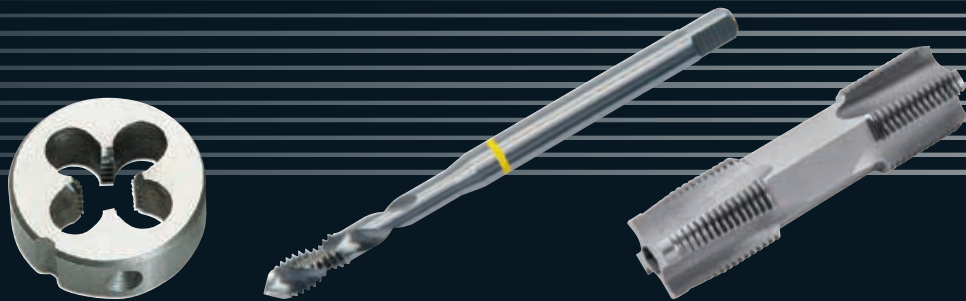


# VÖLKEĻ

THREADING SOLUTIONS ■ ■ ■



■ ■ ■ ■ ■ ■ ■ ■ VD 2016





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1915 – 2015  
VÖLKE THREADING SOLUTIONS  
– WORLDWIDE COMPETENCE IN  
THREAD-CUTTING TOOLS

Based on the experience of 100 years in the production of thread cutting tools VÖLKE has developed into a worldwide leading supplier 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.

1915 – 2015  
VÖLKE THREADING SOLUTIONS  
– COMPETENTI A LIVELLO MONDIALE NEGLI  
UTENSILI PER FILETTARE

Grazie a una esperienza di 100 anni nel campo della filettatura VÖLKE si attesa 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 you rely on a availability of more than 99% on all catalogue items

- more than 7.000 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 7000 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**

14 - 43



**Short Machine Taps**  
**Maschi macchina corti**

44 - 59



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

60 - 73



**Machine Taps**  
**Maschi a macchina**

74 - 128



**Machine Taps with coloured ring**  
**Maschi a macchina con collarini colorati**

129 - 149



**Fluteless (Forming) Taps**  
**Maschi a rulare**

150 - 156



**Machine Nut Taps**  
**Maschi a macchina per dadi**

157 - 159



**Round Dies and Hexagon Die Nuts**  
**Filiere e filiere esagonali**

161 - 202



**Tap & Die Sets**  
**Assortimento**

203 - 228



**Technical Information**  
**Informazioni tecniche**

229 - 242



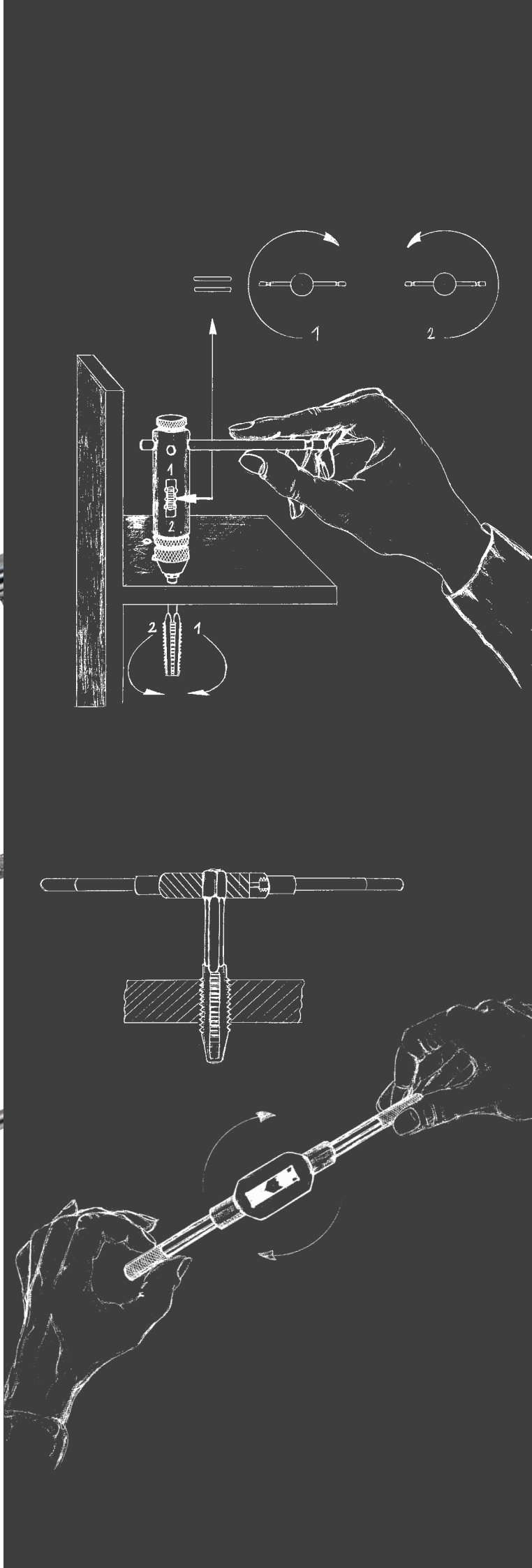
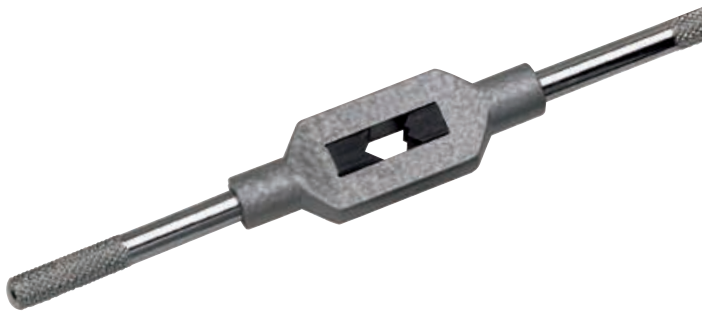
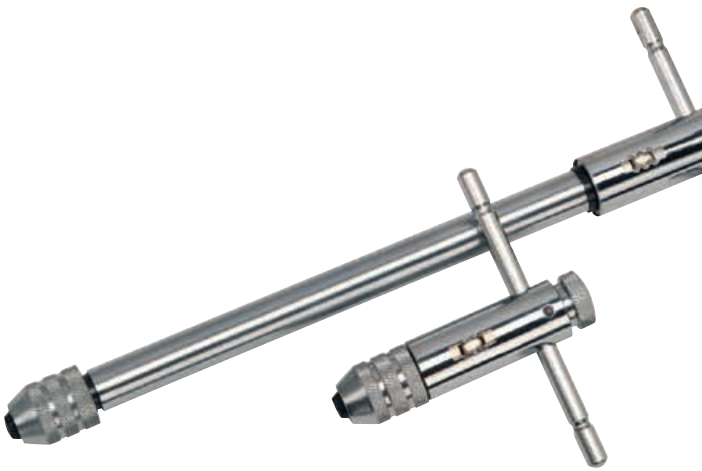
INDEX	M	MF	BSW	BSF	BA	W	UNC	UNF	UNEF	UN	UN-8	UN-12
	DIN 477						UNS					
Hand Taps Maschi a mano	16 35	20 37	26	27	28		29	30	31			
Hand Taps - LH Maschi a mano - LH	39	40	41				42	42				
Short Machine Taps Maschi macchina corti	46	49	50			50	51	51				
Combined Taps Maschi combinati con punte	69 73		73				70	70				
HexTap HexTap	63	64										
Machine Taps Maschi a macchina	77	92	99				101	103	107	105 109	105 106	105 106
Machine Taps - LH Maschi a macchina - LH	119	122										
Machine Taps with oversize Maschi a macchina - tolleranza maggiorata	88											
Machine Taps with coloured ring Maschi a macchina con collarini colorati	132 140 142	139 141					139 141	139 141				
Fluteless Taps Maschi a rulare	153											
Fluteless Taps with oversize - 6G Maschi a rulare – 6G	156											
Machine Nut Taps Maschi a macchina per dadi	158											
Round Dies Filiere	162 182	165 183	171	171	172		173	174	175			
Round Dies - LH Filiere - LH	185	186	189				190	190				
Hexagon Die Nuts Filiere esagonali	192	193	195	195			196	196			197	
Hexagon Die Nuts - LH Filiere esagonali - LH	201											
Tap & Die Sets Assortimento	204 207 210	204 207	208 217	208			209	209				
INDEX	M	MF	BSW	BSF	BA	W	UNC	UNF	UNEF	UN	UN-8	UN-12
	DIN 477						UNS					



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	110	113				114			115	116	117	118
Machine Taps - LH Maschi a macchina - LH	128											
Machine Taps with oversize Maschi a macchina - tolleranza maggiorata												
Machine Taps with coloured ring Maschi a macchina con collarini colorati	139 141											
Fluteless Taps Maschi a rulare												
Fluteless Taps with oversize - 6G Maschi a rulare – 6G												
Machine Nut Taps Maschi a macchina per dadi					159							
Round Dies Filiere	176 184	177		178		179	179			180	180	181
Round Dies - LH Filiere - LH	191											
Hexagon Die Nuts Filiere esagonali	198	199				200						
Hexagon Die Nuts - LH Filiere esagonali - LH	202											
Tap & Die Sets Assortimento	204 208					209						
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 pressoprogetto 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			



## 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

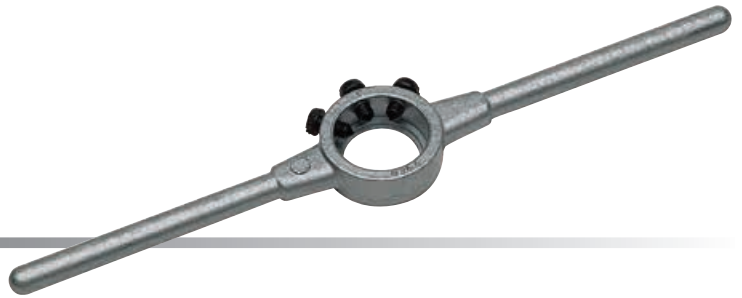
Jaws and Spring for No. 1 und 10	10	10091
Jaws and Spring for No. 2 und 20	10	10092

## 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

## Portafiliera

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**

## Portafiliera

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

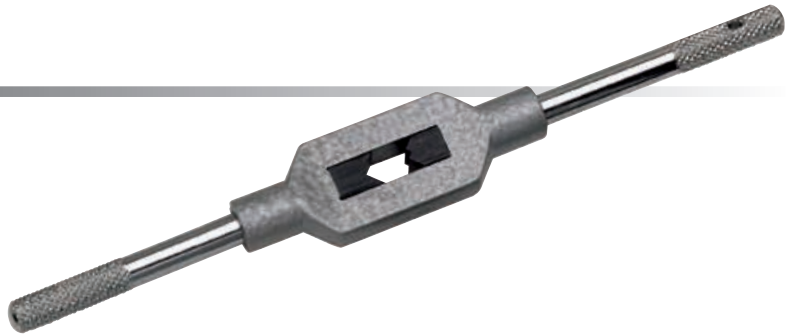



## Adjustable Tap Wrenches

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	0,100	5	14010
1.1/2	M 1-12 1/16-1/2 G 1/8	2.1-8.0	176	0,120	5	14015
2	M 4-12 5/32-1/2 G 1/8	3.0-9.0	280	0,285	5	14020
3	M 5-20 7/32-3/4 G 1/8-1/2	4.9-12	380	0,660	1	14030
4	M 11-27 7/16-1" G 1/4-3/4	5.5-16	500	1,500	1	14040
5	M 13-32 1/2-1.1/4 G 1/4-1"	7-20	700	1,800	1	14050
6	M 18-42 3/4-1.1/2 G 1/2-1.1/4	11-24	1000	2,600	1	14060
7	M 27-52 1.1/8-2" G 3/4-1.3/4	16-32	1250	4,500	1	14070
8	M 27-64 1.1/8"-3" G 3/4-3"	16-40	1250	4,500	1	14080



## 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

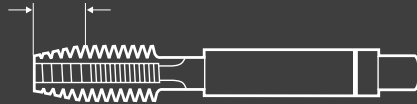


## HAND TAPS MASCHI A MANO



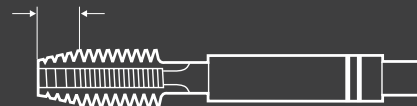
### Nr. 1

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/mm<sup>2</sup>
- 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 truciabilità fino a R 900 N/mm<sup>2</sup>
- Acciaio non legati e scarsamente legati

### Application HSS-E:

- high cutting ability
- abrasive material
- steels up to 1200 N/mm<sup>2</sup>
- and general use

### Applicazione HSS-E:

- elevata durata
- Materiali di difficile truciabilità
- Acciaio R fino a 1.200 N/mm<sup>2</sup>
- 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**

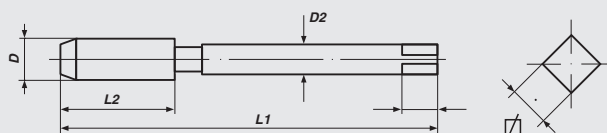
**Tol. ISO2/6H**

**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

metric ISO-thread DIN 13

## Maschi a mano

filettatura metrica ISO DIN 13



**DIN 352**

**HSS-G**

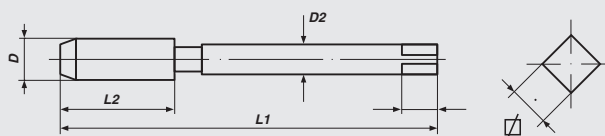
**Tol. ISO2/6H**

**M**

Nominal Diameter D	L 1	L 2	D 2	☒	Art.-No.
M 72 x 6.0	240	80.0	50.0	39.0	28130
M 76 x 6.0	240	80.0	50.0	39.0	28131
M 80 x 6.0	260	85.0	50.0	39.0	28132
M 84 x 6.0	260	85.0	50.0	39.0	28133
M 88 x 6.0	260	85.0	50.0	39.0	28134
M 90 x 6.0	260	85.0	50.0	39.0	28135
M 92 x 6.0	280	90.0	56.0	44.0	28136
M 96 x 6.0	280	90.0	56.0	44.0	28137
M 100 x 6.0	280	90.0	56.0	44.0	28138

### How to order/esempio come ordinare:

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



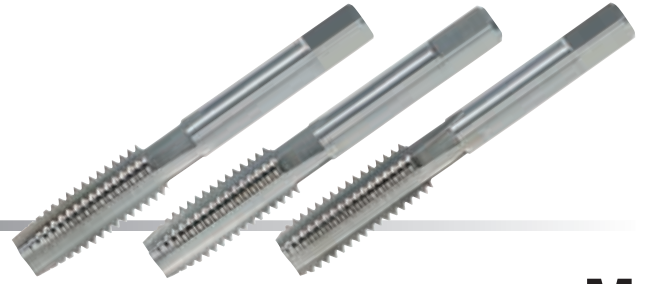


## Hand Taps, *non-serial form*

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/mm<sup>2</sup>
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

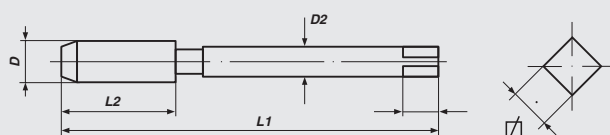
#### How to order/esempio come ordinare:

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

### Applicazione:

#### per uso universale

- Materiali con buona trucidibilità fino a R 900 N/mm<sup>2</sup>
- 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/mm<sup>2</sup>
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

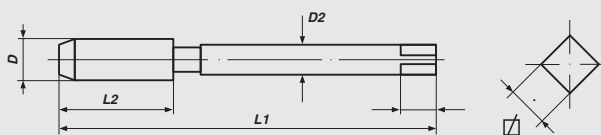
### Applicazione:

#### per uso universale

- Materiali con buona trucidibilità fino a R 900 N/mm<sup>2</sup>
- Acciaio non legati e scarsamente legati
- Fori passanti e ciechi
- Uso manuale

### How to order/eseempio 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/mm<sup>2</sup>
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

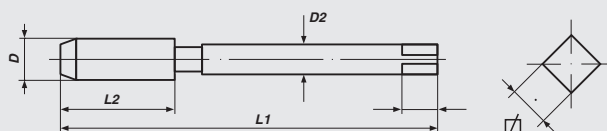
#### How to order/esempio come ordinare:

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 trucidibilità fino a R 900 N/mm<sup>2</sup>
- 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







## 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 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

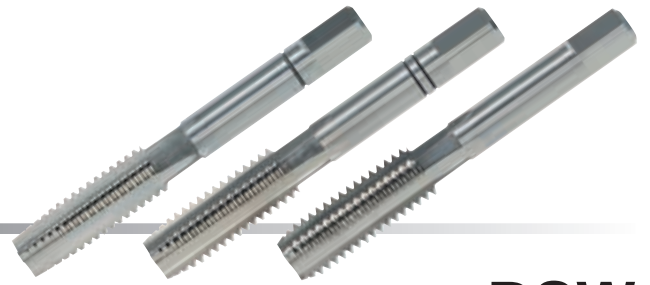


## Hand Taps

Whitworth-thread BS 84

## Maschi a mano

filettatura Whitworth BS 84



≈ DIN 352 HSS-G

**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/mm<sup>2</sup>
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

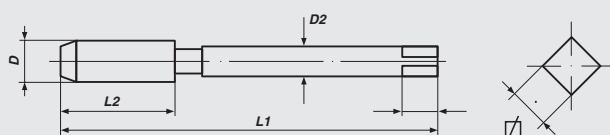
#### How to order/esempio come ordinare:

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 trucioidibilità fino a R 900 N/mm<sup>2</sup>
- 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**

# 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/mm<sup>2</sup>
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

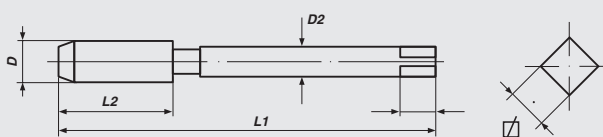
### How to order/esempio come ordinare:

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/mm<sup>2</sup>
- Acciaio non legati e scarsamente legati
- Fori passanti e ciechi
- Uso manuale





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

BA-thread BS 93

**Maschi a mano, *versione conica***

filettatura BA, BS 93



**ISO 529**

**HSS-G**

**BA**

Nominal Diameter D	L 1	L 2	D 2	Ø	Art.-No.
BA 0	66	19	6.3	5.0	89400
BA 1	62	17	5.6	4.5	89401
BA 2	58	16	5.0	4.0	89402
BA 3	53	13	4.5	3.55	89403
BA 4	50	13	3.55	2.8	89404
BA 5	48	11	3.15	2.5	89405
BA 6	45	9.5	2.8	2.24	89406

**Application:**

**for general use**

- non abrasive material up to 900 N/mm<sup>2</sup>
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

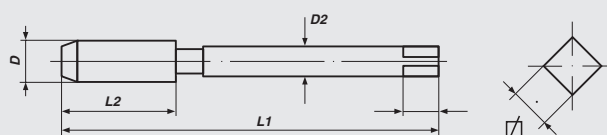
**How to order/esempio come ordinare:**

- 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 trucidibilità fino a R 900 N/mm<sup>2</sup>
- 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/mm<sup>2</sup>
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

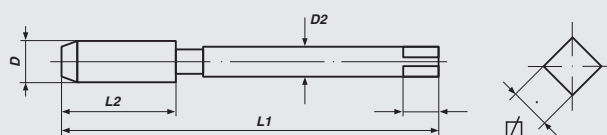
### Applicazione:

#### per uso universale

- Materiali con buona trucidibilità fino a R 900 N/mm<sup>2</sup>
- Acciaio non legati e scarsamente legati
- Fori passanti e ciechi
- Uso manuale

### How to order/eseempio 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





## 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/mm<sup>2</sup>
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

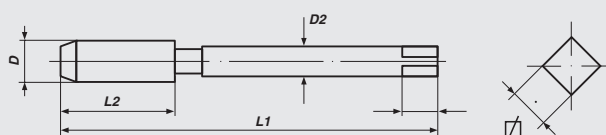
### How to order/esempio come ordinare:

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 trucidibilità fino a R 900 N/mm<sup>2</sup>
- 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/mm<sup>2</sup>
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

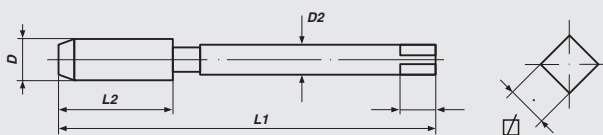
### How to order/esempio come ordinare:

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 trucioidibilità fino a R 900 N/mm<sup>2</sup>
- 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/mm<sup>2</sup>
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

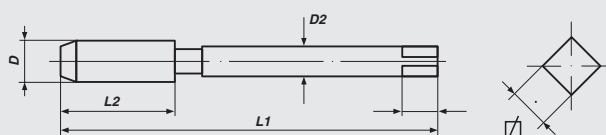
#### How to order/esempio come ordinare:

- 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 truciabilità fino a R 900 N/mm<sup>2</sup>
- Acciaio non legati e scarsamente legati
- Fori passanti e ciechi
- Uso manuale





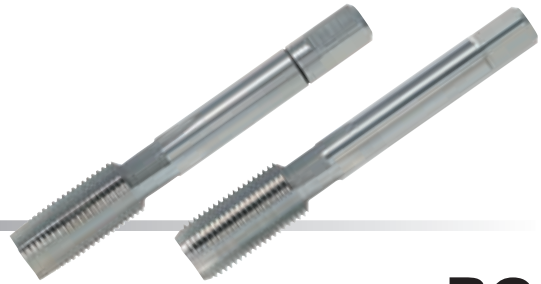


## Hand Taps

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	Ø	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/mm<sup>2</sup>
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

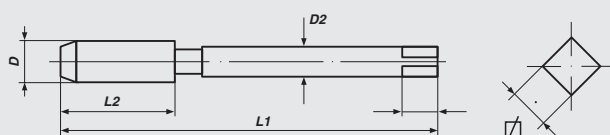
### How to order/esempio come ordinare:

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

### Applicazione:

#### per uso universale

- Materiali con buona trucioidibilità fino a R 900 N/mm<sup>2</sup>
- Acciaio non legati e scarsamente legati
- Fori passanti e ciechi
- Uso manuale



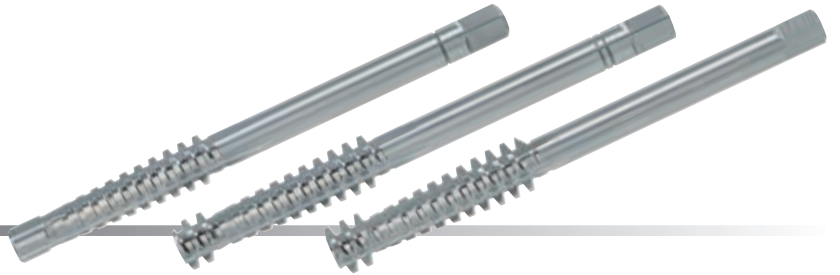


## Hand Taps

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/mm<sup>2</sup>
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

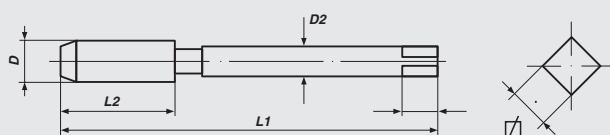
#### How to order/esempio come ordinare:

- 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 trucidabilità fino a R 900 N/mm<sup>2</sup>
- 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**

**ToI. 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:

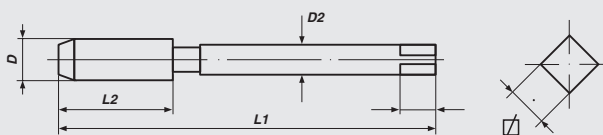
- high cutting ability
- abrasive material
- steels up to 1200 N/mm<sup>2</sup>
- and general use

### Applicazione:

- elevata durata
- materiali di difficile truciolabilità
- Acciaio R fino a 1.200 N/mm<sup>2</sup>
- 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 ISO-thread DIN 13

**Rougher piloted**

## Maschi a mano

filettatura metrica ISO DIN 13

**Sgrossatore con guida**



DIN 352

HSS-E

ToI. 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	57726
M 4 x 0.7	45	13	4.5	3.4	57730
M 5 x 0.8	50	16	6.0	4.9	57734
M 6 x 1.0	50	19	6.0	4.9	57738
M 8 x 1.25	56	22	6.0	4.9	57742
M 10 x 1.5	70	24	7.0	5.5	57746
M 12 x 1.75	75	29	9.0	7.0	57750

### Application:

wear resistant steel up to 1400 N/mm<sup>2</sup>

- high alloy steel
- heat resistant steel
- stainless steel
- alloy tool steel
- cast iron

Surface treatment: steam tempered

### Applicazione:

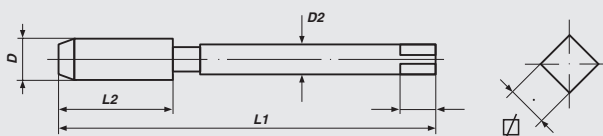
Acciaio ad alta resistenza R a 1.400 N/mm<sup>2</sup>

- Acciaio alto legato
- Acciaio resistenti al calore
- Acciaio inossidabili
- Acciaio per utensili legato
- Ghisia grigia

Superficie: vaporizzato

### How to order / esempio come ordinare:

- M 3 = 57726
- M 3, No. 1 = 57726-1
- M 3, No. 2 = 57726-2
- M 3, No. 3 = 57726-3





## 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:**

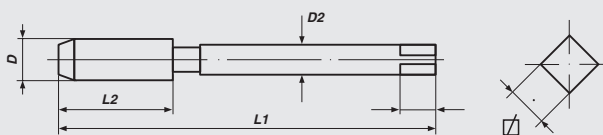
- high cutting ability
- abrasive material
- steels up to 1200 N/mm<sup>2</sup>
- and general use

**Applicazione:**

- elevata durata
- materiali di difficile truciolabilità
- Acciaio R fino a 1.200 N/mm<sup>2</sup>
- 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:

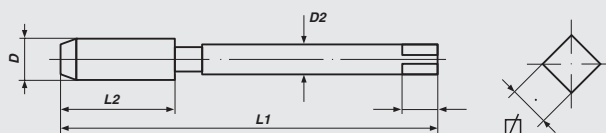
- high cutting ability
- abrasive material
- steels up to 1200 N/mm<sup>2</sup>
- and general use

### Applicazione:

- elevata durata
- materiali di difficile truciolabilità
- Acciaio R fino a 1.200 N/mm<sup>2</sup>
- e per uso universale

### How to order/eseempio 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**

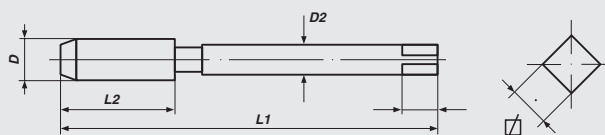
- non abrasive material up to 900 N/mm<sup>2</sup>
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

**Applicazione:****per uso universale**

- Materiali con buona trucidibilità fino a R 900 N/mm<sup>2</sup>
- Acciaio non legati e scarsamente legati
- Fori passanti e ciechi
- Uso manuale

**How to order/eseempio come ordinare:**

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



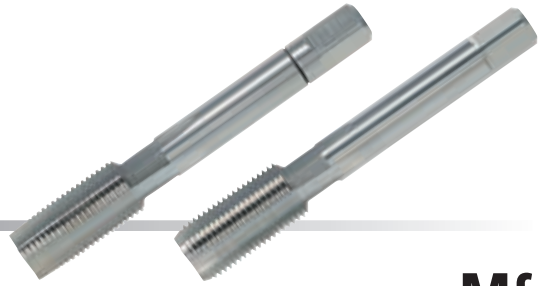


**Hand Taps, *Left Hand***

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/mm<sup>2</sup>
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

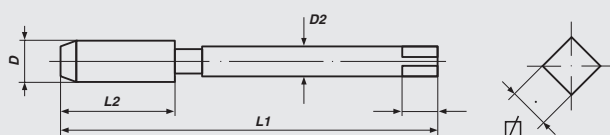
**How to order/eseempio come ordinare:**

- 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 trucioidibilità fino a R 900 N/mm<sup>2</sup>
- 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****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**

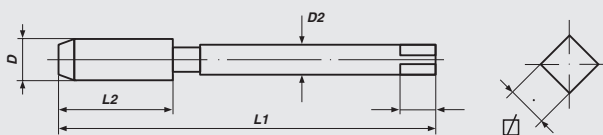
- non abrasive material up to 900 N/mm<sup>2</sup>
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

**Applicazione:****per uso universale**

- Materiali con buona trucidibilità fino a R 900 N/mm<sup>2</sup>
- Acciaio non legati e scarsamente legati
- Fori passanti e ciechi
- Uso manuale

**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





## 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.
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### 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/mm<sup>2</sup>
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

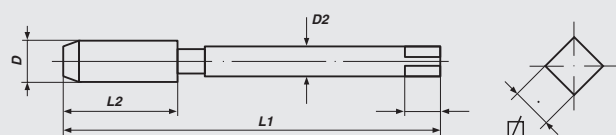
#### How to order/esempio come ordinare:

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 trucidibilità fino a R 900 N/mm<sup>2</sup>
- 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/mm<sup>2</sup>
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

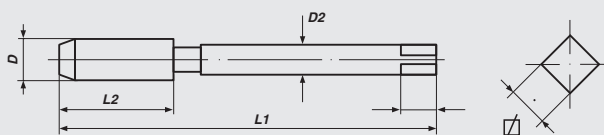
### How to order/esempio come ordinare:

- 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 trucioidibilità fino a R 900 N/mm<sup>2</sup>
- Acciaio non legati e scarsamente legati
- Fori passanti e ciechi
- Uso manuale





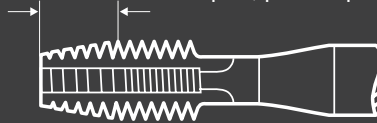
## SHORT MACHINE TAPS MASCHI A MACCHINA CORTI



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

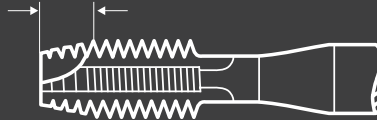
### Form A

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



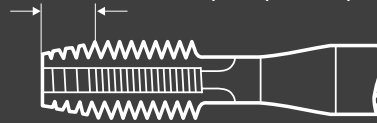
### Form C

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



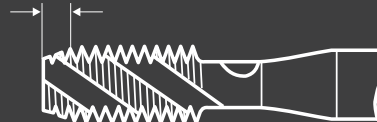
### Form D

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.
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### 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/mm<sup>2</sup>
- 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:

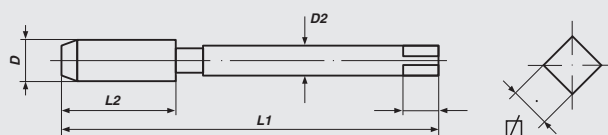
##### per uso universale

- Materiali con buona trucidibilità fino a R 900 N/mm<sup>2</sup>
- 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	∅	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:**

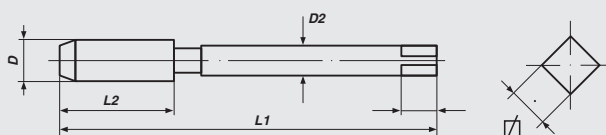
**for general use**

- non abrasive material up to 900 N/mm<sup>2</sup>
- unalloyed and low alloyed steel
- for through holes
- for thread cutting by hand and machine

**Applicazione:**

**per uso universale**

- Materiali con buona trucioidibilità fino a R 900 N/mm<sup>2</sup>
- 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:**

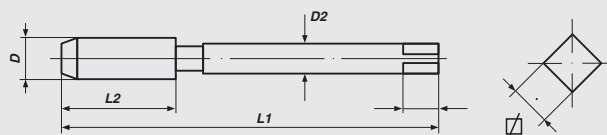
**for general use**

- non abrasive material up to 900 N/mm<sup>2</sup>
- 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/mm<sup>2</sup>
- 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	∅	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 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:

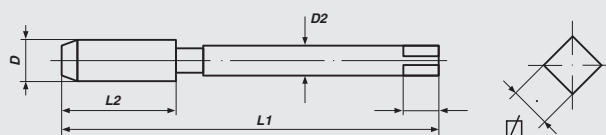
#### for general use

- non abrasive material up to 900 N/mm<sup>2</sup>
- 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/mm<sup>2</sup>
- 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**

**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.
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### 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:

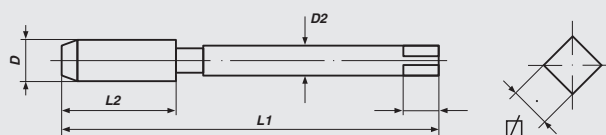
##### for general use

- non abrasive material up to 900 N/mm<sup>2</sup>
- 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/mm<sup>2</sup>
- 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:

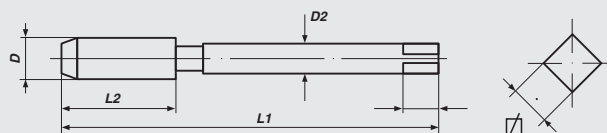
#### for general use

- non abrasive material up to 900 N/mm<sup>2</sup>
- unalloyed and low alloyed steel
- for through holes
- for thread cutting by hand and machine

### Applicazione:

#### per uso universale

- Materiali con buona trucioidibilità fino a R 900 N/mm<sup>2</sup>
- 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

## Rc (BSPT)

Nominal Diameter S	L 1	L 2	D 2	∅	Art.-No.
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### Form C

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 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, 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, 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/mm<sup>2</sup>
- 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:

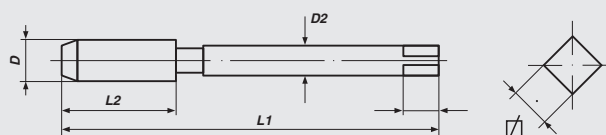
#### per uso universale

- Materiali con buona trucioidibilità fino a R 900 N/mm<sup>2</sup>
- 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.
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### 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/mm<sup>2</sup>
- unalloyed and low alloyed steel
- for thread cutting by hand and machine

**Form C:** for through and blind holes

**Spiral Flute:** for blind holes

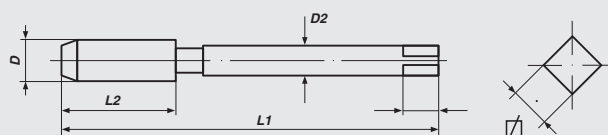
### Applicazione:

#### per uso universale

- Materiali con buona trucioidibilità fino a R 900 N/mm<sup>2</sup>
- 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:

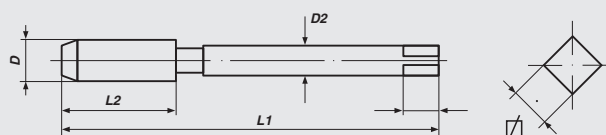
#### for general use

- non abrasive material up to 900 N/mm<sup>2</sup>
- unalloyed and low alloyed steel
- for through holes
- for thread cutting by hand and machine

### Applicazione:

#### per uso universale

- Materiali con buona trucioidibilità fino a R 900 N/mm<sup>2</sup>
- 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.
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### 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/mm<sup>2</sup>
- 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:

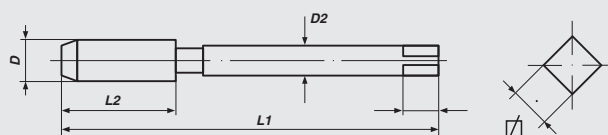
#### per uso universale

- Materiali con buona trucidibilità fino a R 900 N/mm<sup>2</sup>
- 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/mm<sup>2</sup>
- unalloyed and low alloyed steel
- for thread cutting by hand and machine

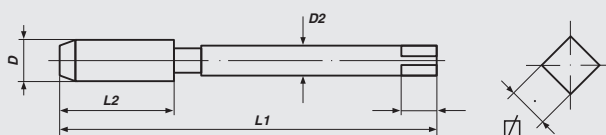
**Form C:** for through and blind holes

### Applicazione:

#### per uso universale

- Materiali con buona trucidibilità fino a R 900 N/mm<sup>2</sup>
- 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.
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### 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/mm<sup>2</sup>
- unalloyed and low alloyed steel
- for thread cutting by hand and machine

**Spiral Point:** for through holes

**Spiral Flute:** for blind holes

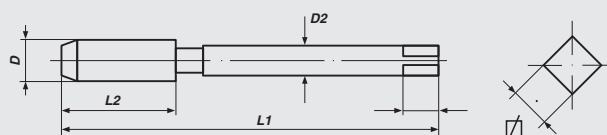
#### Applicazione:

##### per uso universale

- Materiali con buona trucidibilità fino a R 900 N/mm<sup>2</sup>
- 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 tapered 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.
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### 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/mm<sup>2</sup>
- unalloyed and low alloyed steel
- for thread cutting by hand and machine

**Form C:** for through and blind holes

**Spiral Flute:** for blind holes

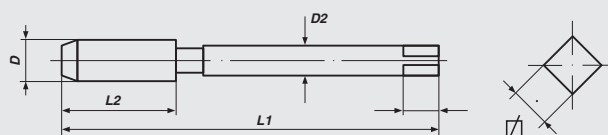
#### Applicazione:

##### per uso universale

- Materiali con buona trucioidibilità fino a R 900 N/mm<sup>2</sup>
- 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	BSW	G(BSP)
HexTap	63	64 - 67			68
Combined Bits Maschi combinati	69		70		
TriBit <sup>2</sup>	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:

VÖLKE 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:

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 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:



## HexTap DS

### Application:

#### for general use

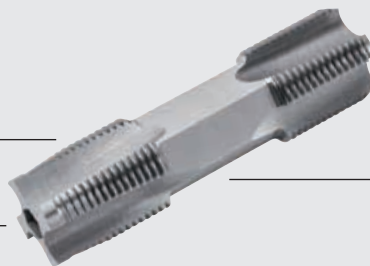
- non abrasive material up to 900 N/mm<sup>2</sup>
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

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



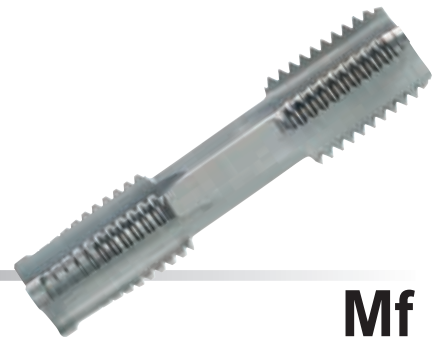


## HexTap DS

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 4	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 4	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



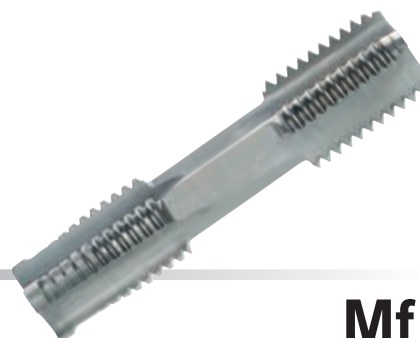


## HexTap DS

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

## HexTap DS

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



**HSS-G**

**ToI. ISO2/6H**

**Mf**

Size	Typ	L 1	L 4	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



### HSS-G

### G (BSP)

Size	Typ	L 1	L 2	SW1	Art.-No.
G 1/8	S	40,5	17	1/4"	67870

### HexTap DS

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

### HexTap DS

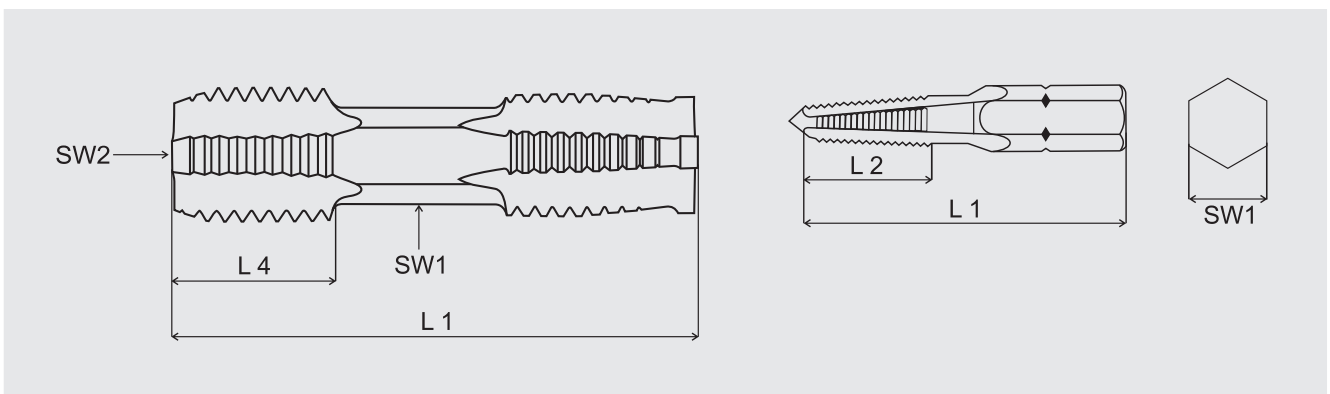
maschi doppio, Multi-Drive  
filettatura per tubi gas DIN ISO 228



### HSS-G

### G (BSP)

Size	Typ	L 1	L 4	SW1	SW2	Art.-No.
G 1/4	DS	70	22	8	4	67871
G 3/8	DS	70	22	12	4	67872
G 1/2	DS	80	24	15	6	67873
G 3/4	DS	90	27	19	8	67874
G 1"	DS	100	29	24	10	67875
G 1.1/4	DS	110	27	32	12	67876
G 1.1/2	DS	140	42	36	17	67877
G 2"	DS	160	47	41	19	67878





## 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 Diametret 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/mm<sup>2</sup> 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 Nm<sup>2</sup> 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



## 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

### UNC / UNF

Nominal Diameter D	D 1	L 1	⬡	Art.-No.
<b>UNC</b>				
UNC Nr. 4 x 40	2.3	36	1/4"	67280
UNC Nr. 5 x 40	2.6	36	1/4"	67281
UNC Nr. 6 x 32	2.85	39	1/4"	67282
UNC Nr. 8 x 32	3.5	39	1/4"	67283
UNC Nr. 10 x 24	3.9	41	1/4"	67284
UNC Nr. 12 x 24	4.5	41	1/4"	67285
UNC 1/4 x 20	5.2	44	1/4"	67286
UNC 5/16 x 18	6.6	50	1/4"	67287
UNC 3/8 x 16	8.0	59	1/4"	67288
<b>UNF</b>				
UNF Nr. 4 x 48	2.4	36	1/4"	67290
UNF Nr. 5 x 44	2.7	36	1/4"	67291
UNF Nr. 6 x 40	3.0	39	1/4"	67292
UNF Nr. 8 x 36	3.5	39	1/4"	67293
UNF Nr. 10 x 32	4.1	41	1/4"	67294
UNF Nr. 12 x 28	4.7	41	1/4"	67295
UNF 1/4 x 28	5.5	44	1/4"	67296
UNF 5/16 x 24	6.9	50	1/4"	67297
UNF 3/8 x 24	8.5	59	1/4"	67298



## TriBit<sup>2</sup>

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

## TriBit<sup>2</sup>




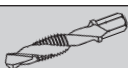
una cassetta in ogni caso  
foratura, filettare, sbarbare  
utensili combinato e speciale



## HSS-G

## Toi. 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

### Tol. ISO2/6H

Nominal Diameter	L 1	S 1	L 2	D 1	D 2	☒	Art.-No.
D							
<b>M</b>							
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
<b>SET</b>							
M 3 - 12		M 3-4-5-6-8-10-12					47837
<b>BSW</b>							
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
<b>SET</b>							
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/mm<sup>2</sup>, 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.

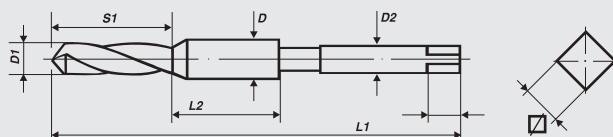
Tapping chucks with pressure compensation may not be used.

### 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.

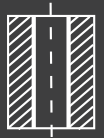
Possono essere realizzati unicamente filetti per fori passanti con profondità massima pari a 2xD. I maschi combinati possono essere utilizzati per uso universale su materiali di media resistenza: acciai legati e non legati fino a 600 N/mm<sup>2</sup>, ghisa, ghisa sferoidale, rame, ottone, alluminio, 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.





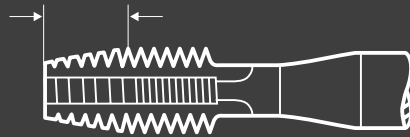
## MACHINE TAPS HSS-E MASCHI A MACCHINA HSS-E



Through hole  
per fori passanti

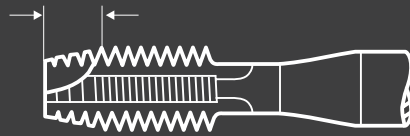
### Form A

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

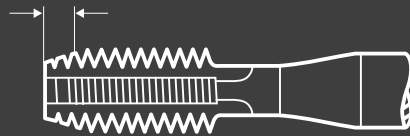
4-5 Threads Lead, Spiral Point with interrupted threads  
Imbocco a 4-5 spire con imbocco corretto e denti alternati per fori passanti



Blind hole  
per fori ciechi

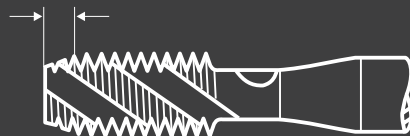
### Form C

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		
UNC			101		102		
UNF			103		104		
8 - UN / 12 - UN			105		106		
UNEF			107		108		
UN / UNS			109				
G (BSP)		110	111		112		
G (BSP) - LH		128					
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 <sup>2</sup> Acciaio da costruzione a 500 N/mm <sup>2</sup>	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>
Structural Steel over 500 N/mm <sup>2</sup> Acciaio da costruzione da 500 N/mm <sup>2</sup>	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>	
free-cutting Steel Acciaio automatici			<input type="radio"/>		<input type="radio"/>	
Cementation Steel, heat treatable Steel Acciaio da cementazione, Acciai bonificato			<input type="radio"/>		<input type="radio"/>	<input type="radio"/>
Tool Steel Acciaio utensili			<input type="radio"/>		<input type="radio"/>	
Stainless Steel Acciaio inossidabile			<input type="radio"/>		<input type="radio"/>	<input type="radio"/>
Cast Steel Ghisa acciaiosa			<input type="radio"/>	<input type="radio"/>	<input type="radio"/>	
Cast Iron, spheroidal graphite Iron Ghisa grigia / Ghisa sferoidale		<input type="radio"/>				
Malleable Cast Iron Ghisa temprata	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>	
Brass, short-chipping Ottone, truciolo corto		<input type="radio"/>				
Brass, long-chipping Ottone, truciolo lungo			<input type="radio"/>	<input type="radio"/>	<input type="radio"/>	
Bronzes Bronzo			<input type="radio"/>		<input type="radio"/>	
Copper Rame			<input type="radio"/>	<input type="radio"/>	<input type="radio"/>	
Al-alloys, short-chipping Alluminio, truciolo corto		<input type="radio"/>	<input type="radio"/>		<input type="radio"/>	
Al-alloys, long-chipping Alluminio, truciolo lungo			<input type="radio"/>	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>
Zinc Alloys Leghe forgiate			<input type="radio"/>	<input type="radio"/>	<input type="radio"/>	
Magnesium Alloys Leghe di magnesio		<input type="radio"/>	<input type="radio"/>		<input type="radio"/>	<input type="radio"/>
Thermoplastics Materiali plastici, materiali termoplastici			<input type="radio"/>		<input type="radio"/>	
Thermosetting Plastics Materiali plastici, materiali termodurenti		<input type="radio"/>				



## 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**

**ToI. 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/mm<sup>2</sup>
- 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/mm<sup>2</sup>
- 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.
<b>DIN 371</b>					
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
<b>DIN 376</b>					
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
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**Application:**

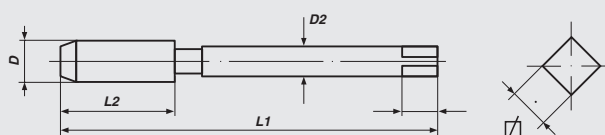
**for general use**

- non abrasive material up to 900 N/mm<sup>2</sup>
- unalloyed and low alloyed steel
- for through holes

**Applicazione:**

**per uso universale**

- Materiali con buona trucidibilità fino a R 900 N/mm<sup>2</sup>
- 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	∅	Art.-No.
<b>DIN 371</b>					
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
<b>DIN 376</b>					
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
<b>SET</b>					
M 3 - 12	M 3-4-5-6-8-10 (DIN 371), M 12 (DIN 376)				47814

### Application:

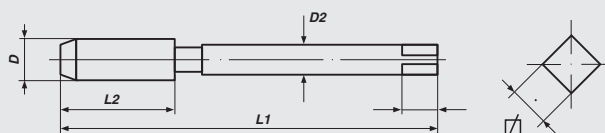
#### for general use

- non abrasive material up to 900 N/mm<sup>2</sup>
- unalloyed and low alloyed steel
- for through and blind holes

### Applicazione:

#### per uso universale

- Materiali con buona trucidibilità fino a R 900 N/mm<sup>2</sup>
- 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/mm<sup>2</sup>
- unalloyed and low alloyed steel
- for through holes

**TIN-coating:**

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

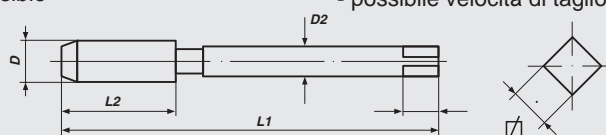
**Applicazione:**

**per uso universale**

- Materiali con buona trucidibilità fino a R 900 N/mm<sup>2</sup>
- 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**

**ToI. 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/mm<sup>2</sup>
- unalloyed and low alloyed steel
- for through holes

##### TIN-coating:

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

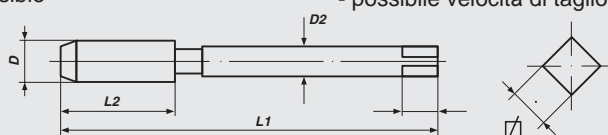
#### Applicazione:

##### per uso universale

- Materiali con buona trucidibilità fino a R 900 N/mm<sup>2</sup>
- Acciaio non legati e scarsamente legati
- per fori passanti

##### rivestimento TIN

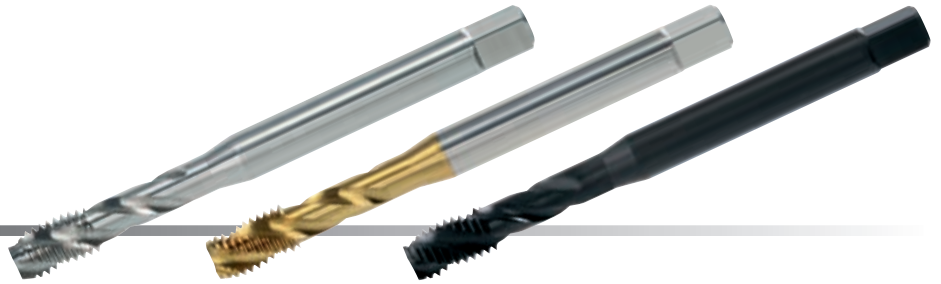
- migliore resistenza all' abrasione e alla rottura
- eccellente uniformità
- possibile velocità di taglio superiore





**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/mm<sup>2</sup>
- unalloyed and low alloyed steel
- for blind holes

**TIN-coating:**

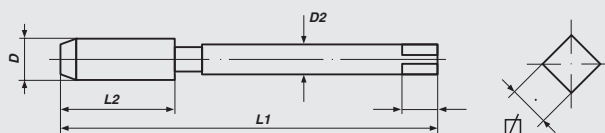
- improved resistance to wear and abrasion
- excellent anti-friction properties
- faster cutting speeds possible

**Applicazione:  
per uso universale**

- Materiali con buona trucidibilità fino a R 900 N/mm<sup>2</sup>
- 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	∅	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/mm<sup>2</sup>
- unalloyed and low alloyed steel
- for blind holes

#### TIN-coating:

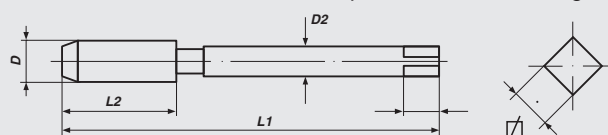
- improved resistance to wear and abrasion
- excellent anti-friction properties
- faster cutting speeds possible

#### Applicazione: per uso universale

- Materiali con buona trucidibilità fino a R 900 N/mm<sup>2</sup>
- 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.
<b>DIN 371</b>					
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
<b>DIN 376</b>					
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
<b>SET</b>					
M 3 - 12	M 3-4-5-6-8-10 (DIN 371), M 12 (DIN 376)				47816

**Application:**

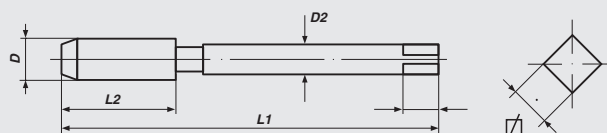
**for general use**

- non abrasive material up to 900 N/mm<sup>2</sup>
- unalloyed and low alloyed steel
- for blind holes

**Applicazione:**

**per uso universale**

- Materiali con buona trucidibilità fino a R 900 N/mm<sup>2</sup>
- 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	∅	Art.-No.
<b>DIN 371</b>					
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
<b>DIN 376</b>					
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
<b>SET</b>					
M 3 - 12	M 3-4-5-6-8-10 (DIN 371), M 12 (DIN 376)				47819

**Application:**

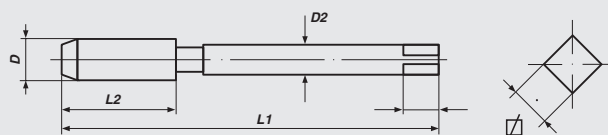
**for general use**

- non abrasive material up to 900 N/mm<sup>2</sup>
- unalloyed and low alloyed steel
- for through holes

**Applicazione:**

**per uso universale**

- Materiali con buona trucidibilità fino a R 900 N/mm<sup>2</sup>
- Acciaio non legati e scarsamente legati
- per fori passanti



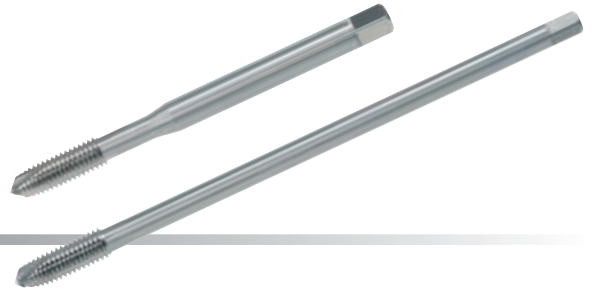


## Machine Taps, *extra long*

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.
<b>100 mm</b>					
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
<b>120 mm</b>					
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
<b>150 mm</b>					
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
<b>150 mm with reduced shank / con gambo passante</b>					
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:

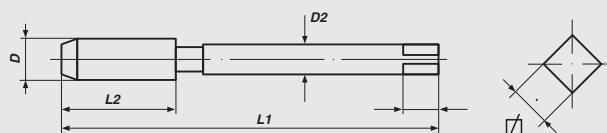
#### for general use in awkward places

- non abrasive material up to 900 N/mm<sup>2</sup>
- unalloyed and low alloyed steel
- for through holes

### Applicazione:

#### per uso universale

- Materiali con buona trucidibilità fino a R 900 N/mm<sup>2</sup>
- Acciaio non legati e scarsamente legati
- per fori passanti



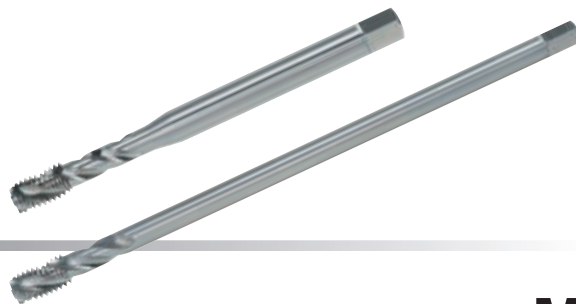


## Machine Taps, *extra long*

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.
<b>100 mm</b>					
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
<b>120 mm</b>					
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
<b>150 mm</b>					
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
<b>150 mm with reduced shank / con gambo passante</b>					
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:

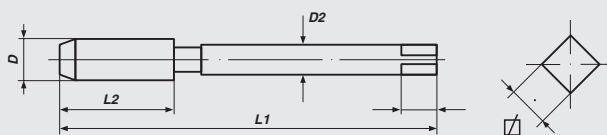
#### for general use in awkward places

- non abrasive material up to 900 N/mm<sup>2</sup>
- unalloyed and low alloyed steel
- for blind holes

### Applicazione:

#### per uso universale

- Materiali con buona trucidibilità fino a R 900 N/mm<sup>2</sup>
- 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.
<b>6G</b>					
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
<b>7G</b>					
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
<b>+ 0,1 mm</b>					
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:

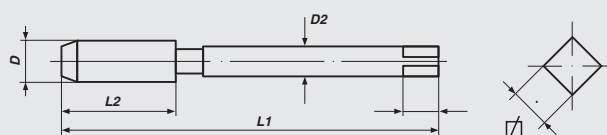
##### for general use

- non abrasive material up to 900 N/mm<sup>2</sup>
- unalloyed and low alloyed steel
- long chipping material
- for through holes

#### Applicazione:

##### per uso universale

- Materiali con buona truciabilità fino a R 900 N/mm<sup>2</sup>
- Acciaio non legati e scarsamente legati
- Materiali truciolo lungo
- per fori passanti







**Machine Taps, *with undersize***

metric ISO-thread DIN13

**Maschi a macchina, *accoppiamento fine***

filettatura metrica ISO DIN 13

DIN 371

DIN 376



**DIN 371/376**

**Form B**

**HSS-E**

**Tol. ISO1/4H**

**M**

Nominal Diameter D	L 1	L 2	D 2	☒	Art.-No.
<b>4H</b>					
	DIN 371				
M 3 x 0.5	56	11	3.5	2.7	32612
M 4 x 0.7	63	13	4.5	3.4	32614
M 5 x 0.8	70	16	6.0	4.9	32616
M 6 x 1.0	80	19	6.0	4.9	32618
M 8 x 1.25	90	22	8.0	6.2	32620
M 10 x 1.5	100	24	10.0	8.0	32622
	DIN 376				
M 12 x 1.75	110	29	9.0	7.0	32624
M 14 x 2.0	110	30	11.0	9.0	32625
M 16 x 2.0	110	32	12.0	9.0	32626

**Application:**

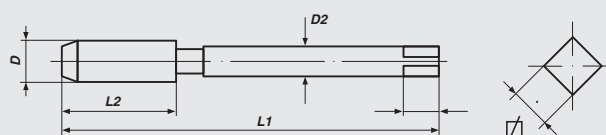
**for general use**

- non abrasive material up to 900 N/mm<sup>2</sup>
- unalloyed and low alloyed steel
- long chipping material
- for through holes

**Applicazione:**

**per uso universale**

- Materiali con buona trucidibilità fino a R 900 N/mm<sup>2</sup>
- Acciaio non legati e scarsamente legati
- Materiali truciolo lungo
- per fori passanti





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

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



**DIN 371/376 Form C/35°RSP HSS-E**

**M**

Nominal Diameter D	L 1	L 2	D 2	☒	Art.-No.
<b>6G</b>					
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
<b>7G</b>					
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
<b>+ 0,1 mm</b>					
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:**

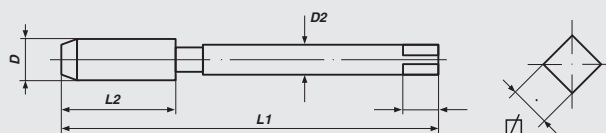
**for general use**

- non abrasive material up to 900 N/mm<sup>2</sup>
- unalloyed and low alloyed steel
- long chipping material
- for blind holes

**Applicazione:**

**per uso universale**

- Materiali con buona truciabilità fino a R 900 N/mm<sup>2</sup>
- Acciaio non legati e scarsamente legati
- Materiali truciolo lungo
- per fori ciechi





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

**Maschi a macchina, *accoppiamento fine***  
filettatura metrica ISO DIN 13



**DIN 371/376      Form C/35°RSP      HSS-E      Tol. ISO1/4H      **M****

Nominal Diameter D	L 1	L 2	D 2	☒	Art.-No.
<b>4H</b>					
	DIN 371				
M 3 x 0.5	56	6	3.5	2.7	32652
M 4 x 0.7	63	7	4.5	3.4	32654
M 5 x 0.8	70	8	6.0	4.9	32656
M 6 x 1.0	80	10	6.0	4.9	32658
M 8 x 1.25	90	14	8.0	6.2	32660
M 10 x 1.5	100	16	10.0	8.0	32662
	DIN 376				
M 12 x 1.75	110	18	9.0	7.0	32664
M 14 x 2.0	110	20	11.0	9.0	32665
M 16 x 2.0	110	22	12.0	9.0	32666

**Application:**

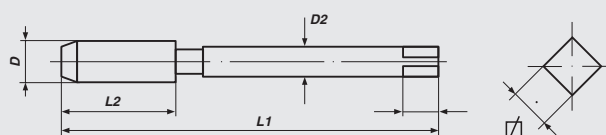
**for general use**

- non abrasive material up to 900 N/mm<sup>2</sup>
- unalloyed and low alloyed steel
- long chipping material
- for blind holes

**Applicazione:**

**per uso universale**

- Materiali con buona trucidibilità fino a R 900 N/mm<sup>2</sup>
- Acciaio non legati e scarsamente legati
- Materiali truciolo lungo
- per fori ciechi





## 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:

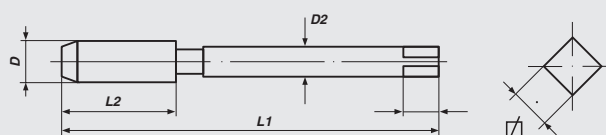
#### for general use

- non abrasive material up to 900 N/mm<sup>2</sup>
- unalloyed and low alloyed steel
- for through holes

### Applicazione:

#### per uso universale

- Materiali con buona trucidibilità fino a R 900 N/mm<sup>2</sup>
- 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:

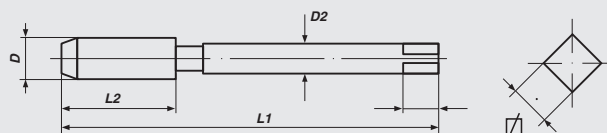
#### for general use

- non abrasive material up to 900 N/mm<sup>2</sup>
- unalloyed and low alloyed steel
- for through holes

### Applicazione:

#### per uso universale

- Materiali con buona trucidibilità fino a R 900 N/mm<sup>2</sup>
- 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:

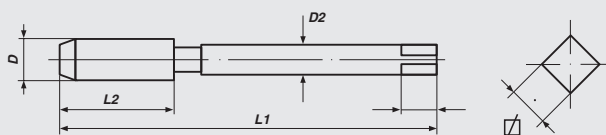
#### for general use

- non abrasive material up to 900 N/mm<sup>2</sup>
- unalloyed and low alloyed steel
- for through holes

### Applicazione:

#### per uso universale

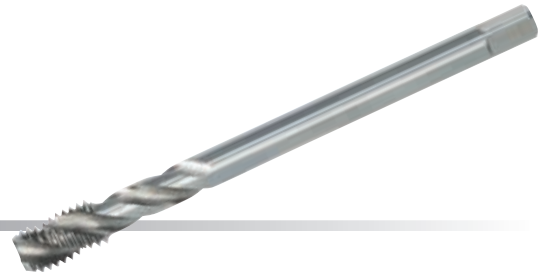
- Materiali con buona trucidibilità fino a R 900 N/mm<sup>2</sup>
- Acciaio non legati e scarsamente legati
- per fori passanti





**Machine Taps**  
metric 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:**

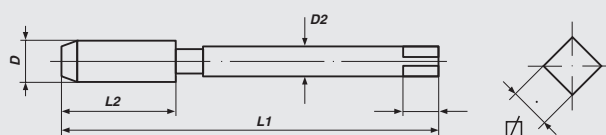
**for general use**

- non abrasive material up to 900 N/mm<sup>2</sup>
- unalloyed and low alloyed steel
- for blind holes

**Applicazione:**

**per uso universale**

- Materiali con buona trucidibilità fino a R 900 N/mm<sup>2</sup>
- Acciaio non legati e scarsamente legati
- per fori ciechi





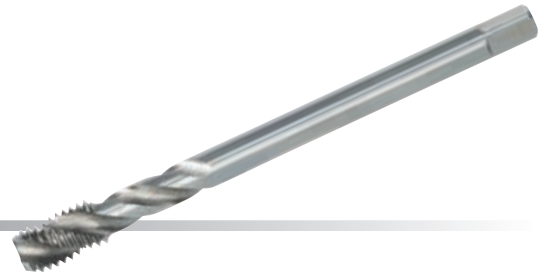


## Machine Taps

metric 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**

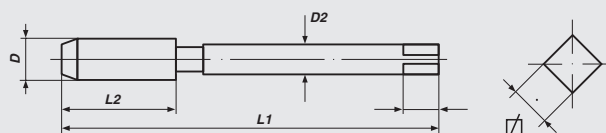
Nominal Diameter D	L 1	L 2	D 2	☒	Art.-No.
M 20 x 1.0	125	14	16.0	12.0	39738
M 20 x 1.25	125	17	16.0	12.0	39739
M 20 x 1.5	125	17	16.0	12.0	39740
M 20 x 2.0	140	20	16.0	12.0	39741
M 21 x 1.5	125	17	16.0	12.0	39742
M 22 x 1.0	125	14	18.0	14.5	39743
M 22 x 1.25	125	17	18.0	14.5	39744
M 22 x 1.5	125	17	18.0	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/mm<sup>2</sup>
- unalloyed and low alloyed steel
- for blind holes

**Applicazione:****per uso universale**

- Materiali con buona trucidibilità fino a R 900 N/mm<sup>2</sup>
- Acciaio non legati e scarsamente legati
- per fori ciechi





**Machine Taps**  
metric 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 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:**

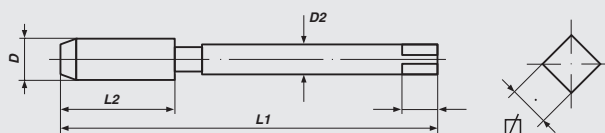
**for general use**

- non abrasive material up to 900 N/mm<sup>2</sup>
- unalloyed and low alloyed steel
- for blind holes

**Applicazione:**

**per uso universale**

- Materiali con buona truciabilità fino a R 900 N/mm<sup>2</sup>
- 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

**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	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:

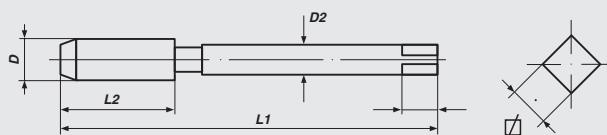
#### for general use

- non abrasive material up to 900 N/mm<sup>2</sup>
- unalloyed and low alloyed steel
- for through holes

### Applicazione:

#### per uso universale

- Materiali con buona trucidibilità fino a R 900 N/mm<sup>2</sup>
- 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**

**BSW**

Nominal Diameter D	L 1	L 2	D 2	☒	Art.-No.
≈ <b>DIN 371</b>					
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
≈ <b>DIN 376</b>					
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:**

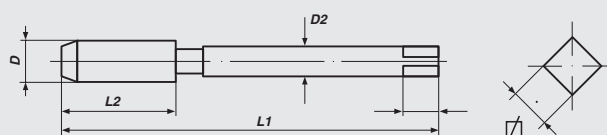
**for general use**

- non abrasive material up to 900 N/mm<sup>2</sup>
- unalloyed and low alloyed steel
- for blind holes

**Applicazione:**

**per uso universale**

- Materiali con buona truciabilità fino a R 900 N/mm<sup>2</sup>
- 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:

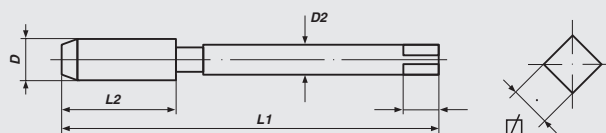
#### for general use

- non abrasive material up to 900 N/mm<sup>2</sup>
- unalloyed and low alloyed steel
- for through holes

### Applicazione:

#### per uso universale

- Materiali con buona trucidibilità fino a R 900 N/mm<sup>2</sup>
- 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.
≈ <b>DIN 371</b>					
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
≈ <b>DIN 376</b>					
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:

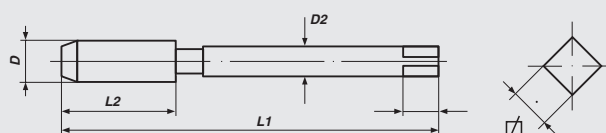
#### for general use

- non abrasive material up to 900 N/mm<sup>2</sup>
- unalloyed and low alloyed steel
- for blind holes

### Applicazione:

#### per uso universale

- Materiali con buona truciabilità fino a R 900 N/mm<sup>2</sup>
- 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:

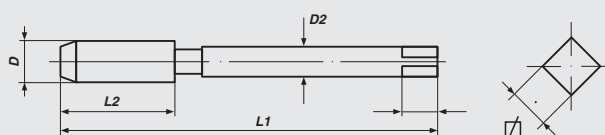
#### for general use

- non abrasive material up to 900 N/mm<sup>2</sup>
- unalloyed and low alloyed steel
- for through holes

### Applicazione:

#### per uso universale

- Materiali con buona trucidibilità fino a R 900 N/mm<sup>2</sup>
- 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.
≈ <b>DIN 371</b>					
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
≈ <b>DIN 376</b>					
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:

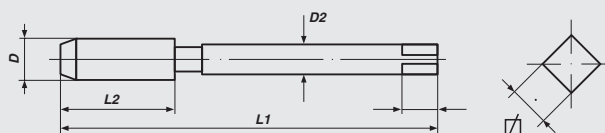
#### for general use

- non abrasive material up to 900 N/mm<sup>2</sup>
- unalloyed and low alloyed steel
- for blind holes

### Applicazione:

#### per uso universale

- Materiali con buona truciabilità fino a R 900 N/mm<sup>2</sup>
- 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.
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### 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:

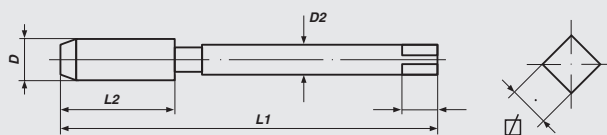
##### for general use

- non abrasive material up to 900 N/mm<sup>2</sup>
- unalloyed and low alloyed steel
- for through holes

#### Applicazione:

##### per uso universale

- Materiali con buona trucidibilità fino a R 900 N/mm<sup>2</sup>
- 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.
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### 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:

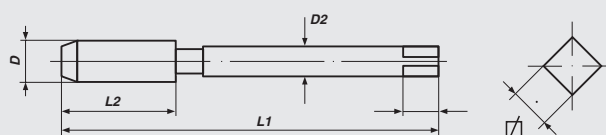
##### for general use

- non abrasive material up to 900 N/mm<sup>2</sup>
- unalloyed and low alloyed steel
- for blind holes

#### Applicazione:

##### per uso universale

- Materiali con buona truciocibilità fino a R 900 N/mm<sup>2</sup>
- 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	∅	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:

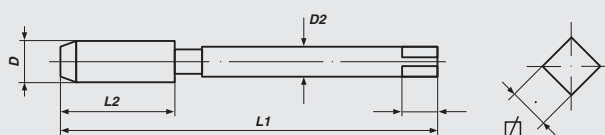
#### for general use

- non abrasive material up to 900 N/mm<sup>2</sup>
- unalloyed and low alloyed steel
- for through holes

### Applicazione:

#### per uso universale

- Materiali con buona trucidibilità fino a R 900 N/mm<sup>2</sup>
- 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:

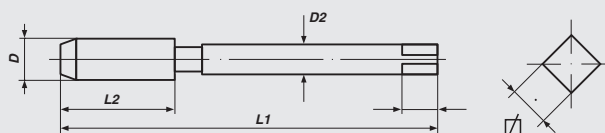
#### for general use

- non abrasive material up to 900 N/mm<sup>2</sup>
- unalloyed and low alloyed steel
- for blind holes

### Applicazione:

#### per uso universale

- Materiali con buona truciabilità fino a R 900 N/mm<sup>2</sup>
- 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.
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### 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 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:

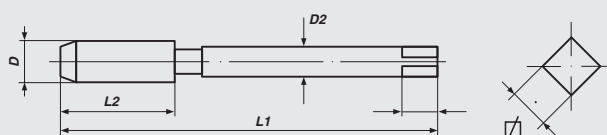
##### for general use

- non abrasive material up to 900 N/mm<sup>2</sup>
- unalloyed and low alloyed steel
- for through holes

#### Applicazione:

##### per uso universale

- Materiali con buona trucidibilità fino a R 900 N/mm<sup>2</sup>
- Acciaio non legati e scarsamente legati
- per fori passanti



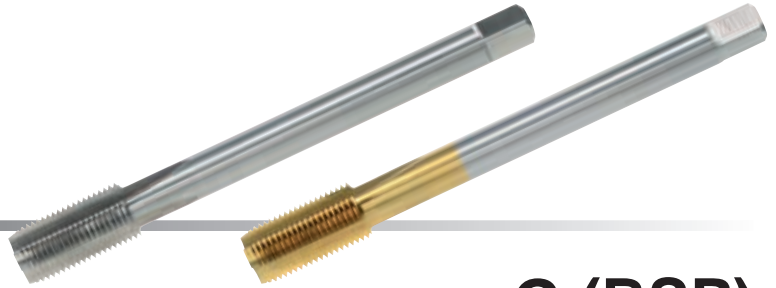


## Machine Taps

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/mm<sup>2</sup>
- unalloyed and low alloyed steel
- for through and blind holes

#### TIN-coating:

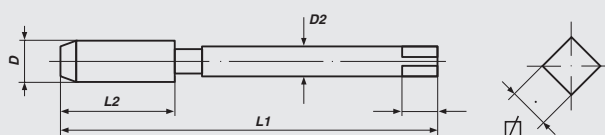
- improved resistance to wear and abrasion
- excellent anti-friction properties
- faster cutting speeds possible

#### Applicazione: per uso universale

- Materiali con buona truciabilità fino a R 900 N/mm<sup>2</sup>
- 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



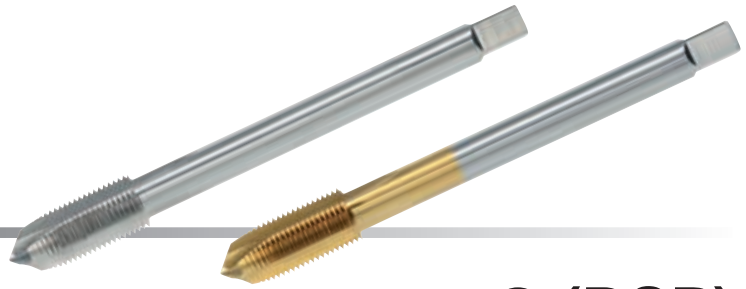


## Machine Taps

Pipe-thread DIN ISO 228

## Maschi a macchina

filettatura per tubi gas DIN ISO 228



**DIN 5156**

**Form 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	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/mm<sup>2</sup>
- unalloyed and low alloyed steel
- for through holes

#### TIN-coating:

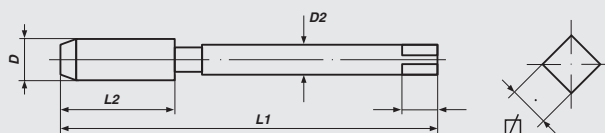
- improved resistance to wear and abrasion
- excellent anti-friction properties
- faster cutting speeds possible

#### Applicazione: per uso universale

- Materiali con buona truciabilità fino a R 900 N/mm<sup>2</sup>
- 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/mm<sup>2</sup>
- unalloyed and low alloyed steel
- for blind holes

**TIN-coating:**

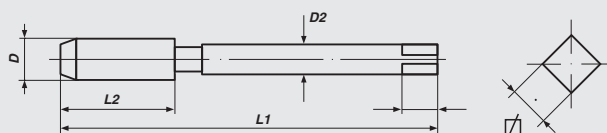
- improved resistance to wear and abrasion
- excellent anti-friction properties
- faster cutting speeds possible

**Applicazione:  
per uso universale**

- Materiali con buona trucidibilità fino a R 900 N/mm<sup>2</sup>
- 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:

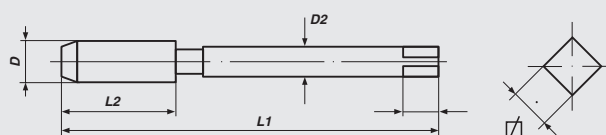
#### for general use

- non abrasive material up to 900 N/mm<sup>2</sup>
- unalloyed and low alloyed steel
- for through and blind holes

### Applicazione:

#### per uso universale

- Materiali con buona trucidibilità fino a R 900 N/mm<sup>2</sup>
- 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	∅	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:

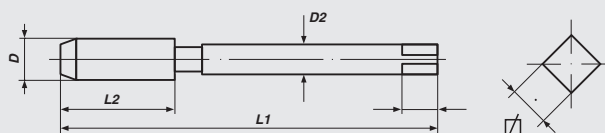
#### for general use

- non abrasive material up to 900 N/mm<sup>2</sup>
- unalloyed and low alloyed steel
- for through and blind holes

### Applicazione:

#### per uso universale

- Materiali con buona trucidibilità fino a R 900 N/mm<sup>2</sup>
- 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	∅	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:

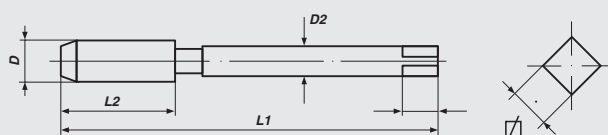
#### for general use

- non abrasive material up to 900 N/mm<sup>2</sup>
- unalloyed and low alloyed steel
- for through and blind holes

### Applicazione:

#### per uso universale

- Materiali con buona trucidibilità fino a R 900 N/mm<sup>2</sup>
- Acciaio non legati e scarsamente legati
- per fori passanti e ciechi



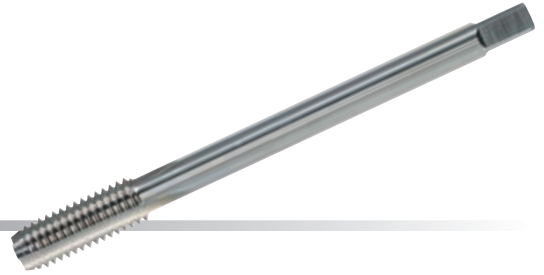


## Machine Taps

Cycle thread DIN 79012

## Maschi a macchina

filettatura per biciclette DIN 79012



**DIN 374**

**Form C**

**HSS-E**

**Tol. medium**

**FG**

Nennmaß 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:

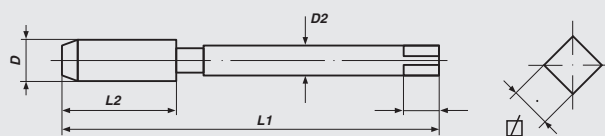
#### for general use

- non abrasive material up to 900 N/mm<sup>2</sup>
- unalloyed and low alloyed steel
- for through and blind holes

### Applicazione:

#### per uso universale

- Materiali con buona trucidibilità fino a R 900 N/mm<sup>2</sup>
- 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:

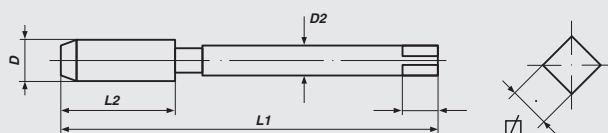
#### for general use

- non abrasive material up to 900 N/mm<sup>2</sup>
- unalloyed and low alloyed steel
- for through and blind holes

### Applicazione:

#### per uso universale

- Materiali con buona trucidibilità fino a R 900 N/mm<sup>2</sup>
- 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:

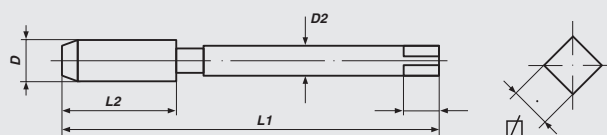
#### for general use

- non abrasive material up to 900 N/mm<sup>2</sup>
- unalloyed and low alloyed steel
- for through and blind holes

### Applicazione:

#### per uso universale

- Materiali con buona trucidibilità fino a R 900 N/mm<sup>2</sup>
- 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.
<b>DIN 371</b>					
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
<b>DIN 376</b>					
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:

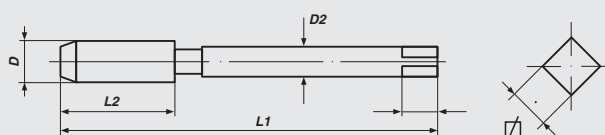
#### for general use

- non abrasive material up to 900 N/mm<sup>2</sup>
- unalloyed and low alloyed steel
- for through and blind holes

### Applicazione:

#### per uso universale

- Materiali con buona trucidibilità fino a R 900 N/mm<sup>2</sup>
- 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.
<b>DIN 371</b>					
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
<b>DIN 376</b>					
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:

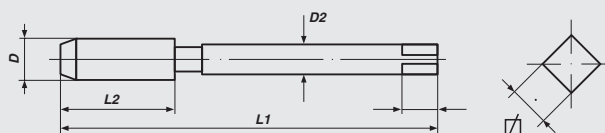
#### for general use

- non abrasive material up to 900 N/mm<sup>2</sup>
- unalloyed and low alloyed steel
- for through holes

### Applicazione:

#### per uso universale

- Materiali con buona truciabilità fino a R 900 N/mm<sup>2</sup>
- 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.
<b>DIN 371</b>					
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
<b>DIN 376</b>					
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:

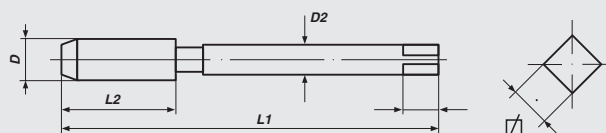
#### for general use

- non abrasive material up to 900 N/mm<sup>2</sup>
- unalloyed and low alloyed steel
- for blind holes

### Applicazione:

#### per uso universale

- Materiali con buona trucidibilità fino a R 900 N/mm<sup>2</sup>
- 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:

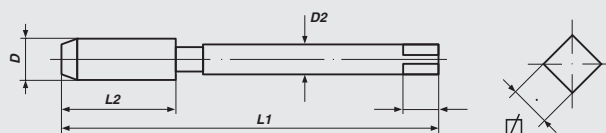
#### for general use

- non abrasive material up to 900 N/mm<sup>2</sup>
- unalloyed and low alloyed steel
- for through holes

### Applicazione:

#### per uso universale

- Materiali con buona trucioidibilità fino a R 900 N/mm<sup>2</sup>
- 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**

**ToI. 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	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:

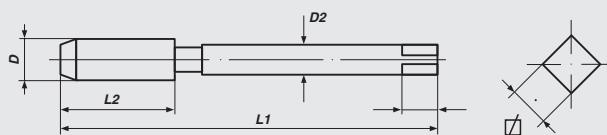
#### for general use

- non abrasive material up to 900 N/mm<sup>2</sup>
- unalloyed and low alloyed steel
- for through holes

### Applicazione:

#### per uso universale

- Materiali con buona trucidibilità fino a R 900 N/mm<sup>2</sup>
- 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**

**ToI. 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:

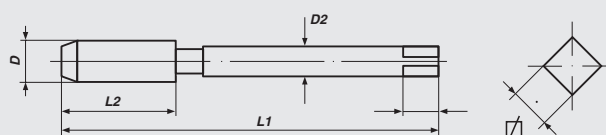
#### for general use

- non abrasive material up to 900 N/mm<sup>2</sup>
- unalloyed and low alloyed steel
- for through holes

### Applicazione:

#### per uso universale

- Materiali con buona trucidibilità fino a R 900 N/mm<sup>2</sup>
- 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:

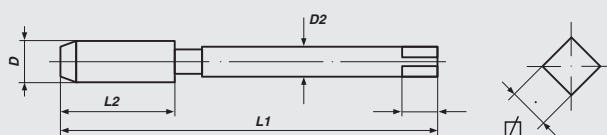
#### for general use

- non abrasive material up to 900 N/mm<sup>2</sup>
- unalloyed and low alloyed steel
- for blind holes

### Applicazione:

#### per uso universale

- Materiali con buona truciabilità fino a R 900 N/mm<sup>2</sup>
- Acciaio non legati e scarsamente legati
- per fori ciechi



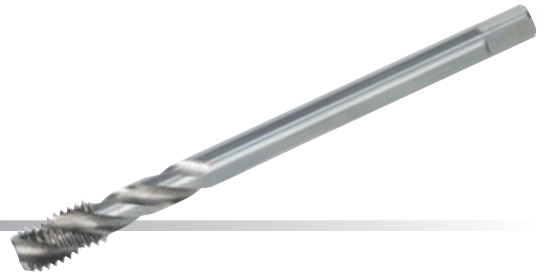


## Machine Taps, *Left Hand*

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:

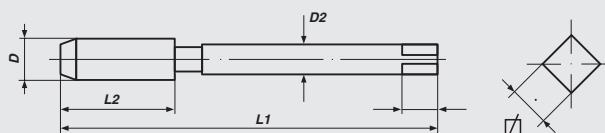
#### for general use

- non abrasive material up to 900 N/mm<sup>2</sup>
- unalloyed and low alloyed steel
- for blind holes

### Applicazione:

#### per uso universale

- Materiali con buona trucidibilità fino a R 900 N/mm<sup>2</sup>
- Acciaio non legati e scarsamente legati
- per fori ciechi



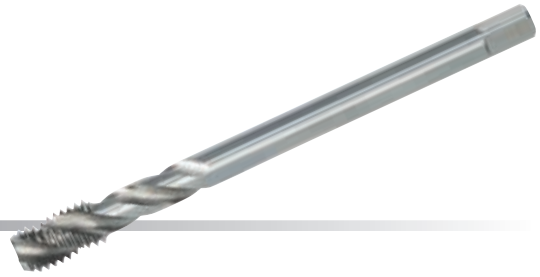


## Machine Taps, *Left Hand*

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 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:

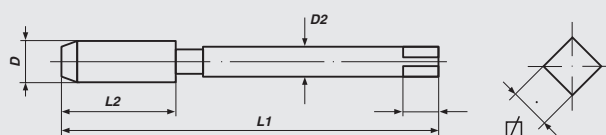
#### for general use

- non abrasive material up to 900 N/mm<sup>2</sup>
- unalloyed and low alloyed steel
- for blind holes

### Applicazione:

#### per uso universale

- Materiali con buona trucidibilità fino a R 900 N/mm<sup>2</sup>
- 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	∅	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:**

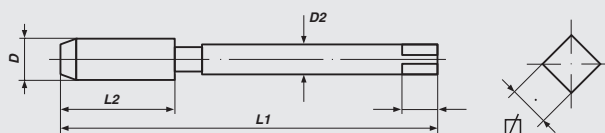
**for general use**

- non abrasive material up to 900 N/mm<sup>2</sup>
- unalloyed and low alloyed steel
- for through and blind holes

**Applicazione:**

**per uso universale**









- Materiali con buona trucioidibilità fino a R 900 N/mm<sup>2</sup>
- 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	132	133	147
	for general use per uso universale	134	135	
	for wear resistant steel Acciaio resistente all'abrasione	136	137	148
	for stainless steel Acciaio inossidabile	138	140	149
	for cast iron Ghisa grigia	142		
	Material from 1200 N/mm2 tensile strength Materiali con resistenza alla trazione da 1.200 N/mm <sup>2</sup>	145		
	for aluminium alloys Alluminio	143		
	for brass Ottone	144		



**because available ■ because reliable ■ because you ■**



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

Material Materiali	Lubricant lubrificante	Cutting Speed velocità di taglio m/min.
Steel, unalloyed and low alloyed, short-chipping Acciaio non legati e scarsamente legati, truciolo corto	S/E	10-20
non abrasive Material, short-chipping Materiali buona trucioldibilità, 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 <sup>2</sup> Acciaio, Acciaio utensili a 1.200 N/mm <sup>2</sup>	S	2- 5
Steel, Tool Steel over 1200 N/mm <sup>2</sup> Acciaio, Acciaio utensili da 1.200 N/mm <sup>2</sup>	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 temprata	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 / olii da taglio

E = oil emulsion / emulsione P = kerosene / petrolio

T = dry / secco



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

Material	Green Ring collarino verde	Blue Ring collarino blu	White Ring collarino bianco	Black Ring collarino nero	Red Ring collarino rosso	Yellow Ring collarino giallo	Orange Ring collarino arancione
Steel, unalloyed and low alloyed, short-chipping Acciaio non legati e scarsamente legati, truciolo corto	● PM						
non abrasive Material, short-chipping Materiali buona truciolidibilità, truciolo corto	● PM						
Steel, heat resistant, long-chipping Acciaio resistenti al calore, truciolo lungo	● PM		○				
Steel, heat resistant, short-chipping Acciaio resistenti al calore, truciolo corto	● PM	●					
Steel, cementation and heat treatable, short-chipping Acciaio da cementazione, Acciaio bonificato, truciolo corto	● PM	●					
Steel, Tool Steel up to 1200 N/mm <sup>2</sup> Acciaio, Acciaio utensili a 1.200 N/mm <sup>2</sup>		●					
Steel, Tool Steel over 1200 N/mm <sup>2</sup> Acciaio, Acciaio utensili da 1.200 N/mm <sup>2</sup>					●		
Steel stainless, short-chipping Acciaio inossidabile, truciolo corto	● PM	●					
Steel stainless, long-chipping Acciaio inossidabile, truciolo lungo	● PM		○				
Iron, Cast Ghisa grigia				●			
Iron, spheroidal graphite Ghisa sferoidale		●					
Iron, Malleable Cast Ghisa temprata	● PM						
Brass, short-chipping Ottone, truciolo corto		●		●			●
Brass, long-chipping Ottone, truciolo lungo	● PM						
Bronze, short-chipping Bronzo, truciolo corto		●		●			
Bronze, long-chipping Bronzo, truciolo lungo	● PM						
Copper Rame	● PM						
Aluminium-alloys, short-chipping Alluminio, truciolo corto		●					
Aluminium-alloys, long-chipping Alluminio, truciolo lungo	● PM					●	
Zinc Alloys Leghe forgiate	● PM						
Magnesium Alloys Leghe di magnesio	● PM	●					
Titanium, short-chipping Titanio, truciolo corto		●					
Titanium, long-chipping Titanio, truciolo lungo			○				
Plastics, thermoplastics Materiali plastici, materiali termoplastici	● PM						
Plastics, thermosetting Materiali plastici, materiali termodurenti				●	●		

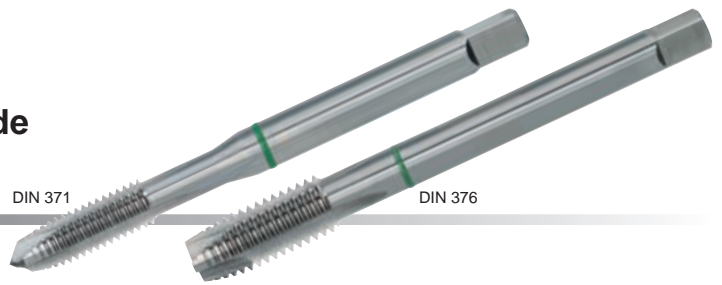


## GREEN RING-Machine Taps

metric ISO-thread DIN 13

### Maschi a macchina con collarino verde

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.
<b>DIN 371</b>					
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
<b>DIN 376</b>					
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
<b>SET</b>					
M 3 - 12	M 3-4-5-6-8-10 (DIN 371), M 12 (DIN 376)				47853

#### Application:

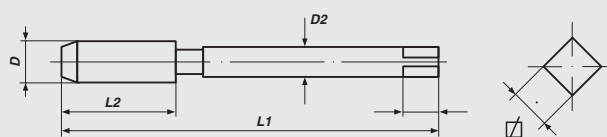
##### for general use

- non abrasive material up to 1000 N/mm<sup>2</sup>
- unalloyed and low alloyed steel
- long chipping material
- for through holes

#### Applicazione:

##### per uso universale

- Materiali con buona truciabilità fino a R 1.000 N/mm<sup>2</sup>
- Acciaio non legati e scarsamente legati
- Materiali truciolo lungo
- per fori passanti





## GREEN RING-Machine Taps

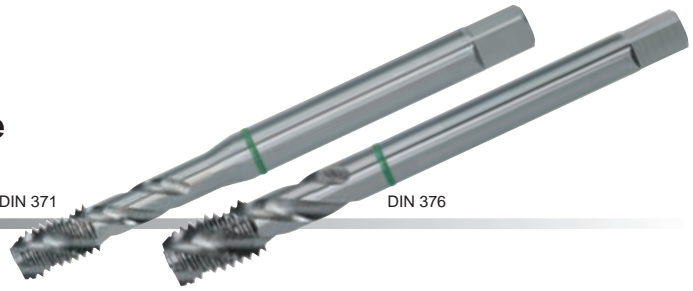
metric ISO-thread DIN 13

## 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.
<b>DIN 371</b>					
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
<b>DIN 376</b>					
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
<b>SET</b>					
M 3 - 12	M 3-4-5-6-8-10 (DIN 371), M 12 (DIN 376)				47863

### Application:

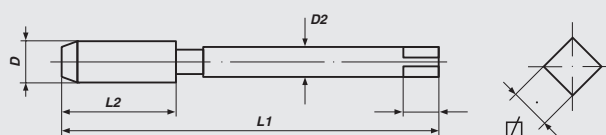
#### for general use

- non abrasive material up to 1000 N/mm<sup>2</sup>
- unalloyed and low alloyed steel
- long chipping material
- for blind holes

### Applicazione

#### per uso universale

- Materiali con buona truciabilità fino a R 1.000 N/mm<sup>2</sup>
- Acciaio non legati e scarsamente legati
- Materiali truciolo lungo
- per fori ciechi





## GREEN RING-Machine Taps

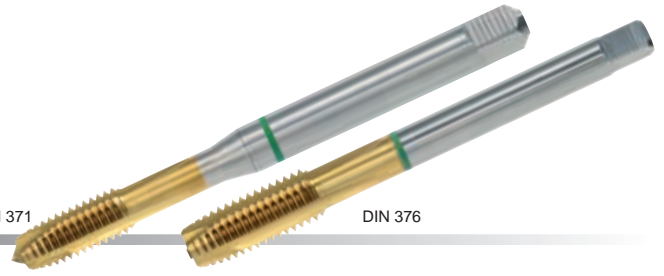
metric ISO-thread DIN 13

### Maschi a macchina con collarino verde

filettatura metrica ISO DIN 13

DIN 371

DIN 376



## DIN 371/376 Form B HSSE-PM-TIN Tol. ISO2/6H

Nominal Diameter D	L 1	L 2	D 2	☒	Art.-No.
<b>DIN 371</b>					
M 3 x 0.5	56	11	3.5	2.7	30031
M 4 x 0.7	63	13	4.5	3.4	30032
M 5 x 0.8	70	14	6.0	4.9	30033
M 6 x 1.0	80	16	6.0	4.9	30034
M 8 x 1.25	90	18	8.0	6.2	30035
M 10 x 1.5	100	22	10.0	8.0	30036
<b>DIN 376</b>					
M 12 x 1.75	110	29	9.0	7.0	30037
M 14 x 2.0	110	30	11.0	9.0	30038
M 16 x 2.0	110	32	12.0	9.0	30039

#### Application: for general use

- non abrasive material up to 1.000 N/mm<sup>2</sup>
- stainless and alloyed steel
- unalloyed and low alloyed steel
- Copper- and Aluminium-alloys
- for through holes

#### Advantages HSSE-PM-TIN

- increased wear resistance and toughness
- TiN-coating improves anti-friction properties, thereby improved wear-resistance and reduced tendency of build-up edge

#### Applicazione per uso universale

- Materiali con buona trucidibilità fino a R 1.000 N/mm<sup>2</sup>
- Acciaio inossidabili e legati
- Acciaio non legati e scarsamente legati
- Leghe di rame e alluminio
- per fori passanti

#### Vantaggio HSSE-PM-TIN

- maggiore resistenza all' abrasione e tenacità
- migliore uniformità per mezzo di rivestimento TiN, riducendo così l'usare e ridotta tendenza di impasti per saldature



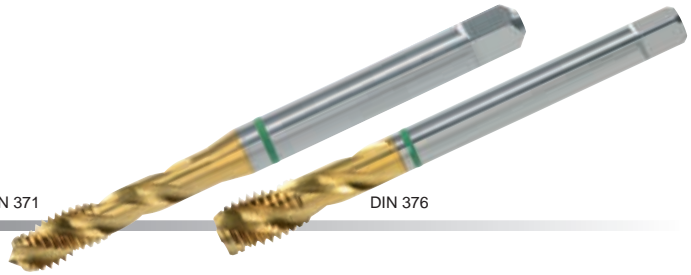
## GREEN RING-Machine Taps

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      HSSE-PM-TIN      Tol. ISO2/6H

Nominal Diameter D	L 1	L 2	D 2	☒	Art.-No.
<b>DIN 371</b>					
M 3 x 0.5	56	6	3.5	2.7	30131
M 4 x 0.7	63	7	4.5	3.4	30132
M 5 x 0.8	70	8	6.0	4.9	30133
M 6 x 1.0	80	10	6.0	4.9	30134
M 8 x 1.25	90	14	8.0	6.2	30135
M 10 x 1.5	100	16	10.0	8.0	30136
<b>DIN 376</b>					
M 12 x 1.75	110	18	9.0	7.0	30137
M 14 x 2.0	110	20	11.0	9.0	30138
M 16 x 2.0	110	22	12.0	9.0	30139

**Application:  
for general use**

- non abrasive material up to 1.000 N/mm<sup>2</sup>
- stainless and alloyed steel
- unalloyed and low alloyed steel
- Copper- and Aluminium-alloys
- for blind holes

**Advantages HSSE-PM-TIN**

- increased wear resistance and toughness
- TiN-coating improves anti-friction properties, thereby improved wear-resistance and reduced tendency of build-up edge

**Applicazione  
per uso universale**

- Materiali con buona trucidibilità fino a R 1.000 N/mm<sup>2</sup>
- Acciaio inossidabili e legati
- Acciaio non legati e scarsamente legati
- Leghe di rame e alluminio
- per fori ciechi

**Vantaggio HSSE-PM-TIN**

- maggiore resistenza all'abrasione e tenacità
- migliore uniformità per mezzo di rivestimento TiN, riducendo così l'usare e ridotta tendenza di impasti per saldature



## 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.
<b>DIN 371</b>					
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
<b>DIN 376</b>					
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
<b>SET</b>					
M 3 - 12	M 3-4-5-6-8-10 (DIN 371), M 12 (DIN 376)				47854

### TiCN

<b>DIN 371</b>					
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
<b>DIN 376</b>					
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/mm<sup>2</sup>

- 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/mm<sup>2</sup>

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

Nominal Diameter D	L 1	L 2	D 2	☒	Art.-No.
<b>DIN 371</b>					
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
<b>DIN 376</b>					
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
<b>SET</b>					
M 3 - 12	M 3-4-5-6-8-10 (DIN 371). M 12 (DIN 376)				47864

### TiCN

<b>DIN 371</b>					
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
<b>DIN 376</b>					
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/mm<sup>2</sup>**

- 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/mm<sup>2</sup>**

- 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



## WHITE RING-Machine Taps

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

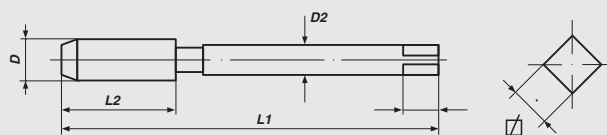
Nominal Diameter D	L 1	L 2	D 2	☒	Art.-No.
<b>DIN 371</b>					
M 3 x 0.5	56	11	3.5	2.7	35226
M 4 x 0.7	63	13	4.5	3.4	35230
M 5 x 0.8	70	16	6.0	4.9	35234
M 6 x 1.0	80	19	6.0	4.9	35238
M 8 x 1.25	90	22	8.0	6.2	35242
M 10 x 1.5	100	24	10.0	8.0	35246
<b>DIN 376</b>					
M 12 x 1.75	110	29	9.0	7.0	35250
M 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
<b>SET</b>					
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/mm<sup>2</sup>**  
- abrasive material  
- chrome-nickel alloys  
- surface treatment: steam tempered  
- for through holes

#### Applicazione:

**Acciaio inossidabile,  
truciolo lungo a 1.000 N/mm<sup>2</sup>**  
- 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.
<b>MF</b> 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
<b>UNC</b> 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
<b>UNF</b> 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
<b>G (BSP)</b> 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:

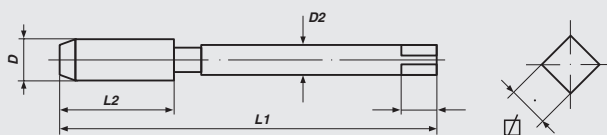
##### Stainless Steel (INOX), long chipping up to 1000 N/mm<sup>2</sup>

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

#### Applicazione:

##### Acciaio inossidabile, truciolo lungo a 1.000 N/mm<sup>2</sup>

- 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**

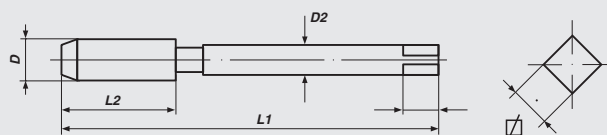
Nominal Diameter D	L 1	L 2	D 2	☒	Art.-No.
<b>DIN 371</b>					
M 3 x 0.5	56	6	3.5	2.7	36226
M 4 x 0.7	63	7	4.5	3.4	36230
M 5 x 0.8	70	8	6.0	4.9	36234
M 6 x 1.0	80	10	6.0	4.9	36238
M 8 x 1.25	90	14	8.0	6.2	36242
M 10 x 1.5	100	16	10.0	8.0	36246
<b>DIN 376</b>					
M 12 x 1.75	110	18	9.0	7.0	36250
M 14 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
<b>SET</b>					
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/mm<sup>2</sup>**  
- abrasive material  
- chrome-nickel alloys  
- surface treatment: steam tempered  
- for blind holes

### Applicazione:

**Acciaio inossidabile,  
truciolo lungo a 1.000 N/mm<sup>2</sup>**  
- 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

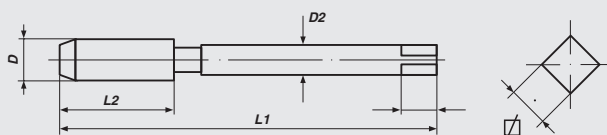
Nominal Diameter D	L 1	L 2	D 2	Ø	Art.-No.
<b>MF</b> DIN 374					
M 5 x 0.5	70	5	3.5	2.7	36903
M 6 x 0.75	80	8	4.5	3.4	36904
M 8 x 0.75	80	8	6.0	4.9	36906
M 8 x 1.0	90	10	6.0	4.9	36907
M 10 x 1.0	90	10	7.0	5.5	36909
M 10 x 1.25	100	16	7.0	5.5	36910
M 12 x 1.25	100	15	9.0	7.0	36913
M 12 x 1.5	100	15	9.0	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
<b>UNC</b> 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
<b>UNF</b> 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
<b>G (BSP)</b> 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/mm<sup>2</sup>**  
- abrasive material  
- chrome-nickel alloys  
- surface treatment: steam tempered  
- for blind holes

**Applicazione:**

**Acciaio inossidabile,  
truciolo lungo a 1.000 N/mm<sup>2</sup>**  
- 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**

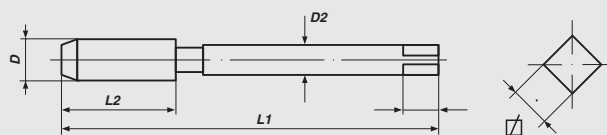
Nominal Diameter D	L 1	L 2	D 2	☒	Art.-No.
<b>DIN 371</b>					
M 3 x 0.5	56	11	3.5	2.7	35126
M 4 x 0.7	63	13	4.5	3.4	35130
M 5 x 0.8	70	16	6.0	4.9	35134
M 6 x 1.0	80	19	6.0	4.9	35138
M 8 x 1.25	90	22	8.0	6.2	35142
M 10 x 1.5	100	24	10.0	8.0	35146
<b>DIN 376</b>					
M 12 x 1.75	110	29	9.0	7.0	35150
M 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
<b>SET</b>					
M 3 - 12	M 3-4-5-6-8-10 (DIN 371), M 12 (DIN 376)				47851

**Application:**

- Cast iron GG**  
**Spheroidal cast iron GGG**
- Magnesium alloys
  - surface treatment nitrided
  - Form C: for through and blind holes

**Applicazione:**

- Ghisa grigia GG**  
**Ghisa sferoidale GGG**
- Leghe di magnesio
  - Superficie: nitrata
  - 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      Tol. ISO2/6H**

Nominal Diameter D	L 1	L 2	D 2	∩	Art.-No.
<b>DIN 371</b>					
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
<b>DIN 376</b>					
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
<b>SET</b>					
M 3 - 12	M 3-4-5-6-8-10 (DIN 371), M 12 (DIN 376)				47860

**Application:**

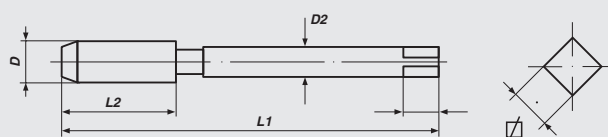
**Aluminium-alloys, long chipping**

- for blind holes
- with 2 flutes

**Applicazione:**

**Alluminio, truciolo lungo**

- per fori ciechi
- A 2 scanalature





## ORANGE RING-Machine Taps

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

Nominal Diameter D	L 1	L 2	D 2	☒	Art.-No.
<b>DIN 371</b>					
M 3 x 0.5	56	11	3.5	2.7	35726
M 4 x 0.7	63	13	4.5	3.4	35730
M 5 x 0.8	70	16	6.0	4.9	35734
M 6 x 1.0	80	19	6.0	4.9	35738
M 8 x 1.25	90	22	8.0	6.2	35742
M 10 x 1.5	100	24	10.0	8.0	35746
<b>DIN 376</b>					
M 12 x 1.75	110	29	9.0	7.0	35750
M 14 x 2.0	110	30	11.0	9.0	35754
M 16 x 2.0	110	32	12.0	9.0	35758
<b>SET</b>					
M 3 - 12	M 3-4-5-6-8-10 (DIN 371), M 12 (DIN 376)				47850

**Application:**

**Ms**  
Brass, short chipping  
- for through and blind holes

**Applicazione:**

**Ms**  
Ottone, truciolo corto  
- per fori passanti e ciechi



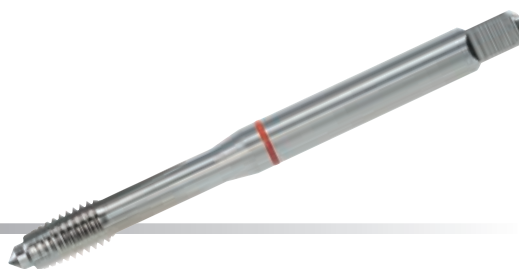


## RED RING-Machine Taps

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.
<b>DIN 371</b>					
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/mm<sup>2</sup> 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/mm<sup>2</sup> 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 + 147 - 149



## 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**

**ToI. ISO2/6H**

Nominal Diameter D			Art.-No.
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#### 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 35° (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/mm<sup>2</sup>
  - 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/mm<sup>2</sup>
  - Acciaio non legati e scarsamente legati
  - Ghisa malleabile e leghe forgiate
- Forma B per fori passanti  
35° 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**

**ToI. ISO2/6H**

Nominal Diameter D			Art.-No.
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#### 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 35°

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/mm<sup>2</sup>

- 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/mm<sup>2</sup>

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

Forma B per fori passanti

35° 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.
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### 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 35°

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/mm<sup>2</sup>**  
- 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/mm<sup>2</sup>**  
- Acciaio resistente al calore truciolo lungo  
- Materiali difficile da tagliare  
Forma B per fori passanti  
35° 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:

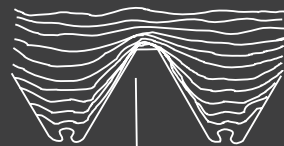
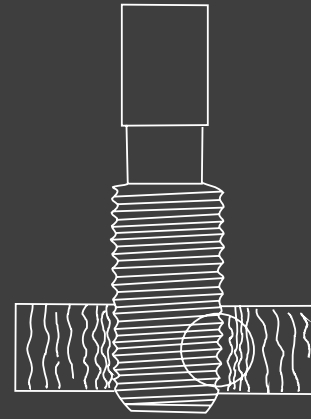
- Acciaio non legati e scarsamente legati
- Acciaio da costruzione
- Acciaio resistenti al calore
- Acciaio inossidabile
- Materiali non ferrosi truciolo lungo (Alluminio, Bronzo, Rame, Ottone)
- Leghe forgiate
- per fori passanti e ciechi

### 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 jaming 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	153	154	155
6G ISO3	156		

### Application:

#### **bright:**

- for nonferrous metal of good ductility

#### **VAP (Steam Tempered):**

- for steel up to approx. 700 N/mm<sup>2</sup>

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

- for steel up to approx. 900 N/mm<sup>2</sup>  
and to increase endurance and cutting speed

### Applicazione:

#### **Lucido:**

- per materiali non ferrosi con buona deformabilità

#### **VAP (vaporizzato):**

- per acciaio a ca. 700 N/mm<sup>2</sup>

#### **TIN (revestimento di nitrurato di titanio):**

- per acciaio a ca. 900 N/mm<sup>2</sup>  
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 e baso 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 Alloyes 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/olii 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**

**ToI. ISO2X/6HX**

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

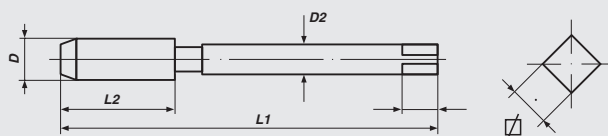
#### bright:

- 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.
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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:**

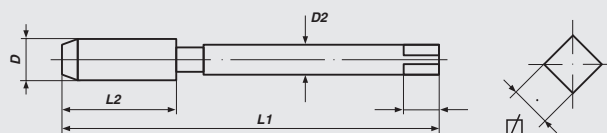
**VAP (Steam Tempered):**

- for steel up to approx. 700 N/mm<sup>2</sup>

**Applicazione:**

**VAP (vaporizzato):**

- per acciaio a ca. 700 N/mm<sup>2</sup>



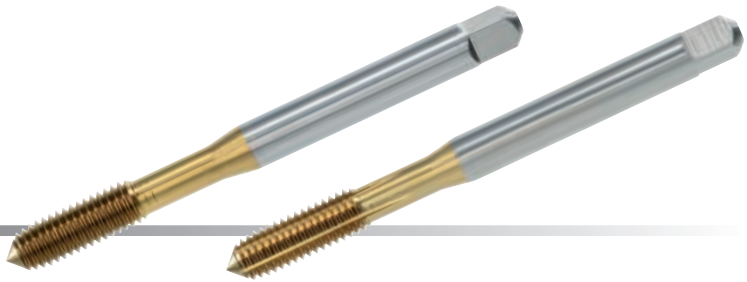


## Fluteless Machine Taps

metric ISO-thread DIN 13

## Maschi a rullare

filettatura metrica ISO DIN 13



**DIN 371/376**

**2.1/2 Thread Start**

**HSSE-TIN**

**ToI. 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:**

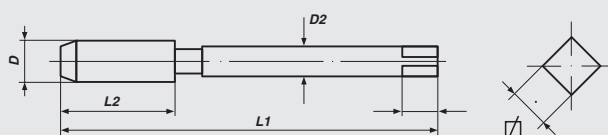
**TIN (Titanium Nitride Coating):**

- for steel up to approx. 900 N/mm<sup>2</sup>  
and to increase endurance and cutting speed

**Applicazione:**

**TIN (revetimento di nitruato di titanio):**

- per acciaio a ca. 900 N/mm<sup>2</sup>  
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.
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**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
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**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
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**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

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

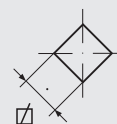
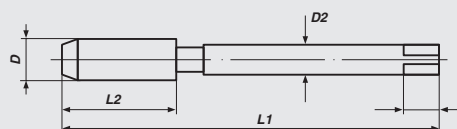
- non abrasive material up to 800 N/mm<sup>2</sup>
- unalloyed and low alloyed steel

### 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 truciabilità fino a R 800 N/mm<sup>2</sup>
- 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	∅	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**

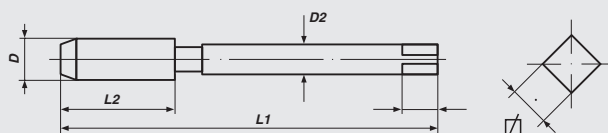
Tr 10 x 2	110	63	7	5.5	79108-L
Tr 10 x 3	125	75	7	5.5	79112-L
Tr 12 x 3	165	111	8	6.2	79116-L
Tr 14 x 3	140	85	10	8.0	79120-L
Tr 14 x 4	170	112	10	8.0	79124-L
Tr 16 x 4	180	116	11	9.0	79128-L
Tr 18 x 4	190	120	12	9.0	79132-L
Tr 20 x 4	200	124	14	11.0	79136-L
Tr 22 x 5	235	155	16	12.0	79140-L
Tr 24 x 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/mm<sup>2</sup>
- unalloyed and low alloyed steel
- for thread depth up to 1 x D
- for through holes

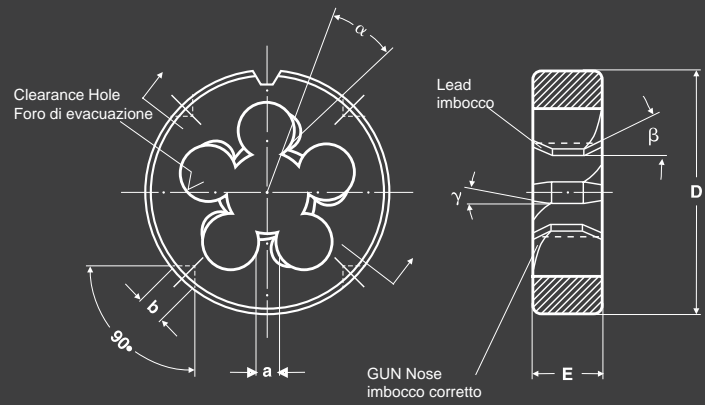
**Applicazione:****per uso universale**

- Materiali buona trucioidibilità fino a R 800 N/mm<sup>2</sup>
- Acciaio non legati e scarsamente legati
- profondità di maschiatura a 1 x D
- per fori passanti



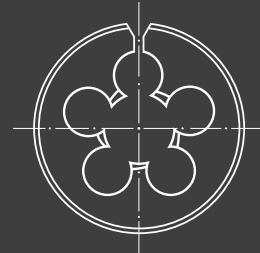


ROUND DIES  
 HEXAGON DIE NUTS  
 FILIERE  
 FILIERE ESAGONALI

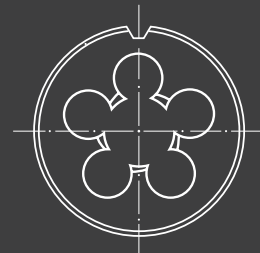


D	Outside diameter	Diametro esterno
E	Width of die	Spessore
a	Width of land	Ampiezza del dente
b	Hole for holding screws	Diametro fissaggio vite
$\alpha$	Rake angle	Angolo di taglio
$\beta$	Lead angle	Angolo dell'imbocco
$\gamma$	Angle of gun nose	Angolo dell'imbocco corretto

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  
HEXAGON DIE NUTS  
FILIERE  
FILIERE ESAGONALI

	HSS 	HSSE 	LH 	HSS 	LH 
M	162	182	185	192	201
M - 6e	164				
Mf	165	183	186	193	
BSW	171		189	195	
BSF	171			195	
BA	172				
UNC	173		190	196	
UNF	174		190	196	
UNEF	175				
8 - UN				197	
G (BSP)	176	184	191	198	202
R (BSPT)	177			199	
PG	178				
NPT	179			200	
NPTF	179				
FG	180				
BSC	180				
Vg	181				





**Round Dies**  
metric ISO-thread DIN 13

**Filiere tonde**  
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/mm<sup>2</sup>
- unalloyed and low alloyed steel

**Applicazione:**

**per uso universale**

- Materiali con buona truciocibilità fino a R 800 N/mm<sup>2</sup>
- Acciaio non legati e scarsamente legati



## Round Dies

metric ISO-thread DIN 13

## Filiere tonde

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/mm<sup>2</sup>
- unalloyed and low alloyed steel

**Applicazione:  
per uso universale**

- Materiali con buona truciabilità fino a R 800 N/mm<sup>2</sup>
- Acciaio non legati e scarsamente legati



**Round Dies**  
metric ISO-thread DIN 13

**Filiere tonde**  
filettatura metrica ISO DIN 13



**DIN 223 (DIN EN 22568)**

**HSS**

**Tol. 6e**

**M**

Nominal Diameter mm	Ø o / d	Art.-No.
M 3 x 0.5	20 x 5	27503
M 4 x 0.7	20 x 5	27505
M 5 x 0.8	20 x 7	27507
M 6 x 1.0	20 x 7	27509
M 8 x 1.25	25 x 9	27511
M 10 x 1.5	30 x 11	27513
M 12 x 1.75	38 x 14	27515
M 14 x 2.0	38 x 14	27516
M 16 x 2.0	45 x 18	27517
M 18 x 2.5	45 x 18	27518
M 20 x 2.5	45 x 18	27519

**Application:  
for general use**

- non abrasive material up to 800 N/mm<sup>2</sup>
- unalloyed and low alloyed steel

**Applicazione:  
per uso universale**

- Materiali con buona trucioidibilità fino a R 800 N/mm<sup>2</sup>
- Acciaio non legati e scarsamente legati



## Round Dies

metric-fine ISO-thread DIN 13

## Filiere tonde

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/mm<sup>2</sup>
- unalloyed and low alloyed steel

**Applicazione:  
per uso universale**

- Materiali con buona trucidibilità fino a R 800 N/mm<sup>2</sup>
- Acciaio non legati e scarsamente legati



## Round Dies

metric-fine ISO-thread DIN 13

## Filiere tonde

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

metric-fine ISO-thread DIN 13

## Filiere tonde

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

metric-fine ISO-thread DIN 13

## Filiere tonde

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

metric-fine ISO-thread DIN 13

## Filiere tonde

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**

metric-fine ISO-thread DIN 13

**Filiere tonde**

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

Whitworth-thread BS 84

## Filiere tonde

filettatura Whitworth BS 84



**DIN 223 (DIN EN 22568)**

**HSS**

**BSW / BSF**

Nominal Diameter	Ø o / d	Art.-No.
<b>BSW</b>		
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
<b>BSF</b>		
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/mm<sup>2</sup>
- unalloyed and low alloyed steel

**Applicazione:  
per uso universale**

- Materiali con buona trucidibilità fino a R 800 N/mm<sup>2</sup>
- Acciaio non legati e scarsamente legati





## Round Dies

Unified Coarse thread

## Filiere tonde

filettatura unificata, serie grossa ANSI B1.1



### DIN 223 (DIN EN 22568)

HSS

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/mm<sup>2</sup>
- unalloyed and low alloyed steel

**Applicazione:  
per uso universale**

- Materiali con buona trucidibilità fino a R 800 N/mm<sup>2</sup>
- Acciaio non legati e scarsamente legati



**Round Dies**  
Unified Fine thread

**Filiere tonde**  
filettatura unificata, serie fina ANSI B1.1



**DIN 223 (DIN EN 22568)**

**HSS**

**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/mm<sup>2</sup>
- unalloyed and low alloyed steel

**Applicazione:  
per uso universale**

- Materiali con buona truciabilità fino a R 800 N/mm<sup>2</sup>
- Acciaio non legati e scarsamente legati



## Round Dies

Unified Extra Fine thread ANSI B 1.1

## Filiere tonde

filettatura unificata, serie extra-fina ANSI B1.1



**DIN 223 (DIN EN 22568)**

**HSS**

**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/mm<sup>2</sup>
- unalloyed and low alloyed steel

**Applicazione:  
per uso universale**

- Materiali con buona truciabilità fino a R 800 N/mm<sup>2</sup>
- Acciaio non legati e scarsamente legati



**Round Dies**  
Pipe-thread DIN ISO 228

**Filiere tonde**  
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	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/mm<sup>2</sup>
- unalloyed and low alloyed steel

**Applicazione:  
per uso universale**

- Materiali con buona trucioidibilità fino a R 800 N/mm<sup>2</sup>
- Acciaio non legati e scarsamente legati







## Round Dies

armoured tube thread DIN 40 430

## Filiere tonde

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/mm<sup>2</sup>
- unalloyed and low alloyed steel

**Applicazione:  
per uso universale**

- Materiali con buona truciabilità fino a R 800 N/mm<sup>2</sup>
- Acciaio non legati e scarsamente legati



## Round Dies

american tapered pipe thread, taper 1:16

## Filiere tonde

filettatura americana conica per tubi, cono 1:16



## HSS

## NPT / NPTF

Nominal Diameter	∅ o / d	Art.-No.
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### 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/mm<sup>2</sup>
- unalloyed and low alloyed steel

#### Applicazione: per uso universale

- Materiali con buona trucioidibilità fino a R 800 N/mm<sup>2</sup>
- Acciaio non legati e scarsamente legati



## Round Dies

Cycle thread DIN 79012 and BS 811

## Filiere tonde

filettatura per biciclette DIN 79012 e BS 811



**DIN 223 (DIN EN 22568)**

**HSS**

**FG / BSC**

Nominal Diameter	Ø o / d	Art.-No.
<b>FG (DIN 79012)</b>		
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
<b>BSC (BS 811)</b>		
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/mm<sup>2</sup>
- unalloyed and low alloyed steel

**Applicazione:  
per uso universale**

- Materiali con buona truciabilità fino a R 800 N/mm<sup>2</sup>
- Acciaio non legati e scarsamente legati



## Round Dies

Valve thread DIN 7756

## Filiere tonde

filettatura per valvole DIN 7756



**DIN 223 (DIN EN 22568)**

**HSS**

**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/mm<sup>2</sup>
- unalloyed and low alloyed steel

**Applicazione:  
per uso universale**

- Materiali con buona trucioidibilità fino a R 800 N/mm<sup>2</sup>
- Acciaio non legati e scarsamente legati



**Round Dies, gun nosed**  
metric ISO-thread DIN 13

**Filiera tonda 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, gun nosed**  
metric-fine ISO-thread DIN 13

**Filiere tonde 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 jaming 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, gun nosed**

Pipe-thread DIN ISO 228

**Filiera tonde con imbocco corretto**

filettatura per tubi gas DIN ISO 228



**DIN 5158 (DIN EN 24231)**

**HSS-E**

**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 jaming of swarf

**Application:**

- abrasive material up to 1200 N/mm<sup>2</sup>
- 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, *Left Hand***

metric ISO-thread DIN 13

**Filiere tonde, *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/mm<sup>2</sup>
- unalloyed and low alloyed steel

**Applicazione:****per uso universale**

- Materiali con buona truciabilità fino a R 800 N/mm<sup>2</sup>
- Acciaio non legati e scarsamente legati



**Round Dies, *Left Hand***  
metric-fine ISO-thread DIN 13

**Filiere tonde, *filetto sinistro***  
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	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/mm<sup>2</sup>
- unalloyed and low alloyed steel

**Applicazione:**

**per uso universale**

- Materiali con buona trucioidibilità fino a R 800 N/mm<sup>2</sup>
- Acciaio non legati e scarsamente legati

**Round Dies, *Left Hand***

metric-fine ISO-thread DIN 13

**Filiere tonde, *filetto sinistro***

filettatura metrica fine 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/mm<sup>2</sup>
- unalloyed and low alloyed steel

**Applicazione:****per uso universale**

- Materiali con buona truciabilità fino a R 800 N/mm<sup>2</sup>
- Acciaio non legati e scarsamente legati



**Round Dies, *Left Hand***  
metric-fine ISO-thread DIN 13

**Filiere tonde, *filetto sinistro***  
filettatura metrica fine 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/mm<sup>2</sup>
- unalloyed and low alloyed steel

**Applicazione:**

**per uso universale**

- Materiali con buona trucioidibilità fino a R 800 N/mm<sup>2</sup>
- Acciaio non legati e scarsamente legati





**Round Dies, *Left Hand***

Unified thread ANSI B 1.1

**Filiere tonde, *filetto sinistro***

filettatura unificata ANSI B1.1



**DIN 223 (DIN EN 22568)**

**HSS**

**UNC / UNF**

Nominal Diameter mm	Width across flats mm	Art.-No.
<b>UNC</b>		
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
<b>UNF</b>		
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/mm<sup>2</sup>
- unalloyed and low alloyed steel

**Applicazione:**

**per uso universale**

- Materiali con buona truciabilità fino a R 800 N/mm<sup>2</sup>
- Acciaio non legati e scarsamente legati





**Hexagon Die Nuts**  
metric ISO-thread DIN 13

**Filiere esagonali**  
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

metric-fine ISO-thread DIN 13

## Filiere esagonali

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**  
metric-fine ISO-thread DIN 13

**Filiere esagonali**  
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

Whitworth-thread BS 84

## Filiere esagonali

filettatura Whitworth BS 84



**DIN 382**

**HSS**

**BSW / BSF**

Nominal Diameter mm	Width across flats mm	Art.-No.
<b>BSW</b>		
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
<b>BSF</b>		
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

Whitworth-thread BS 84

## Filiere esagonali

filettatura unificata ANSI B1.1



**DIN 382**

**HSS**

**UNC / UNF**

Nominal Diameter	Width across flats mm	Art.-No.
<b>UNC</b>		
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
<b>UNF</b>		
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

Unified thread ANSI B 1.1

## Filiere esagonali

filettatura unificata ANSI B1.1



**DIN 382**

**HSS**

**Tol. 2B**

**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



## Hexagon Die Nuts

Pipe-thread DIN ISO 228

## Filiere esagonali

filettatura per tubi gas DIN ISO 228



**DIN 382**

**HSS**

**G (BSP)**

Nominal Diameter	Width across flats mm	Art.-No.
G 1/8 x 28	27 x 11	25512
G 1/4 x 19	36 x 10	25514
G 3/8 x 19	41 x 14	25516
G 1/2 x 14	41 x 14	25518
G 5/8 x 14	50 x 16	25520
G 3/4 x 14	50 x 16	25522
G 7/8 x 14	60 x 18	25524
G 1" x 11	60 x 18	25526
G 1.1/8 x 11	70 x 20	25530
G 1.1/4 x 11	70 x 20	25534
G 1.3/8 x 11	85 x 22	25538
G 1.1/2 x 11	85 x 22	25542
G 1.5/8 x 11	85 x 22	25546
G 1.3/4 x 11	100 x 22	25550
G 2" x 11	100 x 22	25554

**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

american tapered pipe thread, taper 1:16

## Filiere esagonali

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, *Left Hand***  
metric ISO-thread DIN 13**Filiere esagonali, *filetto sinistro***  
filettatura metrica ISO DIN 13**DIN 382****HSS****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



**Hexagon Die Nuts, *Left Hand***  
Pipe-thread DIN ISO 228

**Filiera esagonali, *filetto sinistro***  
filettatura per tubi gas DIN ISO 228



**DIN 382**

**HSS**

**G (BSP)**

Nominal Diameter	Width across flats mm	Art.-No.
G 1/8 x 28	27 x 11	25612
G 1/4 x 19	36 x 10	25614
G 3/8 x 19	41 x 14	25616
G 1/2 x 14	41 x 14	25618
G 5/8 x 14	50 x 16	25620
G 3/4 x 14	50 x 16	25622
G 1" x 11	60 x 18	25626
G 1.1/8 x 11	70 x 20	25630
G 1.1/4 x 11	70 x 20	25634
G 1.3/8 x 11	85 x 22	25638
G 1.1/2 x 11	85 x 22	25642
G 1.3/4 x 11	100 x 22	25650
G 2" x 11	100 x 22	25654

**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	204 - 206
Hand Taps and Dies Maschi a mano e filiera	207 - 213
Hand Taps Maschi a Mano	213, 215, 220
Round Dies Filiera	214, 220
Hexagon Die Nuts Filiera esagonali	214
Short Machine Taps Maschi macchina corti	215
Machine Taps Maschi a macchina	216 - 219
Combined Taps Maschi combinati con punte	217, 221, 223
Tools with hexagon shank Utensili con attacco esagonale	221 - 225
Q.C.-Boxes Cassetta Q. C.	223 - 225
Displays Presentatore	226 - 228





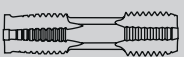
## HexTap Sets

in wooden boxes

## Assortimento HexTap

in cassetta di legna



	Art.-No
<b>M</b> 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
<b>Mf</b> 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
<b>G (BSP)</b> 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



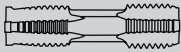

## HexTap Sets

in wooden boxes

## Assortimento HexTap

in cassetta di legna



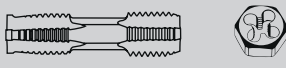
		Art.-No
<b>M</b>		
M 3-4-5-6-8-10-12-14-16-18-20		48621
M 3-4-5-6-8-10-12-14-16-18-20-22-24		48622
M 3-4-5-6-8-10-12-14-16-18-20-22-24-27-30		48623
<b>Mf</b>		
M 4x0.5 - 5x0.5 - 6x0.75 - 8x0.75 - 8x1 - 10x1		48625
M 12x1 - 12x1.5 - 14x1.25 - 14x1.5 - 16x1.5		
M 18x1.5 - M 20x1.5		
M 4x0.5 - 5x0.5 - 6x0.75 - 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		
<b>G (BSP)</b>		
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
<p><b>M</b> M 3-4-5-6-8-10-12-14-16-18-20</p>	48641
<p>M 3-4-5-6-8-10-12-14-16-18-20-22-24</p>	48642
<p>M 3-4-5-6-8-10-12-14-16-18-20-22-24-27-30</p>	48643
<p><b>Mf</b> 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</p>	48645
<p>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</p>	48646
<p><b>G (BSP)</b> G 1/8 - 1/4 - 3/8 - 1/2 - 3/4 - 1"</p>	48648
<p>G 1/8 - 1/4 - 3/8 - 1/2 - 3/4 - 1" - 1.1/4 - 1.1/2</p>	48649

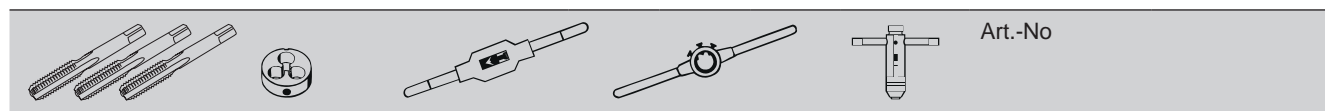


## Tap & Die Sets

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						



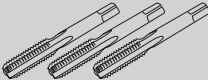

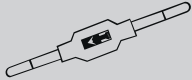


## Tap & Die Sets

in metal cases  
DIN standards

## Utensili per filettare in assortimento

in cassetta metallica  
versione DIN



					Art.-No
<b>G (BSP)</b>					
G 1/8-1/4-3/8-1/2-3/4-1"	No. 1 + 3 + 5	30 x 11 55 x 16	38 x 10 65 x 18	45 x 14	48020
G 1/8-1/4-3/8-1/2-5/8-3/4-7/8-1"	No. 1 + 3 + 5	30 x 11 55 x 16	38 x 10 65 x 18	45 x 14	48021
G 1/4-3/8-1/2-3/4-1"-1.1/4-1.1/2	No. 2 + 4 + 7	38 x 10 65 x 18	45 x 14 75 x 20	55 x 16 90 x 22	48022
<b>BSW</b>					
BSW 1/8-3/16-1/4-5/16-3/8-7/16-1/2	No. 1 + 2	20 x 5 30 x 11	20 x 7 38 x 14	25 x 9	No. 1 48030
BSW 1/4-5/16-3/8-7/16-1/2	No. 1 + 2	20 x 7 38 x 14	25 x 9	30 x 11	No. 1 48031
BSW 1/4-5/16-3/8-7/16-1/2-5/8-3/4	No. 1 + 3	20 x 7 38 x 14	25 x 9 45 x 18	30 x 11	48032
BSW 1/4-5/16-3/8-7/16-1/2-5/8	No. 1 + 4	20 x 7 38 x 14	25 x 9 45 x 18	30 x 11 55 x 22	48034
BSW 3/4-7/8-1"	No. 1	20 x 7	25 x 9	30 x 11	48035
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 65 x 25	45 x 18	55 x 22	
<b>BSF</b>					
BSF 1/4-5/16-3/8-7/16-1/2	No. 1 + 2	20 x 7 38 x 10	25 x 9	30 x 11	No. 1 48041
BSF 1/4-5/16-3/8-7/16-1/2-5/8-3/4	No. 1 + 3	20 x 7 38 x 10	25 x 9 45 x 14	30 x 11	48042
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	
<b>BSW / BSF</b>					
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		



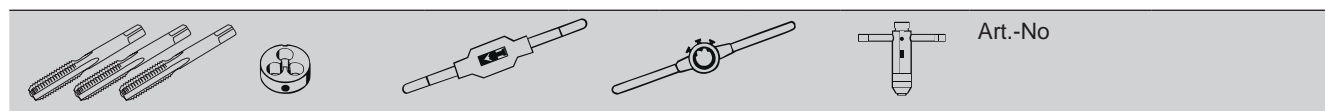


## Tap & Die Sets

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 55 x 22	38 x 14 65 x 25	45 x 18		48025
NPT 1/8-1/4-3/8-1/2-3/4-1" NPT 1.1/4-1.1/2-2"	No. 2 + 4 + 7	30 x 11 55 x 22 90 x 36	38 x 14 65 x 25 105 x 36	45 x 18 75 x 30		48027

### UNC

UNC 1/4-5/16-3/8-7/16-1/2	No. 1 + 2	20 x 7 38 x 14	25 x 9	30 x 11	No. 1	48050
UNC 1/4-5/16-3/8-7/16-1/2-5/8-3/4	No. 1 + 3	20 x 7 38 x 14	25 x 9 45 x 18	30 x 11		48051
UNC 1/4-5/16-3/8-7/16-1/2-5/8 UNC 3/4-7/8-1"	No. 1 + 4	20 x 7 38 x 14	25 x 9 45 x 18	30 x 11 55 x 22		48053
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 65 x 25	45 x 18	55 x 22		

### UNF

UNF 1/4-5/16-3/8-7/16-1/2	No. 1 + 2	20 x 7 38 x 10	25 x 9	30 x 11	No. 1	48060
UNF 1/4-5/16-3/8-7/16-1/2-5/8-3/4	No. 1 + 3	20 x 7 38 x 10	25 x 9 45 x 14	30 x 11		48061
UNF 1/4-5/16-3/8-7/16-1/2-5/8 UNF 3/4-7/8-1"	No. 1 + 4	20 x 7 38 x 10	25 x 9 45 x 14	30 x 11 55 x 16		48063

### UNC / UNF

UNC/UNF 1/4-5/16-3/8-7/16-1/2	No. 1 + 3	20 x 7 38 x 14	25 x 9 45 x 18	30 x 11		48066
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## Tap & Die Sets

in metal cases  
DIN standards

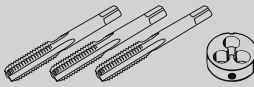










## Utensili per filettare in assortimento

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  
[Rougher piloted](#)  
Round Dies DIN 223, HSSE  
+ 7 Guides for Round Dies

Maschi a mano DIN 352, HSSE

[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
F.Z.1	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
S.F.1	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	No. 1	20 x 5	20 x 7	25 x 9	No. 1 No. 2	49201
	M 16-18-20	No. 3	No. 3	30 x 11	38 x 14	45 x 18		
<b>HSSE</b> <b>drillbox</b>	M 3-4-5-6-8-10-12-14	No. 1	No. 1	20 x 5	20 x 7	25 x 9	No. 1 No. 2	49251
	M 16-18-20	No. 3	No. 3	30 x 11	38 x 14	45 x 18		
<b>LH</b> <b>drillbox</b>	M 3-4-5-6-8-10-12-14	No. 1	No. 1	20 x 5	20 x 7	25 x 9	No. 1 No. 2	49271
	M 16-18-20	No. 3	No. 3	30 x 11	38 x 14	45 x 18		
P.V.3	M 5-6-8-10-12-14	No. 1	No. 1	20 x 7	25 x 9	30 x 11	No. 1 No. 2	49301
	M 16-18-20	No. 3	No. 3	38 x 14	45 x 18			
P.V.5 <b>drillbox</b>	M 3-4-5-6-8-10-12-14	No. 1	No. 1	20 x 5	20 x 7	25 x 9	No. 1 No. 2	49205
	M 16-18-20	No. 3	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

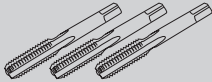
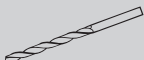
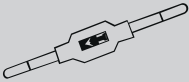

Hand Taps DIN 352

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

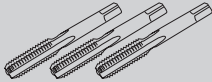

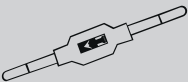


Round Dies 25 x 9 mm  $\varnothing$

Maschi a mano DIN 352

Serie 3 pezzi

Filiera tonde 25 x 9  $\varnothing$



					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	<b>HSSE</b> 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	
<b>LH</b>	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

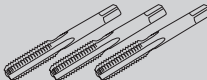
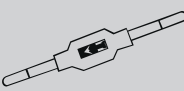

## Utensili per filettare in assortimento

in cassetta di plastica  
versione DIN

Hand Taps DIN 352  
in sets of 3 pieces

Maschi a mano DIN 352  
Serie 3 pezzi

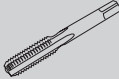
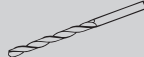
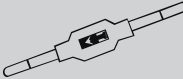



				Art.-No
P.K.20	M 3-4-5-6-8-10-12	No. 1.1/2		47001
P.K.21	M 3-4-5-6-8-10-12	No. 1.1/2	No. 1	47005
<b>HSSE</b>	M 3-4-5-6-8-10-12	No. 1.1/2	No. 1	47055
<b>LH</b>	M 3-4-5-6-8-10-12	No. 1.1/2	No. 1	47075

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


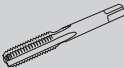

## Utensili per filettare in assortimento

in cassetta di plastica



Machine Taps ISO 529  
Spiral Point (Form B)

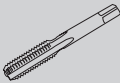
Maschi a macchina ISO 529  
con imbocco corretto (Forma B)

			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

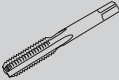
## Maschi a macchina

in cassetta di plastica

Machine Taps **HSSE**  
Spiral Point and Spiral Flute

Maschi a macchina **HSSE**  
con imbocco corretto + con spirale destra a 35°

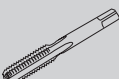


			Art.-No
			
P.K.40	M 3-4-5-6-8-10-12		47901
P.K.41	M 3-4-5-6-8-10-12	<b>TIN</b>	47921

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

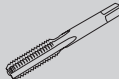







Machine Taps **HSSE**

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	<b>TIN</b>		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			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	<b>TIN</b>	2.5/3.3/4.2/5.0/6.8/8.5/10.2 mm	47836
	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



## Machine Tap Sets

in plastic boxes

## Maschi a macchina

in cassetta di plastica

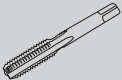



Machine Taps **HSSE**

Spiral Flute

Maschi a macchina **HSSE**

con spirale destra a 35°

				Art.-No
P.K.30	M 3-4-5-6-8-10-12			47817
P.K.31	M 3-4-5-6-8-10-12	<b>TIN</b>		47827
●	M 3-4-5-6-8-10-12			47863
●	M 3-4-5-6-8-10-12			47864
○	M 3-4-5-6-8-10-12			47862
P.K.47	M 3-4-5-6-8-10-12		2.5/3.3/4.2/5.0/6.8/8.5/10.2 mm	47847
P.K.48	M 3-4-5-6-8-10-12	<b>TIN</b>	2.5/3.3/4.2/5.0/6.8/8.5/10.2 mm	47848
●	M 3-4-5-6-8-10-12		2.5/3.3/4.2/5.0/6.8/8.5/10.2 mm	47866
●	M 3-4-5-6-8-10-12		2.5/3.3/4.2/5.0/6.8/8.5/10.2 mm	47867
○	M 3-4-5-6-8-10-12		2.5/3.3/4.2/5.0/6.8/8.5/10.2 mm	47865






## Electrical Conduit Set

in plastic box

## Assortimento per tubatura elettrica

in cassetta di plastica



			Art.-No
M 20x1.5 - M 25x1.25	M 20x1.5 - M 25x1.25	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

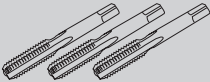
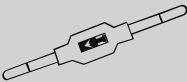


Hand Taps DIN 352

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 <b>TIN</b>		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


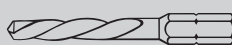
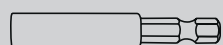


### Form D

M 3-10

HSS-G

ToI. 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

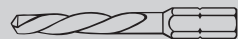
### Assortimento di punte con attacco esagonale 1/4"

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

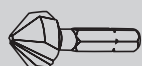
### Assortimento di frese per svasare

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**

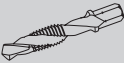
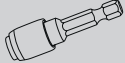
**Combined Bits**

**Assortimento di maschi a macchina combinati**



**M 3 - M 10**

**HSS-G**

		Art.-No
M 3-4-5-6-8-10	non-magnetic 1/4"	67421

**Q.C. 2**


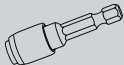

**Threading-Bits**

**Maschi  
con attacco esagonale 1/4"**



**M 3 - M 10**

**HSS-G**

			Art.-No
M 3-4-5-6-8-10	non-magnetic 1/4"	non-magnetic 1/4"	67422



**Q.C. 3**

**Countersink Bits**

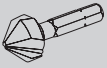
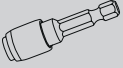
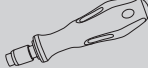
**Frese per svasare**

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**




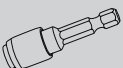
**Punte**

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**




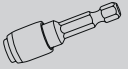
**WOOD Drill Bits**

**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**

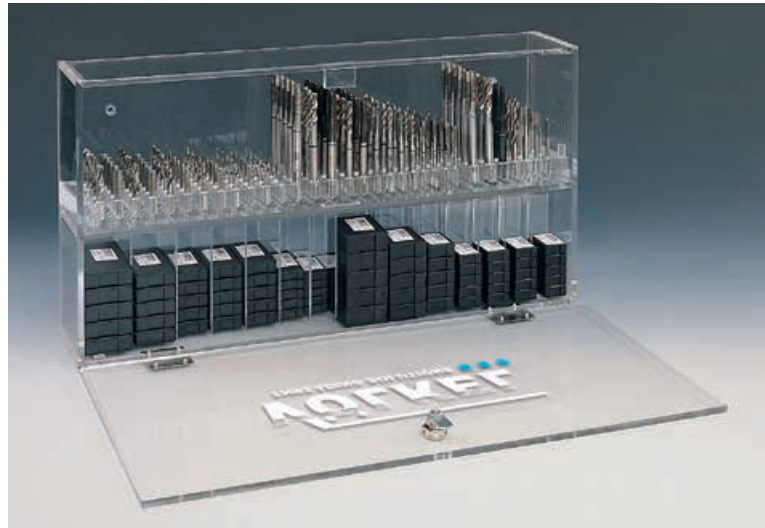
**HSS-G**

		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	230
Engineering drawing of Taps Disegni tecnici di maschi	232
Leeds of Hand Taps Imbocco maschi a mano	232
Engineering drawing of Dies Disegni tecnici di filiere	233
Leads of Machine Taps Imbocco maschi a macchina	233
Tolerance classes Classe di tolleranza	234
Conversion table pitch per inch into mm Tabella di conversione passo del filetto pollice a mm	234
Conversion table of tensile strength and hardness Tabella conversione resistenza e durezza	235
Conversion table of cutting speed Conversione della Velocità di taglio	236
Recommended cutting speed Velocità di taglio raccomandato	237
Conversion table inch-mm Conversione pollice-mm	238
Recommended outside diameter for bolt thread Diametri dei perni da filettare raccomandato	239
Recommended tapping drill sizes Prefori per maschi raccomandato	240



SURFACE FINISHES  
ACABADOS SUPEFICIALES



Each VÖLKEL Tap and each VÖLKEL Die can be supplied with any coating or surface finish quickly.

Ogni maschi VÖLKEL e filiere VÖLKEL 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 Nitruro 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.

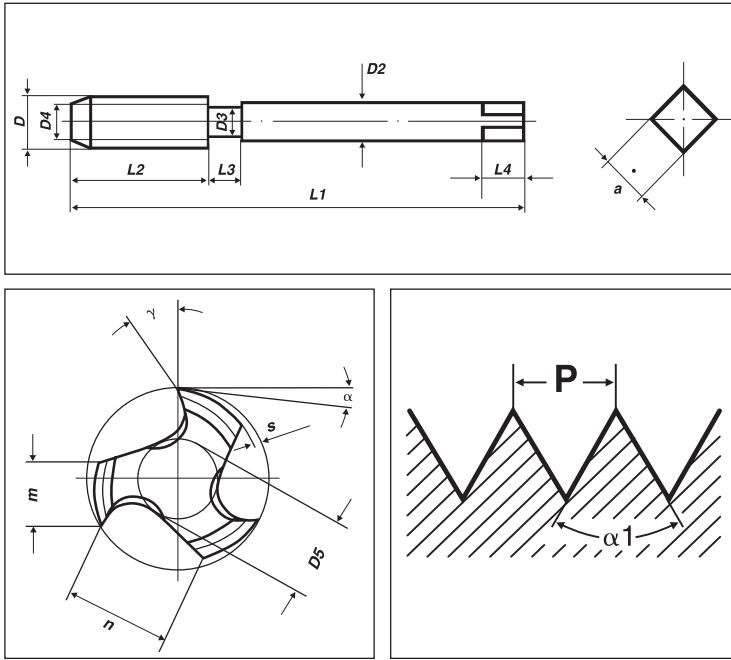
I maschi rivestiti al TiN possono essere utilizzati con velocità di taglio nettamente più elevate.

### **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 carbonitruro di titanio):**

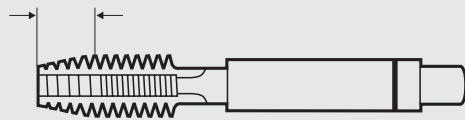
Il rivestimento TiCN è particolarmente indicato per acciai ad elevata resistenza all'abrasione e materiali altamente abrasivi. Il rivestimento TiCN ha una durezza pari a 3.000 HV quindi risulta essere più duro rispetto al rivestimento TiN (2.600 HV); ciò comporta un miglioramento della resistenza all'usura 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.



<b>D</b> Nominal diameter	Diametro nominale
<b>D2</b> Shank diameter	Diametro del gambo
<b>D3</b> Neck diameter	Diametro dell'imbocco
<b>D4</b> Point diameter	Diametro del collarino
<b>D5</b> Web diameter	Diametro del nucleo
<b>L1</b> Overall length	Lunghezza totale
<b>L2</b> Thread length	Lunghezza filetto
<b>L3</b> Neck length	Lunghezza utile
<b>L4</b> Square length	Lunghezza quadro
<b>P</b> Pitch	Passo
<b>a</b> Square size	Quadro
<b>m</b> Land width	Larghezza settore
<b>n</b> Flute width	Larghezza scanalatura
<b>s</b> Thread relief	Spoglia sul filetto
<b>α</b> Relief angle	Angolo di spoglia sul filetto
<b>γ</b> Rake angle	Angolo di taglio
<b>α<sub>1</sub></b> Thread angle	Angolo del profilo

### Leads of Hand Taps, Sets of 3 pcs. Lunghezza di Imbocco – Maschi a mano, serie 3 pezzi

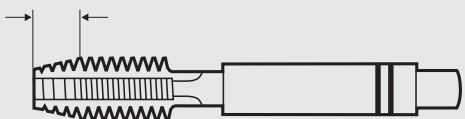
6-8 threads/spire



**Nr. 1**

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

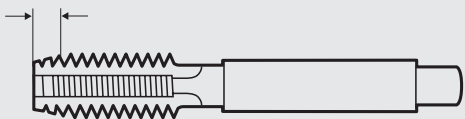
4-5 threads/spire



**Nr. 2**

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

2-3 threads/spire

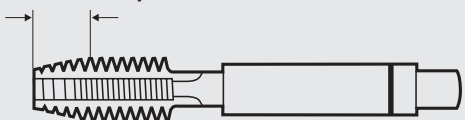


**Nr. 3**

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

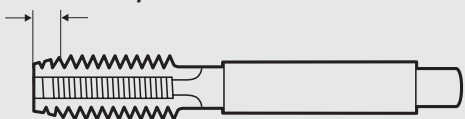
5-6 threads/spire



**Nr. 1**

Rougher, 5-6 Threads Lead  
Sgrossatore, Imbocco a 6-8 spire

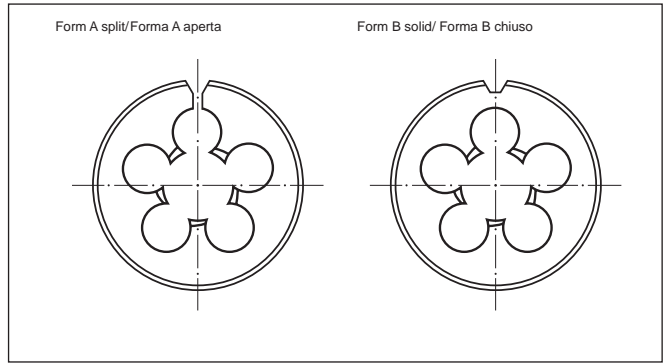
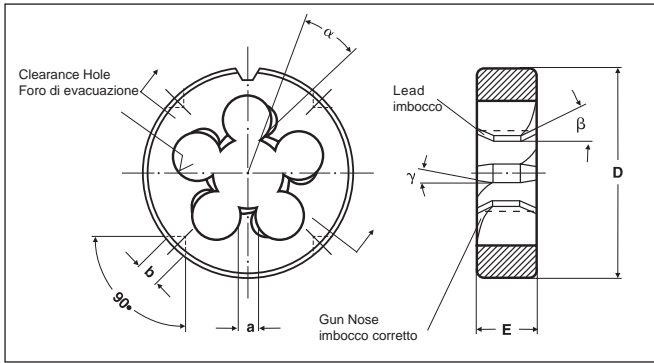
2-3 threads/spire



**Nr. 2**

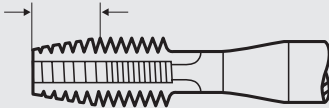
Finisher, 2-3 Threads Lead  
Finitore, Imbocco a 2-3 spire





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

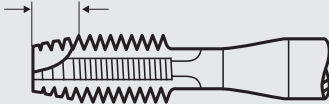
**6-8 threads/spire**



**Form A**

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

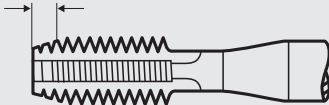
**4-5 threads/spire**



**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

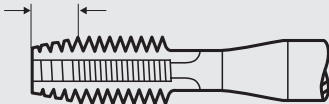
**2-3 threads/spire**



**Form C**

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

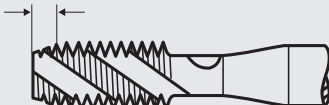
**4-5 threads/spire**



**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 dell rivestimento galvanico / F = fattore dipendente di angolo del profilo a ( $F = 2 / \sin / 2$ )

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	P (Gg/1")	mm	P (Gg/1")	mm
100	0,254 000	24	1,058 333	5	5,080 000
96	0,264 583	22	1,154 545	4.1/2	5,644 444
80	0,317 500	20	1,270 000	4	6,350 000
72	0,352 778	19	1,336 842	3.1/2	7,257 143
64	0,396 875	18	1,411 111	3.1/4	7,815 385
60	0,423 333	16	1,587 500	3	8,466 667
56	0,453 571	14	1,814 286	2.7/8	8,834 783
48	0,529 167	13	1,953 846	2.3/4	9,236 364
44	0,577 273	12	2,116 667	2.5/8	9,676 190
40	0,635 000	11.1/2	2,208 696	2.1/2	10,160 000
36	0,705 555	11	2,309 091	2.1/4	11,288 889
32	0,793 750	10	2,540 000	2	12,700 000
28	0,907 143	9	2,822 222		
27	0,940 741	8	3,175 000		
26	0,976 923	7	3,628 571		
25	1,016 000	6	4,233 333		



CONVERSION TABLE OF TENSILE STRENGTH AND HARDNESS\*  
 TABELLA CONVERSIONE RESISTENZA E DUREZZA\*

N/mm <sup>2</sup>	HRC	Rockwell			Vickers HV (≥98N)	Brinell HB 30
		HRA	HRB	HRF		
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	Revolutions per Minute (rpm) giri al minuto U/min												
mm	inch												
1,6	1/16	800	1194	1592	1791	1988	2386	2983	3579	4176	4971	5369	7158
1,8		708	1065	1415	1598	1768	2121	2652	3182	3712	4419	4743	6364
2	3/32	637	955	1274	1433	1591	1909	2386	2863	3341	3977	4295	5727
2,2		579	869	1158	1303	1446	1736	2169	2603	3037	3616	3905	5207
2,5		510	764	1019	1147	1274	1527	1909	2291	2673	3182	3436	4582
3	1/8	425	637	849	955	1061	1273	1591	1909	2227	2651	2864	3818
3,5		364	546	728	819	909	1091	1364	1636	1909	2273	2455	3273
4	5/32	318	478	637	718	796	955	1193	1432	1671	1989	2148	2864
4,5		283	425	566	637	707	849	1061	1273	1485	1768	1909	2546
5	3/16	255	382	510	573	637	764	955	1146	1337	1591	1719	2292
6	1/4	212	319	425	477	530	636	795	954	1113	1326	1432	1909
7	9/32	182	273	364	409	455	546	682	818	955	1136	1227	1636
8	5/16	159	239	319	358	398	477	597	716	835	994	1074	1432
9		142	212	283	318	354	425	531	637	742	885	955	1293
10	3/8	127	191	255	286	318	382	477	573	668	795	859	1146
11		116	174	232	260	289	347	434	521	608	723	781	1041
12	1/2	106	159	212	238	265	318	398	477	557	663	716	955
13		98	147	196	220	245	294	367	441	514	612	661	881
14	9/16	91	136	182	205	227	273	341	409	477	568	614	818
16	5/8	80	119	159	179	199	239	298	358	418	497	537	716
18		71	106	141	159	177	212	265	318	371	442	477	636
20	3/4	64	96	127	143	159	191	239	286	334	398	430	573
22	7/8	58	87	116	130	145	174	217	260	304	362	391	521
24	1"	53	80	106	119	133	159	199	239	275	331	353	477
27		47	71	94	106	118	141	177	212	245	295	318	424
30	1-1/8	43	64	85	95	106	127	159	191	223	265	286	382
33	1-1/4	39	58	77	87	96	116	145	174	203	241	260	347
36		35	53	71	80	88	106	133	159	186	221	239	318
39	1-1/2	33	49	65	73	82	98	122	147	171	204	220	294
42		30	46	61	68	76	91	114	136	159	189	205	273
45	1-3/4	28	42	57	64	71	85	106	127	149	177	191	255
48		27	40	53	60	66	80	99	119	139	166	179	239
52		24	37	49	55	61	73	92	110	129	153	165	220
56	2"	23	34	46	51	57	68	85	102	119	142	153	205



**RECOMMENDED CUTTING SPEED  
COOLANTS AND LUBRICANTS  
VELOCITÀ DI TAGLIO RACCOMANDATO  
REFRIGERANTE E LUBRIFICAZIONE PER FILETTARE**

<b>Material/Materiali</b>	<b>Lubricant</b>	<b>Cutting Speed</b>
	<b>lubrificante</b>	<b>velocità di taglio m/min.</b>
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 <sup>2</sup> Acciaio, Acciaio utensili a 1.200 N/mm <sup>2</sup>	S	2- 5
Steel, Tool Steel over 1200 N/mm <sup>2</sup> Acciaio, Acciaio utensili da 1.200 N/mm <sup>2</sup>	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**

<b>M</b>	$\emptyset$ mm	<b>Mf</b>	$\emptyset$ mm	<b>BSW</b>	$\emptyset$ mm	<b>UNF</b>	$\emptyset$ mm	<b>FG</b>	$\emptyset$ 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		
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			5/16-24	7,82		
M 3	0,5	2,92	M 20 x 1	19,88	<b>BSF</b>	$\emptyset$	3/8-24	9,41	BSC 1/4 x 26	6,23
M 3	0,6	2,91	M 20 x 1,5	19,85	BSF 3/16	4,67	7/16-20	10,98	BSC 5/16 x 26	7,81
M 3,5	0,6	3,41	M 20 x 2	19,82	BSF 1/4	6,25	1/2-20	12,56	BSC 3/8 x 26	9,40
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 20	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 9/16 x 20LH	14,14
M 4	0,75	3,91	M 22 x 2	21,82	BSF 7/16	10,97	3/4-16	18,89	BSC 1" x 24	25,26
M 4,5	0,75	4,41	M 24 x 1	23,88	BSF 1/2	12,54	7/8-14	22,05	<b>Vg</b>	$\emptyset$
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					Vg 12 x 26	12,04
M 10	1,5	9,85	M 27 x 1	26,88	<b>UNC</b>	$\emptyset$				
M 11	1,5	10,85	M 27 x 1,5	26,85	mm		<b>BSP</b>	$\emptyset$		
M 12	1,75	11,83	M 27 x 2	26,82	No. 1-64	1,79	G 1/8	9,62		
M 14	2	13,82	M 28 x 1,5	27,85	No. 2-56	2,12	G 1/4	13,03		
M 16	2	15,82	M 28 x 2	27,82	No. 3-48	2,44	G 3/8	16,53		
M 18	2,5	17,79	M 30 x 1	29,88	No. 4-40	2,76	G 1/2	20,81		
M 20	2,5	19,79	M 30 x 1,5	29,85	No. 5-40	3,09	G 5/8	22,77		
M 22	2,5	21,79	M 30 x 2	29,82	No. 6-32	3,41	G 3/4	26,30		
M 24	3	23,77	M 32 x 1,5	31,85	No. 8-32	4,07	G 7/8	30,06		
M 27	3	26,77	M 33 x 1,5	32,85	No. 10-24	4,71	G 1"	33,07		
M 30	3,5	29,73	M 33 x 2	32,82	No. 12-24	5,37	G 1.1/8	37,71		
M 33	3,5	32,73	M 34 x 1,5	33,85	1/4-20	6,22	G 1.1/4	41,73		
M 36	4	35,70	M 35 x 1,5	34,85	5/16-18	7,80	G 1.3/8	44,14		
M 39	4	38,70	M 36 x 1,5	35,85	3/8-16	9,37	G 1.1/2	47,62		
M 42	4,5	41,69	M 36 x 2	35,82	7/16-14	10,95	G 1.3/4	53,56		
M 45	4,5	44,69	M 36 x 3	35,76	1/2-13	12,52	G 2"	59,43		
M 48	5	47,66	M 38 x 1,5	37,85	9/16-12	14,10			<b>PG</b>	$\emptyset$
M 52	5	51,66	M 39 x 1,5	38,85	5/8-11	15,68			mm	
			M 39 x 2	38,82	3/4-10	18,84			PG 7	12,40
			M 39 x 3	38,76	7/8- 9	22			PG 9	15,10
			M 40 x 1,5	39,85	1"- 8	25,16			PG 11	18,50
			M 40 x 2	39,82	1.1/8- 7	28,31			PG 13,5	20,30
			M 40 x 3	39,76	1.1/4- 7	31,49			PG 16	22,40
			M 42 x 1,5	41,85	1.3/8- 6	34,63			PG 21	28,15
			M 42 x 2	41,82	1.1/2- 6	37,81			PG 29	36,85
			M 42 x 3	41,76	1.3/4- 5	44,12			PG 36	46,85
			M 45 x 1,5	44,85	2"- 4,5	50,45			PG 42	53,85
			M 45 x 2	44,82	2.1/4- 4,5	56,80			PG 48	59,15
			M 45 x 3	44,76	2.1/2- 4	63,10				
			M 48 x 1,5	47,85	2.3/4- 4	69,45			<b>NPT</b>	$\emptyset$
			M 48 x 2	47,82	3"- 4	75,80			mm	
			M 48 x 3	47,46					1/16	8,17
			M 50 x 1,5	49,85					1/8	10,55
			M 50 x 2	49,82					1/4	14,10
			M 50 x 3	49,76					3/8	17,52
			M 52 x 1,5	51,85					1/2	21,85
			M 52 x 2	51,82					3/4	27,16
			M 52 x 3	51,76					1"	34,16
									1.1/4	42,74
									1.1/2	48,87
									2"	60,95



## RECOMMENDED TAPPING DRILL SIZES PREFORI PER MASCHI RACCOMANDATO

M	Ø	Mf	Ø	Mf	Ø	Mf	Ø	Mf	Ø	
	mm		mm		mm		mm		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	<b>BSW</b>	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
<b>Mf</b>	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**

<b>BSF</b>	$\emptyset$ mm	<b>UNC</b>	$\emptyset$ mm	<b>8-UN</b>	$\emptyset$ mm	<b>UNS</b>	$\emptyset$ mm	<b>Vg</b>	$\emptyset$ 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	<b>Rd</b>	$\emptyset$ mm
BSF 7/8	19,5	<b>UNF</b>	$\emptyset$ 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
<b>BSP</b>	$\emptyset$ mm	No. 0-80	1,3	UN 1.7/8-8	44,5	UNS 1"-14	23,75	Rd 9 x 1/10	7
		No. 1-72	1,6	UN 2"-8	47,75	<b>PG</b>	$\emptyset$ mm	Rd 10 x 1/10	8
<b>G</b>		No. 2-64	1,9	UN 2.1/8-8	50,9			PG 7	11,4
G 1/8	8,8	No. 3-56	2,1	UN 2.1/4-8	54	PG 9	14	Rd 12 x 1/10	10
G 1/4	11,8	No. 4-48	2,4	UN 2.1/2-8	60,4	PG 11	17,25	Rd 14 x 1/8	11,5
G 3/8	15,25	No. 5-44	2,7	UN 2.3/4-8	66,7	PG 13,5	19	Rd 16 x 1/8	13,5
G 1/2	19	No. 6-40	3	UN 3"-8	73,1	PG 16	21,25	Rd 18 x 1/8	15,5
G 5/8	21	No. 8-36	3,5	UN 3.1/4-8	79,4	PG 21	26,75	Rd 20 x 1/8	17,5
G 3/4	24,5	No. 10-32	4,1	UN 3.1/2-8	85,8	PG 29	35,5	Rd 22 x 1/8	19,5
G 7/8	28,25	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"	30,75	1/4-28	5,5	UN 4"-8	98,5	PG 42	52,5	Rd 26 x 1/8	23,5
G 1.1/8	35,3	5/16-24	6,9	<b>UN</b>	$\emptyset$ mm	PG 48	58	Rd 28 x 1/8	25,5
G 1.1/4	39,5	3/8-24	8,5			UN 5/16-28	7	<b>NPT</b>	$\emptyset$ mm
G 1.3/8	41,7	7/16-20	9,9	UN 3/8-20	8,3	1/16-27	6,3		
G 1.1/2	45,25	1/2-20	11,5	UN 3/8-28	8,6	1/8-27	8,5	Rd 34 x 1/8	31,5
G 1.3/4	51,1	9/16-18	12,9	UN 7/16-32	10,3	1/4-18	11,2	Rd 36 x 1/8	33,5
G 2"	57	5/8-18	14,5	UN 1/2-32	11,9	3/8-18	14,5	Rd 38 x 1/8	35,5
G 2.1/4	63,1	3/4-16	17,5	UN 9/16-20	10,9	1/2-14	18	Rd 40 x 1/6	36,6
G 2.1/2	72,6	7/8-14	20,25	UN 9/16-28	11,3	3/4-14	23	Rd 42 x 1/6	38,6
G 2.3/4	78,9	1"-12	23,25	UN 9/16-32	11,4	1"-11,5	29	Rd 44 x 1/6	40,6
G 3"	85,3	1.1/8-12	26,5	UN 5/8-20	14,6	1.1/4-11,5	38	<b>Tr</b>	$\emptyset$ mm
<b>BA</b>	$\emptyset$ mm	1.1/4-12	29,5	UN 5/8-28	15	1.1/2-11,5	44		
		1.3/8-12	32,5	UN 11/16-20	16,2	2"-11,5	56	Tr 10 x 2	8,2
BA 0	5,1	1.1/2-12	36	UN 11/16-16	15,9	2.1/2- 8	67	Tr 10 x 3	7,5
BA 1	4,5	<b>12-UN</b>	$\emptyset$ mm	UN 1"-32	24,6	3- 8	83	Tr 12 x 3	9,25
BA 2	4			UN 1.5/8-12	39,2	<b>UNEF</b>	$\emptyset$ mm	<b>W</b>	$\emptyset$ mm
BA 3	3,4	UN 1.3/4-12	42,4	No. 12-32	4,75				
BA 4	3	UN 1.7/8-12	45,6	1/4-32	5,6	W 19,8	15,1	Tr 16 x 4	12,25
BA 5	2,65	UN 2.1/8-12	51,9	5/16-32	7,2	W 28,8	23,5	Tr 18 x 4	14,25
BA 6	2,3	UN 2.1/4-12	55,1	3/8-32	8,8	W 31,3	26,0	Tr 20 x 4	16,25
<b>UNC</b>	$\emptyset$ mm	UN 2.1/2-12	61,5	7/16-28	10,25	<b>FG</b>	$\emptyset$ mm	Tr 22 x 4	18,25
		UN 2.3/4-12	67,8	1/2-28	11,8			Tr 22 x 5	17,25
No. 1-64	1,5	UN 3"-12	74,2	9/16-24	13,3	FG 2 x 56	1,7	Tr 24 x 5	19,25
No. 2-56	1,8	UN 3.1/4-12	80,5	5/8-24	14,9	FG 2,3 x 56	1,9	Tr 26 x 5	21,25
No. 3-48	2,1	UN 3.1/2-12	86,9	11/16-24	16,5	FG 2,6 x 56	2,2	Tr 28 x 5	23,25
No. 4-40	2,3	UN 3.3/4-12	93,2	3/4-20	17,75	FG 6,35 x 26	5,5	Tr 30 x 6	24,25
No. 5-40	2,6	UN 4"-12	99,6	13/16-20	19,5	FG 7,9 x 26	7	Tr 32 x 6	26,25
No. 6-32	2,85			7/8-20	21	FG 9,5 x 26	8,6	Tr 36 x 6	30,25
No. 8-32	3,5			15/16-20	22,5	FG 14,3 x 20	13,1		
No. 10-24	3,9			1"-20	24,25	FG 14,3 x 20-LH	13,1		
No. 12-24	4,5			1.1/16-18	25,7	FG 25,4 x 24	24,5		
1/4-20	5,2			1.1/8-18	27,25	<b>BSC</b>	$\emptyset$ mm	BSC 1/4 x 26	5,5
5/16-18	6,6			1.3/16-18	28,75			BSC 5/16 x 26	7
5/16-18	6,6			1.1/4-18	30,5	BSC 3/8 x 26	8,6		
3/8-16	8			1.5/16-18	32	BSC 9/16 x 20	13,1		
7/16-14	9,4			1.3/8-18	33,5	BSC 9/16 x 20 LH	13,1		
1/2-13	10,8			1.7/16-18	35,2	BSC 1" x 24	24,5		
9/16-12	12,2			1.1/2-18	36,8				
5/8-11	13,5			1.9/16-18	38,4				
3/4-10	16,5			1.5/8-18	40				
7/8- 9	19,5			1.11/16-18	41,5				
1"- 8	22,25			1.3/4-18	43				
1.1/8- 7	25			2"-18	49,4				
1.1/4- 7	28,25								
1.3/8- 6	30,75								
1.1/2- 6	34								
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	317	82, 83	617	46
130	12	320	86-87	619	46
140	12	325	88	623	50
145	13	326	89, 91	630	57
146	13	327	90	633	51
150	11	334	119	635	56
152	11	335	120	637	53
155	10	337	121	643	51
180	220	344	119	653	52
220	41	345	120	657	55
221	195	347	121	663	49
222	189	348	122-124	665	49
223	26	349	125-127	670	63, 221-222
224	171	351	142	671	72, 222, 225
225	195	352	138, 149	672	69-70, 221
227	27	353	132, 147	673	72, 222
228	171	354	136, 148	674	71, 223-225
230	42	355	153-156	676	71
231	196	356	153-156	677	64-66
232	190	357	144	678	66-68
233	29	359	139	700	73
234	173	361	145	705	99
235	199-200	362	140, 149	707	100
236	179	363	133, 147	715	99
240	42	364	137, 148	717	100
241	196-197	365	143	734	113-114
242	190	369	141	745	101
243	30	370	73	747	102
244	174	371	158	755	101
246	175	373	78	757	102
250	43	374	79	765	103
251	34	375	77, 80	767	104
252	191	376	84	775	103
253	32	377	77, 82	777	104
254	176	379	85	782	128
255	198	383	78	784	110
256	202	384	79	785	111
257	33	385	77, 81	787	112
258	178	386	84	791	159
260	40	387	77, 83	793	180-181
261	193	389	85	794	115-118
262	186-188	394	92	804	19
263	20-21	395	93-95	805	47, 216
264	165-166	397	96-98	807	48, 216
265	21-23	470	215	809	47, 216
266	166-168	476	215	831	105, 106
267	193-194	478	217-219	832	109
268	186-188	479	217	833	105, 106-108
270	39	480	207-209, 220	838	31
271	192	486	204-206	890	172
272	185	489	226-228	894	28
273	16	491	210-211	954	54
274	162	492	212	957	54
275	164	495	213-214	970	177
276	18	553	38	975	53
278	163	554	184	977	53
279	163	563	37	980	179
280	23-25	564	183	985	56, 58
281	17, 25, 168-169	565	37	987	56, 58
282	163, 169-170	566	183	994	59
284	201	573	35	997	59
300	134	574	182		
301	135	577	36		
315	80-81	615	46		



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