11.0	9.0	31577
M 16 x 2.0	110	32	12.0	9.0	31578
M 18 x 2.5	125	34	14.0	11.0	31579
M 20 x 2.5	140	34	16.0	12.0	31580

Application:**for general use**

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through holes

TIN-coating:

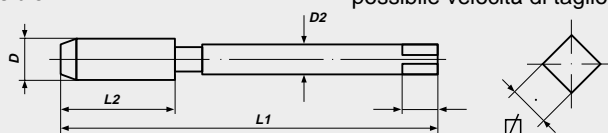
- improved resistance to wear and abrasion
- excellent anti-friction properties
- faster cutting speeds possible

Applicazione:**per uso universale**

- Materiali con buona truciabilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per fori passanti

rivestimento TIN

- migliore resistenza all'abrasione e alla rottura
- eccellente uniformità
- possibile velocità di taglio superiore



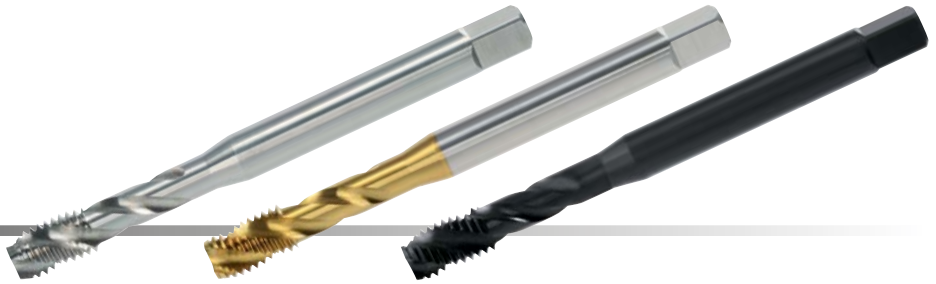


Machine Taps

metric ISO-thread DIN 13

Maschi a macchina

filettatura metrica ISO DIN 13



DIN 371

Form C/35°RSP

HSS-E

Tol. ISO2/6H

M

Nominal Diameter D	L 1	L 2	D 2	☐	Art.-No.
M 1 x 0.25	40	4	2.5	2.1	37702
M 1.1 x 0.25	40	4	2.5	2.1	37704
M 1.2 x 0.25	40	4	2.5	2.1	37706
M 1.4 x 0.3	40	5	2.5	2.1	37708
M 1.6 x 0.35	40	6	2.5	2.1	37710
M 1.7 x 0.35	40	6	2.5	2.1	37712
M 1.8 x 0.35	40	6	2.5	2.1	37714
M 2 x 0.4	45	6	2.8	2.1	37716
M 2.5 x 0.45	50	6	2.8	2.1	37722
M 3 x 0.5	56	6	3.5	2.7	37726
M 3.5 x 0.6	56	6	4.0	3.0	37728
M 4 x 0.7	63	7	4.5	3.4	37730
M 5 x 0.8	70	8	6.0	4.9	37734
M 6 x 1.0	80	10	6.0	4.9	37738
M 7 x 1.0	80	12	7.0	5.5	37740
M 8 x 1.25	90	14	8.0	6.2	37742
M 10 x 1.5	100	16	10.0	8.0	37746
TIN					
M 3 x 0.5	56	6	3.5	2.7	31726
M 4 x 0.7	63	7	4.5	3.4	31730
M 5 x 0.8	70	8	6.0	4.9	31734
M 6 x 1.0	80	10	6.0	4.9	31738
M 8 x 1.25	90	14	8.0	6.2	31742
M 10 x 1.5	100	16	10.0	8.0	31746
VAP					
M 3 x 0.5	56	6	3.5	2.7	31770
M 4 x 0.7	63	7	4.5	3.4	31771
M 5 x 0.8	70	8	6.0	4.9	31772
M 6 x 1.0	80	10	6.0	4.9	31773
M 8 x 1.25	90	14	8.0	6.2	31774
M 10 x 1.5	100	16	10.0	8.0	31775

Application: for general use

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for blind holes

TIN-coating:

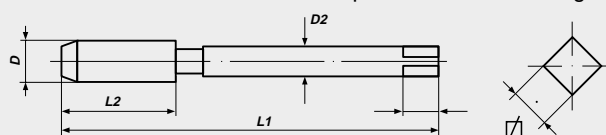
- improved resistance to wear and abrasion
- excellent anti-friction properties
- faster cutting speeds possible

Applicazione: per uso universale

- Materiali con buona truciocibilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per fori ciechi

rivestimento TIN:

- migliore resistenza all' abrasione e alla rottura
- eccellente uniformità
- possibile velocità di taglio superiore





Machine Taps

metric ISO-thread DIN 13

Maschi a macchina

filettatura metrica ISO DIN 13

**DIN 376****Form C/35°RSP****HSS-E****Tol. ISO2/6H****M**

Nominal Diameter D	L 1	L 2	D 2	Ø	Art.-No.
M 3 x 0.5	56	6	2.2	—	38726
M 4 x 0.7	63	7	2.8	2.1	38730
M 5 x 0.8	70	8	3.5	2.7	38734
M 6 x 1.0	80	10	4.5	3.4	38738
M 8 x 1.25	90	14	6.0	4.9	38742
M 10 x 1.5	100	16	7.0	5.5	38746
M 12 x 1.75	110	18	9.0	7.0	38750
M 14 x 2.0	110	20	11.0	9.0	38754
M 16 x 2.0	110	22	12.0	9.0	38758
M 18 x 2.5	125	25	14.0	11.0	38762
M 20 x 2.5	140	25	16.0	12.0	38766
M 22 x 2.5	140	27	18.0	14.5	38770
M 24 x 3.0	160	30	18.0	14.5	38774
M 27 x 3.0	160	30	20.0	16.0	38776
M 30 x 3.5	180	35	22.0	18.0	38778
M 33 x 3.5	180	35	25.0	20.0	38780
M 36 x 4.0	200	40	28.0	22.0	38782
M 39 x 4.0	200	40	32.0	24.0	38784
M 42 x 4.5	200	45	32.0	24.0	38786
M 45 x 4.5	220	45	36.0	29.0	38788
M 48 x 5.0	250	50	36.0	29.0	38790
M 52 x 5.0	250	50	40.0	32.0	38792

TIN

M 12 x 1.75	110	18	9.0	7.0	31750
M 14 x 2.0	110	20	11.0	9.0	31754
M 16 x 2.0	110	22	12.0	9.0	31758
M 18 x 2.5	125	25	14.0	11.0	31762
M 20 x 2.5	140	25	16.0	12.0	31766

VAP

M 12 x 1.75	110	18	9.0	7.0	31776
M 14 x 2.0	110	20	11.0	9.0	31777
M 16 x 2.0	110	22	12.0	9.0	31778
M 18 x 2.5	125	25	14.0	11.0	31779
M 20 x 2.5	140	25	16.0	12.0	31780

**Application:
for general use**

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for blind holes

TIN-coating:

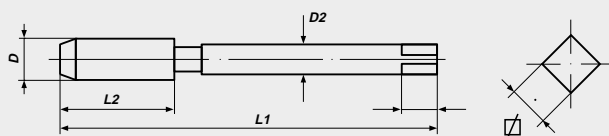
- improved resistance to wear and abrasion
- excellent anti-friction properties
- faster cutting speeds possible

**Applicazione:
per uso universale**

- Materiali con buona truciabilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per fori ciechi

rivestimento TIN:

- migliore resistenza all' abrasione e alla rottura
- eccellente uniformità
- possibile velocità di taglio superiore



Machine Taps

metric ISO-thread DIN 13

Maschi a macchina

filettatura metrica ISO DIN 13

DIN 371

DIN 376



DIN 371/376

Form C/15°RSP

HSS-E

Tol. ISO2/6H

M

Nominal Diameter D	L 1	L 2	D 2	☐	Art.-No.
DIN 371					
M 3 x 0.5	56	11	3.5	2.7	37626
M 3.5 x 0.6	56	13	4.0	3.0	37628
M 4 x 0.7	63	13	4.5	3.4	37630
M 5 x 0.8	70	16	6.0	4.9	37634
M 6 x 1.0	80	19	6.0	4.9	37638
M 7 x 1.0	80	19	7.0	5.5	37640
M 8 x 1.25	90	22	8.0	6.2	37642
M 10 x 1.5	100	24	10.0	8.0	37646
DIN 376					
M 3 x 0.5	56	11	2.2	—	38626
M 4 x 0.7	63	13	2.8	2.1	38630
M 5 x 0.8	70	16	3.5	2.7	38634
M 6 x 1.0	80	19	4.5	3.4	38638
M 8 x 1.25	90	22	6.0	4.9	38642
M 10 x 1.5	100	24	7.0	5.5	38646
M 12 x 1.75	110	29	9.0	7.0	38650
M 14 x 2.0	110	30	11.0	9.0	38654
M 16 x 2.0	110	32	12.0	11.0	38658
M 18 x 2.5	125	34	14.0	11.0	38662
M 20 x 2.5	140	34	16.0	12.0	38666
M 22 x 2.5	140	34	18.0	14.5	38670
M 24 x 3.0	160	38	18.0	14.5	38674
SET					
M 3 - 12	M 3-4-5-6-8-10 (DIN 371), M 12 (DIN 376)				47816

Application:

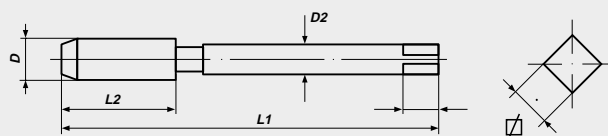
for general use

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for blind holes

Applicazione:

per uso universale

- Materiali con buona truciabilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per fori ciechi





Machine Taps

metric ISO-thread DIN 13

Maschi a macchina

filettatura metrica ISO DIN 13

DIN 371

DIN 376



DIN 371/376

Form B-AZ

HSS-E

Tol. ISO2/6H

M

Nominal Diameter D	L 1	L 2	D 2	Ø	Art.-No.
DIN 371					
M 3 x 0.5	56	11	3.5	2.7	37926
M 4 x 0.7	63	13	4.5	3.4	37930
M 5 x 0.8	70	16	6.0	4.9	37934
M 6 x 1.0	80	19	6.0	4.9	37938
M 8 x 1.25	90	22	8.0	6.2	37942
M 10 x 1.5	100	24	10.0	8.0	37946
DIN 376					
M 3 x 0.5	56	11	2.2	—	38926
M 4 x 0.7	63	13	2.8	2.1	38930
M 5 x 0.8	70	16	3.5	2.7	38934
M 6 x 1.0	80	19	4.5	3.4	38938
M 8 x 1.25	90	22	6.0	4.9	38942
M 10 x 1.5	100	24	7.0	5.5	38946
M 12 x 1.75	110	29	9.0	7.0	38950
M 14 x 2.0	110	30	11.0	9.0	38954
M 16 x 2.0	110	32	12.0	9.0	38958
M 18 x 2.5	125	34	14.0	11.0	38962
M 20 x 2.5	140	34	16.0	12.0	38966
M 22 x 2.5	140	34	18.0	14.5	38970
M 24 x 3.0	160	38	18.0	14.5	38974
SET					
M 3 - 12	M 3-4-5-6-8-10 (DIN 371), M 12 (DIN 376)				47819

Application:

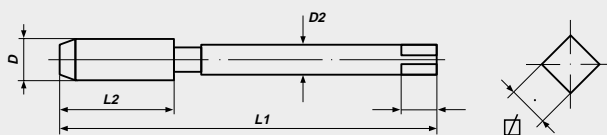
for general use

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through holes

Applicazione:

per uso universale

- Materiali con buona trucidibilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per fori passanti



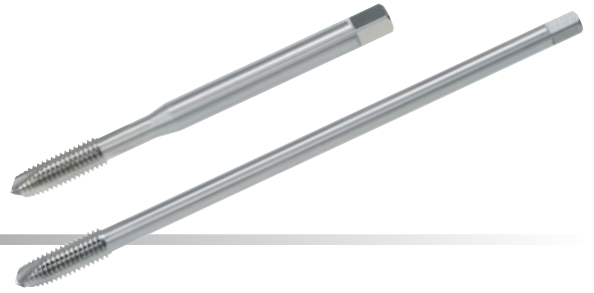


Machine Taps, *extra long*

metric ISO-thread DIN 13

Maschi a macchina, *extra lungo*

filettatura metrica ISO DIN 13



≈ DIN 371

Form B

HSS-E

Tol. ISO2/6H

M

Nominal Diameter D	L 1	L 2	D 2	☐	Art.-No.
100 mm					
M 3 x 0.5	100	11	3.5	2.7	32010
M 4 x 0.7	100	13	4.5	3.4	32011
M 5 x 0.8	100	16	6.0	4.9	32012
M 6 x 1.0	100	19	6.0	4.9	32013
M 8 x 1.25	100	22	8.0	6.2	32014
M 10 x 1.5	100	24	10.0	8.0	32015
M 12 x 1.75	100	29	12.0	9.0	32016
120 mm					
M 4 x 0.7	120	13	4.5	3.4	32021
M 5 x 0.8	120	16	6.0	4.9	32022
M 6 x 1.0	120	19	6.0	4.9	32023
M 8 x 1.25	120	22	8.0	6.2	32024
M 10 x 1.5	120	24	10.0	8.0	32025
M 12 x 1.75	120	29	12.0	9.0	32026
150 mm					
M 4 x 0.7	150	13	4.5	3.4	32031
M 5 x 0.8	150	16	6.0	4.9	32032
M 6 x 1.0	150	19	6.0	4.9	32033
M 8 x 1.25	150	22	8.0	6.2	32034
M 10 x 1.5	150	24	10.0	8.0	32035
M 12 x 1.75	150	29	12.0	9.0	32036
150 mm with reduced shank / con gambo passante					
M 4 x 0.7	150	13	2.8	2.1	32071
M 5 x 0.8	150	16	3.5	2.7	32072
M 6 x 1.0	150	19	4.5	3.4	32073
M 8 x 1.25	150	22	6.0	4.9	32074
M 10 x 1.5	150	24	7.0	5.5	32075
M 12 x 1.75	150	29	9.0	7.0	32076

Application:

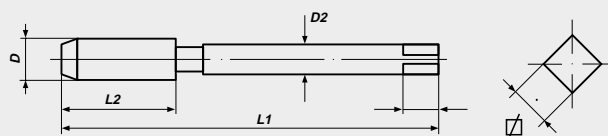
for general use in awkward places

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through holes

Applicazione:

per uso universale

- Materiali con buona trucidibilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per fori passanti



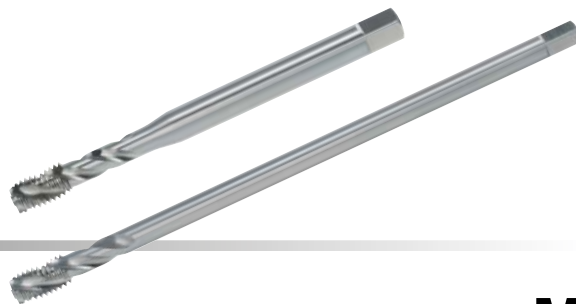


Machine Taps, *extra long*

metric ISO-thread DIN 13

Maschi a macchina, *extra lungo*

filettatura metrica ISO DIN 13



≈ DIN 371

Form C/35°RSP

HSS-E

Tol. ISO2/6H

M

Nominal Diameter D	L 1	L 2	D 2	☑	Art.-No.
100 mm					
M 3 x 0.5	100	6	3.5	2.7	32040
M 4 x 0.7	100	7	4.5	3.4	32041
M 5 x 0.8	100	8	6.0	4.9	32042
M 6 x 1.0	100	10	6.0	4.9	32043
M 8 x 1.25	100	14	8.0	6.2	32044
M 10 x 1.5	100	16	10.0	8.0	32045
M 12 x 1.75	100	18	12.0	9.0	32046
120 mm					
M 4 x 0.7	120	7	4.5	3.4	32051
M 5 x 0.8	120	8	6.0	4.9	32052
M 6 x 1.0	120	10	6.0	4.9	32053
M 8 x 1.25	120	14	8.0	6.2	32054
M 10 x 1.5	120	16	10.0	8.0	32055
M 12 x 1.75	120	18	12.0	9.0	32056
150 mm					
M 4 x 0.7	150	7	4.5	3.4	32061
M 5 x 0.8	150	8	6.0	4.9	32062
M 6 x 1.0	150	10	6.0	4.9	32063
M 8 x 1.25	150	14	8.0	6.2	32064
M 10 x 1.5	150	16	10.0	8.0	32065
M 12 x 1.75	150	18	12.0	9.0	32066
150 mm with reduced shank / con gambo passante					
M 4 x 0.7	150	7	2.8	2.1	32081
M 5 x 0.8	150	8	3.5	2.7	32082
M 6 x 1.0	150	10	4.5	3.4	32083
M 8 x 1.25	150	14	6.0	4.9	32084
M 10 x 1.5	150	16	7.0	5.5	32085
M 12 x 1.75	150	18	9.0	7.0	32086

Application:

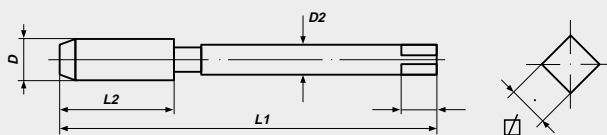
for general use in awkward places

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for blind holes

Applicazione:

per uso universale

- Materiali con buona trucidibilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per fori ciechi



Machine Taps, *with oversize* metric ISO-thread DIN 13

Maschi a macchina, *tolleranza maggiorata* filettatura metrica ISO DIN 13

DIN 371

DIN 376



DIN 371/376 Form B HSS-E

M

Nominal Diameter D	L 1	L 2	D 2	☒	Art.-No.
6G					
DIN 371					
M 2.5 x 0.45	50	9	2.8	2.1	32522
M 3 x 0.5	56	11	3.5	2.7	32526
M 4 x 0.7	63	13	4.5	3.4	32530
M 5 x 0.8	70	16	6.0	4.9	32534
M 6 x 1.0	80	19	6.0	4.9	32538
M 8 x 1.25	90	22	8.0	6.2	32542
M 10 x 1.5	100	24	10.0	8.0	32546
DIN 376					
M 12 x 1.75	110	29	9.0	7.0	32550
M 14 x 2.0	110	30	11.0	9.0	32554
M 16 x 2.0	110	32	12.0	9.0	32558
M 18 x 2.5	125	34	14.0	11.0	32562
M 20 x 2.5	140	34	16.0	12.0	32566
7G					
DIN 371					
M 3 x 0.5	56	11	3.5	2.7	32503
M 4 x 0.7	63	13	4.5	3.4	32504
M 5 x 0.8	70	16	6.0	4.9	32505
M 6 x 1.0	80	19	6.0	4.9	32506
M 8 x 1.25	90	22	8.0	6.2	32508
M 10 x 1.5	100	24	10.0	8.0	32510
DIN 376					
M 12 x 1.75	110	29	9.0	7.0	32512
+ 0,1 mm					
DIN 371					
M 3 x 0.5	56	11	3.5	2.7	32583
M 4 x 0.7	63	13	4.5	3.4	32584
M 5 x 0.8	70	16	6.0	4.9	32585
M 6 x 1.0	80	19	6.0	4.9	32586
M 8 x 1.25	90	22	8.0	6.2	32588
M 10 x 1.5	100	24	10.0	8.0	32590
DIN 376					
M 12 x 1.75	110	29	9.0	7.0	32592

Application:

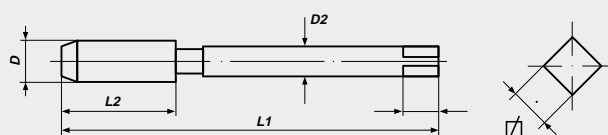
for general use

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- long chipping material
- for through holes

Applicazione:

per uso universale

- Materiali con buona truciabilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- Materiali truciolo lungo
- per fori passanti





M

Technical drawing of a shaft with a keyway. The shaft has a total length L_1 and a section of length L_2 . It has a diameter D and a keyway of width D_2 . A cross-section view shows the keyway profile.

Machine Taps, *with oversize*
metric ISO-thread DIN 13

Maschi a macchina, *tolleranza maggiorata*
filettatura metrica ISO DIN 13

DIN 371

DIN 376



DIN 371/376 Form C/35°RSP HSS-E

M

Nominal Diameter D	L 1	L 2	D 2	☒	Art.-No.
6G					
DIN 371					
M 3 x 0.5	56	6	3.5	2.7	32726
M 4 x 0.7	63	7	4.5	3.4	32730
M 5 x 0.8	70	8	6.0	4.9	32734
M 6 x 1.0	80	10	6.0	4.9	32738
M 8 x 1.25	90	14	8.0	6.2	32742
M 10 x 1.5	100	16	10.0	8.0	32746
DIN 376					
M 12 x 1.75	110	18	9.0	7.0	32750
M 14 x 2.0	110	20	11.0	9.0	32754
M 16 x 2.0	110	22	12.0	9.0	32758
M 18 x 2.5	125	25	14.0	11.0	32762
M 20 x 2.5	140	25	16.0	12.0	32766
7G					
DIN 371					
M 3 x 0.5	56	6	3.5	2.7	32703
M 4 x 0.7	63	7	4.5	3.4	32704
M 5 x 0.8	70	8	6.0	4.9	32705
M 6 x 1.0	80	10	6.0	4.9	32706
M 8 x 1.25	90	14	8.0	6.2	32708
M 10 x 1.5	100	16	10.0	8.0	32710
DIN 376					
M 12 x 1.75	110	18	9.0	7.0	32712
+ 0,1 mm					
DIN 371					
M 3 x 0.5	56	6	3.5	2.7	32783
M 4 x 0.7	63	7	4.5	3.4	32784
M 5 x 0.8	70	8	6.0	4.9	32785
M 6 x 1.0	80	10	6.0	4.9	32786
M 8 x 1.25	90	14	8.0	6.2	32788
M 10 x 1.5	100	16	10.0	8.0	32790
DIN 376					
M 12 x 1.75	110	18	9.0	7.0	32792

Application:

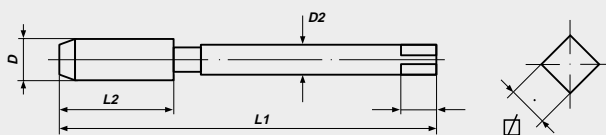
for general use

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- long chipping material
- for blind holes

Applicazione:

per uso universale

- Materiali con buona truciabilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- Materiali truciolo lungo
- per fori ciechi





M

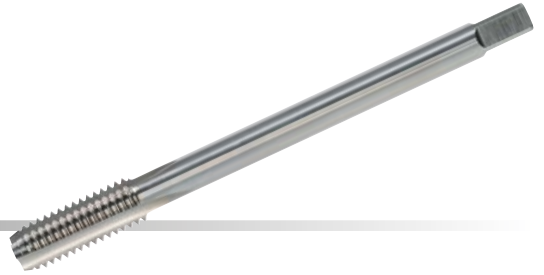


Machine Taps

metric-fine ISO-thread DIN 13

Maschi a macchina

filettatura metrica fine ISO DIN 13



DIN 374

Form C

HSS-E

Tol. ISO2/6H

Mf

Nominal Diameter D	L 1	L 2	D 2	☒	Art.-No.
M 4 x 0.35	63	10	2.8	2.1	39402
M 5 x 0.5	70	12	3.5	2.7	39404
M 6 x 0.75	80	14	4.5	3.4	39407
M 8 x 0.75	80	19	6.0	4.9	39410
M 8 x 1.0	90	22	6.0	4.9	39411
M 10 x 1.0	90	20	7.0	5.5	39415
M 10 x 1.25	100	24	7.0	5.5	39416
M 12 x 1.0	100	22	9.0	7.0	39420
M 12 x 1.25	100	22	9.0	7.0	39421
M 12 x 1.5	100	22	9.0	7.0	39422
M 14 x 1.0	100	22	11.0	9.0	39426
M 14 x 1.25	100	22	11.0	9.0	39427
M 14 x 1.5	100	22	11.0	9.0	39428
M 16 x 1.0	100	22	12.0	9.0	39431
M 16 x 1.5	100	22	12.0	9.0	39433
M 18 x 1.0	110	25	14.0	11.0	39434
M 18 x 1.5	110	25	14.0	11.0	39436
M 18 x 2.0	125	34	14.0	11.0	39437
M 20 x 1.0	125	25	16.0	12.0	39438
M 20 x 1.25	125	25	16.0	12.0	39439
M 20 x 1.5	125	25	16.0	12.0	39440
M 20 x 2.0	140	34	16.0	12.0	39441
M 22 x 1.0	125	25	18.0	14.5	39443
M 22 x 1.5	125	25	18.0	14.5	39445
M 22 x 2.0	140	34	18.0	14.5	39446
M 24 x 1.0	140	28	18.0	14.5	39448
M 24 x 1.5	140	28	18.0	14.5	39450
M 24 x 2.0	140	28	18.0	14.5	39451
M 25 x 1.0	140	28	18.0	14.5	39452
M 26 x 1.5	140	28	18.0	14.5	39454
M 27 x 1.5	140	28	20.0	16.0	39456
M 27 x 2.0	140	28	20.0	16.0	39457
M 28 x 1.5	140	28	20.0	16.0	39459
M 30 x 1.5	150	28	22.0	18.0	39463
M 30 x 2.0	150	28	22.0	18.0	39464
M 32 x 1.5	150	28	22.0	18.0	39466
M 32 x 2.0	150	28	22.0	18.0	39467
M 33 x 2.0	160	30	25.0	20.0	39468
M 35 x 1.5	170	30	28.0	22.0	39472
M 36 x 1.5	170	30	28.0	22.0	39473
M 36 x 2.0	170	30	28.0	22.0	39474
M 38 x 1.5	170	30	28.0	22.0	39476
M 40 x 1.5	170	30	32.0	24.0	39480
M 42 x 1.5	170	30	32.0	24.0	39483
M 45 x 1.5	180	32	36.0	29.0	39486
M 48 x 1.5	190	32	36.0	29.0	39489
M 50 x 1.5	190	32	36.0	29.0	39494
M 52 x 1.5	190	32	40.0	32.0	39497



Machine Taps

metric-fine ISO-thread DIN 13

Maschi a macchina

filettatura metrica fine ISO DIN 13

**DIN 374****Form B****HSS-E****Tol. ISO2/6H****Mf**

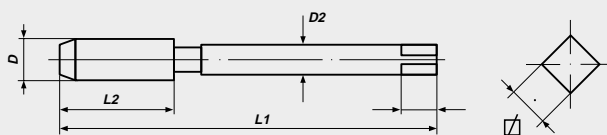
Nominal Diameter D	L 1	L 2	D 2	☒	Art.-No.
M 3 x 0.35	56	9	2.2	-	39501
M 4 x 0.35	63	10	2.8	2.1	39502
M 4 x 0.5	63	10	2.8	2.1	39503
M 5 x 0.5	70	12	3.5	2.7	39504
M 5 x 0.75	70	12	3.5	2.7	39505
M 6 x 0.5	80	14	4.5	3.4	39506
M 6 x 0.75	80	14	4.5	3.4	39507
M 7 x 0.75	80	14	5.5	4.3	39508
M 8 x 0.5	80	19	6.0	4.9	39509
M 8 x 0.75	80	19	6.0	4.9	39510
M 8 x 1.0	90	22	6.0	4.9	39511
M 9 x 0.75	80	19	7.0	5.5	39512
M 9 x 1.0	90	22	7.0	5.5	39513
M 10 x 0.75	90	20	7.0	5.5	39514
M 10 x 1.0	90	20	7.0	5.5	39515
M 10 x 1.25	100	24	7.0	5.5	39516
M 11 x 1.0	90	20	8.0	6.2	39517
M 11 x 1.25	90	22	8.0	6.2	39518
M 12 x 0.75	100	22	9.0	7.0	39519
M 12 x 1.0	100	22	9.0	7.0	39520
M 12 x 1.25	100	22	9.0	7.0	39521
M 12 x 1.5	100	22	9.0	7.0	39522
M 13 x 1.0	100	22	11.0	9.0	39523
M 13 x 1.5	100	22	11.0	9.0	39524
M 14 x 0.75	100	22	11.0	9.0	39525
M 14 x 1.0	100	22	11.0	9.0	39526
M 14 x 1.25	100	22	11.0	9.0	39527
M 14 x 1.5	100	22	11.0	9.0	39528
M 15 x 1.0	100	22	12.0	9.0	39529
M 15 x 1.5	100	22	12.0	9.0	39530
M 16 x 1.0	100	22	12.0	9.0	39531
M 16 x 1.25	100	22	12.0	9.0	39532
M 16 x 1.5	100	22	12.0	9.0	39533
M 18 x 1.0	110	25	14.0	11.0	39534
M 18 x 1.25	110	25	14.0	11.0	39535
M 18 x 1.5	110	25	14.0	11.0	39536
M 18 x 2.0	125	34	14.0	11.0	39537

Application:**for general use**

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through holes

Applicazione:**per uso universale**

- Materiali con buona trucidibilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per fori passanti





Machine Taps

metric-fine ISO-thread DIN 13

Maschi a macchina

filettatura metrica fine ISO DIN 13



DIN 374

Form B

HSS-E

Tol. ISO2/6H

Mf

Nominal Diameter D	L 1	L 2	D 2	☐	Art.-No.
M 20 x 1.0	125	25	16.0	12.0	39538
M 20 x 1.25	125	25	16.0	12.0	39539
M 20 x 1.5	125	25	16.0	12.0	39540
M 20 x 2.0	140	34	16.0	12.0	39541
M 21 x 1.5	125	25	16.0	12.0	39542
M 22 x 1.0	125	25	18.0	14.5	39543
M 22 x 1.25	125	25	18.0	14.5	39544
M 22 x 1.5	125	25	18.0	14.5	39545
M 22 x 2.0	140	34	18.0	14.5	39546
M 23 x 1.5	125	25	18.0	14.5	39547
M 24 x 1.0	140	28	18.0	14.5	39548
M 24 x 1.25	140	28	18.0	14.5	39549
M 24 x 1.5	140	28	18.0	14.5	39550
M 24 x 2.0	140	28	18.0	14.5	39551
M 25 x 1.0	140	28	18.0	14.5	39552
M 25 x 1.5	140	28	18.0	14.5	39553
M 26 x 1.0	140	28	18.0	14.5	3955X
M 26 x 1.5	140	28	18.0	14.5	39554
M 26 x 2.0	140	28	18.0	14.5	39555
M 27 x 1.0	140	28	20.0	16.0	39500
M 27 x 1.5	140	28	20.0	16.0	39556
M 27 x 2.0	140	28	20.0	16.0	39557
M 28 x 1.0	140	28	20.0	16.0	39558
M 28 x 1.5	140	28	20.0	16.0	39559
M 28 x 2.0	140	28	20.0	16.0	39560
M 29 x 1.5	150	28	22.0	18.0	39561
M 30 x 1.0	150	28	22.0	18.0	39562
M 30 x 1.5	150	28	22.0	18.0	39563
M 30 x 2.0	150	28	22.0	18.0	39564
M 30 x 2.5	180	45	22.0	18.0	3956X
M 30 x 3.0	180	45	22.0	18.0	39565
M 32 x 1.5	150	28	22.0	18.0	39566
M 32 x 2.0	150	28	22.0	18.0	39567
M 32 x 3.0	180	50	22.0	18.0	39592
M 33 x 1.5	160	30	25.0	20.0	39593
M 33 x 2.0	160	30	25.0	20.0	39568
M 33 x 3.0	180	50	25.0	20.0	39569



Application:

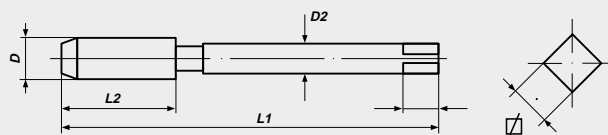
for general use

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through holes

Applicazione:

per uso universale

- Materiali con buona truciabilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per fori passanti





Machine Taps

metric-fine ISO-thread DIN 13

Maschi a macchina

filettatura metrica fine ISO DIN 13

**DIN 374****Form B****HSS-E****Tol. ISO2/6H****Mf**

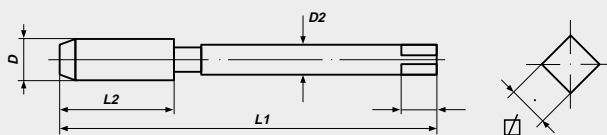
Nominal Diameter D	L 1	L 2	D 2	☐	Art.-No.
M 34 x 1.5	170	30	28.0	22.0	39570
M 34 x 2.0	170	30	28.0	22.0	39571
M 35 x 1.5	170	30	28.0	22.0	39572
M 36 x 1.5	170	30	28.0	22.0	39573
M 36 x 2.0	170	30	28.0	22.0	39574
M 36 x 3.0	200	56	28.0	22.0	39575
M 38 x 1.5	170	30	28.0	22.0	39576
M 39 x 1.5	170	30	32.0	24.0	39577
M 39 x 2.0	170	30	32.0	24.0	39578
M 39 x 3.0	200	60	32.0	24.0	39579
M 40 x 1.5	170	30	32.0	24.0	39580
M 40 x 2.0	170	30	32.0	24.0	39581
M 40 x 3.0	200	60	32.0	24.0	39582
M 42 x 1.5	170	30	32.0	24.0	39583
M 42 x 2.0	170	30	32.0	24.0	39584
M 42 x 3.0	200	60	32.0	24.0	39585
M 45 x 1.5	180	32	36.0	29.0	39586
M 45 x 2.0	180	32	36.0	29.0	39587
M 45 x 3.0	200	50	36.0	29.0	39588
M 48 x 1.5	190	32	36.0	29.0	39589
M 48 x 2.0	190	32	36.0	29.0	39590
M 48 x 3.0	225	50	36.0	29.0	39591
M 50 x 1.5	190	32	36.0	29.0	39594
M 50 x 2.0	190	32	36.0	29.0	39595
M 50 x 3.0	225	50	36.0	29.0	39596
M 52 x 1.5	190	32	40.0	32.0	39597
M 52 x 2.0	190	32	40.0	32.0	39598
M 52 x 3.0	225	50	40.0	32.0	39599
M 63 x 1.5	275	50	50.0	39.0	3959X

Application:**for general use**

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through holes

Applicazione:**per uso universale**

- Materiali con buona truciabilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per fori passanti





Machine Taps

metric-fine ISO-thread DIN 13

Maschi a macchina

filettatura metrica fine ISO DIN 13



DIN 374

Form C/35° RSP

HSS-E

Tol. ISO2/6H

Mf

Nominal Diameter D	L 1	L 2	D 2	☒	Art.-No.
M 3 x 0.35	56	5	2.2	-	39701
M 4 x 0.35	63	5	2.8	2.1	39702
M 4 x 0.5	63	5	2.8	2.1	39703
M 5 x 0.5	70	5	3.5	2.7	39704
M 5 x 0.75	70	8	3.5	2.7	39705
M 6 x 0.5	80	5	4.5	3.4	39706
M 6 x 0.75	80	8	4.5	3.4	39707
M 7 x 0.75	80	8	5.5	4.3	39708
M 8 x 0.5	80	8	6.0	4.9	39709
M 8 x 0.75	80	8	6.0	4.9	39710
M 8 x 1.0	90	10	6.0	4.9	39711
M 9 x 0.75	80	10	7.0	5.5	39712
M 9 x 1.0	90	10	7.0	5.5	39713
M 10 x 0.75	90	10	7.0	5.5	39714
M 10 x 1.0	90	10	7.0	5.5	39715
M 10 x 1.25	100	16	7.0	5.5	39716
M 11 x 1.0	90	11	8.0	6.2	39717
M 11 x 1.25	90	14	8.0	6.2	39718
M 12 x 0.75	100	10	9.0	7.0	39719
M 12 x 1.0	100	11	9.0	7.0	39720
M 12 x 1.25	100	15	9.0	7.0	39721
M 12 x 1.5	100	15	9.0	7.0	39722
M 13 x 1.0	100	11	11.0	9.0	39723
M 13 x 1.5	100	15	11.0	9.0	39724
M 14 x 0.75	100	10	11.0	9.0	39725
M 14 x 1.0	100	11	11.0	9.0	39726
M 14 x 1.25	100	15	11.0	9.0	39727
M 14 x 1.5	100	15	11.0	9.0	39728
M 15 x 1.0	100	12	12.0	9.0	39729
M 15 x 1.5	100	15	12.0	9.0	39730
M 16 x 1.0	100	12	12.0	9.0	39731
M 16 x 1.25	100	15	12.0	9.0	39732
M 16 x 1.5	100	15	12.0	9.0	39733
M 18 x 1.0	110	13	14.0	11.0	39734
M 18 x 1.25	110	15	14.0	11.0	39735
M 18 x 1.5	110	17	14.0	11.0	39736
M 18 x 2.0	125	20	14.0	11.0	39737

Application:

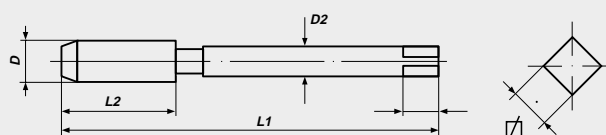
for general use

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for blind holes

Applicazione:

per uso universale

- Materiali con buona trucidibilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per fori ciechi





Machine Taps

metric-fine ISO-thread DIN 13

Maschi a macchina

filettatura metrica fine ISO DIN 13

**DIN 374****Form C/35° RSP****HSS-E****Tol. ISO2/6H****Mf**

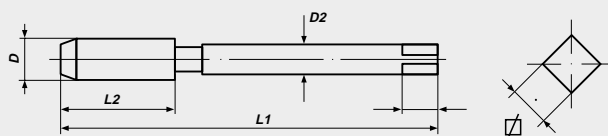
Nominal Diameter D	L 1	L 2	D 2	☐	Art.-No.
M 20 x 1.0	125	14	16.0	12.0	39738
M 20 x 1.25	125	17	16.0	12.0	39739
M 20 x 1.5	125	17	16.0	12.0	39740
M 20 x 2.0	140	20	16.0	12.0	39741
M 21 x 1.5	125	17	16.0	12.0	39742
M 22 x 1.0	125	14	18.0	14.5	39743
M 22 x 1.25	125	17	18.0	14.5	39744
M 22 x 1.5	125	17	18.0	14.5	39745
M 22 x 2.0	140	20	18.0	14.5	39746
M 23 x 1.5	125	17	18.0	14.5	39747
M 24 x 1.0	140	15	18.0	14.5	39748
M 24 x 1.25	140	17	18.0	14.5	39749
M 24 x 1.5	140	20	18.0	14.5	39750
M 24 x 2.0	140	20	18.0	14.5	39751
M 25 x 1.0	140	15	18.0	14.5	39752
M 25 x 1.5	140	20	18.0	14.5	39753
M 26 x 1.0	140	15	18.0	14.5	3975X
M 26 x 1.5	140	20	18.0	14.5	39754
M 26 x 2.0	140	20	18.0	14.5	39755
M 27 x 1.0	140	15	20.0	16.0	39700
M 27 x 1.5	140	20	20.0	16.0	39756
M 27 x 2.0	140	20	20.0	16.0	39757
M 28 x 1.0	140	15	20.0	16.0	39758
M 28 x 1.5	140	20	20.0	16.0	39759
M 28 x 2.0	140	20	20.0	16.0	39760
M 29 x 1.5	150	22	22.0	18.0	39761
M 30 x 1.0	150	17	22.0	18.0	39762
M 30 x 1.5	150	22	22.0	18.0	39763
M 30 x 2.0	150	22	22.0	18.0	39764
M 30 x 2.5	180	27	22.0	18.0	3976X
M 30 x 3.0	180	30	22.0	18.0	39765
M 32 x 1.5	150	22	22.0	18.0	39766
M 32 x 2.0	150	22	22.0	18.0	39767
M 32 x 3.0	180	30	22.0	18.0	39792
M 33 x 1.5	160	24	25.0	20.0	39793
M 33 x 2.0	160	24	25.0	20.0	39768
M 33 x 3.0	180	30	25.0	20.0	39769

Application:**for general use**

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for blind holes

Applicazione:**per uso universale**

- Materiali con buona trucidibilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per fori ciechi





Machine Taps

metric-fine ISO-thread DIN 13

Maschi a macchina

filettatura metrica fine ISO DIN 13



DIN 374

Form C/35° RSP

HSS-E

Tol. ISO2/6H

Mf

Nominal Diameter D	L 1	L 2	D 2	Ø	Art.-No.
M 34 x 1.5	170	24	28.0	22.0	39770
M 34 x 2.0	170	24	28.0	22.0	39771
M 35 x 1.5	170	24	28.0	22.0	39772
M 36 x 1.5	170	24	28.0	22.0	39773
M 36 x 2.0	170	24	28.0	22.0	39774
M 36 x 3.0	200	30	28.0	22.0	39775
M 38 x 1.5	170	24	28.0	22.0	39776
M 39 x 1.5	170	25	32.0	24.0	39777
M 39 x 2.0	170	25	32.0	24.0	39778
M 39 x 3.0	200	30	32.0	24.0	39779
M 40 x 1.5	170	25	32.0	24.0	39780
M 40 x 2.0	170	25	32.0	24.0	39781
M 40 x 3.0	200	30	32.0	24.0	39782
M 42 x 1.5	170	25	32.0	24.0	39783
M 42 x 2.0	170	25	32.0	24.0	39784
M 42 x 3.0	200	30	32.0	24.0	39785
M 45 x 1.5	180	27	36.0	29.0	39786
M 45 x 2.0	180	27	36.0	29.0	39787
M 45 x 3.0	200	30	36.0	29.0	39788
M 48 x 1.5	190	27	36.0	29.0	39789
M 48 x 2.0	190	27	36.0	29.0	39790
M 48 x 3.0	225	33	36.0	29.0	39791
M 50 x 1.5	190	27	36.0	29.0	39794
M 50 x 2.0	190	27	36.0	29.0	39795
M 50 x 3.0	225	33	36.0	29.0	39796
M 52 x 1.5	190	27	40.0	32.0	39797
M 52 x 2.0	190	27	40.0	32.0	39798
M 52 x 3.0	225	33	40.0	32.0	39799
M 63 x 1.5	275	40	50.0	39.0	3979X

Application:

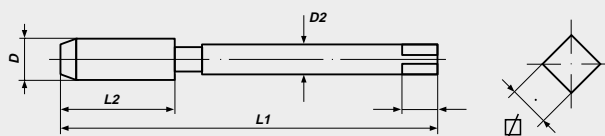
for general use

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for blind holes

Applicazione:

per uso universale

- Materiali con buona truciabilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per fori ciechi





Machine Taps

Withworth-thread BS 84

Maschi a macchina

filettatura Whitworth BS 84

DIN 371

DIN 376

≈ DIN 371/376

Form B

HSS-E

Tol. med.

BSW

Nominal Diameter D	L 1	L 2	D 2	Ø	Art.-No.
≈ DIN 371					
BSW 1/8 x 40	56	11	3.5	2.7	70506
BSW 5/32 x 32	63	13	4.5	3.4	70508
BSW 3/16 x 24	70	15	6.0	4.9	70510
BSW 1/4 x 20	80	17	7.0	5.5	70514
BSW 5/16 x 18	90	20	8.0	6.2	70516
BSW 3/8 x 16	100	22	9.0	7.0	70518
BSW 7/16 x 14	100	22	11.0	9.0	70520
BSW 1/2 x 12	110	25	12.0	9.0	70522
≈ DIN 376					
BSW 1/4 x 20	80	17	4.5	3.4	71514
BSW 5/16 x 18	90	20	6.0	4.9	71516
BSW 3/8 x 16	100	22	7.0	5.5	71518
BSW 7/16 x 14	100	22	8.0	6.2	71520
BSW 1/2 x 12	110	25	9.0	7.0	71522
BSW 9/16 x 12	110	26	11.0	9.0	71524
BSW 5/8 x 11	110	27	12.0	9.0	71526
BSW 3/4 x 10	125	30	14.0	11.0	71530
BSW 7/8 x 9	140	32	18.0	14.5	71534
BSW 1" x 8	160	36	20.0	16.0	71538
BSW 1.1/4 x 7	180	40	22.0	18.0	71546
BSW 1.3/8 x 6	200	50	28.0	22.0	71550
BSW 1.1/2 x 6	200	50	32.0	24.0	71554

Application:

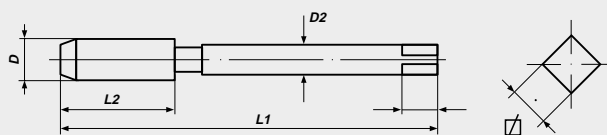
for general use

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through holes

Applicazione:

per uso universale

- Materiali con buona truciabilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per fori passanti



Machine Taps

Withworth-thread BS 84

Maschi a macchina

filettatura Whitworth BS 84

DIN 371

DIN 376

≈ DIN 371/376

Form C/35° RSP

HSS-E

Tol. med.

BSW

Nominal Diameter D	L 1	L 2	D 2	☐	Art.-No.
≈ DIN 371					
BSW 1/8 x 40	56	7	3.5	2.7	70706
BSW 5/32 x 32	63	7	4.5	3.4	70708
BSW 3/16 x 24	70	10	6.0	4.9	70710
BSW 1/4 x 20	80	13	7.0	5.5	70714
BSW 5/16 x 18	90	14	8.0	6.2	70716
BSW 3/8 x 16	100	16	9.0	7.0	70718
BSW 7/16 x 14	100	17	11.0	9.0	70720
BSW 1/2 x 12	110	20	12.0	9.0	70722
≈ DIN 376					
BSW 1/4 x 20	80	13	4.5	3.4	71714
BSW 5/16 x 18	90	14	6.0	4.9	71716
BSW 3/8 x 16	100	16	7.0	5.5	71718
BSW 7/16 x 14	100	17	8.0	6.2	71720
BSW 1/2 x 12	110	20	9.0	7.0	71722
BSW 9/16 x 12	110	20	11.0	9.0	71724
BSW 5/8 x 11	110	22	12.0	9.0	71726
BSW 3/4 x 10	125	25	14.0	11.0	71730
BSW 7/8 x 9	140	27	18.0	14.5	71734
BSW 1" x 8	160	30	20.0	16.0	71738
BSW 1.1/4 x 7	180	35	22.0	18.0	71746
BSW 1.3/8 x 6	200	40	28.0	22.0	71750
BSW 1.1/2 x 6	200	40	32.0	24.0	71754

Application:

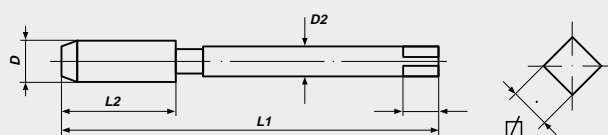
for general use

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for blind holes

Applicazione:

per uso universale

- Materiali con buona truciabilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per fori ciechi





Machine Taps

Unified Coarse thread ANSI B 1.1

Maschi a macchina

filettatura unificata, serie grossa ANSI B1.1

DIN 371

DIN 376



≈ DIN 371/376

Form B

HSS-E

Tol. 2B

UNC

Nominal Diameter D	L 1	L 2	D 2	☒	Art.-No.
≈ DIN 371					
UNC No. 4 x 40	50	10	3.5	2.7	74504
UNC No. 5 x 40	56	11	3.5	2.7	74505
UNC No. 6 x 32	56	12	4.0	3.0	74506
UNC No. 8 x 32	63	13	4.5	3.4	74508
UNC No. 10 x 24	70	15	6.0	4.9	74510
UNC No. 12 x 24	70	16	6.0	4.9	74512
UNC 1/4 x 20	80	17	7.0	5.5	74514
UNC 5/16 x 18	90	20	8.0	6.2	74516
UNC 3/8 x 16	100	22	9.0	7.0	74518
≈ DIN 376					
UNC No. 4 x 40	50	10	1.8	-	75504
UNC No. 5 x 40	56	11	2.2	1.8	75505
UNC No. 6 x 32	56	12	2.5	2.1	75506
UNC No. 8 x 32	63	13	2.8	2.1	75508
UNC No. 10 x 24	70	15	3.5	2.7	75510
UNC No. 12 x 24	70	16	3.5	2.7	75512
UNC 1/4 x 20	80	17	4.5	3.4	75514
UNC 5/16 x 18	90	20	6.0	4.9	75516
UNC 3/8 x 16	100	22	7.0	5.5	75518
UNC 7/16 x 14	100	22	8.0	6.2	75520
UNC 1/2 x 13	110	25	9.0	7.0	75522
UNC 9/16 x 12	110	26	11.0	9.0	75524
UNC 5/8 x 11	110	27	12.0	9.0	75526
UNC 3/4 x 10	125	30	14.0	11.0	75530
UNC 7/8 x 9	140	32	18.0	14.5	75534
UNC 1" x 8	160	36	20.0	16.0	75538
UNC 1.1/4 x 7	180	40	22.0	18.0	75546
UNC 1.1/2 x 6	200	50	32.0	24.0	75554
UNC 1.3/4 x 5	220	65	36.0	29.0	75562
UNC 2" x 4.1/2	250	70	40.0	32.0	75570

Application:

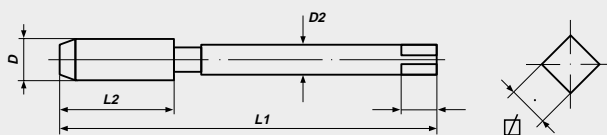
for general use

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through holes

Applicazione:

per uso universale

- Materiali con buona trucidibilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per fori passanti



Machine Taps

Unified Coarse thread ANSI B 1.1

Maschi a macchina

filettatura unificata, serie grossa ANSI B1.1

DIN 371

DIN 376

≈ DIN 371/376

Form C/35° RSP

HSS-E

Tol. 2B

UNC

Nominal Diameter D	L 1	L 2	D 2	☒	Art.-No.
≈ DIN 371					
UNC No. 4 x 40	50	6	3.5	2.7	74704
UNC No. 5 x 40	56	7	3.5	2.7	74705
UNC No. 6 x 32	56	7	4.0	3.0	74706
UNC No. 8 x 32	63	8	4.5	3.4	74708
UNC No. 10 x 24	70	10	6.0	4.9	74710
UNC No. 12 x 24	70	10	6.0	4.9	74712
UNC 1/4 x 20	80	13	7.0	5.5	74714
UNC 5/16 x 18	90	14	8.0	6.2	74716
UNC 3/8 x 16	100	16	9.0	7.0	74718
≈ DIN 376					
UNC No. 4 x 40	50	6	1.8	-	75704
UNC No. 5 x 40	56	7	2.2	1.8	75705
UNC No. 6 x 32	56	7	2.5	2.1	75706
UNC No. 8 x 32	63	8	2.8	2.1	75708
UNC No. 10 x 24	70	10	3.5	2.7	75710
UNC No. 12 x 24	70	10	3.5	2.7	75712
UNC 1/4 x 20	80	13	4.5	3.4	75714
UNC 5/16 x 18	90	14	6.0	4.9	75716
UNC 3/8 x 16	100	16	7.0	5.5	75718
UNC 7/16 x 14	100	17	8.0	6.2	75720
UNC 1/2 x 13	110	20	9.0	7.0	75722
UNC 9/16 x 12	110	20	11.0	9.0	75724
UNC 5/8 x 11	110	22	12.0	9.0	75726
UNC 3/4 x 10	125	25	14.0	11.0	75730
UNC 7/8 x 9	140	27	18.0	14.5	75734
UNC 1" x 8	160	30	20.0	16.0	75738
UNC 1.1/4 x 7	180	35	22.0	18.0	75746
UNC 1.1/2 x 6	200	40	32.0	24.0	75754
UNC 1.3/4 x 5	220	45	36.0	29.0	75762
UNC 2" x 4.1/2	250	50	40.0	32.0	75770

Application:

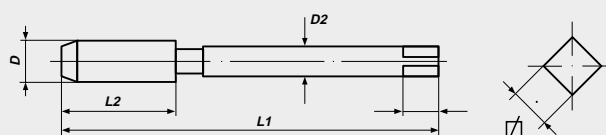
for general use

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for blind holes

Applicazione:

per uso universale

- Materiali con buona truciabilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per fori ciechi





Machine Taps

Unified Fine thread ANSI B 1.1

Maschi a macchina

filettatura unificata, serie fina ANSI B1.1

DIN 371

DIN 376



≈ DIN 371/376

Form B

HSS-E

Tol. 2B

UNF

Nominal Diameter D	L 1	L 2	D 2	☒	Art.-No.
≈ DIN 371					
UNF No. 4 x 48	50	10	3.5	2.7	76504
UNF No. 5 x 44	56	11	3.5	2.7	76505
UNF No. 6 x 40	56	12	4.0	3.0	76506
UNF No. 8 x 36	63	13	4.5	3.4	76508
UNF No. 10 x 32	70	15	6.0	4.9	76510
UNF No. 12 x 28	70	16	6.0	4.9	76512
UNF 1/4 x 28	80	17	7.0	5.5	76514
UNF 5/16 x 24	90	17	8.0	6.2	76516
UNF 3/8 x 24	100	18	9.0	7.0	76518
≈ DIN 376					
UNF 7/16 x 20	100	22	8.0	6.2	77520
UNF 1/2 x 20	100	22	9.0	7.0	77522
UNF 9/16 x 18	100	22	11.0	9.0	77524
UNF 5/8 x 18	100	22	12.0	9.0	77526
UNF 3/4 x 16	110	25	14.0	11.0	77530
UNF 7/8 x 14	140	26	18.0	14.5	77534
UNF 1" x 14	150	28	20.0	16.0	77540
UNF 1" x 12	150	28	20.0	16.0	77538
UNF 1.1/4 x 12	150	30	22.0	18.0	77546
UNF 1.1/2 x 12	170	33	32.0	24.0	77554

Application:

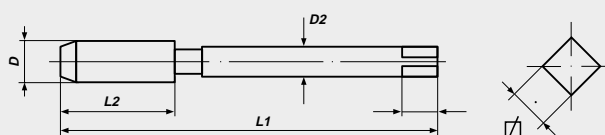
for general use

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through holes

Applicazione:

per uso universale

- Materiali con buona trucidibilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per fori passanti





Machine Taps

Unified Fine thread ANSI B 1.1

Maschi a macchina

filettatura unificata, serie fina ANSI B1.1

DIN 371

DIN 376



≈ DIN 371/376

Form C/35° RSP

HSS-E

Tol. 2B

UNF

Nominal Diameter D	L 1	L 2	D 2	☒	Art.-No.
≈ DIN 371					
UNF No. 4 x 48	50	6	3.5	2.7	76704
UNF No. 5 x 44	56	7	3.5	2.7	76705
UNF No. 6 x 40	56	7	4.0	3.0	76706
UNF No. 8 x 36	63	8	4.5	3.4	76708
UNF No. 10 x 32	70	10	6.0	4.9	76710
UNF No. 12 x 28	70	10	6.0	4.9	76712
UNF 1/4 x 28	80	10	7.0	5.5	76714
UNF 5/16 x 24	90	10	8.0	6.2	76716
UNF 3/8 x 24	100	10	9.0	7.0	76718
≈ DIN 376					
UNF 7/16 x 20	100	13	8.0	6.2	77720
UNF 1/2 x 20	100	13	9.0	7.0	77722
UNF 9/16 x 18	100	15	11.0	9.0	77724
UNF 5/8 x 18	100	15	12.0	9.0	77726
UNF 3/4 x 16	110	17	14.0	11.0	77730
UNF 7/8 x 14	140	17	18.0	14.5	77734
UNF 1" x 14	150	20	20.0	16.0	77740
UNF 1" x 12	150	20	20.0	16.0	77738
UNF 1.1/4 x 12	150	22	22.0	18.0	77746
UNF 1.1/2 x 12	170	25	32.0	24.0	77754

Application:

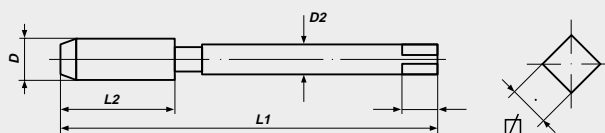
for general use

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for blind holes

Applicazione:

per uso universale

- Materiali con buona truciabilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per fori ciechi





Machine Taps

Unified thread ANSI B 1.1

Maschi a macchina

filettatura unificata ANSI B1.1

**ISO 529****Form B****HSS-E****Tol. 2B****UN**

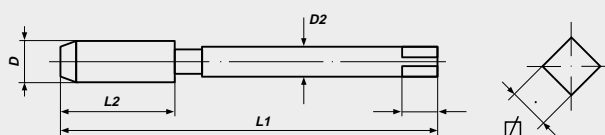
Nominal Diameter D	L 1	L 2	D 2	Ø	Art.-No.
8-UN					
UN 1.1/16 x 8	138	48	20.0	16.0	83101
UN 1.1/8 x 8	138	48	20.0	16.0	83102
UN 1.3/16 x 8	151	51	22.4	18.0	83103
UN 1.1/4 x 8	151	51	22.4	18.0	83104
UN 1.5/16 x 8	162	57	25.0	20.0	83105
UN 1.3/8 x 8	162	57	25.0	20.0	83106
UN 1.1/2 x 8	170	60	28.0	22.4	83107
UN 1.5/8 x 8	170	60	28.0	22.4	83108
UN 1.3/4 x 8	187	67	31.5	25.0	83109
UN 1.7/8 x 8	187	67	31.5	25.0	83110
UN 2" x 8	200	70	35.5	28.0	83111
UN 2.1/8 x 8	200	70	35.5	28.0	83112
UN 2.1/4 x 8	221	76	40.0	31.5	83113
UN 2.1/2 x 8	224	79	40.0	31.5	83115
UN 2.3/4 x 8	234	79	45.0	35.5	83116
UN 3" x 8	258	83	50.0	40.0	83117
UN 3.1/4 x 8	261	86	50.0	40.0	83118
UN 3.1/2 x 8	261	86	50.0	40.0	83119
UN 3.3/4 x 8	279	89	56.0	45.0	83120
UN 4" x 8	279	89	56.0	45.0	83121
12-UN					
UN 1.5/8 x 12	170	60	28.0	22.4	83301
UN 1.3/4 x 12	187	67	31.5	25.0	83302
UN 1.7/8 x 12	187	67	31.5	25.0	83303
UN 2" x 12	200	70	35.5	28.0	83304
UN 2.1/8 x 12	200	70	35.5	28.0	83305
UN 2.1/4 x 12	221	76	40.0	31.5	83306
UN 2.1/2 x 12	224	79	40.0	31.5	83308
UN 2.3/4 x 12	234	79	45.0	35.5	83309
UN 3" x 12	258	83	50.0	40.0	83310
UN 3.1/4 x 12	261	86	50.0	40.0	83311
UN 3.1/2 x 12	261	86	50.0	40.0	83312
UN 3.3/4 x 12	279	89	56.0	45.0	83313
UN 4" x 12	279	89	56.0	45.0	83314

Application:**for general use**

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through holes

Applicazione:**per uso universale**

- Materiali con buona trucidibilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per fori passanti





Machine Taps

Unified thread ANSI B 1.1

Maschi a macchina

filettatura unificata ANSI B1.1



ISO 529

Form C/35° RSP

HSS-E

Tol. 2B

UN

Nominal Diameter D	L 1	L 2	D 2	☒	Art.-No.
8-UN					
UN 1.1/16 x 8	138	48	20.0	16.0	83151
UN 1.1/8 x 8	138	48	20.0	16.0	83152
UN 1.3/16 x 8	151	51	22.4	18.0	83153
UN 1.1/4 x 8	151	51	22.4	18.0	83154
UN 1.5/16 x 8	162	57	25.0	20.0	83155
UN 1.3/8 x 8	162	57	25.0	20.0	83156
UN 1.1/2 x 8	170	60	28.0	22.4	83157
UN 1.5/8 x 8	170	60	28.0	22.4	83158
UN 1.3/4 x 8	187	67	31.5	25.0	83159
UN 1.7/8 x 8	187	67	31.5	25.0	83160
UN 2" x 8	200	70	35.5	28.0	83161
UN 2.1/8 x 8	200	70	35.5	28.0	83162
UN 2.1/4 x 8	221	76	40.0	31.5	83163
UN 2.1/2 x 8	224	79	40.0	31.5	83165
UN 2.3/4 x 8	234	79	45.0	35.5	83166
UN 3" x 8	258	83	50.0	40.0	83167
UN 3.1/4 x 8	261	86	50.0	40.0	83168
UN 3.1/2 x 8	261	86	50.0	40.0	83169
UN 3.3/4 x 8	279	89	56.0	45.0	83170
UN 4" x 8	279	89	56.0	45.0	83171
12-UN					
UN 1.5/8 x 12	170	60	28.0	22.4	83351
UN 1.3/4 x 12	187	67	31.5	25.0	83352
UN 1.7/8 x 12	187	67	31.5	25.0	83353
UN 2" x 12	200	70	35.5	28.0	83354
UN 2.1/8 x 12	200	70	35.5	28.0	83355
UN 2.1/4 x 12	221	76	40.0	31.5	83356
UN 2.1/2 x 12	224	79	40.0	31.5	83358
UN 2.3/4 x 12	234	79	45.0	35.5	83359
UN 3" x 12	258	83	50.0	40.0	83360
UN 3.1/4 x 12	261	86	50.0	40.0	83361
UN 3.1/2 x 12	261	86	50.0	40.0	83362
UN 3.3/4 x 12	279	89	56.0	45.0	83363
UN 4" x 12	279	89	56.0	45.0	83364

Application:

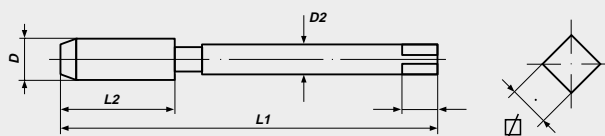
for general use

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for blind holes

Applicazione:

per uso universale

- Materiali con buona truciabilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per fori ciechi





Machine Taps

Unified Extra Fine thread ANSI B 1.1

Maschi a macchina

filettatura unificata, serie extra-fina ANSI B1.1

**ISO 529****Form B****HSS-E****Tol. 2B****UNEF**

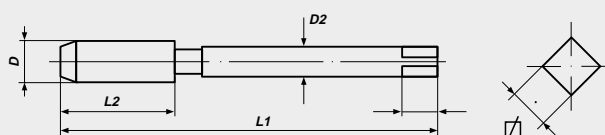
Nominal Diameter D		L 1	L 2	D 2	Ø	Art.-No.
UNEF	Nr.12 x 32	62	17	5.6	4.5	83320
UNEF	1/4 x 32	66	19	6.3	5.0	83321
UNEF	5/16 x 32	72	22	8.0	6.3	83322
UNEF	3/8 x 32	80	24	10.0	8.0	83323
UNEF	7/16 x 28	85	25	8.0	6.3	83324
UNEF	1/2 x 28	89	29	9.0	7.1	83325
UNEF	9/16 x 24	95	30	11.2	9.0	83326
UNEF	5/8 x 24	102	32	12.5	10.0	83327
UNEF	11/16 x 24	112	37	14.0	11.2	83328
UNEF	3/4 x 20	112	37	14.0	11.2	83329
UNEF	13/16 x 20	118	38	16.0	12.5	83330
UNEF	7/8 x 20	118	38	16.0	12.5	83331
UNEF	15/16 x 20	130	45	18.0	14.0	83332
UNEF	1" x 20	130	45	18.0	14.0	83333
UNEF	1.1/16 x 18	138	48	20.0	16.0	83334
UNEF	1.1/8 x 18	138	48	20.0	16.0	83335
UNEF	1.3/16 x 18	151	51	22.4	18.0	83336
UNEF	1.1/4 x 18	151	51	22.4	18.0	83337
UNEF	1.5/16 x 18	162	57	25.0	20.0	83338
UNEF	1.3/8 x 18	162	57	25.0	20.0	83339
UNEF	1.7/16 x 18	170	60	28.0	22.4	83340
UNEF	1.1/2 x 18	170	60	28.0	22.4	83341
UNEF	1.9/16 x 18	170	60	28.0	22.4	83342
UNEF	1.5/8 x 18	170	60	28.0	22.4	83343
UNEF	1.11/16 x 18	187	67	31.5	25.0	83344
UNEF	1.3/4 x 18	187	67	31.5	25.0	83345
UNEF	2" x 18	200	70	35.5	28.0	83346

Application:**for general use**

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through holes

Applicazione:**per uso universale**

- Materiali con buona trucidibilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per fori passanti





Maschine Taps

Unified Extra Fine thread ANSI B 1.1

Maschi a macchina

filettatura unificata, serie extra-fina ANSI B1.1



ISO 529

Form C/35°RSP

HSS-E

Tol. 2B

UNEF

Nominal Diameter D	L 1	L 2	D 2	☒	Art.-No.
UNEF Nr. 12 x 32	62	17	5.6	4.5	83370
UNEF 1/4 x 32	66	19	6.3	5.0	83371
UNEF 5/16 x 32	72	22	8.0	6.3	83372
UNEF 3/8 x 32	80	24	10.0	8.0	83373
UNEF 7/16 x 28	85	25	8.0	6.3	83374
UNEF 1/2 x 28	89	29	9.0	7.1	83375
UNEF 9/16 x 24	95	30	11.2	9.0	83376
UNEF 5/8 x 24	102	32	12.5	10.0	83377
UNEF 11/16 x 24	112	37	14.0	11.2	83378
UNEF 3/4 x 20	112	37	14.0	11.2	83379
UNEF 13/16 x 20	118	38	16.0	12.5	83380
UNEF 7/8 x 20	118	38	16.0	12.5	83381
UNEF 15/16 x 20	130	45	18.0	14.0	83382
UNEF 1" x 20	130	45	18.0	14.0	83383

Application:

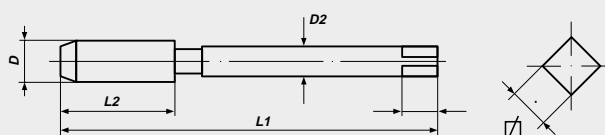
for general use

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for blind holes

Applicazione:

per uso universale

- Materiali con buona truciabilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per fori ciechi





Machine Taps

Unified thread ANSI B 1.1

Maschi a macchina

filettatura unificata ANSI B1.1



ISO 529

Form B

HSS-E

Tol. 2B

UN

Nominal Diameter D	L 1	L 2	D 2	☐	Art.-No.
-----------------------	-----	-----	-----	---	----------

UNS

UNS 1/4 x 24	66	19	6.3	5.0	83201
UNS 1/4 x 36	66	19	6.3	5.0	83202
UNS 1/4 x 40	66	19	6.3	5.0	83203
UNS 3/8 x 27	80	24	10.0	8.0	83204
UNS 7/16 x 24	85	25	8.0	6.3	83205
UNS 1/2 x 24	89	29	9.0	7.1	83206
UNS 5/8 x 27	102	32	12.5	10.0	83207
UNS 3/4 x 24	112	37	14.0	11.2	83208
UNS 7/8 x 18	118	38	16.0	12.5	83209
UNS 1" x 14	130	45	18.0	14.0	83210

UN

UN 5/16 x 20	72	22	8.0	6.3	83220
UN 5/16 x 28	72	22	8.0	6.3	83221
UN 3/8 x 20	80	24	10.0	8.0	83222
UN 3/8 x 28	80	24	10.0	8.0	83223
UN 7/16 x 32	85	25	8.0	6.3	83224
UN 1/2 x 32	89	29	9.0	7.1	83225
UN 9/16 x 20	95	30	11.2	9.0	83226
UN 9/16 x 28	95	30	11.2	9.0	83227
UN 9/16 x 32	95	30	11.2	9.0	83228
UN 5/8 x 20	102	32	12.5	10.0	83229
UN 5/8 x 28	102	32	12.5	10.0	83230
UN 11/16 x 20	112	37	14.0	11.2	83231
UN 11/16 x 16	112	37	14.0	11.2	83232
UN 1" x 32	130	45	18.0	14.0	83233

Application:

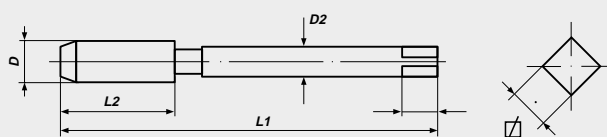
for general use

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through holes

Applicazione:

per uso universale

- Materiali con buona trucidibilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per fori passanti



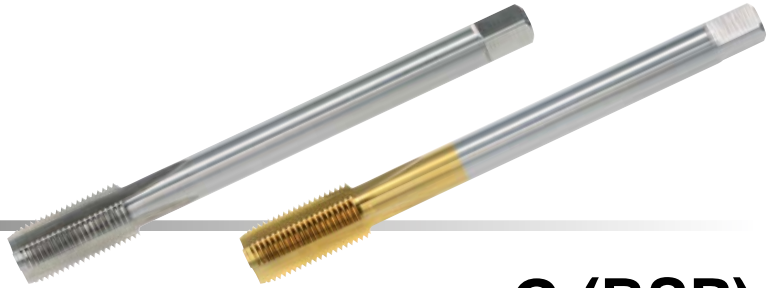


Machine Taps

Pipe-thread DIN ISO 228

Maschi a macchina

filettatura per tubi gas DIN ISO 228



DIN 5156

Form C

HSS-E

G (BSP)

Nominal Diameter D	L 1	L 2	D 2	∅	Art.-No.
G 1/8 x 28	90	20	7.0	5.5	78412
G 1/4 x 19	100	22	11.0	9.0	78414
G 3/8 x 19	100	22	12.0	9.0	78416
G 1/2 x 14	125	25	16.0	12.0	78418
G 5/8 x 14	125	25	18.0	14.5	78420
G 3/4 x 14	140	28	20.0	16.0	78422
G 7/8 x 14	150	28	22.0	18.0	78424
G 1" x 11	160	30	25.0	20.0	78426
G 1.1/8 x 11	170	30	28.0	22.0	78430
G 1.1/4 x 11	170	30	32.0	24.0	78434
G 1.3/8 x 11	180	32	36.0	29.0	78438
G 1.1/2 x 11	190	32	36.0	29.0	78442
G 1.3/4 x 11	190	32	40.0	32.0	78450
G 2" x 11	220	40	45.0	35.0	78454

TIN

G 1/8 x 28	90	20	7.0	5.5	78413
G 1/4 x 19	100	22	11.0	9.0	78415
G 3/8 x 19	100	22	12.0	9.0	78417
G 1/2 x 14	125	25	16.0	12.0	78419
G 3/4 x 14	140	28	20.0	16.0	78423
G 1" x 11	160	30	25.0	20.0	78427

Application: for general use

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes

TIN-coating:

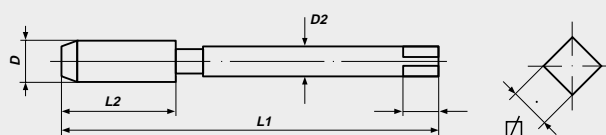
- improved resistance to wear and abrasion
- excellent anti-friction properties
- faster cutting speeds possible

Applicazione: per uso universale

- Materiali con buona truciabilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per fori ciechi

rivestimento TIN

- migliore resistenza all'abrasione e alla rottura
- eccellente uniformità
- possibile velocità di taglio superiore





Machine Taps

Pipe-thread DIN ISO 228

Maschi a macchina

filettatura per tubi gas DIN ISO 228



DIN 5156

Form B

HSS-E

G (BSP)

Nominal Diameter D	L 1	L 2	D 2	∅	Art.-No.
G 1/8 x 28	90	20	7.0	5.5	78512
G 1/4 x 19	100	22	11.0	9.0	78514
G 3/8 x 19	100	22	12.0	9.0	78516
G 1/2 x 14	125	25	16.0	12.0	78518
G 5/8 x 14	125	25	18.0	14.5	78520
G 3/4 x 14	140	28	20.0	16.0	78522
G 7/8 x 14	150	28	22.0	18.0	78524
G 1" x 11	160	30	25.0	20.0	78526
G 1.1/8 x 11	170	30	28.0	22.0	78530
G 1.1/4 x 11	170	30	32.0	24.0	78534
G 1.3/8 x 11	180	32	36.0	29.0	78538
G 1.1/2 x 11	190	32	36.0	29.0	78542
G 1.3/4 x 11	190	32	40.0	32.0	78550
G 2" x 11	220	40	45.0	35.0	78554

TIN

G 1/8 x 28	90	20	7.0	5.5	78513
G 1/4 x 19	100	22	11.0	9.0	78515
G 3/8 x 19	100	22	12.0	9.0	78517
G 1/2 x 14	125	25	16.0	12.0	78519
G 3/4 x 14	140	28	20.0	16.0	78523
G 1" x 11	160	30	25.0	20.0	78527

Application: for general use

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through holes

TIN-coating:

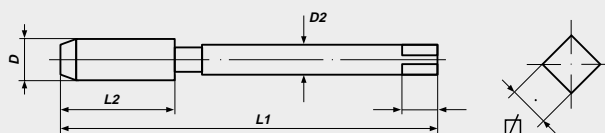
- improved resistance to wear and abrasion
- excellent anti-friction properties
- faster cutting speeds possible

Applicazione: per uso universale

- Materiali con buona truciabilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per fori passanti

rivestimento TIN:

- migliore resistenza all'abrasione e alla rottura
- eccellente uniformità
- possibile velocità di taglio superiore



Machine Taps

Pipe-thread DIN ISO 228

Maschi a macchina

filettatura per tubi gas DIN ISO 228



DIN 5156

Form C/35° RSP

HSS-E

G (BSP)

Nominal Diameter D	L 1	L 2	D 2	∅	Art.-No.
G 1/8 x 28	90	20	7.0	5.5	78712
G 1/4 x 19	100	22	11.0	9.0	78714
G 3/8 x 19	100	22	12.0	9.0	78716
G 1/2 x 14	125	25	16.0	12.0	78718
G 5/8 x 14	125	25	18.0	14.5	78720
G 3/4 x 14	140	28	20.0	16.0	78722
G 7/8 x 14	150	28	22.0	18.0	78724
G 1" x 11	160	30	25.0	20.0	78726
G 1.1/8 x 11	170	30	28.0	22.0	78730
G 1.1/4 x 11	170	30	32.0	24.0	78734
G 1.3/8 x 11	180	32	36.0	29.0	78738
G 1.1/2 x 11	190	32	36.0	29.0	78742
G 1.3/4 x 11	190	32	40.0	32.0	78750
G 2" x 11	220	40	45.0	35.0	78754

TIN

G 1/8 x 28	90	20	7.0	5.5	78713
G 1/4 x 19	100	22	11.0	9.0	78715
G 3/8 x 19	100	22	12.0	9.0	78717
G 1/2 x 14	125	25	16.0	12.0	78719
G 3/4 x 14	140	28	20.0	16.0	78723
G 1" x 11	160	30	25.0	20.0	78727

Application: for general use

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for blind holes

TIN-coating:

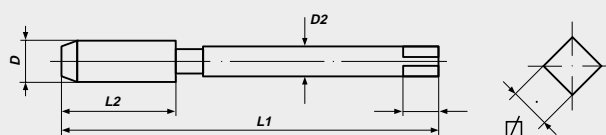
- improved resistance to wear and abrasion
- excellent anti-friction properties
- faster cutting speeds possible

Applicazione: per uso universale

- Materiali con buona truciabilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per fori ciechi

rivestimento TIN:

- migliore resistenza all' abrasione e alla rottura
- eccellente uniformità
- possibile velocità di taglio superiore





Machine Taps

tapered pipe thread, taper 1:16, con. 55°

Maschi a macchina

filettatura conica per tubi, cono 1:16

**DIN 5156****Form C****HSS-E****Rc (BSPT)**

Nominal Diameter D	L 1	L 2	D 2	☒	Art.-No.
Rc 1/8 x 28	90	20	7.0	5.5	73404
Rc 1/4 x 19	100	22	11.0	9.0	73406
Rc 3/8 x 19	100	22	12.0	9.0	73408
Rc 1/2 x 14	125	28	16.0	12.0	73410
Rc 3/4 x 14	140	28	20.0	16.0	73412
Rc 1" x 11	160	38	25.0	20.0	73414

Application:

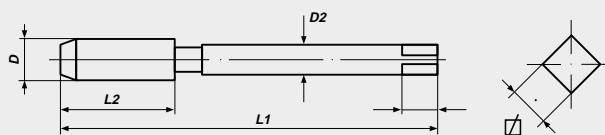
for general use

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes

Applicazione:

per uso universale

- Materiali con buona trucidibilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per fori passanti e ciechi





Machine Taps

american tapered pipe thread, taper 1:16

Maschi a macchina

filettatura americana conica per tubi, cono 1:16



Form C

HSS-E

NPT

Nominal Diameter D	L 1	L 2	D 2	Ø	Art.-No.
NPT 1/16 x 27	90	20	6.0	4.9	73432
NPT 1/8 x 27	90	20	7.0	5.5	73434
NPT 1/4 x 18	100	22	11.0	9.0	73436
NPT 3/8 x 18	100	22	12.0	9.0	73438
NPT 1/2 x 14	125	28	16.0	12.0	73440
NPT 3/4 x 14	140	28	20.0	16.0	73442
NPT 1" x 11.5	160	38	25.0	20.0	73444

Application:

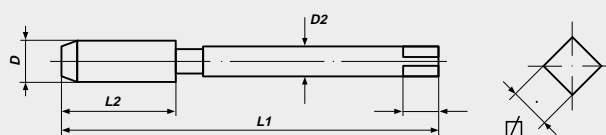
for general use

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes

Applicazione:

per uso universale

- Materiali con buona truciabilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per fori passanti e ciechi





Machine Taps

Knuckle thread DIN 405

Maschi a macchina

filettatura rotunda DIN 405

**DIN 374****Form C****HSS-E****Tol. 7H****Rd**

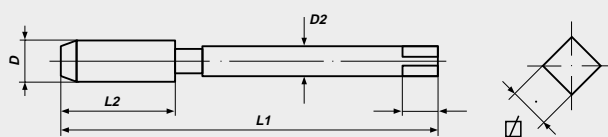
Nominal Diameter D	L 1	L 2	D 2	Ø	Art.-No.
Rd 8 x 1/10	90	26	6.0	4.9	79440
Rd 9 x 1/10	90	26	7.0	5.5	79441
Rd 10 x 1/10	100	28	7.0	5.5	79442
Rd 11 x 1/10	100	28	8.0	6.2	79443
Rd 12 x 1/10	110	28	9.0	7.0	79444
Rd 14 x 1/8	110	32	11.0	9.0	79445
Rd 16 x 1/8	110	32	12.0	9.0	79446
Rd 18 x 1/8	125	32	14.0	11.0	79447
Rd 20 x 1/8	140	32	16.0	12.0	79448
Rd 22 x 1/8	140	32	18.0	14.5	79449
Rd 24 x 1/8	160	34	18.0	14.5	79450
Rd 26 x 1/8	160	36	20.0	16.0	79451
Rd 28 x 1/8	160	36	20.0	16.0	79452
Rd 30 x 1/8	180	36	22.0	18.0	79453
Rd 32 x 1/8	180	36	25.0	20.0	79454
Rd 34 x 1/8	200	36	28.0	22.0	79455
Rd 36 x 1/8	200	36	28.0	22.0	79456
Rd 38 x 1/8	200	38	28.0	22.0	79457
Rd 40 x 1/6	200	50	32.0	24.0	79458
Rd 42 x 1/6	200	50	32.0	24.0	79459
Rd 44 x 1/6	200	50	36.0	29.0	79460

Application:**for general use**

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes

Applicazione:**per uso universale**

- Materiali con buona trucidibilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per fori passanti e ciechi





Machine Taps

Cycle thread DIN 79012

Maschi a macchina

filettatura per biciclette DIN 79012



DIN 374

Form C

HSS-E

Tol. medium

FG

Nominal Diameter D	L 1	L 2	D 2	☒	Art.-No.
FG 2 x 56	45	8	2.8	2.1	79401
FG 2.3 x 56	45	8	2.8	2.1	79402
FG 2.6 x 56	56	8	3.5	2.7	79403
FG 6.35 x 26	80	14	7.0	5.5	79404
FG 7.9 x 26	90	16	8.0	6.2	79405
FG 9.5 x 26	90	16	7.0	5.5	79406
FG 14.3 x 20	100	22	11.0	9.0	79407
FG 14.3 x 20 - LH	100	22	11.0	9.0	79408
FG 25.4 x 24	140	24	18.0	14.5	79409

Application:

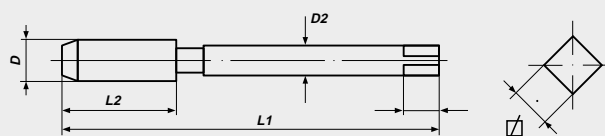
for general use

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes

Applicazione:

per uso universale

- Materiali con buona truciabilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per fori passanti e ciechi





Machine Taps

Cycle thread BS 811

Maschi a macchina

filettatura inglese per biciclette BS 811

**DIN 374****Form C****HSS-E****Tol. medium****BSC**

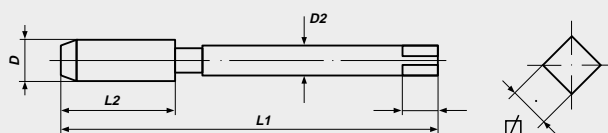
Nominal Diameter D	L 1	L 2	D 2	☒	Art.-No.
BSC 1/4 x 26	80	14	7.0	5.5	79420
BSC 5/16 x 26	90	16	8.0	6.2	79421
BSC 3/8 x 26	90	16	7.0	5.5	79422
BSC 9/16 x 20	100	22	11.0	9.0	79423
BSC 9/16 x 20 - LH	100	22	11.0	9.0	79424
BSC 1" x 24	140	24	18.0	14.5	79425

Application:**for general use**

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes

Applicazione:**per uso universale**

- Materiali con buona trucidibilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per fori passanti e ciechi





Machine Taps

Valve thread DIN 7756

Maschi a macchina

filettatura per valvole DIN 7756



DIN 374

Form C

HSS-E

Tol. medium

Vg

Nominal Diameter D	L 1	L 2	D 2	☒	Art.-No.
Vg 5 x 36	70	12	6.0	4.9	79430
Vg 5.2 x 24	80	17	6.0	4.9	79431
Vg 6 x 32	80	14	7.0	5.5	79432
Vg 8 x 32	80	16	8.0	6.2	79433
Vg 10 x 28	90	18	8.0	6.2	79434
Vg 12 x 26	100	22	9.0	7.0	79435

Application:

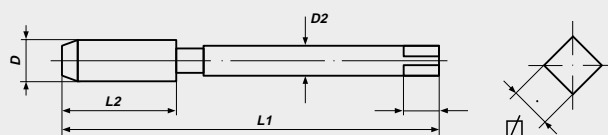
for general use

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes

Applicazione:

per uso universale

- Materiali con buona truciabilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per fori passanti e ciechi



**Machine Taps, *Left Hand***

metric ISO-thread DIN 13

Maschi a macchina, *filetto sinistro*

filettatura metrica ISO DIN 13

DIN 371

DIN 376

**DIN 371/376****Form C****HSS-E****Tol. ISO2/6H****M**

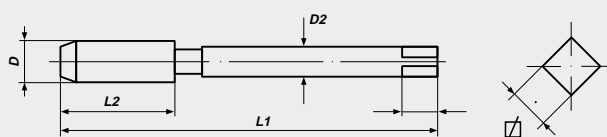
Nominal Diameter D	L 1	L 2	D 2	☐	Art.-No.
DIN 371					
M 3 x 0.5	56	11	3.5	2.7	33426
M 4 x 0.7	63	13	4.5	3.4	33430
M 5 x 0.8	70	16	6.0	4.9	33434
M 6 x 1.0	80	19	6.0	4.9	33438
M 8 x 1.25	90	22	8.0	6.2	33442
M 10 x 1.5	100	24	10.0	8.0	33446
DIN 376					
M 12 x 1.75	110	29	9.0	7.0	34450
M 14 x 2.0	110	30	11.0	9.0	34454
M 16 x 2.0	110	32	12.0	9.0	34458
M 18 x 2.5	125	34	14.0	11.0	34462
M 20 x 2.5	140	34	16.0	12.0	34466
M 22 x 2.5	140	34	18.0	14.5	34470
M 24 x 3.0	160	38	18.0	14.5	34474

Application:**for general use**

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes

Applicazione:**per uso universale**

- Materiali con buona trucidibilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per fori passanti e ciechi



Machine Taps, *Left Hand*

metric ISO-thread DIN 13

Maschi a macchina, *filetto sinistro*

filettatura metrica ISO DIN 13

DIN 371

DIN 376



DIN 371/376

Form B

HSS-E

Tol. ISO2/6H

M

Nominal Diameter D	L 1	L 2	D 2	☒	Art.-No.
DIN 371					
M 3 x 0.5	56	11	3.5	2.7	33526
M 4 x 0.7	63	13	4.5	3.4	33530
M 5 x 0.8	70	16	6.0	4.9	33534
M 6 x 1.0	80	19	6.0	4.9	33538
M 7 x 1.0	80	19	7.0	5.5	33540
M 8 x 1.25	90	22	8.0	6.2	33542
M 10 x 1.5	100	24	10.0	8.0	33546
DIN 376					
M 3 x 0.5	56	11	2.2	—	34526
M 4 x 0.7	63	13	2.8	2.1	34530
M 5 x 0.8	70	16	3.5	2.7	34534
M 6 x 1.0	80	19	4.5	3.4	34538
M 8 x 1.25	90	22	6.0	4.9	34542
M 10 x 1.5	100	24	7.0	5.5	34546
M 12 x 1.75	110	29	9.0	7.0	34550
M 14 x 2.0	110	30	11.0	9.0	34554
M 16 x 2.0	110	32	12.0	9.0	34558
M 18 x 2.5	125	34	14.0	11.0	34562
M 20 x 2.5	140	34	16.0	12.0	34566
M 22 x 2.5	140	34	18.0	14.5	34570
M 24 x 3.0	160	38	18.0	14.5	34574
M 27 x 3.0	160	38	20.0	16.0	34576
M 30 x 3.5	180	45	22.0	18.0	34578
M 33 x 3.5	180	50	25.0	20.0	34580
M 36 x 4.0	200	56	28.0	22.0	34582
M 39 x 4.0	200	60	32.0	24.0	34584
M 42 x 4.5	200	60	32.0	24.0	34586
M 45 x 4.5	220	65	36.0	29.0	34588
M 48 x 5.0	250	70	36.0	29.0	34590
M 52 x 5.0	250	70	40.0	32.0	34592

Application:

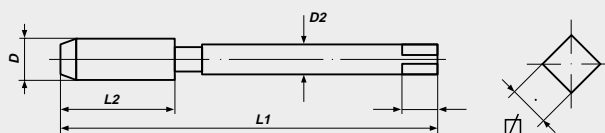
for general use

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through holes

Applicazione:

per uso universale

- Materiali con buona truciabilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per fori passanti



**Machine Taps, *Left Hand***

metric ISO-thread DIN 13

Maschi a macchina, *filetto sinistro*

filettatura metrica ISO DIN 13

DIN 371

DIN 376

**DIN 371/376****Form C/35°SP****HSS-E****Tol. ISO2/6H****M**

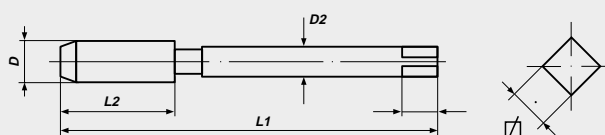
Nominal Diameter D	L 1	L 2	D 2	☒	Art.-No.
DIN 371					
M 3 x 0.5	56	6	3.5	2.7	33726
M 4 x 0.7	63	7	4.5	3.4	33730
M 5 x 0.8	70	8	6.0	4.9	33734
M 6 x 1.0	80	10	6.0	4.9	33738
M 8 x 1.25	90	14	8.0	6.2	33742
M 10 x 1.5	100	16	10.0	8.0	33746
DIN 376					
M 3 x 0.5	56	6	2.2	—	34726
M 4 x 0.7	63	7	2.8	2.1	34730
M 5 x 0.8	70	8	3.5	2.7	34734
M 6 x 1.0	80	10	4.5	3.4	34738
M 8 x 1.25	90	14	6.0	4.9	34742
M 10 x 1.5	100	16	7.0	5.5	34746
M 12 x 1.75	110	18	9.0	7.0	34750
M 14 x 2.0	110	20	11.0	9.0	34754
M 16 x 2.0	110	22	12.0	9.0	34758
M 18 x 2.5	125	25	14.0	11.0	34762
M 20 x 2.5	140	25	16.0	12.0	34766
M 22 x 2.5	140	27	18.0	14.5	34770
M 24 x 3.0	160	30	18.0	14.5	34774
M 27 x 3.0	160	30	20.0	16.0	34776
M 30 x 3.5	180	35	22.0	18.0	34778
M 33 x 3.5	180	35	25.0	20.0	34780
M 36 x 4.0	200	40	28.0	22.0	34782
M 39 x 4.0	200	40	32.0	24.0	34784
M 42 x 4.5	200	45	32.0	24.0	34786
M 45 x 4.5	220	45	36.0	29.0	34788
M 48 x 5.0	250	50	36.0	29.0	34790
M 52 x 5.0	250	50	40.0	32.0	34792

Application:**for general use**

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for blind holes

Applicazione:**per uso universale**

- Materiali con buona trucidibilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per fori ciechi





Machine Taps, *Left Hand*

metric-fine ISO-thread DIN 13

Maschi a macchina, *filetto sinistro*

filettatura metrica fine ISO DIN 13



DIN 374

Form B

HSS-E

Tol. ISO2/6H

Mf

Nominal Diameter D	L 1	L 2	D 2	☒	Art.-No.
M 3 x 0.35	56	9	2.2	-	34801
M 4 x 0.35	63	10	2.8	2.1	34802
M 4 x 0.5	63	10	2.8	2.1	34803
M 5 x 0.5	70	12	3.5	2.7	34804
M 5 x 0.75	70	12	3.5	2.7	34805
M 6 x 0.5	80	14	4.5	3.4	34806
M 6 x 0.75	80	14	4.5	3.4	34807
M 7 x 0.75	80	14	5.5	4.3	34808
M 8 x 0.5	80	19	6.0	4.9	34809
M 8 x 0.75	80	19	6.0	4.9	34810
M 8 x 1.0	90	22	6.0	4.9	34811
M 9 x 0.75	80	19	7.0	5.5	34812
M 9 x 1.0	90	22	7.0	5.5	34813
M 10 x 0.75	90	20	7.0	5.5	34814
M 10 x 1.0	90	20	7.0	5.5	34815
M 10 x 1.25	100	24	7.0	5.5	34816
M 11 x 1.0	90	20	8.0	6.2	34817
M 11 x 1.25	90	22	8.0	6.2	34818
M 12 x 0.75	100	22	9.0	7.0	34819
M 12 x 1.0	100	22	9.0	7.0	34820
M 12 x 1.25	100	22	9.0	7.0	34821
M 12 x 1.5	100	22	9.0	7.0	34822
M 13 x 1.0	100	22	11.0	9.0	34823
M 13 x 1.5	100	22	11.0	9.0	34824
M 14 x 0.75	100	22	11.0	9.0	34825
M 14 x 1.0	100	22	11.0	9.0	34826
M 14 x 1.25	100	22	11.0	9.0	34827
M 14 x 1.5	100	22	11.0	9.0	34828
M 15 x 1.0	100	22	12.0	9.0	34829
M 15 x 1.5	100	22	12.0	9.0	34830
M 16 x 1.0	100	22	12.0	9.0	34831
M 16 x 1.25	100	22	12.0	9.0	34832
M 16 x 1.5	100	22	12.0	9.0	34833
M 18 x 1.0	110	25	14.0	11.0	34834
M 18 x 1.25	110	25	14.0	11.0	34835
M 18 x 1.5	110	25	14.0	11.0	34836
M 18 x 2.0	125	34	14.0	11.0	34837



Application:

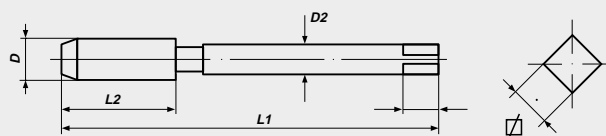
for general use

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through holes

Applicazione:

per uso universale

- Materiali con buona trucidibilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per fori passanti



**Machine Taps, *Left Hand***

metric-fine ISO-thread DIN 13

Maschi a macchina, *filetto sinistro*

filettatura metrica fine ISO DIN 13

**DIN 374****Form B****HSS-E****Tol. ISO2/6H****Mf**

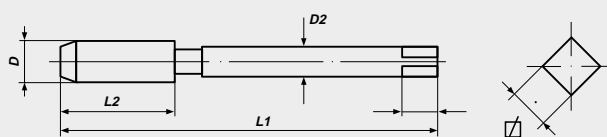
Nominal Diameter D	L 1	L 2	D 2	Ø	Art.-No.
M 20 x 1.0	125	25	16.0	12.0	34838
M 20 x 1.25	125	25	16.0	12.0	34839
M 20 x 1.5	125	25	16.0	12.0	34840
M 20 x 2.0	140	34	16.0	12.0	34841
M 21 x 1.5	125	25	16.0	12.0	34842
M 22 x 1.0	125	25	18.0	14.5	34843
M 22 x 1.25	125	25	18.0	14.5	34844
M 22 x 1.5	125	25	18.0	14.5	34845
M 22 x 2.0	140	34	18.0	14.5	34846
M 23 x 1.5	125	25	18.0	14.5	34847
M 24 x 1.0	140	28	18.0	14.5	34848
M 24 x 1.25	140	28	18.0	14.5	34849
M 24 x 1.5	140	28	18.0	14.5	34850
M 24 x 2.0	140	28	18.0	14.5	34851
M 25 x 1.0	140	28	18.0	14.5	34852
M 25 x 1.5	140	28	18.0	14.5	34853
M 26 x 1.0	140	28	18.0	14.5	3485X
M 26 x 1.5	140	28	18.0	14.5	34854
M 26 x 2.0	140	28	18.0	14.5	34855
M 27 x 1.0	140	28	20.0	16.0	34800
M 27 x 1.5	140	28	20.0	16.0	34856
M 27 x 2.0	140	28	20.0	16.0	34857
M 28 x 1.0	140	28	20.0	16.0	34858
M 28 x 1.5	140	28	20.0	16.0	34859
M 28 x 2.0	140	28	20.0	16.0	34860
M 29 x 1.5	150	28	22.0	18.0	34861
M 30 x 1.0	150	28	22.0	18.0	34862
M 30 x 1.5	150	28	22.0	18.0	34863
M 30 x 2.0	150	28	22.0	18.0	34864
M 30 x 2.5	180	45	22.0	18.0	3486X
M 30 x 3.0	180	45	22.0	18.0	34865
M 32 x 1.5	150	28	22.0	18.0	34866
M 32 x 2.0	150	28	22.0	18.0	34867
M 32 x 3.0	180	50	22.0	18.0	34892
M 33 x 1.5	160	30	25.0	20.0	34893
M 33 x 2.0	160	30	25.0	20.0	34868
M 33 x 3.0	180	50	25.0	20.0	34869

**Application:****for general use**

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through holes

Applicazione:**per uso universale**

- Materiali con buona trucidibilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per fori passanti





Machine Taps, *Left Hand*

metric-fine ISO-thread DIN 13

Maschi a macchina, *filetto sinistro*

filettatura metrica fine ISO DIN 13



DIN 374

Form B

HSS-E

Tol. ISO2/6H

Mf

Nominal Diameter D	L 1	L 2	D 2	☐	Art.-No.
M 34 x 1.5	170	30	28.0	22.0	34870
M 34 x 2.0	170	30	28.0	22.0	34871
M 35 x 1.5	170	30	28.0	22.0	34872
M 36 x 1.5	170	30	28.0	22.0	34873
M 36 x 2.0	170	30	28.0	22.0	34874
M 36 x 3.0	200	56	28.0	22.0	34875
M 38 x 1.5	170	30	28.0	22.0	34876
M 39 x 1.5	170	30	32.0	24.0	34877
M 39 x 2.0	170	30	32.0	24.0	34878
M 39 x 3.0	200	60	32.0	24.0	34879
M 40 x 1.5	170	30	32.0	24.0	34880
M 40 x 2.0	170	30	32.0	24.0	34881
M 40 x 3.0	200	60	32.0	24.0	34882
M 42 x 1.5	170	30	32.0	24.0	34883
M 42 x 2.0	170	30	32.0	24.0	34884
M 42 x 3.0	200	60	32.0	24.0	34885
M 45 x 1.5	180	32	36.0	29.0	34886
M 45 x 2.0	180	32	36.0	29.0	34887
M 45 x 3.0	200	50	36.0	29.0	34888
M 48 x 1.5	190	32	36.0	29.0	34889
M 48 x 2.0	190	32	36.0	29.0	34890
M 48 x 3.0	225	50	36.0	29.0	34891
M 50 x 1.5	190	32	36.0	29.0	34894
M 50 x 2.0	190	32	36.0	29.0	34895
M 50 x 3.0	225	50	36.0	29.0	34896
M 52 x 1.5	190	32	40.0	32.0	34897
M 52 x 2.0	190	32	40.0	32.0	34898
M 52 x 3.0	225	50	40.0	32.0	34899

Application:

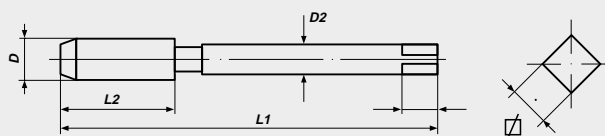
for general use

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through holes

Applicazione:

per uso universale

- Materiali con buona truciabilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per fori passanti



**Machine Taps, *Left Hand***

metric-fine ISO-thread DIN 13

Maschi a macchina, *filetto sinistro*

filettatura metrica fine ISO DIN 13

**DIN 374****Form C/35° SP****HSS-E****Tol. ISO2/6H****Mf**

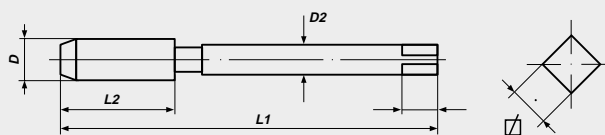
Nominal Diameter D	L 1	L 2	D 2	☐	Art.-No.
M 3 x 0.35	56	5	2.2	-	34901
M 4 x 0.35	63	5	2.8	2.1	34902
M 4 x 0.5	63	5	2.8	2.1	34903
M 5 x 0.5	70	5	3.5	2.7	34904
M 5 x 0.75	70	8	3.5	2.7	34905
M 6 x 0.5	80	5	4.5	3.4	34906
M 6 x 0.75	80	8	4.5	3.4	34907
M 7 x 0.75	80	8	5.5	4.3	34908
M 8 x 0.5	80	8	6.0	4.9	34909
M 8 x 0.75	80	8	6.0	4.9	34910
M 8 x 1.0	90	10	6.0	4.9	34911
M 9 x 0.75	80	10	7.0	5.5	34912
M 9 x 1.0	90	10	7.0	5.5	34913
M 10 x 0.75	90	10	7.0	5.5	34914
M 10 x 1.0	90	10	7.0	5.5	34915
M 10 x 1.25	100	16	7.0	5.5	34916
M 11 x 1.0	90	11	8.0	6.2	34917
M 11 x 1.25	90	14	8.0	6.2	34918
M 12 x 0.75	100	10	9.0	7.0	34919
M 12 x 1.0	100	11	9.0	7.0	34920
M 12 x 1.25	100	15	9.0	7.0	34921
M 12 x 1.5	100	15	9.0	7.0	34922
M 13 x 1.0	100	11	11.0	9.0	34923
M 13 x 1.5	100	15	11.0	9.0	34924
M 14 x 0.75	100	10	11.0	9.0	34925
M 14 x 1.0	100	11	11.0	9.0	34926
M 14 x 1.25	100	15	11.0	9.0	34927
M 14 x 1.5	100	15	11.0	9.0	34928
M 15 x 1.0	100	12	12.0	9.0	34929
M 15 x 1.5	100	15	12.0	9.0	34930
M 16 x 1.0	100	12	12.0	9.0	34931
M 16 x 1.25	100	15	12.0	9.0	34932
M 16 x 1.5	100	15	12.0	9.0	34933
M 18 x 1.0	110	13	14.0	11.0	34934
M 18 x 1.25	110	15	14.0	11.0	34935
M 18 x 1.5	110	17	14.0	11.0	34936
M 18 x 2.0	125	20	14.0	11.0	34937

**Application:****for general use**

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for blind holes

Applicazione:**per uso universale**

- Materiali con buona truciabilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per fori ciechi





Machine Taps, *Left Hand*

metric-fine ISO-thread DIN 13

Maschi a macchina, *filetto sinistro*

filettatura metrica fine ISO DIN 13



DIN 374

Form C/35° SP

HSS-E

Tol. ISO2/6H

Mf

Nominal Diameter D	L 1	L 2	D 2	☒	Art.-No.
M 20 x 1.0	125	14	16.0	12.0	34938
M 20 x 1.25	125	17	16.0	12.0	34939
M 20 x 1.5	125	17	16.0	12.0	34940
M 20 x 2.0	140	20	16.0	12.0	34941
M 21 x 1.5	125	17	16.0	12.0	34942
M 22 x 1.0	125	14	18.0	14.5	34943
M 22 x 1.25	125	17	18.0	14.5	34944
M 22 x 1.5	125	17	18.0	14.5	34945
M 22 x 2.0	140	20	18.0	14.5	34946
M 23 x 1.5	125	17	18.0	14.5	34947
M 24 x 1.0	140	15	18.0	14.5	34948
M 24 x 1.25	140	17	18.0	14.5	34949
M 24 x 1.5	140	20	18.0	14.5	34950
M 24 x 2.0	140	20	18.0	14.5	34951
M 25 x 1.0	140	15	18.0	14.5	34952
M 25 x 1.5	140	20	18.0	14.5	34953
M 26 x 1.0	140	15	18.0	14.5	3495X
M 26 x 1.5	140	20	18.0	14.5	34954
M 26 x 2.0	140	20	18.0	14.5	34955
M 27 x 1.0	140	15	20.0	16.0	34900
M 27 x 1.5	140	20	20.0	16.0	34956
M 27 x 2.0	140	20	20.0	16.0	34957
M 28 x 1.0	140	15	20.0	16.0	34958
M 28 x 1.5	140	20	20.0	16.0	34959
M 28 x 2.0	140	20	20.0	16.0	34960
M 29 x 1.5	150	22	22.0	18.0	34961
M 30 x 1.0	150	17	22.0	18.0	34962
M 30 x 1.5	150	22	22.0	18.0	34963
M 30 x 2.0	150	22	22.0	18.0	34964
M 30 x 2.5	180	27	22.0	18.0	3496X
M 30 x 3.0	180	30	22.0	18.0	34965
M 32 x 1.5	150	22	22.0	18.0	34966
M 32 x 2.0	150	22	22.0	18.0	34967
M 32 x 3.0	180	30	22.0	18.0	34992
M 33 x 1.5	160	24	25.0	20.0	34993
M 33 x 2.0	160	24	25.0	20.0	34968
M 33 x 3.0	180	30	25.0	20.0	34969



Application:

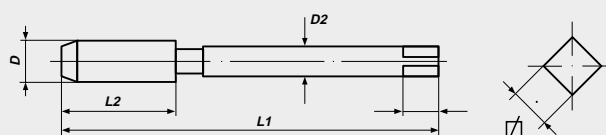
for general use

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for blind holes

Applicazione:

per uso universale

- Materiali con buona trucidibilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per fori ciechi



**Machine Taps, *Left Hand***

metric-fine ISO-thread DIN 13

Maschi a macchina, *filetto sinistro*

filettatura metrica fine ISO DIN 13

**DIN 374****Form C/35° SP****HSS-E****Tol. ISO2/6H****Mf**

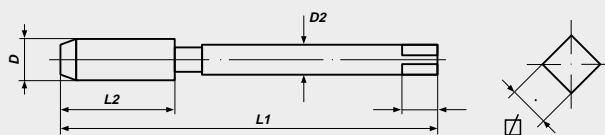
Nominal Diameter D	L 1	L 2	D 2	Ø	Art.-No.
M 34 x 1.5	170	24	28.0	22.0	34970
M 34 x 2.0	170	24	28.0	22.0	34971
M 35 x 1.5	170	24	28.0	22.0	34972
M 36 x 1.5	170	24	28.0	22.0	34973
M 36 x 2.0	170	24	28.0	22.0	34974
M 36 x 3.0	200	30	28.0	22.0	34975
M 38 x 1.5	170	24	28.0	22.0	34976
M 39 x 1.5	170	25	32.0	24.0	34977
M 39 x 2.0	170	25	32.0	24.0	34978
M 39 x 3.0	200	30	32.0	24.0	34979
M 40 x 1.5	170	25	32.0	24.0	34980
M 40 x 2.0	170	25	32.0	24.0	34981
M 40 x 3.0	200	30	32.0	24.0	34982
M 42 x 1.5	170	25	32.0	24.0	34983
M 42 x 2.0	170	25	32.0	24.0	34984
M 42 x 3.0	200	30	32.0	24.0	34985
M 45 x 1.5	180	27	36.0	29.0	34986
M 45 x 2.0	180	27	36.0	29.0	34987
M 45 x 3.0	200	30	36.0	29.0	34988
M 48 x 1.5	190	27	36.0	29.0	34989
M 48 x 2.0	190	27	36.0	29.0	34990
M 48 x 3.0	225	33	36.0	29.0	34991
M 50 x 1.5	190	27	36.0	29.0	34994
M 50 x 2.0	190	27	36.0	29.0	34995
M 50 x 3.0	225	33	36.0	29.0	34996
M 52 x 1.5	190	27	40.0	32.0	34997
M 52 x 2.0	190	27	40.0	32.0	34998
M 52 x 3.0	225	33	40.0	32.0	34999

Application:**for general use**

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for blind holes

Applicazione:**per uso universale**

- Materiali con buona truciabilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per fori ciechi





Machine Taps, *Left Hand*

Whitworth-thread BS 84

Maschi a macchina, *filetto sinistro*

filettatura Whitworth BS 84



≈ DIN 371/376

Form B

HSS-E

BSW

Nominal Diameter D	L 1	L 2	D 2	☒	Art.-No.
≈ DIN 371					
BSW 1/8 x 40	56	11	3.5	2.7	70201
BSW 5/32 x 32	63	13	4.5	3.4	70202
BSW 3/16 x 24	70	15	6.0	4.9	70203
BSW 1/4 x 20	80	17	7.0	5.5	70204
BSW 5/16 x 18	90	20	8.0	6.2	70205
BSW 3/8 x 16	100	22	9.0	7.0	70206
BSW 7/16 x 14	100	22	11.0	9.0	70207
≈ DIN 376					
BSW 1/2 x 12	110	25	9.0	7.0	70221
BSW 9/16 x 12	110	26	11.0	9.0	70222
BSW 5/8 x 11	110	27	12.0	9.0	70223
BSW 3/4 x 10	125	30	14.0	11.0	70224
BSW 7/8 x 9	140	32	18.0	14.5	70225
BSW 1" x 8	160	36	20.0	16.0	70226

Application:

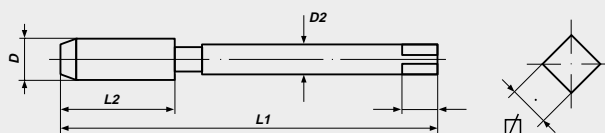
for general use

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through holes

Applicazione:

per uso universale

- Materiali con buona truciabilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per fori passanti



**Machine Taps, *Left Hand***

Whitworth-thread BS 84

Maschi a macchina, *filetto sinistro*

filettatura Whitworth BS 84



≈ DIN 371/376

Form C/35° SP

HSS-E

BSW

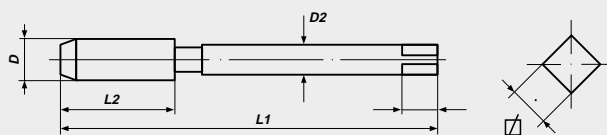
Nominal Diameter D	L 1	L 2	D 2	Ø	Art.-No.
≈ DIN 371					
BSW 1/8 x 40	56	7	3.5	2.7	70209
BSW 5/32 x 32	63	7	4.5	3.4	70210
BSW 3/16 x 24	70	10	6.0	4.9	70211
BSW 1/4 x 20	80	13	7.0	5.5	70212
BSW 5/16 x 18	90	14	8.0	6.2	70213
BSW 3/8 x 16	100	16	9.0	7.0	70214
BSW 7/16 x 14	100	17	11.0	9.0	70215
≈ DIN 376					
BSW 1/2 x 12	110	20	9.0	7.0	70234
BSW 9/16 x 12	110	20	11.0	9.0	70235
BSW 5/8 x 11	110	22	12.0	9.0	70236
BSW 3/4 x 10	125	25	14.0	11.0	70237
BSW 7/8 x 9	140	27	18.0	14.5	70238
BSW 1" x 8	160	30	20.0	16.0	70239

Application:**for general use**

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for blind holes

Applicazione:**per uso universale**

- Materiali con buona truciabilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per fori ciechi





Machine Taps, *Left Hand*

Unified thread ANSI B1.1

Maschi a macchina, *filetto sinistro*

filettatura unificata ANSI B1.1



≈ DIN 371/376

Form B

HSS-E

Tol. 2B

UNC/UNF

Nominal Diameter D	L 1	L 2	D 2	☐	Art.-No.
-----------------------	-----	-----	-----	---	----------

UNC ≈ DIN 371

UNC Nr. 6 x 32	56	12	4.0	3.0	74203
UNC Nr. 8 x 32	63	13	4.5	3.4	74204
UNC Nr. 10 x 24	70	15	6.0	4.9	74205
UNC 1/4 x 20	80	17	7.0	5.5	74207
UNC 5/16 x 18	90	20	8.0	6.2	74208
UNC 3/8 x 16	100	22	9.0	7.0	74209

≈ DIN 376

UNC 7/16 x 14	100	22	8.0	6.2	74228
UNC 1/2 x 13	110	25	9.0	7.0	74229
UNC 9/16 x 12	110	26	11.0	9.0	74230
UNC 5/8 x 11	110	27	12.0	9.0	74231
UNC 3/4 x 10	125	30	14.0	11.0	74232
UNC 7/8 x 9	140	32	18.0	14.5	74233
UNC 1" x 8	160	36	20.0	16.0	74234

UNF ≈ DIN 371

UNF Nr. 10 x 32	70	15	6.0	4.9	76205
UNF 1/4 x 28	80	17	7.0	5.5	76207
UNF 5/16 x 24	90	17	8.0	6.2	76208
UNF 3/8 x 24	100	18	9.0	7.0	76209
UNF 7/16 x 20	100	22	11.0	9.0	76210

≈ DIN 376

UNF 7/16 x 20	100	22	8.0	6.2	76220
UNF 1/2 x 20	100	22	9.0	7.0	76222
UNF 9/16 x 18	100	22	11.0	9.0	76223
UNF 5/8 x 18	100	22	12.0	9.0	76224
UNF 3/4 x 16	110	25	14.0	11.0	76225
UNF 7/8 x 14	140	26	18.0	14.5	76226
UNF 1" x 12	150	28	20.0	16.0	76227
UNF 1" x 14	150	28	20.0	16.0	76228

Application:

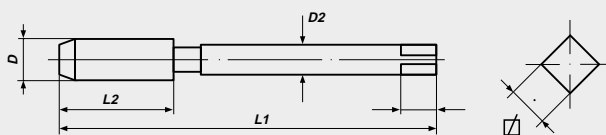
for general use

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through holes

Applicazione:

per uso universale

- Materiali con buona truciabilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per fori passanti



**Machine Taps, *Left Hand***

Unified thread ANSI B1.1

Maschi a macchina, *filetto sinistro*

filettatura unificata ANSI B1.1



≈ DIN 371/376

Form C/35° SP

HSS-E

Tol. 2B

UNC/UNF

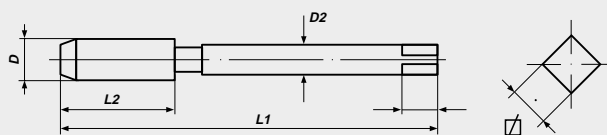
Nominal Diameter D	L 1	L 2	D 2	☒	Art.-No.
UNC ≈ DIN 371					
UNC Nr. 6 x 32	56	7	4.0	3.0	74212
UNC Nr. 8 x 32	63	8	4.5	3.4	74213
UNC Nr. 10 x 24	70	10	6.0	4.9	74214
UNC 1/4 x 20	80	13	7.0	5.5	74216
UNC 5/16 x 18	90	14	8.0	6.2	74217
UNC 3/8 x 16	100	16	9.0	7.0	74218
≈ DIN 376					
UNC 7/16 x 14	100	17	8.0	6.2	74248
UNC 1/2 x 13	110	20	9.0	7.0	74249
UNC 9/16 x 12	110	20	11.0	9.0	74250
UNC 5/8 x 11	110	22	12.0	9.0	74251
UNC 3/4 x 10	125	25	14.0	11.0	74252
UNC 7/8 x 9	140	27	18.0	14.5	74253
UNC 1" x 8	160	30	20.0	16.0	74254
UNF ≈ DIN 371					
UNF Nr. 10 x 32	70	10	6.0	4.9	76215
UNF 1/4 x 28	80	10	7.0	5.5	76217
UNF 5/16 x 24	90	10	8.0	6.2	76218
UNF 3/8 x 24	100	10	9.0	7.0	76219
≈ DIN 376					
UNF 1/2 x 20	100	13	9.0	7.0	76232
UNF 9/16 x 18	100	15	11.0	9.0	76233
UNF 5/8 x 18	100	15	12.0	9.0	76234
UNF 3/4 x 16	110	17	14.0	11.0	76235
UNF 7/8 x 14	140	17	18.0	14.5	76236
UNF 1" x 12	150	20	20.0	16.0	76237
UNF 1" x 14	150	20	20.0	16.0	76238

Application:**for general use**

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for blind holes

Applicazione:**per uso universale**

- Materiali con buona truciolidità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per fori ciechi





Machine Taps, *Left Hand*

Pipe-thread DIN ISO 228

Maschi a macchina, *filetto sinistro*

filettatura per tubi gas DIN ISO 228



DIN 5156

Form C

HSS-E

G (BSP)

Nominal Diameter D	L 1	L 2	D 2	Ø	Art.-No.
G 1/8 x 28	90	20	7.0	5.5	78202
G 1/4 x 19	100	22	11.0	9.0	78203
G 3/8 x 19	100	22	12.0	9.0	78204
G 1/2 x 14	125	25	16.0	12.0	78205
G 5/8 x 14	125	25	18.0	14.5	78206
G 3/4 x 14	140	28	20.0	16.0	78207
G 1" x 11	160	30	25.0	20.0	78209

Application:

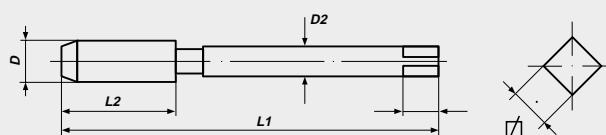
for general use

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes

Applicazione:









per uso universale

- Materiali con buona truciabilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per fori passanti e ciechi





MACHINE TAPS WITH COLOURED RING MASCHI A MACCHINA CON COLLARINI COLORATI

		Form B/A/C	39°RSP	TwinBox
	for general use per uso universale	138	139	153
	for general use per uso universale	140	141	
	for wear resistant steel Acciaio resistente all'abrasione	142	143	154
	for stainless steel Acciaio inossidabile	144	146	155
	for cast iron Ghisa grigia	148		
	Material from 1200 N/mm2 tensile strength Materiali con resistenza alla trazione da 1.200 N/mm²	151		
	for aluminium alloys Alluminio	149		
	for brass Ottone	150		



because available ■ because reliable ■ because you ■



RECOMMENDED APPLICATION OF COLOURED RING MACHINE TAPS

APPLICAZIONE RACCOMANDATA PER MASCHI A MACCHINA CON COLLARINI COLORATI

Material Materiali	Cutting Speed Velocità di taglio V= m/min	coolants and lubrications Refrigerazione e lubrificante
Unalloyed steels, tensile strength < 800 N/mm ² Acciai non legati, resistenza alla trazione < 800 N/mm ²	10 - 18	drilling oil emulsion, cutting oil also with lubricity- increasing additives Emulsione, Olio da taglio con additivi che aumentano la lubrificazione
Machining steels, case hardening steels, tempered steels Acciai automatici, acciai da cementazione, acciai bonificati	10 - 18	
Unalloyed steels, tensile strength < 1000 N/mm ² Acciai non legati, resistenza alla trazione < 1000 N/mm ²	6 - 10	
Unalloyed and alloyed steels, tensile strength < 1200 N/mm ² Acciai legati e non legati, resistenza alla trazione < 1200 N/mm ²	3 - 5	thread cutting oil, cutting oil highly activated with special additives, solid lubricants Olio da taglio per maschiatura, Olio da taglio con additivi lubrificanti solidi
Unalloyed and alloyed steels, tensile strength > 1200 N/mm ² Acciai legati e non legati, resistenza alla trazione > 1200 N/mm ²	2 - 4	
Stainless and acid-resistant steels; VA-steels < 850 N/mm ² Acciai inossidabili < 850 N / mm ²	2 - 4	
Rust- and acid-resistant steels with high chromium-nickel content, V4A steels Acciai inossidabili con alto contenuto in Cromo-Nickel, Acciai V4A	2 - 4	
Gray cast iron Ghisa grigia	8 - 16	thread cutting oil, special thread cutting oil and emulsion Olio da taglio per maschiatura ed emulsione
Graphite cast iron, malleable cast iron Ghisa sferoidale etemprata	8 - 16	
Copper alloys short chipping Leghe di rame, ottone a truciolo corto	18 - 24	thread cutting oil, emulsion Olio da taglio maschiatura, emulsione
Long-chipping brass Ottone a truciolo lungo	12 - 18	
Aluminium, magnesium, unalloyed Alluminio, Magnesio, non legato	20 - 30	thread cutting oil for non-ferrous metals, emulsion, petroleum Olio da taglio per maschiatura per metalli non ferrosi Emulsione, Petrolio
Aluminium alloys, Si < 0,5% Leghe di alluminio, Si < 0,5%	18 - 24	
Aluminium alloys, Si 0,5 - 10% Leghe di alluminio, Si 0,5 - 10%	14 - 18	
Aluminium alloys, Si > 10% Leghe di alluminio, Si > 10%	8 - 10	
Titanium alloys Leghe di titanio	2 - 4	oil, special thread cutting oil Olio, o da taglio speciale per maschiatura
Thermoplastics Termoplastiche	18 - 24	mold release oil, dry, oil mist, compressed air, emulsion Olio di distacco dallo stampo, secco, Olio nebulizzato, secco, aria compressa, emulsione
Thermosetting and fibre-reinforced plastics Duroplaste e plastica rinforzata con fibre	8 - 12	



RECOMMENDED APPLICATION OF COLOURED RING MACHINE TAPS APPLICAZIONE RACCOMANDATA PER MASCHI A MACCHINA CON COLLARINI COLORATI

Material Materiali	Green Ring collarino verde	Green Ring PM collarino verde PM	Blue Ring collarino blu	White Ring collarino bianco	Black Ring collarino nero	Yellow Ring collarino giallo	Orange Ring collarino arancion	Red Ring collarino rosso
Unalloyed steels, tensile strength < 800 N/mm ² Acciai non legati, resistenza alla trazione < 800 N/mm ²	●	PM						
Machining steels, case hardening steels, tempered steels Acciai automatici, acciai da cementazione, acciai bonificati	●	PM	●	○				
Unalloyed steels, tensile strength < 1000 N/mm ² Acciai non legati, resistenza alla trazione < 1000 N/mm ²	●	PM	●					
Unalloyed and alloyed steels, tensile strength < 1200 N/mm ² Acciai legati e non legati, resistenza alla trazione < 1200 N/mm ²		PM	●					○
Unalloyed and alloyed steels, tensile strength > 1200 N/mm ² Acciai legati e non legati, resistenza alla trazione > 1200 N/mm ²								●
Stainless and acid-resistant steels; VA-steels < 850 N/mm ² Acciai inossidabili < 850 N/mm ²		PM	○	○				
Rust- and acid-resistant steels with high chromium-nickel content, V4A steels Acciai inossidabili con alto contenuto in Cromo-Nickel, Acciai V4A			●	○				
Gray cast iron Ghisa grigia					●			
Graphite cast iron, malleable cast iron Ghisa sferoidale etemprata	●	PM	●					
Copper alloys short chipping Leghe di rame, ottone a truciolo corto					○		●	
Long-chipping brass Ottone a truciolo lungo	○	PM						
Aluminium, magnesium, unalloyed Alluminio, Magnesio, non legato						●		
Aluminium alloys, Si < 0,5% Leghe di alluminio, Si < 0,5%			○			●		
Aluminium alloys, Si 0,5 - 10% Leghe di alluminio, Si 0,5 - 10%	○	PM	●			○		
Aluminium alloys, Si > 10% Leghe di alluminio, Si > 10%			●					
Titanium alloys Leghe di titanio			○	○				
Thermoplastics Termoplastiche	●	PM						
Thermosetting and fibre-reinforced plastics Duroplaste e plastica rinforzata con fibre			○		●			●

● = appropriate / idoneità ottimale ○ = conditionally suitable / idoneità limitata



Material No.	DIN	AISI	AFNOR	JIS	tensile strength N/mm ² min./max.		recommendation 1	recommendation 2
1.0044	St 44-2	A 570:Gr.40	E-28-2	SM 41 B	410	560	Standard Form A-C-B-RSP	Green Ring
1.0060	St 60-2			SM 570	600	720	Standard Form A-C-B-RSP	Green Ring
1.0070	St 70-2				670	830	Standard Form A-C-B-RSP	Green Ring
1.0116	St 37-3	A 573:Gr.58	E 24-3;E 24-4		370	450	Standard Form A-C-B-RSP	Green Ring
1.0570	St 52-3		E 36-3;E 36-4	SM 50 YA	450	680	Standard Form A-C-B-RSP	Green Ring
1.0301	C 10	1010	AF 34 C 10	S 10 C	490	780	Standard Form A-C-B-RSP	Green Ring
1.0402	C 22	1020	AF 42 C 20		470	650	Standard Form A-C-B-RSP	Green Ring
1.0501	C 35	1035	AF 55 C 35		550	780	Standard Form A-C-B-RSP	Green Ring
1.0511	C 40	1040	AF 60 C 40		600	800	Standard Form A-C-B-RSP	Green Ring
1.0711	9S 20	1112		SUM 21	370	450	Green Ring	Standard Form B-RSP
1.0715	9SMn 28	1213	S 250	SUM 22	390	580	Green Ring	Standard Form B-RSP
1.0718	9SMnPb 28	12L13	S 250 Pb	SUM 22 L	380	810	Green Ring	Standard Form B-RSP
1.0726	35S 20	1140	35 MF 6		510	880	Green Ring	Standard Form B-RSP
1.0736	9SMn 36	1215	S 300		390	800	Green Ring	Standard Form B-RSP
1.0737	9SMnPb 36	12L14	S 300 Pb		390	800	Green Ring	Standard Form B-RSP
1.0712	13Cr 3				500	800	Green Ring	Standard Form B-RSP
1.1121	Ck 10	1010	XC 10	S 10 C	450	630	Green Ring	Standard Form B-RSP
1.1141	Ck 15	1015	XC 15;XC 18	S 15C;S 15 CK	450	630	Green Ring	Standard Form B-RSP
1.7131	16MnCr 5	5115	16 MC 5	SCR 415	500	700	Green Ring	Standard Form B-RSP
1.1151	Ck 22	1023	XC 25;XC 18	S 20 C; S 20 CK	470	650	Green Ring	Standard Form B-RSP
1.1158	Ck 25	1025	XC 25	S 25 C	500	700	Green Ring	Standard Form B-RSP
1.1183	Cf 35				540	780	Green Ring	Standard Form B-RSP
1.1191	Ck 45	1045	XC 42	S 45 C	650	850	Green Ring PM	Green Ring
1.1203	Ck 55	1055	XC 55	S 55 C	700	950	Green Ring PM	Green Ring
1.1213	Cf 53		XC 48 TS		650	800	Green Ring PM	Green Ring
1.1221	Ck 60	1060	XC 60	S 58 C	750	1000	Green Ring PM	Green Ring
1.5752	14NiCr 14 (ECN 35)	3310;9314	12 NC 15	SNC 815 (H)	880	1000	Green Ring PM	Green Ring
1.0401	C 15	1015	AF 34 C 12		600	900	Green Ring PM	Green Ring
1.0503	C 45	1045	AF 65 C 45	S 45 C	650	850	Green Ring PM	Green Ring
1.0535	C 55	1055			700	950	Green Ring PM	Green Ring
1.0601	C 60	1060	CC 55		750	1000	Green Ring PM	Green Ring
1.1157	40Mn 4	1039	35 M 5		800	1000	Green Ring PM	Green Ring
1.1181	Ck 35	1035	XC 38 H1;XC 32	S 35 C	550	780	Green Ring PM	Green Ring
1.6582	35CrNiMo 6	4340	35 NCD 6	SNCM 447	800	1000	Green Ring PM	Green Ring
1.7015	15Cr 3	5015	12 C 3	SCR 415 (H)	690	1000	Green Ring PM	Green Ring
1.7033	34Cr 4	5132	32 C 4	SCr 430 (H)	700	1000	Green Ring PM	Green Ring
1.7035	41Cr 4	5140	32 C 4	SCr 440 (H)	800	1000	Green Ring PM	Green Ring
1.7218	25CrMo 4	4130	25 CD 4 S	SCM 420;SCM 430	800	1000	Green Ring PM	Green Ring
1.7223	41CrMo 4	4142;4140	42 CD 4 TS	SCM 440	800	1000	Green Ring PM	Green Ring
1.7225	42CrMo 4	4142;4140	42 CD 4 TS	SCM 440	800	1000	Green Ring PM	Green Ring
1.7361	32CrMo 12		30 CD 12		690	1000	Green Ring PM	Green Ring
1.6582	35CrNiMo 6	4340	35 NCD 6	SNCM 447	1000	1200	Blue Ring	
1.8515	31 CrMo 12		30 CD 12		1000	1200	Blue Ring	
1.8519	31CrMo V 9				1000	1250	Blue Ring	
1.8523	39CrMoV 13 9				1000	1200	Blue Ring	
1.1157	40Mn 4	1039	35 M 5		1000	1100	Blue Ring	
1.6580	30CrNiMo 8		30 CND 8	SNCM 431	1000	1200	Blue Ring	
1.7218	25CrMo 4	4130	25 CD 4 S	SCM 420;SCM 430	1000	1100	Blue Ring	
1.7223	41CrMo 4	4142;4140	42 CD 4 TS	SCM 440	1000	1200	Blue Ring	
1.7225	42CrMo 4 V	4142;4140	42 CD 4 TS	SCM 440	1000	1200	Blue Ring	
1.2080	X210Cr 12	D 3	Z 200 C 12	SKD 1	830	830	Blue Ring	
1.2210	115CrV 3	L 2	100 C 3		730	730	Blue Ring	
1.2363	X100CrMoV 5 1	A 2	Z 100 CDV 5	SKD 12	760	760	Blue Ring	
1.2436	X210CRW 12			SKD 2	760	760	Blue Ring	
1.2510	100MnCrW 4	O 1	90 MWCV 5		720	720	Blue Ring	
1.2601	X165CrMoV 12		Z 160 CDV 12		760	760	Blue Ring	
1.2631	X50CrMoW 9 11				860	860	Blue Ring	
1.2842	90MnCrV 8	O2	90 M V 8		740	740	Blue Ring	
1.3207	S10-4-3-10		Z 130 WKCDV 10-10-04-040		1000	1200	Blue Ring	
1.8151	50CrV 4						Blue Ring	
1.8161	58CrV 4				1000	1200	Blue Ring	
1.2083	X42Cr 13		Z 40 C 14	SUS 420 J 2		770	Blue Ring	
1.2311	40CrMnMo 7					770	Blue Ring	
1.2316	X36CrMo 17					840	Blue Ring	
1.2343	X38CrMoV 5 1	H 11	Z 38 CDV 5	SKD 6		800	Blue Ring	
1.2344	X40CrMoV 5 1	H 13	Z 40 CDV 5	SKD 61		800	Blue Ring	
1.2365	X32CrMoV 3 3	H 10	Z 32 CDV 28	SKD 7		800	Blue Ring	
1.2542	45WCrV 7	S 1					Blue Ring	
1.2581	X30WCrV 9 3	H 21	Z 30 WCV 9			800	Blue Ring	
1.2713	55NiCrMoV 6	L 6	55 NCDV 7	SKT 4		800	Blue Ring	
1.2743	60NiCrMoV 12 4						Blue Ring	
1.2766	35NiCrMo 16						Blue Ring	
1.4973	NiCr19CoMo				1200	1320	Red Ring	
1.4980	X5NiCrTi26 15				930	1180	Red Ring	
1.6582	35CrNiMo 6	4340	35 NCD 6	SNCM 447	1200	1400	Red Ring	
1.2379	X155CrVMo 12 1	D 2	Z 160 CDV 12	SKD 11	1200	1400	Red Ring	
1.2714	56NiCrMoV 7				1200	1400	Red Ring	
1.8159	50CrV 4	6150	50 CV 4	SUP 10	1200	1300	Red Ring	
1.4006	X10Cr 13	410;CA-15	Z 12 C 13	SUS 410	450	650	Blue Ring	Blue Ring
1.4008	GX8CrNi 13				590	790	White Ring	Blue Ring
1.4021	X20Cr 13	420	Z 20 C 13	SUS 420 J 1	650	950	White Ring	Blue Ring
1.4027	GX20Cr 14		Z 20 C 13 M		590	700	White Ring	Blue Ring
1.4028	X30Cr 13	420	Z 30 C 13	SUS 420 J 2	600	780	White Ring	Blue Ring
1.4031	X39Cr 13	420	Z 40 C 14	SUS 420 J 2	560	800	White Ring	Blue Ring



Material No.	DIN	AISI	AFNOR	JIS	tensile strength N/mm² min./max.		recommendation 1	recommendation 2
1.4057	X17CrNi 162	431	Z 15 CN 16.02	SUS 431	650	850	Blue Ring	White Ring
1.4104	X14CrMoS 17	430 F	Z 13 CF 17	SUS 430 F	540	840	White Ring	Blue Ring
1.4125	X105CrMo 17	440 C	Z 100 CD 17	SUS 440 C	900	900	Blue Ring	White Ring
1.4301	X5CrNi18 10	304 (V2A)	Z 6 CN 18.09	SUS 304	500	700	White Ring	Blue Ring
1.4305	X8CrNiS 18 9	303	Z 10 CNF 18.09	SUS 303	500	750	White Ring	Blue Ring
1.4306	X2CrNi 19 11	304L (V2A)	Z 2 CN 18.10	SCS 19	460	850	White Ring	Blue Ring
1.4308	GX5CrNi 19 10		Z 6 CN 18.10 M		460	640	White Ring	Blue Ring
1.4310	X10CrNi 18 8	301	Z 11 CN 17-08	SUS 301	700	950	White Ring	Blue Ring
1.4311	X2CrNiN 18 10	304 LN	Z c2 CN 18.10	SUS 304 LN	550	760	White Ring	Blue Ring
1.4541	X10CrNiTi 18 9	321 (V2A)	Z 6 CNT 18.10	SUS 321	500	700	White Ring	Blue Ring
1.4401	X5CrNiMo 17 12 1	316 (V4A)	Z 6 CND 17.11	SUS 316	510	710	White Ring	Blue Ring
1.4404	X2CrNiMo 17 12 2	316L (V4A)	Z 2 CND 17.12	SUS 316 L	490	850	White Ring	Blue Ring
1.4406	X2CrNiMoN 17 12 2	316 LN	Z 2 CND 17.12 AZ	SUS 316 LN	580	800	White Ring	Blue Ring
1.4429	X2CrNiMoN 17 13 3	316 LN	Z 2 CND 17.13 AZ	SUS 316 LN	580	800	White Ring	Blue Ring
1.4435	X2CrNiMo 18 14 3	316 L	Z 2 CND 17.13	SCS 16;SUS 316 L	490	690	White Ring	Blue Ring
1.4436	X5CrNiMo 17 13 3	316	Z 2 CND 17.12	SUS 316	510	710	White Ring	Blue Ring
1.4438	X2CrNiMo 18 16	317 L	Z 2 CND 19.15	SUS 317 L	490	690	White Ring	Blue Ring
1.4449	X5CrNiMo 17 13	317					White Ring	Blue Ring
1.4460	X4CrNiMoN 27 5 2	329	Z 5 CDN 27-05	SUS 329 J 1	600	800	White Ring	Blue Ring
1.4462	X2CrNiMoN 22 5 3	2205	Z 3 CND 22-05 Az	SUS 329J3L	680	880	White Ring	Blue Ring
1.4503	X3NiCrCuMoTi 27 23				500	700	White Ring	Blue Ring
1.4505	X5NiCrMoCuNb 20 18				490	740	White Ring	Blue Ring
1.4510	X6CrTi 17	XM 8;430 Ti	Z 8 CT 17	SUS 430 LX	450	600	White Ring	Blue Ring
1.4511	X6CrNb 17				450	600	White Ring	Blue Ring
1.4512	X6CrTi 12	409	Z 6 CT 12	SUH 409	330	560	Blue Ring	Blue Ring
1.4521	X2CrMoTi 18 2	444	Z 3 CDT 18-02	SUS 444	450	650	White Ring	Blue Ring
1.4542	X5CrNiCuPb 16 4	630	Z 7 CNU 15-05	SCS 630			White Ring	Blue Ring
1.4546	X5CrNiNb 18 10	348	Z 6 CNNb 18.10	SUS 347	410	610	White Ring	Blue Ring
1.4550	X6CrNiNb 18 10	347	Z 6 CN Nb 18.10	SUS 347	550	750	White Ring	Blue Ring
1.4552	GX5CrNiNb 19 10		Z 4 CN Nb 19.10 M		440	640	White Ring	Blue Ring
0.6015	GG15	A48-25 B	Ft 15 D	FC 15	110	150	Black Ring	
0.6020	GG20	A48-30 B	Ft 20 D	FC 20	150	200	Black Ring	
0.6025	GG25	A48-40 B	Ft 25 D	FC 25	200	250	Black Ring	
0.6030	GG30	A48-45 B	Ft 30 D	FC 30	240	270	Black Ring	
0.6035	GG35	A48-50 B	Ft 35 D	FC 35	280	320	Black Ring	
0.6040	GG40	A48-60 B	FT 40 D		350	450	Black Ring	
0.7040	GGG40	60-40-18	FGS 400-12	FCD 40	400	400	Standard Form A-C-B	Green Ring Form B
0.7050	GGG50	65-45-12	FGS 500-7	FCD 50	500	500	Standard Form A-C-B	Green Ring Form B
0.7060	GGG60	80-55-06	FGS 600-3	FCD 60	600	600	Standard Form A-C-B	Green Ring Form B
0.7070	GGG70	100-70-03	FGS 700-2	FCD 70	700	700	Standard Form A-C-B	Green Ring Form B
0.8035	GTW35-04	MB 350-4	MB35-7	FCMW 330	350	350	Standard Form A-C-B	Green Ring Form B
0.8055	GTS55-05				550	550	Standard Form A-C-B	Green Ring Form B
2.0401	CuZn39Pb 3 (MS58)	C 38500	MS58		630	630	Orange Ring	
2.0410	CuZn44Pb 2				630	630	Orange Ring	
2.0580	CuZn40MnNb				400	400	Orange Ring	
2.0250	CuZn 20						Standard Form C-B-B/ AZ-RSP	
2.0265	CuZn 30	C 26000	CuZn 30	C 2600			Standard Form C-B-B/ AZ-RSP	
2.0321	CuZn 37	C 27200	CuZn 37	C 2700			Standard Form C-B-B/ AZ-RSP	
2.0335	CuZn 36 (MS63)		Ms63	C 2700			Standard Form C-B-B/ AZ-RSP	
3.0250	AL 99.5 H		A 5	A1x1		350	Yellow Ring	Standard Form B-AZ
3.0280	AL 99.8 H						Yellow Ring	Standard Form B-AZ
3.0305	AL 99.9		A 9				Yellow Ring	Standard Form B-AZ
3.3308	AL 99.9 Mg 0,5						Yellow Ring	Standard Form B-AZ
3.0515	ALMn 1			144054			Yellow Ring	Standard Form B-AZ
3.0525	AlMn 1 Mg 05		A-M1G0,5				Yellow Ring	Standard Form B-AZ
3.0615	AlMgSi-Pb						Yellow Ring	Standard Form B-AZ
3.1325	AlCuMg 1		A-U4G				Yellow Ring	Standard Form B-AZ
3.1355	AlCuMg 2		A-U4G1	A3x4			Yellow Ring	Standard Form B-AZ
3.3315	AlMg 1		A-G0,5	A2x8			Yellow Ring	Standard Form B-AZ
3.4365	AlZnMgCu 1.5	7175	AZ 4 GU/9050 C				Yellow Ring	Standard Form B-AZ
3.2381	G-AlSi 10 Mg		A-S1OG				Blue Ring	
3.2383	G-AlSi 10 Mg (CU)	A 360.2	A-S1OGU				Blue Ring	
3.2581	G-AlSi 12	A 413.2	A-S13	AC3			Blue Ring	
3.2583	G-AlSi (CU)	A 413.1	A-S12U				Blue Ring	
3.2982	GD-AlSi 12 (CU)						Blue Ring	
3.5912	G-MgAl 9 Zn 1						Blue Ring	
3.2134	G-AlSi 5 Cu 1 Mg						Standard Form C-B-RSP	Blue Ring
3.2152	G-AlSi 6 Cu 4						Standard Form C-B-RSP	Blue Ring
3.2162	G-AlSi 8 Cu 3						Standard Form C-B-RSP	Blue Ring
3.2373	G-AlSi 9 Mg		A-S9G	AC4A			Standard Form C-B-RSP	Blue Ring
3.7115	TiAl 5 Sn 2				790	980	White Ring	
3.7165	TiAl 6 V 4	R56400	T-A6V		980	1140	Blue Ring	
3.7185	TiAl4Mo4Sn2				1000		Blue Ring	
	Polyamid						Standard Form B-RSP	Green Ring
	Polystyrol						Standard Form B-RSP	Green Ring
	Polyvinylchlorid						Standard Form B-RSP	Green Ring
	Ultramid						Standard Form B-RSP	Green Ring
CFK	Faserverstärkte				190	210	Black Ring	Red Ring
GFK	Kunststoffe						Black Ring	Red Ring
	Bakelit						Black Ring	Red Ring
	Ferrozell						Black Ring	Red Ring
	Pertinax						Black Ring	Red Ring

GREEN RING-Machine Taps

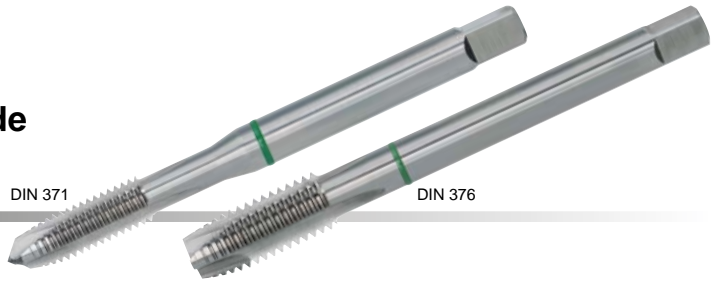
metric ISO-thread DIN 13

Maschi a macchina con collarino verde

filettatura metrica ISO DIN 13

DIN 371

DIN 376



DIN 371/376 Form B HSS-E Tol. ISO2/6H

Nominal Diameter D	L 1	L 2	D 2	☐	Art.-No.
DIN 371					
M 3 x 0.5	56	11	3.5	2.7	35326
M 4 x 0.7	63	13	4.5	3.4	35330
M 5 x 0.8	70	16	6.0	4.9	35334
M 6 x 1.0	80	19	6.0	4.9	35338
M 8 x 1.25	90	22	8.0	6.2	35342
M 10 x 1.5	100	24	10.0	8.0	35346
DIN 376					
M 12 x 1.75	110	29	9.0	7.0	35350
M 14 x 2.0	110	30	11.0	9.0	35354
M 16 x 2.0	110	32	12.0	9.0	35358
M 18 x 2.5	125	34	14.0	11.0	35362
M 20 x 2.5	140	34	16.0	12.0	35366
SET					
M 3 - 12	M 3-4-5-6-8-10 (DIN 371), M 12 (DIN 376)				47853

Application:

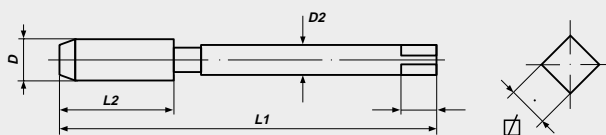
for general use

- non abrasive material up to 1000 N/mm²
- unalloyed and low alloyed steel
- long chipping material
- for through holes

Applicazione:

per uso universale

- Materiali con buona truciabilità fino a 1.000 N/mm²
- Acciaio non legati e scarsamente legati
- Materiali truciolo lungo
- per fori passanti



**GREEN RING-Machine Taps**

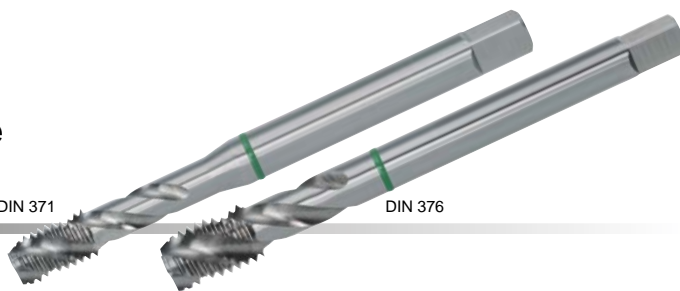
metric ISO-thread DIN 13

Maschi a macchina con collarino verde

filettatura metrica ISO DIN 13

DIN 371

DIN 376

**DIN 371/376****Form C/39° RSP****HSS-E****Tol. ISO2/6H**

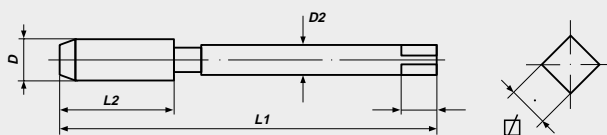
Nominal Diameter D	L 1	L 2	D 2	☒	Art.-No.
DIN 371					
M 3 x 0.5	56	6	3.5	2.7	36326
M 4 x 0.7	63	7	4.5	3.4	36330
M 5 x 0.8	70	8	6.0	4.9	36334
M 6 x 1.0	80	10	6.0	4.9	36338
M 8 x 1.25	90	14	8.0	6.2	36342
M 10 x 1.5	100	16	10.0	8.0	36346
DIN 376					
M 12 x 1.75	110	18	9.0	7.0	36350
M 14 x 2.0	110	20	11.0	9.0	36354
M 16 x 2.0	110	22	12.0	9.0	36358
M 18 x 2.5	125	25	14.0	11.0	36362
M 20 x 2.5	140	25	16.0	12.0	36366
SET					
M 3 - 12	M 3-4-5-6-8-10 (DIN 371), M 12 (DIN 376)				47863

Application:**for general use**

- non abrasive material up to 1000 N/mm²
- unalloyed and low alloyed steel
- long chipping material
- for blind holes

Applicazione:**per uso universale**

- Materiali con buona truciabilità fino a 1.000 N/mm²
- Acciaio non legati e scarsamente legati
- Materiali truciolo lungo
- per fori ciechi





Tol. ISO2/6H

141

BLUE RING-Machine Taps

metric ISO-thread DIN 13

Maschi a macchina con collarino blu

filettatura metrica ISO DIN 13



DIN 371/376 Form B HSS-E Tol. ISO2/6H

Nominal Diameter D	L 1	L 2	D 2	☒	Art.-No.
DIN 371					
M 3 x 0.5	56	11	3.5	2.7	35426
M 4 x 0.7	63	13	4.5	3.4	35430
M 5 x 0.8	70	16	6.0	4.9	35434
M 6 x 1.0	80	19	6.0	4.9	35438
M 8 x 1.25	90	22	8.0	6.2	35442
M 10 x 1.5	100	24	10.0	8.0	35446
DIN 376					
M 12 x 1.75	110	29	9.0	7.0	35450
M 14 x 2.0	110	30	11.0	9.0	35454
M 16 x 2.0	110	32	12.0	9.0	35458
M 18 x 2.5	125	34	14.0	11.0	35462
M 20 x 2.5	140	34	16.0	12.0	35466
SET					
M 3 - 12	M 3-4-5-6-8-10 (DIN 371), M 12 (DIN 376)				47854

TiCN

DIN 371					
M 3 x 0.5	56	11	3.5	2.7	35427
M 4 x 0.7	63	13	4.5	3.4	35431
M 5 x 0.8	70	16	6.0	4.9	35435
M 6 x 1.0	80	19	6.0	4.9	35439
M 8 x 1.25	90	22	8.0	6.2	35443
M 10 x 1.5	100	24	10.0	8.0	35447
DIN 376					
M 12 x 1.75	110	29	9.0	7.0	35451
M 14 x 2.0	110	30	11.0	9.0	35455
M 16 x 2.0	110	32	12.0	9.0	35459
M 18 x 2.5	125	34	14.0	11.0	35463
M 20 x 2.5	140	34	16.0	12.0	35467

Application:

wear resistant steel up to 1200 N/mm²

- high alloy steel
- short chipping material
- short chipping stainless steel
- alloy tool steel
- for through holes

TiCN

- outstanding wear-resistance due to improved hardness and toughness
- intensive and optimum cooling essential as reduced heat resistance

Applicazione:

Acciaio resistente all'usura a 1.200 N/mm²

- acciaio alto legato
- Materiali duri con truciolo corto
- Acciaio inossidabile con truciolo corto
- Acciaio utensili legati
- per fori passanti

TiCN

- eccellente resistente all'usura per mezzo di durezza e tenacia migliorata
- intensa e ottimale lubrificazione è obbligatorio, perché minore resistenza al calore



BLUE RING-Machine Taps

metric ISO-thread DIN 13

Maschi a macchina con collarino blu

filettatura metrica ISO DIN 13

DIN 371

DIN 376



DIN 371/376

Form C/39° RSP

HSS-E

Tol. ISO2/6H

Nominal Diameter D	L 1	L 2	D 2	☑	Art.-No.
DIN 371					
M 3 x 0.5	56	6	3.5	2.7	36426
M 4 x 0.7	63	7	4.5	3.4	36430
M 5 x 0.8	70	8	6.0	4.9	36434
M 6 x 1.0	80	10	6.0	4.9	36438
M 8 x 1.25	90	14	8.0	6.2	36442
M 10 x 1.5	100	16	10.0	8.0	36446
DIN 376					
M 12 x 1.75	110	18	9.0	7.0	36450
M 14 x 2.0	110	20	11.0	9.0	36454
M 16 x 2.0	110	22	12.0	9.0	36458
M 18 x 2.5	125	25	14.0	11.0	36462
M 20 x 2.5	140	25	16.0	12.0	36466
SET					
M 3 - 12	M 3-4-5-6-8-10 (DIN 371). M 12 (DIN 376)				47864

TiCN

DIN 371					
M 3 x 0.5	56	6	3.5	2.7	36427
M 4 x 0.7	63	7	4.5	3.4	36431
M 5 x 0.8	70	8	6.0	4.9	36435
M 6 x 1.0	80	10	6.0	4.9	36439
M 8 x 1.25	90	14	8.0	6.2	36443
M 10 x 1.5	100	16	10.0	8.0	36447
DIN 376					
M 12 x 1.75	110	18	9.0	7.0	36451
M 14 x 2.0	110	20	11.0	9.0	36455
M 16 x 2.0	110	22	12.0	9.0	36459
M 18 x 2.5	125	25	14.0	11.0	36463
M 20 x 2.5	140	25	16.0	12.0	36467

Application:

wear resistant steel up to 1200 N/mm²

- high alloy steel
- short chipping material
- short chipping stainless steel
- alloy tool steel
- for blind holes

TiCN

- outstanding wear-resistance due to improved hardness and toughness
- intensive and optimum cooling essential as reduced heat resistance

Applicazione:

Acciaio resistente all'usura a 1.200 N/mm²

- acciaio alto legato
- Materiali duri con truciolo corto
- Acciaio inossidabile con truciolo corto
- Acciaio utensili legati
- per fori ciechi

TiCN

- eccellente resistente all'usura per mezzo di durezza e tenacia migliorata
- intensa e ottimale lubrificazione è obbligatorio, perché minore resistenza al calore

metric ISO-thread DIN 13

Maschi a macchina con collarino bianco

filettatura metrica ISO DIN 13




DIN 371/376

Form B

HSS-E

Tol. ISO2/6H

Nominal Diameter D	L 1	L 2	D 2		Art.-No.
DIN 371					
M 3 x 0.5	56	11	3.5	2.7	35226
M 4 x 0.7	63	13	4.5	3.4	35230
M 5 x 0.8	70	16	6.0	4.9	35234
M 6 x 1.0	80	19	6.0	4.9	35238
M 8 x 1.25	90	22	8.0	6.2	35242
M 10 x 1.5	100	24	10.0	8.0	35246
DIN 376					
M 12 x 1.75	110	29	9.0	7.0	35250
M 14 x 2.0	110	30	11.0	9.0	35254
M 16 x 2.0	110	32	12.0	9.0	35258
M 18 x 2.5	125	34	14.0	11.0	35262
M 20 x 2.5	140	34	16.0	12.0	35266
SET					
M 3 - 12	M 3-4-5-6-8-10 (DIN 371), M 12 (DIN 376)				47852

Application:

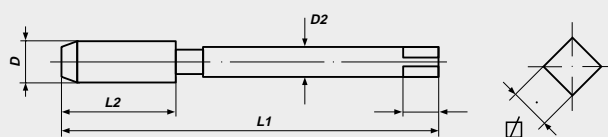
**Stainless Steel (INOX),
long chipping up to 1000 N/mm²**

- abrasive material
- chrome-nickel alloys
- surface treatment: steam tempered
- for through holes

Applicazione:

**Acciaio inossidabile,
truciolo lungo a 1.000 N/mm²**

- materiali difficile da tagliare
- Acciaio legato al Cr
- Superficie: vaporizzato
- per fori passanti





WHITE RING-Machine Taps

Maschi a macchina con collarino bianco



Form B HSS-E

Nominal Diameter D		L 1	L 2	D 2	Ø	Art.-No.
MF	Tol. ISO2/6H	DIN 374				
M	5 x 0.5	70	12	3.5	2.7	35903
M	6 x 0.75	80	14	4.5	3.4	35904
M	8 x 0.75	80	19	6.0	4.9	35906
M	8 x 1.0	90	22	6.0	4.9	35907
M	10 x 1.0	90	20	7.0	5.5	35909
M	10 x 1.25	100	24	7.0	5.5	35910
M	12 x 1.25	100	22	9.0	7.0	35913
M	12 x 1.5	100	22	9.0	7.0	35914
M	14 x 1.5	100	22	11.0	9.0	35917
M	16 x 1.5	100	22	12.0	9.0	35921
M	18 x 1.5	110	25	14.0	11.0	35925
M	20 x 1.5	125	25	16.0	12.0	35929
UNC	Tol. 2B	DIN 371				
UNC	1/4 x 20	80	17	7.0	5.5	35945
UNC	5/16 x 18	90	20	8.0	6.2	35946
UNC	3/8 x 16	100	22	9.0	7.0	35947
		DIN 376				
UNC	7/16 x 14	100	22	8.0	6.2	35948
UNC	1/2 x 13	110	25	9.0	7.0	35949
UNF	Tol. 2B	DIN 371				
UNF	1/4 x 28	80	17	7.0	5.5	35965
UNF	5/16 x 24	90	17	8.0	6.2	35966
UNF	3/8 x 24	100	18	9.0	7.0	35967
		DIN 376				
UNF	7/16 x 20	100	22	8.0	6.2	35968
UNF	1/2 x 20	100	22	9.0	7.0	35969
G (BSP)		DIN 5156				
G	1/8 x 28	90	20	7.0	5.5	35992
G	1/4 x 19	100	22	11.0	9.0	35993
G	3/8 x 19	100	22	12.0	9.0	35994
G	1/2 x 14	125	25	16.0	12.0	35995

Application:

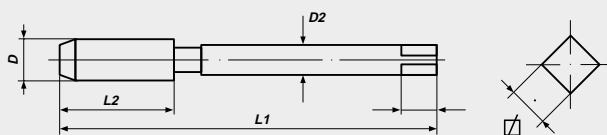
**Stainless Steel (INOX),
long chipping up to 1000 N/mm²**

- abrasive material
- chrome-nickel alloys
- surface treatment: steam tempered
- for through holes

Applicazione:

**Acciaio inossidabile,
truciolo lungo a 1.000 N/mm²**

- materiali difficile da tagliare
- Acciaio legato al Cr
- Superficie: vaporizzato
- per fori passanti





WHITE RING-Machine Taps

metric ISO-thread DIN 13

Maschi a macchina con collarino bianco

filettatura metrica ISO DIN 13



DIN 371/376 Form C/39° RSP HSS-E Tol. ISO2/6H

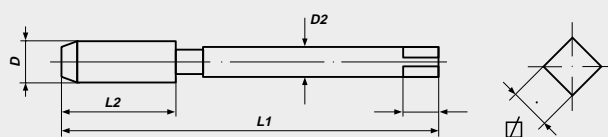
Nominal Diameter D	L 1	L 2	D 2	☐	Art.-No.
DIN 371					
M 3 x 0.5	56	6	3.5	2.7	36226
M 4 x 0.7	63	7	4.5	3.4	36230
M 5 x 0.8	70	8	6.0	4.9	36234
M 6 x 1.0	80	10	6.0	4.9	36238
M 8 x 1.25	90	14	8.0	6.2	36242
M 10 x 1.5	100	16	10.0	8.0	36246
DIN 376					
M 12 x 1.75	110	18	9.0	7.0	36250
M 14 x 2.0	110	20	11.0	9.0	36254
M 16 x 2.0	110	22	12.0	9.0	36258
M 18 x 2.5	125	25	14.0	11.0	36262
M 20 x 2.5	140	25	16.0	12.0	36266
SET					
M 3 - 12	M 3-4-5-6-8-10 (DIN 371), M 12 (DIN 376)				47862

Application:

**Stainless steel (INOX),
long chipping up to 1000 N/mm²**
- abrasive material
- chrome-nickel alloys
- surface treatment: steam tempered
- for blind holes

Applicazione:

**Acciaio inossidabile,
truciolo lungo a 1.000 N/mm²**
- materiali difficile da tagliare
- Acciaio legato al Cr
- Superficie: vaporizzato
- per fori ciechi





WHITE RING-Machine Taps

Maschi a macchina con collarino bianco



Form C/39° RSP

HSS-E

Nominal Diameter D		L 1	L 2	D 2	☒	Art.-No.
MF						
	Tol. ISO2/6H	DIN 374				
M	5 x 0.5	70	5	3.5	2.7	36903
M	6 x 0.75	80	8	4.5	3.4	36904
M	8 x 0.75	80	8	6.0	4.9	36906
M	8 x 1.0	90	10	6.0	4.9	36907
M	10 x 1.0	90	10	7.0	5.5	36909
M	10 x 1.25	100	16	7.0	5.5	36910
M	12 x 1.25	100	15	9.0	7.0	36913
M	12 x 1.5	100	15	9.0	7.0	36914
M	14 x 1.5	100	15	11.0	9.0	36917
M	16 x 1.5	100	15	12.0	9.0	36921
M	18 x 1.5	110	17	14.0	11.0	36925
M	20 x 1.5	125	17	16.0	12.0	36929
UNC						
	Tol. 2B	DIN 371				
UNC	1/4 x 20	80	13	7.0	5.5	36945
UNC	5/16 x 18	90	14	8.0	6.2	36946
UNC	3/8 x 16	100	16	9.0	7.0	36947
DIN 376						
UNC	7/16 x 14	100	17	8.0	6.2	36948
UNC	1/2 x 13	110	20	9.0	7.0	36949
UNF						
	Tol. 2B	DIN 371				
UNF	1/4 x 28	80	10	7.0	5.5	36965
UNF	5/16 x 24	90	10	8.0	6.2	36966
UNF	3/8 x 24	100	10	9.0	7.0	36967
DIN 376						
UNF	7/16 x 20	100	13	8.0	6.2	36968
UNF	1/2 x 20	100	13	9.0	7.0	36969
G (BSP)						
		DIN 5156				
G	1/8 x 28	90	20	7.0	5.5	36992
G	1/4 x 19	100	22	11.0	9.0	36993
G	3/8 x 19	100	22	12.0	9.0	36994
G	1/2 x 14	125	25	16.0	12.0	36995

Application:

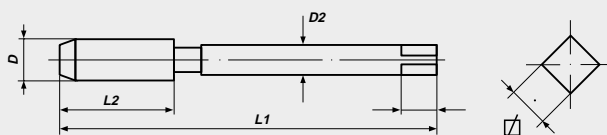
**Stainless steel (INOX),
long chipping up to 1000 N/mm²**

- abrasive material
- chrome-nickel alloys
- surface treatment: steam tempered
- for blind holes

Applicazione:

**Acciaio inossidabile,
truciolo lungo a 1.000 N/mm²**

- materiali difficile da tagliare
- Acciaio legato al Cr
- Superficie: vaporizzato
- per fori ciechi





BLACK RING-Machine Taps

metric ISO-thread DIN 13

Maschi a macchina con collarino nero

filettatura metrica ISO DIN 13



DIN 371/376 Form C HSS-E Tol. ISO2/6H

Nominal Diameter D	L 1	L 2	D 2	☑	Art.-No.
DIN 371					
M 3 x 0.5	56	11	3.5	2.7	35126
M 4 x 0.7	63	13	4.5	3.4	35130
M 5 x 0.8	70	16	6.0	4.9	35134
M 6 x 1.0	80	19	6.0	4.9	35138
M 8 x 1.25	90	22	8.0	6.2	35142
M 10 x 1.5	100	24	10.0	8.0	35146
DIN 376					
M 12 x 1.75	110	29	9.0	7.0	35150
M 14 x 2.0	110	30	11.0	9.0	35154
M 16 x 2.0	110	32	12.0	9.0	35158
M 18 x 2.5	125	34	14.0	11.0	35162
M 20 x 2.5	140	34	16.0	12.0	35166
SET					
M 3 - 12	M 3-4-5-6-8-10 (DIN 371), M 12 (DIN 376)				47851

Application:

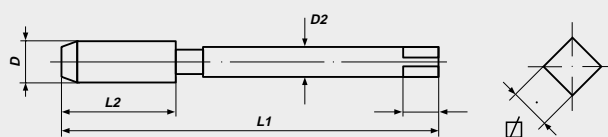
Cast iron GG

- Magnesium alloys
- surface treatment nitrided
- Form C: for through and blind holes

Applicazione:

Ghisa grigia GG

- Leghe di magnesio
- Superficie: nitrurata
- Forma C: per fori passanti e ciechi





YELLOW RING-Machine Taps

metric ISO-thread DIN 13

Maschi a macchina con collarino giallo

filettatura metrica ISO DIN 13



DIN 371/376 Form C/40° RSP HSS-E

Nominal Diameter D	L 1	L 2	D 2	☐	Art.-No.
-----------------------	-----	-----	-----	---	----------

M Tol. ISO2/6H DIN 371

M	3 x 0.5	56	6	3.5	2.7	36526
M	4 x 0.7	63	7	4.5	3.4	36530
M	5 x 0.8	70	8	6.0	4.9	36534
M	6 x 1.0	80	10	6.0	4.9	36538
M	8 x 1.25	90	14	8.0	6.2	36542
M	10 x 1.5	100	16	10.0	8.0	36546

DIN 376

M	12 x 1.75	110	18	9.0	7.0	36550
M	14 x 2.0	110	20	11.0	9.0	36554
M	16 x 2.0	110	22	12.0	9.0	36558

SET

M	3 - 12	M 3-4-5-6-8-10 (DIN 371), M 12 (DIN 376)	47860
---	--------	--	-------

UNC Tol. 2B DIN 371

UNC	1/4 x 20	80	13	7,0	5,5	36580
UNC	5/16 x 18	90	14	8,0	6,2	36581
UNC	3/8 x 16	100	16	9,0	7,0	36582
UNC	7/16 x 14	100	17	8,0	6,2	36583

DIN 376

UNC	1/2 x 13	100	20	9,0	7,0	36584
-----	----------	-----	----	-----	-----	-------

Application:

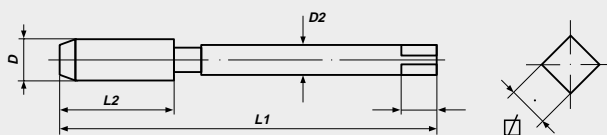
Aluminium-alloys, long chipping

- for blind holes
- with 2 flutes

Applicazione:

Alluminio, truciolo lungo

- per fori ciechi
- A 2 scanalature



metric ISO-thread DIN 13

Maschi a macchina con collarino arancione

filettatura metrica ISO DIN 13



DIN 371/376

Form C

HSS-E

Tol. ISO2/6H

[illegible]

Application:

Ms

Brass, short chipping

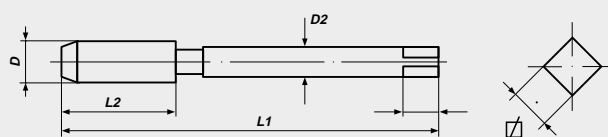
Brass, short chipping
- for through and blind holes

Applicazione:

Ms

Ottone, truciolo corto

- per fori passanti e ciechi





RED RING-Machine Taps

metric ISO-thread DIN 13

Maschi a macchina con collarino rosso

filettatura metrica ISO DIN 13



DIN 371

Form A

HSS-E

Tol. ISO2/6H

Nominal Diameter D	L 1	L 2	D 2	☒	Art.-No.
DIN 371					
M 4 x 0.7	63	9	4.5	3.4	36130
M 5 x 0.8	70	11	6.0	4.9	36134
M 6 x 1.0	80	13	6.0	4.9	36138
M 8 x 1.25	90	15	8.0	6.2	36142
M 10 x 1.5	100	16	10.0	8.0	36146

Application:

short-chipping Material from 1200 N/mm² tensile strength

For through and blind holes.

Due to the very robust execution and the special profile of the flutes this Machine Tap is suitable for extreme applications.

The lead Form A and an additional short lead make working easier.

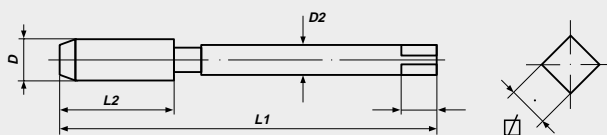
Applicazione:

Materiali con truciolo corto da 1.200 N/mm² resistenza alla trazione

per fori passanti e ciechi

Dalla versione particolarmente robusto e speciale profilo delle scanalature di questo maschi è adatto per applicazioni estreme.

L'imbocco a Forma A e un aggiuntivo imbocco corto facilitano la lavorazione





TWINBOX
Machine Tap + Twist Drill
TWINBOX
Maschi a macchina + punte



Only Machine Taps which are suitable for the application achieve the optimum results. TwinBoxes include Coloured Ring Machine Taps together with the tapping size Drill for most efficient use and best results. Using Machine Taps and Twist Drills which are both suitable for the application will improve the quality of the thread and reduce costs.

Solo attraverso l'impiego di utensili specifici per un determinato materiale è possibile raggiungere un risultato preciso. Confezioni Twin con maschi a macchina con collarino e relative punte consentono una flessibilità di impiego maggiore. Attraverso l'impiego di punte specifiche per un determinato materiale è possibile aumentare la qualità del filetto.



77 + 153 - 155



GREEN RING TwinBox

Machine Tap + Twist Drill
metric ISO-thread DIN 13

TwinBox verde

Maschi a macchina + punte
filettatura metrica ISO DIN 13



DIN 371/376 HSS-E

Tol. ISO2/6H

Nominal Diameter D			Art.-No.
-----------------------	---	---	----------

Form B, Spiral Point / punta en espiral (pasante)

M	3 x 0.5	DIN 371	2.5 mm	35390
M	4 x 0.7	DIN 371	3.3 mm	35391
M	5 x 0.8	DIN 371	4.2 mm	35392
M	6 x 1.0	DIN 371	5.0 mm	35393
M	8 x 1.25	DIN 371	6.8 mm	35394
M	10 x 1.5	DIN 371	8.5 mm	35395
M	12 x 1.75	DIN 376	10.2 mm	35396
M	14 x 2.0	DIN 376	12.0 mm	35397
M	16 x 2.0	DIN 376	14.0 mm	35398

Form C, Spiral Flute / Helicoidal 39° (ciego)

M	3 x 0.5	DIN 371	2.5 mm	36390
M	4 x 0.7	DIN 371	3.3 mm	36391
M	5 x 0.8	DIN 371	4.2 mm	36392
M	6 x 1.0	DIN 371	5.0 mm	36393
M	8 x 1.25	DIN 371	6.8 mm	36394
M	10 x 1.5	DIN 371	8.5 mm	36395
M	12 x 1.75	DIN 376	10.2 mm	36396
M	14 x 2.0	DIN 376	12.0 mm	36397
M	16 x 2.0	DIN 376	14.0 mm	36398

Application:

for general use

- non abrasive material up to 1000 N/mm²
 - unalloyed and low alloyed steel
 - malleable cast iron and zinc alloys
- Spiral Point for through holes
Spiral Flute for blind holes

HSS-CO Twist Drills DIN 338

Type N right, 118° - Spiral: 25-30°

Applicazione:

per uso universale

- Materiali buona trucidibilità fino a 1000 N/mm²
 - Acciaio non legati e scarsamente legati
 - Ghisa malleabile e leghe forgiate
- Forma B per fori passanti
39° RSP per fori ciechi

Punte DIN 338 HSS-Co

Tipo N, destra 118° - elica: 25-30°



BLUE RING TwinBox

Machine Tap + Twist Drill
metric ISO-thread DIN 13

TwinBox blu

Maschi a macchina + punte
filettatura metrica ISO DIN 13



DIN 371/376 HSS-E

Tol. ISO2/6H

Nominal Diameter D			Art.-No.
-----------------------	---	---	----------

Form B, Spiral Point / con imbocco corretto

M	3 x 0.5	DIN 371	2.5 mm	35490
M	4 x 0.7	DIN 371	3.3 mm	35491
M	5 x 0.8	DIN 371	4.2 mm	35492
M	6 x 1.0	DIN 371	5.0 mm	35493
M	8 x 1.25	DIN 371	6.8 mm	35494
M	10 x 1.5	DIN 371	8.5 mm	35495
M	12 x 1.75	DIN 376	10.2 mm	35496
M	14 x 2.0	DIN 376	12.0 mm	35497
M	16 x 2.0	DIN 376	14.0 mm	35498

Form C, Spiral Flute / spirale destra a 39°

M	3 x 0.5	DIN 371	2.5 mm	36490
M	4 x 0.7	DIN 371	3.3 mm	36491
M	5 x 0.8	DIN 371	4.2 mm	36492
M	6 x 1.0	DIN 371	5.0 mm	36493
M	8 x 1.25	DIN 371	6.8 mm	36494
M	10 x 1.5	DIN 371	8.5 mm	36495
M	12 x 1.75	DIN 376	10.2 mm	36496
M	14 x 2.0	DIN 376	12.0 mm	36497
M	16 x 2.0	DIN 376	14.0 mm	36498

Application:

wear resistant steel up to 1200 N/mm²

- high alloy steel
- short chipping material
- short chipping stainless steel
- alloy tool steel

Spiral Point for through holes

Spiral Flute for blind holes

HSS-CO Twist Drills DIN 338

Form C right, 130° - Spiral: 25-30°
with Split Point

Applicazione:

Acciaio resistente all'usura a 1200 N/mm²

- Acciaio alto legato
- Materiali duri con truciolo corto
- Acciaio inossidabile con truciolo corto
- Acciaio utensili legati

Forma B per fori passanti

39° RSP per fori ciechi

Punte DIN 338 HSS-Co

Forma C, destra 130° - elica: 25-30°
con affilatura a croce



WHITE RING TwinBox

Machine Tap + Twist Drill
metric ISO-thread DIN 13

TwinBox bianco

Maschi a macchina + punte
filettatura metrica ISO DIN 13



DIN 371/376 HSS-E

Tol. ISO2/6H

Nominal Diameter D			Art.-No.
-----------------------	---	---	----------

Form B, Spiral Point / con imbocco corretto

M	3 x 0.5	DIN 371	2.5 mm	35290
M	4 x 0.7	DIN 371	3.3 mm	35291
M	5 x 0.8	DIN 371	4.2 mm	35292
M	6 x 1.0	DIN 371	5.0 mm	35293
M	8 x 1.25	DIN 371	6.8 mm	35294
M	10 x 1.5	DIN 371	8.5 mm	35295
M	12 x 1.75	DIN 376	10.2 mm	35296
M	14 x 2.0	DIN 376	12.0 mm	35297
M	16 x 2.0	DIN 376	14.0 mm	35298

Form C, Spiral Flute / spirale destra a 39°

M	3 x 0.5	DIN 371	2.5 mm	36290
M	4 x 0.7	DIN 371	3.3 mm	36291
M	5 x 0.8	DIN 371	4.2 mm	36292
M	6 x 1.0	DIN 371	5.0 mm	36293
M	8 x 1.25	DIN 371	6.8 mm	36294
M	10 x 1.5	DIN 371	8.5 mm	36295
M	12 x 1.75	DIN 376	10.2 mm	36296
M	14 x 2.0	DIN 376	12.0 mm	36297
M	16 x 2.0	DIN 376	14.0 mm	36298

Application:

Stainless Steel (INOX),
long chipping up to 1000 N/mm²
- long chipping, heat resistant steel
- abrasive material
Spiral Point for through holes
Spiral Flute for blind holes
Surface treatment: steam tempered

HSS-CO Twist Drills DIN 338

Form C right, 130° - Spiral: 25-30°
with Split Point

Applicazione:

Acciaio inossidabile truciolo lungo a 1000 N/mm²
- Acciaio resistente al calore truciolo lungo
- Materiali difficile da tagliare
Forma B per fori passanti
39° RSP per fori ciechi
Superficie: vaporizzato

Punte DIN 338 HSS-Co

Forma C, destra 130° - elica: 25-30°
con affilatura a croce



FLUTELESS MACHINE TAPS MASCHI A RULLARE

Application:

- Unalloyed and low alloyed Steel
- Constructional Steel
- heat resistant Steel
- Stainless Steel
- long-chipping nonferrous Metal
- Zinc Alloys
- for through and blind holes

Applicazione:

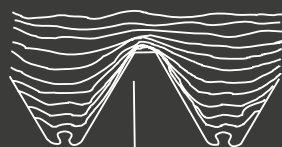
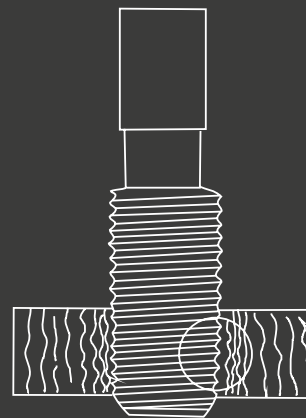
- Acciaio non legati e scarsamente legati
- Acciaio da costruzione
- Acciaio resistenti al calore
- Acciaio inossidabile
- Materiali non ferrosi truciolo lungo (Alluminio, Bronzo, Rame, Ottone)
- Leghe forgiate
- per fori passanti e ciechi

Benefit:

- ✓ longer endurance as cutting taps
- ✓ higher possible cutting speed
- ✓ steady exactness of dimension and profile
- ✓ high stability of the forming threads
- ✓ high security against fracture
- ✓ no removal of swarf, no jamming of swarf

Vantaggio:

- ✓ Elevata durata
- ✓ Velocità di rotazione più elevata
- ✓ Quota e precisione del profilo costanti
- ✓ Più elevato carico ammissibile del filetto realizzato
- ✓ Maggiore resistenza alla rottura
- ✓ Elevata resistenza alla rottura
- ✓ Nessuna produzione di truciolo e relative problematiche



Fibre structure
of thread forming
Andamento delle fibre
per filettatura rullata



Fibre structure
of thread cutting
Andamento delle fibre
per filettatura tagliata

Fluteless Taps (Forming Taps)

are threading tools to form internal threads without cutting. The thread is produced by deformation of the material without damaging the fibre structure.

Maschi a rullare e utensili per la filettatura per la produzione di filetti riportati senza produzione di truciolo. Il filetto viene prodotto per deformazione del materiale, mantenendo intatto l'andamento delle fibre.



FLUTELESS MACHINE TAPS MASCHI A RULLARE

	blank lucido	VAP	TIN
6H ISO2	159	160	161
6G ISO3	162		

Application:

bright:

- for nonferrous metal of good ductility

VAP (Steam Tempered):

- for steel up to approx. 700 N/mm²

TIN (Titanium Nitride Coating):

- for steel up to approx. 900 N/mm²
and to increase endurance and cutting speed

Applicazione:

Lucido:

- per materiali non ferrosi con buona deformabilità

VAP (vaporizzato):

- per acciaio a ca. 700 N/mm²

TIN (revestimento di nitruato di titanio):

- per acciaio a ca. 900 N/mm²
per l'aumento della vita utensile e della velocità di taglio

because available ■ because reliable ■ because you ■



RECOMMENDED APPLICATION OF FLUTELESS MACHINE TAPS PER MASCHI A RULLARE

Material Materiali	bright lucido	VAP	TIN
unalloyed and low alloyed Steel Acciaio non legati e a basso legati, truciolo corto			x
heat resistant Steel Acciaio resistenti al calore			x
Stainless Steel Acciaio inossidabile		x	x
Constructional Steel Acciaio da costruzione		x	x
Brass, long-chipping Ottone, truciolo lungo	x		
Bronzes, long-chipping Bronzo, truciolo lungo	x		
Copper Rame	x		
Al-alloys, long-chipping Alluminio, truciolo lungo	x		
Zinc Alloys Leghe forgiate	x		

Oil Groove:

Use Fluteless Taps with Oil Groove for thread depth over 1,5 x D to optimize lubrication.

Lubrication:

Good lubrication is very important when forming threads.
Use graphitic lubrication/oil with lubricity or add suitable additives.

Canali di espulsione:

Per profondità del filetto oltre 1,5xD si possono utilizzare i maschi a rullare con canali di espulsione per una ottimale sbavatura

Lubrificazione:

Buona lubrificazione e buone proprietà antifrizione sono molto importanti nel caso dei maschi a rullare. Impiegare refrigeranti e lubrificanti/oli alla grafite oppure aggiungere additivi appropriati

RECOMMENDED CORE HOLE DIAMETER DIAMETRO DEL FORO RACCOMANDATO

M 1	M 1,1	M 1,2	M 1,4	M 1,6	M 1,7	M 1,8	M 2	M 2,5	M 3	M 4	M 5	M 6	M 8	M 10	M 12	M 14	M 16
0,90	1,00	1,10	1,25	1,45	1,55	1,65	1,80	2,30	2,80	3,70	4,65	5,55	7,45	9,30	11,20	13,00	15,10



Fluteless Machine Taps (Forming Taps)

metric ISO-thread DIN 13

Maschi a rullare

filettatura metrica ISO DIN 13

**DIN 371/376****2.1/2 Thread Start****HSS-E****Tol. ISO2X/6HX**

Nominal Diameter D	L 1	L 2	D 2	☐	Art.-No.
-----------------------	-----	-----	-----	---	----------

without Oil Groove/senza canali di espulsione

DIN 371

M 1 x 0.25	40	5	2.5	2.1	35500
M 1.1 x 0.25	40	5	2.5	2.1	35501
M 1.2 x 0.25	40	5	2.5	2.1	35502
M 1.4 x 0.3	40	7	2.5	2.1	35503
M 1.6 x 0.35	40	8	2.5	2.1	35504
M 1.7 x 0.35	40	8	2.5	2.1	35505
M 1.8 x 0.35	40	8	2.5	2.1	35506
M 2 x 0.4	45	8	2.8	2.1	35507
M 2.5 x 0.45	50	9	2.8	2.1	35508
M 3 x 0.5	56	11	3.5	2.7	35510
M 4 x 0.7	63	13	4.5	3.4	35512
M 5 x 0.8	70	16	6.0	4.9	35513
M 6 x 1.0	80	19	6.0	4.9	35514
M 8 x 1.25	90	22	8.0	6.2	35515
M 10 x 1.5	100	24	10.0	8.0	35516

DIN 376

M 12 x 1.75	110	29	9.0	7.0	35517
M 14 x 2.0	110	30	11.0	9.0	35518
M 16 x 2.0	110	32	12.0	9.0	35519

with Oil Groove/con canali di espulsione

DIN 371

M 3 x 0.5	56	11	3.5	2.7	35610
M 4 x 0.7	63	13	4.5	3.4	35612
M 5 x 0.8	70	16	6.0	4.9	35613
M 6 x 1.0	80	19	6.0	4.9	35614
M 8 x 1.25	90	22	8.0	6.2	35615
M 10 x 1.5	100	24	10.0	8.0	35616

DIN 376

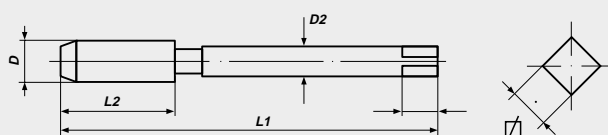
M 12 x 1.75	110	29	9.0	7.0	35617
M 14 x 2.0	110	30	11.0	9.0	35618
M 16 x 2.0	110	32	12.0	9.0	35619

Application:**bright:**

- for nonferrous metal of good ductility

Applicazione:**Lucido:**

- per materiali non ferrosi con buona deformabilità





Fluteless Machine Taps

metric ISO-thread DIN 13

Maschi a rullare

filettatura metrica ISO DIN 13



DIN 371/376

2.1/2 Thread Start

HSSE-VAP

Tol. ISO2X/6HX

Nominal Diameter D	L 1	L 2	D 2	☐	Art.-No.
-----------------------	-----	-----	-----	---	----------

without Oil Groove/senza canali di espulsione

DIN 371

M 3 x 0.5	56	11	3.5	2.7	35550
M 4 x 0.7	63	13	4.5	3.4	35552
M 5 x 0.8	70	16	6.0	4.9	35553
M 6 x 1.0	80	19	6.0	4.9	35554
M 8 x 1.25	90	22	8.0	6.2	35555
M 10 x 1.5	100	24	10.0	8.0	35556

DIN 376

M 12 x 1.75	110	29	9.0	7.0	35557
M 14 x 2.0	110	30	11.0	9.0	35558
M 16 x 2.0	110	32	12.0	9.0	35559

with Oil Groove/con canali di espulsione

DIN 371

M 3 x 0.5	56	11	3.5	2.7	35650
M 4 x 0.7	63	13	4.5	3.4	35652
M 5 x 0.8	70	16	6.0	4.9	35653
M 6 x 1.0	80	19	6.0	4.9	35654
M 8 x 1.25	90	22	8.0	6.2	35655
M 10 x 1.5	100	24	10.0	8.0	35656

DIN 376

M 12 x 1.75	110	29	9.0	7.0	35657
M 14 x 2.0	110	30	11.0	9.0	35658
M 16 x 2.0	110	32	12.0	9.0	35659

Application:

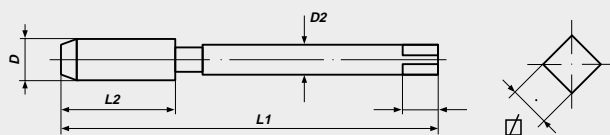
VAP (Steam Tempered):

- for steel up to approx. 700 N/mm²

Applicazione:

VAP (vaporizzato):

- per acciaio a ca. 700 N/mm²





Fluteless Machine Taps

metric ISO-thread DIN 13

Maschi a rullare

filettatura metrica ISO DIN 13

**DIN 371/376****2.1/2 Thread Start****HSSE-TIN****Tol. ISO2X/6HX**

Nominal Diameter D	L 1	L 2	D 2	☐	Art.-No.
-----------------------	-----	-----	-----	---	----------

without Oil Groove/senza canali di espulsione

DIN 371

M	1 x 0.25	40	5	2.5	2.1	35520
M	1.1 x 0.25	40	5	2.5	2.1	35521
M	1.2 x 0.25	40	5	2.5	2.1	35522
M	1.4 x 0.3	40	7	2.5	2.1	35523
M	1.6 x 0.35	40	8	2.5	2.1	35524
M	1.7 x 0.35	40	8	2.5	2.1	35525
M	1.8 x 0.35	40	8	2.5	2.1	35526
M	2 x 0.4	45	8	2.8	2.1	35527
M	2.5 x 0.45	50	9	2.8	2.1	35528
M	3 x 0.5	56	11	3.5	2.7	35530
M	4 x 0.7	63	13	4.5	3.4	35532
M	5 x 0.8	70	16	6.0	4.9	35533
M	6 x 1.0	80	19	6.0	4.9	35534
M	8 x 1.25	90	22	8.0	6.2	35535
M	10 x 1.5	100	24	10.0	8.0	35536

DIN 376

M	12 x 1.75	110	29	9.0	7.0	35537
M	14 x 2.0	110	30	11.0	9.0	35538
M	16 x 2.0	110	32	12.0	9.0	35539

with Oil Groove/con canali di espulsione

DIN 371

M	3 x 0.5	56	11	3.5	2.7	35630
M	4 x 0.7	63	13	4.5	3.4	35632
M	5 x 0.8	70	16	6.0	4.9	35633
M	6 x 1.0	80	19	6.0	4.9	35634
M	8 x 1.25	90	22	8.0	6.2	35635
M	10 x 1.5	100	24	10.0	8.0	35636

DIN 376

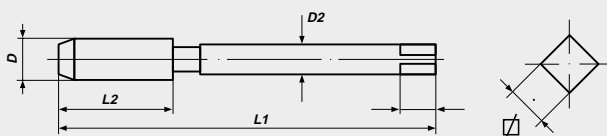
M	12 x 1.75	110	29	9.0	7.0	35637
M	14 x 2.0	110	30	11.0	9.0	35638
M	16 x 2.0	110	32	12.0	9.0	35639

Application:**TIN (Titanium Nitride Coating):**

- for steel up to approx. 900 N/mm²
and to increase endurance and cutting speed

Applicazione:**TIN (revetimento di nitrurato di titanio):**

- per acciaio a ca. 900 N/mm²
per l'aumento della vita utensile e della velocità di taglio





Fluteless Machine Taps (Forming Taps), *with oversize*

metric ISO-thread DIN 13

Maschi a rullare, *tolleranza maggiorata*

metrica ISO DIN 13



DIN 371/376

2.1/2 Thread Start

HSS-E

Tol. ISO3X/6GX

Nominal Diameter D	L 1	L 2	D 2	☑	Art.-No.
-----------------------	-----	-----	-----	---	----------

without Oil Groove/senza canali di espulsione

DIN 371

M 3 x 0.5	56	11	3.5	2.7	35510-6G
M 4 x 0.7	63	13	4.5	3.4	35512-6G
M 5 x 0.8	70	16	6.0	4.9	35513-6G
M 6 x 1.0	80	19	6.0	4.9	35514-6G
M 8 x 1.25	90	22	8.0	6.2	35515-6G
M 10 x 1.5	100	24	10.0	8.0	35516-6G

DIN 376

M 12 x 1.75	110	29	9.0	7.0	35517-6G
-------------	-----	----	-----	-----	----------

with Oil Groove/con canali di espulsione

DIN 371

M 3 x 0.5	56	11	3.5	2.7	35610-6G
M 4 x 0.7	63	13	4.5	3.4	35612-6G
M 5 x 0.8	70	16	6.0	4.9	35613-6G
M 6 x 1.0	80	19	6.0	4.9	35614-6G
M 8 x 1.25	90	22	8.0	6.2	35615-6G
M 10 x 1.5	100	24	10.0	8.0	35616-6G

DIN 376

M 12 x 1.75	110	29	9.0	7.0	35617-6G
-------------	-----	----	-----	-----	----------

Application:

tolerance ISO 3 (6G) =
oversize of 0,02 - 0,4 mm
pre plate material for
galvanising

Applicazione:

Classe di tolleranza ISO 3 (6G) =
tolleranza maggiorata di 0,02 – 0,04 mm
Per materiali con strato protettivo galvanico



MACHINE NUT TAPS MASCHI A MACCHINA PER DADI

	M	Tr
Machine Nut Taps Maschi a macchina per dadi	164	165



because available ■ because reliable ■ because you ■



Machine Nut Taps

metric ISO-thread DIN 13

Maschi a macchina per dadi

filettatura metrica ISO DIN 13



DIN 357

HSS-E

Tol. ISO2/6H

M

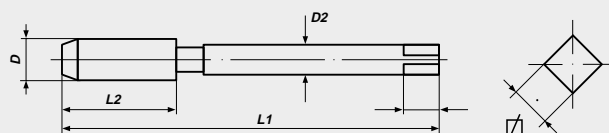
Nominal Diameter D	L 1	L 2	D 2	Ø	Art.-No.
M 3 x 0.5	70	22	2.2	—	37126
M 4 x 0.7	90	25	2.8	2.1	37130
M 5 x 0.8	100	28	3.5	2.7	37134
M 6 x 1.0	110	32	4.5	3.4	37138
M 8 x 1.25	125	40	6.0	4.9	37142
M 10 x 1.5	140	45	7.0	5.5	37146
M 12 x 1.75	180	50	9.0	7.0	37150
M 14 x 2.0	200	56	11.0	9.0	37154
M 16 x 2.0	200	63	12.0	9.0	37158
M 18 x 2.5	220	63	14.0	11.0	37162
M 20 x 2.5	250	70	16.0	12.0	37166
M 22 x 2.5	280	80	18.0	14.5	37170
M 24 x 3.0	280	80	18.0	14.5	37174

Application:

- long reduced shank to allow nuts to run over
- for thread depth up to 1 x D
- ideal for tapping difficult to reach holes
- for through holes
- for general use**
 - non abrasive material up to 800 N/mm²
 - unalloyed and low alloyed steel

Applicazione:

- Gambo prolungato per la lavorazione di più dadi contemporaneamente
- profondità di maschiatura a 1 x D
- per la filettatura in luoghi di difficile accesso
- per fori passanti
- per uso universale**
 - Materiali buona trucidibilità fino a R 800 N/mm²
 - Acciaio non legati e scarsamente legati





Machine Nut Taps

piloted, trapezoidal thread DIN 103

Maschi a macchina per dadi

con nocciolo di guida, filettatura trapezoidale metrica ISO 103

**HSS-G****Tol. 7H****Tr**

Nominal Diameter D	L 1	L 2	D 2	Ø	Art.-No.
Tr 10 x 2	110	63	7	5.5	79108
Tr 10 x 3	125	75	7	5.5	79112
Tr 12 x 3	165	111	8	6.2	79116
Tr 14 x 3	140	85	10	8.0	79120
Tr 14 x 4	170	112	10	8.0	79124
Tr 16 x 4	180	116	11	9.0	79128
Tr 18 x 4	190	120	12	9.0	79132
Tr 20 x 4	200	124	14	11.0	79136
Tr 22 x 4	210	130	16	12.0	79139
Tr 22 x 5	235	155	16	12.0	79140
Tr 24 x 5	245	160	18	14.5	79144
Tr 26 x 5	255	165	20	16.0	79148
Tr 28 x 5	265	170	22	18.0	79152
Tr 30 x 6	290	185	22	18.0	79156
Tr 32 x 6	300	191	25	20.0	79160
Tr 36 x 6	310	200	28	22.0	79164

LEFT HAND THREAD/FILETTO SINISTRO

Tr 10 x 2	110	63	7	5.5	79108-L
Tr 10 x 3	125	75	7	5.5	79112-L
Tr 12 x 3	165	111	8	6.2	79116-L
Tr 14 x 3	140	85	10	8.0	79120-L
Tr 14 x 4	170	112	10	8.0	79124-L
Tr 16 x 4	180	116	11	9.0	79128-L
Tr 18 x 4	190	120	12	9.0	79132-L
Tr 20 x 4	200	124	14	11.0	79136-L
Tr 22 x 5	235	155	16	12.0	79140-L
Tr 24 x 5	245	160	18	14.5	79144-L
Tr 26 x 5	255	165	20	16.0	79148-L
Tr 28 x 5	265	170	22	18.0	79152-L
Tr 30 x 6	290	185	22	18.0	79156-L
Tr 32 x 6	300	191	25	20.0	79160-L
Tr 36 x 6	310	200	28	22.0	79164-L

Application:

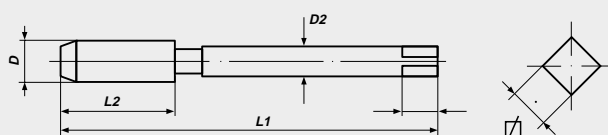
for general use

- non abrasive material up to 700 N/mm²
- unalloyed and low alloyed steel
- for thread depth up to 1 x D
- for through holes

Applicazione:

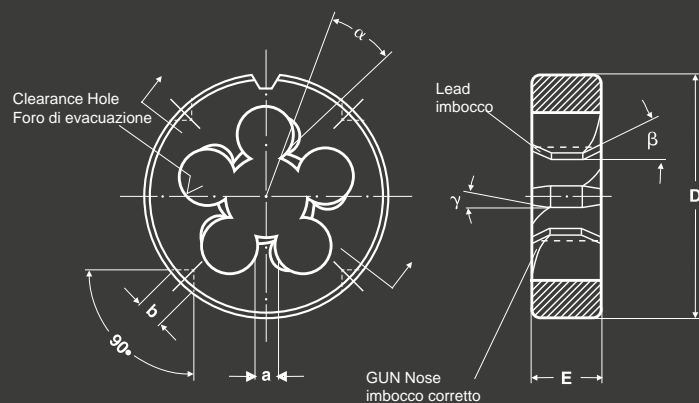
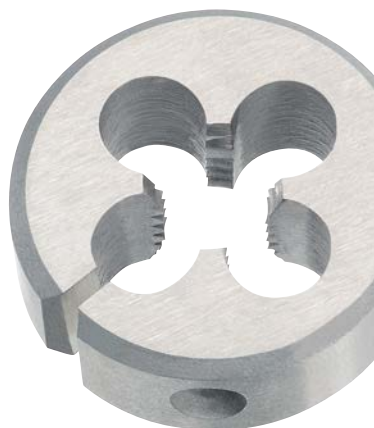
per uso universale

- Materiali buona truciabilità fino a R 800 N/mm²
- Acciaio non legati e scarsamente legati
- profondità di maschiatura a 1 x D
- per fori passanti



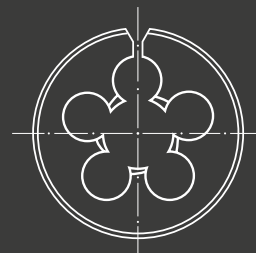


ROUND DIES
HEXAGON DIE NUTS
FILIERE
FILIERE ESAGONALI

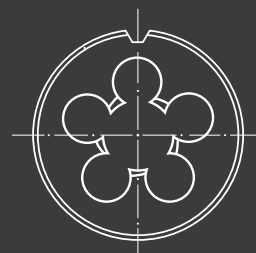


D	Outside diameter	Diametro esterno
E	Width of die	Spessore
a	Width of land	Ampiezza del dente
b	Hole for holding screws	Diametro fissaggio vite
α	Rake angle	Angolo di taglio
β	Lead angle	Angolo dell'imbocco
γ	Angle of gun nose	Angolo dell'imbocco corretto

Form A split / Forma A aperta



Form B solid / Forma B chiuso



Unless otherwise requested,
all dies are supplied solid
(Form B).

Se non diversamente specificato,
forniamo tutte le filiere in forma B (chiuso)



Round Dies VS

HSS Round Dies for general use by hand, for non abrasive material

Filiere tonde VS

Filiere tonde HSS per uso universale a mano, per la lavorazione di materiali con buona truciolabilità.



Round Dies VE

HSS-E Round Dies with gun nose, for general use by hand, for stainless steel and abrasive material

Filiere tonde VE

Filiere tonde HSS-E con imbocco corretto per uso universale a mano, per la lavorazione di acciai inossidabili e materiali di difficile lavorazione.



Round Dies VX

Lapped and steam tempered high performance HSS-E Round Dies with gun nose, for thread cutting by hand and machine, for alloyed, tough-hard material, stainless steel, aluminium and spheroidal graphite cast iron (GGG)

Filiere tonde VX

Filiere tonde per alte prestazioni in HSS-E con imbocco corretto, lappate e vaporizzate, per uso a mano e a macchina, per la lavorazione di materiali teneri legati, acciai inossidabili, alluminio e ghisa sferoidale (GGG).



Round Dies MS

Lapped HSS Round Dies with gun nose, optimized for machining brass, short-chipping material and short-chipping bronze

Filiere tonde MS

Filiere tonde HSS lappate con imbocco corretto per la lavorazione ottimale di materiali in ottone, materiali in bronzo a truciolo corto e in bronzo a truciolo corto.



Hexagon Die Nuts VS

HSS Hexagon Die Nuts, for general use by hand, for non abrasive material, for cleaning and repairing damaged threads and for general use in awkward places

Filiere esagonali VS

Filiere esagonali HSS per uso universale a mano, per la lavorazione di materiali con buona truciolabilità, per la riparazione di filetti danneggiati e in luoghi di difficile accesso.










	VS HSS 	VS HSS 	VE HSSE 	VX HSSE-VAP 	MS HSS 	Collants and lubrications Refrigerazione e lubrificante
Thread cutting by hand Per uso a mano	●	●	●	●	●	
Machine use Per uso a macchina	○		○	●	○	
Steel, unalloyed; tensile strength < 800N/mm ² Acciai non legati; resistenza alla trazione < 800N/mm ²	●	●	●	●		Thread cutting oil also with lubricity-increasing additives, emulsion Emulsione, Olio da taglio con additivi che aumentano la lubrificazione
Machining steels, case hardening steels, tempered steels; tensile strength < 800 N/mm ² Acciai automatici, acciai da cementazione, acciai bonificati; resistenza alla trazione < 800 N/mm ²	○	○	●	●		
Steel, unalloyed; tensile strength < 1000N/mm ² Acciai non legati; resistenza alla trazione < 1000N/mm ²			●	●		
Steel, alloyed and unalloyed; tensile strength < 1200 N/mm ² Acciai legati e non legati; resistenza alla trazione < 1200 N/mm ²			○	●		Thread cutting oil, thread cutting oil highly activated with special additives, emulsion Olio da taglio per maschiatura, Olio da taglio con additivi, Emulsione
Rust- and acid-resistant steels; VA-steels < 850 N/mm ² Acciai inossidabili, Acciai V4A; resistenza alla trazione < 850 N/mm ²			○	●		
Rust- and acid-resistant steels with high chromium-nickel content, V4A steels Acciai inossidabili con alto contenuto in Cromo-Nickel, Acciai V4A				●		
Brass, short-chipping Ottone, truciolo corto					●	Thread cutting oil for non- ferrous metals, emulsion Olio da taglio per maschiatura per metalli non ferrosi, Emulsione
Brass, long-chipping Ottone, truciolo lungo	○	○	●			
Bronze, short-chipping Bronzo, truciolo corto					●	
Copper alloys Leghe di rame			○	●		
Aluminium, short-chipping Alluminio, truciolo corto				●		
Aluminium, long-chipping Alluminio, truciolo lungo	○	○	●			
Titanium alloys; tensile strength < 1200 N/mm ² Leghe di titanio; resistenza alla trazione < 1200 N/mm ²				○		Special thread cutting oil Olio da taglio speciale per maschiatura
Thermosetting plastics Duroplaste					●	Oil mist, compressed air, mold release oil Olio nebulizzato, Aria compressa, Olio di distacco dallo stampo

● = appropriate / idoneità ottimale ○ = conditionally suitable / idoneità limitata



ROUND DIES
HEXAGON DIE NUTS
FILIERE
FILIERE ESAGONALI

	VS HSS 	MS HSS 	VE HSSE 	VX HSSE-VAP 	VS LH 	VS HSS 	VS LH 
M	170	197	190	193	201	208	217
M - 6e	172						
Mf	173	198	191	194	202	209	
BSW	179				205	211	
BSF	179					211	
BA	180						
UNC	181				206	212	
UNF	182				206	212	
UNEF	183						
8 - UN						213	
G (BSP)	184	200	192	196	207	214	218
R (BSPT)	185					215	
PG	186						
NPT	187					216	
NPTF	187						
FG	188						
BSC	188						
Vg	189						

because available ■ because reliable ■ because you ■



Round Dies VS
metric ISO-thread DIN 13

Filiere tonde VS
filettatura metrica ISO DIN 13



DIN 223 (DIN EN 22568)

HSS

Tol. 6g

M

Nominal Diameter mm	Ø o / d	Art.-No.
M 1 x 0.25	16 x 5	27402
M 1.1 x 0.25	16 x 5	27404
M 1.2 x 0.25	16 x 5	27406
M 1.4 x 0.3	16 x 5	27408
M 1.6 x 0.35	16 x 5	27410
M 1.7 x 0.35	16 x 5	27412
M 1.8 x 0.35	16 x 5	27414
M 2 x 0.4	16 x 5	27416
M 2.2 x 0.45	16 x 5	27418
M 2.3 x 0.4	16 x 5	27420
M 2.5 x 0.45	16 x 5	27422
M 2.6 x 0.45	16 x 5	27424
M 3 x 0.5	20 x 5	27426
M 3.5 x 0.6	20 x 5	27428
M 4 x 0.7	20 x 5	27430
M 4.5 x 0.75	20 x 7	27432
M 5 x 0.8	20 x 7	27434
M 5.5 x 0.9	20 x 7	27436
M 6 x 1.0	20 x 7	27438
M 7 x 1.0	25 x 9	27440
M 8 x 1.25	25 x 9	27442
M 9 x 1.25	25 x 9	27444
M 10 x 1.5	30 x 11	27446
M 11 x 1.5	30 x 11	27448
M 12 x 1.75	38 x 14	27450
M 14 x 2.0	38 x 14	27454
M 15 x 2.0	38 x 14	27456
M 16 x 2.0	45 x 18	27458
M 18 x 2.5	45 x 18	27462
M 19 x 2.5	45 x 18	27464
M 20 x 2.5	45 x 18	27466
M 22 x 2.5	55 x 22	27470
M 24 x 3.0	55 x 22	27474
M 27 x 3.0	65 x 25	27476
M 30 x 3.5	65 x 25	27478
M 33 x 3.5	65 x 25	27480
M 36 x 4.0	65 x 25	27482
M 39 x 4.0	75 x 30	27484
M 42 x 4.5	75 x 30	27486
M 45 x 4.5	90 x 36	27488
M 48 x 5.0	90 x 36	27490
M 52 x 5.0	90 x 36	27492
M 56 x 5.5	105 x 36	27494
M 60 x 5.5	105 x 36	27496
M 64 x 6.0	120 x 36	27498
M 68 x 6.0	120 x 36	27499



Application:

for general use

- non abrasive material up to 800 N/mm²
- unalloyed and low alloyed steel

Applicazione:

per uso universale

- Materiali con buona trucidibilità fino a R 800 N/mm²
- Acciaio non legati e scarsamente legati

**Round Dies VS**
metric ISO-thread DIN 13**Filiere tonde VS**
filettatura metrica ISO DIN 13**HSS****Tol. 6g****M**

Nominal Diameter mm	Ø o / d	Art.-No.
M 72 x 6.0	120 x 36	28280
M 76 x 6.0	120 x 36	28281
M 80 x 6.0	120 x 36	28282
M 84 x 6.0	130 x 36	28283
M 88 x 6.0	140 x 36	28284
M 90 x 6.0	140 x 36	28285
M 92 x 6.0	140 x 36	28286
M 96 x 6.0	140 x 36	28287
M 100 x 6.0	150 x 36	28288
M 3 x 0.5	25 x 9	27826
M 4 x 0.7	25 x 9	27830
M 5 x 0.8	25 x 9	27834
M 6 x 1.0	25 x 9	27838
M 8 x 1.25	25 x 9	27842
M 10 x 1.5	25 x 9	27846
M 12 x 1.75	25 x 9	27850
M 3 x 0.5	25.4	Form A 27926
M 4 x 0.7	25.4	Form A 27930
M 5 x 0.8	25.4	Form A 27934
M 6 x 1.0	25.4	Form A 27938
M 8 x 1.25	25.4	Form A 27942
M 10 x 1.5	25.4	Form A 27946
M 12 x 1.75	25.4	Form A 27950
M 14 x 2.0	38.1	Form A 27954
M 16 x 2.0	38.1	Form A 27958
M 18 x 2.5	38.1	Form A 27962
M 20 x 2.5	38.1	Form A 27966

Application:
for general use

- non abrasive material up to 800 N/mm²
- unalloyed and low alloyed steel

Applicazione:
per uso universale

- Materiali con buona truciabilità fino a R 800 N/mm²
- Acciaio non legati e scarsamente legati

**Round Dies VS**

metric-fine ISO-thread DIN 13

Filiere tonde VS

filettatura metrica fine ISO DIN 13

**DIN 223 (DIN EN 22568)****HSS****Tol. 6g****Mf**

Nominal Diameter mm	Ø o / d	Art.-No.
M 2.5 x 0.35	16 x 5	26404
M 2.6 x 0.35	16 x 5	26405
M 3 x 0.35	20 x 5	26408
M 3.5 x 0.35	20 x 5	26409
M 4 x 0.35	20 x 5	26410
M 4 x 0.5	20 x 5	26412
M 4.5 x 0.5	20 x 5	26413
M 5 x 0.5	20 x 5	26414
M 5 x 0.75	20 x 7	26416
M 5.5 x 0.5	20 x 5	26415
M 6 x 0.5	20 x 5	26417
M 6 x 0.75	20 x 7	26418
M 7 x 0.5	25 x 9	26419
M 7 x 0.75	25 x 9	26420
M 8 x 0.5	25 x 9	26422
M 8 x 0.75	25 x 9	26424
M 8 x 1.0	25 x 9	26426
M 9 x 0.5	25 x 9	26427
M 9 x 0.75	25 x 9	26428
M 9 x 1.0	25 x 9	26430
M 10 x 0.5	30 x 11	26431
M 10 x 0.75	30 x 11	26432
M 10 x 1.0	30 x 11	26436
M 10 x 1.25	30 x 11	26438
M 11 x 1.0	30 x 11	26440
M 11 x 1.25	30 x 11	26442
M 12 x 0.5	38 x 10	26445
M 12 x 0.75	38 x 10	26443
M 12 x 1.0	38 x 10	26444
M 12 x 1.25	38 x 10	26446
M 12 x 1.5	38 x 10	26448
M 13 x 0.5	38 x 10	26447
M 13 x 0.75	38 x 10	26449
M 13 x 1.0	38 x 10	26450
M 13 x 1.5	38 x 10	26451
M 14 x 0.5	38 x 10	26455
M 14 x 0.75	38 x 10	26452
M 14 x 1.0	38 x 10	26453
M 14 x 1.25	38 x 10	26454
M 14 x 1.5	38 x 10	26456
M 15 x 0.75	38 x 10	26457
M 15 x 1.0	38 x 10	26458
M 15 x 1.5	38 x 10	26460
M 16 x 0.5	45 x 14	26461
M 16 x 0.75	45 x 14	26463

**Application:
for general use**

- non abrasive material up to 800 N/mm²
- unalloyed and low alloyed steel

**Applicazione:
per uso universale**

- Materiali con buona truciabilità fino a R 800 N/mm²
- Acciaio non legati e scarsamente legati



Round Dies VS

metric-fine ISO-thread DIN 13

Filiere tonde VS

filettatura metrica fine ISO DIN 13



DIN 223 (DIN EN 22568)

HSS

Tol. 6g

Mf

Nominal Diameter mm	Ø o / d	Art.-No.
M 16 x 1.0	45 x 14	26462
M 16 x 1.25	45 x 14	26464
M 16 x 1.5	45 x 14	26466
M 17 x 1.0	45 x 14	26468
M 17 x 1.5	45 x 14	26469
M 18 x 0.5	45 x 14	26467
M 18 x 0.75	45 x 14	26473
M 18 x 1.0	45 x 14	26470
M 18 x 1.25	45 x 14	26471
M 18 x 1.5	45 x 14	26472
M 18 x 2.0	45 x 14	26474
M 19 x 1.0	45 x 14	26475
M 19 x 1.5	45 x 14	26476
M 20 x 0.5	45 x 14	26477
M 20 x 0.75	45 x 14	26479
M 20 x 1.0	45 x 14	26478
M 20 x 1.25	45 x 14	26480
M 20 x 1.5	45 x 14	26484
M 20 x 2.0	45 x 14	26486
M 21 x 1.0	45 x 14	26487
M 21 x 1.5	45 x 14	26488
M 22 x 0.5	55 x 16	26489
M 22 x 0.75	55 x 16	26491
M 22 x 1.0	55 x 16	26490
M 22 x 1.25	55 x 16	26492
M 22 x 1.5	55 x 16	26494
M 22 x 2.0	55 x 16	26496
M 23 x 1.0	55 x 16	26497
M 23 x 1.5	55 x 16	26498
M 24 x 0.5	55 x 16	26601
M 24 x 0.75	55 x 16	26603
M 24 x 1.0	55 x 16	26600
M 24 x 1.25	55 x 16	26602
M 24 x 1.5	55 x 16	26604
M 24 x 2.0	55 x 16	26606
M 25 x 1.0	55 x 16	26607
M 25 x 1.5	55 x 16	26608
M 26 x 1.0	55 x 16	26610
M 26 x 1.5	55 x 16	26612
M 26 x 2.0	55 x 16	26614
M 27 x 1.0	65 x 18	26616
M 27 x 1.5	65 x 18	26617
M 27 x 2.0	65 x 18	26618
M 28 x 1.0	65 x 18	26620
M 28 x 1.5	65 x 18	26622
M 28 x 2.0	65 x 18	26624
M 29 x 1.5	65 x 18	26626
M 30 x 1.0	65 x 18	26628
M 30 x 1.5	65 x 18	26630
M 30 x 2.0	65 x 18	26632



**Round Dies VS**

metric-fine ISO-thread DIN 13

Filiere tonde VS

filettatura metrica fine ISO DIN 13

**DIN 223 (DIN EN 22568)****HSS****Tol. 6g****Mf**

Nominal Diameter mm	Ø o / d	Art.-No.
M 30 x 2.5	65 x 18	26633
M 30 x 3.0	65 x 25	26634
M 32 x 1.0	65 x 18	26639
M 32 x 1.5	65 x 18	26636
M 32 x 2.0	65 x 18	26635
M 32 x 3.0	65 x 25	26637
M 33 x 1.5	65 x 18	26638
M 33 x 2.0	65 x 18	26640
M 33 x 3.0	65 x 25	26642
M 34 x 1.0	65 x 18	26643
M 34 x 1.5	65 x 18	26644
M 34 x 2.0	65 x 18	26646
M 35 x 1.0	65 x 18	26647
M 35 x 1.5	65 x 18	26648
M 35 x 2.0	65 x 18	26649
M 36 x 1.0	65 x 18	26651
M 36 x 1.5	65 x 18	26650
M 36 x 2.0	65 x 18	26652
M 36 x 3.0	65 x 25	26654
M 37 x 1.5	65 x 18	26653
M 38 x 1.0	75 x 20	26655
M 38 x 1.5	75 x 20	26656
M 38 x 2.0	75 x 20	26657
M 38 x 3.0	75 x 30	26659
M 39 x 1.5	75 x 20	26658
M 39 x 2.0	75 x 20	26660
M 39 x 3.0	75 x 30	26662
M 40 x 1.0	75 x 20	26663
M 40 x 1.5	75 x 20	26664
M 40 x 2.0	75 x 20	26666
M 40 x 3.0	75 x 30	26668
M 42 x 1.0	75 x 20	26669
M 42 x 1.5	75 x 20	26670
M 42 x 2.0	75 x 20	26672
M 42 x 3.0	75 x 30	26674
M 44 x 1.5	90 x 22	26671
M 44 x 2.0	90 x 22	26673
M 45 x 1.0	90 x 22	26675
M 45 x 1.5	90 x 22	26676
M 45 x 2.0	90 x 22	26678
M 45 x 3.0	90 x 36	26680
M 46 x 1.5	90 x 22	26681
M 48 x 1.0	90 x 22	26683
M 48 x 1.5	90 x 22	26682
M 48 x 2.0	90 x 22	26684
M 48 x 3.0	90 x 36	26686
M 50 x 1.5	90 x 22	26688
M 50 x 2.0	90 x 22	26690
M 50 x 3.0	90 x 36	26692
M 52 x 1.5	90 x 22	26694



Round Dies VS

metric-fine ISO-thread DIN 13

Filiere tonde VS

filettatura metrica fine ISO DIN 13



DIN 223 (DIN EN 22568)

HSS

Tol. 6g

Mf

Nominal Diameter mm	Ø o / d	Art.-No.
M 52 x 2.0	90 x 22	26696
M 52 x 3.0	90 x 36	26698
M 54 x 1.0	105 x 22	28267
M 54 x 1.5	105 x 22	28150
M 54 x 2.0	105 x 22	28151
M 54 x 3.0	105 x 36	28152
M 54 x 4.0	105 x 36	28153
M 55 x 1.5	105 x 22	28154
M 55 x 2.0	105 x 22	28155
M 55 x 3.0	105 x 36	28156
M 55 x 4.0	105 x 36	28157
M 56 x 1.0	105 x 22	28268
M 56 x 1.5	105 x 22	28158
M 56 x 2.0	105 x 22	28159
M 56 x 3.0	105 x 36	28160
M 56 x 4.0	105 x 36	28161
M 58 x 1.0	105 x 22	28269
M 58 x 1.5	105 x 22	28162
M 58 x 2.0	105 x 22	28163
M 58 x 3.0	105 x 36	28164
M 58 x 4.0	105 x 36	28165
M 60 x 1.5	105 x 22	28166
M 60 x 2.0	105 x 22	28167
M 60 x 3.0	105 x 36	28168
M 60 x 4.0	105 x 36	28169
M 62 x 1.5	105 x 22	28170
M 62 x 2.0	105 x 22	28171
M 62 x 3.0	105 x 36	28172
M 62 x 4.0	105 x 36	28173
M 63 x 1.5	105 x 22	28174
M 64 x 1.5	120 x 22	28175
M 64 x 2.0	120 x 22	28176
M 64 x 3.0	120 x 36	28177
M 64 x 4.0	120 x 36	28178
M 65 x 1.5	120 x 22	28179
M 65 x 2.0	120 x 22	28180
M 65 x 3.0	120 x 36	28181
M 65 x 4.0	120 x 36	28182
M 68 x 1.5	120 x 22	28183
M 68 x 2.0	120 x 22	28184
M 68 x 3.0	120 x 36	28185
M 68 x 4.0	120 x 36	28186
M 70 x 1.5	120 x 22	28187
M 70 x 2.0	120 x 22	28188
M 70 x 3.0	120 x 36	28189
M 70 x 4.0	120 x 36	28190
M 72 x 1.5	120 x 22	28191
M 72 x 2.0	120 x 22	28192
M 72 x 3.0	120 x 36	28193
M 72 x 4.0	120 x 36	28194



**Round Dies VS**

metric-fine ISO-thread DIN 13

Filiere tonde VS

filettatura metrica fine ISO DIN 13

**DIN 223 (DIN EN 22568)****HSS****Tol. 6g****Mf**

Nominal Diameter mm	Ø o / d	Art.-No.
M 74 x 1.5	120 x 22	28195
M 74 x 2.0	120 x 22	28196
M 74 x 3.0	120 x 36	28197
M 74 x 4.0	120 x 36	28198
M 75 x 1.5	120 x 22	28199
M 75 x 2.0	120 x 22	28200
M 75 x 3.0	120 x 36	28201
M 75 x 4.0	120 x 36	28202
M 76 x 1.5	120 x 22	28203
M 76 x 2.0	120 x 22	28204
M 76 x 3.0	120 x 36	28205
M 76 x 4.0	120 x 36	28206
M 78 x 1.5	120 x 22	28207
M 78 x 2.0	120 x 22	28208
M 78 x 3.0	120 x 36	28209
M 78 x 4.0	120 x 36	28210
M 80 x 1.5	120 x 22	28211
M 80 x 2.0	120 x 22	28212
M 80 x 3.0	120 x 36	28213
M 80 x 4.0	120 x 36	28214
M 82 x 1.5	130 x 25	28215
M 82 x 2.0	130 x 25	28216
M 82 x 3.0	130 x 36	28217
M 82 x 4.0	130 x 36	28218
M 84 x 1.5	130 x 25	28219
M 84 x 2.0	130 x 25	28220
M 84 x 3.0	130 x 36	28221
M 84 x 4.0	130 x 36	28222
M 85 x 1.5	130 x 25	28223
M 85 x 2.0	130 x 25	28224
M 85 x 3.0	130 x 36	28225
M 85 x 4.0	130 x 36	28226
M 86 x 1.5	140 x 22	28227
M 86 x 2.0	140 x 22	28228
M 86 x 3.0	140 x 22	28229
M 86 x 4.0	140 x 22	28230
M 88 x 1.5	140 x 22	28231
M 88 x 2.0	140 x 22	28232
M 88 x 3.0	140 x 22	28233
M 88 x 4.0	140 x 22	28234
M 90 x 1.5	140 x 22	28235
M 90 x 2.0	140 x 22	28236
M 90 x 3.0	140 x 22	28237
M 90 x 4.0	140 x 22	28238
M 92 x 1.5	140 x 22	28239
M 92 x 2.0	140 x 22	28240
M 92 x 3.0	140 x 22	28241
M 92 x 4.0	140 x 22	28242
M 95 x 1.5	140 x 22	28243
M 95 x 2.0	140 x 22	28244



Round Dies VS

metric-fine ISO-thread DIN 13

Filiere tonde VS

filettatura metrica fine ISO DIN 13



DIN 223 (DIN EN 22568)

HSS

Tol. 6g

Mf

Nominal Diameter mm	Ø o / d	Art.-No.
M 95 x 3.0	140 x 22	28245
M 95 x 4.0	140 x 22	28246
M 96 x 1.5	140 x 22	28247
M 96 x 2.0	140 x 22	28248
M 96 x 3.0	140 x 22	28249
M 96 x 4.0	140 x 22	28250
M 98 x 1.5	150 x 25	28251
M 98 x 2.0	150 x 25	28252
M 98 x 3.0	150 x 25	28253
M 98 x 4.0	150 x 25	28254
M 100 x 1.5	150 x 25	28255
M 100 x 2.0	150 x 25	28256
M 100 x 3.0	150 x 25	28257
M 100 x 4.0	150 x 25	28258
M 105 x 1.5	150 x 25	28259
M 105 x 2.0	150 x 25	28260
M 105 x 3.0	150 x 25	28261
M 105 x 4.0	150 x 25	28262
M 110 x 1.5	160 x 25	28263
M 110 x 2.0	160 x 25	28264
M 110 x 3.0	160 x 25	28265
M 110 x 4.0	160 x 25	28266

**Round Dies VS**

Whitworth-thread BS 84

Filiere tonde VS

filettatura Whitworth BS 84

**DIN 223 (DIN EN 22568)****HSS****Tol. med.****BSW / BSF**

Nominal Diameter	Ø o / d	Art.-No.
BSW		
BSW 1/16 x 60	16 x 5	22402
BSW 3/32 x 48	16 x 5	22404
BSW 1/8 x 40	20 x 5	22406
BSW 5/32 x 32	20 x 5	22408
BSW 3/16 x 24	20 x 7	22410
BSW 7/32 x 24	20 x 7	22412
BSW 1/4 x 20	20 x 7	22414
BSW 5/16 x 18	25 x 9	22416
BSW 3/8 x 16	30 x 11	22418
BSW 7/16 x 14	30 x 11	22420
BSW 1/2 x 12	38 x 14	22422
BSW 9/16 x 12	38 x 14	22424
BSW 5/8 x 11	45 x 18	22426
BSW 3/4 x 10	45 x 18	22430
BSW 7/8 x 9	55 x 22	22434
BSW 1" x 8	55 x 22	22438
BSW 1.1/8 x 7	65 x 25	22442
BSW 1.1/4 x 7	65 x 25	22446
BSW 1.3/8 x 6	65 x 25	22450
BSW 1.1/2 x 6	65 x 25	22452
BSW 1.1/2 x 6	75 x 30	22454
BSW 1.5/8 x 5	75 x 30	22458
BSW 1.3/4 x 5	90 x 36	22462
BSW 1.7/8 x 4.1/2	90 x 36	22466
BSW 2" x 4.1/2	90 x 36	22470
BSW 2.1/4 x 4	105 x 36	22472
BSW 2.1/2 x 4	105 x 36	22474
BSW 2.3/4 x 3.1/2	120 x 36	22476
BSW 3" x 3.1/2	120 x 36	22478
BSF		
BSF 3/16 x 32	20 x 7	22810
BSF 1/4 x 26	20 x 7	22814
BSF 5/16 x 22	25 x 9	22816
BSF 3/8 x 20	30 x 11	22818
BSF 7/16 x 18	30 x 11	22820
BSF 1/2 x 16	38 x 10	22822
BSF 9/16 x 16	38 x 10	22824
BSF 5/8 x 14	45 x 14	22826
BSF 3/4 x 12	45 x 14	22830
BSF 7/8 x 11	55 x 16	22834
BSF 1" x 10	55 x 22	22838

**Application:
for general use**

- non abrasive material up to 800 N/mm²
- unalloyed and low alloyed steel

**Applicazione:
per uso universale**

- Materiali con buona truciabilità fino a R 800 N/mm²
- Acciaio non legati e scarsamente legati



Round Dies VS

Unified Coarse thread

Filiere tonde VS

filettatura unificata, serie grossa ANSI B1.1

**DIN 223 (DIN EN 22568)****HSS****Tol. 2A****UNC**

Nominal Diameter	Ø o / d	Art.-No.
UNC Nr. 1 x 64	16 x 5	23401
UNC Nr. 2 x 56	16 x 5	23402
UNC Nr. 3 x 48	16 x 5	23403
UNC Nr. 4 x 40	20 x 5	23404
UNC Nr. 5 x 40	20 x 5	23405
UNC Nr. 6 x 32	20 x 7	23406
UNC Nr. 8 x 32	20 x 7	23408
UNC Nr.10 x 24	20 x 7	23410
UNC Nr.12 x 24	20 x 7	23412
UNC 1/4 x 20	20 x 7	23414
UNC 5/16 x 18	25 x 9	23416
UNC 3/8 x 16	30 x 11	23418
UNC 7/16 x 14	30 x 11	23420
UNC 1/2 x 13	38 x 14	23422
UNC 9/16 x 12	38 x 14	23424
UNC 5/8 x 11	45 x 18	23426
UNC 3/4 x 10	45 x 18	23430
UNC 7/8 x 9	55 x 22	23434
UNC 1" x 8	55 x 22	23438
UNC 1.1/8 x 7	65 x 25	23442
UNC 1.1/4 x 7	65 x 25	23446
UNC 1.3/8 x 6	65 x 25	23450
UNC 1.1/2 x 6	65 x 25	23452
UNC 1.1/2 x 6	75 x 30	23454
UNC 1.5/8 x 5	75 x 30	23458
UNC 1.3/4 x 5	90 x 36	23462
UNC 1.7/8 x 4.1/2	90 x 36	23466
UNC 2" x 4.1/2	90 x 36	23470

**Application:
for general use**

- non abrasive material up to 800 N/mm²
- unalloyed and low alloyed steel

**Applicazione:
per uso universale**

- Materiali con buona trucidibilità fino a R 800 N/mm²
- Acciaio non legati e scarsamente legati



Round Dies VS

Unified Fine thread

Filiere tonda VS

filettatura unificata, serie fina ANSI B1.1



DIN 223 (DIN EN 22568)

HSS

Tol. 2A

UNF

Nominal Diameter			Ø o / d	Art.-No.
UNF	Nr.	0 x 80	16 x 5	24400
UNF	Nr.	1 x 72	16 x 5	24401
UNF	Nr.	2 x 64	16 x 5	24402
UNF	Nr.	3 x 56	16 x 5	24403
UNF	Nr.	4 x 48	20 x 5	24404
UNF	Nr.	5 x 44	20 x 5	24405
UNF	Nr.	6 x 40	20 x 5	24406
UNF	Nr.	8 x 36	20 x 7	24408
UNF	Nr.	10 x 32	20 x 7	24410
UNF	Nr.	12 x 28	20 x 7	24412
UNF		1/4 x 28	20 x 7	24414
UNF		5/16 x 24	25 x 9	24416
UNF		3/8 x 24	30 x 11	24418
UNF		7/16 x 20	30 x 11	24420
UNF		1/2 x 20	38 x 10	24422
UNF		9/16 x 18	38 x 10	24424
UNF		5/8 x 18	45 x 14	24426
UNF		3/4 x 16	45 x 14	24430
UNF		7/8 x 14	55 x 16	24434
UNF		1" x 12	55 x 16	24438
UNF		1" x 14	55 x 16	24440
UNF		1.1/8 x 12	65 x 18	24442
UNF		1.1/4 x 12	65 x 18	24446
UNF		1.3/8 x 12	65 x 18	24450
UNF		1.1/2 x 12	65 x 18	24452
UNF		1.1/2 x 12	75 x 20	24454

**Application:
for general use**

- non abrasive material up to 800 N/mm²
- unalloyed and low alloyed steel

**Applicazione:
per uso universale**

- Materiali con buona truciabilità fino a R 800 N/mm²
- Acciaio non legati e scarsamente legati



Round Dies VS

Unified Extra Fine thread ANSI B 1.1

Filiere tonde VS

filettatura unificata, serie extra-fina ANSI B1.1



DIN 223 (DIN EN 22568)

HSS

Tol. 2A

UNEF

Nominal Diameter		Ø o / d	Art.-No.
UNEF	Nr. 12 x 32	20 x 7	24612
UNEF	1/4 x 32	20 x 7	24614
UNEF	5/16 x 32	25 x 9	24615
UNEF	3/8 x 32	30 x 11	24616
UNEF	7/16 x 28	30 x 11	24620
UNEF	1/2 x 28	38 x 10	24621
UNEF	9/16 x 24	38 x 10	24625
UNEF	5/8 x 24	45 x 14	24626
UNEF	11/16 x 24	45 x 14	24627
UNEF	3/4 x 20	45 x 14	24633
UNEF	13/16 x 20	55 x 16	24634
UNEF	7/8 x 20	55 x 16	24635
UNEF	15/16 x 20	55 x 16	24636
UNEF	1" x 20	55 x 16	24637
UNEF	1.1/16 x 18	65 x 18	24645
UNEF	1.1/8 x 18	65 x 18	24646
UNEF	1.3/16 x 18	65 x 18	24647
UNEF	1.1/4 x 18	65 x 18	24648
UNEF	1.5/16 x 18	65 x 18	24649
UNEF	1.3/8 x 18	65 x 18	24650
UNEF	1.7/16 x 18	75 x 20	24651
UNEF	1.1/2 x 18	75 x 20	24652

Application: for general use

- non abrasive material up to 800 N/mm²
- unalloyed and low alloyed steel

Applicazione: per uso universale

- Materiali con buona truciabilità fino a R 800 N/mm²
- Acciaio non legati e scarsamente legati



Round Dies VS
Pipe-thread DIN ISO 228

Filiere tonda VS
filettatura per tubi gas DIN ISO 228



DIN 5158 (DIN EN 24231)

HSS

Tol. A

G (BSP)

Nominal Diameter	Ø o / d	Art.-No.
G 1/8 x 28	30 x 11	25412
G 1/4 x 19	38 x 10	25414
G 3/8 x 19	45 x 14	25416
G 1/2 x 14	45 x 14	25418
G 5/8 x 14	55 x 16	25420
G 3/4 x 14	55 x 16	25422
G 7/8 x 14	65 x 18	25424
G 1" x 11	65 x 18	25426
G 1.1/8 x 11	75 x 20	25430
G 1.1/4 x 11	75 x 20	25434
G 1.3/8 x 11	90 x 22	25438
G 1.1/2 x 11	90 x 22	25442
G 1.5/8 x 11	90 x 22	25446
G 1.3/4 x 11	105 x 22	25450
G 2" x 11	90 x 22	25452
G 2" x 11	105 x 22	25454
G 2.1/4 x 11	120 x 22	25458
G 2.1/2 x 11	120 x 22	25462
G 2.3/4 x 11	120 x 22	25466
G 3" x 11	130 x 25	25470
G 3.1/2 x 11	150 x 25	25474
G 4" x 11	160 x 25	25478

**Application:
for general use**

- non abrasive material up to 800 N/mm²
- unalloyed and low alloyed steel

**Applicazione:
per uso universale**

- Materiali con buona truciabilità fino a R 800 N/mm²
- Acciaio non legati e scarsamente legati



tapered pipe thread, taper 1:16, con. 55°

filettatura conica per tubi, cono 1:16

R (BSPT)

[illegible]



Round Dies VS

armoured tube thread DIN 40 430

Filiere tonde VS

filettatura per tubi corazzati DIN 40 430



DIN 40434

HSS

PG

Nominal Diameter	Ø o / d	Art.-No.
PG 7 x 20	38 x 10	25807
PG 9 x 18	45 x 14	25809
PG 11 x 18	45 x 14	25811
PG 13.5 x 18	45 x 14	25813
PG 16 x 18	55 x 16	25816
PG 21 x 16	65 x 18	25821
PG 29 x 16	65 x 18	25829
PG 36 x 16	90 x 22	25836
PG 42 x 16	105 x 22	25842
PG 48 x 16	105 x 22	25848

Application: for general use

- non abrasive material up to 800 N/mm²
- unalloyed and low alloyed steel

Applicazione: per uso universale

- Materiali con buona truciabilità fino a R 800 N/mm²
- Acciaio non legati e scarsamente legati

**Round Dies VS**

american tapered pipe thread, taper 1:16

Filiere tonde VS

filettatura americana conica per tubi, cono 1:16

**HSS****NPT / NPTF**

Nominal Diameter		Ø	Art.-No.	
		o / d		
NPT				
NPT	1/16 x 27	25 x 9	23610	
NPT	1/8 x 27	30 x 11	23612	
NPT	1/4 x 18	38 x 14	23614	
NPT	3/8 x 18	45 x 14	23616	
NPT	1/2 x 14	45 x 18	23618	
NPT	5/8 x 14	55 x 22	23620	
NPT	3/4 x 14	55 x 22	23622	
NPT	7/8 x 14	65 x 25	23624	
NPT	1" x 11.5	65 x 25	23626	
NPT	1.1/4 x 11.5	75 x 26	23634	
NPT	1.1/2 x 11.5	90 x 27	23642	
NPT	2" x 11.5	105 x 28	23654	
NPTF				
NPTF	1/8 x 27	50 x 11	Form A	98072
NPTF	1/4 x 18	50 x 14	Form A	98074
NPTF	3/8 x 18	50 x 14	Form A	98076
NPTF	1/2 x 14	50 x 18	Form A	98078
NPTF	3/4 x 14	50 x 22	Form A	98080
NPTF	1" x 11.5	50 x 25	Form A	98082

**Application:
for general use**

- non abrasive material up to 800 N/mm²
- unalloyed and low alloyed steel

**Applicazione:
per uso universale**

- Materiali con buona truciabilità fino a R 800 N/mm²
- Acciaio non legati e scarsamente legati



Round Dies VS

Cycle thread DIN 79012 and BS 811

Filiere tonde VS

filettatura per biciclette DIN 79012 e BS 811



DIN 223 (DIN EN 22568)

HSS

Tol. med.

FG / BSC

Nominal Diameter	Ø o / d	Art.-No.
FG (DIN 79012)		
FG 2 x 56	16 x 5	79301
FG 2.3 x 56	16 x 5	79302
FG 2.6 x 56	16 x 5	79303
FG 6.35 x 26	20 x 7	79304
FG 7.9 x 26	25 x 9	79305
FG 9.5 x 26	30 x 11	79306
FG 14.3 x 20	38 x 10	79307
FG 14.3 x 20 - LH	38 x 10	79308
FG 25.4 x 24	55 x 16	79309
BSC (BS 811)		
BSC 1/4 x 26	20 x 7	79320
BSC 5/16 x 26	25 x 9	79321
BSC 3/8 x 26	30 x 11	79322
BSC 9/16 x 20	38 x 10	79323
BSC 9/16 x 20 - LH	38 x 10	79324
BSC 1" x 24	55 x 16	79325

Application: for general use

- non abrasive material up to 800 N/mm²
- unalloyed and low alloyed steel

Applicazione: per uso universale

- Materiali con buona truciabilità fino a R 800 N/mm²
- Acciaio non legati e scarsamente legati

**Round Dies VS**

Valve thread DIN 7756

Filiere tonde VS

filettatura per valvole DIN 7756

**DIN 223 (DIN EN 22568)****HSS****Tol. med.****Vg**

Nominal Diameter	Ø o / d	Art.-No.
VG 5 x 36	20 x 7	79330
VG 5.2 x 24	20 x 7	79331
VG 6 x 32	20 x 7	79332
VG 8 x 32	25 x 9	79333
VG 10 x 28	30 x 11	79334
VG 12 x 26	30 x 11	79335

**Application:
for general use**

- non abrasive material up to 800 N/mm²
- unalloyed and low alloyed steel

**Applicazione:
per uso universale**

- Materiali con buona truciabilità fino a R 800 N/mm²
- Acciaio non legati e scarsamente legati



Round Dies **VE**

gun nosed
metric ISO-thread DIN 13

Filiere tonde **VE**

con imbocco corretto
filettatura metrica ISO DIN 13



DIN 223 (DIN EN 22568)

HSS-E

Tol. 6g

M

Nominal Diameter mm	Ø o / d	Art.-No.
M 3 x 0.5	20 x 5	57426
M 4 x 0.7	20 x 5	57430
M 5 x 0.8	20 x 7	57434
M 6 x 1.0	20 x 7	57438
M 8 x 1.25	25 x 9	57442
M 10 x 1.5	30 x 11	57446
M 12 x 1.75	38 x 14	57450
M 14 x 2.0	38 x 14	57454
M 16 x 2.0	45 x 18	57458
M 18 x 2.5	45 x 18	57462
M 20 x 2.5	45 x 18	57466
M 22 x 2.5	55 x 22	57470
M 24 x 3.0	55 x 22	57474
M 27 x 3.0	65 x 25	57476
M 30 x 3.5	65 x 25	57478

Benefit:

- high cutting ability
- reduction of torque
- uninterrupted swarf flow in direction of feed
- prevents jamming of swarf

Application:

- abrasive material up to 1200 N/mm
- INOX (stainless steel)
- and general use

Vantaggio:

- elevata durata
- taglio più facile
- libero scarico del truciolo dal davanti
- nessun intasamento dei lobi di evacuazione del truciolo

Applicazione:

- materiali di difficile truciolabilità
- Acciaio inossidabili
- e per uso universale



Round Dies VE

gun nosed
metric-fine ISO-thread DIN 13

Filiere tonde VE

con imbocco corretto
filettatura metrica fine ISO DIN 13



DIN 223 (DIN EN 22568)

HSS-E

Tol. 6g

Mf

Nominal Diameter mm	Ø o / d	Art.-No.
M 6 x 0.75	20 x 7	56418
M 8 x 0.75	25 x 9	56424
M 8 x 1.0	25 x 9	56426
M 10 x 1.0	30 x 11	56436
M 10 x 1.25	30 x 11	56438
M 12 x 1.0	38 x 10	56444
M 12 x 1.25	38 x 10	56446
M 12 x 1.5	38 x 10	56448
M 14 x 1.25	38 x 10	56454
M 14 x 1.5	38 x 10	56456
M 16 x 1.5	45 x 14	56466
M 18 x 1.5	45 x 14	56472
M 18 x 2.0	45 x 14	56474
M 20 x 1.5	45 x 14	56484
M 20 x 2.0	45 x 14	56486
M 22 x 1.5	55 x 16	56494
M 24 x 1.5	55 x 16	56604

Benefit:

- high cutting ability
- reduction of torque
- uninterrupted swarf flow in direction of feed
- prevents jamming of swarf

Application:

- abrasive material up to 1200 N/mm
- INOX (stainless steel)
- and general use

Vantaggio:

- elevata durata
- taglio più facile
- libero scarico del truciolo dal davanti
- nessun intasamento dei lobi di evacuazione del truciolo

Applicazione:

- materiali di difficile truciolabilità
- Acciaio inossidabili
- e per uso universale



Round Dies VE

gun nosed

Pipe-thread DIN ISO 228

Filiere tonde VE

con imbocco corretto

filettatura per tubi gas DIN ISO 228



DIN 5158 (DIN EN 24231)

HSS-E

Tol. A

G (BSP)

Nominal Diameter	Ø o / d	Art.-No.
G 1/8 x 28	30 x 11	55412
G 1/4 x 19	38 x 10	55414
G 3/8 x 19	45 x 14	55416
G 1/2 x 14	45 x 14	55418
G 3/4 x 14	55 x 16	55422
G 1" x 11	65 x 18	55426

Benefit:

- high cutting ability
- reduction of torque
- uninterrupted swarf flow in direction of feed
- prevents jamming of swarf

Application:

- abrasive material up to 1200 N/mm²
- INOX (stainless steel)
- and general use

Vantaggio:

- elevata durata
- taglio più facile
- libero scarico del truciolo dal davanti
- nessun intasamento dei lobi di evacuazione del truciolo

Applicazione:

- materiali di difficile truciolabilità
- Acciaio inossidabili
- e per uso universale



Round Dies VX

gun nosed, lapped and steam-tempered
metric ISO-thread DIN 13



Filiere tonde VX

con imbocco corretto, lappate e vaporizzate
filettatura metrica ISO DIN 13

DIN 223 (DIN EN 22568)

HSSE-VAP

Tol. 6g

M

Nominal Diameter	Ø o / d	Art.-No.
M 3 x 0.5	20 x 5	57826
M 4 x 0.7	20 x 5	57830
M 5 x 0.8	20 x 7	57834
M 6 x 1.0	20 x 7	57838
M 8 x 1.25	25 x 9	57842
M 10 x 1.5	30 x 11	57846
M 12 x 1.75	38 x 14	57850
M 14 x 2.0	38 x 14	57854
M 16 x 2.0	45 x 18	57858
M 18 x 2.5	45 x 18	57862
M 20 x 2.5	45 x 18	57866
M 22 x 2.5	55 x 22	57870
M 24 x 3.0	55 x 22	57874
M 27 x 3.0	65 x 25	57876
M 30 x 3.5	65 x 25	57878

Application:

- alloyed, tough-hard material up to 1.200 N/mm²
 - stainless steel
 - aluminium cast
 - spheroidal graphite cast iron (GGG)
 - as well as for general use
- for thread cutting by hand and machine

Advantages:

- high cutting ability
 - reduction of torque
 - uninterrupted swarf flow in direction of feed
 - prevents jamming of swarf
- Steam tempered and hence optimal adhesion of the cutting oil

Applicazione:

- materiali teneri legati fino a 1.200 N/mm²
 - acciai inossidabili
 - alluminio fuso
 - ghisa sferoidale (GGG)
 - per uso universale
- per uso a mano e macchina

Vantaggi:

- elevata durata
 - taglio più facile
 - libero scarico del truciolo dal davanti
 - nessun intasamento dello scarico dei trucioli
- Vaporizzato che garantisce una ottimale aderenza del lubrificante



Round Dies VX

gun nosed, lapped and steam-tempered
metric-fine ISO-thread DIN 13

Filiere tonde VX

con imbocco corretto, lappate e vaporizzate
filettatura metrica fine ISO DIN 13



DIN 223 (DIN EN 22568)

HSSE-VAP

Tol. 6g

Mf

Nominal Diameter	Ø o / d	Art.-No.
Mf 4 x 0.5	20 x 5	56806
Mf 5 x 0.5	20 x 5	56808
Mf 6 x 0.5	20 x 5	56811
Mf 6 x 0.75	20 x 7	56812
Mf 7 x 0.75	25 x 9	56814
Mf 8 x 0.5	25 x 9	56815
Mf 8 x 0.75	25 x 9	56816
Mf 8 x 1.0	25 x 9	56817
Mf 9 x 0.5	25 x 9	56818
Mf 9 x 0.75	25 x 9	56819
Mf 9 x 1.0	25 x 9	56820
Mf 10 x 0.5	30 x 11	56821
Mf 10 x 0.75	30 x 11	56822
Mf 10 x 1.0	30 x 11	56823
Mf 10 x 1.25	30 x 11	56824
Mf 11 x 1.0	30 x 11	56825
Mf 11 x 1.25	30 x 11	56826
Mf 12 x 0.5	38 x 10	56827
Mf 12 x 0.75	38 x 10	56828
Mf 12 x 1.0	38 x 10	56829
Mf 12 x 1.25	38 x 10	56830
Mf 12 x 1.5	38 x 10	56831
Mf 14 x 0.5	38 x 10	56836
Mf 14 x 0.75	38 x 10	56837
Mf 14 x 1.0	38 x 10	56838
Mf 14 x 1.25	38 x 10	56839
Mf 14 x 1.5	38 x 10	56840
Mf 15 x 0.75	38 x 10	56841
Mf 15 x 1.0	38 x 10	56842
Mf 15 x 1.5	38 x 10	56843
Mf 16 x 0.5	45 x 14	56844
Mf 16 x 0.75	45 x 14	56845
Mf 16 x 1.0	45 x 14	56846
Mf 16 x 1.25	45 x 14	56847
Mf 16 x 1.5	45 x 14	56848
Mf 17 x 1.0	45 x 14	56849
Mf 17 x 1.5	45 x 14	56850
Mf 18 x 0.5	45 x 14	56851
Mf 18 x 0.75	45 x 14	56852
Mf 18 x 1.0	45 x 14	56853
Mf 18 x 1.25	45 x 14	56854
Mf 18 x 1.5	45 x 14	56855
Mf 18 x 2.0	45 x 14	56856
Mf 20 x 0.5	45 x 14	56859
Mf 20 x 0.75	45 x 14	56860
Mf 20 x 1.0	45 x 14	56861
Mf 20 x 1.25	45 x 14	56862
Mf 20 x 1.5	45 x 14	56863
Mf 20 x 2.0	45 x 14	56864
Mf 22 x 0.5	55 x 16	56867







Round Dies VX

gun nosed, lapped and steam-tempered
Pipe-thread DIN ISO 228

Filiere tonde VX

con imbocco corretto, lappate e vaporizzate
filettatura per tubi gas DIN ISO 228



DIN 5158 (DIN EN 24231)

HSSE-VAP

G (BSP)

Nominal Diameter	Ø o / d	Art.-No.
G 1/8 x 28	30 x 11	55612
G 1/4 x 19	38 x 10	55614
G 3/8 x 19	45 x 14	55616
G 1/2 x 14	45 x 14	55618
G 3/4 x 14	55 x 16	55622
G 1" x 11	65 x 18	55626

Application:

- alloyed, tough-hard material up to 1.200 N/mm²
 - stainless steel
 - aluminium cast
 - spheroidal graphite cast iron (GGG)
 - as well as for general use
- for thread cutting by hand and machine

Advantages:

- high cutting ability
 - reduction of torque
 - uninterrupted swarf flow in direction of feed
 - prevents jamming of swarf
- Steam tempered and hence optimal adhesion of the cutting oil

Applicazione:

- materiali teneri legati fino a 1.200 N/mm²
 - acciai inossidabili
 - alluminio fuso
 - ghisa sferoidale (GGG)
 - per uso universale
- per uso a mano e macchina

Vantaggi:

- elevata durata
 - taglio più facile
 - libero scarico del truciolo dal davanti
 - nessun intasamento dello scarico dei trucioli
- Vaporizzato che garantisce una ottimale aderenza del lubrificante



Round Dies MS

gun nosed, lapped
metric ISO-thread DIN 13

Filiere tonde MS

con imbocco corretto, lappate
filettatura metrica ISO DIN 13



DIN 223 (DIN EN 22568)

HSS

Tol. 6g

M

Nominal Diameter	Ø o / d	Art.-No.
M 3 x 0.5	20 x 5	57226
M 4 x 0.7	20 x 5	57230
M 5 x 0.8	20 x 7	57234
M 6 x 1.0	20 x 7	57238
M 8 x 1.25	25 x 9	57242
M 10 x 1.5	30 x 11	57246
M 12 x 1.75	38 x 14	57250
M 14 x 2.0	38 x 14	57254
M 16 x 2.0	45 x 18	57258
M 18 x 2.5	45 x 18	57262
M 20 x 2.5	45 x 18	57266
M 22 x 2.5	55 x 22	57270
M 24 x 3.0	55 x 22	57274
M 27 x 3.0	65 x 25	57276
M 30 x 3.5	65 x 25	57278

Application:

- optimised for machining of brass
- short-chipping bronze
- short-chipping material up to 800 N/mm²

Advantages:

- reduction of torque
- uninterrupted swarf flow in direction of feed
- prevents jamming of swarf

Applicazione:

- ottimizzato per la lavorazione dell'ottone
- per il bronzo a truciolo corto
- materiali a truciolo corto fino a 800 N/mm²

Vantaggi:

- taglio più facile
- libero scarico del truciolo dal davanti
- nessun intasamento dello scarico dei trucioli



Round Dies MS

gun nosed, lapped
metric-fine ISO-thread DIN 13

Filiere tonde MS

con imbocco corretto, lappate
filettatura metrica fine ISO DIN 13


DIN 223 (DIN EN 22568)
HSS
Tol. 6g
Mf

Nominal Diameter		Ø o / d	Art.-No.
Mf	4 x 0.5	20 x 5	56206
Mf	5 x 0.5	20 x 5	56208
Mf	6 x 0.5	20 x 5	56211
Mf	6 x 0.75	20 x 7	56212
Mf	7 x 0.75	25 x 9	56214
Mf	8 x 0.5	25 x 9	56215
Mf	8 x 0.75	25 x 9	56216
Mf	8 x 1.0	25 x 9	56217
Mf	9 x 0.5	25 x 9	56218
Mf	9 x 0.75	25 x 9	56219
Mf	9 x 1.0	25 x 9	56220
Mf	10 x 0.5	30 x 11	56221
Mf	10 x 0.75	30 x 11	56222
Mf	10 x 1.0	30 x 11	56223
Mf	10 x 1.25	30 x 11	56224
Mf	11 x 1.0	30 x 11	56225
Mf	11 x 1.25	30 x 11	56226
Mf	12 x 0.5	38 x 10	56227
Mf	12 x 0.75	38 x 10	56228
Mf	12 x 1.0	38 x 10	56229
Mf	12 x 1.25	38 x 10	56230
Mf	12 x 1.5	38 x 10	56231
Mf	14 x 0.5	38 x 10	56236
Mf	14 x 0.75	38 x 10	56237
Mf	14 x 1.0	38 x 10	56238
Mf	14 x 1.25	38 x 10	56239
Mf	14 x 1.5	38 x 10	56240
Mf	15 x 0.75	38 x 10	56241
Mf	15 x 1.0	38 x 10	56242
Mf	15 x 1.5	38 x 10	56243
Mf	16 x 0.5	45 x 14	56244
Mf	16 x 0.75	45 x 14	56245
Mf	16 x 1.0	45 x 14	56246
Mf	16 x 1.25	45 x 14	56247
Mf	16 x 1.5	45 x 14	56248
Mf	17 x 1.0	45 x 14	56249
Mf	17 x 1.5	45 x 14	56250
Mf	18 x 0.5	45 x 14	56251
Mf	18 x 0.75	45 x 14	56252
Mf	18 x 1.0	45 x 14	56253
Mf	18 x 1.25	45 x 14	56254
Mf	18 x 1.5	45 x 14	56255
Mf	18 x 2.0	45 x 14	56256
Mf	20 x 0.5	45 x 14	56259
Mf	20 x 0.75	45 x 14	56260
Mf	20 x 1.0	45 x 14	56261
Mf	20 x 1.25	45 x 14	56262
Mf	20 x 1.5	45 x 14	56263
Mf	20 x 2.0	45 x 14	56264
Mf	22 x 0.5	55 x 16	56267





Round Dies MS

gun nosed, lapped
Pipe-thread DIN ISO 228

Filiere tonde MS

con imbocco corretto, lappate
filettatura per tubi gas DIN ISO 228



DIN 5158 (DIN EN 24231)

HSS

G (BSP)

Nominal Diameter	Ø o / d	Art.-No.
G 1/8 x 28	30 x 11	55212
G 1/4 x 19	38 x 10	55214
G 3/8 x 19	45 x 14	55216
G 1/2 x 14	45 x 14	55218
G 3/4 x 14	55 x 16	55222
G 1" x 11	65 x 18	55226

Application:

- optimised for machining of brass
- short-chipping bronze
- short-chipping material up to 800 N/mm²

Advantages:

- reduction of torque
- uninterrupted swarf flow in direction of feed
- prevents jamming of swarf

Applicazione:

- ottimizzato per la lavorazione dell'ottone
- per il bronzo a truciolo corto
- materiali a truciolo corto fino a 800 N/mm²

Vantaggi:

- taglio più facile
- libero scarico del truciolo dal davanti
- nessun intasamento dello scarico dei trucioli



Round Dies VS

Left Hand

metric ISO-thread DIN 13

Filiere tonde VS

filetto sinistro

filettatura metrica ISO DIN 13

**DIN 223 (DIN EN 22568)****HSS****Tol. 6g****M**

Nominal Diameter mm	Ø o / d	Art.-No.
M 2 x 0.4	16 x 5	27216
M 3 x 0.5	20 x 5	27226
M 4 x 0.7	20 x 5	27230
M 5 x 0.8	20 x 7	27234
M 6 x 1.0	20 x 7	27238
M 8 x 1.25	25 x 9	27242
M 10 x 1.5	30 x 11	27246
M 12 x 1.75	38 x 14	27250
M 14 x 2.0	38 x 14	27254
M 16 x 2.0	45 x 18	27258
M 18 x 2.5	45 x 18	27262
M 20 x 2.5	45 x 18	27266
M 22 x 2.5	55 x 22	27270
M 24 x 3.0	55 x 22	27274
M 27 x 3.0	65 x 25	27276
M 30 x 3.5	65 x 25	27278
M 33 x 3.5	65 x 25	27280
M 36 x 4.0	65 x 25	27282
M 39 x 4.0	75 x 30	27284
M 42 x 4.5	75 x 30	27286
M 45 x 4.5	90 x 36	27288
M 48 x 5.0	90 x 36	27290
M 52 x 5.0	90 x 36	27292

Application:**for general use**

- non abrasive material up to 800 N/mm²
- unalloyed and low alloyed steel

Applicazione:**per uso universale**

- Materiali con buona truciabilità fino a R 800 N/mm²
- Acciaio non legati e scarsamente legati



Round Dies VS

Left Hand

metric ISO-thread DIN 13

Filiere tonde VS

filetto sinistro

filettatura metrica ISO DIN 13



DIN 223 (DIN EN 22568)

HSS

Tol. 6g

Mf

Nominal Diameter mm	Ø o / d	Art.-No.
M 2.5 x 0.35	16 x 5	26801
M 3 x 0.35	20 x 5	26802
M 3.5 x 0.35	20 x 5	26803
M 4 x 0.35	20 x 5	26804
M 4 x 0.5	20 x 5	26805
M 4.5 x 0.5	20 x 5	26806
M 5 x 0.5	20 x 5	26807
M 5 x 0.75	20 x 7	26808
M 5.5 x 0.5	20 x 5	26809
M 6 x 0.5	20 x 5	26810
M 6 x 0.75	20 x 7	26207
M 7 x 0.5	25 x 9	26811
M 7 x 0.75	25 x 9	26812
M 8 x 0.5	25 x 9	26813
M 8 x 0.75	25 x 9	26210
M 8 x 1.0	25 x 9	26211
M 9 x 0.5	25 x 9	26814
M 9 x 0.75	25 x 9	26815
M 9 x 1.0	25 x 9	26816
M 10 x 0.5	30 x 11	26817
M 10 x 0.75	30 x 11	26818
M 10 x 1.0	30 x 11	26215
M 10 x 1.25	30 x 11	26216
M 11 x 1.0	30 x 11	26819
M 11 x 1.25	30 x 11	26820
M 12 x 0.5	38 x 10	26821
M 12 x 0.75	38 x 10	26822
M 12 x 1.0	38 x 10	26220
M 12 x 1.25	38 x 10	26221
M 12 x 1.5	38 x 10	26222
M 13 x 0.5	38 x 10	26823
M 13 x 0.75	38 x 10	26824
M 13 x 1.0	38 x 10	26825
M 13 x 1.5	38 x 10	26826
M 14 x 0.5	38 x 10	26827
M 14 x 0.75	38 x 10	26828
M 14 x 1.0	38 x 10	26829
M 14 x 1.25	38 x 10	26227
M 14 x 1.5	38 x 10	26228
M 15 x 0.75	38 x 10	26830
M 15 x 1.0	38 x 10	26831
M 15 x 1.5	38 x 10	26832
M 16 x 0.75	45 x 14	26833
M 16 x 1.0	45 x 14	26231
M 16 x 1.25	45 x 14	26834
M 16 x 1.5	45 x 14	26233

Application:

for general use

- non abrasive material up to 800 N/mm²
- unalloyed and low alloyed steel

Applicazione:

per uso universale

- Materiali con buona trucidibilità fino a R 800 N/mm²
- Acciaio non legati e scarsamente legati



Round Dies VS

Left Hand

metric ISO-thread DIN 13

Filiere tonde VS

filetto sinistro

filettatura metrica ISO DIN 13

DIN 223 (DIN EN 22568)

HSS

Tol. 6g

Mf

Nominal Diameter	Ø o / d	Art.-No.
M 17 x 1.0	45 x 14	26835
M 17 x 1.5	45 x 14	26836
M 18 x 0.75	45 x 14	26837
M 18 x 1.0	45 x 14	26838
M 18 x 1.25	45 x 14	26839
M 18 x 1.5	45 x 14	26236
M 18 x 2.0	45 x 14	26840
M 19 x 1.0	45 x 14	26841
M 19 x 1.5	45 x 14	26842
M 20 x 0.5	45 x 14	26843
M 20 x 0.75	45 x 14	26844
M 20 x 1.0	45 x 14	26845
M 20 x 1.25	45 x 14	26846
M 20 x 1.5	45 x 14	26240
M 20 x 2.0	45 x 14	26847
M 21 x 1.0	45 x 14	26848
M 21 x 1.5	45 x 14	26849
M 22 x 1.0	55 x 16	26850
M 22 x 1.25	55 x 16	26851
M 22 x 1.5	55 x 16	26245
M 22 x 2.0	55 x 16	26852
M 24 x 1.25	55 x 16	26853
M 24 x 1.5	55 x 16	26250
M 24 x 2.0	55 x 16	26251
M 25 x 1.0	55 x 16	26854
M 25 x 1.5	55 x 16	26855
M 26 x 1.0	55 x 16	26856
M 26 x 1.5	55 x 16	26857
M 26 x 2.0	55 x 16	26858
M 27 x 1.0	65 x 18	26859
M 27 x 1.5	65 x 18	26860
M 27 x 2.0	65 x 18	26861
M 28 x 1.0	65 x 18	26862
M 28 x 1.5	65 x 18	26863
M 28 x 2.0	65 x 18	26864
M 29 x 1.5	65 x 18	26865
M 30 x 1.0	65 x 18	26866
M 30 x 1.5	65 x 18	26867
M 30 x 2.0	65 x 18	26264
M 30 x 2.5	65 x 18	26265
M 30 x 3.0	65 x 25	26266
M 32 x 1.0	65 x 18	26267
M 32 x 1.5	65 x 18	26268
M 32 x 2.0	65 x 18	26269
M 32 x 3.0	65 x 25	26270
M 33 x 1.5	65 x 18	26271

Application:

for general use

- non abrasive material up to 800 N/mm²
- unalloyed and low alloyed steel

Applicazione:

per uso universale

- Materiali con buona truciabilità fino a R 800 N/mm²
- Acciaio non legati e scarsamente legati





Round Dies VS

Left Hand

metric ISO-thread DIN 13

Filiere tonde VS

filetto sinistro

filettatura metrica ISO DIN 13



DIN 223 (DIN EN 22568)

HSS

Tol. 6g

Mf

Nominal Diameter	Ø o / d	Art.-No.
M 33 x 2.0	65 x 18	26272
M 33 x 3.0	65 x 25	26273
M 34 x 1.0	65 x 18	26274
M 34 x 1.5	65 x 18	26275
M 34 x 2.0	65 x 18	26276
M 35 x 1.0	65 x 18	26277
M 35 x 1.5	65 x 18	26278
M 35 x 2.0	65 x 18	26279
M 36 x 1.0	65 x 18	26280
M 36 x 1.5	65 x 18	26281
M 36 x 2.0	65 x 18	26282
M 36 x 3.0	65 x 25	26283
M 37 x 1.5	65 x 18	26284
M 38 x 1.0	75 x 20	26285
M 38 x 1.5	75 x 20	26286
M 38 x 2.0	75 x 20	26287
M 38 x 3.0	75 x 30	26288
M 39 x 1.5	75 x 20	26289
M 39 x 2.0	75 x 20	26290
M 39 x 3.0	75 x 30	26291
M 40 x 1.0	75 x 20	26292
M 40 x 1.5	75 x 20	26293
M 40 x 2.0	75 x 20	26294
M 40 x 3.0	75 x 30	26295
M 42 x 1.0	75 x 20	26296
M 42 x 1.5	75 x 20	26297
M 42 x 2.0	75 x 20	26298
M 42 x 3.0	75 x 30	26299
M 44 x 1.5	90 x 22	26868
M 45 x 1.5	90 x 22	26869
M 45 x 2.0	90 x 22	26870
M 45 x 3.0	90 x 36	26871
M 46 x 1.5	90 x 22	26872
M 48 x 1.5	90 x 22	26873
M 48 x 2.0	90 x 22	26874
M 48 x 3.0	90 x 36	26875
M 50 x 1.5	90 x 22	26876
M 50 x 2.0	90 x 22	26877
M 50 x 3.0	90 x 36	26878
M 52 x 1.5	90 x 22	26879
M 52 x 2.0	90 x 22	26880
M 52 x 3.0	90 x 36	26881

Application:

for general use

- non abrasive material up to 800 N/mm²
- unalloyed and low alloyed steel

Applicazione:

per uso universale

- Materiali con buona truciabilità fino a R 800 N/mm²
- Acciaio non legati e scarsamente legati





Round Dies VS

Left Hand

Unified thread ANSI B 1.1

Filiere tonda VS

filetto sinistro

filettatura unificata ANSI B1.1



DIN 223 (DIN EN 22568)

HSS

Tol. 2A

UNC / UNF

Nominal Diameter mm	Width across flats mm	Art.-No.
UNC		
UNC Nr. 6 x 32	20 x 7	23206
UNC Nr. 8 x 32	20 x 7	23208
UNC Nr. 10 x 24	20 x 7	23210
UNC 1/4 x 20	20 x 7	23214
UNC 5/16 x 18	25 x 9	23216
UNC 3/8 x 16	30 x 11	23218
UNC 7/16 x 14	38 x 14	23220
UNC 1/2 x 13	38 x 14	23222
UNC 9/16 x 12	38 x 14	23224
UNC 5/8 x 11	45 x 18	23226
UNC 3/4 x 10	45 x 18	23230
UNC 7/8 x 9	55 x 22	23234
UNC 1" x 8	55 x 22	23238
UNF		
UNF Nr. 10 x 32	20 x 7	24210
UNF 1/4 x 28	20 x 7	24214
UNF 5/16 x 24	25 x 9	24216
UNF 3/8 x 24	30 x 11	24218
UNF 7/16 x 20	30 x 11	24220
UNF 1/2 x 20	38 x 10	24222
UNF 9/16 x 18	38 x 10	24224
UNF 5/8 x 18	45 x 14	24226
UNF 3/4 x 16	45 x 14	24230
UNF 7/8 x 14	55 x 16	24234
UNF 1" x 12	55 x 16	24238

Application:

for general use

- non abrasive material up to 800 N/mm²
- unalloyed and low alloyed steel

Applicazione:

per uso universale

- Materiali con buona truciabilità fino a R 800 N/mm²
- Acciaio non legati e scarsamente legati





Hexagon Die Nuts VS

metric ISO-thread DIN 13

Filiere esagonali VS

filettatura metrica ISO DIN 13



DIN 382

HSS

Tol. 6g

M

Nominal Diameter mm	Width across flats mm	Art.-No.
M 3 x 0.5	19 x 5	27126
M 3.5 x 0.6	19 x 5	27128
M 4 x 0.7	19 x 5	27130
M 5 x 0.8	19 x 7	27134
M 6 x 1.0	19 x 7	27138
M 7 x 1.0	22 x 9	27140
M 8 x 1.25	22 x 9	27142
M 9 x 1.25	22 x 9	27144
M 10 x 1.5	27 x 11	27146
M 11 x 1.5	27 x 11	27148
M 12 x 1.75	36 x 14	27150
M 14 x 2.0	36 x 14	27154
M 16 x 2.0	41 x 18	27158
M 18 x 2.5	41 x 18	27162
M 20 x 2.5	41 x 18	27166
M 22 x 2.5	50 x 22	27170
M 24 x 3.0	50 x 22	27174
M 27 x 3.0	60 x 25	27176
M 30 x 3.5	60 x 25	27178
M 33 x 3.5	60 x 25	27180
M 36 x 4.0	60 x 25	27182
M 39 x 4.0	70 x 30	27184
M 42 x 4.5	70 x 30	27186
M 45 x 4.5	85 x 36	27188
M 48 x 5.0	85 x 36	27190
M 52 x 5.0	85 x 36	27192
M 56 x 5.5	100 x 36	27194
M 60 x 5.5	100 x 36	27196
M 64 x 6.0	100 x 36	27198
M 68 x 6.0	115 x 36	27199

Application:

For cleaning and repairing damaged threads and for general use in awkward places.

Applicazione:

Per la riparazione di filetti danneggiati e in luoghi di difficile accesso

**Hexagon Die Nuts VS**

metric-fine ISO-thread DIN 13

Filiere esagonali VS

filettatura metrica fine ISO DIN 13

**DIN 382****HSS****Tol. 6g****Mf**

Nominal Diameter mm	Width across flats mm	Art.-No.
M 3 x 0.35	19 x 5	26108
M 4 x 0.35	19 x 5	26110
M 4 x 0.5	19 x 5	26112
M 5 x 0.5	19 x 5	26114
M 5 x 0.75	19 x 7	26116
M 6 x 0.5	19 x 5	26117
M 6 x 0.75	19 x 7	26118
M 7 x 0.75	22 x 9	26120
M 8 x 0.5	22 x 9	26122
M 8 x 0.75	22 x 9	26124
M 8 x 1.0	22 x 9	26126
M 9 x 0.75	22 x 9	26128
M 9 x 1.0	22 x 9	26130
M 10 x 0.75	27 x 11	26132
M 10 x 1.0	27 x 11	26136
M 10 x 1.25	27 x 11	26138
M 11 x 1.0	27 x 11	26140
M 11 x 1.25	27 x 11	26142
M 12 x 0.75	36 x 10	26143
M 12 x 1.0	36 x 10	26144
M 12 x 1.25	36 x 10	26146
M 12 x 1.5	36 x 10	26148
M 13 x 1.0	36 x 10	26150
M 13 x 1.5	36 x 10	26151
M 14 x 0.75	36 x 10	26152
M 14 x 1.0	36 x 10	26153
M 14 x 1.25	36 x 10	26154
M 14 x 1.5	36 x 10	26156
M 15 x 1.0	36 x 10	26158
M 15 x 1.5	36 x 10	26160
M 16 x 1.0	41 x 14	26162
M 16 x 1.25	41 x 14	26164
M 16 x 1.5	41 x 14	26166
M 18 x 1.0	41 x 14	26170
M 18 x 1.25	41 x 14	26171
M 18 x 1.5	41 x 14	26172
M 18 x 2.0	41 x 14	26174
M 20 x 1.0	41 x 14	26178
M 20 x 1.25	41 x 14	26180
M 20 x 1.5	41 x 14	26184
M 20 x 2.0	41 x 14	26186
M 21 x 1.5	41 x 14	26188
M 22 x 1.0	50 x 16	26190
M 22 x 1.25	50 x 16	26192
M 22 x 1.5	50 x 16	26194
M 22 x 2.0	50 x 16	26196
M 23 x 1.5	50 x 16	26198
M 24 x 1.0	50 x 16	26700
M 24 x 1.25	50 x 16	26702
M 24 x 1.5	50 x 16	26704





Hexagon Die Nuts VS

metric-fine ISO-thread DIN 13

Filiere esagonali VS

filettatura metrica fine ISO DIN 13



DIN 382

HSS

Tol. 6g

Mf

Nominal Diameter mm	Width across flats mm	Art.-No.
M 24 x 2.0	50 x 16	26706
M 25 x 1.0	50 x 16	26707
M 25 x 1.5	50 x 16	26708
M 26 x 1.0	50 x 16	26710
M 26 x 1.5	50 x 16	26712
M 26 x 2.0	50 x 16	26714
M 27 x 1.0	60 x 18	26717
M 27 x 1.5	60 x 18	26716
M 27 x 2.0	60 x 18	26718
M 28 x 1.0	60 x 18	26720
M 28 x 1.5	60 x 18	26722
M 28 x 2.0	60 x 18	26724
M 29 x 1.5	60 x 18	26726
M 30 x 1.0	60 x 18	26728
M 30 x 1.5	60 x 18	26730
M 30 x 2.0	60 x 18	26732
M 30 x 3.0	60 x 25	26734
M 32 x 1.5	60 x 18	26736
M 32 x 2.0	60 x 18	26735
M 32 x 3.0	60 x 25	26737
M 33 x 1.5	60 x 18	26738
M 33 x 2.0	60 x 18	26740
M 33 x 3.0	60 x 25	26742
M 34 x 1.5	60 x 18	26744
M 34 x 2.0	60 x 18	26746
M 35 x 1.5	60 x 18	26748
M 36 x 1.5	60 x 18	26750
M 36 x 2.0	60 x 18	26752
M 36 x 3.0	60 x 25	26754
M 38 x 1.5	70 x 20	26756
M 39 x 1.5	70 x 20	26758
M 39 x 2.0	70 x 20	26760
M 39 x 3.0	70 x 30	26762
M 40 x 1.5	70 x 20	26764
M 40 x 2.0	70 x 20	26766
M 40 x 3.0	70 x 30	26768
M 42 x 1.5	70 x 20	26770
M 42 x 2.0	70 x 20	26772
M 42 x 3.0	70 x 30	26774
M 45 x 1.5	85 x 22	26776
M 45 x 2.0	85 x 22	26778
M 45 x 3.0	85 x 36	26780
M 48 x 1.5	85 x 22	26782
M 48 x 2.0	85 x 22	26784
M 48 x 3.0	85 x 36	26786
M 50 x 1.5	85 x 22	26788
M 50 x 2.0	85 x 22	26790
M 50 x 3.0	85 x 36	26792
M 52 x 1.5	85 x 22	26794
M 52 x 2.0	85 x 22	26796
M 52 x 3.0	85 x 36	26798



Hexagon Die Nuts VS

Whitworth-thread BS 84

Filiere esagonali VS

filettatura Whitworth BS 84



DIN 382

HSS

Tol. med.

BSW / BSF

Nominal Diameter mm	Width across flats mm	Art.-No.
BSW		
BSW 1/8 x 40	19 x 5	22106
BSW 3/16 x 24	19 x 7	22110
BSW 1/4 x 20	19 x 7	22114
BSW 5/16 x 18	22 x 9	22116
BSW 3/8 x 16	27 x 11	22118
BSW 7/16 x 14	27 x 11	22120
BSW 1/2 x 12	36 x 14	22122
BSW 9/16 x 12	36 x 14	22124
BSW 5/8 x 11	41 x 18	22126
BSW 3/4 x 10	41 x 18	22130
BSW 7/8 x 9	50 x 22	22134
BSW 1" x 8	50 x 22	22138
BSW 1.1/8 x 7	60 x 25	22142
BSW 1.1/4 x 7	60 x 25	22146
BSW 1.3/8 x 6	60 x 25	22150
BSW 1.1/2 x 6	70 x 30	22154
BSW 2" x 4.1/2	85 x 36	22170
BSW 2.1/4 x 4	100 x 36	22172
BSW 2.1/2 x 4	115 x 36	22174
BSW 2.3/4 x 3.1/2	115 x 36	22176
BSW 3" x 3.1/2	115 x 36	22178
BSF		
BSF 3/16 x 32	19 x 7	22510
BSF 1/4 x 26	19 x 7	22514
BSF 5/16 x 22	22 x 9	22516
BSF 3/8 x 20	27 x 11	22518
BSF 7/16 x 18	27 x 11	22520
BSF 1/2 x 16	36 x 10	22522
BSF 9/16 x 16	36 x 10	22524
BSF 5/8 x 14	41 x 14	22526
BSF 3/4 x 12	41 x 14	22530
BSF 7/8 x 11	50 x 16	22534
BSF 1" x 10	50 x 16	22538

Application:

For cleaning and repairing damaged threads and for general use in awkward places.

Applicazione:

Per la riparazione di filetti danneggiati e in luoghi di difficile accesso



Hexagon Die Nuts VS

Whitworth-thread BS 84

Filiere esagonali VS

filettatura unificata ANSI B1.1



DIN 382

HSS

Tol. 2A

UNC / UNF

Nominal Diameter	Width across flats mm	Art.-No.
UNC		
UNC 1/4 x 20	19 x 7	23114
UNC 5/16 x 18	22 x 9	23116
UNC 3/8 x 16	27 x 11	23118
UNC 7/16 x 14	27 x 11	23120
UNC 1/2 x 13	36 x 14	23122
UNC 9/16 x 12	36 x 14	23124
UNC 5/8 x 11	41 x 18	23126
UNC 3/4 x 10	41 x 18	23130
UNC 7/8 x 9	50 x 22	23134
UNC 1" x 8	50 x 22	23138
UNC 1.1/8 x 7	60 x 25	23142
UNC 1.1/4 x 7	60 x 25	23146
UNC 1.3/8 x 6	60 x 25	23150
UNC 1.1/2 x 6	70 x 30	23154
UNF		
UNF 1/4 x 28	19 x 7	24114
UNF 5/16 x 24	22 x 9	24116
UNF 3/8 x 24	27 x 11	24118
UNF 7/16 x 20	27 x 11	24120
UNF 1/2 x 20	36 x 10	24122
UNF 9/16 x 18	36 x 10	24124
UNF 5/8 x 18	41 x 14	24126
UNF 3/4 x 16	41 x 14	24130
UNF 7/8 x 14	50 x 16	24134
UNF 1" x 12	50 x 16	24138
UNF 1.1/8 x 12	60 x 18	24142
UNF 1.1/4 x 12	60 x 18	24146
UNF 1.3/8 x 12	60 x 18	24150
UNF 1.1/2 x 12	70 x 20	24154

Application:

For cleaning and repairing damaged threads and for general use in awkward places.

Applicazione:

Per la riparazione di filetti danneggiati e in luoghi di difficile accesso

**Hexagon Die Nuts VS**

Unified thread ANSI B 1.1

Filiere esagonali VS

filettatura unificata ANSI B1.1

**DIN 382****HSS****Tol. 2A****8-UN**

Nominal Diameter	Width across flats mm	Art.-No.
UN 1.1/8 x 8	60 x 25	24171
UN 1.1/4 x 8	60 x 25	24172
UN 1.3/8 x 8	60 x 25	24173
UN 1.1/2 x 8	70 x 30	24174
UN 1.5/8 x 8	70 x 30	24175
UN 1.3/4 x 8	85 x 36	24176
UN 1.7/8 x 8	85 x 22	24177
UN 2" x 8	85 x 22	24178
UN 2.1/8 x 8	85 x 22	24179
UN 2.1/4 x 8	100 x 22	24180
UN 2.1/2 x 8	115 x 22	24181

Application:

For cleaning and repairing damaged threads and for general use in awkward places.

Applicazione:

Per la riparazione di filetti danneggiati e in luoghi di difficile accesso

Pipe-thread DIN ISO 228



Filiere esagonali VS

filettatura per tubi gas DIN ISO 228

[illegible]

Application:

For cleaning and repairing damaged threads and for general use in awkward places.

Applicazione:

Per la riparazione di filetti
danneggiati e in luoghi di difficile accesso





Hexagon Die Nuts VS

american tapered pipe thread, taper 1:16

Filiere esagonali VS

filettatura americana conica per tubi, cono 1:16



DIN 382

HSS

NPT

Nominal Diameter	Width across flats mm	Art.-No.
NPT 1/16 x 27	22 x 9	23510
NPT 1/8 x 27	27 x 11	23512
NPT 1/4 x 18	36 x 14	23514
NPT 3/8 x 18	41 x 14	23516
NPT 1/2 x 14	50 x 16	23518
NPT 3/4 x 14	60 x 18	23522
NPT 1" x 11.5	60 x 25	23526
NPT 1.1/4 x 11.5	70 x 25	23528
NPT 1.1/2 x 11.5	85 x 28	23530
NPT 2" x 11.5	100 x 28	23534

Application:

For cleaning and repairing damaged threads and for general use in awkward places.

Applicazione:

Per la riparazione di filetti danneggiati e in luoghi di difficile accesso



Hexagon Die Nuts VS

Left Hand

metric ISO-thread DIN 13

Filiere esagonali VS

filetto sinistro

filettatura metrica ISO DIN 13

**DIN 382****HSS****Tol. 6g****M**

Nominal Diameter		Width across flats mm	Art.-No.
M	3 x 0.5	19 x 5	28426
M	4 x 0.7	19 x 5	28430
M	5 x 0.8	19 x 7	28434
M	6 x 1.0	19 x 7	28438
M	8 x 1.25	22 x 9	28442
M	10 x 1.5	27 x 11	28446
M	12 x 1.75	36 x 14	28450
M	14 x 2.0	36 x 14	28454
M	16 x 2.0	41 x 18	28458
M	18 x 2.5	41 x 18	28462
M	20 x 2.5	41 x 18	28466
M	22 x 2.5	50 x 22	28470
M	24 x 3.0	50 x 22	28474
M	27 x 3.0	60 x 25	28476
M	30 x 3.5	60 x 25	28478
M	33 x 3.5	60 x 25	28480
M	36 x 4.0	60 x 25	28482
M	39 x 4.0	70 x 30	28484
M	42 x 4.5	70 x 30	28486
M	45 x 4.5	85 x 36	28488
M	48 x 5.0	85 x 36	28490
M	52 x 5.0	85 x 36	28492

Application:

For cleaning and repairing damaged threads and for general use in awkward places.

Applicazione:

Per la riparazione di filetti danneggiati e in luoghi di difficile accesso



SETS ASSORTIMENTO

HexTap	220 - 222
Hand Taps and Dies Maschi a mano e filiera	223 - 229
Hand Taps Maschi a Mano	229, 231, 236
Round Dies Filiera	230, 236
Hexagon Die Nuts Filiera esagonali	230
Short Machine Taps Maschi macchina corti	231
Machine Taps Maschi a macchina	232 - 235
Combined Taps Maschi combinati con punte	233, 237, 239
Tools with hexagon shank Utensili con attacco esagonale	237 - 241
Q.C.-Boxes Cassetta Q. C.	239 - 241
Displays Presentatore	242 - 244



because available ■ because reliable ■ because you ■

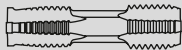
HexTap Sets

in wooden boxes

Assortimento HexTap

in cassetta di legna



	Art.-No
M	
M 3-4-5-6-8-10-12-14-16-18-20	48601
M 3-4-5-6-8-10-12-14-16-18-20-22-24	48602
M 3-4-5-6-8-10-12-14-16-18-20-22-24-27-30	48603
Mf	
M 4x0.5 - 5x0.5 - 6x0.75 - 8x0.75 - 8x1 - 10x1 M 12x1 - 12x1.5 - 14x1.25 - 14x1.5 - 16x1.5 M 18x1.5 - M 20x1.5	48605
M 4x0.5 - 5x0.5 - 6x0.75 - 8x0.75 - 8x1 - 10x1 M 12x1 - 12x1.5 - 14x1.25 - 14x1.5 - 16x1.5 M 18x1.5 - M 20x1.5 - 22x1.5 - 24x1.5	48606
G (BSP)	
G 1/8 - 1/4 - 3/8 - 1/2 - 3/4 - 1"	48608
G 1/8 - 1/4 - 3/8 - 1/2 - 3/4 - 1" - 1.1/4 - 1.1/2	48609



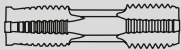

HexTap Sets

in wooden boxes

Assortimento HexTap

in cassetta di legna



 		Art.-No
M		
M 3-4-5-6-8-10-12-14-16-18-20		48621
M 3-4-5-6-8-10-12-14-16-18-20-22-24		48622
M 3-4-5-6-8-10-12-14-16-18-20-22-24-27-30		48623
Mf		
M 4x0.5 - 5x0.5 - 6x0.75 - 8x0.75 - 8x1 - 10x1		48625
M 12x1 - 12x1.5 - 14x1.25 - 14x1.5 - 16x1.5		
M 18x1.5 - M 20x1.5		
M 4x0.5 - 5x0.5 - 6x0.75 - 8x0.75 - 8x1 - 10x1		48626
M 12x1 - 12x1.5 - 14x1.25 - 14x1.5 - 16x1.5		
M 18x1.5 - M 20x1.5 - 22x1.5 - 24x1.5		
G (BSP)		
G 1/8 - 1/4 - 3/8 - 1/2 - 3/4 - 1"		48628
G 1/8 - 1/4 - 3/8 - 1/2 - 3/4 - 1" - 1.1/4 - 1.1/2		48629

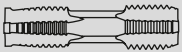

HexTap Sets

in wooden boxes

Assortimento HexTap

in cassetta di legna



 	Art.-No
M	
M 3-4-5-6-8-10-12-14-16-18-20	48641
M 3-4-5-6-8-10-12-14-16-18-20-22-24	48642
M 3-4-5-6-8-10-12-14-16-18-20-22-24-27-30	48643
Mf	
M 4x0.5 - 5x0.5 - 6x0.75 - 8x0.75 - 8x1 - 10x1	48645
M 12x1 - 12x1.5 - 14x1.25 - 14x1.5 - 16x1.5	
M 18x1.5 - M 20x1.5	
M 4x0.5 - 5x0.5 - 6x0.75 - 8x0.75 - 8x1 - 10x1	48646
M 12x1 - 12x1.5 - 14x1.25 - 14x1.5 - 16x1.5	
M 18x1.5 - M 20x1.5 - 22x1.5 - 24x1.5	
G (BSP)	
G 1/8 - 1/4 - 3/8 - 1/2 - 3/4 - 1"	48648
G 1/8 - 1/4 - 3/8 - 1/2 - 3/4 - 1" - 1.1/4 - 1.1/2	48649



Tap & Die Sets

in metal cases

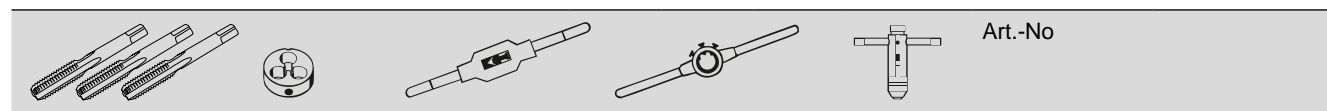
DIN standards

Utensili per filettare

in assortimento

in cassetta metallica

versione DIN



Art.-No

M

M 1-1.2-1.4-1.7-2.0-2.3-2.6	No. 0	16 x 5	20 x 5	20 x 7	No. 1	48002
M 3-3.5-4-5-6-8-10	No. 1	25 x 9	30 x 11			
M 3-4-5-6-7-8-9-10-11-12	No. 1 + 2	20 x 5	20 x 7	25 x 9	No. 1	48003
		30 x 11	38 x 14			
M 5-6-7-8-9-10-11-12	No. 1 + 2	20 x 7	25 x 9		No. 1	48004
		30 x 11	38 x 14			
M 5-6-7-8-9-10-11-12-14-16	No. 1 + 3	20 x 7	25 x 9	30 x 11		48005
M 18-20		38 x 14	45 x 18			
M 3-4-5-6-8-10-12-14-16-18-20	No. 1 + 4	20 x 5	20 x 7	25 x 9		48006
M 22-24		30 x 11	38 x 14	45 x 18		
		55 x 22				
M 5-6-8-10-12-14-16-18-20-22	No. 1	20 x 7	25 x 9	30 x 11		48007
M 24-27-30	No. 3 + 5	38 x 14	45 x 18	55 x 22		
		65 x 25				

Mf

Mf 3 x 0.35-4 x 0.5-5 x 0.5	No. 1 + 2	20 x 5	25 x 9	30 x 11	No. 1	48010
Mf 6 x 0.75-8 x 0.75-8 x 1.0		38 x 10				
Mf 10 x 1.0-12 x 1.5						
Mf 6 x 0.75-8 x 0.75-8 x 1.0-10 x 1.0	No. 1 + 3	20 x 7	25 x 9	30 x 11		48011
Mf 12 x 1.0-12 x 1.5-14 x 1.25-14 x 1.5		38 x 10	45 x 14			
Mf 16 x 1.5-18 x 1.5-20 x 1.5						
Mf 6 x 0.75-8 x 0.75-8 x 1.0-10 x 1.0	No. 1 + 4	20 x 7	25 x 9	30 x 11		48012
Mf 12 x 1.0-12 x 1.5-14 x 1.25-14 x 1.5		38 x 10	45 x 14	55 x 16		
Mf 16 x 1.5-18 x 1.5-20 x 1.5-22 x 1.5						
Mf 24 x 1.5						

Tap & Die Sets

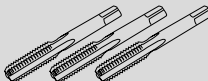

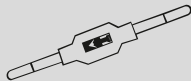


in metal cases
DIN standards

Utensili per filettare

in assortimento

in cassetta metallica
versione DIN



					Art.-No	
G (BSP)						
G 1/8-1/4-3/8-1/2-3/4-1"	No. 1 + 3 + 5	30 x 11	38 x 10	45 x 14	48020	
		55 x 16	65 x 18			
G 1/8-1/4-3/8-1/2-5/8-3/4-7/8-1"	No. 1 + 3 + 5	30 x 11	38 x 10	45 x 14	48021	
		55 x 16	65 x 18			
G 1/4-3/8-1/2-3/4-1"-1.1/4-1.1/2	No. 2 + 4 + 7	38 x 10	45 x 14	55 x 16	48022	
		65 x 18	75 x 20	90 x 22		
BSW						
BSW 1/8-3/16-1/4-5/16-3/8-7/16-1/2	No. 1 + 2	20 x 5	20 x 7	25 x 9	No. 1	48030
		30 x 11	38 x 14			
BSW 1/4-5/16-3/8-7/16-1/2	No. 1 + 2	20 x 7	25 x 9	30 x 11	No. 1	48031
		38 x 14				
BSW 1/4-5/16-3/8-7/16-1/2-5/8-3/4	No. 1 + 3	20 x 7	25 x 9	30 x 11		48032
		38 x 14	45 x 18			
BSW 1/4-5/16-3/8-7/16-1/2-5/8	No. 1 + 4	20 x 7	25 x 9	30 x 11		48034
BSW 3/4-7/8-1"		38 x 14	45 x 18	55 x 22		
BSW 1/4-5/16-3/8-7/16-1/2-5/8-3/4	No. 1	20 x 7	25 x 9	30 x 11		48035
BSW 7/8-1"-1.1/8-1.1/4-1.3/8-1.1/2"	No. 3 + 5	38 x 14	45 x 18	55 x 22		
		65 x 25				
BSF						
BSF 1/4-5/16-3/8-7/16-1/2	No. 1 + 2	20 x 7	25 x 9	30 x 11	No. 1	48041
		38 x 10				
BSF 1/4-5/16-3/8-7/16-1/2-5/8-3/4	No. 1 + 3	20 x 7	25 x 9	30 x 11		48042
		38 x 10	45 x 14			
BSF 1/4-5/16-3/8-7/16-1/2-5/8	No. 1 + 4	20 x 7	25 x 9	30 x 11		48044
BSF 3/4-7/8-1"		38 x 10	45 x 14	55 x 16		
BSW / BSF						
BSW/BSF 1/4-5/16-3/8-7/16-1/2	No. 1 + 3	20 x 7	25 x 9	30 x 11		48046
BSW/BSF 5/8-3/4		38 x 14	45 x 18			



Tap & Die Sets

in metal cases

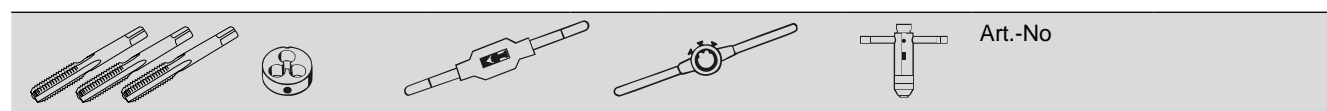
DIN standards

Utensili per filettare

in assortimento

in cassetta metallica

versione DIN



Art.-No

NPT

NPT 1/8-1/4-3/8-1/2-3/4-1"	No. 1 + 3 + 5	30 x 11	38 x 14	45 x 18		48025
		55 x 22	65 x 25			
NPT 1/8-1/4-3/8-1/2-3/4-1"	No. 2 + 4 + 7	30 x 11	38 x 14	45 x 18		48027
NPT 1.1/4-1.1/2-2"		55 x 22	65 x 25	75 x 30		
		90 x 36	105 x 36			

UNC

UNC 1/4-5/16-3/8-7/16-1/2	No. 1 + 2	20 x 7	25 x 9	30 x 11	No. 1	48050
		38 x 14				
UNC 1/4-5/16-3/8-7/16-1/2-5/8-3/4	No. 1 + 3	20 x 7	25 x 9	30 x 11		48051
		38 x 14	45 x 18			
UNC 1/4-5/16-3/8-7/16-1/2-5/8	No. 1 + 4	20 x 7	25 x 9	30 x 11		48053
UNC 3/4-7/8-1"		38 x 14	45 x 18	55 x 22		
UNC 1/4-5/16-3/8-7/16-1/2-5/8-3/4	No. 1	20 x 7	25 x 9	30 x 11		48054
UNC 7/8-1"-1.1/8-1.1/4-1.3/8-1.1/2"	No. 3 + 5	38 x 14	45 x 18	55 x 22		
		65 x 25				

UNF

UNF 1/4-5/16-3/8-7/16-1/2	No. 1 + 2	20 x 7	25 x 9	30 x 11	No. 1	48060
		38 x 10				
UNF 1/4-5/16-3/8-7/16-1/2-5/8-3/4	No. 1 + 3	20 x 7	25 x 9	30 x 11		48061
		38 x 10	45 x 14			
UNF 1/4-5/16-3/8-7/16-1/2-5/8	No. 1 + 4	20 x 7	25 x 9	30 x 11		48063
UNF 3/4-7/8-1"		38 x 10	45 x 14	55 x 16		

UNC / UNF

UNC/UNF 1/4-5/16-3/8-7/16-1/2	No. 1 + 3	20 x 7	25 x 9	30 x 11		48066
UNC/UNF 5/8-3/4		38 x 14	45 x 18			

Tap & Die Sets

in metal cases
DIN standards

Utensili per filettare

in assortimento

in cassetta metallica
versione DIN



Hand Taps DIN 352

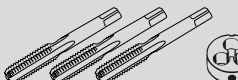

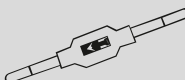








in sets of 3 pieces

Round Dies DIN 223

Maschi a mano DIN 352

Serie 3 pezzi

Filiere tonde DIN 223

											Art.-No
P.V.1	M 3-4-5-6-8	2.5/3.3/4.2/5.0	No. 1	20 x 5	20 x 7	25 x 9	No. 1	49101			
	M 10-12	6.8/8.5/10.2 mm	No. 2	30 x 11	38 x 14						
	M 3-4-5-6-8		No. 1	20 x 5	20 x 7	25 x 9		49107			
	M 10-12		No. 2	30 x 11	38 x 14						
	M 3-4-5-6-8	2.5/3.3/4.2/5.0	No. 1	20 x 5	20 x 7	25 x 9	No. 1	49151			
	M 10-12	6.8/8.5/10.2 mm	No. 2	30 x 11	38 x 14						
	M 3-4-5-6-8	2.5/3.3/4.2/5.0	No. 1	20 x 5	20 x 7	25 x 9	No. 1	49171			
	M 10-12	6.8/8.5/10.2 mm	No. 2	30 x 11	38 x 14						
	M 3-4-5-6-8	2.5/3.3/4.2/5.0	No. 1	20 x 5	20 x 7	25 x 9		49111			
	M 10-12	6.8/8.5/10.2 mm	No. 2	30 x 11	38 x 14						



Tap & Die Sets

in metal cases
DIN standards

Utensili per filettare in assortimento

in cassetta metallica
versione DIN



F.Z. 1

Hand Taps DIN 352, HSSE-VAP
[Rougher piloted](#)
Round Dies DIN 223, HSSE
+ 7 Guides for Round Dies

Maschi a mano DIN 352, HSSE-VAP
[Sgrossatore con guida](#)
Filiere DIN 223, HSSE
+ 7 guida per filiera

S.F. 1

Hand Taps DIN 352, HSS-G
Round Dies DIN 223, HSS
+ 7 Guides for Round Dies

Maschi a mano DIN 352, HSS-G
Filiere DIN 223, HSS
+ 7 guida per filiera

										Art.-No
F.Z.1	M 3-4-5-6-8	2.5/3.3/4.2/5.0	No. 1	20 x 5	20 x 7	25 x 9	No. 1	49150		
drillbox	M 10-12	6.8/8.5/10.2 mm	No. 2	30 x 11	38 x 14					
S.F.1	M 3-4-5-6-8	2.5/3.3/4.2/5.0	No. 1	20 x 5	20 x 7	25 x 9	No. 1	49106		
drillbox	M 10-12	6.8/8.5/10.2 mm	No. 2	30 x 11	38 x 14					

Tap & Die Sets

in metal cases

DIN standards

Utensili per filettare

in assortimento

in cassetta metallica

versione DIN



Hand Taps DIN 352

in sets of 3 pieces

Round Dies DIN 223

Maschi a mano DIN 352

Serie 3 pezzi

Filiere tonde DIN 223

										Art.-No
P.V.2	M 3-4-5-6-8-10-12-14	No. 1	20 x 5	20 x 7	25 x 9	No. 1	No. 2			49201
	M 16-18-20	No. 3	30 x 11	38 x 14	45 x 18					
HSSE	M 3-4-5-6-8-10-12-14	No. 1	20 x 5	20 x 7	25 x 9					49251
	M 16-18-20	No. 3	30 x 11	38 x 14	45 x 18					
LH	M 3-4-5-6-8-10-12-14	No. 1	20 x 5	20 x 7	25 x 9					49271
	M 16-18-20	No. 3	30 x 11	38 x 14	45 x 18					
P.V.3	M 5-6-8-10-12-14	No. 1	20 x 7	25 x 9	30 x 11	No. 1	No. 2			49301
	M 16-18-20	No. 3	38 x 14	45 x 18						
drill box	M 3-4-5-6-8-10-12-14	No. 1	20 x 5	20 x 7	25 x 9					49205
	M 16-18-20	No. 3	30 x 11	38 x 14	45 x 18					



Tap & Die Sets

in metal cases

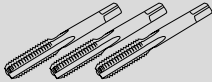
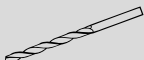
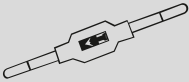

Utensili per filettare in assortimento

in cassetta metallica

Hand Taps DIN 352
in sets of 3 pieces

Maschi a mano DIN 352
Serie 3 pezzi

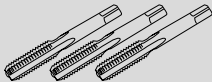

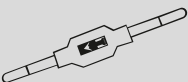




				Art.-No
P.V.22 M 3-4-5-6-8 M 10-12	2.5/3.3/4.2/5.0 6.8/8.5/10.2 mm	No. 1.1/2		49510
P.V.23 M 3-4-5-6-8 M 10-12	2.5/3.3/4.2/5.0 6.8/8.5/10.2 mm	No. 1.1/2	No. 1	49511

Hand Taps DIN 352
in sets of 3 pieces
Round Dies 25 x 9 mm ø

Maschi a mano DIN 352
Serie 3 pezzi
Filieri tonde 25 x 9 ø



					Art.-No
P.V.12 M 3-4-5-6-8-10-12		No. 1.1/2	25 x 9	No. 1	49501
P.V.15 M 3-4-5-6-8-10-12		No. 1.1/2	25 x 9	No. 1	49505





Die Sets

in metal cases
DIN standards

Utensili per filettare in assortimento

in cassetta metallica
versione DIN





			Art.-No
P.V.97	M 3-4-5-6-8-10-12		49521
P.V.98	HSSE M 3-4-5-6-8-10-12		49522
P.V.99		M 3-4-5-6-8-10-12	49520
		UNC 1/4-5/16-3/8-7/16-1/2	49530
		UNF 1/4-5/16-3/8-7/16-1/2	49540
P.V.92	o/d 25x9	M 3-4-5-6-8-10-12	49525

Round Dies DIN 223
+ 7 Guides

Filiere tonde DIN 223
+ 7 guida per filiera



			Art.-No
P.V.14	M 3-4-5-6-8-10-12	20 x 5 20 x 7 25 x 9	49599
		30 x 11 38 x 14	
LH	M 3-4-5-6-8-10-12	20 x 5 20 x 7 25 x 9	49598
		30 x 11 38 x 14	



Tap Sets

in plastic boxes

DIN standards

Utensili per filettare

in assortimento

in cassetta di plastica

versione DIN

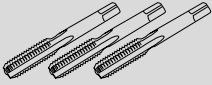
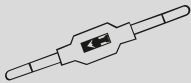

Hand Taps DIN 352

in sets of 3 pieces

Maschi a mano DIN 352

Serie 3 pezzi

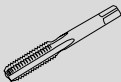

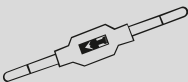



				Art.-No
P.K.20	M 3-4-5-6-8-10-12	No. 1.1/2		47001
P.K.21	M 3-4-5-6-8-10-12	No. 1.1/2	No. 1	47005
HSSE	M 3-4-5-6-8-10-12	No. 1.1/2	No. 1	47055
LH	M 3-4-5-6-8-10-12	No. 1.1/2	No. 1	47075
UNC No.5-No.8-No.10-1/4-5/16-3/8-1/2		No. 1.1/2		47033

Short Machine Taps DIN 352,
Spiral Point

Maschi a macchina corti DIN 352/B
con imbocco corretto



					Art.-No
P.K.25	M 3-4-5-6-8 M 10-12	2.5/3.3/4.2/5.0 6.8/8.5/10.2 mm	No. 1.1/2	No. 1	47605
P.K.26	M 3-4-5-6-8 M 10-12	2.5/3.3/4.2/5.0 6.8/8.5/10.2 mm	No. 1.1/2		47601



Tap & Die Sets

in plastic box
ISO standards


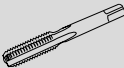

Utensili per filettare in assortimento

in cassetta di plastica

Machine Taps ISO 529
Spiral Point (Form B)

Maschi a macchina ISO 529
con imbocco corretto (Forma B)

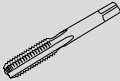


  			Art.-No
P.K.85	M 3-4-5-6-8-10	2.5/3.3/4.2/5.0/6.8/8.5	80501

Machine Taps ISO 529

Maschi a macchina ISO 529



		Art.-No
Form B	M 3-4-5-6-8-10-12	80500
Form B-AZ	M 3-4-5-6-8-10-12	80900
Form C/35°RSP	M 3-4-5-6-8-10-12	80700



Machine Tap Sets

in plastic boxes

Maschi a macchina

in cassetta di plastica


Machine Taps **HSSE**

Spiral Point and Spiral Flute

Maschi a macchina **HSSE**

con imbocco corretto + con spirale destra a 35°

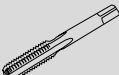


			Art.-No
P.K.40	M 3-4-5-6-8-10-12		47901
P.K.41	M 3-4-5-6-8-10-12	TIN	47921



Combined Taps **HSSE**

Maschi combinati con punte **HSSE**

			Art.-No
P.K.370	M 3-4-5-6-8-10-12		47837
P.K.700	BSW 1/8-5/32-3/16-1/4-5/16-3/8-1/2		47870



Machine Tap Sets

in plastic boxes










Maschi a macchina

in cassetta di plastica

Machine Taps **HSSE**
Spiral Point

Maschi a macchina **HSSE**
con imbocco corretto



				Art.-No
P.K.28	M 3-4-5-6-8-10-12			47815
P.K.29	M 3-4-5-6-8-10-12	TIN		47825
	M 3-4-5-6-8-10-12			47853
	M 3-4-5-6-8-10-12			47854
	M 3-4-5-6-8-10-12	TiCN		47859
	M 3-4-5-6-8-10-12			47852
P.K.35	M 3-4-5-6-8-10-12		2.5/3.3/4.2/5.0/6.8/8.5/10.2 mm	47835
P.K.36	M 3-4-5-6-8-10-12	TIN	2.5/3.3/4.2/5.0/6.8/8.5/10.2 mm	47836
	M 3-4-5-6-8-10-12	VAP	2.5/3.3/4.2/5.0/6.8/8.5/10.2 mm	47858
	M 3-4-5-6-8-10-12		2.5/3.3/4.2/5.0/6.8/8.5/10.2 mm	47856
	M 3-4-5-6-8-10-12		2.5/3.3/4.2/5.0/6.8/8.5/10.2 mm	47857
	M 3-4-5-6-8-10-12		2.5/3.3/4.2/5.0/6.8/8.5/10.2 mm	47855



Electrical Conduit Set

in plastic box

Assortimento per tubatura elettrica

in cassetta di plastica



			Art.-No
M 20x1.5 - M 25x1.5	M 20x1.5 - M 25x1.5	42 mm	18012
M 20x1.5			18002
M 25x1.5			18003

Tap Sets

in wooden boxes

DIN standards

Utensili per filettare in assortimento

in cassetta di legna

versione DIN



Hand Taps DIN 352

in sets of 3 pieces

Maschi a mano DIN 352

Serie 3 pezzi

		Art.-No
M 1-1.2-1.4-1.7 M 2.0-2.3-2.6	No. 0	48001



Combined-Bit-Set


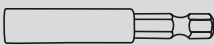
in pastic box

Assortimento di maschi a macchina combinati

in cassetta di plastica



HSS-G

				Art.-No
M	3-4-5-6-8-10		1/4"	67200
M	3-4-5-6-8-10 TIN		1/4"	67209
UNC	No.8 - No.10 - No.12 - 1/4 - 5/16 - 3/8"		1/4"	67272
UNF	No.8 - No.10 - No.12 - 1/4 - 5/16 - 3/8"		1/4"	67274

Threading-Bit-Set

with Twist-Drill-Bits in plastic box

Assortimento di maschi e punte

con attacco esagonale 1/4" in cassetta di plastica


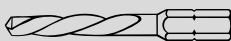
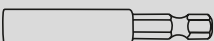


Form D

M 3-10

HSS-G

Tol. ISO2/6H

  			Art.-No
M 3-4-5-6-8-10	2.5/3.3/4.2/5.0/6.8/8.5 mm	1/4"	67020

Threading-Bit-Set

in plastic box

Assortimento di maschi con attacco esagonale 1/4"

in cassetta di plastica



Form D

M 3-10

HSS-G

Tol. ISO2/6H



Art.-No

M 3-4-5-6-8-10

67010

Drill Bit-Set

in plastic box

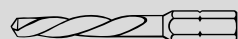
Assortimento di punte con attacco esagonale 1/4"

in cassetta di plastica



1,0 - 10,0 mm

HSS-G



Art.-No

1.0 / 1.5 / 2.0 / 2.5 / 3.0 / 3.5

4.0 / 4.5 / 5.0 / 5.5 / 6.0 / 6.5

7.0 / 7.5 / 8.0 / 8.5 / 9.0 / 9.5 / 10.0

67100

Countersink-Bit-Set

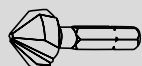
in plastic box

Assortimento di frese per svasare con attacco esagonale 1/4", in cassetta di plastica



6,3 - 20,5 mm

HSS



Art.-No

6.3/8.3/10.4/12.4/16.5/20.5

67300



Q.C. 1

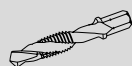
Combined Bits

Assortimento di maschi a macchina combinati



M 3 - M 10

HSS-G



M 3-4-5-6-8-10



non-magnetic
1/4"

Art.-No

67421

Q.C. 2

Threading-Bits

**Maschi
con attacco esagonale 1/4"**



M 3 - M 10

HSS-G



M 3-4-5-6-8-10



non-magnetic
1/4"



non-magnetic
1/4"

Art.-No

67422



Q.C. 3

Countersink Bits

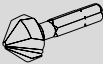
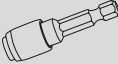

Frese per svasare

con attacco esagonale 1/4"



6,3 - 20,5 mm

HSS

			Art.-No
6.3/8.3/10.4/12.4/16.5/20.5	non-magnetic 1/4"	non-magnetic 1/4"	67423

Q.C. 4

Drill Bits




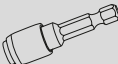
Punte

con attacco esagonale 1/4"







3,0 - 10,0 mm

HSS-G

				Art.-No
3.0/4.0/5.0/6.0/8.0/10.0	6 Bits: 2xPH1, 3xPH2, 1xPH3	6 Torx Bits: T10, T15, T20, T25, T30, T40	non-magnetic 1/4"	67424



**Q.C. 5****WOOD Drill Bits****Punte per legna**
con attacco esagonale 1/4"**3,0 - 10,0 mm****HSS-G**

				Art.-No
3.0/4.0/5.0/6.0/8.0/10.0	6 Bits: 2xPZ1, 3xPZ2, 1xPZ3	6 Torx Bits: T10, T15, T20, T25, T30, T40	magnetic 1/4"	67425

Drill Bit-Set

in plastic box

Punte con attacco esagonale 1/4"
in cassetta di plastica**3,0 - 10,0 mm****HSS-G**

		Art.-No
3.0 / 4.0 / 5.0 / 6.0 / 8.0 / 10.0	for wood / per legna 3.0 / 4.0 / 5.0 / 6.0 / 8.0 / 10,0	67101

SD 2600

Art.-No. 48926



SD 6000

Art.-No. 48960





SD 670
Art.-No. 48967



SD 3000





SD 672

Art.-No	Contents	
48980	20 Sets	67200
48981	10 Sets	67200
	10 Sets	67020
48982	10 Sets	67200
	10 Sets	67100
48983	10 Sets	67200
	10 Sets	67300





TECHNICAL INFORMATION INFORMAZIONI TECNICHE

Surface Finishes Trattamento della superficie	246
Engineering drawing of Taps Disegni tecnici di maschi	248
Leads of Hand Taps Imbocco maschi a mano	248
Engineering drawing of Dies Disegni tecnici di filiere	249
Leads of Machine Taps Imbocco maschi a macchina	249
Tolerance classes Classe di tolleranza	250
Conversion table pitch per inch into mm Tabella di conversione passo del filetto pollice a mm	250
Conversion table of tensile strength and hardness Tabella conversione resistenza e durezza	251
Conversion table of cutting speed Conversione della Velocità di taglio	252
Recommended cutting speed Velocità di taglio raccomandato	253
Conversion table inch-mm Conversione pollice-mm	254
Recommended outside diameter for bolt thread Diametri dei perni da filettare raccomandato	255
Recommended tapping drill sizes Prefori per maschi raccomandato	256 / 257



SURFACE FINISHES ACABADOS SUPEFICIALES



Each VÖLKE Tap and each VÖLKE Die can be supplied with any coating or surface finish quickly.

Ogni maschi VÖLKE e filiere VÖLKE può essere offerto con qualsiasi rivestimento o trattamenti termici breve



SURFACE FINISHES ACABADOS SUPEFICIALES

Steam Tempered:

An iron oxide film is created on the tool surface by heat treatment. This improves the adhesion of the coolant and as a result helps to prevent cold welding of the chip to the tool surface.

Vaporizzazione:

Attraverso un trattamento termico sull'utensile finito si deposita uno strato di ossido di ferro sulla superficie dell'utensile. Questo strato migliora l'aderenza del refrigerante e del lubrificante, riducendo così il rischio di rottura del film lubrificante evitando la formazione di saldature a freddo di scorie.

Nitriding:

The surface hardness is increased by enriching the surface of the tap with nitrogen. This results in high abrasion resistance and improved anti-friction properties.

Nitrurazione:

L'arricchimento della superficie del maschio con azoto permette di aumentare la durezza della superficie dell'utensile. Si ottiene altresì un miglioramento della resistenza all'abrasione e delle proprietà antifrizione.

TiN (Titanium Nitride Coating):

Following PVD processing, the tap undergoes titanium nitride vapour-deposition within the vacuum chamber at approx. 500°C. Excellent anti-friction properties and high resistance to wear and abrasion result from the reduced surface roughness and remarkable hardness. TiN coated taps can be employed using considerably faster cutting speeds.

TiN (Rivestimento al Nitrato di Titanio):

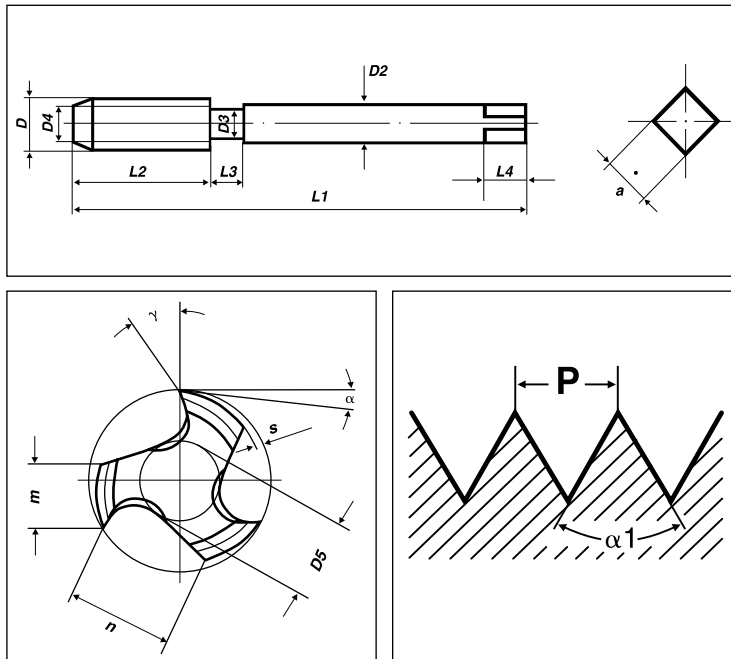
Attraverso il procedimento di metallizzazione a vuoto a 500°C ca. (PVD) viene depositato sull'utensile uno strato vaporizzato di nitrato di Titanio. La riduzione della rugosità della superficie e la durezza estrema permettono di ottenere eccellenti proprietà antifrizione e una forte resistenza all'usura e all'abrasione. I maschi rivestiti al TiN possono essere utilizzati con velocità di taglio nettamente più elevate.

TiCN (Titanium CarboNitride Coating):

The TiCN-coating is particularly suitable for wear-resistant and abrasive material. The TiCN-coating has an hardness of 3.000 HV and thus is harder as the TiN-coating (2.600 HV). As a result the TiCN-coating has an excellent wear-resistance. Also the hardness and the toughness is higher, the heat resistance is reduced. Therefore intensive and optimum cooling is essential.

TiCN (Rivestimento con carbonitrato di titanio):

Il rivestimento TiCN è particolarmente indicato per acciai ad elevata resistenza all'abrasione e materiali altamente abrasivi. Il rivestimento TiCN ha una durezza pari a 3.000 HV quindi risulta essere più duro rispetto al rivestimento TiN (2.600 HV); ciò comporta un miglioramento della resistenza all'usura dell'utensile. Una maggiore tenacità all'abrasione è contrapposta a una minore resistenza alle elevate temperature. Perciò è fondamentale una ottima refrigerazione dell'utensile rivestito.

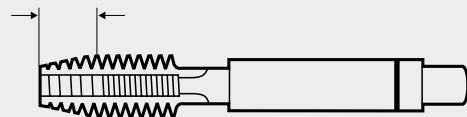


D	Nominal diameter	Diametro nominale
D2	Shank diameter	Diametro del gambo
D3	Neck diameter	Diametro dell'imbocco
D4	Point diameter	Diametro del collarino
D5	Web diameter	Diametro del nucleo
L1	Overall length	Lunghezza totale
L2	Thread length	Lunghezza filetto
L3	Neck length	Lunghezza utile
L4	Square length	Lunghezza quadro
P	Pitch	Passo
a	Square size	Quadro
m	Land width	Larghezza settore
n	Flute width	Larghezza scanalatura
s	Thread relief	Spoglia sul filetto
α	Relief angle	Angolo di spoglia sul filetto
γ	Rake angle	Angolo di taglio
α₁	Thread angle	Angolo del profilo

Leads of Hand Taps, Sets of 3 pcs.

Lunghezza di Imbocco – Maschi a mano, serie 3 pezzi

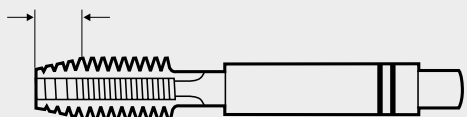
6-8 threads/spire



Nr. 1

Rougher, 6-8 Threads Lead
Sgrossatore, Imbocco a 6-8 spire

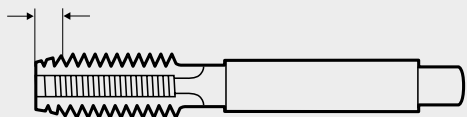
4-5 threads/spire



Nr. 2

Intermediate, 4-5 Threads Lead
Intermedio, Imbocco a 4-5 spire

2-3 threads/spire



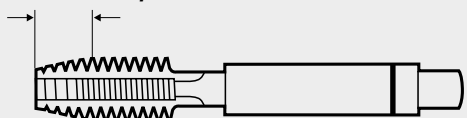
Nr. 3

Finisher, 2-3 Threads Lead
Finitore, Imbocco a 2-3 spire

Leads of Hand Taps, Sets of 2 pcs.

Orden de los machos, juegos de 2 piezas

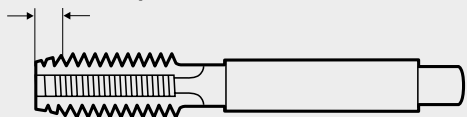
5-6 threads/spire



Nr. 1

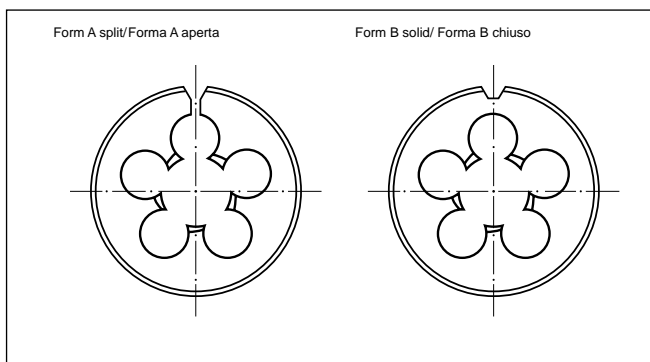
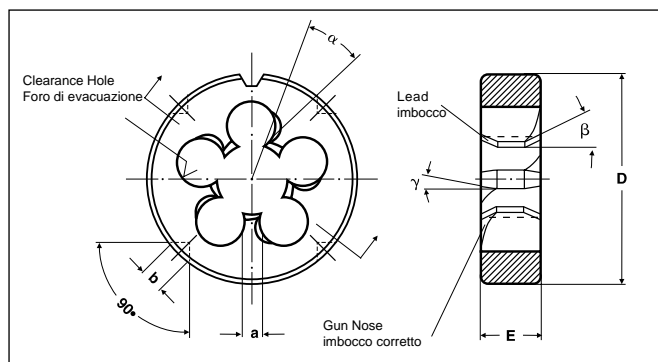
Rougher, 5-6 Threads Lead
Sgrossatore, Imbocco a 6-8 spire

2-3 threads/spire



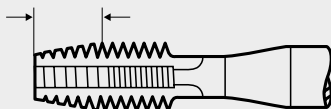
Nr. 2

Finisher, 2-3 Threads Lead
Finitore, Imbocco a 2-3 spire



D	Outside diameter	Diametro esterno
E	Width of die	Spessore
a	Width of land	Ampiezza del dente
b	Hole for holding screws	Diametro fissaggio vite
α	Rake angle	Angolo di taglio
β	Lead angle	Angolo dell'imbocco
γ	Angle of gun nose	Angolo dell'imbocco corretto

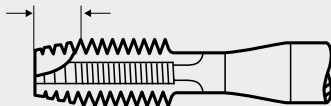
6-8 threads/spire



Form A

6-8 Threads Lead, for short through holes
Imbocco a 6-8 spire, per fori passanti corti

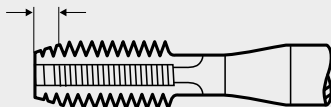
4-5 threads/spire



Form B

4-5 Threads Lead with Spiral Point for through holes
Imbocco a 4-5 spire con imbocco corretto, per tutti i fori passanti

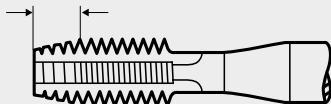
2-3 threads/spire



Form C

2-3 Threads Lead, for blind holes
Imbocco a 2-3 spire, per fori ciechi

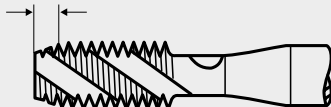
4-5 threads/spire



Form D

4-5 Threads Lead, for through and blind holes
Imbocco a 4-5 spire, per fori passante e ciechi

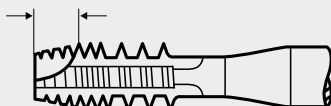
2-3 threads/spire



Form C/35° RSP

2-3 Threads Lead, 35° Spiral Flute, for blind holes
Imbocco a 2-3 spire spirale destra a 35°, per fori ciechi

4-5 threads/spire



Form B-AZ

4-5 Threads Lead with Spiral Point and interrupted threads
for through holes
Imbocco a 4-5 spire e denti alternati per fori passanti



Tolerance of the tap Classe di tolleranza del maschio		Tolerance of the nut thread Utilizzabile nel campo di tolleranza per la filettatura del dado	Explanation commento
Designation according Definizione a tenore di			
DIN 802 DIN	DIN EN 22857 ISO 2857		
4H	ISO 1	4H, 5H	undersize / Fine
6H	ISO 2	4G, 5G, 6H	standard / Normale
6G	ISO 3	6G, 7H, 8H	oversize (M12x1,5 7G = ISO2/6H + 0,03 mm) tolleranza maggiorata (p.es. a M 12x1,5-6G = ca. + 0,03 mm, riferito a ISO 2/6H)
7G	./.	7G, 8G, (6E)	oversize (M12x1,5 7G = ISO2/6H + 0,06 mm) tolleranza maggiorata (p.es. a M 12x1,5-7G = ca. + 0,06 mm riferito a ISO 2/6H)
4HX	ISO 1X	4H, 5H	manufacturer tolerance for special materials (X = small oversize, 4HX ≈ ISO2/6H) Classe di tolleranza speciale per materiale speciale (X = minor tolleranza maggiorata 4 HX corrisponde ≈ ISO 2/6H)
6HX	ISO 2X	6H	manufacturer tolerance for special materials (X = small oversize, 6HX ≈ ISO3/6G) Classe di tolleranza speciale per materiale speciale (X = minor tolleranza maggiorata 6HX corrisponde ≈ ISO 3/6G)
6GX	ISO 3X	6G	manufacturer tolerance for special materials (X = small oversize, 6GX ≈ 7G) Classe di tolleranza speciale per materiale speciale (X = minor tolleranza maggiorata 6GX corrisponde ≈ 7G)
6H + 0,1	ISO 2 + 0,1	4G, 5G, 6H	+ 0,1 mm oversize for galvanic coatings and surface finishing with thickness of Layer up to 25 µm tolleranza maggiorata 0,1 mm, per strato di protezione galvanica e superficie raffinato con spessore fino 25 µm
6H + 0,2	ISO 2 + 0,2	4G, 5G, 6H	+ 0,2 mm oversize for galvanic coatings and surface finishing with thickness of Layer up to 50 µm tolleranza maggiorata 0,2 mm, per strato di protezione galvanica e superficie raffinato con spessore fino 25 µm

The required oversize of the tap with galvanic coatings depends on the thread angle.

The oversize O can be calculated with the following approach formula: $O = S \times F$

S = thickness of the layer / F = factor depending on the thread angle a ($F = 2 / \sin a / 2$)

tolleranza maggiorata necessaria da strato di protezione galvanica e dipendente dall'angolo del profilo

tolleranza maggiorata O può essere calcolata con la seguente formula: $O = S \times F$

S = spessore del rivestimento galvanico / F = fattore dipendente di angolo del profilo a ($F = 2 / \sin a / 2$)

Thread angle /Angolo del profilo	30°	47°/30'	55°	60°	80°	90°
F=	7,727	4,966	4,331	4,000	3,111	2,828

Conversion table - pitch per inch into mm

Tabella di conversione - Paso pollice in mm

P (Gg/1")	mm
100	0,254 000
96	0,264 583
80	0,317 500
72	0,352 778
64	0,396 875
60	0,423 333
56	0,453 571
48	0,529 167
44	0,577 273
40	0,635 000
36	0,705 555
32	0,793 750
28	0,907 143
27	0,940 741
26	0,976 923
25	1,016 000

P (Gg/1")	mm
24	1,058 333
22	1,154 545
20	1,270 000
19	1,336 842
18	1,411 111
16	1,587 500
14	1,814 286
13	1,953 846
12	2,116 667
11.1/2	2,208 696
11	2,309 091
10	2,540 000
9	2,822 222
8	3,175 000
7	3,628 571
6	4,233 333

P (Gg/1")	mm
5	5,080 000
4.1/2	5,644 444
4	6,350 000
3.1/2	7,257 143
3.1/4	7,815 385
3	8,466 667
2.7/8	8,834 783
2.3/4	9,236 364
2.5/8	9,676 190
2.1/2	10,160 000
2.1/4	11,288 889
2	12,700 000



CONVERSION TABLE OF TENSILE STRENGTH AND HARDNESS*

TABELLA CONVERSIONE RESISTENZA E DUREZZA*

N/mm ²	HRC	Rockwell HRA	HRB	HRF	Vickers HV (≥98N)	Brinell HB 30
255	-	-	-	-	80	76
285	-	-	48	83	90	86
320	-	-	56	87	100	95
350	-	-	62	91	110	105
385	-	-	67	94	120	114
415	-	-	71	96	130	124
450	-	-	75	99	140	133
480	-	-	79	101	150	143
510	-	-	82	104	160	152
545	-	-	85	106	170	162
575	-	-	87	107	180	171
610	-	-	90	109	190	181
640	-	-	92	110	200	190
675	-	-	94	111	210	199
705	-	-	95	112	220	209
740	-	-	97	113	230	219
770	20	61	98	114	240	228
800	22	62	100	115	250	238
835	24	62	101	-	260	247
865	26	63	102	-	270	257
900	27	64	104	-	280	266
930	29	65	105	-	290	276
965	30	65	-	-	300	285
1030	32	66	-	-	320	304
1095	34	68	-	-	340	323
1155	37	69	-	-	360	342
1220	39	70	-	-	380	361
1290	41	71	-	-	400	380
1350	43	72	-	-	420	399
1420	45	73	-	-	440	418
1485	46	74	-	-	460	437
1555	48	75	-	-	480	456
1595	48	75	-	-	490	466
1665	50	76	-	-	510	485
1740	51	76	-	-	530	504
1810	52	77	-	-	550	523
1880	54	78	-	-	570	542
1955	55	78	-	-	590	561
2030	56	79	-	-	610	580
2105	57	80	-	-	630	599
2180	58	80	-	-	650	618
-	59	81	-	-	670	636
-	60	81	-	-	690	-
-	61	82	-	-	720	-
-	63	83	-	-	760	-
-	64	83	-	-	800	-
-	65	84	-	-	840	-
-	66	85	-	-	880	-

*no liability assumed

*senza garanzia



CONVERSION TABLE OF CUTTING SPEED M/MIN. TO R/MIN. TRADUZIONE DELLA VELOCITÀ DI M/MIN IN U/MIN

m/min.		4	6	8	9	10	12	15	18	21	25	27	30	36
Size	inch	Revolutions per Minute (rpm) giri al minuto U/min												
1,6	1/16	800	1194	1592	1791	1988	2386	2983	3579	4176	4971	5369	5965	7158
1,8		708	1065	1415	1598	1768	2121	2652	3182	3712	4419	4743	5303	6364
2		637	955	1274	1433	1591	1909	2386	2863	3341	3977	4295	4773	5727
2,2	3/32	579	869	1158	1303	1446	1736	2169	2603	3037	3616	3905	4339	5207
2,5		510	764	1019	1147	1274	1527	1909	2291	2673	3182	3436	3818	4582
3	1/8	425	637	849	955	1061	1273	1591	1909	2227	2651	2864	3182	3818
3,5		364	546	728	819	909	1091	1364	1636	1909	2273	2455	2727	3273
4	5/32	318	478	637	718	796	955	1193	1432	1671	1989	2148	2387	2864
4,5		283	425	566	637	707	849	1061	1273	1485	1768	1909	2122	2546
5	3/16	255	382	510	573	637	764	955	1146	1337	1591	1719	1909	2292
6	1/4	212	319	425	477	530	636	795	954	1113	1326	1432	1592	1909
7	9/32	182	273	364	409	455	546	682	818	955	1136	1227	1364	1636
8	5/16	159	239	319	358	398	477	597	716	835	994	1074	1193	1432
9		142	212	283	318	354	425	531	637	742	885	955	1061	1293
10	3/8	127	191	255	286	318	382	477	573	668	795	859	955	1146
11		116	174	232	260	289	347	434	521	608	723	781	868	1041
12	1/2	106	159	212	238	265	318	398	477	557	663	716	796	955
13		98	147	196	220	245	294	367	441	514	612	661	734	881
14	9/16	91	136	182	205	227	273	341	409	477	568	614	682	818
16	5/8	80	119	159	179	199	239	298	358	418	497	537	597	716
18		71	106	141	159	177	212	265	318	371	442	477	530	636
20	3/4	64	96	127	143	159	191	239	286	334	398	430	477	573
22	7/8	58	87	116	130	145	174	217	260	304	362	391	434	521
24	1"	53	80	106	119	133	159	199	239	275	331	353	398	477
27		47	71	94	106	118	141	177	212	245	295	318	354	424
30	1-1/8	43	64	85	95	106	127	159	191	223	265	286	318	382
33	1-1/4	39	58	77	87	96	116	145	174	203	241	260	289	347
36		35	53	71	80	88	106	133	159	186	221	239	265	318
39	1-1/2	33	49	65	73	82	98	122	147	171	204	220	245	294
42		30	46	61	68	76	91	114	136	159	189	205	227	273
45	1-3/4	28	42	57	64	71	85	106	127	149	177	191	212	255
48		27	40	53	60	66	80	99	119	139	166	179	199	239
52		24	37	49	55	61	73	92	110	129	153	165	184	220
56	2"	23	34	46	51	57	68	85	102	119	142	153	170	205



RECOMMENDED CUTTING SPEED COOLANTS AND LUBRICANTS VELOCITÀ DI TAGLIO RACCOMANDATO REFRIGERANTE E LUBRIFICAZIONE PER FILETTARE

Material/Materiali	Lubricant lubrificante	Cutting Speed velocità di taglio m/min.
Steel, unalloyed and low alloyed, short-chipping Acciaio non legati e a basso legati, truciolo corto	S/E	10-20
non abrasive Material, short-chipping Materiali buona truciolidibilità, truciolo corto	S/E	6-15
Steel, heat resistant, long-chipping Acciaio resistenti al calore, truciolo lungo	S	4- 8
Steel, heat resistant, short-chipping Acciaio resistenti al calore, truciolo corto	S	4- 8
Steel, cementation and heat treatable, short-chipping Acciaio da cementazione, Acciaio bonificato, truciolo corto	S	4- 8
Steel, Tool Steel up to 1200 N/mm ² Acciaio, Acciaio utensili a 1.200 N/mm ²	S	2- 5
Steel, Tool Steel over 1200 N/mm ² Acciaio, Acciaio utensili da 1.200 N/mm ²	S	2- 5
Steel stainless, short-chipping Acciaio inossidabile, truciolo corto	S	5-10
Steel stainless, long-chipping Acciaio inossidabile, truciolo lungo	S	5-10
Iron, Cast Ghisa grigia	P/T	6-20
Iron, spheroidal graphite Ghisa sferoidale	P/T	6-20
Iron, Malleable Cast Ghisa malleabile	E	6-12
Brass, short-chipping Ottone, truciolo corto	E	20-30
Brass, long-chipping Ottone, truciolo lungo	S/E	10-15
Bronze, short-chipping Bronzo, truciolo corto	S/E	6-15
Bronze, long-chipping Bronzo, truciolo lungo	S/E	6-15
Copper Rame	S/E	10-15
Aluminium-alloys, short-chipping Alluminio, truciolo corto	S/E	15-30
Aluminium-alloys, long-chipping Alluminio, truciolo lungo	E	10-20
Zinc Alloys Leghe forgiate	S/E	10-15
Magnesium Alloys Leghe di magnesio	E/T	10-20
Titanium, short-chipping Titanio, truciolo corto	S	3- 4
Titanium, long-chipping Titanio, truciolo lungo	S	3- 4
Plastics, thermoplastics Materiali plastici, materiali termoplastici	E/T	5-15
Plastics, thermosetting Materiali plastici, materiali termodurenti	T	5-15

S = cutting oil/oli da taglio

E = oil emulsion/emulsione

P = kerosene/petrolio

T = dry/secco



CONVERSION TABLE INCH-MM

TABELLA DI CONVERSIONE POLLICE – MM

Nominal-Ø Inch	BSW Pitch Inch	BSF Pitch Inch	UNC Pitch Inch	UNF Pitch Inch	UNEF Pitch Inch	Thread-Ø mm
No. 0	-	-	-	80	-	1,520
No. 1	-	-	64	72	-	1,850
No. 2	-	-	56	64	-	2,180
No. 3	-	-	48	56	-	2,520
No. 4	-	-	40	48	-	2,850
No. 5	-	-	40	44	-	3,180
No. 6	-	-	32	40	-	3,510
No. 8	-	-	32	36	-	4,170
No. 10	-	-	24	32	-	4,830
No. 12	-	-	24	28	32	5,490
1/16"	60	-	-	-	-	1,587
3/32"	48	-	-	-	-	2,381
1/8"	40	-	-	-	-	3,175
5/32"	32	-	-	-	-	3,969
3/16	24	32	-	-	-	4,762
7,32"	24	28	-	-	-	5,556
1/4"	20	26	20	28	32	6,350
5/16"	18	22	18	24	32	7,938
3/8"	16	20	16	24	32	9,525
7/16"	14	18	14	20	28	11,113
1/2"	12	16	13	20	28	12,700
9/16"	12	16	12	18	24	14,288
5/8"	11	14	11	18	24	15,876
11/16"	-	14	-	-	24	17,463
3/4"	10	12	10	16	20	19,051
13/16"	-	12	-	-	20	20,638
7/8"	9	11	9	14	20	22,226
15/16"	-	11	-	-	20	23,813
1"	8	10	8	12	20	25,401
1 1/16"	-	-	-	-	18	26,988
1 1/8"	7	9	7	12	18	28,576
1 3/16"	-	-	-	-	18	30,163
1 1/4"	7	9	7	12	18	31,751
1 5/16"	18	33,338
1 3/8"	6	8	6	12	18	34,926
1 7/16"	-	-	-	-	18	36,512
1 1/2"	6	8	6	12	18	38,101
1 5/8"	5	8	5	-	18	41,277
1 3/4"	5	7	5	-	18	44,452
1 7/8"	4,5	-	4,5	-	18	47,627
2"	4,5	7	4,5	-	18	50,802
2 1/4"	4	-	4,5	-	-	57,152
2 1/2"	4	-	4	-	-	63,502
2 3/4"	3,5	-	4	-	-	69,853
3"	3,5	-	4	-	-	76,203

Nominal-Ø Inch	BSP (G) Pitch Inch	Thread-Ø mm
G 1/8"	28	9,728
G 1/4"	19	13,157
G 3/8"	19	16,662
G 1/2"	14	20,955
G 5/8"	14	22,911
G 3/4	14	26,441
G 7/8"	14	30,201
G 1"	11	33,249
G 1 1/8	11	37,897
G 1 1/4"	11	41,910
G 1 3/8"	11	44,323
G 1 1/2"	11	47,803
G 1 3/4"	11	53,746
G 2"	11	59,614
G 2 1/4"	11	65,710
G 2 1/2"	11	75,184
G 2 3/4"	11	81,534
G 3"	11	87,884
G 3 1/4"	11	93,980
G 3 1/2	11	100,330
G 3 3/4"	11	106,680
G 4"	11	113,030

armoured tube thread PG

Nominal-Ø	Pitch Inch	Thread-Ø mm
PG 7	20	12,500
PG 9	18	15,200
PG 11	18	18,600
PG 13,5	18	20,400
PG 16	18	22,500
PH 21	16	28,300
PG 29	16	37,000
PG 36	16	47,000
PG 42	16	54,000
PG 48	16	59,500



RECOMMENDED OUTSIDE DIAMETER DIAMETRI DEI PERNI DA FILLETTARE RACCOMANDATO

M	Ø mm	Mf	Ø mm	BSW	Ø mm	UNF	Ø mm	FG	Ø mm									
M 1	0,25	0,97	M 13 x 1,75	12,83	W 1/4	6,16	No. 0-80	1,47	FG 2 x 56	2,03								
M 1,1	0,25	1,07	M 14 x 1	13,88	W 5/16	7,76	No. 1-72	1,79	FG 2,3 x 56	2,23								
M 1,2	0,25	1,17	M 14 x 1,25	13,86	W 3/8	9,30	No. 2-64	2,12	FG 2,6 x 56	2,53								
M 1,4	0,3	1,36	M 14 x 1,5	13,85	W 7/16	10,89	No. 3-56	2,44	FG 6,35 x 26	6,23								
M 1,6	0,35	1,54	M 15 x 1	14,88	W 1/2	12,43	No. 4-48	2,77	FG 7,9 x 26	7,81								
M (1,7)	0,35	1,64	M 15 x 1,5	14,85	W 9/16	13,92	No. 5-44	3,10	FG 9,5 x 26	9,40								
M 1,8	0,35	1,74	M 15 x 2	14,82	W 5/8	15,62	No. 6-40	3,42	FG 14,3 x 20	14,14								
M 2	0,4	1,93	M 16 x 1	15,88	W 3/4	18,76	No. 8-36	4,08	FG 14,3 x 20-LH	14,14								
M 2,2	0,45	2,13	M 16 x 1,5	15,85	W 7/8	21,89	No. 10-32	4,73	FG 25,4 x 24	25,26								
M (2,3)	0,4	2,23	M 18 x 1	17,88	W 1"	25,08	No. 12-28	5,38	BSC	Ø mm								
M 2,5	0,45	2,43	M 18 x 1,5	17,85	W 1.1/8	28,21	1/4-28	6,24										
M (2,6)	0,45	2,53	M 18 x 2	17,82	BSF	Ø mm	5/16-24	7,82	BSC 1/4 x 26	6,23								
M 3	0,5	2,92	M 20 x 1	19,88			3/8-24	9,41	BSC 5/16 x 26	7,81								
M 3	0,6	2,91	M 20 x 1,5	19,85	BSF 3/16	4,67	7/16-20	10,98	BSC 3/8 x 26	9,40								
M 3,5	0,6	3,41	M 20 x 2	19,82	BSF 1/4	6,25	1/2-20	12,56	BSC 9/16 x 20	14,14								
M 3,5	0,75	3,41	M 22 x 1	21,88	BSF 5/16	7,82	9/16-18	14,14	BSC 9/16 x 20LH	14,14								
M 4	0,7	3,91	M 22 x 1,5	21,85	BSF 3/8	9,39	5/8-18	15,73	BSC 1" x 24	25,26								
M 4	0,75	3,91	M 22 x 2	21,82	BSF 7/16	10,97	3/4-16	18,89	Vg	Ø mm								
M 4,5	0,75	4,41	M 24 x 1	23,88	BSF 1/2	12,54	7/8-14	22,05										
M 5	0,8	4,90	M 24 x 1,5	23,85	BSF 9/16	14,12	1"-12	25,21	Vg 5 x 36	5,05								
M 5	0,9	4,89	M 24 x 2	23,82	BSF 5/8	15,71	1.1/8-12	28,38	Vg 5,2 x 24	5,12								
M 6	1	5,88	M 25 x 1	24,88	BSF 3/4	18,85	1.1/4-12	31,56	Vg 6 x 32	5,87								
M 7	1	6,88	M 25 x 1,5	24,85	BSF 7/8	22,02	1.3/8-12	34,73	Vg 8 x 32	7,57								
M 8	1,25	7,87	M 26 x 1	25,88	BSF 1"	25,17	1.1/2-12	37,91	Vg 10 x 28	10,16								
M 9	1,25	8,87	M 26 x 1,5	25,85	UNC	Ø mm	BSP G	Ø mm	Vg 12 x 26	12,04								
M 10	1,5	9,85	M 27 x 1	26,88														
M 11	1,5	10,85	M 27 x 1,5	26,85	No. 1-64	1,79	G 1/8	9,62										
M 12	1,75	11,83	M 27 x 2	26,82	No. 2-56	2,12	G 1/4	13,03										
M 14	2	13,82	M 28 x 1,5	27,85	No. 3-48	2,44	G 3/8	16,53										
M 16	2	15,82	M 28 x 2	27,82	No. 4-40	2,76	G 1/2	20,81										
M 18	2,5	17,79	M 30 x 1	29,88	No. 5-40	3,09	G 5/8	22,77										
M 20	2,5	19,79	M 30 x 1,5	29,85	No. 6-32	3,41	G 3/4	26,30										
M 22	2,5	21,79	M 30 x 2	29,82	No. 8-32	4,07	G 7/8	30,06										
M 24	3	23,77	M 32 x 1,5	31,85	No. 10-24	4,71	G 1"	33,07										
M 27	3	26,77	M 33 x 1,5	32,85	No. 12-24	5,37	G 1.1/8	37,71										
M 30	3,5	29,73	M 33 x 2	32,82	1/4-20	6,22	G 1.1/4	41,73										
M 33	3,5	32,73	M 34 x 1,5	33,85	5/16-18	7,80	G 1.3/8	44,14										
M 36	4	35,70	M 35 x 1,5	34,85	3/8-16	9,37	G 1.1/2	47,62										
M 39	4	38,70	M 36 x 1,5	35,85	7/16-14	10,95	G 1.3/4	53,56										
M 42	4,5	41,69	M 36 x 2	35,82	1/2-13	12,52	G 2"	59,43										
M 45	4,5	44,69	M 36 x 3	35,76	9/16-12	14,10	PG	Ø mm										
M 48	5	47,66	M 38 x 1,5	37,85	5/8-11	15,68												
M 52	5	51,66	M 39 x 1,5	38,85	3/4-10	18,84	PG 7	12,40										
Mf	Ø mm	M 39 x 2	38,82	7/8- 9	22	PG 9	15,10											
		M 39 x 3	38,76	1"- 8	25,16	PG 11	18,50											
M 3 x 0,35	2,94	M 40 x 1,5	39,85	1.1/8- 7	28,31	PG 13,5	20,30											
M 3,5 x 0,35	3,44	M 40 x 2	39,82	1.1/4- 7	31,49	PG 16	22,40											
M 4 x 0,35	3,94	M 40 x 3	39,76	1.3/8- 6	34,63	PG 21	28,15											
M 4 x 0,5	3,93	M 42 x 1,5	41,85	1.1/2- 6	37,81	PG 29	36,85											
M 5 x 0,5	4,93	M 42 x 2	41,82	1.3/4- 5	44,12	PG 36	46,85											
M 6 x 0,5	5,93	M 42 x 3	41,76	2"- 4,5	50,45	PG 42	53,85											
M 6 x 0,75	5,90	M 45 x 1,5	44,85	2.1/4- 4,5	56,80	PG 48	59,15											
M 7 x 0,75	6,90	M 45 x 2	44,82	2.1/2- 4	63,10	NPT	Ø mm											
M 8 x 0,5	7,93	M 45 x 3	44,76	2.3/4- 4	69,45													
M 8 x 0,75	7,90	M 48 x 1,5	47,85	3"- 4	75,80	1/16	8,17											
M 8 x 1	7,83	M 48 x 2	47,82										1/8	10,55				
M 9 x 1	8,88	M 48 x 3	47,46										1/4	14,10				
M 10 x 0,5	9,93	M 50 x 1,5	49,85										3/8	17,52				
M 10 x 0,75	9,90	M 50 x 2	49,82										1/2	21,85				
M 10 x 1	9,88	M 50 x 3	49,76										3/4	27,16				
M 10 x 1,25	9,86	M 52 x 1,5	51,85										1"	34,16				
M 11 x 1	10,88	M 52 x 2	51,82										1.1/4	42,74				
M 12 x 0,75	11,90	M 52 x 3	51,76										1.1/2	48,87				
M 12 x 1	11,88												2"	60,95				
M 12 x 1,25	11,86																	
M 12 x 1,5	11,85																	
M 13 x 1	12,88																	
M 13 x 1,5	12,85																	



RECOMMENDED TAPPING DRILL SIZES

PREFORI PER MASCHI RACCOMANDATO

M	Ø mm		Mf	Ø mm		Mf	Ø mm		Mf	Ø mm		Mf	Ø mm	
M 1	0,25	0,75	M 10	x 1,25	8,8	M 30 x 1,0	29	M 56 x 4,0	52	M 86 x 2,0	84			
M 1,1	0,25	0,85	M 11	x 1,0	10	M 30 x 1,5	28,5	M 58 x 1,0	57	M 86 x 3,0	83			
M 1,2	0,25	0,95	M 11	x 1,25	9,8	M 30 x 2,0	28	M 58 x 1,5	56,5	M 86 x 4,0	82			
M 1,4	0,3	1,1	M 12	x 0,75	11,2	M 30 x 2,5	27,5	M 58 x 2,0	56	M 88 x 1,5	86,5			
M 1,6	0,35	1,25	M 12	x 1,0	11	M 30 x 3,0	27	M 58 x 3,0	55	M 88 x 2,0	86			
M (1,7)	0,35	1,3	M 12	x 0,5	11,5	M 32 x 2	30	M 58 x 4,0	54	M 88 x 3,0	85			
M 1,8	0,35	1,45	M 12	x 1,25	10,8	M 32 x 1,5	29,5	M 60 x 1,5	58,5	M 88 x 4,0	84			
M 2	0,4	1,6	M 13	x 0,5	12,5	M 32 x 3,0	29	M 60 x 2,0	58	M 90 x 1,5	88,5			
M 2,2	0,45	1,75	M 12	x 1,5	10,5	M 33 x 1,5	31,5	M 60 x 3,0	57	M 90 x 2,0	88			
M (2,3)	0,4	1,9	M 13	x 0,75	12,25	M 32 x 1	31	M 60 x 4,0	56	M 90 x 3,0	87			
M 2,5	0,45	2,05	M 13	x 1,0	12	M 33 x 2,0	31	M 62 x 1,5	60,5	M 90 x 4,0	86			
M (2,6)	0,45	2,1	M 13	x 1,5	11,5	M 33 x 3,0	30	M 62 x 2,0	60	M 92 x 1,5	90,5			
M 3	0,5	2,5	M 14	x 0,75	13,25	M 34 x 1	33	M 62 x 3,0	59	M 92 x 2,0	90			
M 3,5	0,6	2,9	M 14	x 1,0	13	M 34 x 1,5	32,5	M 62 x 4,0	58	M 92 x 3,0	89			
M 4	0,7	3,3	M 14	x 1,25	12,8	M 34 x 2,0	32	M 63 x 1,5	61,5	M 92 x 4,0	88			
M 4,5	0,75	3,7	M 14	x 0,5	13,5	M 35 x 1	34	M 64 x 1,5	62,5	M 95 x 1,5	93,5			
M 5	0,8	4,2	M 14	x 1,5	12,5	M 35 x 1,5	33,5	M 64 x 2,0	62	M 95 x 2,0	93			
M 6	1	5	M 15	x 0,75	14,25	M 35 x 2	33	M 64 x 3,0	61	M 95 x 3,0	92			
M 7	1	6	M 15	x 1,0	14	M 36 x 1,5	34,5	M 64 x 4,0	60	M 95 x 4,0	91			
M 8	1,25	6,8	M 15	x 1,5	13,5	M 36 x 1	35	M 65 x 1,5	63,5	M 96 x 1,5	94,5			
M 9	1,25	7,8	M 16	x 0,5	15,5	M 36 x 2,0	34	M 65 x 2,0	63	M 96 x 2,0	94			
M 10	1,5	8,5	M 16	x 1,0	15	M 37 x 1,5	35,5	M 65 x 3,0	62	M 96 x 3,0	93			
M 11	1,5	9,5	M 16	x 0,75	15,25	M 36 x 3,0	33	M 65 x 4,0	61	M 96 x 4,0	92			
M 12	1,75	10,2	M 16	x 1,25	14,75	M 38 x 1	37	M 68 x 1,5	66,5	M 98 x 1,5	96,5			
M 14	2	12	M 16	x 1,5	14,5	M 38 x 1,5	36,5	M 68 x 2,0	66	M 98 x 2,0	96			
M 16	2	14	M 18	x 0,5	17,5	M 38 x 2,0	36	M 68 x 3,0	65	M 98 x 3,0	95			
M 18	2,5	15,5	M 17	x 1,0	16	M 39 x 1,5	37,5	M 68 x 4,0	64	M 98 x 4,0	94			
M 20	2,5	17,5	M 18	x 1,0	17	M 38 x 3	35	M 70 x 1,5	68,5	M 100 x 1,5	98,5			
M 22	2,5	19,5	M 18	x 1,25	16,75	M 39 x 2,0	37	M 70 x 2,0	68	M 100 x 2,0	98			
M 24	3	21	M 18	x 1,5	16,5	M 39 x 3,0	36	M 70 x 3,0	67	M 100 x 3,0	97			
M 27	3	24	M 18	x 0,75	17,25	M 40 x 1	39	M 70 x 4,0	66	M 100 x 4,0	96			
M 30	3,5	26,5	M 18	x 2,0	16	M 40 x 1,5	38,5	M 72 x 1,5	70,5	M 105 x 1,5	103,5			
M 33	3,5	29,5	M 19	x 1,0	18	M 40 x 2,0	38	M 72 x 2,0	70	M 105 x 2,0	103			
M 36	4	32	M 19	x 1,5	17,5	M 40 x 3,0	37	M 72 x 3,0	69	M 105 x 3,0	102			
M 39	4	35	M 20	x 0,5	19,5	M 42 x 1	41	M 72 x 4,0	68	M 105 x 4,0	101			
M 42	4,5	37,5	M 20	x 1,0	19	M 42 x 1,5	40,5	M 74 x 1,5	72,5	M 110 x 1,5	108,5			
M 45	4,5	40,5	M 20	x 0,75	19,25	M 44 x 1,5	42,5	M 74 x 2,0	72	M 110 x 2,0	108			
M 48	5	43	M 20	x 1,25	18,75	M 42 x 2,0	40	M 74 x 3,0	71	M 110 x 3,0	107			
M 52	5	47	M 20	x 1,5	18,5	M 44 x 2	42	M 74 x 4,0	70	M 110 x 4,0	106			
M 3	0,6	2,4	M 20	x 2,0	18	M 42 x 3,0	39	M 75 x 1,5	73,5	BSW Ø				
M 3,5	0,75	2,75	M 21	x 1,0	20	M 45 x 1	44	M 75 x 2,0	73	mm				
M 4	0,75	3,25	M 21	x 1,5	19,5	M 45 x 1,5	43,5	M 75 x 3,0	72	W 3/32	1,8			
M 5	0,9	4,1	M 22	x 0,5	21,5	M 45 x 2,0	43	M 75 x 4,0	71	W 1/8	2,6			
Mf Ø			M 22	x 1,0	21	M 45 x 3,0	42	M 76 x 1,5	74,5	W 5/32	3,1			
mm			M 22	x 0,75	21,25	M 46 x 1,5	44,5	M 76 x 2,0	74	W 3/16	3,6			
M 2,5 x 0,35	2,15		M 22	x 1,25	20,75	M 48 x 1,5	46,5	M 76 x 3,0	73	W 7/32	4,4			
M 2,6 x 0,35	2,25		M 22	x 1,5	20,5	M 48 x 1	47	M 76 x 4,0	72	W 1/4	5,1			
M 3 x 0,35	2,65		M 22	x 2,0	20	M 48 x 2,0	46	M 78 x 1,5	76,5	W 5/16	6,5			
M 3,5 x 0,35	3,15		M 23	x 1,0	22	M 48 x 3,0	45	M 78 x 2,0	76	W 3/8	7,9			
M 4 x 0,35	3,65		M 23	x 1,5	21,5	M 50 x 1,5	48,5	M 78 x 3,0	75	W 7/16	9,3			
M 4 x 0,5	3,5		M 24	x 1,0	23	M 50 x 2,0	48	M 78 x 4,0	74	W 1/2	10,5			
M 4,5 x 0,5	4		M 24	x 0,5	23,5	M 50 x 3,0	47	M 80 x 1,5	78,5	W 9/16	12			
M 5 x 0,5	4,5		M 24	x 1,25	22,75	M 52 x 1,5	50,5	M 80 x 2,0	78	W 5/8	13,5			
M 5 x 0,75	4,25		M 24	x 0,75	23,25	M 52 x 2,0	50	M 80 x 3,0	77	W 3/4	16,5			
M 5,5 x 0,5	5		M 24	x 1,5	22,5	M 52 x 3,0	49	M 80 x 4,0	76	W 7/8	19,25			
M 6 x 0,5	5,5		M 24	x 2,0	22	M 54 x 1,0	53	M 82 x 1,5	80,5	W 1"	22			
M 6 x 0,75	5,2		M 25	x 1,0	24	M 54 x 1,5	52,5	M 82 x 2,0	80	W 1.1/8	24,75			
M 7 x 0,5	6,5		M 25	x 1,5	23,5	M 54 x 2,0	52	M 82 x 3,0	79	W 1.1/4	27,75			
M 7 x 0,75	6,2		M 26	x 1,0	25	M 54 x 3,0	51	M 82 x 4,0	78	W 1.3/8	30,2			
M 8 x 0,5	7,5		M 26	x 1,5	24,5	M 54 x 4,0	50	M 84 x 1,5	82,5	W 1.1/2	33,5			
M 8 x 0,75	7,2		M 26	x 2,0	24	M 55 x 1,5	53,5	M 84 x 2,0	82	W 1.3/4	38,5			
M 8 x 1,0	7		M 27	x 1,0	26	M 55 x 2,0	53	M 84 x 3,0	81	W 2"	44,5			
M 9 x 0,5	8,5		M 27	x 1,5	25,5	M 55 x 3,0	52	M 84 x 4,0	80					
M 9 x 0,75	8,2		M 27	x 2,0	25	M 55 x 4,0	51	M 85 x 1,5	83,5					
M 9 x 1,0	8		M 28	x 1,0	27	M 56 x 1,0	55	M 85 x 2,0	83					
M 10 x 0,5	9,5		M 28	x 1,5	26,5	M 56 x 1,5	54,5	M 85 x 3,0	82					
M 10 x 0,75	9,2		M 28	x 2,0	26	M 56 x 2,0	54	M 85 x 4,0	81					
M 10 x 1,0	9		M 29	x 1,5	27,5	M 56 x 3,0	53	M 86 x 1,5	84,5					



RECOMMENDED TAPPING DRILL SIZES PREFORI PER MASCHI RACCOMANDATO

BSF	\emptyset mm	UNC	\emptyset mm	8-UN	\emptyset mm	UNS	\emptyset mm	Vg	\emptyset mm
BSF 1/4	5,2	2"- 4,5	45	UN 1.1/16-8	23,9	UNS 1/4-24	5,4	Vg 5 x 36	4,7
BSF 5/16	6,6	2.1/4- 4,5	51,5	UN 1.1/8-8	25,5	UNS 1/4-36	5,7	Vg 5,2 x 24	4,3
BSF 3/8	8,1	2.1/2- 4	57,25	UN 1.3/16-8	27,1	UNS 1/4-40	5,75	Vg 6 x 32	5,4
BSF 7/16	9,5	2.3/4- 4	63,5	UN 1.1/4-8	28,75	UNS 3/8-27	8,35	Vg 8 x 32	6,9
BSF 1/2	11	3"- 4	70	UN 1.5/16-8	30,3	UNS 7/16-24	10,1	Vg 10 x 28	9,4
BSF 5/8	14	3.1/4- 4	76,2	UN 1.3/8-8	31,75	UNS 1/2-24	11,75	Vg 12 x 26	11,2
BSF 3/4	16,5	3.1/2- 4	82,6	UN 1.1/2-8	35	UNS 5/8-27	14,7	Rd	\emptyset mm
BSF 7/8	19,5	UNF	\emptyset mm	UN 1.5/8-8	38	UNS 3/4-24	18		
BSF 1"	22,5			UN 1.3/4-8	41,5	UNS 7/8-18	21	Rd 8 x 1/10	6
BSP	\emptyset mm	No. 0-80	1,3	UN 1.7/8-8	44,5	PG	\emptyset mm	Rd 9 x 1/10	7
		No. 1-72	1,6	UN 2"-8	47,75			Rd 10 x 1/10	8
G 1/8	8,8	No. 2-64	1,9	UN 2.1/8-8	50,9	PG 7	11,4	Rd 11 x 1/10	9
G 1/4	11,8	No. 3-56	2,1	UN 2.1/4-8	54	PG 9	14	Rd 12 x 1/10	10
G 3/8	15,25	No. 4-48	2,4	UN 2.1/2-8	60,4	PG 11	17,25	Rd 14 x 1/8	11,5
G 1/2	19	No. 5-44	2,7	UN 2.3/4-8	66,7	PG 13,5	19	Rd 16 x 1/8	13,5
G 5/8	21	No. 6-40	3	UN 3"-8	73,1	PG 16	21,25	Rd 18 x 1/8	15,5
G 3/4	24,5	No. 8-36	3,5	UN 3.1/4-8	79,4	PG 21	26,75	Rd 20 x 1/8	17,5
G 7/8	28,25	No. 10-32	4,1	UN 3.1/2-8	85,8	PG 29	35,5	Rd 22 x 1/8	19,5
G 1"	30,75	No. 12-28	4,7	UN 3.3/4-8	92,1	PG 36	45,5	Rd 24 x 1/8	21,5
G 1.1/8	35,3	1/4-28	5,5	UN 4"-8	98,5	PG 42	52,5	Rd 26 x 1/8	23,5
G 1.1/4	39,5	5/16-24	6,9	UN	\emptyset mm	PG 48	58	Rd 28 x 1/8	25,5
G 1.3/8	41,7	3/8-24	8,5			NPT	\emptyset mm	Rd 30 x 1/8	27,5
G 1.1/2	45,25	7/16-20	9,9	UN 5/16-28	7			Rd 32 x 1/8	29,5
G 1.3/4	51,1	1/2-20	11,5	UN 3/8-20	8,3	1/16-27	6,3	Rd 34 x 1/8	31,5
G 2"	57	9/16-18	12,9	UN 3/8-28	8,6	1/8-27	8,5	Rd 36 x 1/8	33,5
G 2.1/4	63,1	5/8-18	14,5	UN 7/16-32	10,3	1/4-18	11,2	Rd 38 x 1/8	35,5
G 2.1/2	72,6	3/4-16	17,5	UN 1/2-32	11,9	3/8-18	14,5	Rd 40 x 1/6	36,6
G 2.3/4	78,9	7/8-14	20,25	UN 9/16-20	10,9	1/2-14	18	Rd 42 x 1/6	38,6
G 3"	85,3	1"-12	23,25	UN 9/16-28	11,3	3/4-14	23	Rd 44 x 1/6	40,6
BA	\emptyset mm	1.1/8-12	26,5	UN 9/16-32	11,4	1"-11,5	29	Tr	\emptyset mm
		1.1/4-12	29,5	UN 5/8-20	14,6	1.1/4-11,5	38		
BA 0	5,1	1.3/8-12	32,5	UN 5/8-28	15	1.1/2-11,5	44	Tr 10 x 2	8,2
BA 1	4,5	1.1/2-12	36	UN 11/16-20	16,2	2"-11,5	56	Tr 10 x 3	7,5
BA 2	4	12-UN	\emptyset mm	UN 11/16-16	15,9	2.1/2- 8	67	Tr 12 x 3	9,25
BA 3	3,4			UN 1"-32	24,6	3- 8	83	Tr 14 x 3	11,25
BA 4	3	UN 1.5/8-12	39,2	UNEF	\emptyset mm	W	\emptyset mm	Tr 14 x 4	10,5
BA 5	2,65	UN 1.3/4-12	42,4					Tr 16 x 4	12,25
BA 6	2,3	UN 1.7/8-12	45,6	No. 12-32	4,75	DIN 477		Tr 18 x 4	14,25
UNC	\emptyset mm	UN 2"-12	48,75	1/4-32	5,6	W 19,8	15,1	Tr 20 x 4	16,25
		UN 2.1/8-12	51,9	5/16-32	7,2	W 28,8	23,5	Tr 22 x 4	18,25
No. 1-64	1,5	UN 2.1/4-12	55,1	3/8-32	8,8	W 31,3	26,0	Tr 22 x 5	17,25
No. 2-56	1,8	UN 2.1/2-12	61,5	7/16-28	10,25	FG	\emptyset mm	Tr 24 x 5	19,25
No. 3-48	2,1	UN 2.3/4-12	67,8	1/2-28	11,8			Tr 26 x 5	21,25
No. 4-40	2,3	UN 3"-12	74,2	9/16-24	13,3	FG 2 x 56	1,7	Tr 28 x 5	23,25
No. 5-40	2,6	UN 3.1/4-12	80,5	5/8-24	14,9	FG 2,3 x 56	1,9	Tr 30 x 6	24,25
No. 6-32	2,85	UN 3.1/2-12	86,9	11/16-24	16,5	FG 2,6 x 56	2,2	Tr 32 x 6	26,25
No. 8-32	3,5	UN 3.3/4-12	93,2	3/4-20	17,75	FG 6,35 x 26	5,5	Tr 36 x 6	30,25
No. 10-24	3,9	UN 4"-12	99,6	13/16-20	19,5	FG 7,9 x 26	7		
No. 12-24	4,5			7/8-20	21	FG 9,5 x 26	8,6		
1/4-20	5,2			15/16-20	22,5	FG 14,3 x 20	13,1		
5/16-18	6,6			1"-20	24,25	FG 14,3 x 20-LH	13,1		
5/16-18	6,6			1.1/16-18	25,7	FG 25,4 x 24	24,5		
3/8-16	8			1.1/8-18	27,25	BSC	\emptyset mm		
7/16-14	9,4			1.3/16-18	28,75				
1/2-13	10,8			1.1/4-18	30,5	BSC 1/4 x 26	5,5		
9/16-12	12,2			1.5/16-18	32	BSC 5/16 x 26	7		
5/8-11	13,5			1.3/8-18	33,5	BSC 3/8 x 26	8,6		
3/4-10	16,5			1.7/16-18	35,2	BSC 9/16 x 20	13,1		
7/8- 9	19,5			1.1/2-18	36,8	BSC 9/16 x 20 LH	13,1		
1"- 8	22,25			1.9/16-18	38,4	BSC 1" x 24	24,5		
1.1/8- 7	25			1.5/8-18	40				
1.1/4- 7	28,25			1.11/16-18	41,5				
1.3/8- 6	30,75			1.3/4-18	43				
1.1/2- 6	34			2"-18	49,4				
1.3/4- 5	39,5								
2"- 4,5	45								
2.1/4- 4,5	51,5								
2.1/2- 4	57,25								



Art.-No.		Art.-No.		Art.-No.	
100	10	334	119	623	50
130	12	335	120	630	57
140	12	337	121	633	51
145	13	344	119	635	56
146	13	345	120	637	53
150	11	347	121	643	51
152	11	348	122-124	653	52
155	10	349	125-127	657	55
180	236	351	148	663	49
220	41	352	144; 155	665	49
221	211	353	138; 153	670	63; 237-238
222	205	354	142; 154	671	72; 238; 241
223	26	355	159-162	672	69-70; 237
224	179	356	159-162	673	72; 238
225	211	357	150	674	71; 239-241
227	27	359	145	676	71
228	179	361	151	677	64-66
230	42	362	146; 155	678	66-68
231	212	363	139; 153	679	68
232	206	364	143; 154	700	73
233	29	365	149	702	128-129
234	181	369	147	705	99
235	215-216	370	73	707	100
236	187	371	164	715	99
240	42	373	78	717	100
241	212-213	374	79	734	113-114
242	206	375	77; 80	742	130; 131
243	30	376	84	745	101
244	182	377	77; 82	747	102
246	183	379	85	755	101
250	43	383	78	757	102
251	34	384	79	762	130; 131
252	207	385	77; 81	765	103
253	32	386	84	767	104
254	184	387	77; 83	775	103
255	214	389	85	777	104
256	218	394	92	782	132
257	33	395	93-95	784	110
258	186	397	96-98	785	111
260	40	470	231	787	112
261	209	476	231	791	165
262	202-204	478	78-79; 84-85; 148-150; 233-235	793	188-189
263	20-21	479	233	794	115-118
264	173-174	480	223-225; 236	804	19
265	21-23	486	220-222	805	47; 232
266	174-176	489	242-244	807	48; 232
267	209-210	491	226-227	809	47; 232
268	202-204	492	228	831	105; 106
270	39	493	228	832	109
271	208	495	229-230	833	105; 106-108
272	201	552	200	838	31
273	16	553	38	890	180
274	170	554	192	894	28
275	172	556	196	954	54
276	18	562	198-199	957	54
278	171	563	37	970	185
279	171	564	191	975	53
281	17; 23; 25; 176-177	565	37	977	53
282	171; 176-178	566	191	980	187
284	217	568	194-195	985	56; 58
300	140	572	197	987	56; 58
301	141	573	35	994	59
315	80-81	574	190	997	59
317	82-83	577	36		
320	86-87	578	193		
325	88	615	46		
326	89; 91	617	46		
327	90	619	46		

