

SNITTAPPE DK

ALT I GEVINDVÆRKTØJER



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VOELKEL Thread-cutting tools

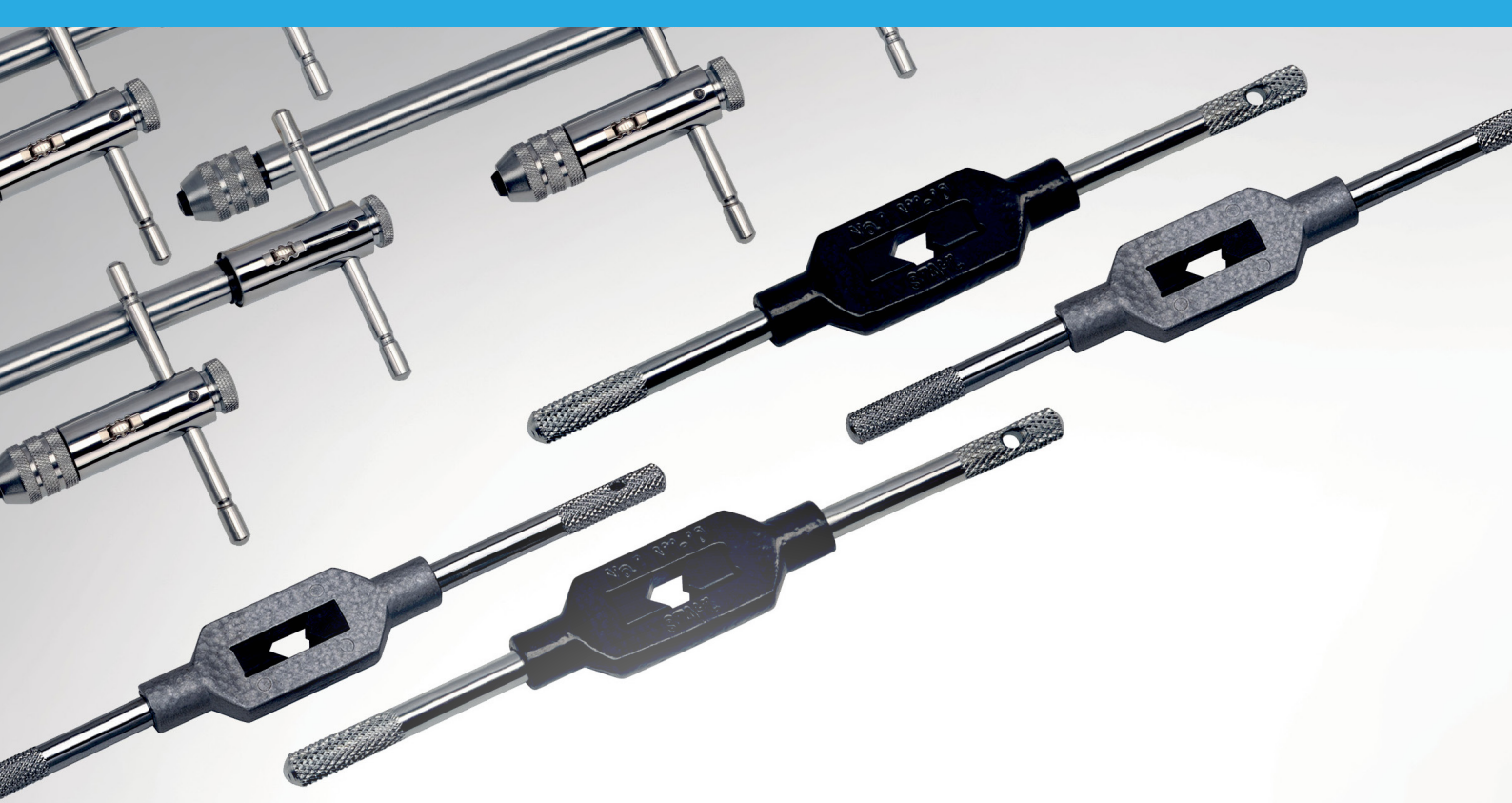


VOELKEL GmbH is a worldwide leading supplier of threading tools and has been a reliable industry, DIY and trade partner for years. In addition to a product range of over 7,000 threading tools available ex stock, the following aspects speaking for tools by VOELKEL GmbH:

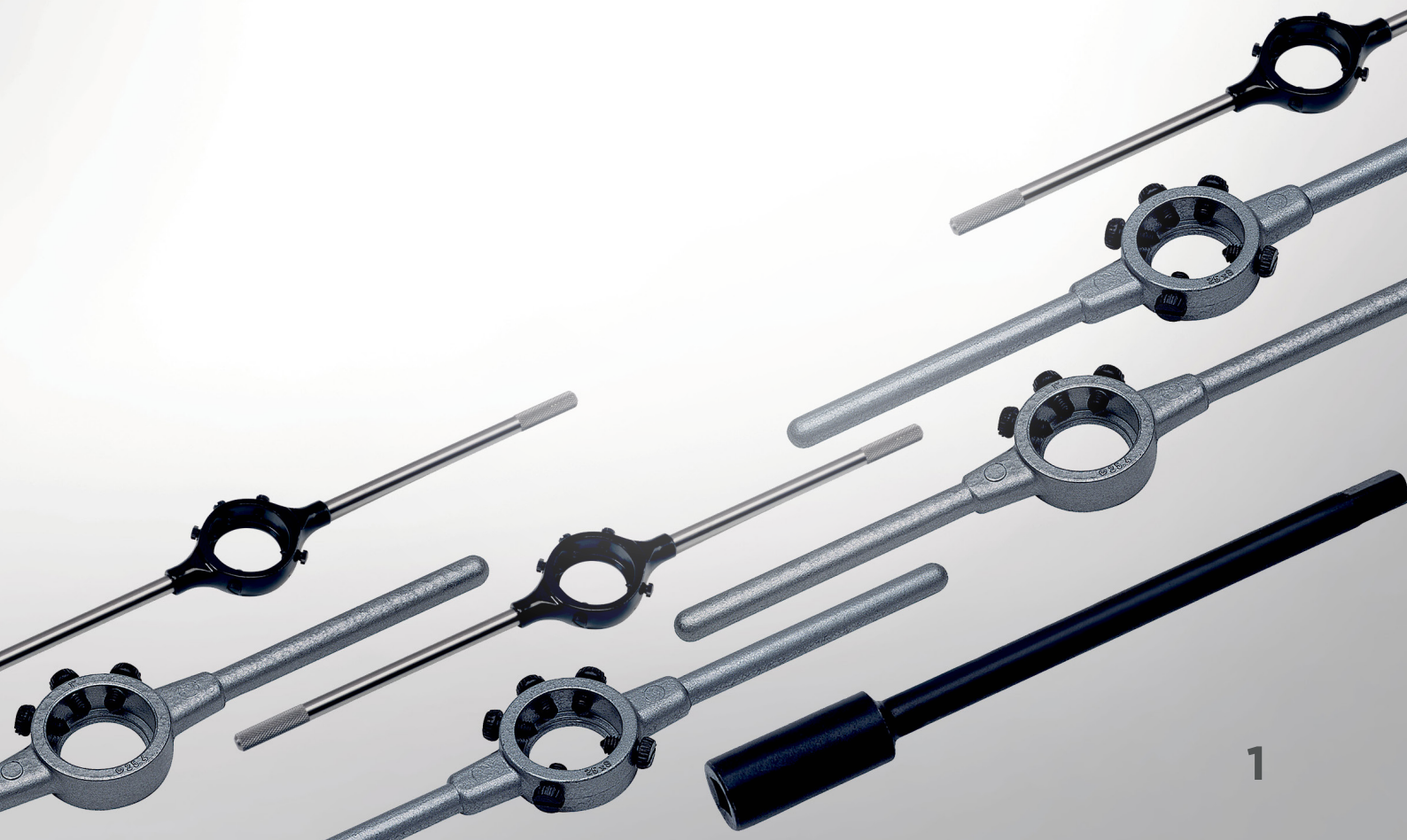
- › Consistent, good industrial quality
- › High availability = short lead times
- › Excellent price-performance ratio for the product mix
- › Attractive package design

In addition to DIN-standard tools, based on global demand VOELKEL also offers a large range of products in the common international standards ISO and JIS-B.

The **entire product range** of VOELKEL threading tools and V-COIL thread repair solutions are available through our shop.



Threading tool holder





Threading tool holder



- Tap holder with ratchet in short or long for taps up to M 12
- Adjustable tap wrenches acc. to DIN 1814 made of zinc die cast or in steel pattern
- Die stocks acc. to DIN 225 (DIN EN 22568) made of zinc die cast or in steel pattern
- Tap extensions acc. to DIN 377 Square acc. DIN 10 from 2,1 mm up to 32 mm

Tap holder with ratchet

- Tap holder with ratchet for right- and left-hand-turn
- All steel quality in short or long pattern
- Ratchet for hand taps and short machine taps up to M 12
- Spare jaws and springs can be ordered seperately



Jaws and Springs for tap holder with ratchet for right-and left-hand-turn

Material: all steel quality

Size: Size No. 1 / 10 and Size No. 2 / 20



Tap holder with ratches, short + long for right-and left-hand-turn, all steel quality

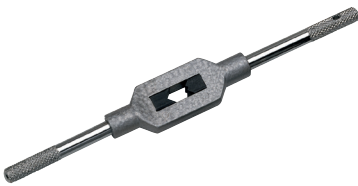
Variants (4):

Size	for Taps		Square mm	Length mm	Weight kg	Pkg. quantity	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 size 1 and 10						10	10091
Jaws and Spring for size 2 and 20						10	10092



Adjustable tap wrenches

- Adjustable tap wrenches acc. to DIN 1814
- Body made of zinc die cast or in steel pattern
- For hand taps and short machine taps up to M 64
- Tap wrench for taps with up to 40 mm square

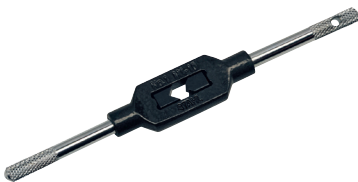


Adjustable tap wrenches

DIN 1814, zinc die cast, hardened jaws

Variants (7):

Size	for Taps		Square mm	Length mm	Weight kg	Pkg. quantity	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	0,095	5	13010
1.1/2	M 1-12	1/16-1/2	G 1/8	2.1-8.0	0,120	5	13015
2	M 4-12	5/32-1/2	G 1/8	3.0-9.0	0,285	5	13020
3	M 5-20	7/32-3/4	G 1/8-1/2	4.9-12	0,660	1	13030
4	M 11-27	7/16-1"	G 1/4-3/4	5.5-16	1,500	1	13040
5 L	M 13-32	1/2-1.1/4	G 1/4-1"	7-20	1,800	1	13050



Adjustable tap wrenches, steel

DIN 1814, steel

Variants (10):

Size	for Taps		Square mm	Length mm	Weight kg	Pkg. quantity	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	0,120	5	14015
2	M 4-12	5/32-1/2	G 1/8	3.0-9.0	0,285	5	14020
3	M 5-20	7/32-3/4	G 1/8-1/2	4.9-12	0,660	1	14030
4	M 11-27	7/16-1"	G 1/4-3/4	5.5-16	1,500	1	14040
5	M 13-32	1/2-1.1/4	G 1/4-1"	7-20	1,800	1	14050
6	M 18-42	3/4-1.1/2	G 1/2-1.1/4	11-24	2,600	1	14060
7	M 27-52	1.1/8-2"	G 3/4-1.3/4	16-32	4,500	1	14070
8	M 27-64	1.1/8"-3"	G 3/4-3"	16-40	4,500	1	14080



Die stocks

- Die stocks acc. to DIN 225 (DIN EN 22568)
- Body made of zinc die cast or in steel pattern
- For round dies up to M 64 and G (BSP) 4"
- Die stocks for round dies up to 160 mm outer diameter



Die Stocks

DIN 225 (DIN EN 22568), steel

Variants (16):

Ø x mm	for round Dies DIN 223 (DIN EN 22568)		Length mm	Weight kg	Pkg. quantity	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



Die Stocks

zinc die cast, (inch), with 3 screws

Variants (10):

Ø	mm	inch/pollice	Length mm	Weight kg	Pkg. quantity	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

Variants (13):

Ø x mm	for round Dies DIN 223 (DIN EN 22568)		Length mm	Weight kg	Pkg. quantity	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



Tap extensions

- Tap extensions acc. to DIN 377
- Squares acc. to DIN 10
- Burnished extensions for taps up to M 52
- Square drive from 2,1 mm up to 32 mm



Tap Extensions

DIN 377, Squares according to DIN 10

Variants (26):

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

Square mm	L1	for DIN 352	Art.-No.
10.0	140		14610
11.0	150	M 18	14611
12.0	150	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



Thread gauges





Thread gauges



Thread gauges for female and male threads

In production it's advisable to test thread samples with standardised gauges. We offer a wide range of thread plug gauges and thread ring gauges for the most common thread types and sizes: Metric (M), metric fine (MF), UNC, UNF, G (BSP) pipe threads as well as for NPT threads.

- Thread plug gauge
= for testing female threads
- Thread ring gauge
= for testing male threads

Thread gauges

- Tap extensions acc. to DIN 377
- Squares acc. to DIN 10
- Burnished extensions for taps up to M 52
- Square drive from 2,1 mm up to 32 mm

VÖLKEL Precision thread plug gauge

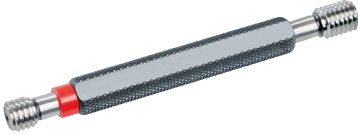
A thread limit plug gauge is a combination of go plug gauge and no-go plug gauge. The scrap side of the thread plug gauge is marked with a red ring.

The GO end of the thread plug or ring gauge must screw into the thread cut into a part by hand (without using excessive force). If unable to do so, the thread does not meet the requested standards (=scrap).

The NO-GO side of the thread plug or ring gauge must not be able to be manually turned more than two turns into the cut thread (without using excessive force). If it can be screwed in more, the thread does not meet the requested standards (=scrap). The no-go thread gauges are marked in red.

As a manufacturer, VÖLKEL will issue a factory calibration certificate upon request (price on request). Calibrated at a measurement laboratory separate from VÖLKEL to specifications and standards (DIN, ISO, ANSI) specified for the respective specimen. Calibrated using IAC thread scanners.

The reference temperature for parts and gauges is 20° Celsius.



Thread Plug Gauge GO-NOGO

metric ISO-thread DIN 13, M1 - M36

Gauge dimension: DIN ISO 1502/DIN 2240

Standard: ISO DIN 13

Variants (26):

Thread Plug Gauge GO-NOGO Art.-No.

M36 x 4,0 - 6H	16036
M1 x 0,25 - 6H	16000
M1.4 x 0,3 - 6H	16003
M1.6 x 0,35 - 6H	16004
M2 x 0,4 - 6H	16007
M2.5 x 0,45 - 6H	16010
M3 x 0,5 - 6H	16012
M3.5 x 0,6 - 6H	16013
M4 x 0,7 - 6H	16014
M5 x 0,8 - 6H	16016
M6 x 1,0 - 6H	16019
M7 x 1,0 - 6H	16020
M8 x 1,25 - 6H	16021

Thread Plug Gauge GO-NOGO Art.-No.

M9 x 1,25 - 6H	16022
M10 x 1,5 - 6H	16023
M11 x 1,5 - 6H	16024
M12 x 1,75 - 6H	16025
M14 x 2,0 - 6H	16027
M16 x 2,0 - 6H	16028
M18 x 2,5 - 6H	16029
M20 x 2,5 - 6H	16030
M22 x 2,5 - 6H	16031
M24 x 3,0 - 6H	16032
M27 x 3,0 - 6H	16033
M30 x 3,5 - 6H	16034
M33 x 3,5 - 6H	16035



Thread Plug Gauge, DLC GO-NOGO

metric ISO-thread DIN 13, M3 - M24

Gauge dimension: DIN ISO 1502/DIN 2240

Standard: ISO DIN 13

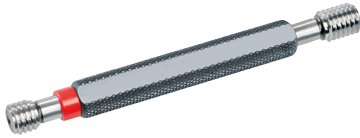
Variants (11):

Thread Plug Gauge GO-NOGO Art.-No.

M3 x 0,5 - 6H	16474
M4 x 0,7 - 6H	16475
M5 x 0,8 - 6H	16476
M6 x 1,0 - 6H	16477
M8 x 1,25 - 6H	16478
M10 x 1,5 - 6H	16479

Thread Plug Gauge GO-NOGO Art.-No.

M12 x 1,75 - 6H	16480
M14 x 2,0 - 6H	16481
M16 x 2,0 - 6H	16482
M20 x 2,5 - 6H	16483
M24 x 3,0 - 6H	16484



Thread Plug Gauge GO-NOGO

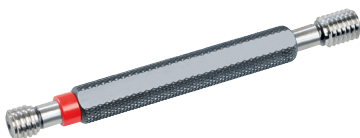
metric-fine ISO-thread DIN 13, M2 - M40

Gauge dimension: DIN ISO 1502/DIN 2240

Standard: ISO DIN 13

Variants (67):

GO-NOGO	Art.-No.	GO-NOGO	Art.-No.	GO-NOGO	Art.-No.
M36 x 1,5 - 6H	16098	M12 x 1,0 - 6H	16055	M25 x 2,0 - 6H	16078
M36 x 2,0 - 6H	16099	M12 x 0,5 - 6H	16056	M26 x 1,5 - 6H	16079
M36 x 3,0 - 6H	16100	M12 x 1,25 - 6H	16057	M27 x 1,0 - 6H	16080
M38 x 1,5 - 6H	16101	M12 x 1,5 - 6H	16058	M27 x 1,5 - 6H	16081
M40 x 1,5 - 6H	16102	M14 x 1,0 - 6H	16059	M27 x 2,0 - 6H	16082
M2 x 0,35 - 6H	16037	M14 x 1,25 - 6H	16060	M28 x 1,5 - 6H	16083
M2.5 x 0,35 - 6H	16038	M14 x 1,5 - 6H	16061	M30 x 1,0 - 6H	16084
M3 x 0,35 - 6H	16039	M16 x 1,0 - 6H	16062	M30 x 1,5 - 6H	16085
M3.5 x 0,35 - 6H	16040	M16 x 1,5 - 6H	16063	M30 x 2,0 - 6H	16086
M4 x 0,35 - 6H	16041	M18 x 1,0 - 6H	16064	M30 x 3,0 - 6H	16087
M4 x 0,5 - 6H	16042	M18 x 1,5 - 6H	16065	M32 x 1,5 - 6H	16088
M5 x 0,35 - 6H	16043	M18 x 2,0 - 6H	16066	M33 x 1,5 - 6H	16089
M5 x 0,5 - 6H	16044	M20 x 1,0 - 6H	16067	M33 x 2,0 - 6H	16090
M6 x 0,35 - 6H	16045	M20 x 1,5 - 6H	16068	M33 x 3,0 - 6H	16091
M6 x 0,5 - 6H	16046	M20 x 2,0 - 6H	16069	M34 x 1,5 - 6H	16092
M6 x 0,75 - 6H	16047	M22 x 1,0 - 6H	16070	M34 x 2,0 - 6H	16093
M8 x 0,5 - 6H	16048	M22 x 1,5 - 6H	16071	34 x 3,0 - 6H	16094
M8 x 0,75 - 6H	16049	M22 x 2,0 - 6H	16072	M35 x 1,5 - 6H	16095
M8 x 1,0 - 6H	16050	M24 x 1,0 - 6H	16073	M35 x 2,0 - 6H	16096
M10 x 0,75 - 6H	16051	M24 x 1,5 - 6H	16074	M35 x 3,0 - 6H	16097
M10 x 1,0 - 6H	16052	M24 x 2,0 - 6H	16075	M40 x 2,0 - 6H	16103
M10 x 1,25 - 6H	16053	M25 x 1,0 - 6H	16076		
M12 x 0,75 - 6H	16054	M25 x 1,5 - 6H	16077		



Thread Plug Gauge GO-NOGO

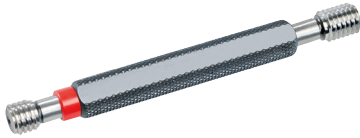
Unified Coarse and Fine thread ANSI B 1.1 (UNC/UNF), Nr.4 - 3/4 UNC

Gauge dimension: ANSI B1.2

Standard: ANSI B 1.1

Variants (12):

GO-NOGO	Art.-No.	GO-NOGO	Art.-No.	GO-NOGO	Art.-No.
Nr. 4 x 40 UNC - 2B	16104	1/4 x 20 UNC - 2B	16108	1/2 x 13 UNC - 2B	16112
Nr. 6 x 32 UNC - 2B	16105	5/16 x 18 UNC - 2B	16109	9/16 x 12 UNC - 2B	16113
Nr. 8 x 32 UNC - 2B	16106	3/8 x 16 UNC - 2B	16110	5/8 x 11 UNC - 2B	16114
Nr. 10 x 24 UNC - 2B	16107	7/16 x 14 UNC - 2B	16111	3/4 x 10 UNC - 2B	16115



Thread Plug Gauge GO-NOGO

Unified Coarse and Fine thread ANSI B 1.1 (UNC/UNF), Nr.4 - 3/4 UNF

Gauge dimension: ANSI B1.2

Standard: ANSI B1.1

Variants (12):

GO-NOGO	Art.-No.	GO-NOGO	Art.-No.	GO-NOGO	Art.-No.
Nr. 4 x 48 UNF - 2B	16116	1/4 x 28 UNF - 2B	16120	1/2 x 20 UNF - 2B	16124
Nr. 6 x 40 UNF - 2B	16117	5/16 x 24 UNF - 2B	16121	9/16 x 18 UNF - 2B	16125
Nr. 8 x 36 UNF - 2B	16118	3/8 x 24 UNF - 2B	16122	5/8 x 18 UNF - 2B	16126
Nr. 10 x 32 UNF - 2B	16119	7/16 x 20 UNF - 2B	16123	3/4 x 16 UNF - 2B	16127



Thread Plug Gauge GO-NOGO

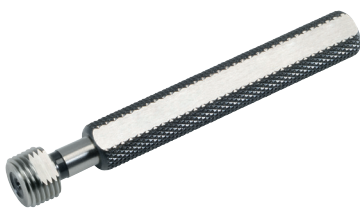
Pipe-thread DIN ISO 228, G 1/8 - G 1"

Gauge dimension: DIN EN ISO 228-2

Standard: DIN ISO 228

Variants (8):

Thread Plug Gauge GO-NOGO	Art.-No.	Thread Plug Gauge GO-NOGO	Art.-No.
G 1/8	16128	G 5/8	16132
G 1/4	16129	G 3/4	16133
G 3/8	16130	G 7/8	16134
G 1/2	16131	G 1"	16135



Thread Plug Gauge GO-NOGO

American tapered pipe thread, taper 1:16 (NPT), 1/8 - 1 NPT

Gauge dimension: ANSI/ASME B 1.20.1

Standard: ANSI/ASME B 1.20.1

Variants (6):

VÖLKEL Precision thread plug gauge - Additional comment:

Combinded GO and NO-GO plug gauge for NPT female threads.

Thread Plug Gauge GO-NOGO	Art.-No.	Thread Plug Gauge GO-NOGO	Art.-No.
1/8 x 27 NPT	16136	1/2 x 14 NPT	16139
1/4 x 18 NPT	16137	3/4 x 14 NPT	16140
3/8 x 18 NPT	16138	1" x 11,5 NPT	16141



GO Thread Plug Gauge

metric ISO-thread DIN 13, M39 - M48

Gauge dimension: DIN ISO 1502/DIN 2240

Standard: ISO DIN 13

Variants (4):

GO Thread Plug Gauge

M39 x 4,0 - 6H

M42 x 4,5 - 6H

Art.-No.

[16160](#)

[16161](#)

GO Thread Plug Gauge

M45 x 4,5 - 6H

M48 x 5,0 - 6H

Art.-No.

[16162](#)

[16163](#)



GO Thread Plug Gauge

metric-fine ISO-thread DIN 13, M42 - M60

Gauge dimension: DIN ISO 1502/DIN 2240

Standard: ISO DIN 13

Variants (14):

GO Thread Plug Gauge

M42 x 1,5 - 6H

M42 x 2,0 - 6H

M45 x 1,5 - 6H

M45 x 2,0 - 6H

M48 x 1,5 - 6H

M48 x 2,0 - 6H

M50 x 1,5 - 6H

Art.-No.

[16146](#)

[16147](#)

[16148](#)

[16149](#)

[16150](#)

[16151](#)

[16152](#)

GO Thread Plug Gauge

M50 x 2,0 - 6H

M52 x 1,5 - 6H

M52 x 2,0 - 6H

M55 x 1,5 - 6H

M55 x 2,0 - 6H

M58 x 1,5 - 6H

M60 x 2,0 - 6H

Art.-No.

[16153](#)

[16154](#)

[16155](#)

[16156](#)

[16157](#)

[16158](#)

[16159](#)



GO Thread Plug Gauge

Pipe-thread DIN ISO 228, G 1.1/4 - G 2"

Gauge dimension: DIN EN ISO 228-2

Standard: DIN ISO 228

Variants (4):

GO Thread Plug Gauge

G 1.1/4

G 1.1/2

Art.-No.

[16160](#)

[16161](#)

GO Thread Plug Gauge

G 1.3/4

G 2"

Art.-No.

[16162](#)

[16163](#)



NO-GO Thread Plug Gauge

metric ISO-thread DIN 13, M39 - M48

Gauge dimension: DIN ISO 1502/DIN 2240

Standard: ISO DIN 13

Variants (4):

NO-GO Thread Plug Gauge

Art.-No.

M39 x 4,0 - 6H

[16164](#)

M42 x 4,5 - 6H

[16165](#)

NO-GO Thread Plug Gauge

Art.-No.

M45 x 4,5 - 6H

[16166](#)

M48 x 5,0 - 6H

[16167](#)



NO-GO Thread Plug Gauge

metric-fine ISO-thread DIN 13, M42 - M60

Gauge dimension: DIN ISO 1502/DIN 2240

Standard: ISO DIN 13

Variants (14):

NO-GO Thread Plug Gauge

Art.-No.

M42 x 1,5 - 6H

[16168](#)

M42 x 2,0 - 6H

[16169](#)

M45 x 1,5 - 6H

[16170](#)

M45 x 2,0 - 6H

[16171](#)

M48 x 1,5 - 6H

[16172](#)

M48 x 2,0 - 6H

[16173](#)

M50 x 1,5 - 6H

[16174](#)

NO-GO Thread Plug Gauge

Art.-No.

M50 x 2,0 - 6H

[16175](#)

M52 x 1,5 - 6H

[16176](#)

M52 x 2,0 - 6H

[16177](#)

M55 x 1,5 - 6H

[16178](#)

M55 x 2,0 - 6H

[16179](#)

M58 x 1,5 - 6H

[16180](#)

M60 x 2,0 - 6H

[16181](#)



NO-GO Thread Plug Gauge

Pipe-thread DIN ISO 228, G 1.1/4 - G 2"

Gauge dimension: DIN EN ISO 228-2

Standard: DIN ISO 228

Variants (4):

NO-GO Thread Plug Gauge

Art.-No.

G 1.1/4

[16182](#)

G 1.1/2

[16183](#)

NO-GO Thread Plug Gauge

Art.-No.

G 1.3/4

[16184](#)

G 2"

[16185](#)



GO Thread Ring Gauge

metric ISO-thread DIN 13, M2 - M48

Gauge dimension: DIN ISO 1502

Standard: ISO DIN 13

Variants (27):

GO Thread Ring Gauge	Art. -No.	GO Thread Ring Gauge	Art. -No.	GO Thread Ring Gauge	Art. -No.	GO Thread Ring Gauge	Art. -No.
M2 x 0,4 - 6g	16186	M7 x 1,0 - 6g	16193	M16 x 2,0 - 6g	16200	M33 x 3,5 - 6g	16207
M2.5 x 0,45 - 6g	16187	M8 x 1,25 - 6g	16194	M18 x 2,5 - 6g	16201	M36 x 4,0 - 6g	16208
M3 x 0,5 - 6g	16188	M9 x 1,25 - 6g	16195	M20 x 2,5 - 6g	16202	M39 x 4,0 - 6g	16209
M3.5 x 0,6 - 6g	16189	M10 x 1,5 - 6g	16196	M22 x 2,5 - 6g	16203	M42 x 4,5 - 6g	16210
M4 x 0,7 - 6g	16190	M11 x 1,5 - 6g	16197	M24 x 3,0 - 6g	16204	M45 x 4,5 - 6g	16211
M5 x 0,8 - 6g	16191	M12 x 1,75 - 6g	16198	M27 x 3,0 - 6g	16205	M48 x 5,0 - 6g	16212
M6 x 1,0 - 6g	16192	M14 x 2,0 - 6g	16199	M30 x 3,5 - 6g	16206		



GO Thread Ring Gauge

metric-fine ISO-thread DIN 13, M2 - M60

Gauge dimension: DIN ISO 1502

Standard: ISO DIN 13

Variants (81):

GO Thread Ring Gauge	Art. -No.	GO Thread Ring Gauge	Art. -No.	GO Thread Ring Gauge	Art. -No.	GO Thread Ring Gauge	Art. -No.
M48 x 1,5 - 6g	16284	M8 x 0,5 - 6g	16224	M20 x 2,0 - 6g	16245	M33 x 2,0 - 6g	16266
M48 x 2,0 - 6g	16285	M8 x 0,75 - 6g	16225	M22 x 1,0 - 6g	16246	M33 x 3,0 - 6g	16267
M50 x 1,5 - 6g	16286	M8 x 1,0 - 6g	16226	M22 x 1,5 - 6g	16247	M34 x 1,5 - 6g	16268
M50 x 2,0 - 6g	16287	M10 x 0,75 - 6g	16227	M22 x 2,0 - 6g	16248	M34 x 2,0 - 6g	16269
M52 x 1,5 - 6g	16288	M10 x 1,0 - 6g	16228	M24 x 1,0 - 6g	16249	M34 x 3,0 - 6g	16270
M52 x 2,0 - 6g	16289	M10 x 1,25 - 6g	16229	M24 x 1,5 - 6g	16250	M35 x 1,5 - 6g	16271
M55 x 1,5 - 6g	16290	M12 x 0,75 - 6g	16230	M24 x 2,0 - 6g	16251	M35 x 2,0 - 6g	16272
M55 x 2,0 - 6g	16291	M12 x 1,0 - 6g	16231	M25 x 1,0 - 6g	16252	M35 x 3,0 - 6g	16273
M58 x 1,5 - 6g	16292	M12 x 0,5 - 6g	16232	M25 x 1,5 - 6g	16253	M36 x 1,5 - 6g	16274
M60 x 2,0 - 6g	16293	M12 x 1,25 - 6g	16233	M25 x 2,0 - 6g	16254	M36 x 2,0 - 6g	16275
M2 x 0,35 - 6g	16213	M12 x 1,5 - 6g	16234	M26 x 1,5 - 6g	16255	M36 x 3,0 - 6g	16276
M2.5 x 0,35 - 6g	16214	M14 x 1,0 - 6g	16235	M27 x 1,0 - 6g	16256	M38 x 1,5 - 6g	16277
M3 x 0,35 - 6g	16215	M14 x 1,25 - 6g	16236	M27 x 1,5 - 6g	16257	M40 x 1,5 - 6g	16278
M3.5 x 0,35 - 6g	16216	M14 x 1,5 - 6g	16237	M27 x 2,0 - 6g	16258	M40 x 2,0 - 6g	16279
M4 x 0,35 - 6g	16217	M16 x 1,0 - 6g	16238	M28 x 1,5 - 6g	16259	M42 x 1,5 - 6g	16280
M4 x 0,5 - 6g	16218	M16 x 1,5 - 6g	16239	M30 x 1,0 - 6g	16260	M42 x 2,0 - 6g	16281
M5 x 0,35 - 6g	16219	M18 x 1,0 - 6g	16240	M30 x 1,5 - 6g	16261	M45 x 1,5 - 6g	16282
M5 x 0,5 - 6g	16220	M18 x 1,5 - 6g	16241	M30 x 2,0 - 6g	16262	M45 x 2,0 - 6g	16283
M6 x 0,35 - 6g	16221	M18 x 2,0 - 6g	16242	M30 x 3,0 - 6g	16263		
M6 x 0,5 - 6g	16222	M20 x 1,0 - 6g	16243	M32 x 1,5 - 6g	16264		
M6 x 0,75 - 6g	16223	M20 x 1,5 - 6g	16244	M33 x 1,5 - 6g	16265		



GO Thread Ring Gauge

Unified Coarse and Fine thread ANSI B 1.1 (UNC/ UNF), Nr. 4 - 3/4 UNC

Gauge dimension: ANSI B1.2

Standard: ANSI B 1.1

Variants (12):

GO Thread Ring Gauge

Art.
-No.

Nr. 4 x 40 UNC - 2A	16294
Nr. 6 x 32 UNC - 2A	16295
Nr. 8 x 32 UNC - 2A	16296
Nr. 10 x 24 UNC - 2A	16297

GO Thread Ring Gauge

Art.
-No.

1/4 x 20 UNC - 2A	16298
5/16 x 18 UNC - 2A	16299
3/8 x 16 UNC - 2A	16300
7/16 x 14 UNC - 2A	16301

GO Thread Ring Gauge

Art.
-No.

1/2 x 13 UNC - 2A	16302
9/16 x 12 UNC - 2A	16303
5/8 x 11 UNC - 2A	16304
3/4 x 10 UNC - 2A	16305



GO Thread Ring Gauge

Unified Coarse and Fine thread ANSI B 1.1 (UNC/ UNF), Nr. 4 - 3/4 UNF

Gauge dimension: ANSI B1.2

Standard: ANSI B 1.1

Variants (12):

GO Thread Ring Gauge

Art.
-No.

Nr. 4 x 48 UNF - 2A	16306
Nr. 6 x 40 UNF - 2A	16307
Nr. 8 x 36 UNF - 2A	16308
Nr. 10 x 32 UNF - 2A	16309

GO Thread Ring Gauge

Art.
-No.

1/4 x 28 UNF - 2A	16310
5/16 x 24 UNF - 2A	16311
3/8 x 24 UNF - 2A	16312
7/16 x 20 UNF - 2A	16313

GO Thread Ring Gauge

Art.
-No.

1/2 x 20 UNF - 2A	16314
9/16 x 18 UNF - 2A	16315
5/8 x 18 UNF - 2A	16316
3/4 x 16 UNF - 2A	16317



GO Thread Ring Gauge

Pipe-thread DIN ISO 228, G 1/8 - G 2

Gauge dimension: DIN EN ISO 228-2

Standard: DIN ISO 228

Variants (12):

GO Thread Ring Gauge

Art.
-No.

G 1/8 A	16318
G 1/4 A	16319
G 3/8 A	16320
G 1/2 A	16321

GO Thread Ring Gauge

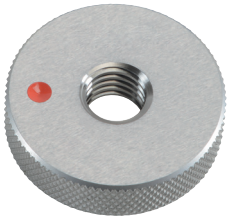
Art.
-No.

G 5/8 A	16322
G 3/4 A	16323
G 7/8 A	16324
G 1" A	16325

GO Thread Ring Gauge

Art.
-No.

G 1.1/4 A	16326
G 1.1/2 A	16327
G 1.3/4 A	16328
G 2" A	16329



NO-GO Thread Ring Gauge

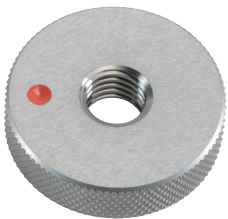
metric ISO-thread DIN 13, M2 - M48

Gauge dimension: DIN ISO 1502

Standard: ISO DIN 13

Variants (27):

NO-GO Thread Ring Gauge	Art. -No.	NO-GO Thread Ring Gauge	Art. -No.	NO-GO Thread Ring Gauge	Art. -No.	NO-GO Thread Ring Gauge	Art. -No.
M2 x 0,4 - 6g	16330	M7 x 1,0 - 6g	16337	M16 x 2,0 - 6g	16344	M33 x 3,5 - 6g	16351
M2.5 x 0,45 - 6g	16331	M8 x 1,25 - 6g	16338	M18 x 2,5 - 6g	16345	M36 x 4,0 - 6g	16352
M3 x 0,5 - 6g	16332	M9 x 1,25 - 6g	16339	M20 x 2,5 - 6g	16346	M39 x 4,0 - 6g	16353
M3.5 x 0,6 - 6g	16333	M10 x 1,5 - 6g	16340	M22 x 2,5 - 6g	16347	M42 x 4,5 - 6g	16354
M4 x 0,7 - 6g	16334	M11 x 1,5 - 6g	16341	M24 x 3,0 - 6g	16348	M45 x 4,5 - 6g	16355
M5 x 0,8 - 6g	16335	M12 x 1,75 - 6g	16342	M27 x 3,0 - 6g	16349	M48 x 5,0 - 6g	16356
M6 x 1,0 - 6g	16336	M14 x 2,0 - 6g	16343	M30 x 3,5 - 6g	16350		



NO-GO Thread Ring Gauge

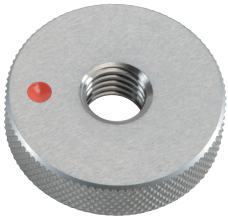
metric-fine ISO-thread DIN 13, M2 - M60

Gauge dimension: DIN ISO 1502

Standard: ISO DIN 13

Variants (81):

NO-GO Thread Ring Gauge	Art. -No.	NO-GO Thread Ring Gauge	Art. -No.	NO-GO Thread Ring Gauge	Art. -No.	NO-GO Thread Ring Gauge	Art. -No.
M2 x 0,35 - 6g	16357	M12 x 1,5 - 6g	16378	M26 x 1,5 - 6g	16399	M36 x 3,0 - 6g	16420
M2.5 x 0,35 - 6g	16358	M14 x 1,0 - 6g	16379	M27 x 1,0 - 6g	16400	M38 x 1,5 - 6g	16421
M3 x 0,35 - 6g	16359	M14 x 1,25 - 6g	16380	M27 x 1,5 - 6g	16401	M40 x 1,5 - 6g	16422
M3.5 x 0,35 - 6g	16360	M14 x 1,5 - 6g	16381	M27 x 2,0 - 6g	16402	M40 x 2,0 - 6g	16423
M4 x 0,35 - 6g	16361	M16 x 1,0 - 6g	16382	M28 x 1,5 - 6g	16403	M42 x 1,5 - 6g	16424
M4 x 0,5 - 6g	16362	M16 x 1,5 - 6g	16383	M30 x 1,0 - 6g	16404	M42 x 2,0 - 6g	16425
M5 x 0,35 - 6g	16363	M18 x 1,0 - 6g	16384	M30 x 1,5 - 6g	16405	M45 x 1,5 - 6g	16426
M5 x 0,5 - 6g	16364	M18 x 1,5 - 6g	16385	M30 x 2,0 - 6g	16406	M45 x 2,0 - 6g	16427
M6 x 0,35 - 6g	16365	M18 x 2,0 - 6g	16386	M30 x 3,0 - 6g	16407	M48 x 1,5 - 6g	16428
M6 x 0,5 - 6g	16366	M20 x 1,0 - 6g	16387	M32 x 1,5 - 6g	16408	M48 x 2,0 - 6g	16429
M6 x 0,75 - 6g	16367	M20 x 1,5 - 6g	16388	M33 x 1,5 - 6g	16409	M50 x 1,5 - 6g	16430
M8 x 0,5 - 6g	16368	M20 x 2,0 - 6g	16389	M33 x 2,0 - 6g	16410	M50 x 2,0 - 6g	16431
M8 x 0,75 - 6g	16369	M22 x 1,0 - 6g	16390	M33 x 3,0 - 6g	16411	M52 x 1,5 - 6g	16432
M8 x 1,0 - 6g	16370	M22 x 1,5 - 6g	16391	M34 x 1,5 - 6g	16412	M52 x 2,0 - 6g	16433
M10 x 0,75 - 6g	16371	M22 x 2,0 - 6g	16392	M34 x 2,0 - 6g	16413	M55 x 1,5 - 6g	16434
M10 x 1,0 - 6g	16372	M24 x 1,0 - 6g	16393	M34 x 3,0 - 6g	16414	M55 x 2,0 - 6g	16435
M10 x 1,25 - 6g	16373	M24 x 1,5 - 6g	16394	M35 x 1,5 - 6g	16415	M58 x 1,5 - 6g	16436
M12 x 0,75 - 6g	16374	M24 x 2,0 - 6g	16395	M35 x 2,0 - 6g	16416	M60 x 2,0 - 6g	16437
M12 x 1,0 - 6g	16375	M25 x 1,0 - 6g	16396	M35 x 3,0 - 6g	16417		
M12 x 0,5 - 6g	16376	M25 x 1,5 - 6g	16397	M36 x 1,5 - 6g	16418		
M12 x 1,25 - 6g	16377	M25 x 2,0 - 6g	16398	M36 x 2,0 - 6g	16419		



NO-GO Thread Ring Gauge

Unified Coarse and Fine thread ANSI B 1.1 UNC, Nr. 4 - 3/4

Gauge dimension: ANSI B1.2

Standard: ANSI B 1.1

Variants (12):

NO-GO Thread Ring Gauge

Art.
-No.

Nr. 4 x 40 UNC - 2A	16438
Nr. 6 x 32 UNC - 2A	16439
Nr. 8 x 32 UNC - 2A	16440
Nr. 10 x 24 UNC - 2A	16441

NO-GO Thread Ring Gauge

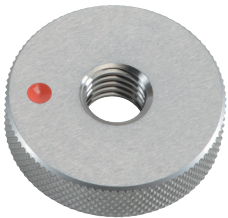
Art.
-No.

1/4 x 20 UNC - 2A	16442
5/16 x 18 UNC - 2A	16443
3/8 x 16 UNC - 2A	16444
7/16 x 14 UNC - 2A	16445

NO-GO Thread Ring Gauge

Art.
-No.

1/2 x 13 UNC - 2A	16446
9/16 x 12 UNC - 2A	16447
5/8 x 11 UNC - 2A	16448
3/4 x 10 UNC - 2A	16449



NO-GO Thread Ring Gauge

Unified fine thread ANSI B 1.1 UNF, No. 4 - 3/4

Gauge dimension: ANSI B1.2

Standard: ANSI B 1.1

Variants (12):

NO-GO Thread Ring Gauge

Art.
-No.

Nr. 4 x 48 UNF - 2A	16450
Nr. 6 x 40 UNF - 2A	16451
Nr. 8 x 36 UNF - 2A	16452
Nr. 10 x 32 UNF - 2A	16453

NO-GO Thread Ring Gauge

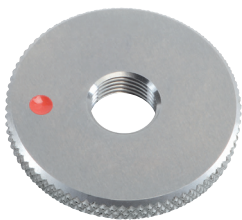
Art.
-No.

1/4 x 28 UNF - 2A	16454
5/16 x 24 UNF - 2A	16455
3/8 x 24 UNF - 2A	16456
7/16 x 20 UNF - 2A	16457

NO-GO Thread Ring Gauge

Art.
-No.

1/2 x 20 UNF - 2A	16458
9/16 x 18 UNF - 2A	16459
5/8 x 18 UNF - 2A	16460
3/4 x 16 UNF - 2A	16461



NO-GO Thread Ring Gauge

Pipe-thread DIN ISO 228, G 1/8 - G 2

Gauge dimension: DIN EN ISO 228-2

Standard: DIN ISO 228

Variants (12):

NO-GO Thread Ring Gauge

Art.
-No.

G 1/8 A	16462
G 1/4 A	16463
G 3/8 A	16464
G 1/2 A	16465

NO-GO Thread Ring Gauge

Art.
-No.

G 5/8 A	16466
G 3/4 A	16467
G 7/8 A	16468
G 1" A	16469

NO-GO Thread Ring Gauge

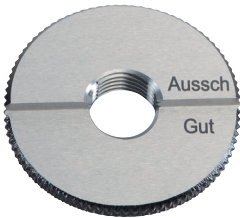
Art.
-No.

G 1.1/4 A	16470
G 1.1/2 A	16471
G 1.3/4 A	16472
G 2" A	16473



Thread plug gauges, 7-piece set in sturdy plastic case metric M 3 - M 12

Contents:	Art.-No.	Art.-No.
1x Thread plug gauge, M3	16012	1x Thread plug gauge, M8 16021
1x Thread plug gauge, M4	16014	1x Thread plug gauge, M10 16023
1x Thread plug gauge, M5	16016	1x Thread plug gauge, M12 16025
1x Thread plug gauge, M6	16019	



Thread Ring Gauge

American tapered pipe thread, taper 1:16 (NPT), 1/8 - 1 NPT

Gauge dimension: ANSI/ASME B 1.20.1 Standard: ANSI/ASME B 1.20.1

Variants (6):

Thread Ring Gauge

	Art.-No.
1/8 x 27 NPT	16485
1/4 x 18 NPT	16486
3/8 x 18 NPT	16487

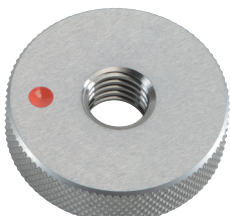
Thread Ring Gauge

	Art.-No.
1/2 x 14 NPT	16488
3/4 x 14 NPT	16489
1" x 11,5 NPT	16490



GO Ring gauges, 7-piece set in sturdy plastic case M 3 - M 12

Contents:	Art.-No.	Art.-No.
1x GO Ring gauge, M3	16188	1x GO Ring gauge, M8 16194
1x GO Ring gauge, M4	16190	1x GO Ring gauge, M10 19196
1x GO Ring gauge, M5	16191	1x GO Ring gauge, M12 19198
1x GO Ring gauge, M6	16192	



NO-GO Ring gauges, 7-piece set in sturdy plastic case M 3 - M 12

Contents:	Art.-No.	Art.-No.
1x NO-GO Thread Ring Gauge M3	16332	1x NO-GO Thread Ring Gauge M8 16338
1x NO-GO Thread Ring Gauge M4	16334	1x NO-GO Thread Ring Gauge M1 16340
1x NO-GO Thread Ring Gauge M5	16335	1x NO-GO Thread Ring Gauge M12 16342
1x NO-GO Thread Ring Gauge M6	16336	

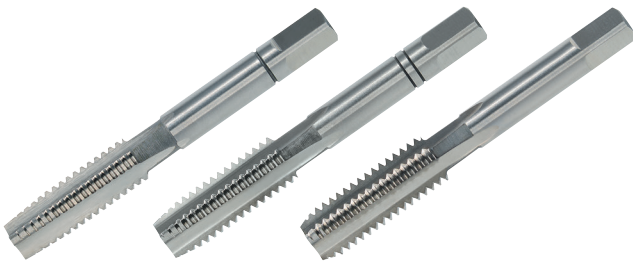


Hand taps

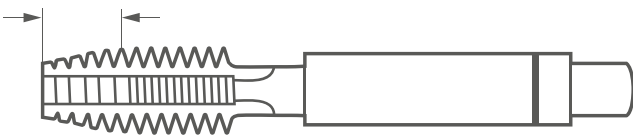




Hand taps



- Rougher = 6-8 Thread pitch
- Intermediate = 4-5 Thread pitch
- Finisher = 2-3 Thread pitch



HSS-G screw taps are suitable for machinable raw materials up to 900 N/mm². The design in HSS-E for hard to machine raw materials up to 1200 N/mm² and vapourised hand screw taps are particularly suited to wear-resistant steels up to 1400 N/mm².

The taps can be distinguished from their thread leads and marking. Pre-cutters (rougher) are marked on their shank with one and middle cutter (intermediate) with two rings. The finished cutter does not carry a ring and is generally not marked.

It is recommended that the finishing cutter should only be used for trimming damaged threads. The rougher, intermediate and finisher can be ordered separately.

M (metric)



Hand taps, metric ISO-thread DIN 13

HSS-G Hand taps for non abrasive material up to 900 N/mm². The taps made of HSS-E are suitable for abrasive steels up to 1200 N/mm² and the steam tempered hand taps are particularly suited to wear resistant steels up to 1400 N/mm² tensile strength.

Hand taps for metric right hand threads

- Hand taps acc. to DIN, ISO and JIS-B standard
- Variations from M 1 to M 100



Mini Hand taps (set of 22 pcs.) (48001)

DIN 352 M 1 - M 2.6

Type of thread	Standard	Material	Packing	Size
metric ISO thread DIN 13	DIN 352	HSS-G	in wooden case	Diameter 1 - 2,6

Application/ for general use:

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

Contents:

	Art. -No.
1x Adjustable Tap Wrenches DIN 1814 Size 0	13000
1x Hand taps (set of 3 pcs.) DIN 352 HSS-G - M 1 x 0.25	27302
1x Hand taps (set of 3 pcs.) DIN 352 HSS-G - M 1.2 x 0.25	27306
1x Hand taps (set of 3 pcs.) DIN 352 HSS-G - M 1.4 x 0.3	27308
1x Hand taps (set of 3 pcs.) DIN 352 HSS-G - M 1.7 x 0.35	27312
1x Hand taps (set of 3 pcs.) DIN 352 HSS-G - M 2 x 0.4	27316
1x Hand taps (set of 3 pcs.) DIN 352 HSS-G - M 2.3 x 0.4	27320
1x Hand taps (set of 3 pcs.) DIN 352 HSS-G - M 2.6 x 0.45	27324



P.K.20 Hand taps (set of 22 pcs.) (47001)

M 3 - M 12

Type of thread	Standard	Material	Packing	Size
metric ISO thread DIN 13	DIN Standard	HSS-G	in plastic case	Diameter M 3 - 12

All threading tools, threading tool holder and accessories can also be ordered separately.

Application/for general use:

- › non abrasive material up to 900 N/mm²
- › unalloyed and low alloyed steel
- › for through and blind holes
- › for thread cutting by hand
- › small and handy problemsolver for standard application
- › the most popular dimensions in one case
- › HSS-G Hand taps acc. to DIN 352

Contents:

	Art. -No.
1x HSS-G Hand taps (set of 3 pcs.) M 3	27326
1x HSS-G Hand taps (set of 3 pcs.) M 4	27330
1x HSS-G Hand taps (set of 3 pcs.) M 5	27334
1x HSS-G Hand taps (set of 3 pcs.) M 6	27338
1x HSS-G Hand taps (set of 3 pcs.) M 8	27342
1x HSS-G Hand taps (set of 3 pcs.) M 10	27346
1x HSS-G Hand taps (set of 3 pcs.) M 12	27350
1x Adjustable tap wrench, zinc die cast No. 1.1/2	13015



Hand taps (set of 22 pcs.) (99917)

HSS-G, UNC No. 5 - UNC 1/2" + cobit BT11Neo Mix-TORSION

Material	Packing	Size
HSS-G	in plastic case	UNC No. 5 - UNC 1/2"

Application/for general use:

- › non abrasive material up to 900 N/mm²
- › unalloyed and low alloyed steel
- › for through and blind holes
- › for thread cutting by hand
- › small and handy problemsolver for standard application
- › the most popular dimensions in one case



P.K.21 Hand taps (set of 23 pcs.) (99916)

incl. ratchet M 3 - M 12 + cobit BT11Neo Mix-TORSION

Type of thread	Standard	Material	Packing	Size
metric ISO thread	DIN	HSS-G	in plastic case	Diameter M 3 - 12
DIN 13	Standard			

All threading tools, threading tool holder and accessories can also be ordered separately.

Application/for general use:

- › non abrasive material up to 900 N/mm²
- › unalloyed and low alloyed steel
- › for through and blind holes
- › for thread cutting by hand
- › small and handy problemsolver for standard application
- › the most popular dimensions in one case
- › HSS-G Hand taps acc. to DIN 352

Contents:

	Art. -No.
1x HSS-G Hand taps (set of 3 pcs.) M 3	27326
1x HSS-G Hand taps (set of 3 pcs.) M 4	27330
1x HSS-G Hand taps (set of 3 pcs.) M 5	27334
1x HSS-G Hand taps (set of 3 pcs.) M 6	27338
1x HSS-G Hand taps (set of 3 pcs.) M 8	27342
1x HSS-G Hand taps (set of 3 pcs.) M 10	27346
1x HSS-G Hand taps (set of 3 pcs.) M 12	27350
1x Adjustable tap wrench, zinc die cast No. 1.1/2	13015
1x Tap holder with ratchet, size 1	10001



P.K.21 Hand taps (set of 23 pcs.) (47005)

incl. ratchet M 3 - M 12

Type of thread	Standard	Material	Packing	Size
metric ISO thread DIN 13	DIN Standard	HSS-G	in plastic case	Diameter M 3 - 12

All threading tools, threading tool holder and accessories can also be ordered separately.

Application/for general use:

- › non abrasive material up to 900 N/mm²
- › unalloyed and low alloyed steel
- › for through and blind holes
- › for thread cutting by hand
- › small and handy problemsolver for standard application
- › the most popular dimensions in one case
- › HSS-G Hand taps acc. to DIN 352

Contents:

	Art. -No.
1x HSS-G Hand taps (set of 3 pcs.) M 3	27326
1x HSS-G Hand taps (set of 3 pcs.) M 4	27330
1x HSS-G Hand taps (set of 3 pcs.) M 5	27334
1x HSS-G Hand taps (set of 3 pcs.) M 6	27338
1x HSS-G Hand taps (set of 3 pcs.) M 8	27342
1x HSS-G Hand taps (set of 3 pcs.) M 10	27346
1x HSS-G Hand taps (set of 3 pcs.) M 12	27350
1x Adjustable tap wrench, zinc die cast No. 1.1/2	13015
1x Tap holder with ratchet, size 1	10001



Hand taps (set of 23 pcs.) (47055)

incl. ratchet HSS-E M 3 - M 12

Type of thread	Standard	Material	Packing	Size
metric ISO thread DIN 13	DIN Standard	HSS-E	in plastic case	Diameter M 3 - 12

All threading tools, threading tool holder and accessories can also be ordered separately.

Application/for general use:

- › non abrasive material up to 900 N/mm²
- › unalloyed and low alloyed steel
- › for through and blind holes
- › for thread cutting by hand
- › small and handy problemsolver for standard application
- › the most popular dimensions in one case
- › HSS-E Hand taps acc. to DIN 352

Contents:

	Art. -No.
1x HSS-E Hand taps (set of 3 pcs.) M 3	57326
1x HSS-E Hand taps (set of 3 pcs.) M 4	57330
1x HSS-E Hand taps (set of 3 pcs.) M 5	57334
1x HSS-E Hand taps (set of 3 pcs.) M 6	57338
1x HSS-E Hand taps (set of 3 pcs.) M 8	57342
1x HSS-E Hand taps (set of 3 pcs.) M 10	57346
1x HSS-E Hand taps (set of 3 pcs.) M 12	57350
1x Adjustable tap wrench, zinc die cast No. 1.1/2	13015
1x Tap holder with ratchet, size 1	10001



P.V.22 Hand taps (set of 29 pcs.) incl. drills M3 - M12 ([49510](#))

Type of thread	Material	Packing	Size
metric ISO thread DIN 13	HSS-G	in drillbox metal case	Diameter M 3 - 12

All threading tools, threading tool holder and accessories can also be ordered separately.

Application/for general use:

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand
- small and handy problemsolver for standard application
- the most popular dimensions in one case
- HSS-G Hand taps acc. to DIN 352
- HSS Round dies acc. to DIN 223 (DIN EN 22568)

Contents:

Contents:	Art. -No.	Contents:
1x HSS-G Hand taps (set of 3 pcs.) M 3	27326	1x HSS Twist drill 2,50 mm (M 3)
1x HSS-G Hand taps (set of 3 pcs.) M 4	27330	1x HSS Twist drill 3,30 mm (M 4)
1x HSS-G Hand taps (set of 3 pcs.) M 5	27334	1x HSS Twist drill 4,20 mm (M 5)
1x HSS-G Hand taps (set of 3 pcs.) M 6	27338	1x HSS Twist drill 5,00 mm (M 6)
1x HSS-G Hand taps (set of 3 pcs.) M 8	27342	1x HSS Twist drill 6,80 mm (M 8)
1x HSS-G Hand taps (set of 3 pcs.) M 10	27346	1x HSS Twist drill 8,50 mm (M 10)
1x HSS-G Hand taps (set of 3 pcs.) M 12	27350	1x HSS Twist drill 10,20 mm (M 12)
1x Adjustable tap wrench, zinc die cast No. 1.1/2	13015	



P.V.23 Hand taps (set of 30 pcs.) incl. drills M3 - M12 ([49511](#))

Type of thread	Material	Packing	Size
metric ISO thread DIN 13	HSS-G	in drillbox metal case	Diameter M 3 - 12

All threading tools, threading tool holder and accessories can also be ordered separately.

Application/for general use:

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand
- the most popular dimensions in one case
- HSS-G Hand taps acc. to DIN 352
- HSS Round dies acc. to DIN 223 (DIN EN 22568)

Contents:

Contents:	Art. -No.	Contents:
1x HSS-G Hand taps (set of 3 pcs.) M 3	27326	1x HSS Twist drill 2,50 mm (M 3)
1x HSS-G Hand taps (set of 3 pcs.) M 4	27330	1x HSS Twist drill 3,30 mm (M 4)
1x HSS-G Hand taps (set of 3 pcs.) M 5	27334	1x HSS Twist drill 4,20 mm (M 5)
1x HSS-G Hand taps (set of 3 pcs.) M 6	27338	1x HSS Twist drill 5,00 mm (M 6)
1x HSS-G Hand taps (set of 3 pcs.) M 8	27342	1x HSS Twist drill 6,80 mm (M 8)
1x HSS-G Hand taps (set of 3 pcs.) M 10	27346	1x HSS Twist drill 8,50 mm (M 10)
1x HSS-G Hand taps (set of 3 pcs.) M 12	27350	1x HSS Twist drill 10,20 mm (M 12)
1x Adjustable tap wrench, zinc die cast No. 1.1/2	13015	
1x Tap holder with ratchet, size 1	10001	



Hand taps (set of 3 pcs.)

DIN 352 HSS-G - M (hand tap taper, hand tap second, hand tap finisher)

Type of thread: metric ISO-thread DIN 13

Tolerance: ISO 2 / 6H

Variants (54):

Application/for general use:

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



D	L1	L2	D2	Square	Art.-No. Set	Art.-No. Taper	Art.-No. Second	Art.-No. Finisher
M 1 x 0.25	32	5.5	2.5	2.1	27302	27302-1	27302-2	27302-3
M 1.1 x 0.25	32	5.5	2.5	2.1	27304	27304-1	27304-2	27304-3
M 1.2 x 0.25	32	5.5	2.5	2.1	27306	27306-1	27306-2	27306-3
M 1.4 x 0.3	32	7.0	2.5	2.1	27308	27308-1	27308-2	27308-3
M 1.6 x 0.35	32	8.0	2.5	2.1	27310	27310-1	27310-2	27310-3
M 1.7 x 0.35	32	8.0	2.5	2.1	27312	27312-1	27312-2	27312-3
M 1.8 x 0.35	32	8.0	2.5	2.1	27314	27314-1	27314-2	27314-3
M 2 x 0.4	36	8.0	2.8	2.1	27316	27316-1	27316-2	27316-3
M 2.2 x 0.45	36	9.0	2.8	2.1	27318	27318-1	27318-2	27318-3
M 2.3 x 0.4	36	9.0	2.8	2.1	27320	27320-1	27320-2	27320-3
M 2.5 x 0.45	40	9.0	2.8	2.1	27322	27322-1	27322-2	27322-3
M 2.6 x 0.45	40	9.0	2.8	2.1	27324	27324-1	27324-2	27324-3
M 3 x 0.5	40	11.0	3.5	2.7	27326	27326-1	27326-2	27326-3
M 3.5 x 0.6	45	13.0	4.0	3.0	27328	27328-1	27328-2	27328-3
M 4 x 0.7	45	13.0	4.5	3.4	27330	27330-1	27330-2	27330-3
M 4.5 x 0.75	50	16.0	6.0	4.9	27332	27332-1	27332-2	27332-3
M 5 x 0.8	50	16.0	6.0	4.9	27334	27334-1	27334-2	27334-3
M 5.5 x 0.9	50	18.0	6.0	4.9	27336	27336-1	27336-2	27336-3
M 6 x 1.0	50	19.0	6.0	4.9	27338	27338-1	27338-2	27338-3
M 7 x 1.0	50	19.0	6.0	4.9	27340	27340-1	27340-2	27340-3
M 8 x 1.25	56	22.0	6.0	4.9	27342	27342-1	27342-2	27342-3
M 9 x 1.25	63	22.0	7.0	5.5	27344	27344-1	27344-2	27344-3
M 10 x 1.5	70	24.0	7.0	5.5	27346	27346-1	27346-2	27346-3
M 11 x 1.5	70	24.0	8.0	6.2	27348	27348-1	27348-2	27348-3
M 12 x 1.75	75	29.0	9.0	7.0	27350	27350-1	27350-2	27350-3
M 14 x 2.0	80	30.0	11.0	9.0	27354	27354-1	27354-2	27354-3
M 15 x 2.0	80	32.0	12.0	9.0	27356	27356-1	27356-2	27356-3
M 16 x 2.0	80	32.0	12.0	9.0	27358	27358-1	27358-2	27358-3
M 18 x 2.5	95	40.0	14.0	11.0	27362	27362-1	27362-2	27362-3
M 20 x 2.5	95	40.0	16.0	12.0	27366	27366-1	27366-2	27366-3
M 22 x 2.5	100	40.0	18.0	14.5	27370	27370-1	27370-2	27370-3
M 24 x 3.0	110	50.0	18.0	14.5	27374	27374-1	27374-2	27374-3



D		L1	L2	D2	Square	Art.-No. Set	Art.-No. Taper	Art.-No. Second	Art.-No. Finisher
M	27 x 3.0	110	50.0	20.0	16.0	27376	27376-1	27376-2	27376-3
M	30 x 3.0	125	56.0	22.0	18.0	27378	27378-1	27378-2	27378-3
M	33 x 3.5	125	56.0	25.0	20.0	27380	27380-1	27380-2	27380-3
M	36 x 4.0	150	63.0	28.0	22.0	27382	27382-1	27382-2	27382-3
M	39 x 4.0	150	63.0	32.0	24.0	27384	27384-1	27384-2	27384-3
M	42 x 4.5	150	63.0	32.0	24.0	27386	27386-1	27386-2	27386-3
M	45 x 4.5	160	70.0	36.0	29.0	27388	27388-1	27388-2	27388-3
M	48 x 5.0	180	75.0	36.0	29.0	27390	27390-1	27390-2	27390-3
M	52 x 5.0	180	75.0	40.0	32.0	27392	27392-1	27392-2	27392-3
M	56 x 5.5	200	85.0	45.0	35.0	27394	27394-1	27394-2	27394-3
M	60 x 5.5	200	85.0	45.0	35.0	27396	27396-1	27396-2	27396-3
M	64 x 6.0	220	90.0	50.0	39.0	27398	27398-1	27398-2	27398-3
M	68 x 6.0	220	90.0	50.0	39.0	27399	27399-1	27399-2	27399-3
M	72 x 6.0	240	80.0	50.0	39.0	28130	28130-1	28130-2	28130-3
M	76 x 6.0	240	80.0	50.0	39.0	28131	28131-1	28131-2	28131-3
M	80 x 6.0	260	85.0	50.0	39.0	28132	28132-1	28132-2	28132-3
M	84 x 6.0	260	85.0	50.0	39.0	28133	28133-1	28133-2	28133-3
M	88 x 6.0	260	85.0	50.0	39.0	28134	28134-1	28134-2	28134-3
M	90 x 6.0	260	85.0	50.0	39.0	28135	28135-1	28135-2	28135-3
M	92 x 6.0	280	90.0	56.0	44.0	28136	28136-1	28136-2	28136-3
M	96 x 6.0	280	90.0	56.0	44.0	28137	28137-1	28137-2	28137-3
M	100 x 6.0	280	90.0	56.0	44.0	28138	28138-1	28138-2	28138-3



Hand taps (set of 3 pcs.)

DIN 352 HSS-E - M

(hand tap rougher, hand tap intermediate, hand tap finisher)

Type of thread: metric ISO-thread DIN 13

Tolerance: ISO 2 /6H

Advantages:

- > high cutting ability

Application:

- > abrasive material
- > Steel up to 1200 N/mm²
- > and for general use

Variants (15):



D	L1	L2	D2	Square	Art.-No. Set	Art.-No. Rougher	Art.-No. Intermediate	Art.-No. Finisher
M 3 x 0.5	40	11	3.5	2.7	57326	57326-1	57326-2	57326-3
M 4 x 0.7	45	13	4.5	3.4	57330	57330-1	57330-2	57330-3
M 5 x 0.8	50	16	6.0	4.9	57334	57334-1	57334-2	57334-3
M 6 x 1.0	50	19	6.0	4.9	57338	57338-1	57338-2	57338-3
M 8 x 1.25	56	22	6.0	4.9	57342	57342-1	57342-2	57342-3
M 10 x 1.5	70	24	7.0	5.5	57346	57346-1	57346-2	57346-3
M 12 x 1.75	75	29	9.0	7.0	57350	57350-1	57350-2	57350-3
M 14 x 2.0	80	30	11.0	9.0	57354	57354-1	57354-2	57354-3
M 16 x 2.0	80	32	12.0	9.0	57358	57358-1	57358-2	57358-3
M 18 x 2.5	95	40	14.0	11.0	57362	57362-1	57362-2	57362-3
M 20 x 2.5	95	40	16.0	12.0	57366	57366-1	57366-2	57366-3
M 22 x 2.5	100	40	18.0	14.5	57370	57370-1	57370-2	57370-3
M 24 x 3.0	110	50	18.0	14.5	57374	57374-1	57374-2	57374-3
M 27 x 3.0	110	50	20.0	16.0	57376	57376-1	57376-2	57376-3
M 30 x 3.5	125	56	22.0	18.0	57378	57378-1	57378-2	57378-3



Hand taps (set of 3 pcs.)

non-serial ISO 529, HSS-G - M

(hand tap taper, hand tap second, hand tap finisher)

Type of thread: metric ISO-thread DIN 13

Tolerance: ISO 2 / 6H

Variants (35/18):

Application/ for general use:

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



D	L1	L2	D2	Square	Art.-No. Set	Art.-No. Taper	Art.-No. Second	Art.-No. Finisher
M 1.6 x 0.35	41	8	2.5	2.0	80410	-	-	-
M 2 x 0.4	41	8	2.5	2.0	80416	80416-1	80416-2	80416-3
M 2.2 x 0.45	44.5	9.5	2.8	2.24	80418	-	-	-
M 2.5 x 0.45	44.5	9.5	2.8	2.24	80422	80422-1	80422-2	80422-3
M 3 x 0.5	48	11	3.15	2.5	80426	80426-1	80426-2	80426-3
M 3.5 x 0.6	50	13	3.55	2.8	80428	80428-1	80428-2	80428-3
M 4 x 0.7	53	13	4.0	3.15	80430	80430-1	80430-2	80430-3
M 4.5 x 0.75	53	13	4.5	3.55	80432	-	-	-
M 5 x 0.8	58	16	5.0	4.0	80434	80434-1	80434-2	80434-3
M 6 x 1.0	66	19	6.3	5.0	80438	80438-1	80438-2	80438-3
M 7 x 1.0	66	19	7.1	5.6	80440	-	-	-
M 8 x 1.25	72	22	8.0	6.3	80442	80442-1	80442-2	80442-3
M 9 x 1.25	72	22	9.0	7.1	80444	-	-	-
M 10 x 1.5	80	24	10.0	8.0	80446	80446-1	80446-2	80446-3
M 11 x 1.5	85	25	8.0	6.3	80448	-	-	-
M 12 x 1.75	89	29	9.0	7.1	80450	80450-1	80450-2	80450-3
M 14 x 2.0	95	30	11.2	9.0	80454	80454-1	80454-2	80454-3
M 16 x 2.0	102	32	12.5	10.0	80458	80458-1	80458-2	80458-3
M 18 x 2.5	110	37	14.0	11.2	80462	80462-1	80462-2	80462-3
M 20 x 2.5	112	37	14.0	11.2	80466	80466-1	80466-2	80466-3
M 22 x 2.5	118	38	16.0	12.5	80470	80470-1	80470-2	80470-3
M 24 x 3.0	130	45	18.0	14.0	80474	80474-1	80474-2	80474-3
M 27 x 3.0	135	45	20.0	16.0	80476	80476-1	80476-2	80476-3
M 30 x 3.5	138	48	20.0	16.0	80478	80478-1	80478-2	80478-3
M 33 x 3.5	151	51	22.4	18.0	80480	-	-	-
M 36 x 4.0	162	57	25.0	20.0	80482	-	-	-
M 39 x 4.0	170	60	28.0	22.4	80484	-	-	-
M 42 x 4.5	170	60	28.0	22.4	80486	-	-	-
M 45 x 4.5	187	67	31.5	25.0	80488	-	-	-
M 48 x 5.0	187	67	31.5	25.0	80490	-	-	-
M 52 x 5.0	200	70	35.5	28.0	80492	-	-	-



D	L1	L2	D2	Square	Art.-No. Set	Art.-No. Taper	Art.-No. Second	Art.-No. Finisher
M 56 x 5.5	200	70	35.5	28.0	80494	-	-	-
M 60 x 5.5	221	76	40.0	31.5	80496	-	-	-
M 64 x 6.0	224	79	40.0	31.5	80498	-	-	-
M 68 x 6.0	234	79	45.0	35.5	80499	-	-	-



Hand taps (set of 3 pcs.)

DIN 352 HSS-E VAP - M

(hand tap rougher, hand tap intermediate, hand tap finisher)

Type of thread: metric ISO-thread DIN 13

Tolerance: ISO 2 /6H

Variants (7):

Application: wear resistant steel up to 1400 N/mm²

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

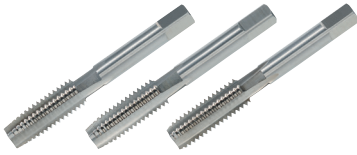
VAP-coating:

- > improved adhesion of the coolant and Lubricant
- > reduces tearing of the lubricating fill and the formation of cold welding

Rougher piloted



D	L1	L2	D2	Square	Art.-No. Set	Art.-No. Rougher	Art.-No. Intermediate	Art.-No. Finisher
M 3 x 0.5	40	11	3.5	2.7	57726	57726-1	57726-2	57726-3
M 4 x 0.7	45	13	4.5	3.4	57730	57730-1	57730-2	57730-3
M 5 x 0.8	50	16	6.0	4.9	57734	57734-1	57734-2	57734-3
M 6 x 1.0	50	19	6.0	4.9	57738	57738-1	57738-2	57738-3
M 8 x 1.25	56	22	6.0	4.9	57742	57742-1	57742-2	57742-3
M 10 x 1.5	70	24	7.0	5.5	57746	57746-1	57746-2	57746-3
M 12 x 1.75	75	29	9.0	7.0	57750	57750-1	57750-2	57750-3



Hand taps (set of 3 pcs.)

non-serial DIN 352 HSS-G - M

(hand tap rougher, hand tap intermediate, hand tap finisher)

Type of thread: metric ISO-thread DIN 13

Tolerance: ISO 2 /6H

Variants (28):

Application/ for general use:

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



D	L1	L2	D2	Square	Art.-No. Set	Art.-No. Rougher	Art.-No. Intermediate	Art.-No. Finisher
M 2 x 0.4	36	8	2.8	2.1	27616	27616-1	27616-2	27616-3
M 2.5 x 0.45	40	9	2.8	2.1	27622	27622-1	27622-2	27622-3
M 3 x 0.5	40	11	3.5	2.7	27626	27626-1	27626-2	27626-3
M 3 x 0.6	40	11	3.5	2.7	27627	27627-1	27627-2	27627-3
M 4 x 0.7	45	13	4.5	3.4	27630	27630-1	27630-2	27630-3
M 4 x 0.75	45	13	4.5	3.4	27631	27631-1	27631-2	27631-3
M 5 x 0.8	50	16	6.0	4.9	27634	27634-1	27634-2	27634-3
M 5 x 0.9	50	16	6.0	4.9	27635	27635-1	27635-2	27635-3
M 6 x 1.0	50	19	6.0	4.9	27638	27638-1	27638-2	27638-3
M 8 x 1.25	56	22	6.0	4.9	27642	27642-1	27642-2	27642-3
M 9 x 1.25	63	22	7.0	5.5	27644	27644-1	27644-2	27644-3
M 10 x 1.5	70	24	7.0	5.5	27646	27646-1	27646-2	27646-3
M 11 x 1.5	70	24	8.0	6.2	27648	27648-1	27648-2	27648-3
M 12 x 1.75	75	29	9.0	7.0	27650	27650-1	27650-2	27650-3
M 13 x 1.75	75	29	9.0	7.0	27652	27652-1	27652-2	27652-3
M 14 x 2.0	80	30	11.0	9.0	27654	27654-1	27654-2	27654-3
M 16 x 2.0	80	32	12.0	9.0	27658	27658-1	27658-2	27658-3
M 18 x 2.5	95	40	14.0	11.0	27662	27662-1	27662-2	27662-3
M 19 x 2.5	95	40	14.0	11.0	27664	27664-1	27664-2	27664-3
M 20 x 2.5	95	40	16.0	12.0	27666	27666-1	27666-2	27666-3
M 22 x 2.5	100	40	18.0	14.5	27670	27670-1	27670-2	27670-3
M 24 x 3.0	110	50	18.0	14.5	27674	27674-1	27674-2	27674-3
M 27 x 3.0	110	50	20.0	16.0	27676	27676-1	27676-2	27676-3
M 30 x 3.5	125	56	22.0	18.0	27678	27678-1	27678-2	27678-3
M 33 x 3.5	125	56	25.0	20.0	27680	27680-1	27680-2	27680-3
M 36 x 4.0	150	63	28.0	22.0	27682	27682-1	27682-2	27682-3
M 39 x 4.0	150	63	32.0	24.0	27684	27684-1	27684-2	27684-3
M 42 x 4.5	150	63	32.0	24.0	27686	27686-1	27686-2	27686-3



Hand taps (set of 3 pcs.)

JIS B-4430 HSS-G - M

(hand tap rougher, hand tap intermediate, hand tap finisher)

Type of thread: metric ISO-thread DIN 13

Tolerance: ISO 2 /6H

Application/ for general use:

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

Variants (21):



D	L1	L2	D2	Square	Art.-No. Set	Art.-No. Rougher	Art.-No. Intermediate	Art.-No. Finisher
M 2 x 0.4	42	15	3.0	2.5	90414	90414-1	90414-2	90414-3
M 2.3 x 0.4	42	15	3.0	2.5	90416	90416-1	90416-2	90416-3
M 2.5 x 0.45	44	16	3.0	2.5	90418	90418-1	90418-2	90418-3
M 2.6 x 0.45	44	16	3.0	2.5	90420	90420-1	90420-2	90420-3
M 3 x 0.5	46	18	4.0	3.2	90422	90422-1	90422-2	90422-3
M 3.5 x 0.6	48	18	4.0	3.2	90424	90424-1	90424-2	90424-3
M 4 x 0.7	52	20	5.0	4.0	90426	90426-1	90426-2	90426-3
M 5 x 0.8	60	22	5.5	4.5	90430	90430-1	90430-2	90430-3
M 6 x 1.0	62	24	6.0	4.5	90438	90438-1	90438-2	90438-3
M 7 x 1.0	65	26	6.2	4.5	90444	90444-1	90444-2	90444-3
M 8 x 1.25	70	30	6.2	5.0	90446	90446-1	90446-2	90446-3
M 10 x 1.5	75	32	7.0	5.5	90454	90454-1	90454-2	90454-3
M 12 x 1.75	82	38	8.5	6.5	90460	90460-1	90460-2	90460-3
M 14 x 2.0	88	42	10.5	8.0	90466	90466-1	90466-2	90466-3
M 16 x 2.0	95	45	12.5	10.0	90472	90472-1	90472-2	90472-3
M 18 x 2.5	100	48	14.0	11.0	90478	90478-1	90478-2	90478-3
M 20 x 2.5	105	50	15.0	12.0	90484	90484-1	90484-2	90484-3
M 22 x 2.5	115	55	17.0	13.0	90490	90490-1	90490-2	90490-3
M 24 x 3.0	120	58	19.0	15.0	90496	90496-1	90496-2	90496-3
M 27 x 3.0	130	62	20.0	15.0	91402	91402-1	91402-2	91402-3
M 30 x 3.5	135	65	23.0	17.0	91408	91408-1	91408-2	91408-3



Hand taps (set of 3 pcs.)

JIS B-4430 HSS-G - Mf

(hand tap rougher, hand tap intermediate, hand tap finisher)

Type of thread: metric ISO-thread DIN 13

Tolerance: ISO 2 /6H

Application/ for general use:

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

Variants (24):



D	L1	L2	D2	Square	Art.-No. Set	Art.-No. Rougher	Art.-No. Intermediate	Art.-No. Finisher
M 5 x 0.75	-	-	-	-	90431	90431-1	90431-2	90431-3
M 6 x 0.75	-	-	-	-	90440	90440-1	90440-2	90440-3
M 8 x 1.0	-	-	-	-	90448	90448-1	90448-2	90448-3
M 8 x 0.75	-	-	-	-	90450	90450-1	90450-2	90450-3
M 10 x 1.25	-	-	-	-	90455	90455-1	90455-2	90455-3
M 10 x 1.0	-	-	-	-	90456	90456-1	90456-2	90456-3
M 12 x 1.5	-	-	-	-	90462	90462-1	90462-2	90462-3
M 12 x 1.25	-	-	-	-	90463	90463-1	90463-2	90463-3
M 12 x 1.0	-	-	-	-	90464	90464-1	90464-2	90464-3
M 14 x 1.5	-	-	-	-	90468	90468-1	90468-2	90468-3
M 14 x 1.25	-	-	-	-	90469	90469-1	90469-2	90469-3
M 14 x 1.0	-	-	-	-	90470	90470-1	90470-2	90470-3
M 16 x 1.5	-	-	-	-	90474	90474-1	90474-2	90474-3
M 16 x 1.0	-	-	-	-	90476	90476-1	90476-2	90476-3
M 18 x 1.5	-	-	-	-	90480	90480-1	90480-2	90480-3
M 18 x 1.0	-	-	-	-	90482	90482-1	90482-2	90482-3
M 20 x 1.5	-	-	-	-	90486	90486-1	90486-2	90486-3
M 20 x 1.0	-	-	-	-	90488	90488-1	90488-2	90488-3
M 22 x 1.5	-	-	-	-	90492	90492-1	90492-2	90492-3
M 22 x 2.0	-	-	-	-	90493	90493-1	90493-2	90493-3
M 22 x 1.0	-	-	-	-	90494	90494-1	90494-2	90494-3
M 24 x 1.5	-	-	-	-	90498	90498-1	90498-2	90498-3
M 27 x 1.5	-	-	-	-	91406	91406-1	91406-2	91406-3
M 30 x 1.5	-	-	-	-	91409	91409-1	91409-2	91409-3



M (metric) left hand

Hand taps, metric ISO-thread DIN 13

HSS-G Hand taps for non abrasive materials up to 900 N/mm² and for thread cutting in through or blind holes.



Hand taps for metric left hand threads

- Hand taps acc. to DIN 352 and ISO 529 standard
- Variations from M 3 LH to M 52 LH



Hand taps, left hand (set of 23 pcs.) (47075)

incl. ratchet M 3 LH - M 12 LH

Type of thread	Standard	Material	Packing	Size
metric ISO thread DIN 13	DIN Standard	HSS-G	in plastic case	Diameter M 3 - 12

Application/for general use:

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand
- small and handy problemsolver for standard application
- the most popular dimensions in one case
- HSS-G Hand taps acc. to DIN 352

All threading tools, threading tool holder and accessories can also be ordered separately.

Contents:

	Art. -No.
1x HSS-G Hand taps (set of 3 pcs.) M 3 LH	27026
1x HSS-G Hand taps (set of 3 pcs.) M 4 LH	27030
1x HSS-G Hand taps (set of 3 pcs.) M 5 LH	27034
1x HSS-G Hand taps (set of 3 pcs.) M 6 LH	27038
1x HSS-G Hand taps (set of 3 pcs.) M 8 LH	27042
1x HSS-G Hand taps (set of 3 pcs.) M 10 LH	27046
1x HSS-G Hand taps (set of 3 pcs.) M 12 LH	27050
1x Adjustable tap wrench, zinc die cast No. 1.1/2	13015
1x Tap holder with ratchet, size 1	10001



Hand taps (set of 3 pcs.) left hand

DIN 352 HSS-G - M LH

(hand tap taper, hand tap second, hand tap finisher)

Type of thread: metric ISO-thread DIN 13

Tolerance: ISO 2 /6H

Application/ for general use:

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

Variants (22):



D	L1	L2	D2	Square	Art.-No. Set	Art.-No. Rougher	Art.-No. Intermediate	Art.-No. Finisher
M 3 x 0.5	40	11	3.5	2.7	27026	27026-1	27026-2	27026-3
M 4 x 0.7	45	13	4.5	3.4	27030	27030-1	27030-2	27030-3
M 5 x 0.8	50	16	6.0	4.9	27034	27034-1	27034-2	27034-3
M 6 x 1.0	50	19	6.0	4.9	27038	27038-1	27038-2	27038-3
M 8 x 1.25	56	22	6.0	4.9	27042	27042-1	27042-2	27042-3
M 10 x 1.5	70	24	7.0	5.5	27046	27046-1	27046-2	27046-3
M 12 x 1.75	75	29	9.0	7.0	27050	27050-1	27050-2	27050-3
M 14 x 2.0	80	30	11.0	9.0	27054	27054-1	27054-2	27054-3
M 16 x 2.0	80	32	12.0	9.0	27058	27058-1	27058-2	27058-3
M 18 x 2.5	95	40	14.0	11.0	27062	27062-1	27062-2	27062-3
M 20 x 2.5	95	40	16.0	12.0	27066	27066-1	27066-2	27066-3
M 22 x 2.5	100	40	18.0	14.5	27070	27070-1	27070-2	27070-3
M 24 x 3.0	110	50	18.0	14.5	27074	27074-1	27074-2	27074-3
M 27 x 3.0	110	50	20.0	16.0	27076	27076-1	27076-2	27076-3
M 30 x 3.5	125	56	22.0	18.0	27078	27078-1	27078-2	27078-3
M 33 x 3.5	125	56	25.0	20.0	27080	27080-1	27080-2	27080-3
M 36 x 4.0	150	63	28.0	22.0	27082	27082-1	27082-2	27082-3
M 39 x 4.0	150	63	32.0	24.0	27084	27084-1	27084-2	27084-3
M 42 x 4.5	150	63	32.0	24.0	27086	27086-1	27086-2	27086-3
M 45 x 4.5	160	70	36.0	29.0	27088	27088-1	27088-2	27088-3
M 48 x 5.0	180	75	36.0	29.0	27090	27090-1	27090-2	27090-3
M 52 x 5.0	180	75	40.0	32.0	27092	27092-1	27092-2	27092-3



Hand taps (set of 3 pcs.) left hand

ISO 529 HSS-G - M LH

(hand tap taper, hand tap second, hand tap finisher)

Type of thread: metric ISO-thread DIN 13

Tolerance: ISO 2 /6H

Variants (15):

Application/ for general use:

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

D	L1	L2	D2	Square	Art.-No. Set
M 3 x 0.5	48	11	3.15	2.5	80326
M 4 x 0.7	53	13	4.0	3.15	80330
M 5 x 0.8	58	16	5.0	4.0	80334
M 6 x 1.0	66	19	6.3	5.0	80338
M 8 x 1.25	72	22	8.0	6.3	80342
M 10 x 1.5	80	24	10.0	8.0	80346
M 12 x 1.75	89	29	9.0	7.1	80350
M 14 x 2.0	95	30	11.2	9.0	80354
M 16 x 2.0	102	32	12.5	10.0	80358
M 18 x 2.5	110	37	14.0	11.2	80362
M 20 x 2.5	112	37	14.0	11.2	80366
M 22 x 2.5	118	35	16.0	12.5	80370
M 24 x 3.0	130	45	18.0	14.0	80374
M 27 x 3.0	135	45	20.0	16.0	80376
M 30 x 3.5	138	48	20.0	18.0	80378



Mf (metric fine)



Hand taps, metric ISO-thread DIN 13

HSS-G Hand taps for non abrasive material up to 900 N/mm² tensile strength. The taps made of HSS-E are suitable for abrasive steels up to 1200 N/mm². All taps are also suitable for through and blind holes.

Hand taps for right hand threads, metric fine

- Hand taps acc. to DIN 2181 and ISO 529
- Variations from M 2x0.35 to M 110x4.0



Hand taps (set of 2 pcs.)

DIN 2181 HSS-G - Mf
(hand tap rougher, hand tap finisher)

Type of thread: metric ISO-thread DIN 13

Tolerance: ISO 2 /6H

Variants (268):

Application/ for general use:

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



D	L1	L2	D2	Square	Art.-No. Set	Art.-No. Rougher	Art.-No. Finisher
M 2.5 x 0.35	40	9	2.8	2.1	26304	26304-1	26304-2
M 2.6 x 0.35	40	9	2.8	2.1	26305	26305-1	26305-2
M 3 x 0.35	40	9	3.5	2.7	26308	26308-1	26308-2
M 3.5 x 0.35	45	10	4.0	3.0	26309	26309-1	26309-2
M 4 x 0.35	45	10	4.5	3.4	26310	26310-1	26310-2
M 4 x 0.5	45	10	4.5	3.4	26312	26312-1	26312-2
M 4.5 x 0.5	50	12	6.0	4.9	26313	26313-1	26313-2
M 5 x 0.5	50	12	6.0	4.9	26314	26314-1	26314-2
M 5.5 x 0.5	50	12	6.0	4.9	26315	26315-1	26315-2
M 5 x 0.75	50	12	6.0	4.9	26316	26316-1	26316-2
M 6 x 0.5	50	14	6.0	4.9	26317	26317-1	26317-2
M 6 x 0.75	50	14	6.0	4.9	26318	26318-1	26318-2
M 7 x 0.5	50	14	6.0	4.9	26319	26319-1	26319-2
M 7 x 0.75	50	14	6.0	4.9	26320	26320-1	26320-2
M 8 x 0.5	50	19	6.0	4.9	26322	26322-1	26322-2
M 8 x 0.75	50	19	6.0	4.9	26324	26324-1	26324-2
M 8 x 1.0	56	22	6.0	4.9	26326	26326-1	26326-2



D	L1	L2	D2	Square	Art.-No. Set	Art.-No. Rougher	Art.-No. Finisher
M 9 x 0.5	56	19	7.0	5.5	26327	26327-1	26327-2
M 9 x 0.75	56	19	7.0	5.5	26328	26328-1	26328-2
M 9 x 1.0	63	20	7.0	5.5	26330	26330-1	26330-2
M 10 x 0.5	63	20	7.0	5.5	26331	26331-1	26331-2
M 10 x 0.75	63	20	7.0	5.5	26332	26332-1	26332-2
M 10 x 1.0	63	20	7.0	5.5	26336	26336-1	26336-2
M 10 x 1.25	70	24	7.0	5.5	26338	26338-1	26338-2
M 11 x 0.75	63	20	8.0	6.2	26339	26339-1	26339-2
M 11 x 1.0	63	20	8.0	6.2	26340	26340-1	26340-2
M 11 x 1.25	63	22	8.0	6.2	26342	26342-1	26342-2
M 12 x 0.5	70	22	9.0	7.0	26345	26345-1	26345-2
M 12 x 0.75	70	22	9.0	7.0	26343	26343-1	26343-2
M 12 x 1.0	70	22	9.0	7.0	26344	26344-1	26344-2
M 12 x 1.25	70	22	9.0	7.0	26346	26346-1	26346-2
M 12 x 1.5	70	22	9.0	7.0	26348	26348-1	26348-2
M 13 x 0.5	70	22	11.0	9.0	26347	26347-1	26347-2
M 13 x 0.75	70	22	11.0	9.0	26349	26349-1	26349-2
M 13 x 1.0	70	22	11.0	9.0	26350	26350-1	26350-2
M 13 x 1.5	70	22	11.0	9.0	26351	26351-1	26351-2
M 14 x 0.5	70	22	11.0	9.0	26355	26355-1	26355-2
M 14 x 0.75	70	22	11.0	9.0	26352	26352-1	26352-2
M 14 x 1.0	70	22	11.0	9.0	26353	26353-1	26353-2
M 14 x 1.25	70	22	11.0	9.0	26354	26354-1	26354-2
M 14 x 1.5	70	22	11.0	9.0	26356	26356-1	26356-2
M 15 x 0.75	70	22	12.0	9.0	26357	26357-1	26357-2
M 15 x 1.0	70	22	12.0	9.0	26358	26358-1	26358-2
M 15 x 1.5	70	22	12.0	9.0	26360	26360-1	26360-2
M 16 x 0.5	70	22	12.0	9.0	26361	26361-1	26361-2
M 16 x 0.75	70	22	12.0	9.0	26363	26363-1	26363-2
M 16 x 1.0	70	22	12.0	9.0	26362	26362-1	26362-2
M 16 x 1.25	70	22	12.0	9.0	26364	26364-1	26364-2
M 16 x 1.5	70	22	12.0	9.0	26366	26366-1	26366-2
M 17 x 1.0	70	22	12.0	9.0	26368	26368-1	26368-2
M 17 x 1.5	70	22	12.0	9.0	26369	26369-1	26369-2
M 18 x 0.5	80	22	14.0	11.0	26367	26367-1	26367-2
M 18 x 0.75	80	22	14.0	11.0	26373	26373-1	26373-2
M 18 x 1.0	80	22	14.0	11.0	26370	26370-1	26370-2
M 18 x 1.25	80	22	14.0	11.0	26371	26371-1	26371-2
M 18 x 1.5	80	22	14.0	11.0	26372	26372-1	26372-2
M 18 x 2.0	80	22	14.0	11.0	26374	26374-1	26374-2
M 19 x 1.0	80	22	14.0	11.0	26375	26375-1	26375-2
M 19 x 1.5	80	22	14.0	11.0	26376	26376-1	26376-2



D	L1	L2	D2	Square	Art.-No. Set	Art.-No. Rougher	Art.-No. Finisher
M 20 x 0.5	80	22	16.0	12.0	26377	26377-1	26377-2
M 20 x 0.75	80	22	16.0	12.0	26379	26379-1	26379-2
M 20 x 1.0	80	22	16.0	12.0	26378	26378-1	26378-2
M 20 x 1.25	80	22	16.0	12.0	26380	26380-1	26380-2
M 20 x 1.5	80	22	16.0	12.0	26384	26384-1	26384-2
M 20 x 2.0	80	22	16.0	12.0	26386	26386-1	26386-2
M 21 x 1.0	80	22	16.0	12.0	26387	26387-1	26387-2
M 21 x 1.5	80	22	16.0	12.0	26388	26388-1	26388-2
M 22 x 0.5	80	22	18.0	14.5	26389	26389-1	26389-2
M 22 x 0.75	80	22	18.0	14.5	26391	26391-1	26391-2
M 22 x 1.0	80	22	18.0	14.5	26390	26390-1	26390-2
M 22 x 1.25	80	22	18.0	14.5	26392	26392-1	26392-2
M 22 x 1.5	80	22	18.0	14.5	26394	26394-1	26394-2
M 22 x 2.0	80	22	18.0	14.5	26396	26396-1	26396-2
M 23 x 1.0	80	22	18.0	14.5	26397	26397-1	26397-2
M 23 x 1.5	80	22	18.0	14.5	26398	26398-1	26398-2
M 24 x 0.5	90	22	18.0	14.5	26501	26501-1	26501-2
M 24 x 0.75	90	22	18.0	14.5	26503	26503-1	26503-2
M 24 x 1.0	90	22	18.0	14.5	26500	26500-1	26500-2
M 24 x 1.25	90	22	18.0	14.5	26502	26502-1	26502-2
M 24 x 1.5	90	22	18.0	14.5	26504	26504-1	26504-2
M 24 x 2.0	90	22	18.0	14.5	26506	26506-1	26506-2
M 25 x 1.0	90	22	18.0	14.5	26507	26507-1	26507-2
M 25 x 1.5	90	22	18.0	14.5	26508	26508-1	26508-2
M 26 x 1.0	90	22	18.0	14.5	26510	26510-1	26510-2
M 26 x 1.5	90	22	18.0	14.5	26512	26512-1	26512-2
M 26 x 2.0	90	22	18.0	14.5	26514	26514-1	26514-2
M 27 x 1.0	90	22	18.0	16.0	26516	26516-1	26516-2
M 27 x 1.5	90	22	20.0	16.0	26517	26517-1	26517-2
M 27 x 2.0	90	22	20.0	16.0	26518	26518-1	26518-2
M 28 x 1.0	90	22	20.0	16.0	26520	26520-1	26520-2
M 28 x 1.5	90	22	20.0	16.0	26522	26522-1	26522-2
M 28 x 2.0	90	22	20.0	16.0	26524	26524-1	26524-2
M 29 x 1.5	90	22	22.0	18.0	26526	26526-1	26526-2
M 30 x 1.0	90	22	22.0	18.0	26528	26528-1	26528-2
M 30 x 1.5	90	22	22.0	18.0	26530	26530-1	26530-2
M 30 x 2.0	90	22	22.0	18.0	26532	26532-1	26532-2
M 30 x 2.5	125	56	22.0	18.0	26533	26533-1	26533-2
M 30 x 3.0	125	56	22.0	18.0	26534	26534-1	26534-2
M 32 x 1.0	90	22	22.0	18.0	26539	26539-1	26539-2
M 32 x 1.5	90	22	22.0	18.0	26536	26536-1	26536-2
M 32 x 2.0	90	22	22.0	18.0	26535	26535-1	26535-2



D	L1	L2	D2	Square	Art.-No. Set	Art.-No. Rougher	Art.-No. Finisher
M 32 x 3.0	125	56	22.0	18.0	26537	26537-1	26537-2
M 33 x 1.5	100	25	25.0	20.0	26538	26538-1	26538-2
M 33 x 2.0	100	25	25.0	20.0	26540	26540-1	26540-2
M 33 x 3.0	125	56	25.0	20.0	26542	26542-1	26542-2
M 34 x 1.0	100	25	28.0	22.0	26543	26543-1	26543-2
M 34 x 1.5	100	25	28.0	22.0	26544	26544-1	26544-2
M 34 x 2.0	125	40	28.0	22.0	26546	26546-1	26546-2
M 35 x 1.0	100	25	28.0	22.0	26547	26547-1	26547-2
M 35 x 1.5	100	25	28.0	22.0	26548	26548-1	26548-2
M 35 x 2.0	125	40	28.0	22.0	26549	26549-1	26549-2
M 36 x 1.0	100	25	28.0	22.0	26551	26551-1	26551-2
M 36 x 1.5	100	25	28.0	22.0	26550	26550-1	26550-2
M 36 x 2.0	125	40	28.0	22.0	26552	26552-1	26552-2
M 36 x 3.0	125	40	28.0	22.0	26554	26554-1	26554-2
M 37 x 1.5	100	25	28.0	22.0	26553	26553-1	26553-2
M 38 x 1.0	100	25	28.0	22.0	26555	26555-1	26555-2
M 38 x 1.5	100	25	28.0	22.0	26556	26556-1	26556-2
M 38 x 2.0	125	40	28.0	22.0	26557	26557-1	26557-2
M 38 x 3.0	125	40	28.0	22.0	26559	26559-1	26559-2
M 39 x 1.5	110	25	32.0	24.0	26558	26558-1	26558-2
M 39 x 2.0	125	40	32.0	24.0	26560	26560-1	26560-2
M 39 x 3.0	125	40	32.0	24.0	26562	26562-1	26562-2
M 40 x 1.0	110	25	32.0	24.0	26563	26563-1	26563-2
M 40 x 1.5	110	25	32.0	24.0	26564	26564-1	26564-2
M 40 x 2.0	125	40	32.0	24.0	26566	26566-1	26566-2
M 40 x 3.0	125	40	32.0	24.0	26568	26568-1	26568-2
M 42 x 1.0	110	25	32.0	24.0	26569	26569-1	26569-2
M 42 x 1.5	110	25	32.0	24.0	26570	26570-1	26570-2
M 42 x 2.0	125	40	32.0	24.0	26572	26572-1	26572-2
M 42 x 3.0	125	40	32.0	24.0	26574	26574-1	26574-2
M 44 x 1.5	110	25	36.0	29.0	26571	26571-1	26571-2
M 44 x 2.0	125	40	36.0	29.0	26573	26573-1	26573-2
M 45 x 1.0	110	25	36.0	29.0	26575	26575-1	26575-2
M 45 x 1.5	110	25	36.0	29.0	26576	26576-1	26576-2
M 45 x 2.0	125	40	36.0	29.0	26578	26578-1	26578-2
M 45 x 3.0	125	40	36.0	29.0	26580	26580-1	26580-2
M 46 x 1.5	140	40	36.0	29.0	26581	26581-1	26581-2
M 48 x 1.0	140	40	36.0	29.0	26583	26583-1	26583-2
M 48 x 1.5	140	40	36.0	29.0	26582	26582-1	26582-2
M 48 x 2.0	140	40	36.0	29.0	26584	26584-1	26584-2
M 48 x 3.0	140	40	36.0	29.0	26586	26586-1	26586-2
M 50 x 1.5	140	40	36.0	29.0	26588	26588-1	26588-2



D	L1	L2	D2	Square	Art.-No. Set	Art.-No. Rougher	Art.-No. Finisher
M 50 x 2.0	140	40	36.0	29.0	26590	26590-1	26590-2
M 50 x 3.0	140	40	36.0	29.0	26592	26592-1	26592-2
M 52 x 1.5	140	40	40.0	32.0	26594	26594-1	26594-2
M 52 x 2.0	140	40	40.0	32.0	26596	26596-1	26596-2
M 52 x 3.0	140	40	40.0	32.0	26598	26598-1	26598-2
M 54 x 1.0	140	32	40.0	32.0	28118	28118-1	28118-2
M 54 x 1.5	140	32	40.0	32.0	28001	28001-1	28001-2
M 54 x 2.0	140	36	40.0	32.0	28002	28002-1	28002-2
M 54 x 3.0	140	40	40.0	32.0	28003	28003-1	28003-2
M 54 x 4.0	180	50	40.0	32.0	28004	28004-1	28004-2
M 55 x 1.5	140	32	40.0	32.0	28005	28005-1	28005-2
M 55 x 2.0	140	36	40.0	32.0	28006	28006-1	28006-2
M 55 x 3.0	140	40	40.0	32.0	28007	28007-1	28007-2
M 55 x 4.0	180	50	40.0	32.0	28008	28008-1	28008-2
M 56 x 1.0	140	32	40.0	32.0	28119	28119-1	28119-2
M 56 x 1.5	140	32	40.0	32.0	28009	28009-1	28009-2
M 56 x 2.0	140	36	40.0	32.0	28010	28010-1	28010-2
M 56 x 3.0	140	40	40.0	32.0	28011	28011-1	28011-2
M 56 x 4.0	180	50	40.0	32.0	28012	28012-1	28012-2
M 58 x 1.0	160	32	45.0	35.0	28120	28120-1	28120-2
M 58 x 1.5	160	32	45.0	35.0	28013	28013-1	28013-2
M 58 x 2.0	160	36	45.0	35.0	28014	28014-1	28014-2
M 58 x 3.0	160	40	45.0	35.0	28015	28015-1	28015-2
M 58 x 4.0	200	55	45.0	35.0	28016	28016-1	28016-2
M 60 x 1.5	160	34	45.0	35.0	28017	28017-1	28017-2
M 60 x 2.0	160	36	45.0	35.0	28018	28018-1	28018-2
M 60 x 3.0	160	40	45.0	35.0	28019	28019-1	28019-2
M 60 x 4.0	200	55	45.0	35.0	28020	28020-1	28020-2
M 62 x 1.5	160	34	50.0	39.0	28021	28021-1	28021-2
M 62 x 2.0	160	36	50.0	39.0	28022	28022-1	28022-2
M 62 x 3.0	180	45	50.0	39.0	28023	28023-1	28023-2
M 62 x 4.0	220	55	50.0	39.0	28024	28024-1	28024-2
M 63 x 1.5	160	32	50.0	39.0	28025	28025-1	28025-2
M 64 x 1.5	160	34	50.0	39.0	28026	28026-1	28026-2
M 64 x 2.0	160	36	50.0	39.0	28027	28027-1	28027-2
M 64 x 3.0	180	45	50.0	39.0	28028	28028-1	28028-2
M 64 x 4.0	220	60	50.0	39.0	28029	28029-1	28029-2
M 65 x 1.5	160	34	50.0	39.0	28030	28030-1	28030-2
M 65 x 2.0	160	36	50.0	39.0	28031	28031-1	28031-2
M 65 x 3.0	180	45	50.0	39.0	28032	28032-1	28032-2
M 65 x 4.0	220	60	50.0	39.0	28033	28033-1	28033-2
M 68 x 1.5	160	36	50.0	39.0	28034	28034-1	28034-2



D	L1	L2	D2	Square	Art.-No. Set	Art.-No. Rougher	Art.-No. Finisher
M 68 x 2.0	160	40	50.0	39.0	28035	28035-1	28035-2
M 68 x 3.0	180	50	50.0	39.0	28036	28036-1	28036-2
M 68 x 4.0	220	60	50.0	39.0	28037	28037-1	28037-2
M 70 x 1.5	160	36	50.0	39.0	28038	28038-1	28038-2
M 70 x 2.0	160	40	50.0	39.0	28039	28039-1	28039-2
M 70 x 3.0	200	50	50.0	39.0	28040	28040-1	28040-2
M 70 x 4.0	240	60	50.0	39.0	28041	28041-1	28041-2
M 72 x 1.5	160	36	50.0	39.0	28042	28042-1	28042-2
M 72 x 2.0	160	40	50.0	39.0	28043	28043-1	28043-2
M 72 x 3.0	200	50	50.0	39.0	28044	28044-1	28044-2
M 72 x 4.0	240	60	50.0	39.0	28045	28045-1	28045-2
M 74 x 1.5	160	36	50.0	39.0	28046	28046-1	28046-2
M 74 x 2.0	160	40	50.0	39.0	28047	28047-1	28047-2
M 74 x 3.0	200	50	50.0	39.0	28048	28048-1	28048-2
M 74 x 4.0	240	60	50.0	39.0	28049	28049-1	28049-2
M 75 x 1.5	160	36	50.0	39.0	28050	28050-1	28050-2
M 75 x 2.0	160	40	50.0	39.0	28051	28051-1	28051-2
M 75 x 3.0	200	50	50.0	39.0	28052	28052-1	28052-2
M 75 x 4.0	240	60	50.0	39.0	28053	28053-1	28053-2
M 76 x 1.5	160	36	50.0	39.0	28054	28054-1	28054-2
M 76 x 2.0	160	40	50.0	39.0	28055	28055-1	28055-2
M 76 x 3.0	220	50	50.0	39.0	28056	28056-1	28056-2
M 76 x 4.0	260	60	50.0	39.0	28057	28057-1	28057-2
M 78 x 1.5	160	36	50.0	39.0	28058	28058-1	28058-2
M 78 x 2.0	160	40	50.0	39.0	28059	28059-1	28059-2
M 78 x 3.0	220	55	50.0	39.0	28060	28060-1	28060-2
M 78 x 4.0	260	65	50.0	39.0	28061	28061-1	28061-2
M 80 x 1.5	160	36	50.0	39.0	28062	28062-1	28062-2
M 80 x 2.0	160	40	50.0	39.0	28063	28063-1	28063-2
M 80 x 3.0	220	55	50.0	39.0	28064	28064-1	28064-2
M 80 x 4.0	260	65	50.0	39.0	28065	28065-1	28065-2
M 82 x 1.5	160	36	50.0	39.0	28066	28066-1	28066-2
M 82 x 2.0	160	40	50.0	39.0	28067	28067-1	28067-2
M 82 x 3.0	220	55	50.0	39.0	28068	28068-1	28068-2
M 82 x 4.0	260	65	50.0	39.0	28069	28069-1	28069-2
M 84 x 1.5	160	36	50.0	39.0	28070	28070-1	28070-2
M 84 x 2.0	160	40	50.0	39.0	28071	28071-1	28071-2
M 84 x 3.0	220	55	50.0	39.0	28072	28072-1	28072-2
M 84 x 4.0	260	65	50.0	39.0	28073	28073-1	28073-2
M 85 x 1.5	160	36	50.0	39.0	28074	28074-1	28074-2
M 85 x 2.0	160	40	50.0	39.0	28075	28075-1	28075-2
M 85 x 3.0	220	55	50.0	39.0	28076	28076-1	28076-2



D		L1	L2	D2	Square	Art.-No. Set	Art.-No. Rougher	Art.-No. Finisher
M	85 x 4.0	260	65	50.0	39.0	28077	28077-1	28077-2
M	86 x 1.5	160	36	50.0	39.0	28078	28078-1	28078-2
M	86 x 2.0	160	40	50.0	39.0	28079	28079-1	28079-2
M	86 x 3.0	220	55	50.0	39.0	28080	28080-1	28080-2
M	86 x 4.0	260	65	50.0	39.0	28081	28081-1	28081-2
M	88 x 1.5	160	38	50.0	39.0	28082	28082-1	28082-2
M	88 x 2.0	160	40	50.0	39.0	28083	28083-1	28083-2
M	88 x 3.0	220	55	50.0	39.0	28084	28084-1	28084-2
M	88 x 4.0	260	65	50.0	39.0	28085	28085-1	28085-2
M	90 x 1.5	160	38	50.0	39.0	28086	28086-1	28086-2
M	90 x 2.0	160	40	50.0	39.0	28087	28087-1	28087-2
M	90 x 3.0	220	55	50.0	39.0	28088	28088-1	28088-2
M	90 x 4.0	260	65	50.0	39.0	28089	28089-1	28089-2
M	92 x 1.5	180	40	56.0	44.0	28090	28090-1	28090-2
M	92 x 2.0	180	45	56.0	44.0	28091	28091-1	28091-2
M	92 x 3.0	240	60	56.0	44.0	28092	28092-1	28092-2
M	92 x 4.0	280	70	56.0	44.0	28093	28093-1	28093-2
M	95 x 1.5	180	40	56.0	44.0	28094	28094-1	28094-2
M	95 x 2.0	180	45	56.0	44.0	28095	28095-1	28095-2
M	95 x 3.0	240	60	56.0	44.0	28096	28096-1	28096-2
M	95 x 4.0	280	70	56.0	44.0	28097	28097-1	28097-2
M	96 x 1.5	180	40	56.0	44.0	28098	28098-1	28098-2
M	96 x 2.0	180	45	56.0	44.0	28099	28099-1	28099-2
M	96 x 3.0	240	60	56.0	44.0	28100	28100-1	28100-2
M	96 x 4.0	280	70	56.0	44.0	28101	28101-1	28101-2
M	98 x 1.5	180	40	56.0	44.0	28102	28102-1	28102-2
M	98 x 2.0	180	45	56.0	44.0	28103	28103-1	28103-2
M	98 x 3.0	240	60	56.0	44.0	28104	28104-1	28104-2
M	98 x 4.0	280	70	56.0	44.0	28105	28105-1	28105-2
M	100 x 1.5	180	45	56.0	44.0	28106	28106-1	28106-2
M	100 x 2.0	180	50	56.0	44.0	28107	28107-1	28107-2
M	100 x 3.0	240	65	56.0	44.0	28108	28108-1	28108-2
M	100 x 4.0	280	75	56.0	44.0	28109	28109-1	28109-2
M	105 x 1.5	180	45	56.0	44.0	28110	28110-1	28110-2
M	105 x 2.0	180	50	56.0	44.0	28111	28111-1	28111-2
M	105 x 3.0	240	65	56.0	44.0	28112	28112-1	28112-2
M	105 x 4.0	280	75	56.0	44.0	28113	28113-1	28113-2
M	110 x 1.5	180	45	56.0	44.0	28114	28114-1	28114-2
M	110 x 2.0	180	50	56.0	44.0	28115	28115-1	28115-2
M	110 x 3.0	240	65	56.0	44.0	28116	28116-1	28116-2
M	110 x 4.0	280	75	56.0	44.0	28117	28117-1	28117-2



Hand taps (set of 2 pcs.)

DIN 2181 HSS-E - Mf

(hand tap rougher, hand tap finisher)

Type of thread: metric ISO-thread DIN 13

Tolerance: ISO 2 /6H

Variants (18):

Advantages:

- > high cutting ability

Application:

- > abrasive material
- > Steel up to 1200 N/mm²
- > fard for general use



D	L1	L2	D2	Square	Art.-No. Set	Art.-No. Rougher	Art.-No. Finisher
M 6 x 0.75	50	14	6.0	4.9	56318	56318-1	56318-2
M 8 x 0.75	50	19	6.0	4.9	56324	56324-1	56324-2
M 8 x 1.0	56	22	6.0	4.9	56326	56326-1	56326-2
M 10 x 1.0	63	20	7.0	5.5	56336	56336-1	56336-2
M 10 x 1.25	70	24	7.0	5.5	56338	56338-1	56338-2
M 12 x 1.0	70	22	9.0	7.0	56344	56344-1	56344-2
M 12 x 1.25	70	22	9.0	7.0	56346	56346-1	56346-2
M 12 x 1.5	70	22	9.0	7.0	56348	56348-1	56348-2
M 14 x 1.25	70	22	11.0	9.0	56354	56354-1	56354-2
M 14 x 1.5	70	22	11.0	9.0	56356	56356-1	56356-2
M 16 x 1.5	70	22	12.0	9.0	56366	56366-1	56366-2
M 18 x 1.5	80	22	14.0	11.0	56372	56372-1	56372-2
M 18 x 2.0	80	22	14.0	11.0	56374	56374-1	56374-2
M 20 x 1.5	80	22	16.0	12.0	56384	56384-1	56384-2
M 20 x 2.0	80	22	16.0	12.0	56386	56386-1	56386-2
M 22 x 1.5	80	22	18.0	14.5	56394	56394-1	56394-2
M 22 x 2.0	80	22	18.0	14.5	56396	56396-1	56396-2
M 24 x 1.5	90	22	18.0	14.5	56504	56504-1	56504-2



Mf (metric fine) left hand



Hand taps, metric ISO-thread DIN 13

HSS-G Hand taps for non abrasive materials up to 900 N/mm² and for thread cutting in through or blind holes.

Hand taps for left hand threads, metric fine

- Hand taps acc. to DIN 2181 standard
- Variations from M 6x0.75 LH to M 30x2.0 LH



Hand taps (set of 2 pcs.)

DIN 2181 HSS-G - Mf LH
(hand tap rougher, hand tap finisher)

Type of thread: metric ISO-thread DIN 13

Tolerance: ISO 2 /6H

Variants (19):

Application/

for general use:

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



D	L1	L2	D2	Square	Art.-No. Set	Art.-No. Rougher	Art.-No. Finisher
M 6 x 0.75	50	14	6.0	4.9	26007	26007-1	26007-2
M 8 x 0.75	50	19	6.0	4.9	26010	26010-1	26010-2
M 8 x 1.0	56	22	6.0	4.9	26011	26011-1	26011-2
M 10 x 1.0	63	20	7.0	5.5	26015	26015-1	26015-2
M 10 x 1.25	70	24	7.0	5.5	26016	26016-1	26016-2
M 12 x 1.0	70	22	9.0	7.0	26020	26020-1	26020-2
M 12 x 1.25	70	22	9.0	7.0	26021	26021-1	26021-2
M 12 x 1.5	70	22	9.0	7.0	26022	26022-1	26022-2
M 14 x 1.25	70	22	11.0	9.0	26027	26027-1	26027-2
M 14 x 1.5	70	22	11.0	9.0	26028	26028-1	26028-2
M 16 x 1.0	70	22	12.0	9.0	26031	26031-1	26031-2
M 16 x 1.5	70	22	12.0	9.0	26033	26033-1	26033-2
M 18 x 1.5	80	22	14.0	11.0	26036	26036-1	26036-2
M 20 x 1.5	80	22	16.0	12.0	26040	26040-1	26040-2
M 22 x 1.5	80	22	18.0	14.5	26045	26045-1	26045-2
M 24 x 1.5	90	22	18.0	14.5	26050	26050-1	26050-2
M 24 x 2.0	90	22	18.0	14.5	26051	26051-1	26051-2
M 30 x 1.5	90	22	22.0	18.0	26063	26063-1	26063-2
M 30 x 2.0	90	22	22.0	18.0	26064	26064-1	26064-2



BSW (Whitworth)



Hand taps, Whitworth-thread BS 84

Hand taps for BSW Whitworth threads made of HSS-G are suitable for machinable non abrasive materials up to 900 N/mm², for through and blind holes. Available in cylindrical and conical (non-serial) form.

Hand taps for BSW (Whitworth) right hand threads

- Hand taps (BSW) acc. to ≈ DIN 352 und ISO 529
- Variations from BSW 1/16 to BSW 3"



Hand taps (set of 3 pcs.)

≈ DIN DIN 352 HSS-G - BSW
(hand tap rougher, hand tap intermediate, hand tap finisher)

Type of thread: Whitworth-thread BS 84

Variants (28):

Application/ for general use:

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



D	L1	L2	D2	Square	Art.-No. Set	Art.-No. Rougher	Art.-No. Intermediate	Art.-No. Finisher
BSW 1/16 x 60	36	10	2.5	2.1	22302	22302-1	22302-2	22302-3
BSW 3/32 x 48	36	10	2.8	2.1	22304	22304-1	22304-2	22304-3
BSW 1/8 x 40	40	12	3.5	2.7	22306	22306-1	22306-2	22306-3
BSW 5/32 x 32	45	14	5.6	3.4	22308	22308-1	22308-2	22308-3
BSW 3/16 x 24	50	18	6.0	4.9	22310	22310-1	22310-2	22310-3
BSW 7/32 x 24	50	18	6.0	4.9	22312	22312-1	22312-2	22312-3
BSW 1/4 x 20	50	19	6.0	4.9	22314	22314-1	22314-2	22314-3
BSW 5/16 x 18	56	22	6.0	4.9	22316	22316-1	22316-2	22316-3
BSW 3/8 x 16	70	24	7.0	5.5	22318	22318-1	22318-2	22318-3
BSW 7/16 x 14	70	24	8.0	6.2	22320	22320-1	22320-2	22320-3
BSW 1/2 x 12	75	29	9.0	7.0	22322	22322-1	22322-2	22322-3
BSW 9/16 x 12	80	30	11.0	9.0	22324	22324-1	22324-2	22324-3
BSW 5/8 x 11	80	32	12.0	9.0	22326	22326-1	22326-2	22326-3
BSW 3/4 x 10	95	40	14.0	11.0	22330	22330-1	22330-2	22330-3
BSW 7/8 x 9	100	40	18.0	14.5	22334	22334-1	22334-2	22334-3
BSW 1" x 8	110	50	18.0	14.5	22338	22338-1	22338-2	22338-3



D		L1	L2	D2	Square	Art.-No. Set	Art.-No. Rougher	Art.-No. Intermediate	Art.-No. Finisher
BSW	1.1/8 x 7	132	56	22.0	18.0	22342	22342-1	22342-2	22342-3
BSW	1.1/4 x 7	132	56	22.0	18.0	22346	22346-1	22346-2	22346-3
BSW	1.3/8 x 6	150	63	28.0	22.0	22350	22350-1	22350-2	22350-3
BSW	1.1/2 x 6	150	63	32.0	24.0	22354	22354-1	22354-2	22354-3
BSW	1.5/8 x 5	160	70	32.0	24.0	22358	22358-1	22358-2	22358-3
BSW	1.3/4 x 5	160	70	36.0	29.0	22362	22362-1	22362-2	22362-3
BSW	1.7/8 x 4.1/2	190	80	36.0	29.0	22366	22366-1	22366-2	22366-3
BSW	2" x 4.1/2	190	80	40.0	32.0	22370	22370-1	22370-2	22370-3
BSW	2.1/4 x 4	220	80	45.0	35.0	22372	22372-1	22372-2	22372-3
BSW	2.1/2 x 4	220	80	50.0	39.0	22374	22374-1	22374-2	22374-3
BSW	2.3/4 x 3.1/2	240	80	50.0	39.0	22376	22376-1	22376-2	22376-3
BSW	3" x 3.1/2	260	80	50.0	39.0	22378	22378-1	22378-2	22378-3



Hand taps (set of 3 pcs.)

ISO 529 HSS-G - BSW

(hand tap rougher, hand tap intermediate, hand tap finisher)

Type of thread: Whitworth-thread BS 84

Variants (27):

Application/

for general use:

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

D		L1	L2	D2	Square	Art.-No. Set
BSW	1/16 x 60	41	8	2.5	2.0	84402
BSW	3/32 x 48	44.5	9.5	2.8	2.24	84404
BSW	1/8 x 40	48	11	3.15	2.5	84406
BSW	5/32 x 32	53	13	4.0	3.15	84408
BSW	3/16 x 24	58	16	5.0	4.0	84410
BSW	7/32 x 24	62	17	5.6	4.5	84412
BSW	1/4 x 20	66	19	6.3	5.0	84414
BSW	9/32 x 20	72	22	8.0	6.3	84415
BSW	5/16 x 18	72	22	8.0	6.3	84416
BSW	3/8 x 16	82	24	10.0	8.0	84418
BSW	7/16 x 14	85	25	8.0	6.3	84420
BSW	1/2 x 12	89	29	9.0	7.1	84422
BSW	9/16 x 12	95	30	11.2	9.0	84424
BSW	5/8 x 11	102	32	12.5	10.0	84426



D		L1	L2	D2	Square	Art.-No. Set
BSW	3/4 x 10	112	37	14.0	11.2	84430
BSW	7/8 x 9	118	38	16.0	12.5	84434
BSW	1" x 8	130	45	18.0	14.0	84438
BSW	1.1/8 x 7	138	48	20.0	16.0	84440
BSW	1.1/4 x 7	151	51	22.4	18.0	84442
BSW	1.3/8 x 6	162	57	25.0	20.0	84444
BSW	1.1/2 x 6	170	60	28.0	22.4	84446
BSW	1.5/8 x 5	170	60	28.0	22.4	84448
BSW	1.3/4 x 5	187	67	31.5	25.0	84450
BSW	1.7/8 x 4.1/2	187	67	31.5	25.0	84452
BSW	2" x 4.1/2	200	70	35.5	28.0	84454
BSW	2.1/4 x 4	221	76	40.0	31.5	84456
BSW	2.1/2 x 4	224	79	40.0	31.5	84458



BSW (Whitworth) left hand



Hand taps, Whitworth-thread BS 84

Hand taps for BSW Whitworth left hand threads made of HSS-G are suitable for machinable non abrasive materials up to 900 N/mm² and for through and blind holes. Available in cylindrical and conical (non-serial) form.

Hand taps for BSW (Whitworth) left hand threads

- Hand taps (BSW) acc. to ≈ DIN 352 und ISO 529
- Variations from BSW 1/8 LH to BSW 1" LH



Hand taps (set of 3 pcs.) left hand

≈ DIN 352 HSS-G - BSW LH

(hand tap rougher, hand tap intermediate, hand tap finisher)

Type of thread: Whitworth-thread BS 84

Variants (13):

Application/ for general use:

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



D	L1	L2	D2	Square	Art.-No. Set	Art.-No. Rougher	Art.-No. Intermediate	Art.-No. Finisher
BSW 1/8 x 40	40	12	3.5	2.7	22006	22006-1	22006-2	22006-3
BSW 5/32 x 32	45	14	4.5	3.4	22008	22008-1	22008-2	22008-3
BSW 3/16 x 24	50	18	6.0	4.9	22010	22010-1	22010-2	22010-3
BSW 1/4 x 20	50	19	6.0	4.9	22014	22014-1	22014-2	22014-3
BSW 5/16 x 18	56	22	6.0	4.9	22016	22016-1	22016-2	22016-3
BSW 3/8 x 16	70	24	7.0	5.5	22018	22018-1	22018-2	22018-3
BSW 7/16 x 14	70	24	8.0	6.2	22020	22020-1	22020-2	22020-3
BSW 1/2 x 12	75	29	9.0	7.0	22022	22022-1	22022-2	22022-3
BSW 9/16 x 12	80	30	11.0	9.0	22024	22024-1	22024-2	22024-3
BSW 5/8 x 11	80	32	12.0	9.0	22026	22026-1	22026-2	22026-3
BSW 3/4 x 10	95	40	14.0	11.0	22030	22030-1	22030-2	22030-3
BSW 7/8 x 9	100	40	18.0	14.5	22034	22034-1	22034-2	22034-3
BSW 1" x 8	110	50	18.0	14.5	22038	22038-1	22038-2	22038-3



Hand taps (set of 3 pcs.) left hand

ISO 529 HSS-G - BSW LH

(hand tap rougher, hand tap intermediate, hand tap finisher)

Type of thread: Whitworth-thread BS 84

Variants (13):

Application/ for general use:

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



D	L1	L2	D2	Square	Art.-No. Set
BSW 1/8 x 40	48	11	3.15	2.5	84307
BSW 5/32 x 32	53	13	4.0	3.15	84308
BSW 3/16 x 24	58	16	5.0	4.0	84309
BSW 1/4 x 20	66	19	6.3	5.0	84310
BSW 5/16 x 18	72	22	8.0	6.3	84311
BSW 3/8 x 16	80	24	10.0	8.0	84312
BSW 7/16 x 14	85	25	8.0	6.3	84313
BSW 1/2 x 12	89	29	9.0	7.1	84314
BSW 9/16 x 12	95	30	11.2	9.0	84315
BSW 5/8 x 11	102	32	12.5	10.0	84316
BSW 3/4 x 10	112	37	14.0	11.2	84317
BSW 7/8 x 9	118	38	16.0	12.5	84318
BSW 1" x 8	130	45	18.0	14.0	84319



BSF (brit. standard fine)



Hand taps, British-Standard-Fine-thread BS 84

Hand taps for BSF threads made of HSS-G are suitable for machinable non abrasive materials up to 900 N/mm² and for through and blind holes. Available in cylindrical and conical (non-serial) form.

Hand taps for BSF right hand threads

- Hand taps (BSF) acc. to ≈ DIN 2181 und ISO 529
- Variations from BSF 3/16 to BSF 2.1/2"



Hand taps (set of 2 pcs.)

≈ DIN 2181 HSS-G - BSF (hand tap rougher, hand tap finisher)

Type of thread: British-Standard-Fine-thread BS 84

Variants (11):

Application/ for general use:

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



D	L1	L2	D2	Square	Art.-No. Set	Art.-No. Rougher	Art.-No. Finisher
BSF 3/16 x 32	50	14	6.0	4.9	22710	22710-1	22710-3
BSF 1/4 x 26	50	18	6.0	4.9	22714	22714-1	22714-3
BSF 5/16 x 22	56	22	6.0	4.9	22716	22716-1	22716-3
BSF 3/8 x 20	63	22	7.0	5.5	22718	22718-1	22718-3
BSF 7/16 x 18	63	22	8.0	6.2	22720	22720-1	22720-3
BSF 1/2 x 16	75	24	9.0	7.0	22722	22722-1	22722-3
BSF 9/16 x 16	80	28	11.0	9.0	22724	22724-1	22724-3
BSF 5/8 x 14	80	28	12.0	9.0	22726	22726-1	22726-3
BSF 3/4 x 12	95	32	14.0	11.0	22730	22730-1	22730-3
BSF 7/8 x 11	100	36	18.0	14.5	22734	22734-1	22734-3
BSF 1" x 10	110	40	18.0	14.5	22738	22738-1	22738-3



Hand taps (set of 3 pcs.)

ISO 529 HSS-G - BSF

Type of thread: British-Standard-Fine-thread BS 84

Variants (21):

Application/ for general use:

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

D		L1	L2	D2	Square	Art.-No. Set
BSF	3/16 x 32	58	16	5.0	4.0	85410
BSF	1/4 x 26	66	19	6.3	5.0	85414
BSF	5/16 x 22	69	19	8.0	6.3	85416
BSF	3/8 x 20	76	20	10.0	8.0	85418
BSF	7/16 x 18	82	22	8.0	6.3	85420
BSF	1/2 x 16	84	24	9.0	7.1	85422
BSF	9/16 x 16	90	25	11.2	9.0	85424
BSF	5/8 x 14	95	25	12.5	10.0	85426
BSF	3/4 x 12	104	29	14.0	11.2	85430
BSF	7/8 x 11	113	33	16.0	12.5	85434
BSF	1" x 10	120	35	18.0	14.0	85438
BSF	1.1/8 x 9	127	37	20.0	16.0	85440
BSF	1.1/4 x 9	137	37	22.4	18.0	85442
BSF	1.3/8 x 8	144	39	25.0	20.0	85444
BSF	1.1/2 x 8	149	45	28.0	22.4	85446
BSF	1.5/8 x 8	164	45	28.0	22.4	85448
BSF	1.3/4 x 7	164	45	31.5	25.0	85450
BSF	1.7/8 x 7	164	45	31.5	25.0	85452
BSF	2" x 7	175	47	35.5	28.0	85454
BSF	2.1/4 x 6	221	76	40.0	31.5	85456
BSF	2.1/2 x 6	224	79	40.0	31.5	85458



BA (brit. assn. thread)



Hand taps, BA-thread BS 93

Hand taps for BA-threads are suitable for machinable non abrasive material up to 900 N/mm² tensile strength, for through and blind holes and for threading in unalloyed and low alloyed steels.

Hand taps in conical (non-serial) form.

- Hand taps for BA-threads acc. to ISO 529
- Variations from BA 0 to BA 6



Hand taps (set of 3 pcs.) non-serial

ISO 529 HSS-G – BA

(hand tap rougher, hand tap intermediate, hand tap finisher)

Type of thread: BA-thread BS 93

Variants (7):

Application/ for general use:

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



D	L1	L2	D2	Square	Art.-No. Set	Art.-No. Rougher	Art.-No. Intermediate	Art.-No. Finisher
BA 0	66	19	6.3	5.0	89400	89400-1	89400-2	89400-3
BA 1	62	17	5.6	4.5	89401	89401-1	89401-2	89401-3
BA 2	58	16	5.0	4.0	89402	89402-1	89402-2	89402-3
BA 3	53	13	4.5	3.55	89403	89403-1	89403-2	89403-3
BA 4	50	13	3.55	2.8	89404	89404-1	89404-2	89404-3
BA 5	48	11	3.15	2.5	89405	89405-1	89405-2	89405-3
BA 6	45	9.5	2.8	2.24	89406	89406-1	89406-2	89406-3



UNC (Unified Coarse)



Hand taps, Unified Coarse thread ANSI B 1.1

Hand taps for UNC threads suitable for non abrasive materials up to 900 N/mm² and for threading in through or blind holes.

Available in cylindrical and conical (non-serial) form.

Hand taps for american UNC right hand threads

- Hand taps (UNC) acc. to DIN, ISO and JIS-B standard
- Variations from UNC No. 1 to UNC 3"



Hand taps (set of 3 pcs.)

JIS B-4430 HSS-G - UNC

(hand tap rougher, hand tap intermediate, hand tap finisher)

Type of thread: Unified Coarse thread ANSI B 1.1

Tolerance: 2B

Variants (10):

Application/ for general use:

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



D	L1	L2	D2	Square	Art.-No. Set	Art.-No. Rougher	Art.-No. Intermediate	Art.-No. Finisher
UNC 3/16	60	17	5.5	4.5	93413	93413-1	93413-2	93413-3
UNC 1/4	62	20	6.0	4.5	93414	93414-1	93414-2	93414-3
UNC 5/16	70	23	6.1	5.5	93415	93415-1	93415-2	93415-3
UNC 3/8	75	25	7.0	5.5	93416	93416-1	93416-2	93416-3
UNC 7/16	80	24	8.0	6.0	93417	93417-1	93417-2	93417-3
UNC 1/2	85	30	9.0	7.0	93418	93418-1	93418-2	93418-3
UNC 5/8	95	32	12.0	9.0	93420	93420-1	93420-2	93420-3
UNC 3/4	105	38	14.0	11.0	93422	93422-1	93422-2	93422-3
UNC 7/8	115	38	17.0	13.0	93424	93424-1	93424-2	93424-3
UNC 1"	126	45	20.0	15.0	93426	93426-1	93426-2	93426-3



Hand taps (set of 3 pcs.)

ISO 529 HSS-G - UNC

Type of thread: Unified Coarse thread ANSI B 1.1

Tolerance: 2B

Variants (24):

Application/ for general use:

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

D		L1	L2	D2	Square	Art.-No. Set
UNC	No. 4 x 40	48	11	3.2	2.5	82404
UNC	No. 5 x 40	48	11	3.2	2.5	82405
UNC	No. 6 x 32	50	13	3.6	2.8	82406
UNC	No. 8 x 32	53	13	4.5	2.8	82408
UNC	No. 10 x 24	58	16	5.0	4.0	82410
UNC	No. 12 x 24	62	17	5.6	4.5	82412
UNC	1/4 x 20	66	19	6.3	5.0	82414
UNC	5/16 x 18	72	22	8.0	6.3	82416
UNC	3/8 x 16	80	24	10.0	8.0	82418
UNC	7/16 x 14	85	25	8.0	6.3	82420
UNC	1/2 x 13	89	29	9.0	7.1	82422
UNC	9/16 x 12	95	30	11.2	9.0	82424
UNC	5/8 x 11	102	32	12.5	10.0	82426
UNC	3/4 x 10	112	37	14.0	11.2	82430
UNC	7/8 x 9	118	38	16.0	12.5	82434
UNC	1" x 8	130	45	18.0	14.0	82438
UNC	1.1/8 x 7	138	48	20.0	16.0	82440
UNC	1.1/4 x 7	151	51	22.4	18.0	82442
UNC	1.3/8 x 6	162	57	25.0	20.0	82444
UNC	1.1/2 x 6	170	60	28.0	22.4	82446
UNC	1.5/8 x 5	170	60	28.0	22.4	82447
UNC	1.3/4 x 5	187	67	31.5	25.0	82448
UNC	1.7/8 x 5	187	67	31.5	25.0	82449
UNC	2" x 4.5	200	70	35.5	28.0	82450



Hand taps (set of 3 pcs.)

≈ DIN 352 HSS-G - UNC

(hand tap rougher, hand tap intermediate, hand tap finisher)

Type of thread: Unified Coarse thread ANSI B 1.1

Tolerance: 2B

Variants (31):

Application/ for general use:

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



D		L1	L2	D2	Square	Art.-No. Set	Art.-No. Rougher	Art.-No. Intermediate	Art.-No. Finisher
UNC	No. 1 x 64	32	10	2.5	2.1	23301	23301-1	23301-2	23301-3
UNC	No. 2 x 56	36	11	2.8	2.1	23302	23302-1	23302-2	23302-3
UNC	No. 3 x 48	36	11	2.8	2.1	23303	23303-1	23303-2	23303-3
UNC	No. 4 x 40	40	12	3.5	2.7	23304	23304-1	23304-2	23304-3
UNC	No. 5 x 40	40	12	3.5	2.7	23305	23305-1	23305-2	23305-3
UNC	No. 6 x 32	45	14	4.0	3.0	23306	23306-1	23306-2	23306-3
UNC	No. 8 x 32	45	14	4.5	3.4	23308	23308-1	23308-2	23308-3
UNC	No. 10 x 24	50	16	6.0	4.9	23310	23310-1	23310-2	23310-3
UNC	No. 12 x 24	50	18	6.0	4.9	23312	23312-1	23312-2	23312-3
UNC	1/4 x 20	50	19	6.0	4.9	23314	23314-1	23314-2	23314-3
UNC	5/16 x 18	56	22	6.0	4.9	23316	23316-1	23316-2	23316-3
UNC	3/8 x 16	70	24	7.0	5.5	23318	23318-1	23318-2	23318-3
UNC	7/16 x 14	70	24	8.0	6.2	23320	23320-1	23320-2	23320-3
UNC	1/2 x 13	75	29	9.0	7.0	23322	23322-1	23322-2	23322-3
UNC	9/16 x 12	80	30	11.0	9.0	23324	23324-1	23324-2	23324-3
UNC	5/8 x 11	80	32	12.0	9.0	23326	23326-1	23326-2	23326-3
UNC	3/4 x 10	95	40	14.0	11.0	23330	23330-1	23330-2	23330-3
UNC	7/8 x 9	100	40	18.0	14.5	23334	23334-1	23334-2	23334-3
UNC	1" x 8	110	50	18.0	14.5	23338	23338-1	23338-2	23338-3
UNC	1.1/8 x 7	132	56	22.0	18.0	23342	23342-1	23342-2	23342-3
UNC	1.1/4 x 7	132	56	22.0	18.0	23346	23346-1	23346-2	23346-3
UNC	1.3/8 x 6	150	63	28.0	22.0	23350	23350-1	23350-2	23350-3
UNC	1.1/2 x 6	150	63	32.0	24.0	23354	23354-1	23354-2	23354-3
UNC	1.5/8 x 5	160	70	32.0	24.0	23358	23358-1	23358-2	23358-3
UNC	1.3/4 x 5	160	70	36.0	29.0	23362	23362-1	23362-2	23362-3
UNC	1.7/8 x 4.1/2	190	80	36.0	29.0	23366	23366-1	23366-2	23366-3
UNC	2" x 4.1/2	190	80	40.0	32.0	23370	23370-1	23370-2	23370-3
UNC	2.1/4 x 4.1/2	220	80	45.0	35.0	23372	23372-1	23372-2	23372-3
UNC	2.1/2 x 4	220	80	50.0	39.0	23374	23374-1	23374-2	23374-3
UNC	2.3/4 x 4	240	80	50.0	39.0	23376	23376-1	23376-2	23376-3
UNC	3" x 4	260	80	50.0	39.0	23378	23378-1	23378-2	23378-3



UNC (Unified Coarse) left hand



Hand taps, Unified Coarse thread ANSI B 1.1

Hand taps for UNC left hand threads suitable for non abrasive materials up to 900 N/mm² and for threading in through or blind holes.

Available in cylindrical and conical (non-serial) form.

Hand taps for american UNC left hand threads

- Hand taps (UNC) acc. to DIN and ISO standard
- Variations from UNC No. 6 LH to UNC 1" LH



Hand taps (set of 3 pcs.) left hand

ISO 529 HSS-G - UNC LH

Type of thread: Unified Coarse thread ANSI B 1.1

Tolerance: 2B

Variants (10):

Application/ for general use:

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

D		L1	L2	D2	Square	Art.-No. Set
UNC	1/4 x 20	66	19	6.3	5.0	82310
UNC	5/16 x 18	72	22	8.0	6.3	82311
UNC	3/8 x 16	80	24	10.0	8.0	82312
UNC	7/16 x 14	85	25	8.0	6.3	82313
UNC	1/2 x 13	89	29	9.0	7.1	82314
UNC	9/16 x 12	95	30	11.2	9.0	82315
UNC	5/8 x 11	102	32	12.5	10.0	82316
UNC	3/4 x 10	112	37	14.0	11.2	82317
UNC	7/8 x 9	118	38	16.0	12.5	82318
UNC	1" x 8	130	45	18.0	14.0	82319



Hand taps (set of 3 pcs.) left hand

≈ DIN 352 HSS-G - UNC LH

(hand tap rougher, hand tap intermediate, hand tap finisher)

Type of thread: Unified Coarse thread ANSI B 1.1

Tolerance: 2B

Variants (14):

Application/ for general use:

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



D		L1	L2	D2	Square	Art.-No. Set	Art.-No. Rougher	Art.-No. Intermediate	Art.-No. Finisher
UNC	No. 6 x 32	45	14	4.0	3.0	23006	23006-1	23006-2	23006-3
UNC	No. 8 x 32	45	14	4.5	3.4	23008	23008-1	23008-2	23008-3
UNC	No. 10 x 24	50	16	6.0	4.9	23010	23010-1	23010-2	23010-3
UNC	No. 12 x 24	50	18	6.0	4.9	23012	23012-1	23012-2	23012-3
UNC	1/4 x 20	50	19	6.0	4.9	23014	23014-1	23014-2	23014-3
UNC	5/16 x 18	56	22	6.0	4.9	23016	23016-1	23016-2	23016-3
UNC	3/8 x 16	70	24	7.0	5.5	23018	23018-1	23018-2	23018-3
UNC	7/16 x 14	70	24	8.0	6.2	23020	23020-1	23020-2	23020-3
UNC	1/2 x 13	75	29	9.0	7.0	23022	23022-1	23022-2	23022-3
UNC	9/16 x 12	80	30	11.0	9.0	23024	23024-1	23024-2	23024-3
UNC	5/8 x 11	80	32	12.0	9.0	23026	23026-1	23026-2	23026-3
UNC	3/4 x 10	95	40	14.0	11.0	23030	23030-1	23030-2	23030-3
UNC	7/8 x 9	100	40	18.0	14.5	23034	23034-1	23034-2	23034-3
UNC	1" x 8	110	50	18.0	14.5	23038	23038-1	23038-2	23038-3



UNF (Unified fine)



Hand taps, Unified fine thread ANSI B 1.1

Hand taps for UNF threads suitable for non abrasive materials up to 900 N/mm² and for threading in through or blind holes.

Available in cylindrical and conical (non-serial) form.

Hand taps for american UNF right hand threads

- Hand taps (UNF) acc. to DIN, ISO and JIS-B standard
- Variations from UNF No. 0 to UNF 2.1/2"



Hand taps (set of 3 pcs.)

JIS B-4430 HSS-G - UNF

(hand tap rougher, hand tap intermediate, hand tap finisher)

Type of thread: Unified Fine thread ANSI B 1.1

Tolerance: 2B

Variants (10):

Application/ for general use:

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



D	L1	L2	D2	Square	Art.-No. Set	Art.-No. Rougher	Art.-No. Intermediate	Art.-No. Finisher
UNF 3/16	60	17	5.5	4.5	93463	93463-1	93463-2	93463-3
UNF 1/4	62	20	6.0	4.5	93464	93464-1	93464-2	93464-3
UNF 5/16	70	23	6.1	5.0	93465	93465-1	93465-2	93465-3
UNF 3/8	75	25	7.0	5.5	93466	93466-1	93466-2	93466-3
UNF 7/16	80	24	8.0	6.0	93467	93467-1	93467-2	93467-3
UNF 1/2	85	30	9.0	7.0	93468	93468-1	93468-2	93468-3
UNF 5/8	95	32	12.0	9.0	93470	93470-1	93470-2	93470-3
UNF 3/4	105	38	14.0	11.0	93472	93472-1	93472-2	93472-3
UNF 7/8	115	38	17.0	13.0	93474	93474-1	93474-2	93474-3
UNF 1"	126	45	20.0	15.0	93476	93476-1	93476-2	93476-3



Hand taps (set of 2 pcs.)

≈ DIN 2181 HSS-G - UNF

(hand tap rougher, hand tap finisher)

Type of thread: Unified Fine thread ANSI B 1.1

Tolerance: 2B

Variants (25):

Application/ for general use:

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



D	L1	L2	D2	Square	Art.-No. Set	Art.-No. Rougher	Art.-No. Finisher
UNF 0 x 80	28	8	2.5	2.1	24300	24300-1	24300-3
UNF 1 x 72	32	9	2.8	2.1	24301	24301-1	24301-3
UNF 2 x 64	32	10	2.8	2.1	24302	24302-1	24302-3
UNF 3 x 56	32	10	2.8	2.1	24303	24303-1	24303-3
UNF 4 x 48	36	11	3.5	2.7	24304	24304-1	24304-3
UNF 5 x 44	36	11	3.5	2.7	24305	24305-1	24305-3
UNF 6 x 40	40	12	4.5	3.4	24306	24306-1	24306-3
UNF 8 x 36	40	12	4.5	3.4	24308	24308-1	24308-3
UNF 10 x 32	45	14	6.0	4.9	24310	24310-1	24310-3
UNF 12 x 28	50	14	6.0	4.9	24312	24312-1	24312-3
UNF 1/4 x 28	50	18	6.0	4.9	24314	24314-1	24314-3
UNF 5/16 x 24	56	22	6.0	4.9	24316	24316-1	24316-3
UNF 3/8 x 24	63	22	7.0	5.5	24318	24318-1	24318-3
UNF 7/16 x 20	63	22	8.0	6.2	24320	24320-1	24320-3
UNF 1/2 x 20	75	24	9.0	7.0	24322	24322-1	24322-3
UNF 9/16 x 18	80	28	11.0	9.0	24324	24324-1	24324-3
UNF 5/8 x 18	80	28	12.0	9.0	24326	24326-1	24326-3
UNF 3/4 x 16	95	32	14.0	11.0	24330	24330-1	24330-3
UNF 7/8 x 14	100	36	18.0	14.5	24334	24334-1	24334-3
UNF 1" x 12	110	40	18.0	14.5	24338	24338-1	24338-3
UNF 1" x 14	110	40	18.0	14.5	24340	24340-1	24340-3
UNF 1.1/8 x 12	110	50	22.0	18.0	24342	24342-1	24342-3
UNF 1.1/4 x 12	132	56	22.0	18.0	24346	24346-1	24346-3
UNF 1.3/8 x 12	132	56	28.0	22.0	24350	24350-1	24350-3
UNF 1.1/2 x 12	150	63	32.0	24.0	24354	24354-1	24354-3



Hand taps (set of 3 pcs.)

ISO 529 HSS-G - UNF

Type of thread: Unified Fine thread ANSI B 1.1

Tolerance: 2B

Variants (27):

Application/ for general use:

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

D		L1	L2	D2	Square	Art.-No. Set
UNF	No. 4 x 48	48	11	3.15	2.5	83405
UNF	No. 5 x 44	48	11	3.15	2.5	83406
UNF	No. 6 x 40	50	13	3.55	2.8	83407
UNF	No. 8 x 36	53	13	4.5	3.55	83408
UNF	No. 10 x 32	58	16	5.0	4.0	83410
UNF	No. 12 x 28	62	17	5.6	4.5	83412
UNF	1/4 x 28	66	19	6.3	5.0	83414
UNF	5/16 x 24	69	19	8.0	6.3	83416
UNF	3/8 x 24	76	20	10.0	8.0	83418
UNF	7/16 x 20	82	22	8.0	6.3	83420
UNF	1/2 x 20	84	24	9.0	7.1	83422
UNF	9/16 x 18	90	25	11.2	9.0	83424
UNF	5/8 x 18	95	25	12.5	10.0	83426
UNF	3/4 x 16	104	29	14.0	11.2	83430
UNF	7/8 x 14	113	33	16.0	12.5	83434
UNF	1" x 12	120	35	18.0	14.0	83438
UNF	1.1/8 x 12	127	37	20.0	16.0	83440
UNF	1.1/4 x 12	137	37	22.4	18.0	83442
UNF	1.3/8 x 12	144	39	25.0	20.0	83444
UNF	1.1/2 x 12	149	39	28.0	22.4	83446
UNF	1.5/8 x 12	164	45	28.0	22.4	83447
UNF	1.3/4 x 12	164	45	31.5	25.0	83448
UNF	1.7/8 x 12	164	45	31.5	25.0	83449
UNF	2" x 12	175	47	35.5	28.0	83454
UNF	2.1/8 x 12	200	70	35.5	28.0	83455
UNF	2.1/4 x 12	221	76	40.0	31.5	83456
UNF	2.1/2 x 12	224	79	40.0	31.5	83458



UNF (Unified fine) left hand



Hand taps, Unified fine thread ANSI B 1.1

Hand taps for UNF left hand threads suitable for non abrasive materials up to 900 N/mm² and for threading in through or blind holes.

Available in cylindrical and conical (non-serial) form.

Hand taps for american UNF left hand threads

- Hand taps (UNF) acc. to DIN and ISO standard
- Variations from UNF No. 10 LH to UNF 1" LH



Hand taps (set of 3 pcs.) left hand

JIS B-4430 HSS-G - UNF

Type of thread: Unified Fine thread ANSI B 1.1

Tolerance: 2B

Variants (10):

Application/ for general use:

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

D		L1	L2	D2	Square	Art.-No. Set
UNF	1/4 x 28	66	19	6.3	5.0	82350
UNF	5/16 x 24	69	19	8.0	6.3	82351
UNF	3/8 x 24	76	20	10.0	8.0	82352
UNF	7/16 x 20	83	22	8.0	6.3	82353
UNF	1/2 x 20	84	24	9.0	7.1	82354
UNF	9/16 x 18	90	25	11.2	9.0	82355
UNF	5/8 x 18	95	25	12.5	10.0	82356
UNF	3/4 x 16	104	29	14.0	11.2	82357
UNF	7/8 x 14	113	33	16.0	12.5	82358
UNF	1" x 12	120	35	18.0	14.0	82359



Hand taps (set of 2 pcs.) left hand

≈ DIN 2181 HSS-G - UNF LH
(hand tap rougher, hand tap finisher)

Type of thread: Unified Fine thread ANSI B 1.1

Tolerance: 2B

Variants (10):

Application/ for general use:

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



D		L1	L2	D2	Square	Art.-No. Set	Art.-No. Rougher	Art.-No. Finisher
UNF	No. 10 x 32	45	14	6.0	4.9	24010	24010-1	24010-3
UNF	1/4 x 28	50	18	6.0	4.9	24014	24014-1	24014-3
UNF	5/16 x 24	56	22	6.0	4.9	24016	24016-1	24016-3
UNF	3/8 x 24	63	22	7.0	5.5	24018	24018-1	24018-3
UNF	7/16 x 20	63	22	8.0	6.2	24020	24020-1	24020-3
UNF	1/2 x 20	75	24	9.0	7.0	24022	24022-1	24022-3
UNF	9/16 x 18	80	28	11.0	9.0	24024	24024-1	24024-3
UNF	5/8 x 18	80	28	12.0	9.0	24026	24026-1	24026-3
UNF	3/4 x 16	95	32	14.0	11.0	24030	24030-1	24030-3
UNF	7/8 x 14	100	36	18.0	14.5	24034	24034-1	24034-3
UNF	1" 12	110	40	18.0	14.5	24038	24038-1	24038-3



UNEF (Unified extra fine)



Hand taps, Unified extra fine thread ANSI B 1.1

Hand taps for UNEF threads in conical (non-serial) form suitable for non abrasive materials up to 900 N/mm² and for threading in through or blind holes.

Hand taps for american UENF threads

- Hand taps (UNEF) acc. to ISO 529
- Variations from UNEF 1/4 to UNEF 1"



Hand taps (set of 3 pcs.) non-serial

ISO 529 HSS-G - UNEF

(hand tap rougher, hand tap intermediate, hand tap finisher)

Type of thread: Unified Extra Fine thread ANSI B 1.1

Tolerance: 2B

Variants (10):

Application/ for general use:

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



D	L1	L2	D2	Square	Art.-No. Set	Art.-No. Rougher	Art.-No. Intermediate	Art.-No. Finisher
UNEF 1/4 x 32	66	19	6.3	5.0	83821	83821-1	83821-2	83821-3
UNEF 5/16 x 32	72	22	8.0	6.3	83822	83822-1	83822-2	83822-3
UNEF 3/8 x 32	80	24	10.0	8.0	83823	83823-1	83823-2	83823-3
UNEF 7/16 x 28	85	25	8.0	6.3	83824	83824-1	83824-2	83824-3
UNEF 1/2 x 28	89	29	9.0	7.1	83825	83825-1	83825-2	83825-3
UNEF 9/16 x 24	95	30	11.2	9.0	83826	83826-1	83826-2	83826-3
UNEF 5/8 x 24	102	32	12.5	10.0	83827	83827-1	83827-2	83827-3
UNEF 3/4 x 20	112	37	14.0	11.2	83829	83829-1	83829-2	83829-3
UNEF 7/8 x 20	118	38	16.0	12.5	83831	83831-1	83831-2	83831-3
UNEF 1" x 20	130	45	16.0	14.0	83833	83833-1	83833-2	83833-3



G (BSP) Pipe-thread



Hand taps, Pipe thread DIN ISO 228

G (BSP) Hand taps in cylindrical and conical (non-serial) form for non abrasive material up to 900 N/mm².

- Hand taps G (BSP) acc. to DIN 5157 and ISO 529
- Taps for through and blind holes
- Hand taps for right- and left-handed threads (LH)
- G (BSP) rougher and finisher can be ordered separately
- Variations: G (BSP) 1/8 to G (BSP) 4"



Hand taps (set of 2 pcs.)

DIN 5157 HSS-E - G (BSP)
(hand tap rougher, hand tap finisher)

Type of thread: Pipe-thread DIN ISO 228

Variants (6):

Advantages:

- high cutting ability

Application:

- abrasive material
- Steel up to 1200 N/mm²
- and for general use



D		L1	L2	D2	Square	Art.-No. Set	Art.-No. Rougher	Art.-No. Finisher
G	1/8 x 28	63	20	7.0	5.5	55312	55312-1	55312-2
G	1/4 x 19	70	22	11.0	9.0	55314	55314-1	55314-2
G	3/8 x 19	70	22	12.0	9.0	55316	55316-1	55316-2
G	1/2 x 14	80	22	16.0	12.0	55318	55318-1	55318-2
G	3/4 x 14	90	22	20.0	16.0	55322	55322-1	55322-2
G	1" x 11	100	25	25.0	20.0	55326	55326-1	55326-2



Hand taps (set of 2 pcs.)

DIN 5157 HSS-G - G (BSP)
(hand tap rougher, hand tap finisher)

Type of thread: Pipe-thread DIN ISO 228

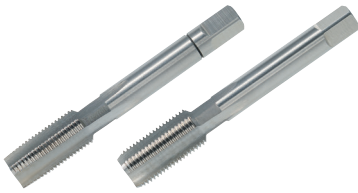
Variants (21):

Application/ for general use:

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



D		L1	L2	D2	Square	Art.-No. Set	Art.-No. Rougher	Art.-No. Finisher
G	1/8 x 28	63	20	7.0	5.5	25312	25312-1	25312-2
G	1/4 x 19	70	22	11.0	9.0	25314	25314-1	25314-2
G	3/8 x 19	70	22	12.0	9.0	25316	25316-1	25316-2
G	1/2 x 14	80	22	16.0	12.0	25318	25318-1	25318-2
G	5/8 x 14	80	22	18.0	14.5	25320	25320-1	25320-2
G	3/4 x 14	90	22	20.0	16.0	25322	25322-1	25322-2
G	7/8 x 14	90	22	22.0	18.0	25324	25324-1	25324-2
G	1" x 11	100	25	25.0	20.0	25326	25326-1	25326-2
G	1.1/8 x 11	125	40	28.0	22.0	25330	25330-1	25330-2
G	1.1/4 x 11	125	40	32.0	24.0	25334	25334-1	25334-2
G	1.3/8 x 11	140	40	36.0	29.0	25338	25338-1	25338-2
G	1.1/2 x 11	140	40	36.0	29.0	25342	25342-1	25342-2
G	1.5/8 x 11	140	40	40.0	32.0	25345	25345-1	25345-2
G	1.3/4 x 11	140	40	40.0	32.0	25350	25350-1	25350-2
G	2" x 11	160	40	45.0	35.0	25354	25354-1	25354-2
G	2.1/4 x 11	160	40	50.0	39.0	25358	25358-1	25358-2
G	2.1/2 x 11	160	40	50.0	39.0	25362	25362-1	25362-2
G	2.3/4 x 11	160	40	50.0	39.0	25366	25366-1	25366-2
G	3" x 11	160	40	50.0	39.0	25370	25370-1	25370-2
G	3.1/2 x 11	180	45	56.0	44.0	25374	25374-1	25374-2
G	4" x 11	180	45	56.0	44.0	25378	25378-1	25378-2



Hand taps (set of 2 pcs.) left hand

DIN 5157 HSS-G - G (BSP) LH

(hand tap rougher, hand tap finisher)

Type of thread: Pipe-thread DIN ISO 228

Variants (13):

Application/ for general use:

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



D		L1	L2	D2	Square	Art.-No. Set	Art.-No. Rougher	Art.-No. Finisher
G	1/8 x 28	63	20	7.0	5.5	25012	25012-1	25012-2
G	1/4 x 19	70	22	11.0	9.0	25014	25014-1	25014-2
G	3/8 x 19	70	22	12.0	9.0	25016	25016-1	25016-2
G	1/2 x 14	80	22	16.0	12.0	25018	25018-1	25018-2
G	5/8 x 14	80	22	18.0	14.5	25020	25020-1	25020-2
G	3/4 x 14	90	22	20.0	16.0	25022	25022-1	25022-2
G	1" x 11	100	25	25.0	20.0	25026	25026-1	25026-2
G	1.1/8 x 11	125	40	28.0	22.0	25030	25030-1	25030-2
G	1.1/4 x 11	125	40	32.0	24.0	25034	25034-1	25034-2
G	1.3/8 x 11	140	40	36.0	29.0	25038	25038-1	25038-2
G	1.1/2 x 11	140	40	36.0	29.0	25042	25042-1	25042-2
G	1.3/4 x 11	140	40	40.0	32.0	25050	25050-1	25050-2
G	2" x 11	160	40	45.0	35.0	25054	25054-1	25054-2



Hand taps (set of 3 pcs.)

ISO 529 HSS-G - G (BSP)

(hand tap rougher, hand tap intermediate, hand tap finisher)

Type of thread: Pipe-thread DIN ISO 228

Variants (17):

Application/ for general use:

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

D		L1	L2	D2	Square	Art.-No. Set
G	1/8 x 28	59	15	8.0	6.3	86412
G	1/4 x 19	67	19	10.0	8.0	86414
G	3/8 x 19	75	21	12.5	10.0	86416
G	1/2 x 14	87	26	16.0	12.5	86418
G	5/8 x 14	91	26	18.0	14.0	86421
G	3/4 x 14	96	28	20.0	16.0	86422
G	7/8 x 14	102	29	22.4	18.0	86424
G	1" x 11	109	33	25.0	20.0	86426
G	1.1/8 x 11	115	34	28.0	22.4	86430
G	1.1/4 x 11	119	36	31.5	25.0	86434
G	1.1/2 x 11	125	37	35.5	28.0	86442
G	1.3/4 x 11	132	39	35.5	28.0	86448
G	2" x 11	140	41	40.0	31.5	86454
G	2.1/4 x 11	142	42	40.0	31.5	86458
G	2.1/2 x 11	153	45	45.0	35.5	86460
G	3"	164	48	50.0	40.0	86464
G	4"	185	53	71.0	56.0	86478



PG (Armoured tube thread)



Hand taps, armoured tube thread DIN 40 430

Hand taps for PG threads are suitable for non abrasive materials up to 900 N/mm², for unalloyed and low alloyed steel and for threading in through or blind holes.

Hand taps for PG threads

- Hand taps (PG-threads) acc. to DIN 40 432
- Variations from PG 7 to PG 48



Hand taps (set of 2 pcs.)

DIN 40432 HSS-G - PG
(hand tap rougher, hand tap finisher)

Type of thread: armoured tube thread DIN 40 430

Variants (10):

Application/

for general use:

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



D		L1	L2	D2	Square	Art.-No. Set	Art.-No. Rougher	Art.-No. Finisher
PG	7 x 20	70	22	9.0	7.0	25707	25707-1	25707-2
PG	9 x 18	70	22	12.0	9.0	25709	25709-1	25709-2
PG	11 x 18	80	22	14.0	11.0	25711	25711-1	25711-2
PG	13.5 x 18	80	22	16.0	12.0	25713	25713-1	25713-2
PG	16 x 18	80	22	18.0	14.5	25716	25716-1	25716-2
PG	21 x 16	90	22	22.0	18.0	25721	25721-1	25721-2
PG	29 x 16	100	25	28.0	22.0	25729	25729-1	25729-2
PG	36 x 16	140	40	36.0	29.0	25736	25736-1	25736-2
PG	42 x 16	140	40	40.0	32.0	25742	25742-1	25742-2
PG	48 x 16	160	40	45.0	35.0	25748	25748-1	25748-2



Tr (trapezoidal thread)



Hand taps, trapezoidal thread DIN103

Hand taps for trapezoidal threads made of HSS-G are suitable for non abrasive material up to 900 N/mm² and for thread cutting in unalloyed and low alloyed materials.

- Taps for thread cutting in through and blind holes
- Variations from Tr 10x2 to Tr 32x6

Please note that for thread cutting of trapezoidal threads by hand it is recommended to use the complete set with rougher, intermediate and finisher. The finisher should be used in single only for **re-cutting** of an existing thread.



Hand taps (set of 3 pcs.)

HSS-G - Tr

(hand tap rougher, hand tap intermediate, hand tap finisher)

Type of thread: trapezoidal thread DIN 103

Tolerance: 7H

Variants (14):

Application/ for general use:

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



D	L1	L2	D2	Square	Art.-No. Set	Art.-No. Rougher	Art.-No. Intermediate	Art.-No. Finisher
Tr 10 x 2	90	34	7.0	5.5	25108	25108-1	25108-2	25108-3
Tr 10 x 3	100	40	7.0	5.5	25112	25112-1	25112-2	25112-3
Tr 12 x 3	110	40	8.0	6.2	25116	25116-1	25116-2	25116-3
Tr 14 x 3	130	45	10.0	8.0	25120	25120-1	25120-2	25120-3
Tr 14 x 4	130	55	10.0	8.0	25124	25124-1	25124-2	25124-3
Tr 16 x 4	140	55	11.0	9.0	25128	25128-1	25128-2	25128-3
Tr 18 x 4	150	55	12.0	9.0	25132	25132-1	25132-2	25132-3
Tr 20 x 4	160	55	14.0	11.0	25136	25136-1	25136-2	25136-3
Tr 22 x 5	175	65	16.0	12.0	25140	25140-1	25140-2	25140-3
Tr 24 x 5	190	65	18.0	14.5	25144	25144-1	25144-2	25144-3
Tr 26 x 5	210	70	20.0	16.0	25148	25148-1	25148-2	25148-3
Tr 28 x 5	220	70	22.0	18.0	25152	25152-1	25152-2	25152-3
Tr 30 x 6	240	80	22.0	18.0	25156	25156-1	25156-2	25156-3
Tr 32 x 6	255	80	25.0	20.0	25160	25160-1	25160-2	25160-3



American UNx8 thread



Hand taps, Unified thread ANSI B 1.1

American UN Thread-series with constant 8 pitches per inch. Hand taps for UNx8 threads suitable for non abrasive material up to 900 N/mm², for thread cutting in through or blind holes and for unalloyed and low alloyed steels.

Hand taps for american UNx8 threads

- Hand taps UNx8 acc. to ISO 529
- Variations from UN 1.1/8 x8 to UN 4" x8



Hand taps (set of 3 pcs.)

ISO 529 HSS-G - UN

(hand tap rougher, hand tap intermediate, hand tap finisher)

Type of thread: Unified thread ANSI B 1.1

Tolerance: 2B

Variants (16):

Application/

for general use:

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

D		L1	L2	D2	Square	Art.-No. Set
UNS	1.1/8 x 8	138	48	20.0	16.0	82940
UNS	1.1/4 x 8	151	51	22.4	18.0	82942
UNS	1.3/8 x 8	162	57	25.0	20.0	82944
UNS	1.1/2 x 8	170	60	28.0	22.4	82946
UNS	1.5/8 x 8	170	60	28.0	22.4	82947
UNS	1.3/4 x 8	187	67	31.5	25.0	82948
UNS	1.7/8 x 8	187	67	31.5	25.0	82949
UNS	2" x 8	200	70	35.5	28.0	82950
UNS	2.1/8 x 8	200	70	35.5	28.0	82951
UNS	2.1/4 x 8	221	76	40.0	31.5	82952
UNS	2.3/8 x 8	224	79	40.0	31.5	82953
UNS	2.1/2 x 8	224	79	40.0	31.5	82954
UNS	2.3/4 x 8	234	79	45.0	35.5	82956
UNS	3" x 8	258	83	50.0	40.0	82958
UNS	3.1/2 x 8	261	86	50.0	40.0	82960
UNS	4" x 8	279	89	56.0	45.0	82962



Whitworth screw thread for gas cylinders



Hand taps, tapered Whitworth screw thread BS 84

Whitworth-taps for screw threads for cylinder valves are suitable for non abrasive materials up to 900 N/mm² as well as for low unalloyed and low alloyed steels.

Whitworth hand taps for gas cylinder valves 3:25

- Hand taps acc. to Japanese standard JIS-B 4430
- Variations from W 1/8 to W 1.1/4



Hand taps (set of 3 pcs.)

JIS B-4430 HSS-G - W

(hand tap rougher, hand tap intermediate, hand tap finisher)

Type of thread: tapered Whitworth screw thread for gas cylinders taper 3.25

Variants (14):

Application/

for general use:

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



D	L1	L2	D2	Square	Art.-No. Set	Art.-No. Rougher	Art.-No. Intermediate	Art.-No. Finisher
W 1/8	47	11	4.0	3.2	94406	94406-1	94406-2	94406-3
W 5/32	53	14	5.0	4.0	94408	94408-1	94408-2	94408-3
W 3/16	60	17	5.5	4.5	94410	94410-1	94410-2	94410-3
W 1/4	62	20	6.0	4.5	94414	94414-1	94414-2	94414-3
W 5/16	70	23	6.1	5.0	94416	94416-1	94416-2	94416-3
W 3/8	75	25	7.0	5.5	94418	94418-1	94418-2	94418-3
W 7/16	80	24	8.0	6.0	94420	94420-1	94420-2	94420-3
W 1/2	85	30	9.0	7.0	94422	94422-1	94422-2	94422-3
W 9/16	90	30	10.5	8.0	94424	94424-1	94424-2	94424-3
W 5/8	95	32	12.0	9.0	94426	94426-1	94426-2	94426-3
W 3/4	105	38	14.0	11.0	94430	94430-1	94430-2	94430-3
W 7/8	115	38	17.0	13.0	94434	94434-1	94434-2	94434-3
W 1"	126	45	20.0	15.0	94438	94438-1	94438-2	94438-3
W 1.1/4	145	51	24.0	19.0	94440	94440-1	94440-2	94440-3

Short Machine Taps





Short machine taps



Taps for thread cutting by hand and machine

- › Short machine taps acc. to DIN, ISO and JIS-B
- › Taps for through and blind holes
- › for non abrasive material up to 900 N/mm²
- › Short machine taps for right and left-handed threads (LH)
- › Taps with short and long thread lead

M



Metric ISO-thread DIN 13

Short machine taps for metric coarse threads for non abrasive materials up to 900 N/mm².

- › Short machine taps acc. to DIN 352
- › Taps for thread cutting by hand and machine

Application

- › Form B with spiral point: for through holes
- › Form C with 35° spiral flute: for blind holes
- › Form B-AZ (with interrupted threads): for through holes

Metric Coarse thread from M 3 up to M 24



P.K.25 Short machine taps (set of 16 pcs.) (47605)

incl. ratchet and drills M 3 – M 12, DIN 352, Form B with Spiral Point, HSS-E

Type of thread	Standard	Material	Packing	Size
metric ISO thread DIN 13	DIN Standard	HSS-E	in plastic case	Diameter M 3 - 12

Application/for general use:

- › non abrasive material up to 900 N/mm²
- › unalloyed and low alloyed steel
- › for through holes
- › for thread cutting by hand
- › small, handy set for standard application
- › the most popular dimensions in one case

Contents:

	Art. -No.
1x Tap holder with Ratchet for right- and left-hand-turn, Size 1	10001
1x Adjustable Tap Wrenches DIN 1814 Size 1.1/2	13015
1x Short Machine Taps, DIN 352, HSS-E, M 3 x 0.5	61526
1x Short Machine Taps, DIN 352, HSS-E, M 4 x 0.7	61530
1x Short Machine Taps, DIN 352, HSS-E, M 5 x 0.8	61534
1x Short Machine Taps, DIN 352, HSS-E, M 6 x 1.0	61538
1x Short Machine Taps, DIN 352, HSS-E, M 8 x 1.25	61542
1x Short Machine Taps, DIN 352, HSS-E, M 10 x 1.5	61546
1x Short Machine Taps, DIN 352, HSS-E, M 12 x 1.75	61550
Twist drill 2.5 / 3.3 / 4.2 / 5.0 / 6.8 / 8.5 / 10.2 mm	



P.K.26 Short machine taps (set of 15 pcs.) (47601)

incl. drills M 3 – M 12, DIN 352, Form B with Spiral Point, HSS-E

Type of thread	Standard	Material	Packing	Size
metric ISO thread DIN 13	DIN Standard	HSS-E	in plastic case	Diameter M 3 - 12

Application/for general use:

- › non abrasive material up to 900 N/mm²
- › unalloyed and low alloyed steel
- › for through holes
- › for thread cutting by hand
- › small, handy set for standard application
- › the most popular dimensions in one case

Contents:

	Art. -No.
1x Adjustable Tap Wrenches DIN 1814 Size 1.1/2	13015
1x Short Machine Taps, DIN 352, HSS-E, M 3 x 0.5	61526
1x Short Machine Taps, DIN 352, HSS-E, M 4 x 0.7	61530
1x Short Machine Taps, DIN 352, HSS-E, M 5 x 0.8	61534
1x Short Machine Taps, DIN 352, HSS-E, M 6 x 1.0	61538
1x Short Machine Taps, DIN 352, HSS-E, M 8 x 1.25	61542
1x Short Machine Taps, DIN 352, HSS-E, M 10 x 1.5	61546
1x Short Machine Taps, DIN 352, HSS-E, M 12 x 1.75	61550
Twist drill 2.5 / 3.3 / 4.2 / 5.0 / 6.8 / 8.5 / 10.2 mm	



Short machine taps

DIN 352 Form B HSS-E - M, Spiral point

Type of thread: metric ISO-thread DIN 13

Tolerance: ISO 2 /6H

Variants (13):

Application/for general use:

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

D		L1	L2	D2	Square	Art.-No.
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



Short machine taps

DIN 352 Form C 35°RSP HSS-E - M, Spiral flute

Type of thread: metric ISO-thread DIN 13

Tolerance: ISO 2 /6H

Variants (7):

Application/for general use:

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

D		L1	L2	D2	Square	Art.-No.
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



Short machine taps

DIN 352 Form B-AZ HSS-E - M, with interrupted threads

Type of thread: metric ISO-thread DIN 13

Tolerance: ISO 2 /6H

Variants (7):

Application/for general use:

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

D		L1	L2	D2	Square	Art.-No.
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



M (ISO 529)



Metric ISO-thread DIN 13

Short machine taps for metric coarse threads for non abrasive materials up to 900 N/mm².

- Short machine taps acc. to ISO 529
- Taps for thread cutting by hand and machine

Application

- Form B with spiral point: for through holes
- Form C with 35° spiral flute: for blind holes
- Form B-AZ (with interrupted threads): for through holes

Metric Coarse thread from M 2 up to M 30



P.K.85 Machine taps (set of 18 pcs.) (80501)

ISO 529 incl. drills M 3 - M 10, Form B Round Dies DIN 223 / 25 x 9

Type of thread	Standard	Material	Packing	Size
metric ISO thread DIN 13	ISO Standard	HSS-G	in plastic case	Diameter M 3 - 10

Application/for general use:

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through holes
- small, handy set for standard application
- the most popular dimensions in one case

Contents:	Art. -No.	Contents:	Art. -No.
1x Short Machine Taps, ISO 529, HSS-G, M 3 x 0.5	80526	1x Round Dies, DIN 223 (DIN EN 22568), HSS-G, M 3 x 0.5	27426
1x Short Machine Taps, ISO 529, HSS-G, M 4 x 0.7	80530	1x Round Dies, DIN 223 (DIN EN 22568), HSS-G, M 4 x 0.7	27430
1x Short Machine Taps, ISO 529, HSS-G, M 5 x 0.8	80534	1x Round Dies, HSS-G, M 5 x 0.8	27834
1x Short Machine Taps, ISO 529, HSS-G, M 6 x 1.0	80538	1x Round Dies, HSS-G, M 6 x 1.0	27838
1x Short Machine Taps, ISO 529, HSS-G, M 8 x 1.25	80542	1x Round Dies, HSS-G, M 8 x 1.25	27842
1x Short Machine Taps, ISO 529, HSS-G, M 10 x 1.5	80546	1x Round Dies, HSS-G, M 10 x 1.5	27846
Twist drill 2.5 / 3.3 / 4.2 / 5.0 / 6.8 / 8.5 mm			



Machine taps (set of 7 pcs.) (80500)

ISO 529 Form B M 3 - M 12

Type of thread	Standard	Material	Packing	Size
metric ISO thread DIN 13	ISO 529	HSS-G	in plastic case	Diameter M 3 - 12

Application/for general use:

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

Contents:

	Art. -No.
1x Short Machine Taps, ISO 529, HSS-G, M 3 x 0.5	80526
1x Short Machine Taps, ISO 529, HSS-G, M 4 x 0.7	80530
1x Short Machine Taps, ISO 529, HSS-G, M 5 x 0.8	80534
1x Short Machine Taps, ISO 529, HSS-G, M 6 x 1.0	80538
1x Short Machine Taps, ISO 529, HSS-G, M 8 x 1.25	80542
1x Short Machine Taps, ISO 529, HSS-G, M 10 x 1.5	80546
1x Short Machine Taps, ISO 529, HSS-G, M 12 x 1.75	80550



Machine taps (set of 7 pcs.) (80900)

ISO 529 Form B-AZ M 3 - M 12

Type of thread	Standard	Material	Packing	Size
metric ISO thread DIN 13	ISO 529	HSS-G	in plastic case	Diameter M 3 - 12

Application/for general use:

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

Contents:

	Art. -No.
1x Short Machine Taps, ISO 529, HSS-G, M 3 x 0.5	80926
1x Short Machine Taps, ISO 529, HSS-G, M 4 x 0.7	80930
1x Short Machine Taps, ISO 529, HSS-G, M 5 x 0.8	80934
1x Short Machine Taps, ISO 529, HSS-G, M 6 x 1.0	80938
1x Short Machine Taps, ISO 529, HSS-G, M 8 x 1.25	80942
1x Short Machine Taps, ISO 529, HSS-G, M 10 x 1.5	80946
1x Short Machine Taps, ISO 529, HSS-G, M 12 x 1.75	80950



Machine taps (set of 7 pcs.) (80700)

ISO 529 Form C/35°RSP M 3 - M 12

Type of thread	Standard	Material	Packing	Size
metric ISO thread DIN 13	ISO 529	HSS-G	in plastic case	Diameter M 3 - 12

Application/for general use:

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

Contents:

	Art.-No.
1x Short Machine Taps, ISO 529, HSS-G, M 3 x 0.5	80726
1x Short Machine Taps, ISO 529, HSS-G, M 4 x 0.7	80730
1x Short Machine Taps, ISO 529, HSS-G, M 5 x 0.8	80734
1x Short Machine Taps, ISO 529, HSS-G, M 6 x 1.0	80738
1x Short Machine Taps, ISO 529, HSS-G, M 8 x 1.25	80742
1x Short Machine Taps, ISO 529, HSS-G, M 10 x 1.5	80746
1x Short Machine Taps, ISO 529, HSS-G, M 12 x 1.75	80750



Machine taps, extra long

ISO 2283 HSS-G - M

Type of thread: metric ISO-thread DIN 13	Tolerance: ISO 2 /6H
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Variants (7):

Application/for general use:

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

D		L1	L2	D2	Square	Art.-No.
M	3 x 0.6	73	13	3.15	2.5	80104
M	4 x 0.7	73	13	3.15	2.5	80105
M	5 x 0.8	79	16	4.0	3.15	80106
M	6 x 1.0	89	19	4.5	3.55	80107
M	8 x 1.25	97	22	6.3	5.0	80108
M	10 x 1.5	108	24	8.0	6.3	80109
M	12 x 1.75	119	29	9.0	7.1	80110



Short machine taps

ISO 529 Form C 35°RSP HSS-G - M

Type of thread: metric ISO-thread DIN 13

Tolerance: ISO 2 /6H

Variants (17):

Application/for general use:

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

D		L1	L2	D2	Square	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



Short machine taps

ISO 529 Form B HSS-G - M

Type of thread: metric ISO-thread DIN 13

Tolerance: ISO 2 /6H

Variants (19):

Application/for general use:

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

D		L1	L2	D2	Square	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



Short machine taps

ISO 529 Form B-AZ HSS-G - M

Type of thread: metric ISO-thread DIN 13

Tolerance: ISO 2 /6H

Variants (14):

Application/for general use:

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

D		L1	L2	D2	Square	Art.-No.
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	10.00	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



Mf



Metric-fine ISO-thread DIN 13

Short machine taps for metric fine threads for non abrasive materials up to 900 N/mm².

- Short machine taps, metric fine acc. to DIN 2181
- Taps for thread cutting by hand and machine
- Form D with 4-5 threads lead: for through holes

Metric fine taps from M 6x0.75 - M 32x1.5



Short machine taps

DIN 2181 Form D HSS-G - Mf

Type of thread: metric-fine ISO-thread DIN 13

Tolerance: ISO 2 /6H

Variants (33):

Application/for general use:

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

D		L1	L2	D2	Square	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



D		L1	L2	D2	Square	Art.-No.
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



BSW - W (DIN 477)



Whitworth-thread

Short machine taps for BSW (British-Standard-Whitworth) and tapered Whitworth screw threads (for gas cylinders). Especially suitable for non abrasive materials up to 900 N/mm².

- Short machine taps acc. to ≈ DIN 352
- Taps for thread cutting by hand and machine
- unalloyed and low alloyed steel

BSW 1/8 - BSW 1" and W 19.8 - W 31.3



Short machine taps

≈ DIN 352 Form D HSS-G – BSW

Type of thread: Whitworth-thread BS 84

Variants (12):

Application/for general use:

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

D		L1	L2	D2	Square	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

≈ DIN 352 Form C HSS-G - W

Type of thread: tapered Whitworth thread, for gas cylinders taper 3:25, DIN 477

Variants (3):

Application/for general use:

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

D		L1	L2	D2	Square	Art.-No.
W	19.8 x 14	90	32	16.0	12.0	62397
W	28.8 x 14	100	40	20.0	16.0	62398
W	31.3 x 14	110	40	22.0	18.0	62399



UNC / UNF



Unified Coarse and Fine thread ANSI B 1.1

Short machine taps for UNC (Unified Coarse) and UNF (Unified Fine threads). Taps especially suitable for non abrasive materials up to 900 N/mm².

- UNC/UNF Short machine taps acc. to ≈ DIN 352
- Taps for thread cutting by hand and machine
- unalloyed and low alloyed steel

UNC 1/4 - UNC 1" and UNF 1/4 - UNF 1"



Short machine taps

≈ DIN 352 Form D HSS-G - UNC + ≈ DIN 352 Form D HSS-G - UNF

Type of thread: UNC: Unified Coarse thread ANSI B 1.1

Type of thread: UNF: Unified Fine thread ANSI B 1.1

Tolerance: 2B

Variants (10 + 10):

Application/ for general use:

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

D	L1	L2	D2	Square	Art.-No.	Art.-No.
1/4 x 20	50	19	6.0	4.9	UNC: 63314	UNF: 64314
5/16 x 18	56	22	6.0	4.9	UNC: 63316	UNF: 64316
3/8 x 16	70	24	7.0	5.5	UNC: 63318	UNF: 64318
7/16 x 14	70	24	8.0	6.2	UNC: 63320	UNF: 64320
1/2 x 13	75	29	9.0	7.0	UNC: 63322	UNF: 64322
9/16 x 12	80	30	11.0	9.0	UNC: 63324	UNF: 64324
5/8 x 11	80	32	12.0	9.0	UNC: 63326	UNF: 64326
3/4 x 10	95	40	14.0	11.0	UNC: 63330	UNF: 64330
7/8 x 9	100	40	18.0	14.5	UNC: 63334	UNF: 64334
1" x 8	110	50	18.0	14.5	UNC: 63338	UNF: 64338



G (BSP)



Pipe thread DIN ISO 228

Short machine taps for G (BSP) pipe threads.
Taps especially suitable for non abrasive materials up to 900 N/mm².

- G (BSP) Short machine taps acc. to DIN 5157
- Taps for thread cutting by hand and machine
- unalloyed and low alloyed steel

Pipe thread G (BSP) 1/8 - G (BSP) 4"



Short machine taps

DIN 5157 Form D HSS-G - G (BSP)

Type of thread: Pipe-thread DIN ISO 228

Variants (16):

Application/for general use:

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

D		L1	L2	D2	Square	Art.-No.
G	1/8 x 28	63	20	7.0	5.5	65312
G	1/4 x 19	70	22	11.0	9.0	65314
G	3/8 x 19	70	22	12.0	9.0	65316
G	1/2 x 14	80	22	16.0	12.0	65318
G	3/4 x 14	90	22	20.0	16.0	65322
G	1" x 11	100	25	25.0	20.0	65326
G	1.1/4 x 11	125	40	32.0	24.0	65334
G	1.1/2 x 11	140	40	36.0	29.0	65342
G	1.3/4 x 11	140	40	40.0	32.0	65350
G	2" x 11	160	40	45.0	35.0	65354
G	2.1/4 x 11	160	40	50.0	39.0	65358
G	2.1/2 x 11	160	40	50.0	39.0	65362
G	2.3/4 x 11	160	40	50.0	39.0	65366
G	3" x 11	160	40	50.0	39.0	65370
G	3.1/2 x 11	180	45	56.0	44.0	65374
G	4" x 11	180	45	56.0	44.0	65378



Rc (BSPT)



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

Short machine taps for Rc (BSPT) tapered pipe thread. Taps especially suitable for non abrasive materials up to 900 N/mm².

- Rc (BSPT) Short machine taps for unalloyed and low alloyed steel
- Taps for thread cutting by hand and machine

Application

- Form C: for through and blind holes
- Form B: for through holes
- Form C with 35° spiral flute: for blind holes

Tapered pipe thread PT 1/16 - PT 2"



Short machine taps

Form C HSS-G - Rc (BSPT)

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

Variants (7):

Application/for general use:

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

D		L1	L2	D2	Square	Art.-No.
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	22.0	16.0	63722
PT	5/8	-	-	-	-	63720
PT	1" x 11	110	38.0	25.0	20.0	63726



Short machine taps

Form C 35°RSP HSS-G - Rc (BSPT)

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

Variants (10):

Application/for general use:

- › non abrasive material up to 900 N/mm²
- › unalloyed and low alloyed steel
- › for thread cutting by hand and machine
- › Form C for blind holes,
- › Form B for through holes

D		L1	L2	D2	Square	Art.-No.
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



Short machine taps

Form B HSS-G - Rc (BSPT)

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

Variants (10):

Application/for general use:

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

D		L1	L2	D2	Square	Art.-No.
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



Rp (BSPP)



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

Short machine taps for Rp (BSPP) cylindrical pipe thread. Taps especially suitable for non abrasive materials up to 900 N/mm².

- Rp (BSPP) Short machine taps for unalloyed and low alloyed steel
- Taps for thread cutting by hand and machine

Application

- Form C: for through and blind holes
- Form C with 35° spiral flute: for blind holes

Cylindrical pipe thread PS 1/16 - PS 2"



Short machine taps

Form C 35°RSP HSS-G – Rp (BSPP) + Form C HSS-G – Rp (BSPP)

Type of thread: Pipe-thread ISO 7-1

Variants (10 + 10):

Application/for general use:

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for thread cutting by hand and machine
- Form C 35° for blind holes
- Form C for through and blind holes

D	L1	L2	D2	Square	Art.-No.	Art.-No.
PS 1/16 x 28	55	19	6.5	5.0	Form C 35°: 95702	Form C: 95402
PS 1/8 x 28	55	19	8.0	6.0	Form C 35°: 95706	Form C: 95406
PS 1/4 x 19	62	28	11.0	9.0	Form C 35°: 95714	Form C: 95414
PS 3/8 x 19	65	28	14.0	11.0	Form C 35°: 95718	Form C: 95418
PS 1/2 x 14	80	35	18.0	14.0	Form C 35°: 95722	Form C: 95422
PS 3/4 x 14	85	35	23.0	17.0	Form C 35°: 95730	Form C: 95430
PS 1" x 11	95	45	26.0	21.0	Form C 35°: 95738	Form C: 95438
PS 1.1/4 x 11	105	45	32.0	26.0	Form C 35°: 95746	Form C: 95446
PS 1.1/2 x 11	110	45	38.0	29.0	Form C 35°: 95754	Form C: 95454
PS 2" x 11	120	50	46.0	35.0	Form C 35°: 95770	Form C: 95470



PG



Armoured tube thread DIN 40 430

Short machine taps for armoured tube threads (PG-threads). Taps especially suitable for non abrasive materials up to 900 N/mm².

- PG Short machine tap acc. to DIN 40432
- Taps for thread cutting by hand and machine
- unalloyed and low alloyed steel

Armoured tube threads PG 7 - PG 48



Short machine taps

DIN 40432 Form D HSS-G - PG

Type of thread: armoured tube thread DIN 40 430

Variants (10):

Application/for general use:

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

D		L1	L2	D2	Square	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



NPT



American tapered pipe thread, taper 1:16 (NPT)

Short machine taps for NPT american tapered pipe thread. Taps especially suitable for non abrasive materials up to 900 N/mm².

- NPT Short machine taps for unalloyed and low alloyed steel
- Taps for thread cutting by hand and machine

Application

- Form C: for through and blind holes
- Form B: for through holes
- Form C with 35° spiral flute: for blind holes

American, tapered pipe thread NPT 1/16 - NPT 2"



Short machine taps

Form C HSS-G - NPT

Type of thread: american tapered pipe thread, taper 1:16

Variants (10):

Application/for general use:

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

D		L1	L2	D2	Square	Art.-No.
NPT	1/16 x 27	65	19	7.0	5.5	63510
NPT	1/8 x 27	65	19	7.0	5.5	63512
NPT	1/4 x 18	70	25	11.0	9.0	63514
NPT	3/8 x 18	75	26	12.0	9.0	63516
NPT	1/2 x 14	80	31	16.0	12.0	63518
NPT	3/4 x 14	100	33	20.0	16.0	63522
NPT	1" x 11.5	110	38	25.0	20.0	63526
NPT	1.1/4 x 11.5	125	41	32.0	24.0	63534
NPT	1.1/2 x 11.5	140	42	36.0	29.0	63542
NPT	2" x 11.5	160	44	36.0	29.0	63554



Short machine taps

Form C 35°RSP HSS-G - NPT + Form B HSS-G - NPT

Type of thread: american tapered pipe thread, taper 1:16

Variants (10 + 10):

Application/for general use:

- › non abrasive material up to 900 N/mm²
- › unalloyed and low alloyed steel
- › for thread cutting by hand and machine
- › Form C 35° for blind holes
- › Form B for through holes

D		L1	L2	D2	Square	Art.-No.	Art.-No.
NPT	1/16 x 27	65	19	7.0	5.5	Form C: 98702	Form B: 98502
NPT	1/8 x 27	65	19	7.0	5.5	Form C: 98706	Form B: 98506
NPT	1/4 x 18	70	25	11.0	9.0	Form C: 98714	Form B: 98514
NPT	3/8 x 18	75	26	12.0	9.0	Form C: 98718	Form B: 98518
NPT	1/2 x 14	80	31	16.0	12.0	Form C: 98722	Form B: 98522
NPT	3/4 x 14	100	33	20.0	16.0	Form C: 98730	Form B: 98530
NPT	1" x 11.5	110	38	25.0	20.0	Form C: 98738	Form B: 98538
NPT	1.1/4 x 11.5	125	41	32.0	24.0	Form C: 98746	Form B: 98546
NPT	1.1/2 x 11.5	140	42	36.0	29.0	Form C: 98754	Form B: 98554
NPT	2" x 11.5	160	44	36.0	29.0	Form C: 98770	Form B: 98570



NPT - Left Hand



american tapered pipe thread, taper 1:16 NPT Left Hand

Short machine taps for left-handed american tapered pipe thread (NPT LH). Taps especially suitable for non abrasive materials up to 900 N/mm².

- NPT Short machine taps for unalloyed and low alloyed steel
- Form C: for through and blind holes
- Taps for thread cutting by hand and machine

Application

- Form C: for through and blind holes
- Form B: for through holes
- Form C with 35° spiral flute: for blind holes

NPT Left-handed thread NPT 1/8 LH - NPT 1.1/2" LH



Short machine taps, left hand

Form C HSS-G - NPT LH

Type of thread: american tapered pipe thread, taper 1:16

Variants (8):

Application/for general use:

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

D		L1	L2	D2	Square	Art.-No.
NPT	1/8 x 27	65	19	7.0	5.5	63002
NPT	1/4 x 18	70	25	11.0	9.0	63003
NPT	3/8 x 18	75	26	12.0	9.0	63004
NPT	1/2 x 14	80	31	16.0	12.0	63005
NPT	3/4 x 14	100	33	20.0	16.0	63007
NPT	1" x 11.5	110	38	25.0	20.0	63009
NPT	1.1/4 x 11.5	125	41	32.0	24.0	63011
NPT	1.1/2 x 11.5	140	42	36.0	29.0	63013



NPTF



american tapered pipe thread, taper 1:16 (NPTF)

Short machine taps for NPTF american tapered pipe thread. Taps especially suitable for non abrasive materials up to 900 N/mm².

- NPTF Short machine taps for unalloyed and low alloyed steel
- Taps for thread cutting by hand and machine

Application

- Form B: for through holes
- Form C with 35° spiral flute: for blind holes

American, tapered pipe thread NPTF 1/16 - NPTF 2"



Short machine taps

Form B HSS-E - NPTF + Form C 35°RSP HSS-E - NPTF

Type of thread: american tapered pipe thread, taper 1:16

Variants (10 + 6):

Application/for general use:

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for thread cutting by hand and machine
- Form B for through holes
- Form C 35° for blind holes

D		L1	L2	D2	Square	Art.-No.	Art.-No.
NPTF	1/16 x 27	55	19	6.5	5.0	Form B: 98571	-
NPTF	1/8 x 27	55	19	8.0	6.0	Form B: 98572	Form C 35° 98772
NPTF	1/4 x 18	62	28	11.0	9.0	Form B: 98574	Form C 35° 98774
NPTF	3/8 x 18	65	28	14.0	11.0	Form B: 98576	Form C 35° 98776
NPTF	1/2 x 14	80	35	18.0	14.0	Form B: 98578	Form C 35° 98778
NPTF	3/4 x 14	85	35	23.0	17.0	Form B: 98580	Form C 35° 98780
NPTF	1" x 11.5	95	45	26.0	21.0	Form B: 98582	Form C 35° 98782
NPTF	1.1/4 x 11.5	105	45	32.0	26.0	Form B: 98584	-
NPTF	1.1/2 x 11.5	110	45	38.0	29.0	Form B: 98586	-
NPTF	2" x 11.5	120	50	46.0	35.0	Form B: 98588	-



NPS



American tapered pipe thread, cylindrical (NPS)

Short machine taps for NPS cylindrical american tapered pipe thread. Taps especially suitable for non abrasive materials up to 900 N/mm².

- NPS Short machine taps for unalloyed and low alloyed steel
- Taps for thread cutting by hand and machine

Application

- Form C: for through and blind holes
- Form C with 35° spiral flute: for blind holes

American, cylindrical tapered pipe thread NPS 1/16 - NPS 2"



Short machine taps

Form C 35°RSP HSS-E - NPS + Form C HSS-E - NPS

Type of thread: american tapered pipe thread

Variants (10 + 10):

Application/for general use:

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for thread cutting by hand and machine
- Form C 35° for blind holes
- Form C for through and blind holes

D		L1	L2	D2	Square	Art.-No.	Art.-No.
NPS	1/16 x 27	54	17.5	8.0	6.0	Form C 35° 99702	Form C: 99402
NPS	1/8 x 27	55	19.0	8.0	6.0	Form C 35° 99706	Form C: 99406
NPS	1/4 x 18	62	28.0	11.0	9.0	Form C 35° 99714	Form C: 99414
NPS	3/8 x 18	65	28.0	14.0	11.0	Form C 35° 99718	Form C: 99418
NPS	1/2 x 14	80	35.0	18.0	14.0	Form C 35° 99722	Form C: 99422
NPS	3/4 x 14	85	35.0	23.0	17.0	Form C 35° 99730	Form C: 99430
NPS	1" x 11.5	95	45.0	26.0	21.0	Form C 35° 99738	Form C: 99438
NPS	1.1/4 x 11.5	105	45.0	32.0	26.0	Form C 35° 99746	Form C: 99446
NPS	1.1/2 x 11.5	110	45.0	38.0	29.0	Form C 35° 99754	Form C: 99454
NPS	2" x 11.5	120	50.0	46.0	35.0	Form C 35° 99770	Form C: 99470



Bit-Edition · HexTap · TriBit



Bit-Edition - Hextap - TriBit



for quick drilling, countersinking and threading

- HexTap S and HexTap DS Multi-Drive
- Combined threading-bit with 1/4" hexagon drive
- TriBit All-in-One Box
- Twist drill bits for wood and metal
- Countersink bits 90° with 1/4" hexagon drive

HexTap - TriBit



Threading-Bit 1/4" HexTap S

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. 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.

Multi-Drive Tap HexTap DS

These are special hand taps with two-in-one pre-tap and final cutter. This tool developed by Völkel is particularly suitable for difficult to access areas and for recutting or repairing damaged threads.

This tap can be driven from both ends with a ratchet or offset screwdriver, or at the middle part consisting of an external hex, again using an open-ended spanner.

VÖLKE TriBit²

One Bit-box for all occasions. The box includes a twist drill bit, combined threading bit, HexTap S short machine tap bit and a countersink bit with 1/4" hexagon drive.



HexTap - Double ended tap, Multi-Drive (sets)

Type of thread	Tolerance	Material	Packing
metric ISO thread DIN 13	ISO 2 /6H	HSS-G	in wooden case

All HexTap S and HexTap DS threading tools can also be ordered separately.

Application/for general use:

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

Advantages:

- › 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
- › Hexagon Hole for Ratchet or Hexagon Keys
- › External Hexagon for Open-End Wrench
- › in high quality wooden case

Contents:

	Art. -No.	99920 set of 13 pcs. M 3 - M 24	48601 set of 11 pcs. M 3 - M 20	48602 set of 13 pcs. M 3 - M 24	48603 set of 15 pcs. M 3 - M 30
1x Threading-Bit 1/4" HexTap S M 3	67026	x	x	x	x
1x Threading-Bit 1/4" HexTap S M 4	67030	x	x	x	x
1x Threading-Bit 1/4" HexTap S M 5	67034	x	x	x	x
1x Threading-Bit 1/4" HexTap S M 6	67038	x	x	x	x
1x Threading-Bit 1/4" HexTap S M 8	67042	x	x	x	x
1x Threading-Bit 1/4" HexTap S M 10	67046	x	x	x	x
1x Double Ended Tap, Multi-Drive HexTap DS M 12	67050	x	x	x	x
1x Double Ended Tap, Multi-Drive HexTap DS M 14	67051	x	x	x	x
1x Double Ended Tap, Multi-Drive HexTap DS M 16	67052	x	x	x	x
1x Double Ended Tap, Multi-Drive HexTap DS M 18	67053	x	x	x	x
1x Double Ended Tap, Multi-Drive HexTap DS M 20	67054	x	x	x	x
1x Double Ended Tap, Multi-Drive HexTap DS M 22	67055	x		x	x
1x Double Ended Tap, Multi-Drive HexTap DS M 24	67056	x		x	x
1x Double Ended Tap, Multi-Drive HexTap DS M 27	67057				x
1x Double Ended Tap, Multi-Drive HexTap DS M 30	67058				x
Cobit bits, set of 26 pcs.			x		



HexTap - Double ended tap, Multi-Drive (sets)

Type of thread	Tolerance	Material	Packing
metric ISO thread DIN 13	ISO 2 /6H	HSS-G	in wooden case

Contents:	Art. -No.	48605	48606
		set of 13 pcs. M 4x0.5 - M 20x1.5	set of 15 pcs. M 4x0.5 - M 24x1.5
1x Threading-Bit 1/4" HexTap S M 4x0,5	67703	x	x
1x Threading-Bit 1/4" HexTap S M 5x0,5	67705	x	x
1x Threading-Bit 1/4" HexTap S M 6x0,75	67709	x	x
1x Threading-Bit 1/4" HexTap S M 8x0,75	67713	x	x
1x Threading-Bit 1/4" HexTap S M 8x1	67714	x	x
1x Threading-Bit 1/4" HexTap S M 10x1	67720	x	x
1x Double Ended Tap, Multi-Drive HexTap DS M 12x1	67727	x	x
1x Double Ended Tap, Multi-Drive HexTap DS M 12x1,5	67729	x	x
1x Double Ended Tap, Multi-Drive HexTap DS M 14x1,25	67737	x	x
1x Double Ended Tap, Multi-Drive HexTap DS M 14x1,5	67738	x	x
1x Double Ended Tap, Multi-Drive HexTap DS M 16x1,5	67746	x	x
1x Double Ended Tap, Multi-Drive HexTap DS M 18x1,5	67753	x	x
1x Double Ended Tap, Multi-Drive HexTap DS M 20x1,5	67761	x	x
1x Double Ended Tap, Multi-Drive HexTap DS M 22x1,5	67769		x
1x Double Ended Tap, Multi-Drive HexTap DS M 24x1,5	67777		x

HexTap - Double ended tap, Multi-Drive (sets)

Type of thread	Material	Packing
Pipe-thread DIN ISO 228	HSS-G	in wooden case

Contents:	Art. -No.	48608	48609
		set of 6 pcs. G (BSP) 1/8 - 1"	set of 8 pcs. G (BSP) 1/8 - 1.1/2
1x Threading-Bit 1/4" HexTap S G (BSP) 1/8	67870	x	x
1x Double Ended Tap, Multi-Drive HexTap DS G (BSP) 1/4	67871	x	x
1x Double Ended Tap, Multi-Drive HexTap DS G (BSP) 3/8	67872	x	x
1x Double Ended Tap, Multi-Drive HexTap DS G (BSP) 1/2	67873	x	x
1x Double Ended Tap, Multi-Drive HexTap DS G (BSP) 3/4	67874	x	x
1x Double Ended Tap, Multi-Drive HexTap DS G (BSP) 1"	67875	x	x
1x Double Ended Tap, Multi-Drive HexTap DS G (BSP) 1.1/4	67876		x
1x Double Ended Tap, Multi-Drive HexTap DS G (BSP) 1.1/2	67877		x



HexTap - Double ended tap + round dies (sets)

Type of thread	Tolerance	Material	Packing
metric ISO thread DIN 13	ISO 2 /6H	HSS-G	in wooden case

All HexTap S and HexTap DS threading tools can also be ordered separately.

Application/for general use:

- › non abrasive material up to 800 N/mm²
- › unalloyed and low alloyed steel
- › for through and blind holes
- › for thread cutting by hand
- › Round dies acc. to DIN 223 (DIN EN 22568)

Advantages:

- › 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
- › Hexagon Hole for Ratchet or Hexagon Keys
- › External Hexagon for Open-End Wrench
- › in high quality wooden case

Contents:	Art.-No.	48621	48622	48623
		set of 22 pcs. M 3 - M 20	set of 26 pcs. M 3 - M 24	set of 30 pcs. M 3 - M 30
1x Threading-Bit 1/4" HexTap S M 3	67026	x	x	x
1x Threading-Bit 1/4" HexTap S M 4	67030	x	x	x
1x Threading-Bit 1/4" HexTap S M 5	67034	x	x	x
1x Threading-Bit 1/4" HexTap S M 6	67038	x	x	x
1x Threading-Bit 1/4" HexTap S M 8	67042	x	x	x
1x Threading-Bit 1/4" HexTap S M 10	67046	x	x	x
1x Double Ended Tap, Multi-Drive HexTap DS M 12	67050	x	x	x
1x Double Ended Tap, Multi-Drive HexTap DS M 14	67051	x	x	x
1x Double Ended Tap, Multi-Drive HexTap DS M 16	67052	x	x	x
1x Double Ended Tap, Multi-Drive HexTap DS M 18	67053	x	x	x
1x Double Ended Tap, Multi-Drive HexTap DS M 20	67054	x	x	x
1x Double Ended Tap, Multi-Drive HexTap DS M 22	67055		x	x
1x Double Ended Tap, Multi-Drive HexTap DS M 24	67056		x	x
1x Double Ended Tap, Multi-Drive HexTap DS M 27	67057			x
1x Double Ended Tap, Multi-Drive HexTap DS M 30	67058			x

HSS Round dies	Art.-No.	48621	48622	48623	HSS Round dies	Art.-No.	48621	48622	48623
		set of 22 pcs. M 3 - M 20	set of 26 pcs. M 3 - M 24	set of 30 pcs. M 3 - M 30			set of 22 pcs. M 3 - M 20	set of 26 pcs. M 3 - M 24	set of 30 pcs. M 3 - M 30
1x M 3	27426	x	x	x	1x M 16	27458	x	x	x
1x M 4	27430	x	x	x	1x M 18	27462	x	x	x
1x M 5	27434	x	x	x	1x M 20	27466	x	x	x
1x M 6	27438	x	x	x	1x M 22	27470		x	x
1x M 8	27442	x	x	x	1x M 24	27474		x	x
1x M 10	27446	x	x	x	1x M 27	27476			x
1x M 12	27450	x	x	x	1x M 30	27478			x
1x M 14	27454	x	x	x					



HexTap - Double ended tap + round dies (sets)

Type of thread	Tolerance	Material	Packing
metric-fine ISO-thread DIN 13	ISO 2 /6H	HSS-G	in wooden case

Contents:	Art. -No.	48625	48626
		set of 26 pcs. M 4x0.5 - M 20x1.5	set of 30 pcs. M 4x0.5 - M 24x1.5
1x Threading-Bit 1/4" HexTap S M 4x0,5	67703	x	x
1x Threading-Bit 1/4" HexTap S M 5x0,5	67705	x	x
1x Threading-Bit 1/4" HexTap S M 6x0,75	67709	x	x
1x Threading-Bit 1/4" HexTap S M 8x0,75	67713	x	x
1x Threading-Bit 1/4" HexTap S M 8x1	67714	x	x
1x Threading-Bit 1/4" HexTap S M 10x1	67720	x	x
1x Double Ended Tap, Multi-Drive HexTap DS M 12x1	67727	x	x
1x Double Ended Tap, Multi-Drive HexTap DS M 12x1,5	67729	x	x
1x Double Ended Tap, Multi-Drive HexTap DS M 14x1,25	67737	x	x
1x Double Ended Tap, Multi-Drive HexTap DS M 14x1,5	67738	x	x
1x Double Ended Tap, Multi-Drive HexTap DS M 16x1,5	67746	x	x
1x Double Ended Tap, Multi-Drive HexTap DS M 18x1,5	67753	x	x
1x Double Ended Tap, Multi-Drive HexTap DS M 20x1,5	67761	x	x
1x Double Ended Tap, Multi-Drive HexTap DS M 22x1,5	67769		x
1x Double Ended Tap, Multi-Drive HexTap DS M 24x1,5	67777		x
1x HSS Round die M 4x0,5	26412	x	x
1x HSS Round die M 5x0,5	26414	x	x
1x HSS Round die M 6x0,75	26418	x	x
1x HSS Round die M 8x0,75	26424	x	x
1x HSS Round die M 8x1	26426	x	x
1x HSS Round die M 10x1	26436	x	x
1x HSS Round die M 12x1	26444	x	x
1x HSS Round die M 12x1,5	26448	x	x
1x HSS Round die M 14x1,25	26454	x	x
1x HSS Round die M 14x1,5	26456	x	x
1x HSS Round die M 16x1,5	26466	x	x
1x HSS Round die M 18x1,5	26472	x	x
1x HSS Round die M 20x1,5	26484	x	x
1x HSS Round die M 22x1,5	26494		x
1x HSS Round die M 24x1,5	26604		x



HexTap - Double ended tap + round dies (sets)

Type of thread	Material	Packing
Pipe-thread DIN ISO 228	HSS-G	in wooden case

Contents:	Art. -No.	48628	48629
		set of 12 pcs. G (BSP) 1/8 - 1"	set of 16 pcs. G (BSP) 1/8 - 1.1/2
1x Threading-Bit 1/4" HexTap S G (BSP) 1/8	67870	x	x
1x Double Ended Tap, Multi-Drive HexTap DS G (BSP) 1/4	67871	x	x
1x Double Ended Tap, Multi-Drive HexTap DS G (BSP) 3/8	67872	x	x
1x Double Ended Tap, Multi-Drive HexTap DS G (BSP) 1/2	67873	x	x
1x Double Ended Tap, Multi-Drive HexTap DS G (BSP) 3/4	67874	x	x
1x Double Ended Tap, Multi-Drive HexTap DS G (BSP) 1"	67875	x	x
1x Double Ended Tap, Multi-Drive HexTap DS G (BSP) 1.1/4	67876		x
1x Double Ended Tap, Multi-Drive HexTap DS G (BSP) 1.1/2	67877		x
1x HSS Round die G (BSP) 1/8	25412	x	x
1x HSS Round die G (BSP) 1/4	25414	x	x
1x HSS Round die G (BSP) 3/8	25416	x	x
1x HSS Round die G (BSP) 1/2	25418	x	x
1x HSS Round die G (BSP) 3/4	25422	x	x
1x HSS Round die G (BSP) 1"	25426	x	x
1x HSS Round die G (BSP) 1.1/4	25434		x
1x HSS Round die G (BSP) 1.1/2	25442		x



HexTap - Double ended tap + hexagon die nuts (sets)

Type of thread	Tolerance	Material	Packing
metric ISO thread DIN 13	ISO 2 /6H	HSS-G	in wooden case

Unique threading tool set which can be completely operated without maintenance tools only with standard hand tools. For cleaning and repairing damaged threads, and for general use in awkward places. For general use.

All HexTap S and HexTap DS threading tools can also be ordered separately.

Application/ for general use:

- › non abrasive material up to 900 N/mm²
- › unalloyed and low alloyed steel
- › for through and blind holes
- › for thread cutting by hand*
- › Hexagon die nuts acc. to DIN 382**

Advantages:

- › 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
- › Hexagon Hole for Ratchet or Hexagon Keys
- › External Hexagon for Open-End Wrench
- › in high quality wooden case

Contents:

	Art. -No.	48641** set of 22 pcs. M 3 - M 20	48642*/** set of 26 pcs. M 3 - M 24	48643*/** set of 30 pcs. M 3 - M 30
1x Threading-Bit 1/4" HexTap S M 3	67026	x	x	x
1x Threading-Bit 1/4" HexTap S M 4	67030	x	x	x
1x Threading-Bit 1/4" HexTap S M 5	67034	x	x	x
1x Threading-Bit 1/4" HexTap S M 6	67038	x	x	x
1x Threading-Bit 1/4" HexTap S M 8	67042	x	x	x
1x Threading-Bit 1/4" HexTap S M 10	67046	x	x	x
1x Double Ended Tap, Multi-Drive HexTap DS M 12	67050	x	x	x
1x Double Ended Tap, Multi-Drive HexTap DS M 14	67051	x	x	x
1x Double Ended Tap, Multi-Drive HexTap DS M 16	67052	x	x	x
1x Double Ended Tap, Multi-Drive HexTap DS M 18	67053	x	x	x
1x Double Ended Tap, Multi-Drive HexTap DS M 20	67054	x	x	x
1x Double Ended Tap, Multi-Drive HexTap DS M 22	67055		x	x
1x Double Ended Tap, Multi-Drive HexTap DS M 24	67056		x	x
1x Double Ended Tap, Multi-Drive HexTap DS M 27	67057			x
1x Double Ended Tap, Multi-Drive HexTap DS M 30	67058			x

HSS Hex. die nut	Art.- No.	48641** set of 22 pcs. M 3 - M 20	48642*/** set of 26 pcs. M 3 - M 24	48643*/** set of 30 pcs. M 3 - M 30	HSS Hex. die nut	Art.- No.	48641** set of 22 pcs. M 3 - M 20	48642*/** set of 26 pcs. M 3 - M 24	48643*/** set of 30 pcs. M 3 - M 30
1x M 3	27126	x	x	x	1x M 16	27158	x	x	x
1x M 4	27130	x	x	x	1x M 18	27162	x	x	x
1x M 5	27134	x	x	x	1x M 20	27166	x	x	x
1x M 6	27138	x	x	x	1x M 22	27170		x	x
1x M 8	27142	x	x	x	1x M 24	27174		x	x
1x M 10	27146	x	x	x	1x M 27	27176			x
1x M 12	27150	x	x	x	1x M 30	27178			x
1x M 14	27154	x	x	x					



HexTap - Double ended tap + hexagon die nuts (sets)

Type of thread	Tolerance	Material	Packing
metric-fine ISO-thread DIN 13	ISO 2 /6H	HSS-G	in wooden case

Contents:	Art. -No.	48645*	48646*
		set of 26 pcs. M 4x0.5 - M 20x1.5	set of 30 pcs. M 4x0.5 - M 24x1.5
1x Threading-Bit 1/4" HexTap S M 4x0,5	67703	x	x
1x Threading-Bit 1/4" HexTap S M 5x0,5	67705	x	x
1x Threading-Bit 1/4" HexTap S M 6x0,75	67709	x	x
1x Threading-Bit 1/4" HexTap S M 8x0,75	67713	x	x
1x Threading-Bit 1/4" HexTap S M 8x1	67714	x	x
1x Threading-Bit 1/4" HexTap S M 10x1	67720	x	x
1x Double Ended Tap, Multi-Drive HexTap DS M 12x1	67727	x	x
1x Double Ended Tap, Multi-Drive HexTap DS M 12x1,5	67729	x	x
1x Double Ended Tap, Multi-Drive HexTap DS M 14x1,25	67737	x	x
1x Double Ended Tap, Multi-Drive HexTap DS M 14x1,5	67738	x	x
1x Double Ended Tap, Multi-Drive HexTap DS M 16x1,5	67746	x	x
1x Double Ended Tap, Multi-Drive HexTap DS M 18x1,5	67753	x	x
1x Double Ended Tap, Multi-Drive HexTap DS M 20x1,5	67761	x	x
1x Double Ended Tap, Multi-Drive HexTap DS M 22x1,5	67769		x
1x Double Ended Tap, Multi-Drive HexTap DS M 24x1,5	67777		x
1x HSS Hexagon die nut M 4x0,5	26112	x	x
1x HSS Hexagon die nut M 5x0,5	26114	x	x
1x HSS Hexagon die nut M 6x0,75	26118	x	x
1x HSS Hexagon die nut M 8x0,75	26124	x	x
1x HSS Hexagon die nut M 8x1	26126	x	x
1x HSS Hexagon die nut M 10x1	26136	x	x
1x HSS Hexagon die nut M 12x1	26144	x	x
1x HSS Hexagon die nut M 12x1,5	26148	x	x
1x HSS Hexagon die nut M 14x1,25	26154	x	x
1x HSS Hexagon die nut M 14x1,5	26156	x	x
1x HSS Hexagon die nut M 16x1,5	26166	x	x
1x HSS Hexagon die nut M 18x1,5	26172	x	x
1x HSS Hexagon die nut M 20x1,5	26184	x	x
1x HSS Hexagon die nut M 22x1,5	26194		x
1x HSS Hexagon die nut M 24x1,5	26704		x



HexTap - Double ended tap + hexagon die nuts (sets)

Type of thread	Material	Packing
Pipe-thread DIN ISO 228	HSS-G	in wooden case

Contents:	Art. -No.	48648* set of 12 pcs. G (BSP) 1/8 - 1"		48649* set of 16 pcs. G (BSP) 1/8 - 1.1/2	
1x Threading-Bit 1/4" HexTap S G (BSP) 1/8	67870	x		x	
1x Double Ended Tap, Multi-Drive HexTap DS G (BSP) 1/4	67871	x		x	
1x Double Ended Tap, Multi-Drive HexTap DS G (BSP) 3/8	67872	x		x	
1x Double Ended Tap, Multi-Drive HexTap DS G (BSP) 1/2	67873	x		x	
1x Double Ended Tap, Multi-Drive HexTap DS G (BSP) 3/4	67874	x		x	
1x Double Ended Tap, Multi-Drive HexTap DS G (BSP) 1"	67875	x		x	
1x Double Ended Tap, Multi-Drive HexTap DS G (BSP) 1.1/4	67876				x
1x Double Ended Tap, Multi-Drive HexTap DS G (BSP) 1.1/2	67877				x
1x HSS Hexagon die nut G (BSP) 1/8	25512	x		x	
1x HSS Hexagon die nut G (BSP) 1/4	25514	x		x	
1x HSS Hexagon die nut G (BSP) 3/8	25516	x		x	
1x HSS Hexagon die nut G (BSP) 1/2	25518	x		x	
1x HSS Hexagon die nut G (BSP) 3/4	25522	x		x	
1x HSS Hexagon die nut G (BSP) 1"	25526	x		x	
1x HSS Hexagon die nut G (BSP) 1.1/4	25534				x
1x HSS Hexagon die nut G (BSP) 1.1/2	25542				x



Threading-bits (set of 6 pcs.) M 3 - M 10 (67010)

Type of thread	Tolerance	Material	Packing	Size
metric ISO thread DIN 13	ISO 2 /6H	HSS-G	in plastic case	Diameter M 3 - 10

Contents:

Contents:	Art. -No.	Contents:	Art. -No.
1x HexTap S Tap bit, HSS-G, M 3	67026	1x HexTap S Tap bit, HSS-G, M 6	67038
1x HexTap S Tap bit, HSS-G, M 4	67030	1x HexTap S Tap bit, HSS-G, M 8	67042
1x HexTap S Tap bit, HSS-G, M 5	67034	1x HexTap S Tap bit, HSS-G, M 10	67046



Threading-bits (set of 12 pcs.) (67020)

incl. drill bits + cobit IMPACT bits, set of 7 pcs. BT7Neo

Type of thread	Tolerance	Material	Packing	Size
metric ISO thread DIN 13	ISO 2 /6H	HSS-G	in plastic case	Diameter M 3 - 10

Contents:

Contents:	Art. -No.	Contents:	Art. -No.
1x HexTap S Tap bit, HSS-G, M 3	67026	1x Drill bits, HSS-G, 2,5 (M3)	67125
1x HexTap S Tap bit, HSS-G, M 4	67030	1x Drill bits, HSS-G, 3,3 (M4)	67133
1x HexTap S Tap bit, HSS-G, M 5	67034	1x Drill bits, HSS-G, 4,2 (M5)	67142
1x HexTap S Tap bit, HSS-G, M 6	67038	1x Drill bits, HSS-G, 5,0 (M6)	67150
1x HexTap S Tap bit, HSS-G, M 8	67042	1x Drill bits, HSS-G, 6,8 (M8)	67168
1x HexTap S Tap bit, HSS-G, M 10	67046	1x Drill bits, HSS-G, 8,5 (M10)	67185



Q.C.2 Short machine taps (Bit-set of 8 pcs.) (67422)

M 3 - M 10

Type of thread	Tolerance	Material	Packing	Size
metric ISO thread DIN 13	ISO 2 /6H	HSS-G	in plastic case	Diameter M 3 - 10

Contents:

Contents:	Art. -No.	Contents:	Art. -No.
1x HexTap S Tap bit, HSS-G, M 3	67026	1x HexTap S Tap bit, HSS-G, M 6	67038
1x HexTap S Tap bit, HSS-G, M 4	67030	1x HexTap S Tap bit, HSS-G, M 8	67042
1x HexTap S Tap bit, HSS-G, M 5	67034	1x HexTap S Tap bit, HSS-G, M 10	67046



TriBit² Combined threading-bit set HSS-G - M

Type of thread	Tolerance	Material	Packing	Size
metric ISO thread DIN 13	ISO 2 /6H	HSS-G	in plastic case	Diameter M 3 - 10

One set for all applications Drilling, Tapping, Deburring Combined and specific tools
with HexTap S, Twist Drill-, Countersink- and Combined Bit

Contents:	67403 M 3 x 0.5	67404 M 4 x 0.7	67405 M 5 x 0.8	67406 M 6 x 1.0	67408 M 8 x 1.25	67410 M 10 x 1.5
1x HexTap S Tap bit	M 3 (67026)	M 4 (67030)	M 5 (67034)	M 6 (67038)	M 8 (67042)	M 10 (67046)
1x Drill bits	2.5 mm (67125)	3.3 mm (67133)	4.2 mm (67142)	5.0 mm (67150)	6.8 mm (67168)	8.5 mm (67185)
1x Combined Bits	M 3 (67226)	M 4 (67230)	M 5 (67234)	M 6 (67238)	M 8 (67242)	M 10 (67246)
1x Countersink-Bits	6.3 mm (67306)	8.3 mm (67308)	10.4 mm (67310)	12.4 mm (67312)	16.5 mm (67316)	20.5 mm (67320)



HexTap S Threading-bit HSS-G - M

Type of thread: metric ISO-thread DIN 13	Tolerance: ISO 2 /6H	Width across flat (SW1): 1/4" inch
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Variants (11):

Size, D	Typ	L1	L2	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 HSS-G - M

Type of thread: metric ISO-thread DIN 13
Tolerance: ISO 2 /6H

Variants (17):

Application/for general use:

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

Advantages:

- › 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
- › Hexagon Hole for Ratchet or Hexagon Keys
- › External Hexagon for Open-End Wrench

Size, D	Typ	L1	L2	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 HSS-G - Mf

Type of thread: metric-fine ISO-thread DIN 13
Tolerance: ISO 2 /6H

Variants (22):

Size, D	Typ	L1	L2	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 4x 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 HSS-G - Mf

Type of thread: metric-fine ISO-thread DIN 13
Tolerance: ISO 2 /6H

Variants (125):

Application/for general use:

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

Advantages:

- 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
- Hexagon Hole for Ratchet or Hexagon Keys
- External Hexagon for Open-End Wrench

Size, D	Typ	L1	L4	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



Size, D	Typ	L1	L4	SW1	SW2	Art.-No.
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
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



Size, D	Typ	L1	L4	SW1	SW2	Art.-No.
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
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



Size, D	Typ	L1	L4	SW1	SW2	Art.-No.
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 DS Double ended tap, Multi-Drive HSS-G - G (BSP)

Type of thread:
Pipe-thread DIN ISO 228

Variants (8):

Application/for general use:

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

Advantages:

- › 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
- › Hexagon Hole for Ratchet or Hexagon Keys
- › External Hexagon for Open-End Wrench

Size, D	Typ	L1	L4	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



HexTap S Tap bit HSS-G - G (BSP) 1/8

Type of thread:
Pipe-thread DIN ISO 228

Size, D	Typ	L1	L4	SW1	Art.-No.
G 1/8	S	40.5	17	1/4"	67870



HexTap DS Double ended tap, Multi-Drive HSS-G - UN

Type of thread:
Unified thread ANSI B 1.1

Variants (9):

Application/for general use:

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

Advantages:

- › 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
- › Hexagon Hole for Ratchet or Hexagon Keys
- › External Hexagon for Open-End Wrench

Size, D	Typ	L1	L4	SW1	SW2	Art.-No.
UN 1" x 8						67901
UN 1.1/8 x 8						67902
UN 1.1/4 x 8						67903
UN 1.3/8 x 8						67904
UN 1.1/2 x 8						67905
UN 1.5/8 x 8						67906
UN 1.3/4 x 8						67907
UN 1.7/8 x 8						67908
UN 2" x 8						67909



Combined bits



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.

Application of combined threading and drill bits:

The Combined Bit is suitable for universal use in materials of medium mechanical strength, non ferrous metals and thermoplastics (up to 600 N/mm² tensile strength). It is possible with this tool to produce through threads up to a maximum threaded depth of 1xD. 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.



Combined threading and drill-bit (set of 7 pcs.) (67200)

HSS-G M 3 - M 10

Type of thread	Tolerance	Material	Packing	Size
metric ISO thread DIN 13	ISO 2 /6H	HSS-G	in plastic case	Diameter M 3 - 10

Contents:

Contents:	Art. -No.	Contents:	Art. -No.
1x Combined Bits, HSS-G, M 3 x 0,5	67226	1x Combined Bits, HSS-G, M 6 x 1,0	67238
1x Combined Bits, HSS-G, M 4 x 0,7	67230	1x Combined Bits, HSS-G, M 8 x 1,25	67242
1x Combined Bits, HSS-G, M 5 x 0,8	67234	1x Combined Bits, HSS-G, M 10 x 1,5	67246



Combined threading and drill-bit (set of 7 pcs.) (67209)

HSS-G TiN M 3 - M 10

Type of thread	Tolerance	Material	Packing	Size
metric ISO thread DIN 13	ISO 2 /6H	HSS-G	in plastic case	Diameter M 3 - 10

Contents:

Contents:	Art. -No.	Contents:	Art. -No.
1x Combined Bits, M 3 x 0,5	67210	1x Combined Bits, M 6 x 1,0	67213
1x Combined Bits, M 4 x 0,7	67211	1x Combined Bits, M 8 x 1,25	67214
1x Combined Bits, M 5 x 0,8	67212	1x Combined Bits, M 10 x 1,5	67215



Combined threading and drill-bit (set of 7 pcs.) (67272)

HSS-G UNC No. 8 - UNC 3/8

Type of thread	Tolerance	Material	Packing	Size
Unified Coarse thread ANSI B 1.1	ISO 2 /6H	HSS-G	in plastic case	Diameter M 3 - 10

Contents:	Art. -No.	Contents:	Art. -No.
1x Combined Bits, UNC No. 8 x 32	67283	1x Combined Bits, UNC 1/4 x 20	67286
1x Combined Bits, UNC No. 10 x 24	67284	1x Combined Bits, UNC 5/16 x 18	67287
1x Combined Bits, UNC No. 12 x 24	67285	1x Combined Bits, UNC 3/8 x 16	67288

Combined threading and drill-bit (set of 7 pcs.) (67274)

HSS-G UNF No. 8 - UNF 3/8

Type of thread	Material	Packing	Size
Unified Fine thread ANSI B 1.1	HSS-G	in plastic case	Diameter M 3 - 10

Contents:	Art. -No.	Contents:	Art. -No.
1x Combined Bits, UNF No. 8 x 36	67293	1x Combined Bits, UNF 1/4 x 28	67296
1x Combined Bits, UNF No. 10 x 32	67294	1x Combined Bits, UNF 5/16 x 14	67297
1x Combined Bits, UNF No. 12 x 28	67295	1x Combined Bits, UNF 3/8 x 24	67298



Q.C.1 Combined threading bits (set of 7 pcs.) (67421)

incl. holder M 3 - M 10

Type of thread	Tolerance	Material	Packing	Size
metric ISO-thread DIN 13	ISO 2 /6H	HSS-G	in plastic case	Diameter M 3 - 10

Contents:	Art. -No.	Contents:	Art. -No.
1x Combined Bits, HSS-G, M 3 x 0,5	67226	1x Combined Bits, HSS-G, M 6 x 1,0	67238
1x Combined Bits, HSS-G, M 4 x 0,7	67230	1x Combined Bits, HSS-G, M 8 x 1,25	67242
1x Combined Bits, HSS-G, M 5 x 0,8	67234	1x Combined Bits, HSS-G, M 10 x 1,5	67246



Combined Threading and drill-bits

HSS-G - M + HSS-G TiN - M

Type of thread	Tolerance	Material	Drive connector	Size
metric ISO-thread DIN 13	ISO 2 /6H	HSS-G	Hexagon 1/4" inch	Diameter M 3 - 10

Variants (8):

For Drilling, Tapping and Deburring in one operation with 1/4"-Hexagon Drive



D		D1	L1	Hex	max. RPM	Art.-No. HSS-G - M	Art.-No. HSS-G TiN - M
M	3 x 0.5	2.5	36	1/4"	1600 UpM	67226	67210
M	4 x 0.7	3.3	39	1/4"	1200 UpM	67230	67211
M	5 x 0.8	4.2	41	1/4"	950 UpM	67234	67212
M	6 x 1.0	5.0	44	1/4"	800 UpM	67238	67213
M	8 x 1.25	6.8	50	1/4"	600 UpM	67242	67214
M	10 x 1.5	8.5	59	1/4"	450 UpM	67246	67215



Combined Threading and drill-bits

HSS-G - UNC + HSS-G - UNF

Type of thread	Material
Unified Coarse thread ANSI B 1.1	HSS-G
Unified Fine thread ANSI B 1.1	

Variants (9):

For Drilling, Tapping and Deburring in one operation with 1/4"-Hexagon Drive

UNC, D	D1	L1	Hex	Art.-No.
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
UNF, D	D1	L1	Hex	Art.-No.
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



Drill bits



HSS-G Jobber drills with 1/4" hexagon drive

- Jobber drill bits for metal from 1.0 mm - 10.2 mm
- Jobber drill bits for wood from 3.0 mm - 10.0 mm

The drill bits for metal are also in-between sizes for core hole drilling for threads up to M 12 available. The drills can be ordered single or in the practical Pocket-Set.



Twist drill bits (set of 19 pcs.) 1.0 – 10.0 mm (67100)

+ cobit IMPACT bits, set of 7 pcs. BT7Neo

Type of thread	Tolerance	Material	Packing	Size
metric ISO thread DIN 13	ISO 2 /6H	HSS-G	in plastic case	Diameter M 3 - 10

Advantages:

- Drill Bit Set 1.0 – 10.0 mm, for fast, clean and efficient work
- all Twist Drill together in a handy, useful packaging
- versatile usable
- Hexagon Drive
- small and handy
- for assembly work and small batch production

Contents:	Art. -No.	Contents:	Art. -No.
1x Drill bits, HSS-G, 1,0	67110	1x Drill bits, HSS-G, 6,0	67160
1x Drill bits, HSS-G, 1,5	67115	1x Drill bits, HSS-G, 6,5	67165
1x Drill bits, HSS-G, 2,0	67120	1x Drill bits, HSS-G, 7,0	67170
1x Drill bits, HSS-G, 2,5 (M3)	67125	1x Drill bits, HSS-G, 7,5	67175
1x Drill bits, HSS-G, 3,0	67130	1x Drill bits, HSS-G, 8,0	67180
1x Drill bits, HSS-G, 3,5	67135	1x Drill bits, HSS-G, 8,5 (M10)	67185
1x Drill bits, HSS-G, 4,0	67140	1x Drill bits, HSS-G, 9,0	67190
1x Drill bits, HSS-G, 4,5	67145	1x Drill bits, HSS-G, 9,5	67195
1x Drill bits, HSS-G, 5,0 (M6)	67150	1x Drill bits, HSS-G, 10,0	67198
1x Drill bits, HSS-G, 5,5	67155		



Q.C.4 Twist drill bits (set of 19 pcs.) for metal (67424)

3.0 - 10.0 mm

Material	Packing	Size
HSS-G	in plastic case	Diameter 3,0 - 10,0 mm

Advantages:

- › Drill Bit Set 1.0 - 10.0 mm, for fast, clean and efficient work
- › all Twist Drill together in a handy, useful packaging

- › versatile usable
- › Hexagon Drive
- › small and handy
- › for assembly work and small batch production

Contents:	Art. -No.	Contents:	Art. -No.
1x Drill bits, HSS-G, 3,0	67130	1x Drill bits, HSS-G, 6,0	67160
1x Drill bits, HSS-G, 4,0	67140	1x Drill bits, HSS-G, 8,0	67180
1x Drill bits, HSS-G, 5,0 (M6)	67150	1x Drill bits, HSS-G, 10,0	67198



Q.C.5 Twist drill bits (set of 19 pcs.) for wood (67425)

3.0 - 10.0 mm

Material	Packing	Size
HSS-G	in plastic case	Diameter 3,0 - 10,0 mm

Contents:	Art. -No.	Contents:	Art. -No.
1x Wood Drill Bits, HSS-G, 3,0	67630	1x Wood Drill Bits, HSS-G, 6,0	67660
1x Wood Drill Bits, HSS-G, 4,0	67640	1x Wood Drill Bits, HSS-G, 8,0	67680
1x Wood Drill Bits, HSS-G, 5,0	67650	1x Wood Drill Bits, HSS-G, 10,0	67698



Twist drill bit-set for metal and wood (67101)

3.0 - 10.0 mm

Material	Packing	Size
HSS-G	in plastic case	Diameter 3,0 - 10,0 mm

Advantages:

- › Drill bits for the processing of wood
- › Drill Bit Set 1.0 - 10.0 mm, for fast, clean and efficient work
- › all Twist Drill together in a handy, useful packaging

- › versatile usable
- › Hexagon Drive
- › small and handy
- › for assembly work and small batch production

Contents:	Art. -No.	Contents:	Art. -No.
1x Drill bits, HSS-G, 3,0	67130	1x Wood Drill Bits, HSS-G, 3,0	67630
1x Drill bits, HSS-G, 4,0	67140	1x Wood Drill Bits, HSS-G, 4,0	67640
1x Drill bits, HSS-G, 5,0 (M6)	67150	1x Wood Drill Bits, HSS-G, 5,0	67650
1x Drill bits, HSS-G, 6,0	67160	1x Wood Drill Bits, HSS-G, 6,0	67660
1x Drill bits, HSS-G, 8,0	67180	1x Wood Drill Bits, HSS-G, 8,0	67680
1x Drill bits, HSS-G, 10,0	67198	1x Wood Drill Bits, HSS-G, 10,0	67698



Drill bits for wood HSS-G

Drive connector	Material
Hexagon 1/4" inch	HSS-G

Variants (6):

D	L1	S2	Hex	Art.-No.	D	L1	S2	Hex	Art.-No.
3.0 mm	38	16	1/4"	67630	6.0 mm	50	26	1/4"	67660
4.0 mm	44	20	1/4"	67640	8.0 mm	51	32	1/4"	67680
5.0 mm	50	26	1/4"	67650	10.0 mm	54	38	1/4"	67698



Drill bits HSS-G

Drive connector	Material
Hexagon 1/4" inch	HSS-G

Variants (23):

D	L1	S2	Hex	Art.-No.	D	L1	S2	Hex	Art.-No.
1.0 mm	32	7	1/4"	67110	6.0 mm	50	26	1/4"	67160
1.5 mm	32	10	1/4"	67115	6.5 mm	50	30	1/4"	67165
2.0 mm	34	12	1/4"	67120	6.8 mm (M8)	50	30	1/4"	67168
2.5 mm (M3)	36	14	1/4"	67125	7.0 mm	50	30	1/4"	67170
3.0 mm	38	16	1/4"	67130	7.5 mm	51	32	1/4"	67175
3.3 mm (M4)	40	18	1/4"	67133	8.0 mm	51	32	1/4"	67180
3.5 mm	40	18	1/4"	67135	8.5 mm (M10)	53	33	1/4"	67185
4.0 mm	44	20	1/4"	67140	9.0 mm	53	33	1/4"	67190
4.2 mm (M5)	45	20	1/4"	67142	9.5 mm	54	38	1/4"	67195
4.5 mm	46	24	1/4"	67145	10.0 mm	54	38	1/4"	67198
5.0 mm (M6)	50	26	1/4"	67150	10.2 mm (M12)	54	38	1/4"	67199
5.5 mm	50	26	1/4"	67155					



Countersink bits 90°



HSS Countersink 90° with 1/4" hexagon drive

Countersink and deburring tool with 3 flutes suitable for either metal or synthetic materials.

Manufactured with 1/4" hexagonal shank for direct use in standard chuck, cordless drills or through a magnetic bit holder.

The countersinks can be ordered single or in the practical Pocket-Set.



Countersink-bits 90° (set of 6 pcs.) (67300)

6.3 - 20.5 mm

Material	Packing	Size
HSS-G	in plastic case	Diameter 6,3 - 20,5 mm

Advantages:

- the complete Countersink Bit Set for fast, clean and efficient work
- all countersink bits all together in a handy and usefull plastic packaging
- To be used by hand or cordless powertool
- versatile usable
- Hexagon Drive
- small and handy
- for assembly work and small batch production

Contents:	Art. -No.	Contents:	Art. -No.
1x Countersink-Bits, HSS-G, 6,3	67306	1x Countersink-Bits, HSS-G, 12,4	67312
1x Countersink-Bits, HSS-G, 8,3	67308	1x Countersink-Bits, HSS-G, 16,5	67316
1x Countersink-Bits, HSS-G, 10,4	67310	1x Countersink-Bits, HSS-G, 20,5	67320



Q.C.3 Countersink-bits 90° (set of 8 pcs.) (67423)

6.3 - 20.5 mm

Material	Packing	Size
HSS-G	in plastic case	Diameter 6,3 - 20,5 mm

Contents:	Art. -No.	Contents:	Art. -No.
1x Countersink-Bits, HSS-G, 6,3	67306	1x Countersink-Bits, HSS-G, 12,4	67312
1x Countersink-Bits, HSS-G, 8,3	67308	1x Countersink-Bits, HSS-G, 16,5	67316
1x Countersink-Bits, HSS-G, 10,4	67310	1x Countersink-Bits, HSS-G, 20,5	67320



Countersink-bits 90° HSS-G

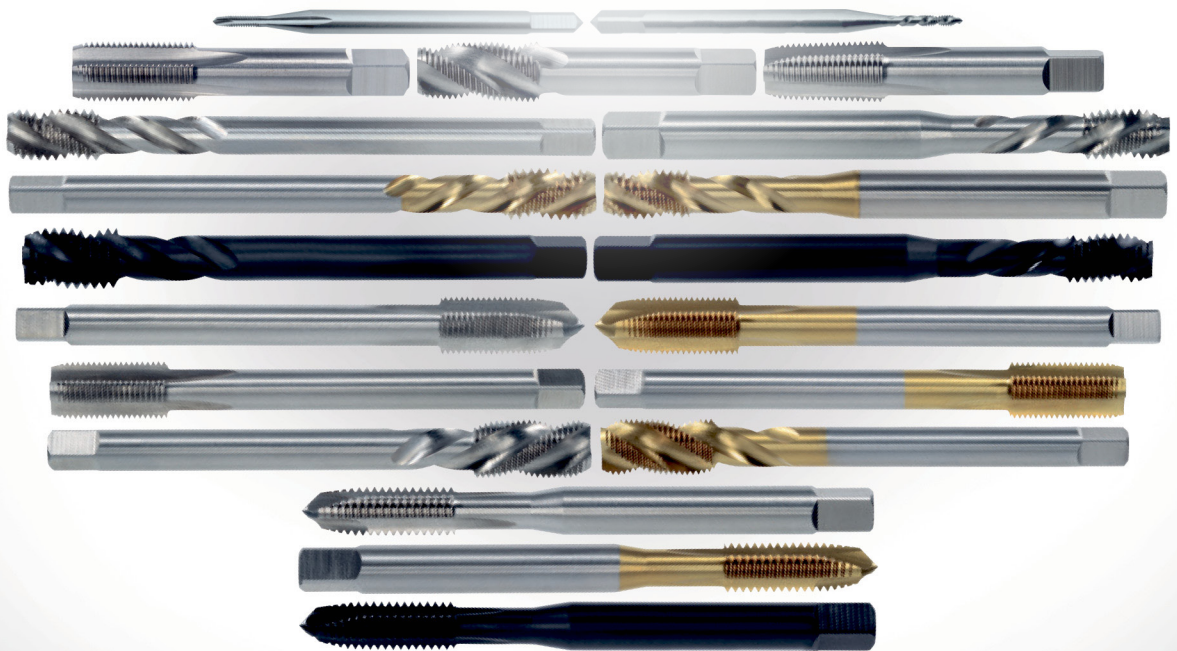
Drive connector	Material
Hexagon 1/4" inch	HSS-G

Variants (6):

D	L1	Hex	Art.-No.	D	L1	Hex	Art.-No.
6.3 mm	31	1/4"	67306	12.4 mm	35	1/4"	67312
8.3 mm	31	1/4"	67308	16.5 mm	40	1/4"	67316
10.4 mm	34	1/4"	67310	20.5 mm	41	1/4"	67320



Machine taps





Machine taps



HSSE Machine taps for through holes:

- Form A = 6-8 Threads lead
- Form B = 4-5 Threads lead with spiral point
- Form B-AZ = 4-5 Threads lead spiral point, interrupted threads

HSSE Machine taps for blind holes:

- Form C = 2-3 Threads lead
- Form C/RSP = 2-3 Threads lead with 15° or 35° spiral flute

M (metric)



P.K.47 HSS-E Machine taps for blind holes (set of 14 pcs.) (47847) incl. drills DIN 371/376 M 3 - M 12

Type of thread	Standard	Material	Tolerance	Packing	Size
metric ISO thread DIN 13	DIN 371/376	HSS-E	ISO 2 / 6H	in plastic case	Diameter M 3 - 12

Application/ for general use:

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

Contents:

	Art. -No.
1x Machine taps DIN 371 Form C 35°RSP HSS-E - M 3 x 0.5	37726
1x Machine taps DIN 371 Form C 35°RSP HSS-E - M 4 x 0.7	37730
1x Machine taps DIN 371 Form C 35°RSP HSS-E - M 5 x 0.8	37734
1x Machine taps DIN 371 Form C 35°RSP HSS-E - M 6 x 1.0	37738
1x Machine taps DIN 371 Form C 35°RSP HSS-E - M 8 x 1.25	37742
1x Machine taps DIN 371 Form C 35°RSP HSS-E - M 10 x 1.5	37746
1x Machine taps DIN 376 Form C 35°RSP HSS-E - M 12 x 1.75	38750
Twist drill 2.5 / 3.3 / 4.2 / 5.0 / 6.8 / 8.5 / 10.2 mm	



P.K.48 HSS-E TiN Machine taps for blind holes (set of 14 pcs.) (47848) incl. drills DIN 371/376 M 3 - M 12

Type of thread	Standard	Material	Tolerance	Packing	Size
metric ISO thread DIN 13	DIN 371/376	HSS-E	ISO 2/6H	in plastic case	Diameter M 3 - 12

Application/ for general use:

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

TIN-coating:

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

Contents:

	Art. -No.
1x Machine taps DIN 371 Form C 35°RSP HSS-E TiN - M 3 x 0.5	31726
1x Machine taps DIN 371 Form C 35°RSP HSS-E TiN - M 4 x 0.7	31730
1x Machine taps DIN 371 Form C 35°RSP HSS-E TiN - M 5 x 0.8	31734
1x Machine taps DIN 371 Form C 35°RSP HSS-E TiN - M 6 x 1.0	31738
1x Machine taps DIN 371 Form C 35°RSP HSS-E TiN - M 8 x 1.25	31742
1x Machine taps DIN 371 Form C 35°RSP HSS-E TiN - M 10 x 1.5	31746
1x Machine taps DIN 376 Form C 35°RSP HSS-E TiN - M 12 x 1.75	31750
Twist drill 2.5 / 3.3 / 4.2 / 5.0 / 6.8 / 8.5 / 10.2 mm	



P.K.31 HSS-E TiN Machine taps for blind holes (set of 7 pcs.) (47827) DIN 371/376 M 3 - M 12

Type of thread	Standard	Material	Tolerance	Packing	Size
metric ISO thread DIN 13	DIN 371/376	HSS-E	ISO 2/6H	in plastic case	Diameter M 3 - 12

Application/ for general use:

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

TIN-coating:

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

Contents:

	Art. -No.
1x Machine taps DIN 371 Form C 35°RSP HSS-E TiN - M 3 x 0.5	31726
1x Machine taps DIN 371 Form C 35°RSP HSS-E TiN - M 4 x 0.7	31730
1x Machine taps DIN 371 Form C 35°RSP HSS-E TiN - M 5 x 0.8	31734
1x Machine taps DIN 371 Form C 35°RSP HSS-E TiN - M 6 x 1.0	31738
1x Machine taps DIN 371 Form C 35°RSP HSS-E TiN - M 8 x 1.25	31742
1x Machine taps DIN 371 Form C 35°RSP HSS-E TiN - M 10 x 1.5	31746
1x Machine taps DIN 376 Form C 35°RSP HSS-E TiN - M 12 x 1.75	31750



Application/ for general use:

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



Application/ for general use:

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

TiN-coating:

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

P.K.30 HSS-E Machine taps for blind holes (set of 7 pcs.) (47817) DIN 371/376 M 3 - M 12

Type of thread	Standard	Material	Tolerance	Packing	Size
metric ISO thread DIN 13	DIN 371/376	HSS-E	ISO 2/6H	in plastic case	Diameter M 3 - 12

Contents:

	Art. -No.
1x Machine taps DIN 371 Form C 35°RSP HSS-E - M 3 x 0.5	37726
1x Machine taps DIN 371 Form C 35°RSP HSS-E - M 4 x 0.7	37730
1x Machine taps DIN 371 Form C 35°RSP HSS-E - M 5 x 0.8	37734
1x Machine taps DIN 371 Form C 35°RSP HSS-E - M 6 x 1.0	37738
1x Machine taps DIN 371 Form C 35°RSP HSS-E - M 8 x 1.25	37742
1x Machine taps DIN 371 Form C 35°RSP HSS-E - M 10 x 1.5	37746
1x Machine taps DIN 376 Form C 35°RSP HSS-E - M 12 x 1.75	38750

P.K.36 HSS-E TiN Machine taps (set of 14 pcs.) (47836) incl. drills DIN 371/376 M 3 - M 12

Type of thread	Standard	Material	Tolerance	Packing	Size
metric ISO thread DIN 13	DIN 371/376	HSS-E	ISO 2/6H	in plastic case	Diameter M 3 - 12

Contents:

	Art. -No.
1x Machine taps DIN 371 Form B HSS-E TiN - M 3 x 0.5	31526
1x Machine taps DIN 371 Form B HSS-E TiN - M 4 x 0.7	31530
1x Machine taps DIN 371 Form B HSS-E TiN - M 5 x 0.8	31534
1x Machine taps DIN 371 Form B HSS-E TiN - M 6 x 1.0	31538
1x Machine taps DIN 371 Form B HSS-E TiN - M 8 x 1.25	31542
1x Machine taps DIN 371 Form B HSS-E TiN - M 10 x 1.5	31546
1x Machine taps DIN 376 Form B HSS-E TiN - M 12 x 1.75	31550
Twist drill 2.5 / 3.3 / 4.2 / 5.0 / 6.8 / 8.5 / 10.2 mm	



Application/ for general use:

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

P.K.35 HSS-E Machine taps (set of 14 pcs.) (47835)

incl. drills DIN 371/376 M 3 - M 12

Type of thread	Standard	Material	Tolerance	Packing	Size
metric ISO thread DIN 13	DIN 371/376	HSS-E	ISO 2/6H	in plastic case	Diameter M 3 - 12

Contents:

	Art. -No.
1x Machine taps DIN 371 Form B HSS-E - M 3 x 0.5	37526
1x Machine taps DIN 371 Form B HSS-E - M 4 x 0.7	37530
1x Machine taps DIN 371 Form B HSS-E - M 5 x 0.8	37534
1x Machine taps DIN 371 Form B HSS-E - M 6 x 1.0	37538
1x Machine taps DIN 371 Form B HSS-E - M 8 x 1.25	37542
1x Machine taps DIN 371 Form B HSS-E - M 10 x 1.5	37546
1x Machine taps DIN 376 Form B HSS-E - M 12 x 1.75	38550
Twist drill 2.5 / 3.3 / 4.2 / 5.0 / 6.8 / 8.5 / 10.2 mm	



Application/ for general use:

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

TiN-coating:

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

P.K.29 HSS-E TiN Machine taps (set of 7 pcs.) (47825)

DIN 371/376 M 3 - M 12

Type of thread	Standard	Material	Tolerance	Packing	Size
metric ISO thread DIN 13	DIN 371/376	HSS-E	ISO 2/6H	in plastic case	Diameter M 3 - 12

Contents:

	Art. -No.
1x Machine taps DIN 371 Form B HSS-E TiN - M 3 x 0.5	31526
1x Machine taps DIN 371 Form B HSS-E TiN - M 4 x 0.7	31530
1x Machine taps DIN 371 Form B HSS-E TiN - M 5 x 0.8	31534
1x Machine taps DIN 371 Form B HSS-E TiN - M 6 x 1.0	31538
1x Machine taps DIN 371 Form B HSS-E TiN - M 8 x 1.25	31542
1x Machine taps DIN 371 Form B HSS-E TiN - M 10 x 1.5	31546
1x Machine taps DIN 376 Form B HSS-E TiN - M 12 x 1.75	31550



P.K.28 HSS-E Machine taps (set of 7 pcs.) (47815)

DIN 371/376 M 3 - M 12

Type of thread	Standard	Material	Tolerance	Packing	Size
metric ISO thread DIN 13	DIN 371/376	HSS-E	ISO 2 /6H	in plastic case	Diameter M 3 - 12

Application/ for general use:

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

Contents:

	Art. -No.
1x Machine taps DIN 371 Form B HSS-E - M 3 x 0.5	37526
1x Machine taps DIN 371 Form B HSS-E - M 4 x 0.7	37530
1x Machine taps DIN 371 Form B HSS-E - M 5 x 0.8	37534
1x Machine taps DIN 371 Form B HSS-E - M 6 x 1.0	37538
1x Machine taps DIN 371 Form B HSS-E - M 8 x 1.25	37542
1x Machine taps DIN 371 Form B HSS-E - M 10 x 1.5	37546
1x Machine taps DIN 376 Form B HSS-E - M 12 x 1.75	38550



P.K.41 HSS-E TiN Machine taps (set of 14 pcs.) (47912)

DIN 371/376 M 3 - M 12

Type of thread	Standard	Material	Tolerance	Packing	Size
metric ISO thread DIN 13	DIN 371/376	HSS-E	ISO 2 /6H	in plastic case	Diameter M 3 - 12

Application/ for general use:

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

TiN-coating:

- › improved resistance to wear and abrasion
- › excellent anti-friction properties

Contents:

	Art. -No.
1x Machine taps DIN 371 Form B HSS-E TiN - M 3 x 0.5	31526
1x Machine taps DIN 371 Form B HSS-E TiN - M 4 x 0.7	31530
1x Machine taps DIN 371 Form B HSS-E TiN - M 5 x 0.8	31534
1x Machine taps DIN 371 Form B HSS-E TiN - M 6 x 1.0	31538
1x Machine taps DIN 371 Form B HSS-E TiN - M 8 x 1.25	31542
1x Machine taps DIN 371 Form B HSS-E TiN - M 10 x 1.5	31546
1x Machine taps DIN 376 Form B HSS-E TiN - M 12 x 1.75	31550
1x Machine taps DIN 371 Form C 35°RSP HSS-E TiN - M 3 x 0.5	31726
1x Machine taps DIN 371 Form C 35°RSP HSS-E TiN - M 4 x 0.7	31730
1x Machine taps DIN 371 Form C 35°RSP HSS-E TiN - M 5 x 0.8	31734
1x Machine taps DIN 371 Form C 35°RSP HSS-E TiN - M 6 x 1.0	31738
1x Machine taps DIN 371 Form C 35°RSP HSS-E TiN - M 8 x 1.25	31742
1x Machine taps DIN 371 Form C 35°RSP HSS-E TiN - M 10 x 1.5	31746
1x Machine taps DIN 376 Form C 35°RSP HSS-E TiN - M 12 x 1.75	31750



P.K.40 HSS-E Machine taps (set of 14 pcs.) (47901)

DIN 371/376 M 3 - M 12

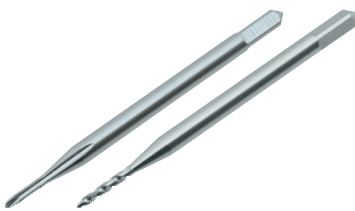
Type of thread	Standard	Material	Tolerance	Packing	Size
metric ISO thread DIN 13	DIN 371/376	HSS-E	ISO 2 /6H	in plastic case	Diameter M 3 - 12

Application/ for general use:

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

Contents:

	Art. -No.
1x Machine taps DIN 371 Form B HSS-E - M 3 x 0.5	37526
1x Machine taps DIN 371 Form B HSS-E - M 4 x 0.7	37530
1x Machine taps DIN 371 Form B HSS-E - M 5 x 0.8	37534
1x Machine taps DIN 371 Form B HSS-E - M 6 x 1.0	37538
1x Machine taps DIN 371 Form B HSS-E - M 8 x 1.25	37542
1x Machine taps DIN 371 Form B HSS-E - M 10 x 1.5	37546
1x Machine taps DIN 371 Form C 35°RSP HSS-E - M 3 x 0.5	37726
1x Machine taps DIN 371 Form C 35°RSP HSS-E - M 4 x 0.7	37730
1x Machine taps DIN 371 Form C 35°RSP HSS-E - M 5 x 0.8	37734
1x Machine taps DIN 371 Form C 35°RSP HSS-E - M 6 x 1.0	37738
1x Machine taps DIN 371 Form C 35°RSP HSS-E - M 8 x 1.25	37742
1x Machine taps DIN 371 Form C 35°RSP HSS-E - M 10 x 1.5	37746
1x Machine taps DIN 376 Form B HSS-E - M 12 x 1.75	38550
1x Machine taps DIN 376 Form C 35°RSP HSS-E - M 12 x 1.75	38750



Micro machine taps DIN 371

Form B HSS-E - M

Type of thread: metric ISO-thread DIN 13	Tolerance: ISO 2 /6H
--	----------------------

Variants (7):

Advantages:

- > safe production process and precise cutting of micro-threads M1 - M1.8
- > for all-purpose
- > best industrial quality
- > immediately available frostock

Application/for general use:

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

D	L1	L2	D2	Square	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 0.30	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



Micro machine taps DIN 371

Form C 35°RSP HSS-E - M

Type of thread: metric ISO-thread DIN 13

Tolerance: ISO 2 /6H

Variants (7):

Advantages:

- › safe production process and precise cutting of micro-threads M1 - M1.8
- › for all-purpose
- › best industrial quality
- › immediately available frostock

Application/for general use:

- › non abrasive material up to 900 N/mm²
- › unalloyed and low alloyed steel
- › Form C 35° RSP for blind holes

D	L1	L2	D2	Square	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 0.30	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



Machine taps DIN 371

Form B HSS-E - M + Form B HSS-E TiN - M + Form B HSS-E VAP - M

Type of thread: metric ISO-thread DIN 13

Tolerance: ISO 2 /6H

Variants (10/6/6):

Application/for general use:

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

TIN-coating:

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

VAP-coating:

- › improved adhesion of the coolant and Lubricant
- › reduces tearing of the lubricating fill and the formation of cold welding



D	L1	L2	D2	Square	Art.-No. B	Art.-No. TIN	Art.-No. VAP
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	31526	31570
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	31530	31571
M 5 x 0.8	70	16	6.0	4.9	37534	31534	31572
M 6 x 1.0	80	19	6.0	4.9	37538	31538	31573
M 7 x 1.0	80	19	7.0	5.5	37540	-	-
M 8 x 1.25	90	22	8.0	6.2	37542	31542	31574
M 10 x 1.5	100	24	10.0	8.0	37546	31546	31575



Machine taps DIN 376

Form B HSS-E - M + Form B HSS-E TiN - M + Form B HSS-E VAP - M

Type of thread: metric ISO-thread DIN 13

Tolerance: ISO 2 /6H

Variants (23/5/5):

Application/ for general use:

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

TIN-coating:

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

VAP-coating:

- improved adhesion of the coolant and Lubricant
- reduces tearing of the lubricating fill and the formation of cold welding



D		L1	L2	D2	Square	Art.-No. B	Art.-No. TIN	Art.-No. VAP
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	31550	31576
M	14 x 2.0	110	30	11.0	9.0	38554	31554	31577
M	16 x 2.0	110	32	12.0	9.0	38558	31558	31578
M	18 x 2.5	125	34	14.0	11.0	38562	31562	31579
M	20 x 2.5	140	34	16.0	12.0	38566	31566	31580
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	-	-



Machine taps DIN 376

Form C 35°RSP HSS-E - M - M + Form C 35°RSP HSS-E TiN - M
+ Form C 35°RSP HSS-E VAP - M

Type of thread: metric ISO-thread DIN 13

Tolerance: ISO 2 /6H

Variants (10/6/6):

Application/ for general use:

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

TIN-coating:

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

VAP-coating:

- improved adhesion of the coolant and Lubricant
- reduces tearing of the lubricating fill and the formation of cold welding



D		L1	L2	D2	Square	Art.-No. C 35°	Art.-No. TiN	Art.-No. VAP
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	31726	31770
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	31730	31771
M	5 x 0.8	70	8	6.0	4.9	37734	31734	31772
M	6 x 1.0	80	10	6.0	4.9	37738	31738	31773
M	7 x 1.0	80	12	7.0	5.5	37740	-	-
M	8 x 1.25	90	14	8.0	6.2	37742	31742	31774
M	10 x 1.5	100	16	10.0	8.0	37746	31746	31775



Machine taps DIN 376

Form C 35°RSP HSS-E - M + Form C 35°RSP HSS-E TIN - M
+ Form C 35°RSP HSS-E VAP - M

Type of thread: metric ISO-thread DIN 13

Tolerance: ISO 2 /6H

Variants (22/5/5):

Application/ for general use:

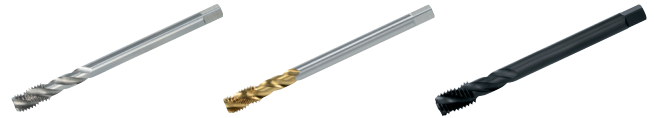
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for blind holes

TIN-coating:

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

VAP-coating:

- improved adhesion of the coolant and Lubricant
- reduces tearing of the lubricating fill and the formation of cold welding



D		L1	L2	D2	Square	Art.-No. B	Art.-No. TIN	Art.-No. VAP
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	31750	31776
M	14 x 2.0	110	20	11.0	9.0	38754	31754	31777
M	16 x 2.0	110	22	12.0	9.0	38758	31758	31778
M	18 x 2.5	125	25	14.0	11.0	38762	31762	31779
M	20 x 2.5	140	25	16.0	12.0	38766	31766	31780
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	-	-



Machine taps DIN 371

Form B-AZ HSS-E - M

Type of thread: metric ISO-thread DIN 13

Tolerance: ISO 2 /6H

Variants (6):

Application/for general use:

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

D	L1	L2	D2	Square	Art.-No.
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



Machine taps DIN 376

Form B-AZ HSS-E - M

Type of thread: metric ISO-thread DIN 13

Tolerance: ISO 2 /6H

Variants (13):

Application/for general use:

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

D	L1	L2	D2	Square	Art.-No.
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



Machine taps DIN 371

Form C 15°RSP HSS-E - M

Type of thread: metric ISO-thread DIN 13

Tolerance: ISO 2 /6H

Variants (8):

Application/for general use:

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

D	L1	L2	D2	Square	Art.-No.
M 3 x 0.5	56	11	3.5	2.7	37626
M 3.5 x 0.5	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



Machine taps DIN 376

Form C 15°RSP HSS-E - M

Type of thread: metric ISO-thread DIN 13

Tolerance: ISO 2 /6H

Variants (13):

Application/for general use:

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

D	L1	L2	D2	Square	Art.-No.
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	9.0	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



Machine taps

JIS B-4430 HSS-E - M

Type of thread: metric ISO-thread DIN 13

Tolerance: ISO 2 /6H

Variants (2/16/19):

Application/ for general use:

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



D		L1	L2	D2	Square	Art.-No.*	Art.-No.*	Art.-No.**
M	2.5 x 0.45	44	16	3	2.5	-	-	90718
M	2.6 x 0.45	44	16	3	2.5	-	90520	90720
M	3 x 0.5	46	18	4	3.2	-	90522	90722
M	3.5 x 0.6	48	18	4	3.2	-	90524	90724
M	4 x 0.7	52	20	5	4	-	90526	90726
M	5 x 0.8	60	22	5.5	4.5	-	90530	90730
M	6 x 1.0	62	24	6	4.5	-	90538	90738
M	7 x 1.0	65	26	6.2	4.5	-	90544	90744
M	8 x 1.25	70	30	6.2	5	-	90546	90746
M	10 x 1.5	75	32	7	5.5	-	90554	90754
M	12 x 1.75	82	38	8.5	6.5	-	90560	90760
M	14 x 2.0	88	42	10.5	8	-	90566	90766
M	16 x 2.0	95	45	12.5	10	-	90572	90772
M	18 x 2.5	100	48	14	11	-	90578	90778
M	20 x 2.5	105	50	15	12	-	90584	90784
M	22 x 2.5	115	55	17	13	-	90590	90790
M	24 x 3.0	120	58	19	15	-	90596	90796
M	27	130	62	20	15	91502	-	91702
M	30	135	65	23	17	91508	-	91708



Machine taps DIN 371

Form A HSS-E - M

Type of thread: metric ISO-thread DIN 13

Tolerance: ISO 2 /6H

Variants (10):

Application/for general use:

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

D	L1	L2	D2	Square	Art.-No.
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



Machine taps DIN 376

Form A HSS-E - M

Type of thread: metric ISO-thread DIN 13

Tolerance: ISO 2 /6H

Variants (16):

Application/for general use:

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

D	L1	L2	D2	Square	Art.-No.
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



Machine taps DIN 371

Form C HSS-E - M

Type of thread: metric ISO-thread DIN 13

Tolerance: ISO 2 /6H

Variants (12):

Application/for general use:

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

D	L1	L2	D2	Square	Art.-No.
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



Machine taps DIN 376

Form C HSS-E - M

Type of thread: metric ISO-thread DIN 13

Tolerance: ISO 2 /6H

Variants (23):

Application/for general use:

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

D	L1	L2	D2	Square	Art.-No.	D	L1	L2	D2	Square	Art.-No.
M 3 x 0.5	56	11	2.2	-	38426	M 22 x 2.5	140	34	18.0	14.5	38470
M 4 x 0.7	63	13	2.8	2.1	38430	M 24 x 3.0	160	38	18.0	14.5	38474
M 5 x 0.8	70	16	3.5	2.7	38434	M 27 x 3.0	160	38	20.0	16.0	38476
M 6 x 1.0	80	19	4.5	3.4	38438	M 30 x 3.5	180	45	22.0	18.0	38478
M 8 x 1.25	90	22	6.0	4.9	38442	M 33 x 3.5	180	50	25.0	20.0	38480
M 10 x 1.5	100	24	7.0	5.5	38446	M 36 x 4.0	200	56	28.0	22.0	38482
M 11 x 1.5	100	24	8.0	6.2	38448	M 39 x 4.0	200	60	32.0	24.0	38484
M 12 x 1.75	110	29	9.0	7.0	38450	M 42 x 4.5	200	60	32.0	24.0	38486
M 14 x 2.0	110	30	11.0	9.0	38454	M 45 x 4.5	220	65	36.0	29.0	38488
M 16 x 2.0	110	32	12.0	9.0	38458	M 48 x 5.0	250	70	36.0	29.0	38490
M 18 x 2.5	125	34	14.0	11.0	38462	M 52 x 5.0	250	70	40.0	32.0	38492
M 20 x 2.5	140	34	16.0	12.0	38466						



TwinBox DIN 371/376

Form B HSS-E - M + Form C 35°RSP HSS-E - M

Type of thread: metric ISO-thread DIN 13

Tolerance: ISO 2 /6H

Variants (9/9):

Application/for general use:

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

HSS-G Twist Drill DIN 338, Typ N

bright finish, profile ground

D	Machine Tap	Twist Drill	Art.-No. Form B	Art.-No. Form C
M 3 x 0.5	DIN 371	2.5 mm	37590	37790
M 4 x 0.7	DIN 371	3.3 mm	37591	37791
M 5 x 0.8	DIN 371	4.2 mm	37592	37792
M 6 x 1.0	DIN 371	5.0 mm	37593	37793
M 8 x 1.25	DIN 371	6.8 mm	37594	37794
M 10 x 1.5	DIN 371	8.5 mm	37595	37795
M 12 x 1.75	DIN 376	10.2 mm	38596	38796
M 14 x 2.0	DIN 376	12.0 mm	38597	38797
M 16 x 2.0	DIN 376	14.0 mm	38598	38798



M - extra long



Machine taps, extra long

≈ DIN 371 HSS-E - M

Type of thread: metric ISO-thread DIN 13

Tolerance: ISO 2 /6H

Variants (7/7+6/6+6/6+6/6):

Application/ for general use:

- > non abrasive material up to 900 N/mm²
- > unalloyed and low alloyed steel

- > for thread cutting in hard to be reached places
- > for through holes*
- > for blind holes**



100 mm:		L1	L2	L2	D2	Square	Art.-No.*	Art.-No.**
D			Form B	Form C			Form B	Form C
M	3 x 0.5	100	11	6	3.5	2.7	32010	32040
M	4 x 0.7	100	13	7	4.5	3.4	32011	32041
M	5 x 0.8	100	16	8	6.0	4.9	32012	32042
M	6 x 1.0	100	19	10	6.0	4.9	32013	32043
M	8 x 1.25	100	22	14	8.0	6.2	32014	32044
M	10 x 1.5	100	24	16	10.0	8.0	32015	32045
M	12 x 1.75	100	29	18	12.0	9.0	32016	32046

120 mm:		L1	L2	L2	D2	Square	Art.-No.*	Art.-No.**
D			Form B	Form C			Form B	Form C
M	4 x 0.7	120	13	7	4.5	3.4	32021	32051
M	5 x 0.8	120	16	8	6.0	4.9	32022	32052
M	6 x 1.0	120	19	10	6.0	4.9	32023	32053
M	8 x 1.25	120	22	14	8.0	6.2	32024	32054
M	10 x 1.5	120	24	16	10.0	8.0	32025	32055
M	12 x 1.75	120	29	18	12.0	9.0	32026	32056

150 mm:		L1	L2	L2	D2	Square	Art.-No.*	Art.-No.**
D			Form B	Form C			Form B	Form C
M	4 x 0.7	150	13	7	4.5	3.4	32031	32061
M	5 x 0.8	150	16	8	6.0	4.9	32032	32062
M	6 x 1.0	150	19	10	6.0	4.9	32033	32063
M	8 x 1.25	150	22	14	8.0	6.2	32034	32064
M	10 x 1.5	150	24	16	10.0	8.0	32035	32065
M	12 x 1.75	150	29	18	12.0	9.0	32036	32066



150 mm, reduced shank:		L1	L2	L2	D2	Square	Art.-No.*	Art.-No.**
D			Form B	Form C			Form B	Form C
M	4 x 0.7	150	13	7	2.8	2.1	32071	32081
M	5 x 0.8	150	16	8	3.5	2.7	32072	32082
M	6 x 1.0	150	19	10	4.5	3.4	32073	32083
M	8 x 1.25	150	22	14	6.0	4.9	32074	32084
M	10 x 1.5	150	24	16	7.0	5.5	32075	32085
M	12 x 1.75	150	29	18	9.0	7.0	32076	32086



M - 6G - 7G - +0,1 - 4H



Machine taps, oversize

6G, 7G, +0,1 - DIN 371/376 HSS-E - M

Type of thread: metric ISO-thread DIN 13

Tolerance: 6G/7G/+0,1

Variants (12/11+7/7+7/7):

Application/ for general use:

- > non abrasive material up to 900 N/mm²
- > unalloyed and low alloyed steel

- > long chipping material
- > for through holes*
- > for blind holes**



6G		L1	L2 Form B	L2 Form C	D2	Square	Art.-No.* Form B	Art.-No.** Form C
DIN 371								
M	2.5 x 0.45	50	9	-	2.8	2.1	32522	-
M	3 x 0.5	56	11	6	3.5	2.7	32526	32726
M	4 x 0.7	63	13	7	4.5	3.4	32530	32730
M	5 x 0.8	70	16	8	6.0	4.9	32534	32734
M	6 x 1.0	80	19	10	6.0	4.9	32538	32738
M	8 x 1.25	90	22	14	8.0	6.2	32542	32742
M	10 x 1.5	100	24	16	10.0	8.0	32546	32746
DIN 376								
M	12 x 1.75	110	29	18	9.0	7.0	32550	32750
M	14 x 2.0	110	30	20	11.0	9.0	32554	32754
M	16 x 2.0	110	32	22	12.0	9.0	32558	32758
M	18 x 2.5	125	34	25	14.0	11.0	32562	32762
M	20 x 2.5	140	34	25	16.0	12.0	32566	32766
7G								
		L1	L2 Form B	L2 Form C	D2	Square	Art.-No.* Form B	Art.-No.** Form C
DIN 371								
M	3 x 0.5	56	11	6	3.5	2.7	32503	32703
M	4 x 0.7	63	13	7	4.5	3.4	32504	32704
M	5 x 0.8	70	16	8	6.0	4.9	32505	32705
M	6 x 1.0	80	19	10	6.0	4.9	32506	32706
M	8 x 1.25	90	22	14	8.0	6.2	32508	32708
M	10 x 1.5	100	24	16	10.0	8.0	32510	32710
DIN 376								
M	12 x 1.75	110	29	18	9.0	7.0	32512	32712



+0,1 mm		L1	L2 Form B	L2 Form C	D2	Square	Art.-No.* Form B	Art.-No.** Form C
DIN 371								
M	3 x 0.5	56	11	6	3.5	2.7	32583	32783
M	4 x 0.7	63	13	7	4.5	3.4	32584	32784
M	5 x 0.8	70	16	8	6.0	4.9	32585	32785
M	6 x 1.0	80	19	10	6.0	4.9	32586	32786
M	8 x 1.25	90	22	14	8.0	6.2	32588	32788
M	10 x 1.5	100	24	16	10.0	8.0	32590	32790
DIN 376								
M	12 x 1.75	110	29	18	9.0	7.0	32592	32792



Machine taps, undersize

4H - DIN 371/376 HSS-E - M

Type of thread: metric ISO-thread DIN 13

Tolerance: 4H

Variants (9/9):

Application/ for general use:

- > non abrasive material up to 900 N/mm²
- > unalloyed and low alloyed steel

- > long chipping material
- > for through holes*
- > for blind holes**



4H		L1	L2 Form B	L2 Form C	D2	Square	Art.-No.* Form B	Art.-No.** Form C
DIN 371								
M	3 x 0.5	56	11	6	3.5	2.7	32612	32652
M	4 x 0.7	63	13	7	4.5	3.4	32614	32654
M	5 x 0.8	70	16	8	6.0	4.9	32616	32656
M	6 x 1.0	80	19	10	6.0	4.9	32618	32658
M	8 x 1.25	90	22	14	8.0	6.2	32620	32660
M	10 x 1.5	100	24	16	10.0	8.0	32622	32662
DIN 376								
M	12 x 1.75	110	29	18	9.0	7.0	32624	32664
M	14 x 2.0	110	30	20	11.0	9.0	32625	32665
M	16 x 2.0	110	32	22	12.0	9.0	32626	32666



M (left hand) LH



Machine taps, left hand

DIN 371/376 Form B HSS-E - M LH
+ DIN 376 Form C 35°SP HSS-E - M LH

Type of thread: metric ISO-thread DIN 13

Tolerance: ISO 2 /6H

Variants (7/22+6/22):

Application/ for general use:

- > non abrasive material up to 900 N/mm²
- > unalloyed and low alloyed steel

- > long chipping material
- > for through holes*
- > for blind holes**



DIN 371		L1	L2	L2	D2	Square	Art.-No.*	Art.-No.**
D			Form B	Form C			Form B	Form C
M	3 x 0.5	56	11	6	3.5	2.7	33526	33726
M	4 x 0.7	63	13	7	4.5	3.4	33530	33730
M	5 x 0.8	70	16	8	6.0	4.9	33534	33734
M	6 x 1.0	80	19	10	6.0	4.9	33538	33738
M	7 x 1.0	80	19	-	7.0	5.5	33540	-
M	8 x 1.25	90	22	14	8.0	6.2	33542	33742
M	10 x 1.5	100	24	16	10.0	8.0	33546	33746



DIN 376		L1	L2	L2	D2	Square	Art.-No.*	Art.-No.**
D			Form B	Form C			Form B	Form C
M	3 x 0.5	56	11	6	2.2	-	34526	34726
M	4 x 0.7	63	13	7	2.8	2.1	34530	34730
M	5 x 0.8	70	16	8	3.5	2.7	34534	34734
M	6 x 1.0	80	19	10	4.5	3.4	34538	34738
M	8 x 1.25	90	22	14	6.0	4.9	34542	34742
M	10 x 1.5	100	24	16	7.0	5.5	34546	34746
M	12 x 1.75	110	29	18	9.0	7.0	34550	34750
M	14 x 2.0	110	30	20	11.0	9.0	34554	34754
M	16 x 2.0	110	32	22	12.0	9.0	34558	34758
M	18 x 2.5	125	34	25	14.0	11.0	34562	34762
M	20 x 2.5	140	34	25	16.0	12.0	34566	34766



DIN 376		L1	L2	L2	D2	Square	Art.-No.*	Art.-No.**
D			Form B	Form C			Form B	Form C
M	22 x 2.5	140	34		18.0	14.5	34570	34770
M	24 x 3.0	160	38		18.0	14.5	34574	34774
M	27 x 3.0	160	38		20.0	16.0	34576	34776
M	30 x 3.5	180	45		22.0	18.0	34578	34778
M	33 x 3.5	180	50		25.0	20.0	34580	34780
M	36 x 4.0	200	56		28.0	22.0	34582	34782
M	39 x 4.0	200	60		32.0	24.0	34584	34784
M	42 x 4.5	200	60		32.0	24.0	34586	34786
M	45 x 4.5	220	65		36.0	29.0	34588	34788
M	48 x 5.0	250	70		36.0	29.0	34590	34790
M	52 x 5.0	250	70		40.0	32.0	34592	34792



Machine taps, left hand

left hand DIN 371/376 Form C HSS-E - M LH

Type of thread: metric ISO-thread DIN 13

Tolerance: ISO 2 /6H

Variants (13):

Application/ for general use:

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

D		L1	L2	D2	Square	Art.-No.*
DIN 371						
M	3 x 0.5	56	11	3.5	2.7	33426
M	4 x 0.7	63	13	4.5	3.4	33430
M	5 x 0.8	70	16	6.0	4.9	33434
M	6 x 1.0	80	19	6.0	4.9	33438
M	8 x 1.25	90	22	8.0	6.2	33442
M	10 x 1.5	100	24	10.0	8.0	33446
DIN 376						
M	12 x 1.75	110	29	9.0	7.0	34450
M	14 x 2.0	110	30	11.0	9.0	34454
M	16 x 2.0	110	32	12.0	9.0	34458
M	18 x 2.5	125	34	14.0	11.0	34462
M	20 x 2.5	140	34	16.0	12.0	34466
M	22 x 2.5	140	34	18.0	14.5	34470
M	24 x 3.0	160	38	18.0	14.5	34474



Machine taps, left hand

ISO 529 HSS-G - M LH + ISO 529 35°SP HSS-G - M LH

Type of thread: metric ISO-thread DIN 13

Tolerance: ISO 2 /6H

Variants (7/7):

Application/ for general use:

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

- for thread cutting by hand and machine**
- for through holes*
- for through and blind holes**



D		L1	L2	D2	Square	Art.-No.*	Art.-No.** /SP
M	3 x 0.5	48	11	3.15	2.5	80810	80850
M	4 x 0.7	53	13	4	3.15	80812	80852
M	5 x 0.8	58	16	5	4	80814	80854
M	6 x 1.0	66	19	6.3	5	80816	80856
M	8 x 1.25	72	22	8	6.3	80818	80858
M	10 x 1.5	80	24	10	8	80820	80860
M	12 x 1.75	89	29	9	7.1	80822	80862



Mf (metric fine)



Machine taps

DIN 374 Form B HSS-E - Mf + Form C 35°RSP HSS-E - Mf

Type of thread: metric ISO-thread DIN 13

Tolerance: ISO 2 /6H

Variants (103/103):

Application/ for general use:

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



D	L1	L2		D2	Square	Art.-No.*	Art.-No.**	
		Form B	Form C			Form B	Form C	
M	3 x 0.35	56	9	5	2.2	-	39501	39701
M	4 x 0.35	63	10	5	2.8	2.1	39502	39702
M	4 x 0.5	63	10	5	2.8	2.1	39503	39703
M	5 x 0.5	70	12	5	3.5	2.7	39504	39704
M	5 x 0.75	70	12	8	3.5	2.7	39505	39705
M	6 x 0.5	80	14	5	4.5	3.4	39506	39706
M	6 x 0.75	80	14	8	4.5	3.4	39507	39707
M	7 x 0.75	80	14	8	5.5	4.3	39508	39708
M	8 x 0.5	80	19	8	6.0	4.9	39509	39709
M	8 x 0.75	80	19	8	6.0	4.9	39510	39710
M	8 x 1.0	90	22	10	6.0	4.9	39511	39711
M	9 x 0.75	80	19	10	7.0	5.5	39512	39712
M	9 x 1.0	90	22	10	7.0	5.5	39513	39713
M	10 x 0.75	90	20	10	7.0	5.5	39514	39714
M	10 x 1.0	90	20	10	7.0	5.5	39515	39715
M	10 x 1.25	100	24	16	7.0	5.5	39516	39716
M	11 x 1.0	90	20	11	8.0	6.2	39517	39717
M	11 x 1.25	90	22	14	8.0	6.2	39518	39718
M	12 x 0.75	100	22	10	9.0	7.0	39519	39719
M	12 x 1.0	100	22	11	9.0	7.0	39520	39720
M	12 x 1.25	100	22	15	9.0	7.0	39521	39721
M	12 x 1.5	100	22	15	9.0	7.0	39522	39722
M	13 x 1.0	100	22	11	11.0	9.0	39523	39723
M	13 x 1.5	100	22	15	11.0	9.0	39524	39724
M	14 x 0.75	100	22	10	11.0	9.0	39525	39725
M	14 x 1.0	100	22	11	11.0	9.0	39526	39726
M	14 x 1.25	100	22	15	11.0	9.0	39527	39727
M	14 x 1.5	100	22	15	11.0	9.0	39528	39728



D	L1	L2		D2	Square	Art.-No.*		
		Form B	Form C			Form B	Form C	
M	15 x 1.0	100	22	12	12.0	9.0	39529	39729
M	15 x 1.5	100	22	15	12.0	9.0	39530	39730
M	16 x 1.0	100	22	12	12.0	9.0	39531	39731
M	16 x 1.25	100	22	15	12.0	9.0	39532	39732
M	16 x 1.5	100	22	15	12.0	9.0	39533	39733
M	18 x 1.0	110	25	13	14.0	11.0	39534	39734
M	18 x 1.25	110	25	15	14.0	11.0	39535	39735
M	18 x 1.5	110	25	17	14.0	11.0	39536	39736
M	18 x 2.0	125	34	20	14.0	11.0	39537	39737
M	20 x 1.0	125	25	14	16.0	12.0	39538	39738
M	20 x 1.25	125	25	17	16.0	12.0	39539	39739
M	20 x 1.5	125	25	17	16.0	12.0	39540	39740
M	20 x 2.0	140	34	20	16.0	12.0	39541	39741
M	21 x 1.5	125	25	17	16.0	12.0	39542	39742
M	22 x 1.0	125	25	14	18.0	14.5	39543	39743
M	22 x 1.25	125	25	17	18.0	14.5	39544	39744
M	22 x 1.5	125	25	17	18.0	14.5	39545	39745
M	22 x 2.0	140	34	20	18.0	14.5	39546	39746
M	23 x 1.5	125	25	17	18.0	14.5	39547	39747
M	24 x 1.0	140	28	15	18.0	14.5	39548	39748
M	24 x 1.25	140	28	17	18.0	14.5	39549	39749
M	24 x 1.5	140	28	20	18.0	14.5	39550	39750
M	24 x 2.0	140	28	20	18.0	14.5	39551	39751
M	25 x 1.0	140	28	15	18.0	14.5	39552	39752
M	25 x 1.5	140	28	20	18.0	14.5	39553	39753
M	26 x 1.0	140	28	15	18.0	14.5	3955X	3975X
M	26 x 1.5	140	28	20	18.0	14.5	39554	39754
M	26 x 2.0	140	28	20	18.0	14.5	39555	39755
M	27 x 1.0	140	28	15	20.0	16.0	39500	39700
M	27 x 1.5	140	28	20	20.0	16.0	39556	39756
M	27 x 2.0	140	28	20	20.0	16.0	39557	39757
M	28 x 1.0	140	28	15	20.0	16.0	39558	39758
M	28 x 1.5	140	28	20	20.0	16.0	39559	39759
M	28 x 2.0	140	28	20	20.0	16.0	39560	39760
M	29 x 1.5	150	28	22	22.0	18.0	39561	39761
M	30 x 1.0	150	28	17	22.0	18.0	39562	39762
M	30 x 1.5	150	28	22	22.0	18.0	39563	39763
M	30 x 2.0	150	28	22	22.0	18.0	39564	39764
M	30 x 2.5	180	45	27	22.0	18.0	3956X	3976X
M	30 x 3.0	180	45	30	22.0	18.0	39565	39765
M	32 x 1.5	150	28	22	22.0	18.0	39566	39766



D		L1	L2		D2	Square	Art.-No.*	
			Form B	Form C			Form B	Form C
M	32 x 2.0	150	28	22	22.0	18.0	39567	39767
M	32 x 3.0	180	50	30	22.0	18.0	39592	39792
M	33 x 1.5	160	30	24	25.0	20.0	39593	39793
M	33 x 2.0	160	30	24	25.0	20.0	39568	39768
M	33 x 3.0	180	50	30	25.0	20.0	39569	39769
M	34 x 1.5	170	30	24	28.0	22.0	39570	39770
M	34 x 2.0	170	30	24	28.0	22.0	39571	39771
M	35 x 1.5	170	30	24	28.0	22.0	39572	39772
M	36 x 1.5	170	30	24	28.0	22.0	39573	39773
M	36 x 2.0	170	30	24	28.0	22.0	39574	39774
M	36 x 3.0	200	56	30	28.0	22.0	39575	39775
M	38 x 1.5	170	30	24	28.0	22.0	39576	39776
M	39 x 1.5	170	30	25	28.0	22.0	39577	39777
M	39 x 2.0	170	30	25	32.0	24.0	39578	39778
M	39 x 3.0	200	60	30	32.0	24.0	39579	39779
M	40 x 1.5	170	30	25	32.0	24.0	39580	39780
M	40 x 2.0	170	30	25	32.0	24.0	39581	39781
M	40 x 3.0	200	60	30	32.0	24.0	39582	39782
M	42 x 1.5	170	30	25	32.0	24.0	39583	39783
M	42 x 2.0	170	30	25	32.0	24.0	39584	39784
M	42 x 3.0	200	60	30	32.0	24.0	39585	39785
M	45 x 1.5	180	32	27	36.0	29.0	39586	39786
M	45 x 2.0	180	32	27	36.0	29.0	39587	39787
M	45 x 3.0	200	50	30	36.0	29.0	39588	39788
M	48 x 1.5	190	32	27	36.0	29.0	39589	39789
M	48 x 2.0	190	32	27	36.0	29.0	39590	39790
M	48 x 3.0	225	50	33	36.0	29.0	39591	39791
M	50 x 1.5	190	32	27	36.0	29.0	39594	39794
M	50 x 2.0	190	32	27	36.0	29.0	39595	39795
M	50 x 3.0	225	50	33	36.0	29.0	39596	39796
M	52 x 1.5	190	32	27	40.0	32.0	39597	39797
M	52 x 2.0	190	32	27	40.0	32.0	39598	39798
M	52 x 3.0	225	50	33	40.0	32.0	39599	39799
M	63 x 1.5	275	50	40	50.0	39.0	3959X	3979X



Machine taps

DIN 374 Form C HSS-E - Mf

Type of thread: metric ISO-thread DIN 13

Tolerance: ISO 2 /6H

Variants (48):

Application/ for general use:

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

D	L1	L2	D2	Square	Art.-No.	D	L1	L2	D2	Square	Art.-No.
M 4 x 0.35	63	10	2.8	2.1	39402	M 22 x 2.0	140	34	18.0	14.5	39446
M 5 x 0.5	70	12	3.5	2.7	39404	M 24 x 1.0	140	28	18.0	14.5	39448
M 6 x 0.75	80	14	4.5	3.4	39407	M 24 x 1.5	140	28	18.0	14.5	39450
M 8 x 0.75	80	19	6.0	4.9	39410	M 24 x 2.0	140	28	18.0	14.5	39451
M 8 x 1.0	90	22	6.0	4.9	39411	M 25 x 1.0	140	28	18.0	14.5	39452
M 10 x 1.0	90	20	7.0	5.5	39415	M 26 x 1.5	140	28	18.0	14.5	39454
M 10 x 1.25	100	24	7.0	5.5	39416	M 27 x 1.5	140	28	20.0	16.0	39456
M 12 x 1.0	100	22	9.0	7.0	39420	M 27 x 2.0	140	28	20.0	16.0	39457
M 12 x 1.25	100	22	9.0	7.0	39421	M 28 x 1.5	140	28	20.0	16.0	39459
M 12 x 1.5	100	22	9.0	7.0	39422	M 30 x 1.5	150	28	22.0	18.0	39463
M 14 x 1.0	100	22	11.0	9.0	39426	M 30 x 2.0	150	28	22.0	18.0	39464
M 14 x 1.25	100	22	11.0	9.0	39427	M 32 x 1.5	150	28	22.0	18.0	39466
M 14 x 1.5	100	22	11.0	9.0	39428	M 32 x 2.0	150	28	22.0	18.0	39467
M 16 x 1.0	100	22	12.0	9.0	39431	M 33 x 2.0	160	30	25.0	20.0	39468
M 16 x 1.5	100	22	12.0	9.0	39433	M 35 x 1.5	170	30	28.0	22.0	39472
M 18 x 1.0	110	25	14.0	11.0	39434	M 36 x 1.5	170	30	28.0	22.0	39473
M 18 x 1.5	110	25	14.0	11.0	39436	M 36 x 2.0	170	30	28.0	22.0	39474
M 18 x 2.0	125	34	14.0	11.0	39437	M 38 x 1.5	170	30	28.0	22.0	39476
M 20 x 1.0	125	25	16.0	12.0	39438	M 40 x 1.5	170	30	32.0	24.0	39480
M 20 x 1.25	125	25	16.0	12.0	39439	M 42 x 1.5	170	30	32.0	24.0	39483
M 20 x 1.5	125	25	16.0	12.0	39440	M 45 x 1.5	180	32	36.0	29.0	39486
M 20 x 2.0	140	34	16.0	12.0	39441	M 48 x 1.5	190	32	36.0	29.0	39489
M 22 x 1.0	125	25	18.0	14.5	39443	M 50 x 1.5	190	32	36.0	29.0	39494
M 22 x 1.5	125	25	18.0	14.5	39445	M 52 x 1.5	190	32	40.0	32.0	39497



Machine taps

JIS B-4430 HSS-E - Mf

Type of thread: metric ISO-thread DIN 13

Tolerance: ISO 2 /6H - 2B

Variants (23/23):

Application/ for general use:

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



D		L1	L2	D2	Square	Art.-No.*	Art.-No.**
M	6 x 0.75	62	24	6	4.5	90540	90740
M	8 x 1.0	70	30	6.2	5	90548	90748
M	8 x 0.75	70	30	7	5	90550	90750
M	10 x 1.25	75	32	7	5.5	90555	90755
M	10 x 1.0	75	32	7	5.5	90556	90756
M	12 x 1.5	82	38	8.5	6.5	90562	90762
M	12 x 1.25	82	38	8.5	6.5	90563	90763
M	12 x 1.0	82	38	8.5	6.5	90564	90764
M	14 x 1.5	88	42	10.5	8	90568	90768
M	14 x 1.25	88	39	10.5	8	90569	90769
M	14 x 1.0	70	30	10.5	8	90570	90770
M	16 x 1.5	95	45	12.5	10	90574	90774
M	16 x 1.0	75	30	12.5	10	90576	90776
M	18 x 1.5	95	45	14	11	90580	90780
M	18 x 1.0	95	45	14	11	90582	90782
M	20 x 1.5	95	45	15	12	90586	90786
M	20 x 1.0	80	30	15	12	90588	90788
M	22 x 1.5	95	45	17	13	90592	90792
M	22 x 2.0	95	45	17	13	90593	90793
M	22 x 1.0	95	45	17	13	90594	90794
M	24 x 1.5	95	45	19	15	90598	90798
M	27 x 1.5	95	45	20	15	91506	91706
M	30 x 1.5	105	45	23	17	91509	91709



Machine taps

ISO 529 HSS-G - Mf

Type of thread: metric ISO-thread DIN 13

Tolerance: ISO 2 /6H

Variants (10):

Application/ for general use:

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

D		L1	L2	D2	Square	Art.-No.
M	3 x 0.35	48	11	3.15	2.5	81501
M	4 x 0.5	53	13	4	3.15	81503
M	5 x 0.5	58	16	5	4	81505
M	6 x 0.75	66	19	6.3	5	81507
M	8 x 1.0	69	19	8	6.3	81513
M	10 x 1.0	76	20	10	8	81518
M	10 x 1.25	76	20	10	8	81519
M	12 x 1.0	84	24	9	7.1	81523
M	12 x 1.25	84	24	9	7.1	81524
M	12 x 1.5	89	29	9	7.1	81525



Mf (left hand) LH



Machine taps, left hand

DIN 374 Form B HSS-E - Mf LH + DIN 374 Form C 35°SP HSS-E - Mf LH

Type of thread: metric ISO-thread DIN 13

Tolerance: ISO 2 /6H

Variants (102/102):

Application/ for general use:

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



D	L1	L2		D2	Square	Art.-No.*	Art.-No.**	
		Form B	Form C			Form B	Form C	
M	3 x 0.35	56	9	5	2.2	-	34801	34901
M	4 x 0.35	63	10	5	2.8	2.1	34802	34902
M	4 x 0.5	63	10	5	2.8	2.1	34803	34903
M	5 x 0.5	70	12	5	3.5	2.7	34804	34904
M	5 x 0.75	70	12	8	3.5	2.7	34805	34905
M	6 x 0.5	80	14	5	4.5	3.4	34806	34906
M	6 x 0.75	80	14	8	4.5	3.4	34807	34907
M	7 x 0.75	80	14	8	5.5	4.3	34808	34908
M	8 x 0.5	80	19	8	6.0	4.9	34809	34909
M	8 x 0.75	80	19	8	6.0	4.9	34810	34910
M	8 x 1.0	90	22	10	6.0	4.9	34811	34911
M	9 x 0.75	80	19	10	7.0	5.5	34812	34912
M	9 x 1.0	90	22	10	7.0	5.5	34813	34913
M	10 x 0.75	90	20	10	7.0	5.5	34814	34914
M	10 x 1.0	90	20	10	7.0	5.5	34815	34915
M	10 x 1.25	100	24	16	7.0	5.5	34816	34916
M	11 x 1.0	90	20	11	8.0	6.2	34817	34917
M	11 x 1.25	90	22	14	8.0	6.2	34818	34918
M	12 x 0.75	100	22	10	9.0	7.0	34819	34919
M	12 x 1.0	100	22	11	9.0	7.0	34820	34920
M	12 x 1.25	100	22	15	9.0	7.0	34821	34921
M	12 x 1.5	100	22	15	9.0	7.0	34822	34922
M	13 x 1.0	100	22	11	11.0	9.0	34823	34923
M	13 x 1.5	100	22	15	11.0	9.0	34824	34924
M	14 x 0.75	100	22	10	11.0	9.0	34825	34925
M	14 x 1.0	100	22	11	11.0	9.0	34826	34926
M	14 x 1.25	100	22	15	11.0	9.0	34827	34927
M	14 x 1.5	100	22	15	11.0	9.0	34828	34928

D = Nominal Diameter

L1 = Overall Length

L2 = Thread Length

D2 = Shank Diameter

Square = Drive Connector



D	L1	L2		D2	Square	Art.-No.*		
		Form B	Form C			Form B	Form C	
M	15 x 1.0	100	22	12	12.0	9.0	34829	34929
M	15 x 1.5	100	22	15	12.0	9.0	34830	34930
M	16 x 1.0	100	22	12	12.0	9.0	34831	34931
M	16 x 1.25	100	22	15	12.0	9.0	34832	34932
M	16 x 1.5	100	22	15	12.0	9.0	34833	34933
M	18 x 1.0	110	25	13	14.0	11.0	34834	34934
M	18 x 1.25	110	25	15	14.0	11.0	34835	34935
M	18 x 1.5	110	25	17	14.0	11.0	34836	34936
M	18 x 2.0	125	34	20	14.0	11.0	34837	34937
M	20 x 1.0	125	25	14	16.0	12.0	34838	34938
M	20 x 1.25	125	25	17	16.0	12.0	34839	34939
M	20 x 1.5	125	25	17	16.0	12.0	34840	34940
M	20 x 2.0	140	34	20	16.0	12.0	34841	34941
M	21 x 1.5	125	25	17	16.0	12.0	34842	34942
M	22 x 1.0	125	25	14	18.0	14.5	34843	34943
M	22 x 1.25	125	25	17	18.0	14.5	34844	34944
M	22 x 1.5	125	25	17	18.0	14.5	34845	34945
M	22 x 2.0	140	34	20	18.0	14.5	34846	34946
M	23 x 1.5	125	25	17	18.0	14.5	34847	34947
M	24 x 1.0	140	28	15	18.0	14.5	34848	34948
M	24 x 1.25	140	28	17	18.0	14.5	34849	34949
M	24 x 1.5	140	28	20	18.0	14.5	34850	34950
M	24 x 2.0	140	28	20	18.0	14.5	34851	34951
M	25 x 1.0	140	28	15	18.0	14.5	34852	34952
M	25 x 1.5	140	28	20	18.0	14.5	34853	34953
M	26 x 1.0	140	28	15	18.0	14.5	3485X	3495X
M	26 x 1.5	140	28	20	18.0	14.5	34854	34954
M	26 x 2.0	140	28	20	18.0	14.5	34855	34955
M	27 x 1.0	140	28	15	20.0	16.0	34800	34900
M	27 x 1.5	140	28	20	20.0	16.0	34856	34956
M	27 x 2.0	140	28	20	20.0	16.0	34857	34957
M	28 x 1.0	140	28	15	20.0	16.0	34858	34958
M	28 x 1.5	140	28	20	20.0	16.0	34859	34959
M	28 x 2.0	140	28	20	20.0	16.0	34860	34960
M	29 x 1.5	150	28	22	22.0	18.0	34861	34961
M	30 x 1.0	150	28	17	22.0	18.0	34862	34962
M	30 x 1.5	150	28	22	22.0	18.0	34863	34963
M	30 x 2.0	150	28	22	22.0	18.0	34864	34964
M	30 x 2.5	180	45	27	22.0	18.0	3486X	3496X
M	30 x 3.0	180	45	30	22.0	18.0	34865	34965
M	32 x 1.5	150	28	22	22.0	18.0	34866	34966



D		L1	L2	L2	D2	Square	Art.-No.*	Art.-No.**
			Form B	Form C			Form B	Form C
M	32 x 2.0	150	28	22	22.0	18.0	34867	34967
M	32 x 3.0	180	50	30	22.0	18.0	34892	34992
M	33 x 1.5	160	30	24	25.0	20.0	34893	34993
M	33 x 2.0	160	30	24	25.0	20.0	34868	34968
M	33 x 3.0	180	50	30	25.0	20.0	34869	34969
M	34 x 1.5	170	30	24	28.0	22.0	34870	34970
M	34 x 2.0	170	30	24	28.0	22.0	34871	34971
M	35 x 1.5	170	30	24	28.0	22.0	34872	34972
M	36 x 1.5	170	30	24	28.0	22.0	34873	34973
M	36 x 2.0	170	30	24	28.0	22.0	34874	34974
M	36 x 3.0	200	56	30	28.0	22.0	34875	34975
M	38 x 1.5	170	30	24	28.0	22.0	34876	34976
M	39 x 1.5	170	30	25	28.0	22.0	34877	34977
M	39 x 2.0	170	30	25	32.0	24.0	34878	34978
M	39 x 3.0	200	60	30	32.0	24.0	34879	34979
M	40 x 1.5	170	30	25	32.0	24.0	34880	34980
M	40 x 2.0	170	30	25	32.0	24.0	34881	34981
M	40 x 3.0	200	60	30	32.0	24.0	34882	34982
M	42 x 1.5	170	30	25	32.0	24.0	34883	34983
M	42 x 2.0	170	30	25	32.0	24.0	34884	34984
M	42 x 3.0	200	60	30	32.0	24.0	34885	34985
M	45 x 1.5	180	32	27	36.0	29.0	34886	34986
M	45 x 2.0	180	32	27	36.0	29.0	34887	34987
M	45 x 3.0	200	50	30	36.0	29.0	34888	34988
M	48 x 1.5	190	32	27	36.0	29.0	34889	34989
M	48 x 2.0	190	32	27	36.0	29.0	34890	34990
M	48 x 3.0	225	50	33	36.0	29.0	34891	34991
M	50 x 1.5	190	32	27	36.0	29.0	34894	34994
M	50 x 2.0	190	32	27	36.0	29.0	34895	34995
M	50 x 3.0	225	50	33	36.0	29.0	34896	34996
M	52 x 1.5	190	32	27	40.0	32.0	34897	34997
M	52 x 2.0	190	32	27	40.0	32.0	34898	34998
M	52 x 3.0	225	50	33	40.0	32.0	34899	34999



BSW (Whitworth-thread)



Machine taps ≈ DIN 371/376 Form B HSS-E - BSW
+ ≈ DIN 371/376 Form C 35°RSP HSS-E - BSW

Type of thread: Whitworth-thread BS 84

Variants (8/13+8/13):

**Application/
for general use:**

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



DIN 371	L1	L2	L2	D2	Square	Art.-No.*	Art.-No.**
D		Form B	Form C			Form B	Form C
BSW 1/8 x 40	56	11	7	3.5	2.7	70506	70706
BSW 5/32 x 32	63	13	7	4.5	3.4	70508	70708
BSW 3/16 x 24	70	15	10	6.0	4.9	70510	70710
BSW 1/4 x 20	80	17	13	7.0	5.5	70514	70714
BSW 5/16 x 18	90	20	14	8.0	6.2	70516	70716
BSW 3/8 x 16	100	22	16	9.0	7.0	70518	70718
BSW 7/16 x 14	100	22	17	11.0	9.0	70520	70720
BSW 1/2 x 12	110	25	20	12.0	9.0	70522	70722



DIN 376	L1	L2	L2	D2	Square	Art.-No.*	Art.-No.**
D		Form B	Form C			Form B	Form C
BSW 1/4 x 20	80	17	13	4.5	3.4	71514	71714
BSW 5/16 x 18	90	20	14	6.0	4.9	71516	71716
BSW 3/8 x 16	100	22	16	7.0	5.5	71518	71718
BSW 7/16 x 14	100	22	17	8.0	6.2	71520	71720
BSW 1/2 x 12	110	25	20	9.0	7.0	71522	71722
BSW 9/16 x 12	110	26	20	11.0	9.0	71524	71724
BSW 5/8 x 11	110	27	22	12.0	9.0	71526	71726
BSW 3/4 x 10	125	30	25	14.0	11.0	71530	71730
BSW 7/8 x 9	140	32	27	18.0	14.5	71534	71734
BSW 1" x 8	160	36	30	20.0	16.0	71538	71738
BSW 1.1/4 x 7	180	40	35	22.0	18.0	71546	71746
BSW 1.3/8 x 6	200	50	40	28.0	22.0	71550	71750
BSW 1.1/2 x 6	200	50	40	32.0	24.0	71554	71754



Machine taps

ISO 529 HSS-G - BSW + ISO 529 35°RSP HSS-G - BSW

Type of thread: Whitworth-thread BS 84

Variants (21/16):

Application/

for general use:

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



D	L1	L2	D2	Square	Art.-No.*	Art.-No.** RSP
BSW 1/8 x 40	48	11	3.15	2.5	84506	84706
BSW 5/32 x 24	53	13	4	3.15	84508	-
BSW 3/16 x 24	58	16	5	4	84510	84710
BSW 7/32 x 24	62	17	5.6	4.5	84512	-
BSW 1/4 x 20	66	19	6.3	5	84514	84714
BSW 5/16 x 18	72	22	8	6.3	84516	84716
BSW 3/8 x 16	80	24	10	8	84518	84718
BSW 7/16 x 14	85	25	8	6.3	84520	84720
BSW 1/2 x 12	89	29	9	7.1	84522	84722
BSW 9/16 x 12	95	30	11.2	9	84524	84724
BSW 5/8 x 11	102	32	12.5	10	84526	84726
BSW 3/4 x 10	112	37	14	11.2	84530	84730
BSW 7/8 x 9	118	38	16	12.5	84534	84734
BSW 1" x 8	130	45	18	14	84538	84738
BSW 1.1/8 x 7	138	48	20	16	84540	84740
BSW 1.1/4 x 7	151	51	22.4	18	84542	84742
BSW 1.3/8 x 7	162	57	25	20	-	84744
BSW 1.1/2 x 6	170	60	28	22.4	84546	84746
BSW 1.5/8 x 5	170	60	28	22.4	84548	-
BSW 1.3/4 x 5	187	67	31.5	25	84550	-
BSW 2.1/4 x 4	221	76	40	31.5	84556	-
BSW 2.1/2 x 4	224	79	40	31.5	84558	-



BSF (brit. standard fine)



Machine taps

ISO 529 HSS-G - BSF + ISO 529 35°RSP HSS-G - BSF

Type of thread: British-Standard-Fine-thread BS 84

Variants (10/10):

Application/

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



D		L1	L2	D2	Square	Art.-No.*	Art.-No.** RSP
BSF	3/16 x 32	58	16	5	4	85510	85710
BSF	1/4 x 26	66	19	6.3	5	85514	85714
BSF	5/16 x 22	69	19	8	6.3	85516	85716
BSF	3/8 x 20	76	20	10	8	85518	85718
BSF	7/16 x 18	82	22	8	6.3	85520	85720
BSF	1/2 x 16	84	24	9	7.1	85522	85722
BSF	5/8 x 14	95	25	12.5	10	85526	85726
BSF	3/4 x 12	104	29	14	11.2	85530	85730
BSF	7/8 x 11	113	33	16	12.5	85534	85734
BSF	1" x 10	120	35	18	14	85538	85738



UNC (Unified Coarse)



Machine taps

≈ DIN 371/376 Form B HSS-E - UNC

+ ≈ DIN 371/376 Form C 35°RSP HSS-E - UNC

Type of thread: Unified Coarse thread ANSI B 1.1

Tolerance: 2B

Variants (9/20+9/20):

Application/ for general use:

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



DIN 371

D		L1	L2 Form B	L2 Form C	D2	Square	Art.-No.* Form B	Art.-No.** Form C
UNC	No. 4 x 40	50	10	6	3.5	2.7	74504	74704
UNC	No. 5 x 40	56	11	7	3.5	2.7	74505	74705
UNC	No. 6 x 32	56	12	7	4.0	3.0	74506	74706
UNC	No. 8 x 32	63	13	8	4.5	3.4	74508	74708
UNC	No. 10 x 24	70	15	10	6.0	4.9	74510	74710
UNC	No. 12 x 24	70	16	10	6.0	4.9	74512	74712
UNC	1/4 x 20	80	17	13	7.0	5.5	74514	74714
UNC	5/16 x 18	90	20	14	8.0	6.2	74516	74716
UNC	3/8 x 16	100	22	16	9.0	7.0	74518	74718



DIN 376

D		L1	L2 Form B	L2 Form C	D2	Square	Art.-No.* Form B	Art.-No.** Form C
UNC	No. 4 x 40	50	10	6	1.8	-	75504	75704
UNC	No. 5 x 40	56	11	7	2.2	1.8	75505	75705
UNC	No. 6 x 32	56	12	7	2.5	2.1	75506	75706
UNC	No. 8 x 32	63	13	8	2.8	2.1	75508	75708
UNC	No. 10 x 24	70	15	10	3.5	2.7	75510	75710
UNC	No. 12 x 24	70	16	10	3.5	2.7	75512	75712
UNC	1/4 x 20	80	17	13	4.5	3.4	75514	75714
UNC	5/16 x 18	90	20	14	6.0	4.9	75516	75716
UNC	3/8 x 16	100	22	16	7.0	5.5	75518	75718
UNC	7/16 x 14	100	22	17	8.0	6.2	75520	75720
UNC	1/2 x 13	110	25	20	9.0	7.0	75522	75722



DIN 376		L1	L2	L2	D2	Square	Art.-No.*	Art.-No.**
D			Form B	Form C			Form B	Form C
UNC	9/16 x 12	110	26	20	11.0	9.0	75524	75724
UNC	5/8 x 11	110	27	22	12.0	9.0	75526	75726
UNC	3/4 x 10	125	30	25	14.0	11.0	75530	75730
UNC	7/8 x 9	140	32	27	18.0	14.5	75534	75734
UNC	1" x 8	160	36	30	20.0	16.0	75538	75738
UNC	1.1/4 x 7	180	40	35	22.0	18.0	75546	75746
UNC	1.1/2 x 6	200	50	40	32.0	24.0	75554	75754
UNC	1.3/4 x 5	220	65	45	36.0	29.0	75562	75762
UNC	2" x 4.1/2	250	70	50	40.0	32.0	75570	75770



Machine taps

ISO 529 HSS-G - UNC ≈ DIN 376
+ ISO 529 35°RSP HSS-G - UNC ≈ DIN 376

Type of thread: Unified Coarse thread ANSI B 1.1

Tolerance: 2B

Variants (19/19):

Application/

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



D		L1	L2	D2	Square	Art.-No.*	Art.-No.**
							RSP
UNC	No. 10 x 24	58	16	5	4	82510	82710
UNC	1/4 x 20	66	19	6.3	5	82514	82714
UNC	5/16 x 18	72	22	8	6.3	82516	82716
UNC	3/8 x 16	80	24	10	8	82518	82718
UNC	7/16 x 14	85	25	8	6.3	82520	82720
UNC	1/2 x 13	89	29	9	7.1	82522	82722
UNC	9/16 x 12	95	30	11.2	9	82524	82724
UNC	5/8 x 11	102	32	12.5	10	82526	82726
UNC	3/4 x 10	112	37	14	11.2	82530	82730
	7/8 x 9	118	38	18	12.5	82534	82734
	1" x 8	130	45	16	14	82538	82738
	1.1/8 x 7	138	48	20	16	82540	82740
	1.1/4 x 7	151	51	22.4	18	82542	82742
UNC	No. 1.3/8 x 6	162	57	25	20	82544	82744
UNC	No. 1.1/2 x 6	170	60	28	22.4	82546	82746
UNC	No. 1.5/8 x 5	170	60	28	22.4	82547	82748
UNC	No. 1.3/4 x 5	187	67	31.5	25	82548	82750
UNC	No. 1.7/8 x 5	187	67	31.5	25	82549	82752
UNC	No. 2" x 4.5	200	70	35.5	28	82550	82754



Machine taps

JIS B-4430 HSS-E - UNC + JIS B-4430 HSS-E - UNC

Type of thread: Unified Coarse thread ANSI B 1.1

Variants (16/19):



Application/

for general use:

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

D		L1	L2	D2	Square	Art.-No.*	Art.-No.**
UNC	No. 4 x 40	45	10	3	2.5	93504	93704
UNC	No. 5 x 40	47	12	4	3.2	93505	93705
UNC	No. 6 x 32	49	14	4	3.2	93506	93706
UNC	No. 8 x 32	53	14	5	4	93508	93708
UNC	No. 10 x 24	61	17	5.5	4.5	93509	93709
UNC	No. 12 x 24	61	17	5.5	4.5	93510	93710
UNC	1/8 x 40	47	11	4	3.2	-	93711
UNC	5/32 x 32	53	14	5	4	-	93712
UNC	3/16 x 24	60	17	5.5	4.5	-	93713
UNC	1/4 x 20	62	20	6	4.5	93514	93714
UNC	5/16 x 18	70	23	6.1	5	93515	93715
UNC	3/8 x 16	75	25	7	5.5	93516	93716
UNC	7/16 x 14	80	24	8	6	93517	93717
UNC	1/2 x 13	85	30	9	7	93518	93718
UNC	9/16 x 12	90	30	10.5	8	93519	93719
UNC	5/8 x 11	95	32	12	9	93520	93720
UNC	3/4 x 10	105	38	14	11	93522	93722
UNC	7/8 x 9	115	38	17	13	93524	93724
UNC	1" x 8	126	45	20	15	93526	93726



UNF (Unified fine thread)



Machine taps

≈ DIN 371/376 Form B HSS-E - UNF

+ ≈ DIN 371/376 Form C 35°RSP HSS-E - UNF

Type of thread: Unified Fine thread ANSI B 1.1

Tolerance: 2B

Variants (9/10+9/10):

Application/ for general use:

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



DIN 371		L1	L2	L2	D2	Square	Art.-No.*	Art.-No.**
D			Form B	Form C			Form B	Form C
UNF	No. 4 x 48	50	10	6	3.5	2.7	76504	76704
UNF	No. 5 x 44	56	11	7	3.5	2.7	76505	76705
UNF	No. 6 x 40	56	12	7	4.0	3.0	76506	76706
UNF	No. 8 x 36	63	13	8	4.5	3.4	76508	76708
UNF	No. 10 x 32	70	15	10	6.0	4.9	76510	76710
UNF	No. 12 x 28	70	16	10	6.0	4.9	76512	76712
UNF	1/4 x 28	80	17	10	7.0	5.5	76514	76714
UNF	5/16 x 24	90	17	10	8.0	6.2	76516	76716
UNF	3/8 x 24	100	18	10	9.0	7.0	76518	76718



DIN 376		L1	L2	L2	D2	Square	Art.-No.*	Art.-No.**
D			Form B	Form C			Form B	Form C
UNF	7/16 x 20	100	22	13	8.0	6.2	77520	77720
UNF	1/2 x 20	100	22	13	9.0	7.0	77522	77722
UNF	9/16 x 18	100	22	15	11.0	9.0	77524	77724
UNF	5/8 x 18	100	22	15	12.0	9.0	77526	77726
UNF	3/4 x 16	110	25	17	14.0	11.0	77530	77730
UNF	7/8 x 14	140	26	17	18.0	14.5	77534	77734
UNF	1" x 14	150	28	20	20.0	16.0	77540	77740
UNF	1" x 12	150	28	20	20.0	16.0	77538	77738
UNF	1.1/4 x 12	150	30	22	22.0	18.0	77546	77746
UNF	1.1/2 x 12	170	33	25	32.0	24.0	77554	77754



Machine taps

ISO 529 HSS-G - UNF ≈ DIN 371 + ISO 529 35°SP HSS-G - UNF ≈ DIN 371

Type of thread: Unified Fine thread ANSI B 1.1

Tolerance: 2B

Variants (14/14):

Application/

for general use:

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



D		L1	L2	D2	Square	Art.-No.*	Art.-No.** SP
UNF	1/4 x 28	66	19	6.3	5	83514	83714
UNF	5/16 x 24	69	19	8	6.3	83516	83716
UNF	3/8 x 24	76	20	10	8	83518	83718
UNF	7/16 x 20	82	22	8	6.3	83520	83720
UNF	1/2 x 20	84	24	9	7.1	83522	83722
UNF	9/16 x 18	90	25	11.2	9	83524	83724
UNF	5/8 x 18	95	25	12.5	10	83526	83726
UNF	3/4 x 16	104	29	14	11.2	83530	83730
UNF	7/8 x 14	113	33	16	12.5	83534	83734
UNF	1" x 12	120	35	18	14	83538	83738
UNF	1.1/8 x 12	127	37	20	16	83540	83740
UNF	1.1/4 x 12	137	37	22.4	18	83542	83742
UNF	1.3/8 x 12	144	39	25	20	83544	83744
UNF	1.1/2 x 12	149	39	28	22.4	83546	83746



Machine taps

JIS B-4430 HSS-E - UNF + JIS B-4430 HSS-E - UNF

Type of thread: Unified Fine thread ANSI B 1.1

Variants (19/19):

Application/

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



D		L1	L2	D2	Square	Art.-No.*	Art.-No.**
UNF	No. 4 x 48	45	10	3	2.5	93554	93754
UNF	No. 5 x 44	47	12	4	3.2	93555	93755
UNF	No. 6 x 40	49	14	4	3.2	93556	93756
UNF	No. 8 x 36	53	14	5	4	93558	93758
UNF	No. 10 x 32	61	17	5.5	4.5	93559	93759
UNF	No. 12 x 28	61	17	5.5	4.5	93560	93760
UNF	1/8 x 44	47	11	4	3.2	93561	93761
UNF	5/32 x 36	53	14	5	4	93562	93762
UNF	3/16 x 32	60	17	5.5	4.5	93563	93763
UNF	1/4 x 28	62	20	6	4.5	93564	93764
UNF	5/16 x 24	70	23	6.1	5	93565	93765
UNF	3/8 x 24	75	25	7	5.5	93566	93766
UNF	7/16 x 20	80	24	8	6	93567	93767
UNF	1/2 x 20	85	30	9	7	93568	93768
UNF	9/16 x 18	90	30	10.5	8	93569	93769
UNF	5/8 x 18	95	32	12	9	93570	93770
UNF	3/4 x 16	105	38	14	11	93572	93772
UNF	7/8 x 14	115	38	17	13	93574	93774
UNF	1" x 12	126	45	20	15	93576	93776



UNEF (Unified extra fine)



Machine taps

ISO 529 Form B HSS-E - UNEF + ISO 529 Form C 35°RSP HSS-E - UNEF

Type of thread: Unified Extra Fine thread ANSI B 1.1

Tolerance: 2B

Variants (27/14):

Application/ for general use:

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



D	L1	L2	D2	Square	Art.-No.*	Art.-No.** SP
UNEF No. 12 x 32	62	17	5.6	4.5	83320	83370
UNEF 1/4 x 32	66	19	6.3	5.0	83321	83371
UNEF 5/16 x 32	72	22	8.0	6.3	83322	83372
UNEF 3/8 x 32	80	24	10.0	8.0	83324	83373
UNEF 7/16 x 28	85	25	8.0	6.3	83325	83374
UNEF 1/2 x 28	89	29	9.0	7.1	83326	83375
UNEF 9/16 x 24	95	30	11.2	9.0	83327	83376
UNEF 5/8 x 24	102	32	12.5	10.0	83328	83377
UNEF 11/16 x 24	112	37	14.0	11.2	83329	83378
UNEF 3/4 x 20	112	37	14.0	11.2	83330	83379
UNEF 13/16 x 20	118	38	16.0	12.5	83331	83380
UNEF 7/8 x 20	118	38	16.0	12.5	83332	83381
UNEF 15/16 x 20	130	45	18.0	14.0	83333	83382
UNEF 1" x 20	130	45	18.0	14.0	83334	83383
UNEF 1.1/16 x 18	138	48	20.0	16.0	83335	-
UNEF 1.1/8 x 18	138	48	20.0	16.0	83336	-
UNEF 1.3/16 x 18	151	51	22.4	18.0	83337	-
UNEF 1.1/4 x 18	151	51	22.4	18.0	83338	-
UNEF 1.5/16 x 18	162	57	25.0	20.0	83339	-
UNEF 1.3/8 x 18	162	57	25.0	20.0	83340	-
UNEF 1.7/16 x 18	170	60	28.0	22.4	83341	-
UNEF 1.1/2 x 18	170	60	28.0	22.4	83342	-
UNEF 1.9/16 x 18	170	60	28.0	22.4	83343	-
UNEF 1.5/8 x 18	170	60	28.0	22.4	83344	-
UNEF 1.11/16 x 18	187	67	31.5	25.0	83345	-
UNEF 1.3/4 x 18	187	67	31.5	25.0	83346	-
UNEF 2" x 18	200	70	35.5	28.0		-



8 - UN / 12 - UN



Machine taps

ISO 529 Form B HSS-E - UNx8/UNx12
+ ISO 529 Form C 35°RSP HSS-E - UNx8/UNx12

Type of thread: Unified thread ANSI B 1.1

Tolerance: 2B

Variants (20/13+20/13):

Application/ for general use:

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



UNx8 D		L1	L2	D2	Square	Art.-No.* Form B	Art.-No.** Form C
UN	1.1/16 x 8	138	48	20.0	16.0	83101	83151
UN	1.1/8 x 8	138	48	20.0	16.0	83102	83152
UN	1.3/16 x 8	151	51	22.4	18.0	83103	83153
UN	1.1/4 x 8	151	51	22.4	18.0	83104	83154
UN	1.5/16 x 18	162	57	25.0	20.0	83105	83155
UN	1.3/8 x 8	162	57	25.0	20.0	83106	83156
UN	1.1/2 x 8	170	60	28.0	22.4	83107	83157
UN	1.5/8 x 8	170	60	28.0	22.4	83108	83158
UN	1.3/4 x 8	187	67	31.5	25.0	83109	83159
UN	1.7/8 x 8	187	67	31.5	25.0	83110	83160
UN	2" x 8	200	70	35.5	28.0	83111	83161
UN	2.1/8 x 8	200	70	35.5	28.0	83112	83162
UN	2.1/4 x 8	221	76	40.0	31.5	83113	83163
UN	2.1/2 x 8	224	79	40.0	31.5	83115	83165
UN	2.3/4 x 8	234	79	45.0	35.5	83116	83166
UN	3" x 8	258	83	50.0	40.0	83117	83167
UN	3.1/4 x 8	261	86	50.0	40.0	83118	83168
UN	3.1/2 x 8	261	86	50.0	40.0	83119	83169
UN	3.3/4 x 8	279	89	56.0	45.0	83120	83170
UN	4" x 8	279	89	56.0	45.0	83121	83171



UNx12		L1	L2	D2	Square	Art.-No.*	Art.-No.**
D						Form B	Form C
UN	1.5/8 x 12	170	60	28.0	22.4	83301	83351
UN	1.3/4 x 12	187	67	31.5	25.0	83302	83352
UN	1.7/8 x 12	187	67	31.5	25.0	83303	83353
UN	2" x 12	200	70	35.5	28.0	83304	83354
UN	2.1/8 x 12	200	70	35.5	28.0	83305	83355
UN	2.1/4 x 12	221	76	40.0	31.5	83306	83356
UN	2.1/2 x 12	224	79	40.0	31.5	83308	83358
UN	2.3/4 x 12	234	79	45.0	35.5	83309	83359
UN	3" x 12	258	83	50.0	40.0	83310	83360
UN	3.1/4 x 12	261	86	50.0	40.0	83311	83361
UN	3.1/2 x 12	261	86	50.0	40.0	83312	83362
UN	3.3/4 x 12	279	89	56.0	45.0	83313	83363
UN	4" x 12	279	89	56.0	45.0	83314	83364



UN / UNS



Machine taps

ISO 529 Form B HSS-E - UN/UNS

Type of thread: Unified thread ANSI B 1.1

Tolerance: 2B

Variants (13/10):

Application/ for general use:

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

UN D		L1	L2	D2	Square	Art.-No. Form B
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

UNS D		L1	L2	D2	Square	Art.-No. Form B
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



G (BSP) Pipe-thread



Machine taps

- DIN 5156 Form B HSS-E/HSS-E TiN - G (BSP)
- + DIN 5156 Form C HSS-E/HSS-E TiN - G (BSP)
- + DIN 5156 Form C 35°RSP HSS-E/HSS-E TiN - G (BSP)

Type of thread: Pipe-thread DIN ISO 228

Variants (14/6+14/6+14/6):

Application/ for general use:

- > non abrasive material up to 900 N/mm²

- > unalloyed and low alloyed steel
- > for through holes*
- > for blind holes**
- > for through and blind holes***



HSS-E

D		L1	L2	D2	Square	Art.-No.** Form B	Art.-No.* Form C	Art.-No.** Form C 35°
G	1/8 x 28	90	20	7.0	5.5	78512	78412	78712
G	1/4 x 19	100	22	11.0	9.0	78514	78414	78714
G	3/8 x 19	100	22	12.0	9.0	78516	78416	78716
G	1/2 x 14	125	25	16.0	12.0	78518	78418	78718
G	5/8 x 14	125	25	18.0	14.5	78520	78420	78720
G	3/4 x 14	140	28	20.0	16.0	78522	78422	78722
G	7/8 x 14	150	28	22.0	18.0	78524	78424	78724
G	1" x 11	160	30	25.0	20.0	78526	78426	78726
G	1.1/8 x 11	170	30	28.0	22.0	78530	78430	78730
G	1.1/4 x 11	170	30	32.0	24.0	78534	78434	78734
G	1.3/8 x 11	180	32	36.0	29.0	78538	78438	78738
G	1.1/2 x 11	190	32	36.0	29.0	78542	78442	78742
G	1.3/4 x 11	190	32	40.0	32.0	78550	78450	78750
G	2" x 11	220	40	45.0	35.0	78554	78454	78754

TIN-coating:

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



HSS-E TiN

D		L1	L2	D2	Square	Art.-No.* Form B	Art.-No.* Form C	Art.-No.** Form C 35°
G	1/8 x 28	90	20	7.0	5.5	78513	78413	78713
G	1/4 x 19	100	22	11.0	9	78515	78415	78715
G	3/8 x 19	100	22	12.0	9	78517	78417	78717
G	1/2 x 14	125	25	16.0	12	78519	78419	78719
G	3/4 x 14	140	28	20.0	16	78523	78423	78723
G	1" x 11	160	30	25.0	20	78527	78427	78727



G (BSP) left hand (LH)



Machine taps, left hand

DIN 5156 Form C HSS-E - G (BSP) LH

Type of thread: Pipe-thread DIN ISO 228

Variants (7):

**Application/
for general use:**

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

D		L1	L2	D2	Square	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



Rc (BSPT)



Machine taps

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

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

Variants (6):

Application/ for general use:

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

D		L1	L2	D2	Square	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



NPT (tapered pipe thread)



Machine taps

Form C HSS-E - NPT

Type of thread: american tapered pipe thread, taper 1:16

Variants (7):

Application/ for general use:

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

D		L1	L2	D2	Square	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



Rd (knuckle thread)



The round thread is a knuckle thread, shaped to ensure it is not susceptible to dirt to ensure low maintenance. Common applications: Coupler shafts on railway vehicles, brake rods, respirators.

Machine taps for knuckle threads

Knuckle thread screw taps are suitable for materials with good machinability up to 900 N/mm², non-alloy and low-alloy steels, and for through and blind holes.

- Taps for knuckle threads (Rd) acc. to DIN 374
- Machine taps Rd 8 - Rd 44



Machine taps

DIN 374 Form C HSS-E - Rd

Type of thread: Knuckled Thread DIN 405

Tolerance: 7H

Variants (21):

- Application/ for general use:**
- non abrasive material up to 900 N/mm²
 - unalloyed and low alloyed steel
 - for through and blind holes

D	L1	L2	D2	Square	Art.-No.	D	L1	L2	D2	Square	Art.-No.
Rd 8 x 1/10	90	26	6	4.9	79440	Rd 26 x 1/8	160	36	20	16	79451
Rd 9 x 1/10	90	26	7	5.5	79441	Rd 28 x 1/8	160	36	20	16	79452
Rd 10 x 1/10	100	28	7	5.5	79442	Rd 30 x 1/8	180	36	22	18	79453
Rd 11 x 1/10	100	28	8	6.2	79443	Rd 32 x 1/8	180	36	25	20	79454
Rd 12 x 1/10	110	28	9	7	79444	Rd 34 x 1/8	200	36	28	22	79455
Rd 14 x 1/8	110	32	11	9	79445	Rd 36 x 1/8	200	36	28	22	79456
Rd 16 x 1/8	110	32	12	9	79446	Rd 38 x 1/8	200	38	28	22	79457
Rd 18 x 1/8	125	32	14	11	79447	Rd 40 x 1/6	200	50	32	24	79458
Rd 20 x 1/8	140	32	16	12	79448	Rd 42 x 1/6	200	50	32	24	79459
Rd 22 x 1/8	140	32	18	14.5	79449	Rd 44 x 1/6	200	50	36	29	79460
Rd 24 x 1/8	160	34	18	14.5	79450						



FG / BSC (cycle threads)



Machine taps

DIN 374 Form C HSS-E - BSC + DIN 374 Form C HSS-E - FG

Type of thread: British Cycle Thread BS 811
+ Cycle Thread DIN 790012

Tolerance: medium

Variants (6/9):

Application/ for general use:

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

BSC D		L1	L2	D2	Square	Art.-No. Form C
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
FG D		L1	L2	D2	Square	Art.-No. Form C
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



Vg (valve thread)



Machine taps

DIN 374 Form C HSS-E - Vg

Type of thread: Valve Thread DIN 7756

Tolerance: medium

Variants (6):

Application/ for general use:

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

D		L1	L2	D2	Square	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



Combined Machine Taps





Combined machine taps

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. This tool can produce through threads up to a maximum threaded depth of 2 x D. The Combined Tap is suitable for universal use in materials of medium mechanical strength: non-alloyed and alloyed steel sorts up to 600 N/mm², malleable cast iron, nodulized graphite cast iron, copper, brass, aluminium, aluminium-magnesium and zinc alloys, red bronze, electron metal, pressure-cast zinc. This tool should be used on machines possessing an RP 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.



P.K.370 Combined taps (set of 7 pcs.) (47837)

M 3 - M 12

Type of thread	Tolerance	Material	Packing	Size
metric ISO thread DIN 13	ISO 2 /6H	HSS-E	in plastic case	Diameter M 3 - 12

Contents:

	Art. -No.		Art. -No.
1x Combined Machine Tap, M 3 x 0,5	37026	1x Combined Machine Tap, 8 x 1,25	37042
1x Combined Machine Tap, M 4 x 0,7	37030	1x Combined Machine Tap, M 10 x 1,5	37046
1x Combined Machine Tap, M 5 x 0,8	37034	1x Combined Machine Tap, M 12 x 1,75	37050
1x Combined Machine Tap, M 6 x 1,0	37038		



P.K.700 Combined taps (set of 7 pcs.) (47870)

BSW 1/8 - BSW 1/2

Type of thread	Material	Packing	Size
Whitworth-thread BS 84	HSS-E	in plastic case	Diameter BSW 1/8 - 1/2

Contents:

	Art. -No.		Art. -No.
1x Combined Machine Tap, BSW 1/8 x 40	70006	1x Combined Machine Tap, BSW 5/16 x 18	70016
1x Combined Machine Tap, BSW 5/32 x 32	70008	1x Combined Machine Tap, BSW 3/8 x 16	70018
1x Combined Machine Tap, BSW 3/16 x 24	70010	1x Combined Machine Tap, BSW 1/2 x 12	70022
1x Combined Machine Tap, BSW 1/4 x 20	70014		



Combined Machine taps

HSS-E - M + HSS-E - BSW

Type of thread: metric ISO-thread DIN 13
+ Whitworth-thread BS 84

Tolerance: ISO 2 /6H

Variants (7/7):

M		L1	S1	L2	D1	D2	Square	Art.-No.
D								
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

BSW		L1	S1	L2	D1	D2	Square	Art.-No.
D								
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	7.8	10.0	8.0	70018
BSW	1/2 x 12	115	32	35	10.5	12.0	9.0	70022

D = Nominal Diameter

L1 = Overall Length

L2 = Thread Length

D1 = Core hole D

S1 = Length

D2 = Shank Diameter

Square = Drive Connector



G (BSPF)



Machine taps

ISO 529 35°RSP HSS-G - G (BSPF)

Type of thread: Pipe-thread DIN ISO 228

Variants (5):

Application/ for general use:

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

D		L1	L2	D2	Square	Art.-No.
G	1/8 x 28	59	15	8	6.3	86712
G	1/4 x 19	67	19	10	8	86714
G	3/8 x 19	75	21	12.5	10	86716
G	1/2 x 14	87	26	16	12.5	86718
G	3/4 x 14	96	28	20	16	86722



Machine taps

ISO 529 HSS-G - G (BSPF)

Type of thread: Pipe-thread DIN ISO 228

Variants (6):

Application/ for general use:

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

D		L1	L2	D2	Square	Art.-No.
G	1/8 x 28	59	15	8	6.3	86512
G	1/4 x 19	67	19	10	8	86514
G	3/8 x 19	75	21	12.5	10	86516
G	1/2 x 14	87	26	16	12.5	86518
G	3/4 x 14	96	28	20	16	86522
G	1" x 14	109	33	25	20	86526



BSPT



Machine taps

ISO 529 HSS-G - BSPT + ISO 529 HSS-G - NPT

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

Variants (12/11):

Application/ for general use:

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

D	L1	L2	D2	Square	Art.-No. BSPT	Art.-No. NPT
1/16 x 27	52	14	5.6	4.5	-	88410
1/8 x 28	59	15	8	6.3	87412	88412
1/4 x 19	67	19	10	8	87414	88414
3/8 x 19	75	21	12.5	10	87416	88416
1/2 x 14	87	26	16	12.5	87418	88418
5/8 x 14	91	27	18	14	87419	-
3/4 x 14	96	28	20	16	87422	88422
7/8 x 14	96	28	20	16	87423	-
1" x 11	109	33	25	20	87426	88426
1.1/4 x 11	119	36	31.5	25	87434	88434
1.1/2 x 11	125	37	35.5	28	87442	88442
2" x 11	140	41	40	31.5	87454	88454
2.1/2 x 11	153	45	45	35.5	87464	88464
4" x 12	279	89	56.0	45.0	83314	-



W



Machine taps

JIS B-4430 HSS-E - W

Type of thread: tapered Whitworth screw thread
for gas cylinders taper 3.25

Variants (14/14):

Application/ for general use:

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



D		L1	L2	D2	Square	Art.-No.*	Art.-No.**
W	1/8 x 40	47	11	4	3.2	94506	94706
W	5/32 x 32	53	14	5	4	94508	94708
W	3/16 x 24	60	17	5.5	4.5	94510	94710
W	1/4 x 20	62	20	6	4.5	94514	94714
W	5/16 x 18	70	23	6.1	5	94516	94716
W	3/8 x 16	75	25	7	5.5	94518	94718
W	7/16 x 14	80	24	8	6	94520	94720
W	1/2 x 13	85	30	9	7	94522	94722
W	9/16 x 12	90	30	10.5	8	94524	94724
W	5/8 x 11	95	32	12	9	94526	94726
W	3/4 x 10	105	38	14	11	94530	94730
W	7/8 x 9	115	38	17	13	94534	94734
W	1" x 8	126	45	20	15	94538	94738
W	1.1/4 x 17	145	51	24	19	94540	94740



PF



Machine taps

JIS B-4430 HSS-E - PF

Type of thread: Pipe-thread DIN ISO 228

Variants (10/10):

Application/ for general use:

- > Non-abrassive materials up to 900 N/mm²
- > Unalloyed and low alloyed steel
- > For blind holes
- > For thread cutting by machine

D		L1	L2	D2	Square	Art.-No.* Form B	Art.-No.** Form C 35°RSP
PF	1/8 x 28	55	17.5	8	6	96502	96702
PF	1/8 x 28	55	19	8	6	96506	96706
PF	1/4 x 19	62	28	11	9	96514	96714
PF	3/8 x 19	65	28	14	11	96518	96718
PF	1/2 x 14	80	35	18	14	96522	96722
PF	3/4 x 14	85	35	23	17	96530	96730
PF	1" x 11	95	45	26	21	96538	96738
PF	1.1/4 x 11	105	45	32	26	96546	96746
PF	1.1/2 x 11	110	45	38	29	96554	96754
PF	2" x 11	120	50	46	35	96570	96770

Coloured ring Machine Taps





Coloured ring machine taps



... for many materials the right tool

These are machine taps marked with a coloured ring on the shaft. The colour coding corresponds to materials being processed.

Application of coloured ring machine taps:

- GREEN RING: for general use
- BLUE RING: for wear resistant steel
- WHITE RING: for stainless steel
- BLACK RING: for cast iron
- RED RING: material from 1200 N/mm² tensile strength
- YELLOW RING: for aluminium alloys
- ORANGE RING: for brass

GREEN RING



GREEN RING Machine taps

The VOELKEL HSS-E machine taps with green ring are suitable for non abrasive material up to 1000 N/mm².

Recommended application:

- Steel, unalloyed and low alloyed, short-chipping
- non abrasive Material, short-chipping
- Copper, Malleable cast iron
- Brass and bronze, long-chipping
- Aluminium-alloys, long-chipping
- Zinc and Magnesium alloys
- Plastics and thermoplastics



GREEN RING Machine taps (set of 7 pcs.) (47853)

DIN 371/376 M 3 - M 12

Type of thread	Standard	Material	Tolerance	Packing	Size
metric ISO thread DIN 13	DIN 371/376	HSS-E	ISO 2 /6H	in plastic case	Diameter M 3 - 12

Application/ for general use:

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

Contents:

Art. -No.

1x GREEN RING Machine Tap, DIN 371, HSS-E, M 3 x 0,5	35326
1x GREEN RING Machine Tap, DIN 371, HSS-E, M 4 x 0,7	35330
1x GREEN RING Machine Tap, DIN 371, HSS-E, M 5 x 0,8	35334
1x GREEN RING Machine Tap, DIN 371, HSS-E, M 6 x 1,0	35338
1x GREEN RING Machine Tap, DIN 371, HSS-E, M 8 x 1,25	35342
1x GREEN RING Machine Tap, DIN 371, HSS-E, M 10 x 1,5	35346
1x GREEN RING Machine Tap, DIN 376, HSS-E, M 12 x 1,75	35350



GREEN RING Machine taps for blind holes (set of 7 pcs.)

(47863) DIN 371/376 M 3 - M 12

Type of thread	Standard	Material	Tolerance	Packing	Size
metric ISO thread DIN 13	DIN 371/376	HSS-E	ISO 2 /6H	in plastic case	Diameter M 3 - 12

Application/ for general use:

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

Contents:

Art. -No.

1x GREEN RING Machine Tap, DIN 371, HSS-E, M 3 x 0,5	36326
1x GREEN RING Machine Tap, DIN 371, HSS-E, M 4 x 0,7	36330
1x GREEN RING Machine Tap, DIN 371, HSS-E, M 5 x 0,8	36334
1x GREEN RING Machine Tap, DIN 371, HSS-E, M 6 x 1,0	36338
1x GREEN RING Machine Tap, DIN 371, HSS-E, M 8 x 1,25	36342
1x GREEN RING Machine Tap, DIN 371, HSS-E, M 10 x 1,5	36346
1x GREEN RING Machine Tap, DIN 376, HSS-E, M 12 x 1,75	36350



Application/ for general use:

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

GREEN RING Machine taps (set of 7 pcs.) incl. drills ([47856](#)) DIN 371/376 M 3 - M 12

Type of thread	Standard	Material	Tolerance	Packing	Size
metric ISO thread DIN 13	DIN 371/376	HSS-E	ISO 2/6H	in plastic case	Diameter M 3 - 12

Contents:

Art. -No.

1x GREEN RING Machine Tap, DIN 371, HSS-E, M 3 x 0,5	35326
1x GREEN RING Machine Tap, DIN 371, HSS-E, M 4 x 0,7	35330
1x GREEN RING Machine Tap, DIN 371, HSS-E, M 5 x 0,8	35334
1x GREEN RING Machine Tap, DIN 371, HSS-E, M 6 x 1,0	35338
1x GREEN RING Machine Tap, DIN 371, HSS-E, M 8 x 1,25	35342
1x GREEN RING Machine Tap, DIN 371, HSS-E, M 10 x 1,5	35346
1x GREEN RING Machine Tap, DIN 376, HSS-E, M 12 x 1,75	35350
Twist drill 2.5 / 3.3 / 4.2 / 5.0 / 6.8 / 8.5 / 10.2 mm	



Application/ for general use:

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

GREEN RING Machine taps for blind holes (set of 7 pcs.) incl. drills ([47866](#)) DIN 371/376 M 3 - M 12

Type of thread	Standard	Material	Tolerance	Packing	Size
metric ISO thread DIN 13	DIN 371/376	HSS-E	ISO 2/6H	in plastic case	Diameter M 3 - 12

Contents:

Art. -No.

1x GREEN RING Machine Tap, DIN 371, HSS-E, M 3 x 0,5	36326
1x GREEN RING Machine Tap, DIN 371, HSS-E, M 4 x 0,7	36330
1x GREEN RING Machine Tap, DIN 371, HSS-E, M 5 x 0,8	36334
1x GREEN RING Machine Tap, DIN 371, HSS-E, M 6 x 1,0	36338
1x GREEN RING Machine Tap, DIN 371, HSS-E, M 8 x 1,25	36342
1x GREEN RING Machine Tap, DIN 371, HSS-E, M 10 x 1,5	36346
1x GREEN RING Machine Tap, DIN 376, HSS-E, M 12 x 1,75	36350
Twist drill 2.5 / 3.3 / 4.2 / 5.0 / 6.8 / 8.5 / 10.2 mm	



GREEN RING TwinBox

DIN 371 /376 Form B HSS-E - M
+ DIN 371/376 Form C 35°RSP HSS-E - M

Type of thread: metric ISO-thread DIN 13

Tolerance: ISO 2 /6H

Variants (9/9):

Application/

for general use:

- > for through holes*
- > for blind holes**

- > non abrasive material up to 1000 N/mm²
- > unalloyed and low alloyed steel
- > Malleable Cast Iron and Zinc alloys

HSS-CO Twist Drill DIN 338

Type N right, 118° - Spiral: 25-30°

D		Machine tap	Twist drill	Art.-No.*	Art.-No.**
				Form B	Form C
M	3 x 0.5	DIN 371	2.5 mm	35390	36390
M	4 x 0.7	DIN 371	3.3 mm	35391	36391
M	5 x 0.8	DIN 371	4.2 mm	35392	36392
M	6 x 1.0	DIN 371	5.0 mm	35393	36393
M	8 x 1.25	DIN 371	6.8 mm	35394	36394
M	10 x 1.5	DIN 371	8.5 mm	35395	36395
M	12 x 1.75	DIN 376	10.2 mm	35396	36396
M	14 x 2.0	DIN 376	12.0 mm	35397	36397
M	16 x 2.0	DIN 376	14.0 mm	35398	36398



GREEN RING Machine taps

DIN 371/376 Form B HSS-E - M + DIN 371/376 Form C 39°RSP HSS-E - M

Type of thread: metric ISO-thread DIN 13

Tolerance: ISO 2 /6H

Variants (11/11):



Application/

for general use:

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

DIN 371		L1	L2	L2	D2	Square	Art.-No.*	Art.-No.**
D			Form B	Form C			Form B	Form C
M	3 x 0.5	56	11	6	3.5	2.7	35326	36326
M	4 x 0.7	63	13	7	4.5	3.4	35330	36330
M	5 x 0.8	70	16	8	6.0	4.9	35334	36334
M	6 x 1.0	80	19	10	6.0	4.9	35338	36338
M	8 x 1.25	90	22	14	8.0	6.2	35342	36342
M	10 x 1.5	100	24	16	10.0	8.0	35346	36346
DIN 376		L1	L2	L2	D2	Square	Art.-No.*	Art.-No.**
D			Form B	Form C			Form B	Form C
M	12 x 1.75	110	29	18	9.0	7.0	35350	36350
M	14 x 2.0	110	30	20	11.0	9.0	35354	36354
M	16 x 2.0	110	32	22	12.0	9.0	35358	36358
M	18 x 2.5	125	34	25	14.0	11.0	35362	36362
M	20 x 2.5	140	34	25	16.0	12.0	35366	36366



GREEN RING Machine taps

JIS B-4430 HSS-E - M

Type of thread: metric ISO-thread DIN 13

Tolerance: OH1

Variants (28/28):

Application/ for general use:

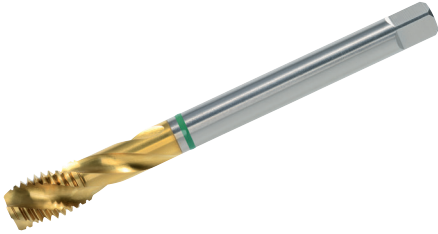
- > non abrasive material up to 1000 N/mm²
- > unalloyed and low alloyed steel
- > long chipping material
- > for through holes*
- > for blind holes**



D		L1	L2 *	L2 **	D2	Square	Art.-No.*	Art.-No.**
M	2 x 0.4	42	8	6	3	2.5	91601	91801
M	2.3 x 0.4	42	8	6	3	2.5	91602	91802
M	2.5 x 0.45	44	8	6	3	2.5	91603	91803
M	2.6 x 0.45	44	8	6	3	2.5	91604	91804
M	3 x 0.5	46	9	6	4	3.2	91605	91805
M	3.5 x 0.6	48	11	7	4	3.2	91606	91806
M	4 x 0.7	52	11	7	5	4	91607	91807
M	5 x 0.8	60	14	8	5.5	4.5	91609	91809
M	6 x 1.0	62	17	10	6	0.45	91611	91811
M	6 x 0.75	62	17	10	6	0.45	91612	91812
M	8 x 1.25	70	20	14	6.2	5	91613	91813
M	8 x 1.0	70	20	14	6.2	5	91614	91814
M	8 x 0.75	70	20	14	6.2	5	91624	91824
M	10 x 1.5	75	22	16	7	5.5	91615	91815
M	10 x 1.25	75	22	16	7	5.5	91616	91816
M	10 x 1.0	75	22	16	7	5.5	91626	91826
M	12 x 1.75	82	27	18	8.5	6.5	91617	91817
M	12 x 1.5	82	27	18	8.5	6.5	91690	91890
M	12 x 1.25	82	27	18	8.5	6.5	91618	91818
M	12 x 1.0	82	27	18	8.5	6.5	91627	91827
M	14 x 2.0	88	28	20	10.5	8	91619	91819
M	14 x 1.5	88	28	20	10.5	8	91620	91820
M	14 x 1.25	88	28	20	10.5	8	91628	91828
M	16 x 2.0	95	30	22	12.5	10	91621	91821
M	16 x 1.5	95	30	22	12.5	10	91622	91822
M	16 x 1.0	95	30	22	12.5	10	91629	91829
M	18 x 2.5	100	32	25	14	11	91623	91823
M	20 x 2.5	105	32	25	15	12	91625	91825



GREEN RING PM



HSS-E PM GREEN RING Machine taps

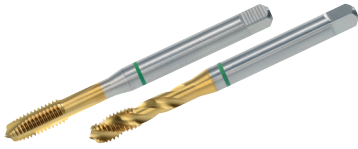
The VOELKEL HSS-E machine taps with green ring are suitable for non abrasive material up to 1000 N/mm².

Recommended application:

- Steel, unalloyed and low alloyed, short-chipping
- non abrasive Material, short-chipping
- heat resistant steel, short- and long-chipping
- Steel, cementation and heat treatable, short-chipping
- Stainless steel, short- and long-chipping
- Brass and bronze, long-chipping
- Aluminium-alloys, long-chipping
- Zinc and Magnesium alloys
- Plastics, thermoplastics
- Copper, Malleable cast iron

Advantages HSSE-PM-TiN Machine taps:

The HSS-E-PM-TiN machine taps have an increased wear resistance and toughness. Furthermore the TiN-coating improves anti-friction properties, thereby improved wear-resistance and reduced tendency of build-up edge.



GREEN RING Machine taps

DIN 371/376 Form B HSS-E PM TiN - M
+ DIN 371/376 Form C 39°RSP HSS-E PM TiN - M

Type of thread: metric ISO-thread DIN 13

Tolerance: ISO 2 /6H

Variants (9/9):

Advantages:

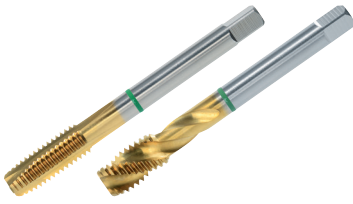
- › made from PM-HSSE V3 Steel
- › increased wear resistance
- › increased toughness
- › improved anti-friction properties by TiN coating
- › longer tool life
- › improved surface finish
- › increased productivity
- › reduced production costs

Application:

- › non abrasive material up to 1000 N/mm²
- › stainless and alloyed steel sorts
- › unalloyed and low alloyed steel
- › Copper- and aluminiumalloys
- › Form B for through holes
- › Form C for blind holes



DIN 371		L1	L2	L2	D2	Square	Art.-No.*	Art.-No.**
D			Form B	Form C			Form B	Form C
M	3 x 0.5	56	11	6	3.5	2.7	30031	30131
M	4 x 0.7	63	13	7	4.5	3.4	30032	30132
M	5 x 0.8	70	14	8	6.0	4.9	30033	30133
M	6 x 1.0	80	16	10	6.0	4.9	30034	30134
M	8 x 1.25	90	18	14	8.0	6.2	30035	30135
M	10 x 1.5	100	22	16	10.0	8.0	30036	30136
DIN 376		L1	L2	L2	D2	Square	Art.-No.*	Art.-No.**
D			Form B	Form C			Form B	Form C
M	12 x 1.75	110	29	18	9.0	7.0	30037	30137
M	14 x 2.0	110	30	20	11.0	9.0	30038	30138
M	16 x 2.0	110	32	22	12.0	9.0	30039	30139



GREEN RING Machine taps

JIS B-4430 HSS-E PM TiN - M
+ JIS B-4430 39°RSP HSS-E PM TiN - M

Type of thread: metric ISO-thread DIN 13

Tolerance: OH2/OH1

Variants (9/9):

Advantages:

- › made from PM-HSSE V3 Steel
- › increased wear resistance
- › increased toughness
- › improved anti-friction properties by TiN coating
- › longer tool life
- › improved surface finish
- › increased productivity
- › reduced production costs

Application:

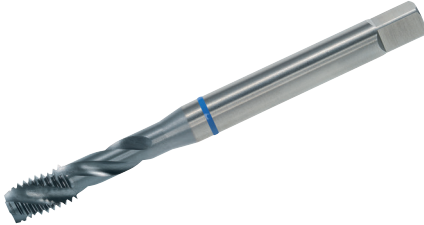
- › non abrasive material up to 1000 N/mm²
- › stainless and alloyed steel sorts
- › unalloyed and low alloyed steel
- › Copper- and aluminiumalloys
- › Form B for through holes
- › Form C for blind holes



D		L1	L2	L2	D2	Square	Art.-No.*	Art.-No.**
			Form B	Form C			Form B	Form C
M	3 x 0.5	46	9	6	4	3.2	91105	91155
M	4 x 0.7	52	11	7	5	4	91107	91157
M	5 x 0.8	60	14	8	5.5	4.5	91108	91158
M	6 x 1.0	62	17	10	6	4.5	91109	91159
M	8 x 1.25	70	20	14	6.2	5	91111	91161
M	10 x 1.5	75	22	16	7	5.5	91113	91163
M	12 x 1.75	82	27	18	8.5	6.5	91115	91165
M	14 x 2.0	88	28	20	10.5	8	91116	91166
M	16 x 2.0	95	30	22	12.5	10	91117	91167



BLUE RING



HSS-E PM BLUE RING Machine taps

The VOELKEL HSS-E PM machine taps with blue ring are suitable for non abrasive material up to 1200 N/mm².

Recommended application:

- › heat resistant steel, short-chipping
- › Steel, cementation and heat treatable, short-chipping
- › Tool steel up to 1200 N/mm²
- › Stainless steel, short-chipping
- › Iron, spheroidal graphite
- › Brass and bronze, short-chipping
- › Aluminium-alloys, short-chipping
- › Magnesium alloys
- › Titanium, short-chipping

HSSE Machine taps with TiCN coating

Machine taps with outstanding wear-resistance due to improved hardness and toughness. Intensive and optimum cooling essential as reduced heat resistance.



BLUE RING Machine taps (set of 7 pcs.) (47854)

DIN 371/376 M 3 - M 12

Type of thread	Standard	Material	Tolerance	Packing	Size
metric ISO thread DIN 13	DIN 371/376	HSS-E	ISO 2/6H	in plastic case	Diameter M 3 - 12

Application/ for general use:

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

Contents:

Art. -No.

1x BLUE RING machine tap, DIN 371, HSS-E, M 3 x 0,5	35426
1x BLUE RING machine tap, DIN 371, HSS-E, M 4 x 0,7	35430
1x BLUE RING machine tap, DIN 371, HSS-E, M 5 x 0,8	35434
1x BLUE RING machine tap, DIN 371, HSS-E, M 6 x 1,0	35438
1x BLUE RING machine tap, DIN 371, HSS-E, M 8 x 1,25	35442
1x BLUE RING machine tap, DIN 371, HSS-E, M 10 x 1,5	35446
1x BLUE RING machine tap, DIN 376, HSS-E, M 12 x 1,75	35450



BLUE RING Machine taps for blind holes (set of 7 pcs.)

(47864) DIN 371/376 M 3 - M 12

Type of thread	Standard	Material	Tolerance	Packing	Size
metric ISO thread DIN 13	DIN 371/376	HSS-E	ISO 2/6H	in plastic case	Diameter M 3 - 12

Application/ for general use:

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

Contents:

Art. -No.

1x BLUE RING machine tap, DIN 371, HSS-E, M 3 x 0,5	36426
1x BLUE RING machine tap, DIN 371, HSS-E, M 4 x 0,7	36430
1x BLUE RING machine tap, DIN 371, HSS-E, M 5 x 0,8	36434
1x BLUE RING machine tap, DIN 371, HSS-E, M 6 x 1,0	36438
1x BLUE RING machine tap, DIN 371, HSS-E, M 8 x 1,25	36442
1x BLUE RING machine tap, DIN 371, HSS-E, M 10 x 1,5	36446
1x BLUE RING machine tap, DIN 376, HSS-E, M 12 x 1,75	36450



Application/ for general use:

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

BLUE RING Machine taps (set of 14 pcs.) incl. drills (47857)

DIN 371/376 M 3 - M 12

Type of thread	Standard	Material	Tolerance	Packing	Size
metric ISO thread DIN 13	DIN 371/376	HSS-E	ISO 2 /6H	in plastic case	Diameter M 3 - 12

Contents:

Art. -No.

1x BLUE RING machine tap, DIN 371, HSS-E, M 3 x 0,5	35426
1x BLUE RING machine tap, DIN 371, HSS-E, M 4 x 0,7	35430
1x BLUE RING machine tap, DIN 371, HSS-E, M 5 x 0,8	35434
1x BLUE RING machine tap, DIN 371, HSS-E, M 6 x 1,0	35438
1x BLUE RING machine tap, DIN 371, HSS-E, M 8 x 1,25	35442
1x BLUE RING machine tap, DIN 371, HSS-E, M 10 x 1,5	35446
1x BLUE RING machine tap, DIN 376, HSS-E, M 12 x 1,75	35450
Twist drill 2.5 / 3.3 / 4.2 / 5.0 / 6.8 / 8.5 / 10.2 mm	



Application/ for general use:

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

BLUE RING Machine taps (set of 14 pcs.) incl. drills (47867)

DIN 371/376 M 3 - M 12

Type of thread	Standard	Material	Tolerance	Packing	Size
metric ISO thread DIN 13	DIN 371/376	HSS-E	ISO 2 /6H	in plastic case	Diameter M 3 - 12

Contents:

Art. -No.

1x BLUE RING machine tap, DIN 371, HSS-E, M 3 x 0,5	36426
1x BLUE RING machine tap, DIN 371, HSS-E, M 4 x 0,7	36430
1x BLUE RING machine tap, DIN 371, HSS-E, M 5 x 0,8	36434
1x BLUE RING machine tap, DIN 371, HSS-E, M 6 x 1,0	36438
1x BLUE RING machine tap, DIN 371, HSS-E, M 8 x 1,25	36442
1x BLUE RING machine tap, DIN 371, HSS-E, M 10 x 1,5	36446
1x BLUE RING machine tap, DIN 376, HSS-E, M 12 x 1,75	36450
Twist drill 2.5 / 3.3 / 4.2 / 5.0 / 6.8 / 8.5 / 10.2 mm	



BLUE RING TwinBox

DIN 371 /376 Form B HSS-E - M
+ DIN 371/376 Form C 35°RSP HSS-E - M

Type of thread: metric ISO-thread DIN 13

Tolerance: ISO 2 /6H

Variants (9/9):

**Application/
for wear resistant steel
up to 1200 N/mm²:**

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

HSS-CO Twist Drill DIN 338

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

D		Machine tap	Twist drill	Art.-No.*	Art.-No.**
				Form B	Form C
M	3 x 0.5	DIN 371	2.5 mm	35490	36490
M	4 x 0.7	DIN 371	3.3 mm	35491	36491
M	5 x 0.8	DIN 371	4.2 mm	35492	36492
M	6 x 1.0	DIN 371	5.0 mm	35493	36493
M	8 x 1.25	DIN 371	6.8 mm	35494	36494
M	10 x 1.5	DIN 371	8.5 mm	35495	36495
M	12 x 1.75	DIN 376	10.2 mm	35496	36496
M	14 x 2.0	DIN 376	12.0 mm	35497	36497
M	16 x 2.0	DIN 376	14.0 mm	35498	36498



GREEN RING Machine taps

- DIN 371/376 Form B HSS-E - M
- + DIN 371/376 Form C 39°RSP HSS-E - M
- + DIN 371/376 Form B HSS-E TiCN - M
- + DIN 371/376 Form C 39°RSP HSS-E TiCN - M

Type of thread: metric ISO-thread DIN 13

Tolerance: ISO 2 / 6H

Variants (11/11+11/11):

**Application/
for wear resistant steel
up to 1200 N/mm²:**

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

TiCN-coating

- › excellent wear resistance by improved hardness and toughness
- › intensive and optimal cooling required because of lower heat resistance



DIN 371		L1	L2	L2	D2	Square	Art.-No.* Form B	Art.-No.** Form C	Art.-No.* Form B TiCN	Art.-No.* Form C TiCN
M	3 x 0.5	56	11	6	3.5	2.7	35426	36426	35427	36427
M	4 x 0.7	63	13	7	4.5	3.4	35430	36430	35431	36431
M	5 x 0.8	70	16	8	6.0	4.9	35434	36434	35435	36435
M	6 x 1.0	80	19	10	6.0	4.9	35438	36438	35439	36439
M	8 x 1.25	90	22	14	8.0	6.2	35442	36442	35443	36443
M	10 x 1.5	100	24	16	10.0	8.0	35446	36446	35447	36447
DIN 376		L1	L2	L2	D2	Square	Art.-No.* Form B	Art.-No.** Form C	Art.-No.* Form B TiCN	Art.-No.* Form C TiCN
M	12 x 1.75	110	29	18	9.0	7.0	35450	36450	35451	36451
M	14 x 2.0	110	30	20	11.0	9.0	35454	36454	35455	36455
M	16 x 2.0	110	32	22	12.0	9.0	35458	36458	35459	36459
M	18 x 2.5	125	34	25	14.0	11.0	35462	36462	35463	36463
M	20 x 2.5	140	34	25	16.0	12.0	35466	36466	35467	36467



BLUE RING Machine taps

JIS B-4430 HSS-E - M + JIS B-4430 39°RSP HSS-E - M

Type of thread: metric ISO-thread DIN 13

Tolerance: OH2

Variants (21/21):

**Application/
for wear resistant steel
up to 1200 N/mm²:**

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



D		L1	L2	L2 RSP	D2	Square	Art.-No.*	Art.-No.** RSP
M	3 x 0.5	46	9	6	4	3.2	91305	91355
M	4 x 0.7	52	11	7	5	4	91307	91357
M	5 x 0.8	60	14	8	5.5	4.5	91308	91358
M	6 x 1.0	62	17	10	6	4.5	91309	91359
M	6 x 0.75	62	17	10	6	4.5	91330	91380
M	8 x 1.25	70	20	14	6.2	5	91311	91361
M	8 x 1.0	70	20	14	6.2	5	91331	91381
M	8 x 0.75	70	20	14	6.2	5	91332	91382
M	10 x 1.5	75	22	16	7	5.5	91313	91363
M	10 x 1.25	75	22	16	7	5.5	91333	91383
M	10 x 1.0	75	22	16	7	5.5	91334	91384
M	12 x 1.75	82	27	18	8.5	6.5	91315	91365
M	12 x 1.5	82	27	18	8.5	6.5	91335	91385
M	12 x 1.25	82	27	18	8.5	6.5	91336	91386
M	12 x 1.0	82	27	18	8.5	6.5	91337	91387
M	14 x 2.0	88	28	20	10.5	8	91316	91366
M	14 x 1.5	88	28	20	10.5	8	91338	91388
M	14 x 1.25	88	28	20	10.5	8	91339	91389
M	16 x 2.0	95	30	22	12.5	10	91317	91367
M	16 x 1.5	95	30	22	12.5	10	91340	91390
M	16 x 1.0	95	30	22	12.5	10	91341	91391



WHITE RING



HSS-E PM WHITE RING Machine taps

The VOELKEL HSS-E machine taps with white ring are especially suitable for stainless steel (INOX), long-chipping up to 1000 N/mm² and for chrome-nickel alloys.

More recommended application:

- heat resistant steel, long-chipping
- Stainless steel, long-chipping
- Titanium, long-chipping

HSSE Machine taps with steam tempered (VAP) surface:

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.



WHITE RING Machine taps (set of 7 pcs.) (47852)

DIN 371/376 M 3 - M 12

Type of thread	Standard	Material	Tolerance	Packing	Size
metric ISO thread DIN 13	DIN 371/376	HSS-E	ISO 2/6H	in plastic case	Diameter M 3 - 12

Application/ for general use:

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

Contents:

	Art. -No.
1x WHITE RING machine tap, DIN 371, HSS-E, M 3 x 0,5	35226
1x WHITE RING machine tap, DIN 371, HSS-E, M 4 x 0,7	35230
1x WHITE RING machine tap, DIN 371, HSS-E, M 5 x 0,8	35234
1x WHITE RING machine tap, DIN 371, HSS-E, M 6 x 1,0	35238
1x WHITE RING machine tap, DIN 371, HSS-E, M 8 x 1,25	35242
1x WHITE RING machine tap, DIN 371, HSS-E, M 10 x 1,5	35246
1x WHITE RING machine tap, DIN 376, HSS-E, M 12 x 1,75	35250



WHITE RING Machine taps for blind holes (set of 7 pcs.) (47862)

DIN 371/376 M 3 - M 12

Type of thread	Standard	Material	Tolerance	Packing	Size
metric ISO thread DIN 13	DIN 371/376	HSS-E	ISO 2/6H	in plastic case	Diameter M 3 - 12

Application/ for general use:

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

Contents:

	Art. -No.
1x WHITE RING machine tap, DIN 371, HSS-E, M 3 x 0,5	36226
1x WHITE RING machine tap, DIN 371, HSS-E, M 4 x 0,7	36230
1x WHITE RING machine tap, DIN 371, HSS-E, M 5 x 0,8	36234
1x WHITE RING machine tap, DIN 371, HSS-E, M 6 x 1,0	36238
1x WHITE RING machine tap, DIN 371, HSS-E, M 8 x 1,25	36242
1x WHITE RING machine tap, DIN 371, HSS-E, M 10 x 1,5	36246
1x WHITE RING machine tap, DIN 376, HSS-E, M 12 x 1,75	36250



WHITE RING Machine taps (set of 14 pcs.) incl. drills (47855)

DIN 371/376 M 3 - M 12

Type of thread	Standard	Material	Tolerance	Packing	Size
metric ISO thread DIN 13	DIN 371/376	HSS-E	ISO 2/6H	in plastic case	Diameter M 3 - 12

Application/ for general use:

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

Contents:

	Art. -No.
1x WHITE RING machine tap, DIN 371, HSS-E, M 3 x 0,5	35226
1x WHITE RING machine tap, DIN 371, HSS-E, M 4 x 0,7	35230
1x WHITE RING machine tap, DIN 371, HSS-E, M 5 x 0,8	35234
1x WHITE RING machine tap, DIN 371, HSS-E, M 6 x 1,0	35238
1x WHITE RING machine tap, DIN 371, HSS-E, M 8 x 1,25	35242
1x WHITE RING machine tap, DIN 371, HSS-E, M 10 x 1,5	35246
1x WHITE RING machine tap, DIN 376, HSS-E, M 12 x 1,75	35250
Twist drill 2.5 / 3.3 / 4.2 / 5.0 / 6.8 / 8.5 / 10.2 mm	



WHITE RING Machine taps for blind holes (set of 14 pcs.) incl. drills (47865)

DIN 371/376 M 3 - M 12

Type of thread	Standard	Material	Tolerance	Packing	Size
metric ISO thread DIN 13	DIN 371/376	HSS-E	ISO 2/6H	in plastic case	Diameter M 3 - 12

Application/ for general use:

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

Contents:

	Art. -No.
1x WHITE RING machine tap, DIN 371, HSS-E, M 3 x 0,5	36226
1x WHITE RING machine tap, DIN 371, HSS-E, M 4 x 0,7	36230
1x WHITE RING machine tap, DIN 371, HSS-E, M 5 x 0,8	36234
1x WHITE RING machine tap, DIN 371, HSS-E, M 6 x 1,0	36238
1x WHITE RING machine tap, DIN 371, HSS-E, M 8 x 1,25	36242
1x WHITE RING machine tap, DIN 371, HSS-E, M 10 x 1,5	36246
1x WHITE RING machine tap, DIN 376, HSS-E, M 12 x 1,75	36250
Twist drill 2.5 / 3.3 / 4.2 / 5.0 / 6.8 / 8.5 / 10.2 mm	



WHITE RING TwinBox

DIN 371 /376 Form B HSS-E - M
+ DIN 371/376 Form C 35°RSP HSS-E - M

Type of thread: metric ISO-thread DIN 13

Tolerance: ISO 2 /6H

Variants (9/9):

**Application/
for stainless steel,
long-chipping up to
1000 N/mm²:**

- > long-chipping, heat resistant steel
- > abrasive material
- > for through holes*
- > for blind holes**

Surface treatment: Steam tempered:

- > improved adhesion of the coolant and Lubricant
- > reduces tearing of the lubricating fill and the formation of cold welding

HSS-CO Twist Drill DIN 338

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

D		Machine tap	Twist drill	Art.-No.*	Art.-No.**
				Form B	Form C
M	3 x 0.5	DIN 371	2.5 mm	35290	36290
M	4 x 0.7	DIN 371	3.3 mm	35291	36291
M	5 x 0.8	DIN 371	4.2 mm	35292	36292
M	6 x 1.0	DIN 371	5.0 mm	35293	36293
M	8 x 1.25	DIN 371	6.8 mm	35294	36294
M	10 x 1.5	DIN 371	8.5 mm	35295	36295
M	12 x 1.75	DIN 376	10.2 mm	35296	36296
M	14 x 2.0	DIN 376	12.0 mm	35297	36297
M	16 x 2.0	DIN 376	14.0 mm	35298	36298



Application/ stainless steel, long-chipping up to 1000 N/mm²:

- > abrasive material
- > chrome-nickel alloys
- > for through holes*
- > for blind holes**

WHITE RING Machine taps

- DIN 374 Form B/Form C 39°RSP HSS-E - Mf
- + DIN 371/376 Form B/Form C 39°RSP HSS-E - UNC
- + DIN 371/376 Form B/Form C 39°RSP HSS-E - UNF
- + DIN 5156 Form B/Form C 39°RSP HSS-E - G (BSP)

Type of thread: metric-fine ISO-thread DIN 13
 + Unified Coarse thread ANSI B 1.1
 + Unified Fine thread ANSI B 1.1
 + Pipe-thread DIN ISO 228

Tolerance: ISO 2 /6H

Variants (12/5/5/4+12/5/5/4):

VAP-coating

- > improved adhesion of the coolant and Lubricant
- > reduces tearing of the lubricating fill and the formation of cold welding



MF		L1	L2	L2	D2	Square	Art.-No.*	Art.-No.**
D			Form B	Form C			Form B	Form C
DIN 374								
M	5 x 0.5	70	12	5	3.5	2.7	35903	36903
M	6 x 0.75	80	14	8	4.5	3.4	35904	36904
M	8 x 0.75	80	19	8	6.0	4.9	35906	36906
M	8 x 1.0	90	22	10	6.0	4.9	35907	36907
M	10 x 1.0	90	20	10	7.0	5.5	35909	36909
M	10 x 1.25	100	24	16	7.0	5.5	35910	36910
M	12 x 1.25	100	22	15	9.0	7.0	35913	36913
M	12 x 1.5	100	22	15	9.0	7.0	35914	36914
M	14 x 1.5	100	22	15	11.0	9.0	35917	36917
M	16 x 1.5	100	22	15	12.0	9.0	35921	36921
M	18 x 1.5	110	25	17	14.0	11.0	35925	36925
M	20 x 1.5	125	25	17	16.0	12.0	35929	36929
UNC								
D		L1	L2	L2	D2	Square	Art.-No.*	Art.-No.**
			Form B	Form C			Form B	Form C
DIN 371								
UNC	1/4 x 20	80	17	13	7.0	5.5	35945	36945
UNC	5/16 x 18	90	20	14	8.0	6.2	35946	36946
UNC	3/8 x 16	100	22	16	9.0	7.0	35947	36947
DIN 376								
UNC	7/16 x 14	100	22	17	8.0	6.2	35948	36948
UNC	1/2 x 13	110	25	20	9.0	7.0	35949	36949



UNF D		L1	L2 Form B	L2 Form C	D2	Square	Art.-No.* Form B	Art.-No.** Form C
DIN 371								
UNF	1/4 x 28	80	17	10	7.0	5.5	35965	36965
UNF	5/16 x 24	90	17	10	8.0	6.2	35966	36966
UNF	3/8 x 24	100	18	10	9.0	7.0	35967	36967
DIN 376								
UNF	7/16 x 20	100	22	13	8.0	6.2	35968	36968
UNF	1/2 x 20	100	22	13	9.0	7.0	35969	36969
G (BSP) D		L1	L2 Form B	L2 Form C	D2	Square	Art.-No.* Form B	Art.-No.** Form C
DIN 5156								
G	1/8 x 28	90	20	20	7.0	5.5	35992	36992
G	1/4 x 19	100	22	22	11.0	9.0	35993	36993
G	3/8 x 19	100	22	22	12.0	9.0	35994	36994
G	1/2 x 14	125	25	25	16.0	12.0	35995	36995



**Application/
stainless steel,
long-chipping up to
1000 N/mm²:**

- > abrasive material
- > chrome-nickel alloys
- > for through holes*
- > for blind holes**

VAP-coating

- > improved adhesion of the coolant and Lubricant
- > reduces tearing of the lubricating fill and the formation of cold welding



WHITE RING Machine taps

DIN 371/376 Form B HSS-E - M + DIN 371/376 Form C 39°RSP HSS-E - M

Type of thread: metric-fine ISO-thread DIN 13

Tolerance: ISO 2 /6H

Variants (11/11):

DIN 371		L1	L2	L2	D2	Square	Art.-No.*	Art.-No.**
D	Form B		Form C	Form B			Form C	
M	3 x 0.5	56	11	6	3.5	2.7	35226	36226
M	4 x 0.7	63	13	7	4.5	3.4	35230	36230
M	5 x 0.8	70	16	8	6.0	4.9	35234	36234
M	6 x 1.0	80	19	10	6.0	4.9	35238	36238
M	8 x 1.25	90	22	14	8.0	6.2	35242	36242
M	10 x 1.5	100	24	16	10.0	8.0	35246	36246
DIN 376		L1	L2	L2	D2	Square	Art.-No.*	Art.-No.**
D	Form B		Form C	Form B			Form C	
M	12 x 1.75	110	29	18	9.0	7.0	35250	36250
M	14 x 2.0	110	30	20	11.0	9.0	35254	36254
M	16 x 2.0	110	32	22	12.0	9.0	35258	36258
M	18 x 2.5	125	34	25	14.0	11.0	35262	36262
M	20 x 2.5	140	34	25	16.0	12.0	35266	36266



WHITE RING Machine taps

JIS B-4430 HSS-E - M + JIS B-4430 39°RSP HSS-E - M

Type of thread: metric ISO-thread DIN 13

Tolerance: OH2-OH3

Variants (21/21):

**Application/
stainless steel,
long-chipping up to
1000 N/mm²:**

- > abrasive material
- > chrome-nickel alloys
- > for through holes*
- > for blind holes**

VAP-coating

- > improved adhesion of the coolant and Lubricant
- > reduces tearing of the lubricating fill and the formation of cold welding



D		Tolerance		L1	L2	L2	D2	Square	Art.-No.*	Art.-No.**
		RSP				RSP				RSP
M	3 x 0.5	OH2	OH2	46	9	6	4	3.2	91205	91255
M	4 x 0.7	OH2	OH2	52	11	7	5	4	91207	91257
M	5 x 0.8	OH2	OH2	60	14	8	5.5	4.5	91208	91258
M	6 x 1.0	OH2	OH2	62	17	10	6	4.5	91209	91259
M	6 x 1.0	OH2	OH2	62	17	10	6	4.5	91230	91280
M	8 x 1.25	OH3	OH3	70	20	14	6.2	5	91211	91261
M	8 x 1.25	OH3	OH2	70	20	14	6.2	5	91231	91281
M	8 x 1.25	OH3	OH2	70	20	14	6.2	5	91232	91282
M	10 x 1.5	OH3	OH3	75	22	16	7	5.5	91213	91263
M	10 x 1.25	OH3	OH3	75	22	16	7	5.5	91233	91283
M	10 x 1.0	OH3	OH2	75	22	16	7	5.5	91234	91284
M	12 x 1.75	OH3	OH3	82	27	18	8.5	6.5	91215	91265
M	12 x 1.5	OH3	OH3	82	27	18	8.5	6.5	91235	91285
M	12 x 1.25	OH3	OH3	82	27	18	8.5	6.5	91236	91286
M	12 x 1.0	OH3	OH2	82	27	18	8.5	6.5	91237	91287
M	14 x 2.0	OH3	OH3	88	28	20	10.5	8	91216	91266
M	14 x 1.5	OH3	OH3	88	28	20	10.5	8	91238	91288
M	14 x 1.25	OH3	OH3	88	28	20	10.5	8	91239	91289
M	16 x 2.0	OH3	OH3	95	30	22	12.5	10	91217	91267
M	16 x 1.5	OH3	OH3	95	30	22	12.5	10	91240	91290
M	16 x 1.0	OH3	OH3	95	30	22	12.5	10	91241	91291



BLACK RING



BLACK RING Machine taps

The VOELKEL HSS-E machine taps with black ring are especially suitable for cast iron (GG) and spheroidal cast iron (GGG).

More recommended application:

- › Brass and bronze, short-chipping
- › Plastics, thermosetting

Machine taps with nitrided surface:

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.

Variations:

- › Machine taps (black-ring) DIN 371/376 M3-M20
- › Taps for cast iron in set of 7 pcs. (M3-M12)



BLACK RING Machine taps (set of 7 pcs.) (47851)

DIN 371/376 M 3 - M 12

Type of thread	Standard	Material	Tolerance	Size
metric ISO thread DIN 13	DIN 371/376	HSS-E	ISO 2 /6H	Diameter M 3 - 12

Application/ cast iron GG, spheroidal graphite iron GGG

- > Magnesium alloys
- > for through and blind holes

Surface treatment nitrided:

- > increased surface hardness
- > high abrasion resistance
- > improved anti-friction properties

Contents:

	Art. -No.
1x BLACK RING machine tap, DIN 371, HSS-E, M 3 x 0,5	35126
1x BLACK RING machine tap, DIN 371, HSS-E, M 4 x 0,7	35130
1x BLACK RING machine tap, DIN 371, HSS-E, M 5 x 0,8	35134
1x BLACK RING machine tap, DIN 371, HSS-E, M 6 x 1,0	35138
1x BLACK RING machine tap, DIN 371, HSS-E, M 8 x 1,25	35142
1x BLACK RING machine tap, DIN 371, HSS-E, M 10 x 1,5	35146
1x BLACK RING machine tap, DIN 376, HSS-E, M 12 x 1,75	35150



BLACK RING Machine taps

DIN 371/376 Form C HSS-E - M

Type of thread: metric-fine ISO-thread DIN 13 Tolerance: ISO 2 /6H

Variants (11):

Application/cast iron GG, spheroidal graphite iron GGG

- > Magnesium alloys
- > for through and blind holes

Surface treatment nitrided:

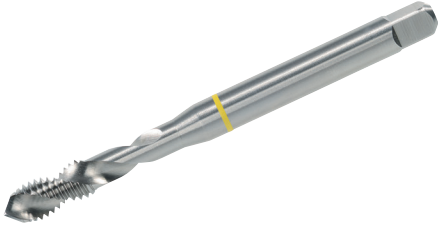
- > increased surface hardness
- > high abrasion resistance
- > improved anti-friction properties

DIN 371 - D	L1	L2	D2	Square	Art.-No.
M 3 x 0.5	56	11	3.5	2.7	35126
M 4 x 0.7	63	13	4.5	3.4	35130
M 5 x 0.8	70	16	6.0	4.9	35134
M 6 x 1.0	80	19	6.0	4.9	35138
M 8 x 1.25	90	22	8.0	6.2	35142
M 10 x 1.5	100	24	10.0	8.0	35146

DIN 376 - D	L1	L2	D2	Square	Art.-No.
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



YELLOW RING



YELLOW RING Machine taps

The VOELKEL HSS-E machine taps with yellow-ring are especially suitable for aluminium alloys (long-chipping).

- Machine taps with 40° right-spiral
- for blind holes
- Taps with two flutes

Variations:

- Machine taps (yellow-ring) DIN 371/376 M3-M16
- Taps for aluminium in set of 7 pcs. (M3-M12)



YELLOW RING Machine taps (set of 7 pcs.) (47860)

DIN 371/376 M 3 - M 12

Type of thread	Standard	Material	Tolerance	Size
metric ISO thread DIN 13	DIN 371/376	HSS-E	ISO 2 /6H	Diameter M 3 - 12

**Application/
Aluminium-alloys,
long-chipping**
 > for blind holes
 > with 2 flutes

Contents:	Art. -No.
1x YELLOW RING machine tap, DIN 371, HSS-E, M 3 x 0.5	36526
1x YELLOW RING machine tap, DIN 371, HSS-E, M 4 x 0.7	36530
1x YELLOW RING machine tap, DIN 371, HSS-E, M 5 x 0.8	36534
1x YELLOW RING machine tap, DIN 371, HSS-E, M 6 x 1.0	36538
1x YELLOW RING machine tap, DIN 371, HSS-E, M 8 x 1.25	36542
1x YELLOW RING machine tap, DIN 371, HSS-E, M 10 x 1.5	36546
1x YELLOW RING machine tap, DIN 376, HSS-E, M 12 x 1.75	36550



YELLOW RING Machine taps

DIN 371/376 Form C 40°RSP HSS-E - M

Type of thread: metric-fine ISO-thread DIN 13	Tolerance: ISO 2 /6H
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Variants (9):

**Application/
Aluminium-alloys,
long-chipping**
 > for blind holes
 > with 2 flutes

DIN 371 - D	L1	L2	D2	Square	Art.-No.
M 3 x 0.5	56	6	3.5	2.7	36526
M 4 x 0.7	63	7	4.5	3.4	36530
M 5 x 0.8	70	8	6.0	4.9	36534
M 6 x 1.0	80	10	6.0	4.9	36538
M 8 x 1.25	90	14	8.0	6.2	36542
M 10 x 1.5	100	16	10.0	8.0	36546

DIN 376 - D	L1	L2	D2	Square	Art.-No.
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



ORANGE RING



ORANGE RING Machine taps

The VOELKEL HSS-E orange-ring machine taps are especially suitable for brass (Ms), short-chipping as well as for through and blind holes.

Variations:

- Machine taps (orange-ring) DIN 371/376 M3-M16
- Taps for brass (Ms) in set of 7 pcs. (M3-M12)



ORANGE RING Machine taps (set of 7 pcs.) (47850)

DIN 371/376 M 3 - M 12

Type of thread	Standard	Material	Tolerance	Size
metric ISO thread DIN 13	DIN 371/376	HSS-E	ISO 2 /6H	Diameter M 3 - 12

Application/ Ms Brass, short-chipping

> for through and blind holes

Contents:

Art. -No.

1x ORANGE RING machine tap, DIN 371, HSS-E, M 3 x 0.5	35726
1x ORANGE RING machine tap, DIN 371, HSS-E, M 4 x 0.7	35730
1x ORANGE RING machine tap, DIN 371, HSS-E, M 5 x 0.8	35734
1x ORANGE RING machine tap, DIN 371, HSS-E, M 6 x 1.0	35738
1x ORANGE RING machine tap, DIN 371, HSS-E, M 8 x 1.25	35742
1x ORANGE RING machine tap, DIN 371, HSS-E, M 10 x 1.5	35746
1x ORANGE RING machine tap, DIN 376, HSS-E, M 12 x 1.75	35750



ORANGE RING Machine taps

DIN 371/376 Form C HSS-E - M

Type of thread: metric-fine ISO-thread DIN 13 Tolerance: ISO 2 /6H

Variants (9):

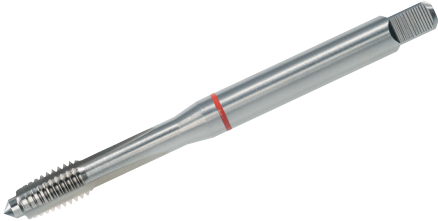
Application/ Ms Brass, short-chipping

> for through and blind holes

DIN 371 - D		L1	L2	D2	Square	Art.-No.
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
DIN 376 - D		L1	L2	D2	Square	Art.-No.
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



RED RING



RED RING Machine taps

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.

Recommended application:

- › Steel and tool steels over 1200 N/mm²
- › Taps for short-chipping materials
- › Plastics, thermosetting
- › for through- and blind hole threads



RED RING Machine taps

DIN 371 Form A HSS-E - M

Type of thread: metric-fine ISO-thread DIN 13

Tolerance: ISO 2 /6H

Variants (9):

Application/short-chipping materials from 1200 N/mm² tensile strength

> for through and blind holes

Due to the very robust execution and the special profile of the flutes this Machine Tap is suitable for extreme applications. The lead Form A and an additional short lead make working easier.

DIN 371

D		L1	L2	D2	Square	Art.-No.
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



Fluteless Machine Taps



Fluteless machine taps



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.

Benefit of fluteless machine forming taps:

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

Application:

bright:

for nonferrous metal of good ductility

VAP (Steam Tempered):

for steel up to approx. 700 N/mm²

TiN (Titanium Nitride Coating):

for steel up to approx. 900 N/mm²



Fluteless machine taps



Fluteless Machine taps

DIN 371/376 HSS-E - M + w/ oil groove
 DIN 371/376 HSS-E TiN - M + w/ oil groove
 DIN 371/376 HSS-E VAP - M + w/ oil groove

Type of thread: metric ISO-thread DIN 13

Tolerance: ISO 2X /6HX

Variants (18/9+18/9+9/9):

Advantages:

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

Oil groove:

- › for optimum effect of lubrication of thread depth over 1,5 x D
- › Use graphite lubrication/oil or add another suitable lubricant.

Application/for chipless production of internal threads - bright:

- › for nonferrous metal of good ductility
- › for long-chipping nonferrous Metal (Cooper, Brass, Bronze, Alu)
- › Zinc alloys
- › for through and blind holes
- › with TiN-coating for steel up to approx. 900 N/mm²*
- › VAP (steam tempered) for steel up to approx. 700 N/mm²**
- › unalloyed and low alloyed steel*
- › heat resistant steel*
- › Structural Steel*/**
- › stainless steel*/**



D	L1	L2	D2	Square	Art.-No. HSS-E	Art.-No.* HSS-E-TiN	Art.-No.** HSS-E-VAP
DIN 371							
M 1 x 0.25	40	5	2.5	2.1	35500	35520	-
M 1.1 x 0.25	40	5	2.5	2.1	35501	35521	-
M 1.2 x 0.25	40	5	2.5	2.1	35502	35522	-
M 1.4 x 0.3	40	7	2.5	2.1	35503	35523	-
M 1.6 x 0.35	40	8	2.5	2.1	35504	35524	-
M 1.7 x 0.35	40	8	2.5	2.1	35505	35525	-
M 1.8 x 0.35	40	8	2.5	2.1	35506	35526	-
M 2 x 0.4	45	8	2.8	2.1	35507	35527	-
M 2.5 x 0.45	50	9	2.8	2.1	35508	35528	-
M 3 x 0.5	56	11	3.5	2.7	35510	35530	35550
M 4 x 0.7	63	13	4.5	3.4	35512	35532	35552
M 5 x 0.8	70	16	6.0	4.9	35513	35533	35553
M 6 x 1.0	80	19	6.0	4.9	35514	35534	35554
M 8 x 1.25	90	22	8.0	6.2	35515	35535	35555
M 10 x 1.5	100	24	10.0	8.0	35516	35536	35556



D	L1	L2	D2	Square	Art.-No. HSS-E	Art.-No.* HSS-E-TiN	Art.-No.** HSS-E-VAP
DIN 376							
M 12 x 1.75	110	29	9.0	7.0	35517	35537	35557
M 14 x 2.0	110	30	11.0	9.0	35518	35538	35558
M 16 x 2.0	110	32	12.0	9.0	35519	35539	35559



w/ oil groove D	L1	L2	D2	Square	Art.-No. HSS-E	Art.-No.* HSS-E-TiN	Art.-No.** HSS-E-VAP
DIN 371							
M 3 x 0.5	56	11	3.5	2.7	35610	35630	35650
M 4 x 0.7	63	13	4.5	3.4	35612	35632	35652
M 5 x 0.8	70	16	6.0	4.9	35613	35633	35653
M 6 x 1.0	80	19	6.0	4.9	35614	35634	35654
M 8 x 1.25	90	22	8.0	6.2	35615	35635	35655
M 10 x 1.5	100	24	10.0	8.0	35616	35636	35656
DIN 376							
M 12 x 1.75	110	29	9.0	7.0	35617	35637	35657
M 14 x 2.0	110	30	11.0	9.0	35618	35638	35658
M 16 x 2.0	110	32	12.0	9.0	35619	35639	35659



Fluteless Machine taps, oversize

DIN 371/376 HSS-E - M + w/ oil groove DIN 371/376 HSS-E - M

Type of thread: metric ISO-thread DIN 13

Tolerance: ISO 3X /6gX

Variants (7/7):

Advantages:

- › 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

Oil groove:

- › for optimum effect of lubrication of thread depth over 1,5 x D
- › Use graphite lubrication/oil or add another suitable lubricant.

Application/

for chipless production of internal threads:

- › for nonferrous metal of good ductility
- › for materials with galvanic protection layers
- › tolerance ISO 3 (6G) = oversize of 0,02 - 0,04 mm
- › for long-chipping nonferrous Metal (Cooper, Brass, Bronze, Alu)
- › Zinc alloys
- › for through and blind holes
- › VAP (steam tempered) for steel up to approx. 700 N/mm²*
- › constructional steel*
- › stainless steel*



D	L1	L2	D2	Square	Art.-No.	Art.-No.* w/ oil groove
DIN 371						
M 3 x 0.5	56	11	3.5	2.7	35510-6G	35510-6G
M 4 x 0.7	63	13	4.5	3.4	35512-6G	35612-6G
M 5 x 0.8	70	16	6	4.9	35513-6G	35613-6G
M 6 x 1.0	80	19	6	4.9	35514-6G	35614-6G
M 8 x 1.25	90	22	8	6.2	35515-6G	35615-6G
M 10 x 1.5	100	24	10	8	35516-6G	35616-6G
DIN 376						
M 12 x 1.75	110	29	9	7	35517-6G	35617-6G



Fluteless Machine taps

JIS B-4430 HSS-E - M + w/ oil groove JIS B-4430 HSS-E - M

Type of thread: metric ISO-thread DIN 13

Variants (10/10):

Advantages:

- › 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

Oil groove:

- › for optimum effect of lubrication of thread depth over 1,5 x D
- › Use graphite lubrication/oil or add another suitable lubricant.

Application/for chipless production of internal threads - bright:

- › for nonferrous metal of good ductility
- › for materials with galvanic protection layers*
- › for long-chipping nonferrous Metal (Cooper, Brass, Bronze, Alu)
- › Zinc alloys
- › for through and blind holes
- › tolerance ISO 3 (6G) = oversize of 0,02 - 0,04 mm*



D	L1	L2	D2	Square	Art.-No.	Art.-No.* w/ oil groove
M 2 x 0.4	40	8	3	2.5	90814	90914
M 2.3 x 0.4	42	9.5	3	2.5	90816	90916
M 2.5 x 0.45	44		3	2.5	90818	90918
M 2.6 x 0.45	44		3	2.5	90820	90920
M 3 x 0.5	46	11	4	3.2	90822	90922
M 4 x 0.7	52	13	5	4	90826	90926
M 5 x 0.8	60	16	5.5	4.5	90830	90930
M 6 x 1.0	62	19	6	4.5	90838	90938
M 8 x 1.25	70	13	6.2	5	90846	90946
M 10	75	15	7	5.5	90854	90954



Fluteless Machine taps

JIS B-4430 HSS-E - UNC + w/ oil groove JIS B-4430 HSS-E - UNC

Type of thread: Unified Coarse thread ANSI B 1.1

Variants (4/4):

Advantages:

- › 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

Oil groove:

- › for optimum effect of lubrication of thread depth over 1,5 x D
- › Use graphite lubrication/oil or add another suitable lubricant.

Application/for chipless production of internal threads - bright:

- › for nonferrous metal of good ductility
- › for materials with galvanic protection layers*
- › for long-chipping nonferrous Metal (Cooper, Brass, Bronze, Alu)
- › Zinc alloys
- › for through and blind holes
- › tolerance ISO 3 (6G) = oversize of 0,02 - 0,04 mm*



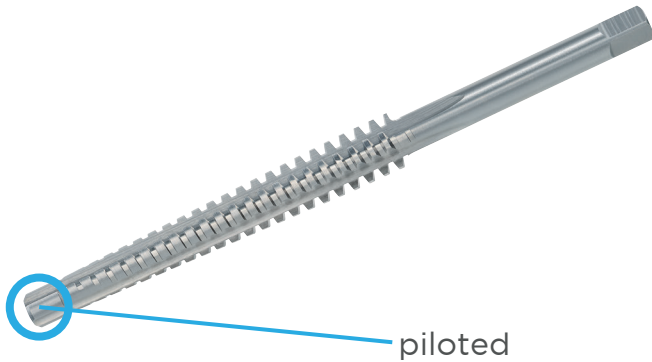
D	L1	L2	D2	Square	Art.-No.	Art.-No.* w/ oil groove
M 4 x 40	45	10	3	2.5	93804	93904
M 6 x 32	49	14	4	3.2	93806	93906
M 8 x 32	53	14	5	4	93808	93908
M 10 x 24	61	17	5.5	4.5	93809	93909

The image features a collection of machine nut taps arranged in a circular pattern around the central text. There are four pairs of taps, each pair consisting of a standard tap and a double-flute tap. The taps are arranged in two rows, with two pairs in the top row and two pairs in the bottom row. The central text is in a bold, blue, sans-serif font.

Machine nut taps



Machine nut taps



piloted

- Machine nut taps for through holes
- for thread depth up to 1.0xD
- Nut taps for unalloyed and low alloyed steel
- for tapping of non abrasive materials
- Trapezoidal nut taps up to Tr 36x6 for right- and left-hand threads
- for metric threads up to M 24 with long reduced shank to allow nuts to run over

Machine nut taps



Machine nut taps, piloted + left hand piloted

HSS-G - Tr + HSS-G - Tr LH

Type of thread: trapezoidal thread DIN 103

Tolerance: 7H

Variants (16/15):

Application:

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

D	L1	L2	D2	Square	Art.-No.	Art.-No. LH
Tr 10 x 2	110	63	7	5.5	79108	79108-L
Tr 10 x 3	125	75	7	5.5	79112	79112-L
Tr 12 x 3	165	111	8	6.2	79116	79116-L
Tr 14 x 3	140	85	10	8.0	79120	79120-L
Tr 14 x 4	170	112	10	8.0	79124	79124-L
Tr 16 x 4	180	116	11	9.0	79128	79128-L
Tr 18 x 4	190	120	12	9.0	79132	79132-L
Tr 20 x 4	200	124	14	11.0	79136	79136-L
Tr 22 x 4	210	130	16	12.0	79139	-
Tr 22 x 5	235	155	16	12.0	79140	79140-L
Tr 24 x 5	245	160	18	14.5	79144	79144-L
Tr 26 x 5	255	165	20	16.0	79148	79148-L
Tr 28 x 5	265	170	22	18.0	79152	79152-L
Tr 30 x 6	290	185	22	18.0	79156	79156-L
Tr 32 x 6	300	191	25	20.0	79160	79160-L
Tr 36 x 6	310	200	28	22.0	79164	79164-L



Machine nut taps

DIN 357 HSS-E - M

Type of thread: metric ISO-thread DIN 13

Tolerance: ISO 2 /6H

Variants (13):

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 threads for general use
- › non abrasive material up to 800 N/mm²
- › unalloyed and low alloyed steel

D		L1	L2	D2	Square	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



Round dies Hexagon die nuts



Round dies / Hexagon die nuts



HSS Dies and nuts

- Round dies and Hexagon die nuts for general use
- for non abrasive materials up to 800 N/mm²
- Round dies for unalloyed and low alloyed steel

Application:

- Round dies and Hexagon die nuts with high cutting ability
- for abrasive materials up to 1200 N/mm²
- Round dies for INOX (stainless steel)
- Round dies and hexagon die nuts, gun nosed

M (metric)



P.V.99 Hexagon die nuts (set of 7 pcs.) ([49520](#))

DIN standard HSS M 3 - M 12

Type of thread	Standard	Material	Packing	Size
metric ISO thread DIN 13	DIN standard	HSS-G	in metal case	Diameter M 3 - 12

Application/ for general use:

- non abrasive material up to 800 N/mm²
- unalloyed and low alloyed steel
- small, handy set for standard application
- the most popular diameter together in one case
- Hexagon die nuts acc. to DIN 382

All threading tools, threading tool holder and accessories can also be ordered separately

Contents:

	Art. -No.
1x HSS Hexagon die nut M 3	27126
1x HSS Hexagon die nut M 4	27130
1x HSS Hexagon die nut M 5	27134
1x HSS Hexagon die nut M 6	27138
1x HSS Hexagon die nut M 8	27142
1x HSS Hexagon die nut M 10	27146
1x HSS Hexagon die nut M 12	27150



P.V.97 Round dies (set of 7 pcs.) (49521)

DIN standard HSS M 3 - M 12

Type of thread	Standard	Material	Packing	Size
metric ISO thread DIN 13	DIN standard	HSS-G	in metal case	Diameter M 3 - 12

Application/ for general use:

- › non abrasive material up to 800 N/mm²
- › unalloyed and low alloyed steel
- › small, handy set for standard application
- › the most popular diameter together in one case

All threading tools, threading tool holder and accessories can also be ordered separately

Contents:

Art. -No.

1x HSS Round die M 3	27426
1x HSS Round die M 4	27430
1x HSS Round die M 5	27434
1x HSS Round die M 6	27438
1x HSS Round die M 8	27442
1x HSS Round die M 10	27446
1x HSS Round die M 12	27450



P.V.98 Round dies (set of 7 pcs.) (49522)

DIN standard HSS-E M 3 - M 12

Type of thread	Standard	Material	Packing	Size
metric ISO thread DIN 13	DIN standard	HSS-E	in metal case	Diameter M 3 - 12

Advantages:

- › high cutting ability
- › easy cut
- › uninterrupted swarf flow in direction of feed
- › prevents jaming of swarf
- › small, handy set for standard application
- › the most popular dimensions in one case

Application:

- › abrasive material up to 1200 N/mm²
- › stainless steel
- › and for general use
- › HSS-E Round dies acc. to DIN 223 (DIN EN 22568)

All threading tools, threading tool holder and accessories can also be ordered separately

Contents:

Art. -No.

1x HSS-E Round die M 3	57426
1x HSS-E Round die M 4	57430
1x HSS-E Round die M 5	57434
1x HSS-E Round die M 6	57438
1x HSS-E Round die M 8	57442
1x HSS-E Round die M 10	57446
1x HSS-E Round die M 12	57450



P.V.92 Round dies (set of 8 pcs.) (49525)

DIN standard HSS M 3 - M 12

Type of thread	Standard	Material	Packing	Size
metric ISO thread DIN 13	DIN standard	HSS	in metal case	Diameter M 3 - 12

Contents:	Art. -No.
1x Round Dies, HSS-G, M 3 x 0.5	27826
1x Round Dies, HSS-G, M 4 x 0.7	27830
1x Round Dies, HSS-G, M 5 x 0.8	27834
1x Round Dies, HSS-G, M 6 x 1.0	27838
1x Round Dies, HSS-G, M 8 x 1.25	27842
1x Round Dies, HSS-G, M 10 x 1.5	27846
1x Round Dies, HSS-G, M 12 x 1.75	27850

All threading tools, threading tool holder and accessories can also be ordered separately



P.V.14 Round dies (set of 19 pcs.) incl. guides (49599)

M 3 - M 12

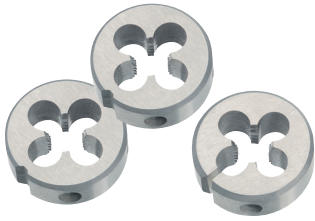
Type of thread	Standard	Material	Packing	Size
metric ISO thread DIN 13	DIN standard	HSS-E	in metal case	Diameter M 3 - 12

Application/ for general use:

- > non abrasive material up to 800 N/mm²
- > unalloyed and low alloyed steel
- > small, handy set for standard application
- > the most popular diameter together in one case
- > 7 Guides for round dies
- > HSS Round dies acc. to DIN 223 (DIN EN 22568)

All threading tools, threading tool holder and accessories can also be ordered separately

Contents:	Art. -No.
1x HSS Round die M 3	27426
1x HSS Round die M 4	27430
1x HSS Round die M 5	27434
1x HSS Round die M 6	27438
1x HSS Round die M 8	27442
1x HSS Round die M 10	27446
1x HSS Round die M 12	27450
1x Guides for round dies (set of 7 pcs.) M 3 - M 12	15100
1x Die stock, zinc die cast 20x5 mm	15002
1x Die stock, zinc die cast 20x7 mm	15003
1x Die stock, zinc die cast 25x9 mm	15004
1x Die stock, zinc die cast 30x11 mm	15005
1x Die stock, zinc die cast 38x14 mm	15007



Round dies

DIN 223 (DIN EN 22568) HSS-G - M + HSS-G - M + split Form A HSS-G M

Type of thread: metric ISO-thread DIN 13

Tolerance: 6g

Variants (56/7/12):

Application/ for general use:

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

DIN 223



HSS



Form A



D - mm DIN 223	Ø - o / d	Art. -No.	D - mm DIN 223	Ø - o / d	Art. -No.	D - mm DIN 223	Ø - o / d	Art. -No.
M 1 x 0.25	16 x 5	27402	M 7 x 1.0	25 x 9	27440	M 42 x 4.5	75 x 30	27486
M 1.1 x 0.25	16 x 5	27404	M 8 x 1.25	25 x 9	27442	M 45 x 4.5	90 x 36	27488
M 1.2 x 0.25	16 x 5	27406	M 9 x 1.25	25 x 9	27444	M 48 x 5.0	90 x 36	27490
M 1.4 x 0.3	16 x 5	27408	M 10 x 1.5	30 x 11	27446	M 52 x 5.0	90 x 36	27492
M 1.6 x 0.35	16 x 5	27410	M 11 x 1.5	30 x 11	27448	M 56 x 5.5	105 x 36	27494
M 1.7 x 0.35	16 x 5	27412	M 12 x 1.75	38 x 14	27450	M 60 x 5.5	105 x 36	27496
M 1.8 x 0.35	16 x 5	27414	M 14 x 2.0	38 x 14	27454	M 64 x 6.0	120 x 36	27498
M 2 x 0.4	16 x 5	27416	M 15 x 2.0	38 x 14	27456	M 68 x 6.0	120 x 36	27499
M 2.2 x 0.45	16 x 5	27418	M 16 x 2.0	45 x 18	27458	M 72 x 6.0	120 x 36	28280
M 2.3 x 0.4	16 x 5	27420	M 18 x 2.5	45 x 18	27462	M 76 x 6.0	120 x 36	28281
M 2.5 x 0.45	16 x 5	27422	M 19 x 2.5	45 x 18	27464	M 80 x 6.0	120 x 36	28282
M 2.6 x 0.45	16 x 5	27424	M 20 x 2.5	45 x 18	27466	M 84 x 6.0	130 x 36	28283
M 3 x 0.5	20 x 5	27426	M 22 x 2.5	55 x 22	27470	M 88 x 6.0	140 x 36	28284
M 3.5 x 0.6	20 x 5	27428	M 24 x 3.0	55 x 22	27474	M 90 x 6.0	140 x 36	28285
M 4 x 0.7	20 x 5	27430	M 27 x 3.0	65 x 25	27476	M 92 x 6.0	140 x 36	28286
M 4.5 x 0.75	20 x 7	27432	M 30 x 3.5	65 x 25	27478	M 96 x 6.0	140 x 36	28287
M 5 x 0.8	20 x 7	27434	M 33 x 3.5	65 x 25	27480	M 100 x 6.0	150 x 36	28288
M 5.5 x 0.9	20 x 7	27436	M 36 x 4.0	65 x 25	27482			
M 6 x 1.0	20 x 7	27438	M 39 x 4.0	75 x 30	27484			

D - mm HSS	Ø - o / d	Art. -No.
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

D - mm Form A	Ø - o / d	Art. -No.	D - mm Form A	Ø - o / d	Art. -No.
M 3 x 0.5	25.4	27926	M 10 x 1.5	25.4	27946
M 4 x 0.7	25.4	27930	M 12 x 1.75	25.4	27950
M 5 x 0.8	25.4	27934	M 14 x 2.0	38.1	27954
M 6 x 1.0	25.4	27938	M 16 x 2.0	38.1	27958
M 7 x 1.0	25.4	27940	M 18 x 2.5	38.1	27962
M 8 x 1.25	25.4	27942	M 20 x 2.5	38.1	27966



Round dies

gun nosed DIN 223 (DIN EN 22568) HSS-E - M
+ DIN 223 (DIN EN 22568) HSS-G - M

Type of thread: metric ISO-thread DIN 13

Tolerance: 6g/6e

Variants (15/11):

Advantages*:

- › high cutting ability
- › easy cut
- › uninterrupted swarf flow in direction of feed
- › prevents jamming of swarf



Application:

- › abrasive/non abrasive* material up to 1200 N/mm²/800 N/mm²*
- › stainless steel*
- › unalloyed and low alloyed steel
- › and for general use



D - mm	Ø - o / d	Art.-No.
gun nosed*		
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

D - 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



Hexagon die nuts

DIN 382 HSS - M

Type of thread: metric ISO-thread DIN 13

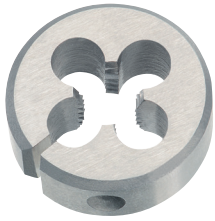
Tolerance: 6g

Variants (30):

Application:

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

D - 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



Round dies

JIS B-4451 HSS - M

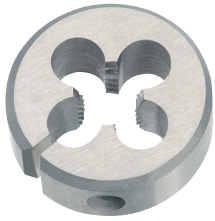
Type of thread: metric ISO-thread DIN 13

Tolerance: 6g/6e

Variants (39/31):

Application: > non abrasive material up to 800 N/mm² > unalloyed and low alloyed steel

D - mm	Ø - o / d	Art.-No.	D - mm	Ø - o / d	Art.-No.
M 3 x 0.5	25	90022	M 16 x 1.5	38	90074
M 3.5 x 0.6	25	90024	M 16 x 1.5	50	90075
M 4 x 0.7	25	90026	M 16 x 1.0	38	90076
M 5 x 0.8	25	90030	M 16 x 1.0	50	90077
M 5 x 0.8	38	90031	M 18 x 2.5	50	90078
M 6 x 1.0	25	90038	M 18 x 1.5	50	90080
M 6 x 1.0	38	90039	M 18 x 1.0	50	90082
M 7 x 1.0	25	90044	M 20 x 2.5	50	90084
M 7 x 1.0	38	90045	M 20 x 1.5	50	90086
M 8 x 1.25	25	90046	M 20 x 1.0	50	90088
M 8 x 1.25	38	90047	M 22 x 2.5	50	90090
M 8 x 1.0	25	90048	M 22 x 2.5	65	90091
M 8 x 1.0	38	90049	M 22 x 1.5	50	90092
M 8 x 0.75	25	90050	M 22 x 1.5	50	90093
M 8 x 0.75	38	90051	M 22 x 1.0	65	90094
M 10 x 1.25	25	90052	M 22 x 1.0	50	90095
M 10 x 1.5	25	90054	M 24 x 3.0	65	90096
M 10 x 1.5	38	90055	M 24 x 3.0	50	90097
M 10 x 1.0	25	90056	M 24 x 1.5	65	90098
M 10 x 1.0	38	90057	M 24 x 1.0	65	90101
M 10 x 1.25	38	90059	M 27 x 3.0	65	90102
M 12 x 1.75	38	90060	M 27 x 2.0	50	90104
M 12 x 1.75	50	90061	M 27 x 1.5	65	90106
M 12 x 1.5	38	90062	M 30 x 3.5	65	90108
M 12 x 1.5	50	90063	M 30 x 1.5	65	90112
M 12 x 1.0	38	90064	M 33 x 3.5	65	90116
M 12 x 1.0	50	90065	M 33 x 1.5	65	90120
M 14 x 2.0	38	90066	M 36 x 4.0	65	90124
M 14 x 2.0	50	90067	M 36 x 1.5	65	90130
M 14 x 1.5	38	90068	M 8 x 1.25	50	90150
M 14 x 1.5	50	90069	M 10 x 1.5	50	90153
M 14 x 1.0	38	90070	M 10 x 1.25	50	90154
M 14 x 1.0	50	90071	M 10 x 1.0	50	90155
M 16 x 2.0	38	90072	M 12 x 1.25	50	90156
M 16 x 2.0	50	90073	M 14 x 1.25	50	90157



Round dies

BS 1127; 1950 HSS - M

Type of thread: metric ISO-thread DIN 13

Tolerance: 6g

Variants (47):

Application: > non abrasive material up to 800 N/mm² > unalloyed and low alloyed steel

D - mm	Ø - o / d	L1	Art.-No.	D - mm	Ø - o / d	L1	Art.-No.
M 2 x 0.4	13/16 o / d	1/4 width	80000	M 18 x 2.5	2" o / d	5/8 width	80043
M 2.2 x 0.45	13/16 o / d	1/4 width	80001	M 20 x 2.5	2" o / d	5/8 width	80044
M 2.5 x 0.45	13/16 o / d	1/4 width	80002	M 22 x 2.5	2" o / d	5/8 width	80045
M 3 x 0.5	13/16 o / d	1/4 width	80003	M 24 x 3.0	2" o / d	5/8 width	80046
M 3.5 x 0.6	13/16 o / d	1/4 width	80004	M 27 x 3.0	3" o / d	7/8 width	80050
M 4 x 0.7	13/16 o / d	1/4 width	80005	M 30 x 3.5	3" o / d	7/8 width	80051
M 4.5 x 0.47	13/16 o / d	1/4 width	80006	M 33 x 3.5	3" o / d	7/8 width	80052
M 5 x 0.8	13/16 o / d	3/8 width	80007	M 36 x 4.0	3" o / d	7/8 width	80053
M 6 x 1.0	13/16 o / d	3/8 width	80008	M 39 x 4.0	3" o / d	7/8 width	80054
M 7 x 1.0	13/16 o / d	3/8 width	80009	M 42 x 4.5	4" o / d	1 width	80060
M 5 x 0.8	1" o / d	3/8 width	80010	M 45 x 4.5	4" o / d	1 width	80061
M 6 x 1.0	1" o / d	3/8 width	80011	M 48 x 5.0	4" o / d	1 width	80062
M 7 x 1.0	1" o / d	3/8 width	80012				
M 8 x 1.25	1" o / d	3/8 width	80013				
M 9 x 1.25	1" o / d	3/8 width	80014				
M 10 x 1.5	1" o / d	3/8 width	80015				
M 12 x 1.75	1" o / d	3/8 width	80016				
M 6 x 1.0	1.5/16 o / d	7/16 width	80020				
M 7 x 1.0	1.5/16 o / d	7/16 width	80021				
M 8 x 1.25	1.5/16 o / d	7/16 width	80022				
M 9 x 1.25	1.5/16 o / d	7/16 width	80023				
M 10 x 1.5	1.5/16 o / d	7/16 width	80024				
M 11 x 1.5	1.5/16 o / d	7/16 width	80025				
M 12 x 1.75	1.5/16 o / d	7/16 width	80026				
M 14 x 2.0	1.5/16 o / d	7/16 width	80027				
M 10 x 1.5	1.1/2 o / d	1/2 width	80030				
M 11 x 1.5	1.1/2 o / d	1/2 width	80031				
M 12 x 1.75	1.1/2 o / d	1/2 width	80032				
M 14 x 2.0	1.1/2 o / d	1/2 width	80033				
M 16 x 2.0	1.1/2 o / d	1/2 width	80034				
M 18 x 2.5	1.1/2 o / d	1/2 width	80035				
M 20 x 2.5	1.1/2 o / d	1/2 width	80036				
M 12 x 1.75	2" o / d	5/8 width	80040				
M 14 x 2.0	2" o / d	5/8 width	80041				
M 16 x 2.0	2" o / d	5/8 width	80042				

D = Nominal Diameter o / d = Outer Diameter L1 = Overall Length



M (metric) left hand



Round dies, left hand (set of 19 pcs.) incl. guides (49598) M 3 LH - M 12 LH

Type of thread	Standard	Material	Packing	Size
metric ISO thread DIN 13	DIN standard	HSS-G	in metal case	Diameter M 3 - 12

Application/ for general use:

- › non abrasive material up to 800 N/mm²
- › unalloyed and low alloyed steel
- › small, handy set for standard application
- › the most popular diameter together in one case
- › 7 Guides for round dies
- › HSS Round dies acc. to DIN 223 (DIN EN 22568)

All threading tools, threading tool holder and accessories can also be ordered separately

Contents:

Art. -No.

1x HSS HSS Round die M 3 LH	27226
1x HSS HSS Round die M 4 LH	27230
1x HSS HSS Round die M 5 LH	27234
1x HSS HSS Round die M 6 LH	27238
1x HSS HSS Round die M 8 LH	27242
1x HSS HSS Round die M 10 LH	27246
1x HSS HSS Round die M 12 LH	27250
1x Guides for round dies (set of 7 pcs.) M 3 - M 12	15100
1x Die stock, zinc die cast 20x5 mm	15002
1x Die stock, zinc die cast 20x7 mm	15003
1x Die stock, zinc die cast 25x9 mm	15004
1x Die stock, zinc die cast 30x11 mm	15005
1x Die stock, zinc die cast 38x14 mm	15007



Round dies, left hand

DIN 223 (DIN EN 22568) HSS-G - M LH

Type of thread: metric ISO-thread DIN 13

Tolerance: 6g

Variants (23):

Application: > non abrasive material up to 800 N/mm² > unalloyed and low alloyed steel

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



Hexagon die nuts, left hand

DIN 382 HSS - M LH

Type of thread: metric ISO-thread DIN 13

Tolerance: 6g

Variants (22):

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

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



Mf



Round dies

DIN 223 (DIN EN 22568) HSS-G - Mf

Type of thread: metric ISO-thread DIN 13

Tolerance: 6g

Variants (267):

Application: > non abrasive material up to 800 N/mm² > unalloyed and low alloyed steel

D - mm	Ø - o / d	Art.-No.	D - mm	Ø - o / d	Art.-No.	D - mm	Ø - o / d	Art.-No.
M 2.5 x 0.35	16 x 5	26404	M 13 x 0.75	38 x 10	26449	M 21 x 1.0	45 x 14	26487
M 2.6 x 0.35	16 x 5	26405	M 13 x 1.0	38 x 10	26450	M 21 x 1.5	45 x 14	26488
M 3 x 0.35	20 x 5	26408	M 13 x 1.5	38 x 10	26451	M 22 x 0.5	55 x 16	26489
M 3.5 x 0.35	20 x 5	26409	M 14 x 0.5	38 x 10	26455	M 22 x 0.75	55 x 16	26491
M 4 x 0.35	20 x 5	26410	M 14 x 0.75	38 x 10	26452	M 22 x 1.0	55 x 16	26490
M 4 x 0.5	20 x 5	26412	M 14 x 1.0	38 x 10	26453	M 22 x 1.25	55 x 16	26492
M 4.5 x 0.5	20 x 5	26413	M 14 x 1.25	38 x 10	26454	M 22 x 1.5	55 x 16	26494
M 5 x 0.5	20 x 5	26414	M 14 x 1.5	38 x 10	26456	M 22 x 2.0	55 x 16	26496
M 5 x 0.75	20 x 7	26416	M 15 x 0.75	38 x 10	26457	M 23 x 1.0	55 x 16	26497
M 5.5 x 0.5	20 x 5	26415	M 15 x 1.0	38 x 10	26458	M 23 x 1.5	55 x 16	26498
M 6 x 0.5	20 x 5	26417	M 15 x 1.5	38 x 10	26460	M 24 x 0.5	55 x 16	26601
M 6 x 0.75	20 x 7	26418	M 16 x 0.5	45 x 14	26461	M 24 x 0.75	55 x 16	26603
M 7 x 0.5	25 x 9	26419	M 16 x 0.75	45 x 14	26436	M 24 x 1.0	55 x 16	26600
M 7 x 0.75	25 x 9	26420	M 16 x 1.0	45 x 14	26462	M 24 x 1.25	55 x 16	26602
M 8 x 0.5	25 x 9	26422	M 16 x 1.25	45 x 14	26464	M 24 x 1.5	55 x 16	26604
M 8 x 0.75	25 x 9	26424	M 16 x 1.5	45 x 14	26466	M 24 x 2.0	55 x 16	26606
M 8 x 1.0	25 x 9	26426	M 17 x 1.0	45 x 14	26468	M 25 x 1.0	55 x 16	26607
M 9 x 0.5	25 x 9	26427	M 17 x 1.5	45 x 14	26469	M 25 x 1.5	55 x 16	26608
M 9 x 0.75	25 x 9	26428	M 18 x 0.5	45 x 14	26467	M 26 x 1.0	55 x 16	26610
M 9 x 1.0	25 x 9	26430	M 18 x 0.75	45 x 14	26473	M 26 x 1.5	55 x 16	26612
M 10 x 0.5	30 x 11	26431	M 18 x 1.0	45 x 14	26470	M 26 x 2.0	55 x 16	26614
M 10 x 0.75	30 x 11	26432	M 18 x 1.25	45 x 14	26471	M 27 x 1.0	65 x 18	26616
M 10 x 1.0	30 x 11	26436	M 18 x 1.5	45 x 14	26472	M 27 x 1.5	65 x 18	26617
M 10 x 1.25	30 x 11	26438	M 18 x 2.0	45 x 14	26474	M 27 x 2.0	65 x 18	26618
M 11 x 1.0	30 x 11	26440	M 19 x 1.0	45 x 14	26475	M 28 x 1.0	65 x 18	26620
M 11 x 1.25	30 x 11	26442	M 19 x 1.5	45 x 14	26476	M 28 x 1.5	65 x 18	26622
M 12 x 0.5	38 x 10	26445	M 20 x 0.5	45 x 14	26477	M 28 x 2.0	65 x 18	26624
M 12 x 0.75	38 x 10	26443	M 20 x 0.75	45 x 14	26479	M 29 x 1.5	65 x 18	26626
M 12 x 1.0	38 x 10	26444	M 20 x 1.0	45 x 14	26478	M 30 x 1.0	65 x 18	26628
M 12 x 1.25	38 x 10	26446	M 20 x 1.25	45 x 14	26480	M 30 x 1.5	65 x 18	26630
M 12 x 1.5	38 x 10	26448	M 20 x 1.5	45 x 14	26484	M 30 x 2.0	65 x 18	26632
M 13 x 0.5	38 x 10	26447	M 20 x 2.0	45 x 14	26486	M 30 x 2.5	65 x 18	26633

D = Nominal Diameter Ø / d = Outer Diameter



D - mm	Ø - o / d	Art.-No.	D - mm	Ø - o / d	Art.-No.	D - mm	Ø - o / d	Art.-No.
M 30 x 3.0	65 x 25	26634	M 48 x 2.0	90 x 22	26684	M 65 x 4.0	120 x 36	28182
M 32 x 1.0	65 x 18	26639	M 48 x 3.0	90 x 36	26686	M 68 x 1.5	120 x 22	28183
M 32 x 1.5	65 x 18	26636	M 50 x 1.5	90 x 22	26688	M 68 x 2.0	120 x 22	28184
M 32 x 2.0	65 x 18	26635	M 50 x 2.0	90 x 22	26690	M 68 x 3.0	120 x 36	28185
M 32 x 3.0	65 x 25	26637	M 50 x 3.0	90 x 36	26692	M 68 x 4.0	120 x 36	28186
M 33 x 1.5	65 x 18	26638	M 52 x 1.5	90 x 22	26694	M 70 x 1.5	120 x 22	28187
M 33 x 2.0	65 x 18	26640	M 52 x 2.0	90 x 22	26696	M 70 x 2.0	120 x 22	28188
M 33 x 3.0	65 x 25	26642	M 52 x 3.0	90 x 36	26698	M 70 x 3.0	120 x 36	28189
M 34 x 1.0	65 x 18	26643	M 54 x 1.0	105 x 22	28267	M 70 x 4.0	120 x 36	28190
M 34 x 1.5	65 x 18	26644	M 54 x 1.5	105 x 22	28150	M 72 x 1.5	120 x 22	28191
M 34 x 2.0	65 x 18	26646	M 54 x 2.0	105 x 22	28151	M 72 x 2.0	120 x 22	28192
M 35 x 1.0	65 x 18	26647	M 54 x 3.0	105 x 36	28152	M 72 x 3.0	120 x 36	28193
M 35 x 1.5	65 x 18	26648	M 54 x 4.0	105 x 36	28153	M 72 x 4.0	120 x 36	28194
M 35 x 2.0	65 x 18	26649	M 55 x 1.5	105 x 22	28154	M 74 x 1.5	120 x 22	28195
M 36 x 1.0	65 x 18	26651	M 55 x 2.0	105 x 22	28155	M 74 x 2.0	120 x 22	28196
M 36 x 1.5	65 x 18	26650	M 55 x 3.0	105 x 36	28156	M 74 x 3.0	120 x 36	28197
M 36 x 2.0	65 x 18	26652	M 55 x 4.0	105 x 36	28157	M 74 x 4.0	120 x 36	28198
M 36 x 3.0	65 x 25	26654	M 56 x 1.0	105 x 22	28268	M 75 x 1.5	120 x 22	28199
M 37 x 1.5	65 x 18	26653	M 56 x 1.5	105 x 22	28158	M 75 x 2.0	120 x 22	28200
M 38 x 1.0	75 x 20	26655	M 56 x 2.0	105 x 22	28159	M 75 x 3.0	120 x 36	28201
M 38 x 1.5	75 x 20	26656	M 56 x 3.0	105 x 36	28160	M 75 x 4.0	120 x 36	28202
M 38 x 2.0	75 x 20	26657	M 56 x 4.0	105 x 36	28161	M 76 x 1.5	120 x 22	28203
M 38 x 3.0	75 x 30	26659	M 58 x 1.0	105 x 22	28269	M 76 x 2.0	120 x 22	28204
M 39 x 1.5	75 x 20	26658	M 58 x 1.5	105 x 22	28162	M 76 x 3.0	120 x 36	28205
M 39 x 2.0	75 x 20	26660	M 58 x 2.0	105 x 22	28163	M 76 x 4.0	120 x 36	28206
M 39 x 3.0	75 x 30	26662	M 58 x 3.0	105 x 36	28164	M 78 x 1.5	120 x 22	28207
M 40 x 1.0	75 x 20	26663	M 58 x 4.0	105 x 36	28165	M 78 x 2.0	120 x 22	28208
M 40 x 1.5	75 x 20	26664	M 60 x 1.5	105 x 22	28166	M 78 x 3.0	120 x 36	28209
M 40 x 2.0	75 x 20	26666	M 60 x 2.0	105 x 22	28167	M 78 x 4.0	120 x 36	28210
M 40 x 3.0	75 x 30	26668	M 60 x 3.0	105 x 36	28168	M 80 x 1.5	120 x 22	28211
M 42 x 1.0	75 x 20	26669	M 60 x 4.0	105 x 36	28169	M 80 x 2.0	120 x 22	28212
M 42 x 1.5	75 x 20	26670	M 62 x 1.5	105 x 22	28170	M 80 x 3.0	120 x 36	28213
M 42 x 2.0	75 x 20	26672	M 62 x 2.0	105 x 22	28171	M 80 x 4.0	120 x 36	28214
M 42 x 3.0	75 x 30	26674	M 62 x 3.0	105 x 36	28172	M 82 x 1.5	130 x 25	28215
M 44 x 1.5	90 x 22	26671	M 62 x 4.0	105 x 36	28173	M 82 x 2.0	130 x 25	28216
M 44 x 2.0	90 x 22	26673	M 63 x 1.5	105 x 22	28174	M 82 x 3.0	130 x 36	28217
M 45 x 1.0	90 x 22	26675	M 64 x 1.5	120 x 22	28175	M 82 x 4.0	130 x 36	28218
M 45 x 1.5	90 x 22	26676	M 64 x 2.0	120 x 22	28176	M 84 x 1.5	130 x 25	28219
M 45 x 2.0	90 x 22	26678	M 64 x 3.0	120 x 36	28177	M 84 x 2.0	130 x 25	28220
M 45 x 3.0	90 x 36	26680	M 64 x 4.0	120 x 36	28178	M 84 x 3.0	130 x 36	28221
M 46 x 1.5	90 x 22	26681	M 65 x 1.5	120 x 22	28179	M 84 x 4.0	130 x 35	28222
M 48 x 1.0	90 x 22	26683	M 65 x 2.0	120 x 22	28180	M 85 x 1.5	130 x 25	28223
M 48 x 1.5	90 x 22	26682	M 65 x 3.0	120 x 36	28181	M 85 x 2.0	130 x 25	28224



D - mm	Ø - o / d	Art.-No.	D - mm	Ø - o / d	Art.-No.	D - mm	Ø - o / d	Art.-No.
M 85 x 3.0	130 x 36	28225	M 92 x 1.5	140 x 22	28239	M 98 x 3.0	150 x 25	28253
M 85 x 4.0	130 x 36	28226	M 92 x 2.0	140 x 22	28240	M 98 x 4.0	150 x 25	28254
M 86 x 1.5	140 x 22	28227	M 92 x 3.0	140 x 22	28241	M 100 x 1.5	150 x 25	28255
M 86 x 2.0	140 x 22	28228	M 92 x 4.0	140 x 22	28242	M 100 x 2.0	150 x 25	28256
M 86 x 3.0	140 x 22	28229	M 95 x 1.5	140 x 22	28243	M 100 x 3.0	150 x 25	28257
M 86 x 4.0	140 x 22	28230	M 95 x 2.0	140 x 22	28244	M 100 x 4.0	150 x 25	28258
M 88 x 1.5	140 x 22	28231	M 95 x 3.0	140 x 22	28245	M 105 x 1.5	150 x 25	28259
M 88 x 2.0	140 x 22	28232	M 95 x 4.0	140 x 22	28246	M 105 x 2.0	150 x 25	28260
M 88 x 3.0	140 x 22	28233	M 96 x 1.5	140 x 22	28247	M 105 x 3.0	150 x 25	28261
M 88 x 4.0	140 x 22	28234	M 96 x 2.0	140 x 22	28248	M 105 x 4.0	150 x 25	28262
M 90 x 1.5	140 x 22	28235	M 96 x 3.0	140 x 22	28249	M 110 x 1.5	160 x 25	28263
M 90 x 2.0	140 x 22	28236	M 96 x 4.0	140 x 22	28250	M 110 x 2.0	160 x 25	28264
M 90 x 3.0	140 x 22	28237	M 98 x 1.5	150 x 25	28251	M 110 x 3.0	160 x 25	28265
M 90 x 4.0	140 x 22	28238	M 98 x 2.0	150 x 25	28252	M 110 x 4.0	160 x 25	28266



Round dies gun nosed

DIN 223 (DIN EN 22568) HSS-E - Mf

Type of thread: metric ISO-thread DIN 13

Tolerance: 6g

Variants (17):

Advantages:

- > high cutting ability
- > easy cut
- > uninterrupted swarf flow in direction of feed
- > prevents jamming of swarf

Application:

- > abrasive material up to 1200 N/mm²
- > stainless steel
- > and for general use

D - 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

D - mm	Ø - o / d	Art.-No.
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



Round dies, left hand

DIN 223 (DIN EN 22568) HSS - Mf LH

Type of thread: metric ISO-thread DIN 13

Tolerance: 6g

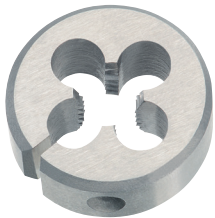
Variants (134):

Application: > non abrasive material up to 800 N/mm² > unalloyed and low alloyed steel

D - mm	Ø - o / d	Art.-No.	D - mm	Ø - o / d	Art.-No.	D - mm	Ø - o / d	Art.-No.
M 2.5 x 0.35	16 x 5	26801	M 14 x 1.0	38 x 10	26829	M 26 x 1.0	55 x 16	26856
M 3 x 0.35	20 x 5	26802	M 14 x 1.25	38 x 10	26227	M 26 x 1.5	55 x 16	26857
M 3.5 x 0.35	20 x 5	26803	M 14 x 1.5	38 x 10	26228	M 26 x 2.0	55 x 16	26858
M 4 x 0.35	20 x 5	26804	M 15 x 0.75	38 x 10	26830	M 27 x 1.0	65 x 18	26859
M 4 x 0.5	20 x 5	26805	M 15 x 1.0	38 x 10	26831	M 27 x 1.5	65 x 18	26860
M 4.5 x 0.5	20 x 5	26806	M 15 x 1.5	38 x 10	26832	M 27 x 2.0	65 x 18	26861
M 5 x 0.5	20 x 5	26807	M 16 x 0.75	45 x 14	26833	M 28 x 1.0	65 x 18	26862
M 5 x 0.75	20 x 7	26808	M 16 x 1.0	45 x 14	26231	M 28 x 1.5	65 x 18	26863
M 5.5 x 0.5	20 x 5	26809	M 16 x 1.25	45 x 14	26834	M 28 x 2.0	65 x 18	26864
M 6 x 0.5	20 x 5	26810	M 16 x 1.5	45 x 14	26233	M 29 x 1.5	65 x 18	26865
M 6 x 0.75	20 x 7	26207	M 17 x 1.0	45 x 14	26835	M 30 x 1.0	65 x 18	26866
M 7 x 0.5	25 x 9	26811	M 17 x 1.5	45 x 14	26836	M 30 x 1.5	65 x 18	26867
M 7 x 0.75	25 x 9	26812	M 18 x 0.75	45 x 14	26837	M 30 x 2.0	65 x 18	26264
M 8 x 0.5	25 x 9	26813	M 18 x 1.0	45 x 14	26838	M 30 x 2.5	65 x 18	26265
M 8 x 0.75	25 x 9	26210	M 18 x 1.25	45 x 14	26839	M 30 x 3.0	65 x 25	26266
M 8 x 1.0	25 x 9	26211	M 18 x 1.5	45 x 14	26236	M 32 x 1.0	65 x 18	26267
M 9 x 0.5	25 x 9	26814	M 18 x 2.0	45 x 14	26840	M 32 x 1.5	65 x 18	26268
M 9 x 0.75	25 x 9	26815	M 19 x 1.0	45 x 14	26841	M 32 x 2.0	65 x 18	26269
M 9 x 1.0	25 x 9	26816	M 19 x 1.5	45 x 14	26842	M 32 x 3.0	65 x 25	26270
M 10 x 0.5	30 x 11	26817	M 20 x 0.5	45 x 14	26843	M 33 x 1.5	65 x 18	26271
M 10 x 0.75	30 x 11	26818	M 20 x 0.75	45 x 14	26844	M 33 x 2.0	65 x 18	26272
M 10 x 1.0	30 x 11	26215	M 20 x 1.0	45 x 14	26845	M 33 x 3.0	65 x 25	26273
M 10 x 1.25	30 x 11	26216	M 20 x 1.25	45 x 14	26846	M 34 x 1.0	65 x 18	26274
M 11 x 1.0	30 x 11	26819	M 20 x 1.5	45 x 14	26240	M 34 x 1.5	65 x 18	26275
M 11 x 1.25	30 x 11	26820	M 20 x 2.0	45 x 14	26847	M 34 x 2.0	65 x 18	26276
M 12 x 0.5	38 x 10	26821	M 21 x 1.0	45 x 14	26848	M 35 x 1.0	65 x 18	26277
M 12 x 0.75	38 x 10	26822	M 21 x 1.5	45 x 14	26849	M 35 x 1.5	65 x 18	26278
M 12 x 1.0	38 x 10	26220	M 22 x 1.0	55 x 16	26850	M 35 x 2.0	65 x 18	26279
M 12 x 1.25	38 x 10	26221	M 22 x 1.25	55 x 16	26851	M 36 x 1.0	65 x 18	26280
M 12 x 1.5	38 x 10	26222	M 22 x 1.5	55 x 16	26245	M 36 x 1.5	65 x 18	26281
M 13 x 0.5	38 x 10	26823	M 22 x 2.0	55 x 16	26852	M 36 x 2.0	65 x 18	26282
M 13 x 0.75	38 x 10	26824	M 24 x 1.25	55 x 16	26853	M 36 x 3.0	65 x 25	26283
M 13 x 1.0	38 x 10	26825	M 24 x 1.5	55 x 16	26250	M 37 x 1.5	65 x 18	26284
M 13 x 1.5	38 x 10	26826	M 24 x 2.0	55 x 16	26251	M 38 x 1.0	75 x 20	26285
M 14 x 0.5	38 x 10	26827	M 25 x 1.0	55 x 16	26854	M 38 x 1.5	75 x 20	26286
M 14 x 0.75	38 x 10	26828	M 25 x 1.5	55 x 16	26855	M 38 x 2.0	75 x 20	26287



D - mm	Ø - o / d	Art.-No.	D - mm	Ø - o / d	Art.-No.	D - mm	Ø - o / d	Art.-No.
M 38 x 3.0	75 x 30	26288	M 42 x 1.5	75 x 20	26297	M 48 x 2.0	90 x 22	26874
M 39 x 1.5	75 x 20	26289	M 42 x 2.0	75 x 20	26298	M 48 x 3.0	90 x 36	26875
M 39 x 2.0	75 x 20	26290	M 42 x 3.0	75 x 30	26299	M 50 x 1.5	90 x 22	26876
M 39 x 3.0	75 x 30	26291	M 44 x 1.5	90 x 22	26868	M 50 x 2.0	90 x 22	26877
M 40 x 1.0	75 x 20	26292	M 45 x 1.5	90 x 22	26869	M 50 x 3.0	90 x 36	26878
M 40 x 1.5	75 x 20	26293	M 45 x 2.0	90 x 22	26870	M 52 x 1.5	90 x 22	26879
M 40 x 2.0	75 x 20	26294	M 45 x 3.0	90 x 36	26871	M 52 x 2.0	90 x 22	26880
M 40 x 3.0	75 x 30	26295	M 46 x 1.5	90 x 22	26872	M 52 x 3.0	90 x 36	26881
M 42 x 1.0	75 x 20	26296	M 48 x 1.5	90 x 22	26873			



Round dies

BS 1127; 1950 HSS - Mf

Type of thread: metric ISO-thread DIN 13

Tolerance: 6g

Variants (46):

Application: > non abrasive material up to 800 N/mm² > unalloyed and low alloyed steel

D - mm	Ø - o / d	L1	Art.-No.	D - mm	Ø - o / d	L1	Art.-No.
M 3 x 0.35	13/16 o / d	1/4 width	81010	M 16 x 1.5	1.1/2 o / d	1/2 width	81044
M 4 x 0.5	13/16 o / d	1/4 width	81011	M 18 x 1.0	1.1/2 o / d	1/2 width	81045
M 4 x 0.75	13/16 o / d	1/4 width	81012	M 18 x 1.25	1.1/2 o / d	1/2 width	81046
M 5 x 0.5	13/16 o / d	1/4 width	81013	M 18 x 1.5	1.1/2 o / d	1/2 width	81047
M 5 x 0.9	13/16 o / d	1/4 width	81014	M 18 x 2.0	1.1/2 o / d	1/2 width	81048
M 6 x 0.75	13/16 o / d	1/4 width	81015	M 20 x 1.0	1.1/2 o / d	1/2 width	81049
M 6 x 0.75	1" o / d	3/8 width	81020	M 20 x 1.25	1.1/2 o / d	1/2 width	81050
M 8 x 0.75	1" o / d	3/8 width	81021	M 20 x 1.5	1.1/2 o / d	1/2 width	81051
M 8 x 1.0	1" o / d	3/8 width	81022	M 20 x 2.0	1.1/2 o / d	1/2 width	81052
M 9 x 1.0	1" o / d	3/8 width	81023	M 18 x 1.5	5/8 o / d	5/8 width	81060
M 10 x 0.75	1" o / d	3/8 width	81024	M 20 x 1.0	5/8 o / d	5/8 width	81061
M 10 x 1.0	1" o / d	3/8 width	81025	M 20 x 1.5	5/8 o / d	5/8 width	81062
M 10 x 1.25	1" o / d	3/8 width	81026	M 22 x 1.5	5/8 o / d	5/8 width	81063
M 12 x 1.0	1.5/16 o / d	7/16 width	81030	M 24 x 1.5	5/8 o / d	5/8 width	81064
M 12 x 1.25	1.5/16 o / d	7/16 width	81031	M 24 x 2.0	5/8 o / d	5/8 width	81065
M 12 x 1.5	1.5/16 o / d	7/16 width	81032	M 25 x 1.5	5/8 o / d	5/8 width	81066
M 14 x 1.25	1.5/16 o / d	7/16 width	81033	M 26 x 1.5	5/8 o / d	5/8 width	81067
M 14 x 1.5	1.5/16 o / d	7/16 width	81034	M 27 x 2.0	3/4 o / d	3/4 width	81080
M 16 x 1.5	1.5/16 o / d	7/16 width	81035	M 30 x 2.0	3/4 o / d	3/4 width	81081
M 14 x 1.0	1.1/2 o / d	1/2 width	81040	M 27 x 1.5	7/8 o / d	7/8 width	81090
M 14 x 1.25	1.1/2 o / d	1/2 width	81041	M 30 x 1.5	7/8 o / d	7/8 width	81091
M 14 x 1.5	1.1/2 o / d	1/2 width	81042	M 36 x 2.0	7/8 o / d	7/8 width	81092
M 16 x 1.0	1.1/2 o / d	1/2 width	81043	M 36 x 3.0	7/8 o / d	7/8 width	81093

D = Nominal Diameter o / d = Outer Diameter L1 = Overall Length



Hexagon die nuts

DIN 382 HSS - Mf

Type of thread: metric ISO-thread DIN 13

Tolerance: 6g

Variants (101):

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

D - mm	Width across flats	Art.-No.	D - mm	Width across flats	Art.-No.	D - mm	Width across flats	Art.-No.
M 3 x 0.35	19 x 5	26108	M 18 x 1.25	41 x 14	26171	M 32 x 2.0	60 x 18	26735
M 4 x 0.35	19 x 5	26110	M 18 x 1.5	41 x 14	26172	M 32 x 3.0	60 x 25	26737
M 4 x 0.5	19 x 5	26112	M 18 x 2.0	41 x 14	26174	M 33 x 1.5	60 x 18	26738
M 5 x 0.5	19 x 5	26114	M 20 x 1.0	41 x 14	26178	M 33 x 2.0	60 x 18	26740
M 5 x 0.75	19 x 7	26116	M 20 x 1.25	41 x 14	26180	M 33 x 3.0	60 x 25	26742
M 6 x 0.5	19 x 5	26117	M 20 x 1.5	41 x 14	26184	M 34 x 1.5	60 x 18	26744
M 6 x 0.75	19 x 7	26118	M 20 x 2.0	41 x 14	26186	M 34 x 2.0	60 x 18	26746
M 7 x 0.75	22 x 9	26120	M 21 x 1.5	41 x 14	26188	M 35 x 1.5	60 x 18	26748
M 8 x 0.5	22 x 9	26122	M 22 x 1.0	50 x 16	26190	M 36 x 1.5	60 x 18	26750
M 8 x 0.75	22 x 9	26124	M 22 x 1.25	50 x 16	26192	M 36 x 2.0	60 x 18	26752
M 8 x 1.0	22 x 9	26126	M 22 x 1.5	50 x 16	26194	M 36 x 3.0	60 x 25	26754
M 9 x 0.75	22 x 9	26128	M 22 x 2.0	50 x 16	26196	M 38 x 1.5	70 x 20	26756
M 9 x 1.0	22 x 9	26130	M 23 x 1.5	50 x 16	26198	M 39 x 1.5	70 x 20	26758
M 10 x 0.75	27 x 11	26132	M 24 x 1.0	50 x 16	26700	M 39 x 2.0	70 x 20	26760
M 10 x 1.0	27 x 11	26136	M 24 x 1.25	50 x 16	26702	M 39 x 3.0	70 x 30	26762
M 10 x 1.25	27 x 11	26138	M 24 x 1.5	50 x 16	26704	M 40 x 1.5	70 x 20	26764
M 11 x 1.0	27 x 11	26140	M 24 x 2.0	50 x 16	26706	M 40 x 2.0	70 x 20	26766
M 11 x 1.25	27 x 11	26142	M 25 x 1.0	50 x 16	26707	M 40 x 3.0	70 x 30	26768
M 12 x 0.75	36 x 10	26143	M 25 x 1.5	50 x 16	26708	M 42 x 1.5	70 x 20	26770
M 12 x 1.0	36 x 10	26144	M 26 x 1.0	50 x 16	26710	M 42 x 2.0	70 x 20	26772
M 12 x 1.25	36 x 10	26146	M 26 x 1.5	50 x 16	26712	M 42 x 3.0	70 x 30	26774
M 12 x 1.5	36 x 10	26148	M 26 x 2.0	50 x 16	26714	M 45 x 1.5	85 x 22	26776
M 13 x 1.0	36 x 10	26150	M 27 x 1.0	60 x 18	26717	M 45 x 2.0	85 x 22	26778
M 13 x 1.5	36 x 10	26151	M 27 x 1.5	60 x 18	26716	M 45 x 3.0	85 x 36	26780
M 14 x 0.75	36 x 10	26152	M 27 x 2.0	60 x 18	26718	M 48 x 1.5	85 x 22	26782
M 14 x 1.0	36 x 10	26153	M 28 x 1.0	60 x 18	26720	M 48 x 2.0	85 x 22	26784
M 14 x 1.25	36 x 10	26154	M 28 x 1.5	60 x 18	26722	M 48 x 3.0	85 x 36	26786
M 14 x 1.5	36 x 10	26156	M 28 x 2.0	60 x 18	26724	M 50 x 1.5	85 x 22	26788
M 15 x 1.0	36 x 10	26158	M 29 x 1.5	60 x 18	26726	M 50 x 2.0	85 x 22	26790
M 15 x 1.5	36 x 10	26160	M 30 x 1.0	60 x 18	26728	M 50 x 3.0	85 x 36	26792
M 16 x 1.0	41 x 14	26162	M 30 x 1.5	60 x 18	26730	M 52 x 1.5	85 x 22	26794
M 16 x 1.25	41 x 14	26164	M 30 x 2.0	60 x 18	26732	M 52 x 2.0	85 x 22	26796
M 16 x 1.5	41 x 14	26166	M 30 x 3.0	60 x 25	26734	M 52 x 3.0	85 x 36	26798
M 18 x 1.0	41 x 14	26170	M 32 x 1.5	60 x 18	26736			



BSW



Round dies

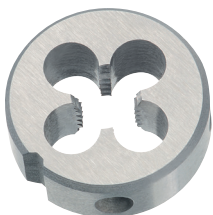
DIN 223 (DIN EN 22568) HSS-G - BSW

Type of thread: Whitworth-thread BS 84

Variants (29):

Application: > non abrasive material up to 800 N/mm² > unalloyed and low alloyed steel

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



Round dies

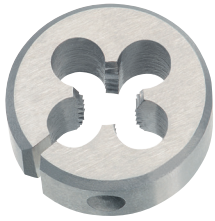
BS 1127; 1950 HSS - BSW fine

Type of thread: Whitworth-thread BS 84

Variants (5):

Application: > non abrasive material up to 800 N/mm² > unalloyed and low alloyed steel

D - mm	Ø - o / d	L1	Art.-No.
BSW 1/4 x 26	1" o / d	3/8 width	84110
BSW 5/16 x 26	1" o / d	3/8 width	84111
BSW 3/8 x 26	1" o / d	3/8 width	84112
BSW 7/16 x 26	1.5/16 o / d	7/16 width	84120
BSW 1/2 x 26	1.5/16 o / d	7/16 width	84121



Round dies

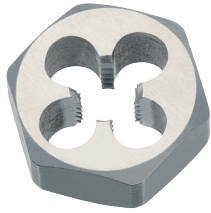
BS 1127; 1950 HSS - BSW

Type of thread: Whitworth-thread BS 84

Variants (33):

Application: > non abrasive material up to 800 N/mm² > unalloyed and low alloyed steel

D - mm	Ø - o / d	L1	Art.-No.
BSW 3/32 x 48	13/16 o / d	1/4 width	84001
BSW 1/8 x 40	13/16 o / d	1/4 width	84002
BSW 5/32 x 32	13/16 o / d	1/4 width	84003
BSW 3/16 x 24	13/16 o / d	1/4 width	84004
BSW 7/32 x 24	13/16 o / d	1/4 width	84005
BSW 1/4 x 20	13/16 o / d	1/4 width	84006
BSW 1/4 x 20	1" o / d	3/8 width	84010
BSW 5/16 x 18	1" o / d	3/8 width	84011
BSW 3/8 x 16	1" o / d	3/8 width	84012
BSW 7/16 x 14	1" o / d	3/8 width	84013
BSW 1/2 x 12	1" o / d	3/8 width	84014
BSW 1/4 x 20	1.5/16 o / d	7/16 width	84020
BSW 5/16 x 18	1.5/16 o / d	7/16 width	84021
BSW 3/8 x 16	1.5/17 o / d	7/16 width	84022
BSW 7/16 x 14	1.5/17 o / d	7/16 width	84023
BSW 1/2 x 12	1.5/18 o / d	7/8 width	84024
BSW 9/16 x 12	1.5/18 o / d	7/8 width	84025
BSW 3/8 x 16	1.1/2 o / d	1/2 width	84030
BSW 7/16 x 14	1.1/2 o / d	1/2 width	84031
BSW 1/2 x 12	1.1/2 o / d	1/2 width	84032
BSW 9/16 x 12	1.1/2 o / d	1/2 width	84033
BSW 5/8 x 11	1.1/2 o / d	1/2 width	84034
BSW 3/4 x 10	1.1/2 o / d	1/2 width	84035
BSW 1/2 x 12	2" o / d	5/8 width	84040
BSW 9/16 x 12	2" o / d	5/8 width	84041
BSW 5/8 x 11	2" o / d	5/8 width	84042
BSW 3/4 x 10	2" o / d	5/8 width	84043
BSW 7/8 x 9	2" o / d	5/8 width	84044
BSW 1 x 8	2" o / d	5/8 width	84045
BSW 1.1/8 x 7	3" o / d	7/6 width	84050
BSW 1.1/4 x 7	3" o / d	7/6 width	84051
BSW 1.3/8 x 6	3" o / d	7/8 width	84052
BSW 1.1/2 x 6	3" o / d	7/8 width	84053



Hexagon die nuts

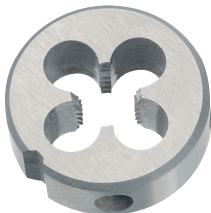
DIN 382 HSS - BSW

Type of thread: Whitworth-thread BS 84

Variants (21):

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

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



Round dies, left hand

DIN 223 (DIN EN 22568) HSS-G - BSW LH

Type of thread: Whitworth-thread BS 84

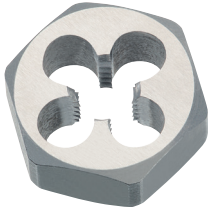
Variants (13):

Application: > non abrasive material up to 800 N/mm² > unalloyed and low alloyed steel

D - mm	Ø - o / d	Art.-No.
BSW 1/8 x 40	20 x 5	22206
BSW 5/32 x 32	20 x 5	22208
BSW 3/16 x 24	20 x 7	22210
BSW 1/4 x 20	20 x 7	22214
BSW 5/16 x 18	25 x 9	22216
BSW 3/8 x 16	30 x 11	22218
BSW 7/16 x 14	30 x 11	22220
BSW 1/2 x 12	38 x 14	22222
BSW 9/16 x 12	38 x 14	22224
BSW 5/8 x 11	45 x 18	22226
BSW 3/4 x 10	45 x 18	22230
BSW 7/8 x 9	55 x 22	22234
BSW 1" x 8	55 x 22	22238



BSF



Hexagon die nuts

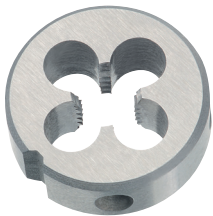
DIN 382 HSS - BSF

Type of thread: Whitworth-thread BS 84

Variants (11):

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

D - mm	Width across flats	Art.-No.	D - mm	Width across flats	Art.-No.
BSF 3/16 x 32	19 x 7	22510	BSF 9/16 x 16	36 x 10	22524
BSF 1/4 x 26	19 x 7	22514	BSF 5/8 x 14	41 x 14	22526
BSF 5/16 x 22	22 x 9	22516	BSF 3/4 x 12	41 x 14	22530
BSF 3/8 x 20	27 x 11	22518	BSF 7/8 x 11	50 x 16	22534
BSF 7/16 x 18	27 x 11	22520	BSF 1" x 10	50 x 16	22538
BSF 1/2 x 16	36 x 10	22522			



Round dies

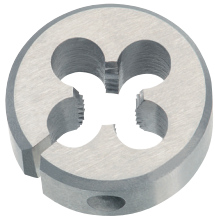
DIN 223 (DIN EN 22568) HSS-G - BSF

Type of thread: British-Standard-Fine-thread BS 84

Variants (11):

Application: > non abrasive material up to 800 N/mm² > unalloyed and low alloyed steel

D - mm	Ø - o / d	Art.-No.
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



Round dies

BS 1127; 1950 HSS - BSF

Type of thread: British-Standard-Fine-thread BS 84

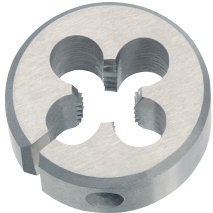
Variants (26):

Application: > non abrasive material up to 800 N/mm² > unalloyed and low alloyed steel

D - mm	Ø - o / d	L1	Art.-No.
BSF 3/16 x 32	13/16 o / d	1/4 width	85004
BSF 7/32 x 30	13/16 o / d	1/4 width	85005
BSF 1/4 x 26	13/16 o / d	1/4 width	85006
BSF 1/4 x 26	1" o / d	3/8 width	85010
BSF 5/16 x 22	1" o / d	3/8 width	85011
BSF 3/8 x 20	1" o / d	3/8 width	85012
BSF 7/16 x 18	1" o / d	3/8 width	85013
BSF 1/2 x 16	1" o / d	3/8 width	85014
BSF 1/4 x 26	1.5/16 o / d	7/16 width	85020
BSF 5/16 x 22	1.5/16 o / d	7/16 width	85021
BSF 3/8 x 20	1.5/16 o / d	7/16 width	85022
BSF 7/16 x 18	1.5/16 o / d	7/16 width	85023
BSF 1/2 x 16	1.5/16 o / d	7/16 width	85024
BSF 9/16 x 16	1.5/16 o / d	7/16 width	85025
BSF 3/8 x 20	1.1/2 o / d	1/2 width	85030
BSF 7/16 x 18	1.1/2 o / d	1/2 width	85031
BSF 1/2 x 16	1.1/2 o / d	1/2 width	85032
BSF 9/16 x 16	1.1/2 o / d	1/2 width	85033
BSF 5/8 x 14	1.1/2 o / d	1/2 width	85034
BSF 3/4 x 12	1.1/2 o / d	1/2 width	85035
BSF 1/2 x 16	2" o / d	1/2 width	85040
BSF 9/16 x 16	2" o / d	5/8 width	85041
BSF 5/8 x 14	2" o / d	5/8 width	85042
BSF 3/4 x 12	2" o / d	5/8 width	85043
BSF 7/8 x 11	2" o / d	5/8 width	85044
BSF 1 x 10	2" o / d	5/8 width	85045



BA



Round dies, split
Form A BS 1127 HSS-G - BA

Type of thread: BA-thread BS 93

Variants (7):

Application: > non abrasive material up to 800 N/mm² > unalloyed and low alloyed steel

D - mm	Ø - o / d	Art.-No.
BA 0	20.6 x 6.35	89000
BA 1	20.6 x 6.35	89001
BA 2	20.6 x 6.35	89002
BA 3	20.6 x 6.35	89003
BA 4	20.6 x 6.35	89004
BA 5	20.6 x 6.35	89005
BA 6	20.6 x 6.35	89006



UNC



Hexagon die nuts (set of 5 pcs.) (49530)

DIN standard HSS UNC 1/4 - UNC 1/2

Type of thread	Standard	Material	Packing	Size
Unified Coarse thread ANSI B 1.1	DIN standard	HSS-G	in metal case	Diameter UNC 1/4 - 1/2

Application/ for general use:

- › non abrasive material up to 800 N/mm²
- › unalloyed and low alloyed steel
- › small, handy set for standard application
- › the most popular diameter together in one case
- › Hexagon die nuts acc. to DIN 382

All threading tools, threading tool holder and accessories can also be ordered separately

Contents:

Art. -No.

1x HSS Hexagon die nut UNC 1/4	23114
1x HSS Hexagon die nut UNC 5/16	23116
1x HSS Hexagon die nut UNC 3/8	23118
1x HSS Hexagon die nut UNC 7/16	23120
1x HSS Hexagon die nut UNC 1/2	23122



Hexagon die nuts

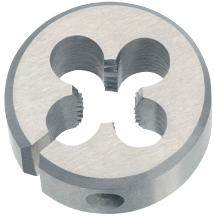
DIN 382 HSS - UNC

Type of thread: Unified Coarse thread ANSI B 1.1

Variants (14):

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

D - mm		Width across flats	Art.-No.	D - mm		Width across flats	Art.-No.
UNC 1/4 x 20		19 x 7	23114	UNC 3/4 x 10		41 x 18	23130
UNC 5/16 x 18		22 x 9	23116	UNC 7/8 x 9		50 x 22	23134
UNC 3/8 x 16		27 x 11	23118	UNC 1" x 8		50 x 22	23138
UNC 7/16 x 14		27 x 11	23120	UNC 1.1/8 x 7		60 x 25	23142
UNC 1/2 x 13		36 x 14	23122	UNC 1.1/4 x 7		60 x 25	23146
UNC 9/16 x 12		36 x 14	23124	UNC 1.3/8 x 6		60 x 25	23150
UNC 5/8 x 11		41 x 18	23126	UNC 1.1/2 x 6		70 x 30	23154



Round dies

BS 1127; 1950 HSS - UNC

Type of thread: Unified Coarse thread ANSI B 1.1

Variants (33):

Application: > non abrasive material up to 800 N/mm² > unalloyed and low alloyed steel

D - mm	Ø - o / d	L1	Art.-No.
UNC 4 x 40	13/16 o / d	1/4 width	82004
UNC 5 x 40	13/16 o / d	1/4 width	82005
UNC 6 x 32	13/16 o / d	1/4 width	82006
UNC 8 x 32	13/16 o / d	1/4 width	82008
UNC 10 x 24	13/16 o / d	1/4 width	82010
UNC 12 x 24	13/16 o / d	1/4 width	82012
UNC 1/4 x 20	13/16 o / d	1/4 width	82013
UNC 1/4 x 20	1" o / d	3/8 width	82020
UNC 5/16 x 18	1" o / d	3/8 width	82021
UNC 3/8 x 16	1" o / d	3/8 width	82022
UNC 7/16 x 14	1" o / d	3/8 width	82023
UNC 1/2 x 13	1" o / d	3/8 width	82024
UNC 1/4 x 20	1.5/16 o / d	7/16 width	82030
UNC 5/16 x 18	1.5/16 o / d	7/16 width	82031
UNC 3/8 x 16	1.5/16 o / d	7/16 width	82032
UNC 7/16 x 14	1.5/16 o / d	7/16 width	82033
UNC 1/2 x 13	1.5/16 o / d	7/16 width	82034
UNC 9/16 x 12	1.5/16 o / d	7/16 width	82035
UNC 3/8 x 16	1.1/2 o / d	1/2 width	82040
UNC 7/16 x 14	1.1/2 o / d	1/2 width	82041
UNC 1/2 x 13	1.1/2 o / d	1/2 width	82042
UNC 9/16 x 12	1.1/2 o / d	1/2 width	82043
UNC 5/8 x 11	1.1/2 o / d	1/2 width	82044
UNC 3/4 x 10	1.1/2 o / d	1/2 width	82045
UNC 1/2 x 13	2" o / d	5/8 width	82050
UNC 9/16 x 12	2" o / d	5/8 width	82051
UNC 5/8 x 11	2" o / d	5/8 width	82052
UNC 3/4 x 10	2" o / d	5/8 width	82053
UNC 7/8 x 9	2" o / d	5/8 width	82054
UNC 1 x 8	2" o / d	5/8 width	82055
UNC 1.1/4 x 7	3" o / d	7/8 width	82056
UNC 1.3/8 x 6	3" o / d	7/8 width	82057
UNC 1.1/2 x 6	3" o / d	7/8 width	82058



Round dies, left hand

DIN 223 (DIN EN 22568) HSS-G - UNC LH

Type of thread: Unified Coarse thread ANSI B 1.1

Variants (13):

Application: > non abrasive material up to 800 N/mm² > unalloyed and low alloyed steel

D - mm	Ø - o / d	Art.-No.	D - mm	Ø - o / d	Art.-No.
UNC Nr. 6 x 32	20 x 7	23206	UNC 1/2 x 13	38 x 14	23222
UNC Nr. 8 x 32	20 x 7	23208	UNC 9/16 x 12	38 x 14	23224
UNC Nr.10 x 24	20 x 7	23210	UNC 5/8 x 11	45 x 18	23226
UNC 1/4 x 20	20 x 7	23214	UNC 3/4 x 10	45 x 18	23230
UNC 5/16 x 18	25 x 9	23216	UNC 7/8 x 9	55 x 22	23234
UNC 3/8 x 16	30 x 11	23218	UNC 1" x 8	55 x 22	23238
UNC 7/16 x 14	38 x 14	23220			



Round dies

DIN 223 (DIN EN 22568) HSS-G - UNC

Type of thread: Unified Coarse thread ANSI B 1.1

Variants (28):

Application: > non abrasive material up to 800 N/mm² > unalloyed and low alloyed steel

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



UNF - UNEF



Hexagon die nuts (set of 5 pcs.) (49540)

DIN standard HSS UNF 1/4 - UNF 1/2

Type of thread	Standard	Material	Packing	Size
Unified Fine thread ANSI B 1.1	DIN standard	HSS-G	in metal case	Diameter UNF 1/4 - 1/2

Application:

- › for cleaning and repairing damaged threads and for general use in awkward places.
- › non abrasive material up to 800 N/mm²
- › unalloyed and low alloyed steel
- › small, handy set for standard application
- › the most popular diameter together in one case
- › Hexagon die nuts acc. to DIN 382

All threading tools, threading tool holder and accessories can also be ordered separately

Contents:

Art. -No.

1x HSS Hexagon die nut UNF 1/4	24114
1x HSS Hexagon die nut UNF 5/16	24116
1x HSS Hexagon die nut UNF 3/8	24118
1x HSS Hexagon die nut UNF 7/16	24120
1x HSS Hexagon die nut UNF 1/2	24122



Hexagon die nuts

DIN 382 HSS - UNF

Type of thread: Unified Fine thread ANSI B 1.1

Variants (14):

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

D - mm	Width across flats	Art.-No.	D - mm	Width across flats	Art.-No.
UNF 1/4 x 28	19 x 7	24114	UNF 3/4 x 16	41 x 14	24130
UNF 5/16 x 24	22 x 9	24116	UNF 7/8 x 14	50 x 16	24134
UNF 3/8 x 24	27 x 11	24118	UNF 1" x 12	50 x 16	24138
UNF 7/16 x 20	27 x 11	24120	UNF 1.1/8 x 12	60 x 18	24142
UNF 1/2 x 20	36 x 10	24122	UNF 1.1/4 x 12	60 x 18	24146
UNF 9/16 x 18	36 x 10	24124	UNF 1.3/8 x 12	60 x 18	24150
UNF 5/8 x 18	41 x 14	24126	UNF 1.1/2 x 12	70 x 20	24154



Round dies

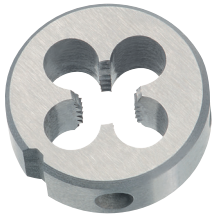
DIN 223 (DIN EN 22568) HSS-G - UNF

Type of thread: Unified Fine thread ANSI B 1.1

Variants (26):

Application: > non abrasive material up to 800 N/mm² > unalloyed and low alloyed steel

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



Round dies, left hand

DIN 223 (DIN EN 22568) HSS-G - UNF LH

Type of thread: Unified Fine thread ANSI B 1.1

Variants (11):

Application: > non abrasive material up to 800 N/mm² > unalloyed and low alloyed steel

D - mm	Ø - o / d	Art.-No.	D - mm	Ø - o / d	Art.-No.
UNF Nr. 10 x 32	20 x 7	24210	UNF 9/16 x 18	38 x 10	24224
UNF 1/4 x 28	20 x 7	24214	UNF 5/8 x 18	45 x 14	24226
UNF 5/16 x 24	25 x 9	24216	UNF 3/4 x 16	45 x 14	24230
UNF 3/8 x 24	30 x 11	24218	UNF 7/8 x 14	55 x 16	24234
UNF 7/16 x 20	30 x 11	24220	UNF 1" x 12	55 x 16	24238
UNF 1/2 x 20	38 x 10	24222			



Round dies

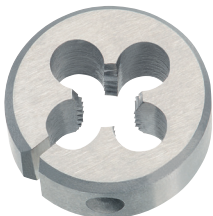
DIN 223 (DIN EN 22568) HSS-G - UNEF

Type of thread: Unified Extra Fine thread ANSI B 1.1

Variants (22):

Application: > non abrasive material up to 800 N/mm² > unalloyed and low alloyed steel

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



Round dies

BS 1127; 1950 HSS - UNF

Type of thread: Unified Fine thread ANSI B 1.1

Variants (35):

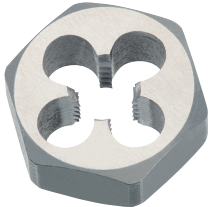
Application: > non abrasive material up to 800 N/mm² > unalloyed and low alloyed steel

D - mm	Ø - o / d	L1 width	Art.-No.	D - mm	Ø - o / d	L1 width	Art.-No.	D - mm	Ø - o / d	L1 width	Art.-No.
UNF 4 x 48	13/16	1/4	83004	UNF 3/8 x 24	1.5/16	7/16	83032	UNF 7/8 x 14	2"	5/8	83054
UNF 5 x 44	13/16	1/4	83005	UNF 7/16 x 20	1.5/16	7/16	83033	UNF 1" x 12	2"	5/8	83055
UNF 6 x 40	13/16	1/4	83006	UNF 1/2 x 20	1.5/16	7/16	83034	UNF 1" x 14	2"	5/8	83056
UNF 8 x 36	13/16	1/4	83008	UNF 9/16 x 18	1.5/16	7/16	83035	UNF 1.1/8 x 12	3"	7/8	83057
UNF 10 x 32	13/16	1/4	83010	UNF 3/8 x 24	1.1/2	1/2	83040	UNF 1.1/4 x 12	3"	7/8	83059
UNF 12 x 28	13/16	1/4	83012	UNF 7/16 x 20	1.1/2	1/2	83041	UNF 1.3/8 x 12	3"	7/8	83061
UNF 1/4 x 28	13/16	3/8	83013	UNF 1/2 x 20	1.1/2	1/2	83042	UNF 1.1/2 x 12	3"	7/8	83063
UNF 1/4 x 28	1"	3/8	83020	UNF 9/16 x 18	1.1/2	1/2	83043				
UNF 5/16 x 24	1"	3/8	83021	UNF 5/8 x 18	1.1/2	1/2	83044				
UNF 3/8 x 24	1"	3/8	83022	UNF 3/4 x 16	1.1/2	1/2	83045				
UNF 7/16 x 20	1"	3/8	83023	UNF 1/2 x 20	2"	5/8	83050				
UNF 1/2 x 20	1.5/16	3/8	83024	UNF 9/16 x 18	2"	5/8	83051				
UNF 1/4 x 28	1.5/16	7/16	83030	UNF 5/8 x 18	2"	5/8	83052				
UNF 5/16 x 24	1.5/16	7/16	83031	UNF 3/4 x 16	2"	5/8	83053				

D = Nominal Diameter Ø - o / d = Outer Diameter L1 = Overall Length



8 - UN



Hexagon die nuts

DIN 382 HSS - UNx8

Type of thread: Unified thread ANSI B 1.1

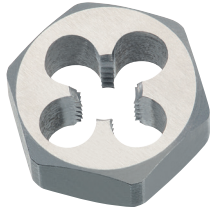
Variants (11):

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

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



G (BSP) - G (BSPF)



Hexagon die nuts + left hand

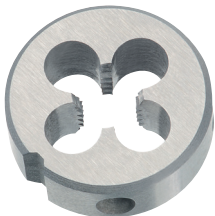
DIN 382 HSS - G (BSP) + left hand DIN 382 HSS - G (BSP) LH

Type of thread: Pipe-thread DIN ISO 228

Variants (15/13):

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

D - mm	Width across flats	Art.-No.	Art.-No. LH	D - mm	Width across flats	Art.-No.	Art.-No. LH
G 1/8 x 28	27 x 11	25512	25612	G 1.1/8 x 11	70 x 20	25530	25630
G 1/4 x 19	36 x 10	25514	25614	G 1.1/4 x 11	70 x 20	25534	25634
G 3/8 x 19	41 x 14	25516	25616	G 1.3/8 x 11	85 x 22	25538	25638
G 1/2 x 14	41 x 14	25518	25618	G 1.1/2 x 11	85 x 22	25542	25642
G 5/8 x 14	50 x 16	25520	25620	G 1.5/8 x 11	85 x 22	25546	-
G 3/4 x 14	50 x 16	25522	25622	G 1.3/4 x 11	100 x 22	25550	25650
G 7/8 x 14	60 x 18	25524	-	G 2" x 11	100 x 22	25554	25654
G 1" x 11	60 x 18	25526	25626				



Round dies gun nosed

DIN 5158 (DIN EN 24231) HSS-E - G (BSP)

Type of thread: Pipe-thread DIN ISO 228

Variants (6):

Advantages:

- > high cutting ability
- > easy cut
- > uninterrupted swarf flow in direction of feed
- > prevents jamming of swarf

Application:

- > abrasive material up to 1200 N/mm²
- > stainless steel
- > and for general use

D - mm	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



Round dies

DIN 5158 (DIN EN 24231) HSS-G - G (BSP)

Type of thread: Pipe-thread DIN ISO 228

Variants (22):

Application: > non abrasive material up to 800 N/mm² > unalloyed and low alloyed steel

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



Round dies, left hand

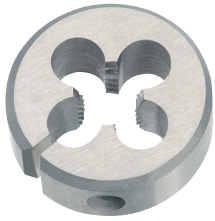
DIN 5158 (DIN EN 24231) HSS-G - G (BSP) LH

Type of thread: Pipe-thread DIN ISO 228

Variants (15):

Application: > non abrasive material up to 800 N/mm² > unalloyed and low alloyed steel

D - mm	Width across flats	Art.-No.	D - mm	Width across flats	Art.-No.
G 1/8 x 28	30 x 11	25212	G 1.1/8 x 11	75 x 20	25230
G 1/4 x 19	38 x 10	25214	G 1.1/4 x 11	75 x 20	25234
G 3/8 x 19	45 x 14	25216	G 1.3/8 x 11	90 x 22	25238
G 1/2 x 14	45 x 14	25218	G 1.1/2 x 11	90 x 22	25242
G 5/8 x 14	55 x 16	25220	G 1.5/8 x 11	90 x 22	25246
G 3/4 x 14	55 x 16	25222	G 1.3/4 x 11	105 x 22	25250
G 7/8 x 14	65 x 18	25224	G 2" x 11	105 x 22	25254
G 1" x 11	65 x 18	25226			



Round dies

BS 1127; 1950 HSS - G (BSPF)

Type of thread: Pipe-thread DIN ISO 228

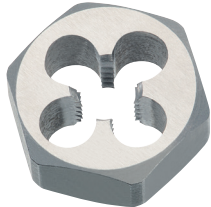
Variants (20):

Application: > non abrasive material up to 800 N/mm² > unalloyed and low alloyed steel

D - mm	Ø - o / d	L1	Art.-No.	D - mm	Ø - o / d	L1	Art.-No.
G 1/8 x 28	1"	3/8 width	86004	G 5/8 x 14	2"	5/8 width	86033
G 1/8 x 28	1.5/16	7/16 width	86012	G 3/4 x 14	2"	5/8 width	86034
G 1/4 x 19	1.5/16	7/16 width	86014	G 3/8 x 19	2.1/4	11/16 width	86040
G 1/8 x 28	1.1/2	1/2 width	86020	G 3/4 x 14	2.1/4	11/16 width	86041
G 1/4 x 19	1.1/2	1/2 width	86022	G 7/8 x 14	2.1/4	11/16 width	86042
G 3/8 x 19	1.1/2	1/2 width	86024	G 1 x 11	2.1/4	11/16 width	86043
G 1/2 x 19	1.1/2	1/2 width	86026	G 1 x 11	3"	7/8 width	86050
G 1/4 x 19	2"	5/8 width	86030	G 1.1/4 x 11	3"	7/8 width	86054
G 3/8 x 19	2"	5/8 width	86031	G 1.1/2 x 11	4"	1 width	86060
G 1/2 x 14	2"	5/8 width	86032	G 2 x 11	4"	1 width	86064



NPT - NPTF - NPS



Hexagon die nuts

DIN 382 HSS - NPT

Type of thread: american tapered pipe thread, taper 1:16

Variants (10):

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

D - mm		Width across flats	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

D - mm		Width across flats	Art.-No.
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	23554



Round dies

HSS-G - NPT + split Form A HSS-G - NPTF

Type of thread: american tapered pipe thread, taper 1:16

Variants (12/6):

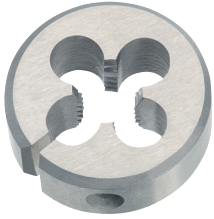
Application: > non abrasive material up to 800 N/mm² > unalloyed and low alloyed steel



D - mm		Ø - o / d	Art.-No.
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



D - mm		Ø - o / d	Art.-No.
Form A			
NPT	1/8 x 27	50 x 11	98072
NPT	1/4 x 18	50 x 14	98074
NPT	3/8 x 18	50 x 14	98076
NPT	1/2 x 14	50 x 18	98078
NPT	3/4 x 14	50 x 22	98080
NPT	1" x 11.5	50 x 25	98082



Round dies

JIS B-4451 HSS - NPT + JIS B-4451 HSS - NPS

Type of thread: american tapered pipe thread, taper 1:16

Variants (14/6):

Application: > non abrasive material up to 800 N/mm² > unalloyed and low alloyed steel

D - mm	Ø - o / d	Art.-No.
NPT 1/8	38	98006
NPT 1/8	50	98008
NPT 1/4	38	98014
NPT 1/4	50	98016
NPT 3/8	38	98018
NPT 3/8	50	98020
NPT 1/2	38	98022
NPT 3/4	50	98030
NPT 3/4	38	98032
NPT 1"	50	98038
NPT 1"	38	98040
NPT 1"	50	98042
NPT 1.1/4	38	98046
NPT 1.1/4	50	98048

D - mm	Ø - o / d	Art.-No.
NPS 1/8	50	99008
NPS 1/4	50	99016
NPS 3/8	50	99020
NPS 1/2	50	99022
NPS 3/4	50	99030
NPS 1"	50	99038



R (BSPT) Rp (BSPP) - PF - PT



Hexagon die nuts

DIN 382 HSS - R (BSPT)

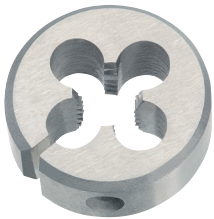
Type of thread: tapered pipe thread, taper 1:16, con. 55°

Variants (9):

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

D - mm		Width across flats	Art.-No.
R	1/8 x 28	27 x 11	23562
R	1/4 x 19	36 x 14	23564
R	3/8 x 19	41 x 15	23566
R	1/2 x 14	50 x 19	23568
R	3/4 x 14	60 x 20	23572

D - mm		Width across flats	Art.-No.
R	1" x 11	60 x 25	23576
R	1.1/4 x 11	85 x 26	23578
R	1.1/2 x 11	85 x 26	23580
R	2" x 11	100 x 31	23584



Round dies

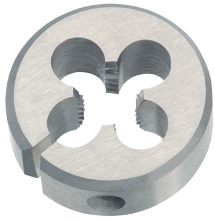
split Form A HSS-G - R (BSPT)

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

Variants (7):

Application: > non abrasive material up to 800 N/mm² > unalloyed and low alloyed steel

D - mm		Ø - o / d	Art.-No.
PT	1/8 x 28	38 x 11	97006
PT	1/4 x 19	38 x 16	97014
PT	3/8 x 19	50 x 18	97020
PT	1/2 x 14	50 x 22	97022
PT	3/4 x 14	50 x 24	97030
PT	1" x 11	63 x 28	97040
PT	1.1/4 x 11	75 x 32	97048



Round dies

JIS B-4451 HSS - Rp (BSPP)
 + JIS B-4451 HSS - PF
 + JIS B-4451 HSS - PT

Type of thread: Pipe-thread ISO 7-1
 Pipe-thread DIN ISO 228
 tapered pipe thread, taper 1:16, con. 55°

Variants (6/14/10):

Application: > non abrasive material up to 800 N/mm² > unalloyed and low alloyed steel

D - mm	Ø - o / d	Art.-No.	D - mm	Ø - o / d	Art.-No.	D - mm	Ø - o / d	Art.-No.
PS 1/8	50	95008	PF 1/8	38	96006	PT 1/8	50	97008
PS 1/4	50	95016	PF 1/8	50	96008	PT 1/4	50	97016
PS 3/8	50	95020	PF 1/4	38	96014	PT 3/8	38	97018
PS 1/2	50	95022	PF 1/4	50	96016	PT 5/8	55	97026
PS 3/4	50	95030	PF 3/8	38	96018	PT 3/4	65	97032
PS 1"	50	95038	PF 3/8	50	96020	PT 7/8	65	97036
			PF 1/2	50	96022	PT 1"	50	97038
			PF 3/4	50	96030	PT 1"	75	97042
			PF 3/4	65	96032	PT 1.1/4	65	97046
			PF 1"	50	96038	PT 1.1/2	90	97054
			PF 1"	65	96040			
			PF 1"	75	96042			
			PF 1.1/4	65	96046			
			PF 1.1/4	75	96048			



FG - BSC



Round dies

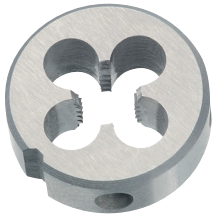
DIN 223 (DIN EN 22568) HSS - FG

Type of thread: Cycle Thread DIN 790012

Variants (9):

Application: > non abrasive material up to 800 N/mm² > unalloyed and low alloyed steel

D - mm	Ø - o / d	Art.-No.
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



Round dies

DIN 223 (DIN EN 22568) HSS - BSC

Type of thread: Cycle Thread DIN 790012

Variants (6):

Application: > non abrasive material up to 800 N/mm² > unalloyed and low alloyed steel

D - mm	Ø - o / d	Art.-No.
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



PG



Round dies

DIN 40434 HSS-G - PG

Type of thread: armoured tube thread DIN 40 430

Variants (10):

Application: > non abrasive material up to 800 N/mm² > unalloyed and low alloyed steel

D - mm	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



Vg



Round dies

DIN 223 (DIN EN 22568) HSS - Vg

Type of thread: Valve Thread DIN 7756

Variants (6):

Application: > non abrasive material up to 800 N/mm² > unalloyed and low alloyed steel

D - mm	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



Square dies



Square dies



Square dies

Hos Snittappe.dk tilbyder vi et bredt udvalg af firkantede gevindbakker. Vi kan tilbyde firkantede gevindbakker med flere forskellige gevindtyper bl.a. British Standard Pipe (BSP), Metrisk (M), Metrisk Fingevind (MF), Unified Thread Standard (UNC), Unified Thread Standard Fine (UNF). Vores firkantede gevindbakker fås i størrelser fra M3 og op til M27 og også med en gevindstigning fra 0,35 og op til 1,75.

Alle vores firkantede gevindbakker er lavet af den tyske producent Völkel, som i 2018 lancerede denne type gevindbakker.

KLUP



NR.1 (M3-16) KLUP til firkantede gevindbakker ([29398](#))

Materiale:

Antal i kasse: 1 stk.



NR.3 (M18-24) KLUP til firkantede gevindbakker ([29399](#))

Materiale:

Antal i kasse: 1 stk.



M



Metrisk Firkantet gevindbakke HSS

Ståltype	Gevindtype	Antal i kasse
HSS	M (Metrisk)	1 stk.

Varianter (15):

Gevindstigning	Art-Nr	Gevindstigning	Art-Nr	Gevindstigning	Art-Nr
M 3 0,5	29301	M 8 1,25	29306	M 16 2	29311
M 4 0,7	29302	M 9 1,25	29307	M 18 2,5	29312
M 5 0,8	29303	M 10 1,5	29308	M 20 2,5	29313
M 6 1	29304	M 12 1,75	29309	M 22 2,5	29314
M 7 1	29305	M 14 2	29310	M 24 3	29315

MF



Metrisk fingevind Firkantet gevindbakke HSS

Ståltype	Gevindtype	Antal i kasse
HSS	MF (Metrisk fingevind)	1 stk.

Varianter (18):

Gevindstigning	Art-Nr	Gevindstigning	Art-Nr	Gevindstigning	Art-Nr
M 3 0,35	29337	M 12 1,25	29343	M 16 1,5	29349
M 4 0,5	29338	M 12 1,5	29344	M 18 1,5	29350
M 6 0,75	29339	M 14 1	29345	M 20 1,5	29351
M 8 1	29340	M 14 1,25	29346	M 22 1,5	29352
M 10 1	29341	M 14 1,5	29347	M 24 1,5	29353
M 10 1,25	29342	M 16 1	29348	M 27 1,5	29354



UNC



UNC Firkantet gevindbakke HSS

Ståltype	Gevindtype	Antal i kasse
HSS	UNC (Unified Thread Standard)	1 stk.

Varianter (8):

Gevindstigning		Art-Nr	Gevindstigning		Art-Nr
UNC 1/4	20	29316	UNC 1/2	13	29320
UNC 5/16	18	29317	UNC 5/8	11	29321
UNC 3/8	16	29318	UNC 3/4	10	29322
UNC 7/16	14	29319	UNC 1"	8	29323

UNF



UNF Firkantet gevindbakke HSS

Ståltype	Gevindtype	Antal i kasse
HSS	UNC (Unified Thread Standard)	1 stk.

Varianter (8):

Gevindstigning		Art-Nr	Gevindstigning		Art-Nr
UNF 1/4	28	29324	UNF 1/2	20	29328
UNF 5/16	24	29325	UNF 5/8	18	29329
UNF 3/8	24	29326	UNF 3/4	16	29330
UNF 7/16	20	29327	UNF 1"	12	29331

BSP



BSP Firkantet gevindbakke HSS

Ståltype	Gevindtype	Antal i kasse
HSS	British Standard Pipe	1 stk.

Varianter (5):

Gevindstigning		Art-Nr	Gevindstigning		Art-Nr	Gevindstigning		Art-Nr
G 1/8	28	29332	G 3/8	19	29334	G 3/4	14	29336
G 1/4	19	29333	G 1/2	14	29335			



Gevindværktøj





Gevindreparation



Silbertool - Et gevindværktøj der virker!

Silbertool er et nyt patenteret "IKKE-SKÆRENDE" værktøj, der genopretter og besvar styrken på udvendige gevind fra M5 til M110 (5mm - 110mm). Både Metrisk; Metrisk Fingevind, UNC, UNF, BSW, G (BSP), til alle gevindtyper og gevindstigninger.

Silbertool er et tysk produceret værktøj, og som de eneste og første på markedet, med et nyt værktøj der kan genoprette udvendig gevind, hvor materialet bevares, modsat andre teknologier, hvor man typisk fjerner gevind, og dermed bliver emnet både svagere og mere usikkert. Modellen R16, R36, R60 og R110 repræsenterer de forskellige størrelser, hvor R110, kan klare op til 110mm. Under hver gruppe kan du finde både værktøjet og tilbehør dertil

R110 + R60



R110 Gevindværktøj M 50 - M 110 (Ø 50-110mm) (10)

Materiale:	Stainless Steel (parally hardened)	
Maximum Radius Of Action:	184mm (while working with Ø 50 mm)	
Pitch:	Minimum: 0,5 mm	Maximum: 3,0 mm
Thread diameter:	Minimum: Ø 50 mm	Maximum: Ø 110 mm
Weight:	1390g	



R60 Gevindværktøj M 10 - M 60 (Ø 10-60mm) (100)

Materiale:	Stainless Steel (parally hardened)	
Maximum Radius Of Action:	162mm (while working with Ø 10 mm)	
Pitch:	Minimum: 0,5 mm	Maximum: 3,0 mm
Thread diameter:	Minimum: Ø 10 mm	Maximum: Ø 60 mm
Weight:	1210g	



R110 Gevindtilbehør (rullesæt)

Materiale	Gevindtype	Antal i kasse
Stål, LH/RH	Metrisk DIN ISO 13	1 sæt af 3
Varianter (18):		

LINKS

Gevind diameter	Gevind stigning	Vægt, g	Art-Nr
10-110 mm	0.5 mm	345	101
10-110 mm	0.8 mm	345	102
10-110 mm	1 mm	345	103
10-110 mm	1.25 mm	345	104
10-110 mm	1.5 mm	345	105
10-110 mm	1.75 mm	345	106
10-110 mm	2 mm	345	107
10-110 mm	2.5 mm	345	108
10-110 mm	3 mm	345	109

Gevind diameter	Gevind stigning	Vægt, g	Art-Nr
10-110 mm	0.5 LH mm	345	101.1
10-110 mm	0.8 LH mm	345	102.1
10-110 mm	1 LH mm	345	103.1
10-110 mm	1.25 LH mm	345	104.1
10-110 mm	1.5 LH mm	345	105.1
10-110 mm	1.75 LH mm	345	106.1
10-110 mm	2 LH mm	345	107.1
10-110 mm	2.5 LH mm	345	108.1
10-110 mm	3 LH mm	345	109.1



R110 Gevindtilbehør (rullesæt)

Materiale	Gevindtype	Antal i kasse
Stål, RH	UNC/UNF/UNEF, ANSI B1.1	1 sæt af 3
Varianter (10):		

Gevind diameter	Gevindstigning/ Gribevidde (TPI)	Vægt, g	Art-Nr
10-110 mm	28	345	121
10-110 mm	24	345	122
10-110 mm	20	345	123
10-110 mm	18	345	124
10-110 mm	16	345	125
10-110 mm	14	345	126
10-110 mm	12	345	127
10-110 mm	11	345	128
10-110 mm	10	345	129
10-110 mm	9	345	130



R110 Gevindtilbehør (rullesæt)

Materiale	Gevindtype	Antal i kasse
Stål, RH	BSW/BSF/BSPP/BS84, DIN ISO 228	1 sæt af 3

Varianter (8):

Gevind diameter	Gevindstigning/ Gribevidde (TPI)	Vægt, g	Art-Nr
10-110 mm	19	345	141
10-110 mm	18	345	142
10-110 mm	16	345	143
10-110 mm	14	345	144
10-110 mm	12	345	145
10-110 mm	11	345	146
10-110 mm	10	345	147
10-110 mm	9	345	148



R16



R16 Gevindværktøj M 5 - M 16 (Ø 5-16mm) (300)

Materiale:	Stainless Steel (parally hardened)	
Maximum Radius Of Action:	35mm (while working with Ø 5 mm)	
Pitch:	Minimum: 0,5 mm	Maximum: 2,0 mm
Thread diameter:	Minimum: Ø 5 mm	Maximum: Ø 16 mm
Weight:	145g	



R16 Gevindtilbehør (rullesæt)

Materiale	Gevindtype	Antal i kasse
Stål, LH/RH	Metrisk DIN ISO 13	1 sæt af 3

Varianter (16):

LINKS

Gevind diameter	Gevind stigning	Vægt, g	Art-Nr	Gevind diameter	Gevind stigning	Vægt, g	Art-Nr
5-16 mm	0.5 mm	19	301	5-16 mm	0.5 LH mm	19	301.1
5-16 mm	0.75 mm	19	302	5-16 mm	0.75 LH mm	19	302.1
5-16 mm	0.8 mm	19	303	5-16 mm	0.8 LH mm	19	303.1
5-16 mm	1.0 mm	19	304	5-16 mm	1.0 LH mm	19	304.1
5-16 mm	1.25 mm	19	305	5-16 mm	1.25 LH mm	19	305.1
5-16 mm	1.5 mm	19	306	5-16 mm	1.5 LH mm	19	306.1
5-16 mm	1.75 mm	19	307	5-16 mm	1.75 LH mm	19	307.1
5-16 mm	2.0 mm	19	308	5-16 mm	2.0 LH mm	19	308.1



R16 Gevindtilbehør (rullesæt)

Materiale	Gevindtype	Antal i kasse
Stål, RH	UNC/UNF/UNEF, ANSI B1.1	1 sæt af 3

Varianter (10):

Gevind diameter	Gevindstigning/ Gribevidde (TPI)	Vægt, g	Art-Nr	Gevind diameter	Gevindstigning/ Gribevidde (TPI)	Vægt, g	Art-Nr
5-16 mm	32	19	321	5-16 mm	16	19	326
5-16 mm	28	19	322	5-16 mm	14	19	327
5-16 mm	24	19	323	5-16 mm	13	19	328
5-16 mm	20	19	324	5-16 mm	12	19	329
5-16 mm	18	19	325	5-16 mm	11	19	330



R16 Gevindtilbehør (rullesæt)

Materiale	Gevindtype	Antal i kasse
Stål, RH	BSW/BSF/BSPP/BS84, DIN ISO 228	1 sæt af 3

Varianter (11):

Gevind diameter	Gevindstigning/ Gribevidde (TPI)	Vægt, g	Art-Nr
5-16 mm	32	19	341
5-16 mm	28	19	342
5-16 mm	26	19	343
5-16 mm	24	19	344
5-16 mm	20	19	345
5-16 mm	19	19	346
5-16 mm	18	19	347
5-16 mm	16	19	348
5-16 mm	14	19	349
5-16 mm	12	19	350
5-16 mm	11	19	351



R36



R36 Gevindværktøj M 10 - M 36 (Ø 10-36mm) (200)

Materiale:	Stainless Steel (parally hardened)	
Maximum Radius Of Action:	115mm (while working with Ø 10 mm)	
Pitch:	Minimum: 0,5 mm	Maximum: 4,0 mm
Thread diameter:	Minimum: Ø 10 mm	Maximum: Ø 36 mm
Weight:	708g	



R36 Gevindtilbehør (rullesæt)

Materiale	Gevindtype	Antal i kasse
Stål, LH/RH	Metrisk DIN ISO 13	1 sæt af 3

Varianter (22):

LINKS

Gevind diameter	Gevind stigning	Vægt, g	Art-Nr	Gevind diameter	Gevind stigning	Vægt, g	Art-Nr
10-36 mm	0.5 mm	85	201	10-36 mm	0.5 LH mm	85	201.1
10-36 mm	0.75 mm	85	202	10-36 mm	0.75 LH mm	85	202.1
10-36 mm	1 mm	85	203	10-36 mm	1 LH mm	85	203.1
10-36 mm	1.25 mm	85	204	10-36 mm	1.25 LH mm	85	204.1
10-36 mm	1.5 mm	85	205	10-36 mm	1.5 LH mm	85	205.1
10-36 mm	1.75 mm	85	206	10-36 mm	1.75 LH mm	85	206.1
10-36 mm	2 mm	85	207	10-36 mm	2 LH mm	85	207.1
10-36 mm	2.5 mm	85	208	10-36 mm	2.5 LH mm	85	208.1
10-36 mm	3 mm	85	209	10-36 mm	3 LH mm	85	209.1
10-36 mm	3.5 mm	85	210	10-36 mm	3.5 LH mm	85	210.1
10-36 mm	4 mm	85	211	10-36 mm	4 LH mm	85	211.1



R36 Gevindtilbehør (rullesæt)

Materiale	Gevindtype	Antal i kasse
Stål, RH	UNC/UNF/UNEF, ANSI B1.1	1 sæt af 3
Varianter (12):		

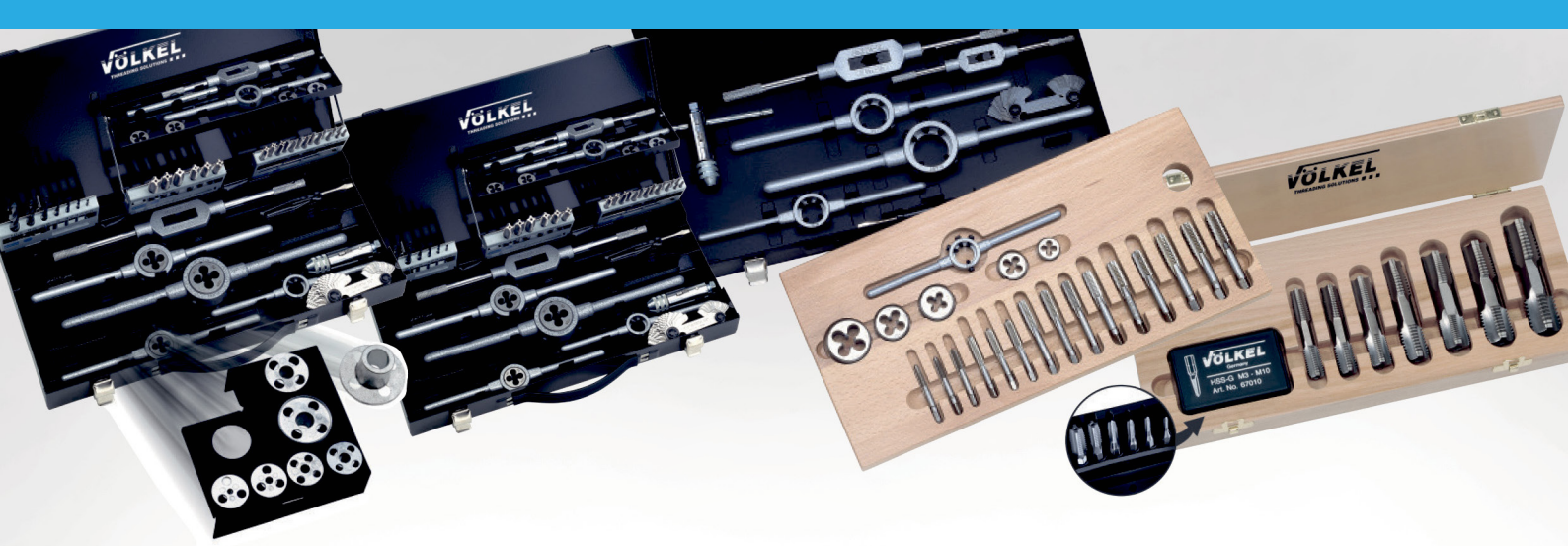
Gevind diameter	Gevindstigning/ Gribevidde (TPI)	Vægt, g	Art-Nr	Gevind diameter	Gevindstigning/ Gribevidde (TPI)	Vægt, g	Art-Nr
10-36 mm	24	85	221	10-36 mm	12	85	227
10-36 mm	20	85	222	10-36 mm	11	85	228
10-36 mm	18	85	223	10-36 mm	10	85	229
10-36 mm	16	85	224	10-36 mm	9	85	230
10-36 mm	14	85	225	10-36 mm	8	85	231
10-36 mm	13	85	226	10-36 mm	7	85	232



R36 Gevindtilbehør (rullesæt)

Materiale	Gevindtype	Antal i kasse
Stål, RH	BSW/BSF/BSPP/BS84, DIN ISO 228	1 sæt af 3
Varianter (8):		

Gevind diameter	Gevindstigning/ Gribevidde (TPI)	Vægt, g	Art-Nr
10-36 mm	14	85	241
10-36 mm	12	85	242
10-36 mm	11	85	243
10-36 mm	10	85	244
10-36 mm	9	85	245
10-36 mm	8	85	246
10-36 mm	7	85	247
10-36 mm	6	85	248



Threading tool sets





Threading tool sets



VÖLKEKEL offers many different sets for thread cutting tools, which are practically assembled for the workplace. From practical pocket sets for fitters up to extensive workshop assortments.

- Threading tools in quality, sturdy packaging
- Contents can be ordered separately

Hand taps, machine taps, threading dies or combined taps, sets with and without core hole drills, with tools for cutting of right- or left-hand threads, taps for through- or blind holes. Choose from one of the largest selections of threading tool sets, available from stock.



HexTap



Threading tool sets HexTap S & HexTap DS

Unique threading tool sets by VÖLKEL. All thread cutting tools can be completely operated without maintenance tools only with standard hand tools. For cleaning and repairing damaged threads and for general use in awkward places. The delivery takes place in high quality wooden case.

- Metric (M) M 3 - M 30
- Metric fine (Mf) M 4x0.5 - M 24x1.5
- Pipe thread G (BSP) 1/8 - G (BSP) 1.1/2"

Sets (22):

Art. -No.

HexTap - Double ended tap, Multi-Drive (set of 13 pcs.) M 3 - M 24 + cobit bits, set of 26 pcs.	99920
HexTap - Double ended tap, Multi-Drive (set of 11 pcs.) M 3 - M 20	48601
HexTap - Double ended tap, Multi-Drive (set of 13 pcs.) M 3 - M 24	48602
HexTap - Double ended tap, Multi-Drive (set of 15 pcs.) M 3 - M 30	48603
HexTap - Double ended tap, Multi-Drive (set of 13 pcs.) M 4x0.5 - M 20x1.5	48605
HexTap - Double ended tap, Multi-Drive (set of 15 pcs.) M 4x0.5 - M 24x1.5	48606
HexTap - Double ended tap, Multi-Drive (set of 6 pcs.) G (BSP) 1/8 - 1"	48608
HexTap - Double ended tap, Multi-Drive (set of 8 pcs.) G (BSP) 1/8 - 1.1/2	48609
HexTap - Double ended tap + round dies (set of 22 pcs.) M 3 - M 20	48621
HexTap - Double ended tap + round dies (set of 26 pcs.) M 3 - M 24	48622
HexTap - Double ended tap + round dies (set of 30 pcs.) M 3 - M 30	48623
HexTap - Double ended tap + round dies (set of 26 pcs.) M 4x0.5 - M 20x1.5	48625
HexTap - Double ended tap + round dies (set of 30 pcs.) M 4x0.5 - M 24x1.5	48626
HexTap - Double ended tap + round dies (set of 12 pcs.) G (BSP) 1/8 - 1"	48628
HexTap - Double ended tap + round dies (set of 16 pcs.) G (BSP) 1/8 - 1.1/2	48629
HexTap - Double ended tap + hexagon die nuts (set of 22 pcs.) M 3 - M 20	48641
HexTap - Double ended tap + hexagon die nuts (set of 26 pcs.) M 3 - M 24	48642
HexTap - Double ended tap + hexagon die nuts (set of 30 pcs.) M 3 - M 30	48643
HexTap - Double ended tap + hexagon die nuts (set of 26 pcs.) M 4x0.5 - M 20x1.5	48645
HexTap - Double ended tap + hexagon die nuts (set of 30 pcs.) M 4x0.5 - M 24x1.5	48646
HexTap - Double ended tap + hexagon die nuts (set of 12 pcs.) G (BSP) 1/8 - 1"	48648
HexTap - Double ended tap + hexagon die nuts (set of 16 pcs.) G (BSP) 1/8 - 1.1/2	48649



Hand taps



Sets (9):

	Art. -No.
P.V.22 Hand taps (set of 29 pcs.) incl. drills M 3 - M 12	49510
P.V.23 Hand taps (set of 30 pcs.) incl. drills M 3 - M 12	49511
P.K.20 Hand taps (set of 22 pcs.) M 3 - M 12	47001
P.K.21 Hand taps (set of 23 pcs.) incl. ratchet M 3 - M 12	47005
Hand taps (set of 23 pcs.) incl. ratchet HSS-E M 3 - M 12	47055
Hand taps, left hand (set of 23 pcs.) incl. ratchet M 3 LH - M 12 LH	47075
Mini Hand taps (set of 22 pcs.) DIN 352 M 1 - M 2.6	48001
P.K.21 Hand taps (set of 23 pcs.) incl. ratchet M 3 - M 12 + cobit BT11Neo Mix-TORSION	99916
Hand taps (set of 22 pcs.) HSS-G , UNC No. 5 - UNC 1/2" + cobit BT11Neo Mix-TORSION	99917

Round dies



Sets (5):

	Art. -No.
P.V.97 Round dies (set of 7 pcs.) DIN standard HSS M 3 - M 12	49521
P.V.98 Round dies (set of 7 pcs.) DIN standard HSS-E M 3 - M 12	49522
P.V.92 Round dies (set of 8 pcs.) incl. holder HSS M 3 - M 12	49525
P.V.14 Round dies (set of 19 pcs.) incl. guides M 3 - M 12	49599
Round dies, left hand (set of 19 pcs.) incl. guides M 3 LH - M 12 LH	49598



Hexagon die nuts



Sets (3):

	Art. -No.
P.V.99 Hexagon die nuts (set of 7 pcs.) DIN standard HSS M 3 – M 12	49520
Hexagon die nuts (set of 5 pcs.) DIN standard HSS UNC 1/4 – UNC 1/2	49530
Hexagon die nuts (set of 5 pcs.) DIN standard HSS UNF 1/4 – UNF 1/2	49540

Short machine taps



Sets (9):

	Art. -No.
P.K.25 Short machine taps (set of 16 pcs.) incl. ratchet and drills M 3 – M 12	47605
P.K.26 Short machine taps (set of 15 pcs.) incl. drills M 3 – M 12	47601
P.K.85 Machine taps (set of 18 pcs.) ISO 529 incl. drills M 3 – M 10	80501
Machine taps (set of 7 pcs.) ISO 529 Form B M 3 – M 12	80500
Machine taps (set of 7 pcs.) ISO 529 Form B-AZ M 3 – M 12	80900
Machine taps (set of 7 pcs.) ISO 529 Form C/35°RSP M 3 – M 12	80700
Threading-bits (set of 12 pcs.) incl. drill bits M 3 – M 10	67020
Threading-bits (set of 6 pcs.) M 3 – M 10	67010
Q.C.2 Short machine taps (Bit-set of 8 pcs.) M 3 – M 10	67422



Machine taps



Sets (25):	Art. -No.
GREEN RING Machine taps (set of 14 pcs.) incl. drills DIN 371/376 M 3 - M 12	47856
WHITE RING Machine taps for blind holes (set of 14 pcs.) incl. drills DIN 371/376 M 3 - M 12	47865
BLUE RING Machine taps for blind holes (set of 14 pcs.) incl. drills DIN 371/376 M 3 - M 12	47867
GREEN RING Machine taps for blind holes (set of 14 pcs.) incl. drills DIN 371/376 M 3 - M 12	47866
P.K.48 HSS-E TiN Machine taps for blind holes (set of 14 pcs.) incl. drills DIN 371/376 M 3 - M 12	47848
P.K.47 HSS-E Machine taps for blind holes (set of 14 pcs.) incl. drills DIN 371/376 M 3 - M 12	47847
WHITE RING Machine taps for blind holes (set of 7 pcs.) DIN 371/376 M 3 - M 12	47862
BLUE RING Machine taps for blind holes (set of 7 pcs.) DIN 371/376 M 3 - M 12	47864
GREEN RING Machine taps for blind holes (set of 7 pcs.) DIN 371/376 M 3 - M 12	47863
P.K.31 HSS-E TiN Machine taps for blind holes (set of 7 pcs.) DIN 371/376 M 3 - M 12	47827
P.K.30 HSS-E Machine taps for blind holes (set of 7 pcs.) DIN 371/376 M 3 - M 12	47817
WHITE RING Machine taps (set of 14 pcs.) incl. drills DIN 371/376 M 3 - M 12	47855
BLUE RING Machine taps (set of 14 pcs.) incl. drills DIN 371/376 M 3 - M 12	47857
BLACK RING Machine taps (set of 7 pcs.) DIN 371/376 M 3 - M 12	47851
P.K.36 HSS-E TiN Machine taps (set of 14 pcs.) incl. drills DIN 371/376 M 3 - M 12	47836
P.K.35 HSS-E Machine taps (set of 14 pcs.) incl. drills DIN 371/376 M 3 - M 12	47835
WHITE RING Machine taps (set of 7 pcs.) DIN 371/376 M 3 - M 12	47852
BLUE RING Machine taps (set of 7 pcs.) DIN 371/376 M 3 - M 12	47854
GREEN RING Machine taps (set of 7 pcs.) DIN 371/376 M 3 - M 12	47853
P.K.29 HSS-E TiN Machine taps (set of 7 pcs.) DIN 371/376 M 3 - M 12	47825
P.K.28 HSS-E Machine taps (set of 7 pcs.) DIN 371/376 M 3 - M 12	47815
P.K.41 HSS-E TiN Machine taps (set of 14 pcs.) DIN 371/376 M 3 - M 12	47912
P.K.40 HSS-E Machine taps (set of 14 pcs.) DIN 371/376 M 3 - M 12	47901
ORANGE RING Machine taps (set of 7 pcs.) DIN 371/376 M 3 - M 12	47850
YELLOW RING Machine taps (set of 7 pcs.) DIN 371/376 M 3 - M 12	47860



Screw taps TwinBox 2in1



Machine taps and suitable twist drills (core hole drill) in one practical set. The machine taps in TwinBox are available in the following variations:

- Machine taps for general use
- Blue ring taps for wear resistant steel
- White ring taps for stainless steel (VA)

The Twin-Boxes contain HSS-E machine taps for metric ISO right-hand threads and alternatively for through and blind holes.

Sets (8):	Art. -No.
TwinBox DIN 371/376 Form B HSS-E - M (9 variants)	37590-37598
TwinBox DIN 371/376 Form C 35°RSP HSS-E - M (9 variants)	37790-38798
GREEN RING TwinBox DIN 371 /376 Form B HSS-E - M (9 variants)	35390-35398
GREEN RING TwinBox DIN 371/376 Form C 35°RSP HSS-E - M (9 variants)	36390-36398
BLUE RING TwinBox DIN 371/376 Form B HSS-E - M (9 variants)	35490-35498
BLUE RING TwinBox DIN 371/376 Form C 35°RSP HSS-E - M (9 variants)	36490-36498
WHITE RING TwinBox DIN 371/376 Form B HSS-E - M (9 variants)	35290-35298
WHITE RING TwinBox DIN 371/376 Form C 35°RSP HSS-E - M (9 variants)	36290-36298

Combined machine taps



Sets (7):	Art. -No.
P.K.370 Combined taps (set of 7 pcs.) M 3 - M 12	47837
P.K.700 Combined taps (set of 7 pcs.) BSW 1/8 - BSW 1/2	47870
Combined threading and drill-bit (set of 7 pcs.) HSS-G M 3 - M 10	67200
Combined threading and drill-bit (set of 7 pcs.) HSS-G TiN M 3 - M 10	67209
Combined threading and drill-bit (set of 7 pcs.) HSS-G UNC No. 8 - UNC 3/8	67272
Combined threading and drill-bit (set of 7 pcs.) HSS-G UNF No. 8 - UNF 3/8	67274
Q.C.1 Combined threading bits (set of 7 pcs.) incl. holder M 3 - M 10	67421



Bit assortments



Sets (14):	Art. -No.
Combined threading and drill-bit (set of 7 pcs.) HSS-G M 3 - M 10	67200
Combined threading and drill-bit (set of 7 pcs.) HSS-G TiN M 3 - M 10	67209
Combined threading and drill-bit (set of 7 pcs.) HSS-G UNC No. 8 - UNC 3/8	67272
Combined threading and drill-bit (set of 7 pcs.) HSS-G UNF No. 8 - UNF 3/8	67274
Threading-bits (set of 12 pcs.) incl. drill bits M 3 - M 10	67020
Threading-bits (set of 6 pcs.) M 3 - M 10	67010
Twist drill bits (set of 19 pcs.) 1.0 - 10.0 mm	67100
Countersink-bits 90° (set of 6 pcs.) 6.3 - 20.5 mm	67300
Q.C.1 Combined threading bits (set of 7 pcs.) incl. holder M 3 - M 10	67421
Q.C.2 Short machine taps (Bit-set of 8 pcs.) M 3 - M 10	67422
Q.C.3 Countersink-bits 90° (set of 8 pcs.) 6.3 - 20.5 mm	67423
Q.C.4 Twist drill bits (set of 19 pcs.) for metal 3.0 - 10.0 mm	67424
Q.C.5 Twist drill bits (set of 19 pcs.) for wood 3.0 - 10.0 mm	67425
Twist drill bit-set for metal and wood 3.0 - 10.0 mm	67101



Q.C. sets



Sets (5):

Art. -No.

Q.C.1 Combined threading bits (set of 7 pcs.) incl. holder M 3 - M 10

[67421](#)

Q.C.2 Short machine taps (Bit-set of 8 pcs.) M 3 - M 10

[67422](#)

Q.C.3 Countersink-bits 90° (set of 8 pcs.) 6.3 - 20.5 mm

[67423](#)

Q.C.4 Twist drill bits (set of 19 pcs.) for metal 3.0 - 10.0 mm

[67424](#)

Q.C.5 Twist drill bits (set of 19 pcs.) for wood 3.0 - 10.0 mm

[67425](#)



Assortments



Hand taps and round dies, M / Mf

Type of thread	Standard	Material	Packing
metric ISO thread DIN 13	DIN Standard	HSS-G	in metal case

All HexTap S and HexTap DS threading tools can also be ordered separately.

Application/for general use:

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand
- HSS-G Hand taps acc. to DIN 352
- HSS Round dies acc. to DIN 223 (DIN EN 22568)

M / Mf

Sets (9):

	Art. -No.
Hand taps and round dies (set of 64 pcs.) M 1 - M 10	48002
Hand taps and round dies (set of 48 pcs.) M 3 - M 12	48003
Hand taps and round dies (set of 39 pcs.) M 5 - M 12	48004
Hand taps and round dies (set of 55 pcs.) M 5 - M 20	48005
Hand taps and round dies (set of 61 pcs.) M 3 - M 24	48006
Hand taps and round dies (set of 62 pcs.) M 5 - M 30	48007
Hand taps and round dies (set of 31 pcs.) M 3x0.35 - M 12x1.5	48010
Hand taps and round dies (set of 40 pcs.) M 6x0.75 - M 20x1.5	48011
Hand taps and round dies (set of 47 pcs.) M 6x0.75 - M 24x1.5	48012

[48002](#) - set of 64 pcs. M 1 - M 10

Contents:

HSS-G Hand taps

(sets of 3 pcs.) Art.-No

1x M 1	27302
1x M 1,2	27306
1x M 1,4	27308
1x M 1,7	27312
1x M 2	27316
1x M 2,3	27320
1x M 2,6	27324
1x M 3	27326
1x M 3,5	27328
1x M 4	27330
1x M 5	27334
1x M 6	27338
1x M 8	27342
1x M 10	27346

Contents:

HSS Round die

Art.-No

1x M 1	27402
1x M 1,2	27406
1x M 1,4	27408
1x M 1,7	27412
1x M 2	27416
1x M 2,3	27420
1x M 2,6	27424
1x M 3	27426
1x M 3,5	27428
1x M 4	27430
1x M 5	27434
1x M 6	27438
1x M 8	27442
1x M 10	27446

Contents:

Art.-No

1x Adjustable tap wrench, zinc die cast No. 0	13000
1x Adjustable tap wrench, zinc die cast No. 1	13010
1x Die stock, zinc die cast 16x5 mm	15001
1x Die stock, zinc die cast 20x5 mm	15002
1x Die stock, zinc die cast 20x7 mm	15003
1x Die stock, zinc die cast 25x9 mm	15004
1x Die stock, zinc die cast 30x11 mm	15005
1x Tap holder with ratchet, size 1	10001



48003 - set of 48 pcs. M 3 - M 12

Contents: HSS-G Hand taps

(sets of 3 pcs.)	Art.-No.
1x M 3	27326
1x M 4	27330
1x M 5	27334
1x M 6	27338
1x M 7	27340
1x M 8	27342
1x M 9	27344
1x M 10	27346
1x M 11	27348
1x M 12	27350

Contents: HSS Round dies

	Art.-No.
1x M 3	27426
1x M 4	27430
1x M 5	27434
1x M 6	27438
1x M 7	27440
1x M 8	27442
1x M 9	27444
1x M 10	27446
1x M 11	27448
1x M 12	27450

Contents:

	Art.-No.
1x Adjustable tap wrench, zinc die cast No. 1	13010
1x Adjustable tap wrench, zinc die cast No. 2	13020
1x Die stock, zinc die cast 20x5 mm	15002
1x Die stock, zinc die cast 20x7 mm	15003
1x Die stock, zinc die cast 25x9 mm	15004
1x Die stock, zinc die cast 30x11 mm	15005
1x Die stock, zinc die cast 38x14 mm	15007
1x Tap holder with ratchet, size 1	10001

48004 - set of 39 pcs. M 5 - M 12

Contents: HSS-G Hand taps

(sets of 3 pcs.)	Art.-No.
1x M 5	27334
1x M 6	27338
1x M 7	27340
1x M 8	27342
1x M 9	27344
1x M 10	27346
1x M 11	27348
1x M 12	27350

Contents: HSS Round die

	Art.-No.
1x M 5	27434
1x M 6	27438
1x M 7	27440
1x M 8	27442
1x M 9	27444
1x M 10	27446
1x M 11	27448
1x M 12	27450

Contents:

	Art.-No.
1x Adjustable tap wrench, zinc die cast No. 1	13010
1x Adjustable tap wrench, zinc die cast No. 2	13020
1x Die stock, zinc die cast 20x7 mm	15003
1x Die stock, zinc die cast 25x9 mm	15004
1x Die stock, zinc die cast 30x11 mm	15005
1x Die stock, zinc die cast 38x14 mm	15007
1x Tap holder with ratchet, size 1	10001



48005 - set of 55 pcs. M 5 - M 20

Contents: HSS-G Hand taps

(sets of 3 pcs.)	Art.-No.
1x M 5	27334
1x M 6	27338
1x M 7	27340
1x M 8	27342
1x M 9	27344
1x M 10	27346
1x M 11	27348
1x M 12	27350
1x M 14	27354
1x M 16	27358
1x M 18	27362
1x M 20	27366

Contents: HSS Round die

	Art.-No.
1x M 5	27434
1x M 6	27438
1x M 7	27440
1x M 8	27442
1x M 9	27444
1x M 10	27446
1x M 11	27448
1x M 12	27450
1x M 14	27454
1x M 16	27458
1x M 18	27462
1x M 20	27466

Contents:

	Art.-No.
1x Adjustable tap wrench, zinc die cast No. 1	13010
1x Adjustable tap wrench, zinc die cast No. 2	13020
1x Die stock, zinc die cast 20x7 mm	15003
1x Die stock, zinc die cast 25x9 mm	15004
1x Die stock, zinc die cast 30x11 mm	15005
1x Die stock, zinc die cast 38x14 mm	15007
1x Die stock, zinc die cast 45x18 mm	15009

48006 - set of 61 pcs. M 3 - M 24

Contents: HSS-G Hand taps

(sets of 3 pcs.)	Art.-No.
1x M 3	27326
1x M 4	27330
1x M 5	27334
1x M 6	27338
1x M 8	27342
1x M 10	27346
1x M 12	27350
1x M 14	27354
1x M 16	27358
1x M 18	27362
1x M 20	27366
1x M 22	27370
1x M 24	27374

Contents: HSS Round die

	Art.-No.
1x M 3	27426
1x M 4	27430
1x M 5	27434
1x M 6	27438
1x M 8	27442
1x M 10	27446
1x M 12	27450
1x M 14	27454
1x M 16	27458
1x M 18	27462
1x M 20	27466
1x M 22	27470
1x M 24	27474

Contents:

	Art.-No.
1x Adjustable tap wrench, zinc die cast No. 1	13010
1x Adjustable tap wrench, zinc die cast No. 4	13040
1x Die stock, zinc die cast 20x5 mm	15002
1x Die stock, zinc die cast 20x7 mm	15003
1x Die stock, zinc die cast 25x9 mm	15004
1x Die stock, zinc die cast 30x11 mm	15005
1x Die stock, zinc die cast 38x14 mm	15007
1x Die stock, zinc die cast 45x18 mm	15009
1x Die stock, zinc die cast 55x22 mm	15011



48007 - set of 62 pcs. M 5 - M 30

Contents: HSS-G Hand taps

(sets of 3 pcs.)	Art.-No.
1x M 5	27334
1x M 6	27338
1x M 8	27342
1x M 10	27346
1x M 12	27350
1x M 14	27354
1x M 16	27358
1x M 18	27362
1x M 20	27366
1x M 22	27370
1x M 24	27374
1x M 27	27376
1x M 30	27378

Contents: HSS Round die

	Art.-No.
1x M 5	27434
1x M 6	27438
1x M 8	27442
1x M 10	27446
1x M 12	27450
1x M 14	27454
1x M 16	27458
1x M 18	27462
1x M 20	27466
1x M 22	27470
1x M 24	27474
1x M 27	27476
1x M 30	27478

Contents:

	Art.-No.
1x Adjustable tap wrench, zinc die cast No. 1	13010
1x Adjustable tap wrench, zinc die cast No. 3	13030
1x Adjustable tap wrench, zinc die cast No. 5	13050
1x Die stock, zinc die cast 20x7 mm	15003
1x Die stock, zinc die cast 25x9 mm	15004
1x Die stock, zinc die cast 30x11 mm	15005
1x Die stock, zinc die cast 38x14 mm	15007
1x Die stock, zinc die cast 45x18 mm	15009
1x Die stock, zinc die cast 55x22 mm	15011
1x Die stock, zinc die cast 65x25 mm	15013

48010 - set of 31 pcs. M 3x0.35 - M 12x1.5

Contents: HSS-G Hand taps

(sets of 2 pcs.)	Art.-No.
1x M 3x0,35	26308
1x M 4x0,5	26312
1x M 5x0,5	26314
1x M 6x0,75	26318
1x M 8x0,75	26324
1x M 8x1	26326
1x M 10x1	26336
1x M 12x1,5	26348

Contents: HSS Round die

	Art.-No.
1x M 3x0,35	26408
1x M 4x0,5	26412
1x M 5x0,5	26414
1x M 6x0,75	26418
1x M 8x0,75	26424
1x M 8x1	26426
1x M 10x1	26436
1x M 12x1,5	26448

Contents:

	Art.-No.
1x Adjustable tap wrench, zinc die cast No. 1	13010
1x Adjustable tap wrench, zinc die cast No. 2	13020
1x Die stock, zinc die cast 20x5 mm	15002
1x Die stock, zinc die cast 25x9 mm	15004
1x Die stock, zinc die cast 30x11 mm	15005
1x Die stock, zinc die cast 38x10 mm	15006
1x Tap holder with ratchet, size 1	10001



48011 - set of 40 pcs. M 6x0.75 - M 20x1.5

Contents: HSS-G Hand taps

(sets of 2 pcs.)	Art.-No.
1x M 6x0,75	26318
1x M 8x0,75	26324
1x M 8x1	26326
1x M 10x1	26336
1x M 12x1	26344
1x M 12x1,5	26348
1x M 14x1,25	26354
1x M 14x1,5	26356
1x M 16x1,5	26366
1x M 18x1,5	26372
1x M 20x1,5	26384

Contents: HSS Round die

	Art.-No.
1x M 6x0,75	26418
1x M 8x0,75	26424
1x M 8x1	26426
1x M 10x1	26436
1x M 12x1	26444
1x M 12x1,5	26448
1x M 14x1,25	26454
1x M 14x1,5	26456
1x M 16x1,5	26466
1x M 18x1,5	26472
1x M 20x1,5	26484

Contents:

	Art.-No.
1x Adjustable tap wrench, zinc die cast No. 1	13010
1x Adjustable tap wrench, zinc die cast No. 3	13030
1x Die stock, zinc die cast 20x7 mm	15003
1x Die stock, zinc die cast 25x9 mm	15004
1x Die stock, zinc die cast 30x11 mm	15005
1x Die stock, zinc die cast 38x10 mm	15006
1x Die stock, zinc die cast 45x14 mm	15008

48012 - set of 47 pcs. M 6x0.75 - M 24x1.5

Contents: HSS-G Hand taps

(sets of 2 pcs.)	Art.-No.
1x M 6x0,75	26318
1x M 8x0,75	26324
1x M 8x1	26326
1x M 10x1	26336
1x M 12x1	26344
1x M 12x1,5	26348
1x M 14x1,25	26354
1x M 14x1,5	26356
1x M 16x1,5	26366
1x M 18x1,5	26372
1x M 20x1,5	26384
1x M 22x1,5	26394
1x M 24x1,5	26504

Contents: HSS Round die

	Art.-No.
1x M 6x0,75	26418
1x M 8x0,75	26424
1x M 8x1	26426
1x M 10x1	26436
1x M 12x1	26444
1x M 12x1,5	26448
1x M 14x1,25	26454
1x M 14x1,5	26456
1x M 16x1,5	26466
1x M 18x1,5	26472
1x M 20x1,5	26484
1x M 22x1,5	26494
1x M 24x1,5	26604

Contents:

	Art.-No.
1x Adjustable tap wrench, zinc die cast No. 1	13010
1x Adjustable tap wrench, zinc die cast No. 4	13040
1x Die stock, zinc die cast 20x7 mm	15002
1x Die stock, zinc die cast 25x9 mm	15004
1x Die stock, zinc die cast 30x11 mm	15005
1x Die stock, zinc die cast 38x10 mm	15006
1x Die stock, zinc die cast 45x14 mm	15008
1x Die stock, zinc die cast 55x16 mm	15010



Hand taps and round dies, BSW / BSF

Type of thread	Standard	Material	Packing
Whitworth-thread BS 84 + British Standard Fine thread BS 84	DIN Standard	HSS-G	in metal case

All threading tools, threading tool holder and accessories can also be ordered separately.

Application/for general use:

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand
- HSS-G Hand taps acc. to ≈ DIN 352*
- HSS-G Hand taps acc. to ≈ DIN 2181**
- HSS Round dies acc. to DIN 223 (DIN EN 22568)

BSW / BSF

Sets (9):

	Art. -No.
Hand taps and round dies (set of 36 pcs.) BSW 1/8 - 1/2	48030 *
Hand taps and round dies (set of 27 pcs.) BSW 1/4 - 1/2	48031 *
Hand taps and round dies (set of 35 pcs.) BSW 1/4 - 3/4	48032 *
Hand taps and round dies (set of 44 pcs.) BSW 1/4 - 1"	48034 *
Hand taps and round dies (set of 62 pcs.) BSW 1/4 - 1.1/2	48035 *
Hand taps and round dies (set of 22 pcs.) BSF 1/4 - 1/2	48041 **
Hand taps and round dies (set of 28 pcs.) BSF 1/4 - 3/4	48042 **
Hand taps and round dies (set of 35 pcs.) BSF 1/4 - 1"	48044 **
Hand taps and round dies (set of 56 pcs.) BSW+BSF 1/4 - 3/4	48046 */**

[48030](#) - set of 36 pcs. BSW 1/8 - 1/2

Contents:

HSS-G Hand taps

(sets of 3 pcs.) Art.-No.

1x BSW 1/8	22306
1x BSW 3/16	22310
1x BSW 1/4	22314
1x BSW 5/16	22316
1x BSW 3/8	22318
1x BSW 7/16	22320
1x BSW 1/2	22322

Contents:

HSS Round die

Art.-No.

1x BSW 1/8	22406
1x BSW 3/16	22410
1x BSW 1/4	22414
1x BSW 5/16	22416
1x BSW 3/8	22418
1x BSW 7/16	22420
1x BSW 1/2	22422

Contents:

	Art.-No.
1x Adjustable tap wrench, zinc die cast No. 1	13010
1x Adjustable tap wrench, zinc die cast No. 2	13020
1x Die stock, zinc die cast 20x5 mm	15002
1x Die stock, zinc die cast 20x7 mm	15003
1x Die stock, zinc die cast 25x9 mm	15004
1x Die stock, zinc die cast 30x11 mm	15005
1x Die stock, zinc die cast 38x14 mm	15007
1x Tap holder with ratchet, size 1	10001



48031 - set of 27 pcs. BSW 1/4 - 1/2

Contents: HSS-G Hand taps

(sets of 3 pcs.)	Art.-No.
1x BSW 1/4	22314
1x BSW 5/16	22316
1x BSW 3/8	22318
1x BSW 7/16	22320
1x BSW 1/2	22322

Contents: HSS Round die

	Art.-No.
1x BSW 1/4	22414
1x BSW 5/16	22416
1x BSW 3/8	22418
1x BSW 7/16	22420
1x BSW 1/2	22422

Contents:

	Art.-No.
1x Adjustable tap wrench, zinc die cast No. 1	13010
1x Adjustable tap wrench, zinc die cast No. 2	13020
1x Die stock, zinc die cast 20x7 mm	15003
1x Die stock, zinc die cast 25x9 mm	15004
1x Die stock, zinc die cast 30x11 mm	15005
1x Die stock, zinc die cast 38x14 mm	15007
1x Tap holder with ratchet, size 1	10001

48032 - set of 35 pcs. BSW 1/4 - 3/4

Contents: HSS-G Håndtappe

(sets of 3 pcs.)	Art.-No.
1x BSW 1/4	22314
1x BSW 5/16	22316
1x BSW 3/8	22318
1x BSW 7/16	22320
1x BSW 1/2	22322
1x BSW 5/8	22326
1x BSW 3/4	22330

Contents: HSS Round die

	Art.-No.
1x BSW 1/4	22414
1x BSW 5/16	22416
1x BSW 3/8	22418
1x BSW 7/16	22420
1x BSW 1/2	22422
1x BSW 5/8	22426
1x BSW 3/4	22430

Contents:

	Art.-No.
1x Adjustable tap wrench, zinc die cast No. 1	13010
1x Adjustable tap wrench, zinc die cast No. 3	13030
1x Die stock, zinc die cast 20x7 mm	15003
1x Die stock, zinc die cast 25x9 mm	15004
1x Die stock, zinc die cast 30x11 mm	15005
1x Die stock, zinc die cast 38x14 mm	15007
1x Die stock, zinc die cast 45x18 mm	15009



48034 - set of 44 pcs. BSW 1/4 - 1"

Contents: HSS-G Hand taps

(sets of 3 pcs.)	Art.-No.
1x BSW 1/4	22314
1x BSW 5/16	22316
1x BSW 3/8	22318
1x BSW 7/16	22320
1x BSW 1/2	22322
1x BSW 5/8	22326
1x BSW 3/4	22330
1x BSW 7/8	22334
1x BSW 1"	22338

Contents: HSS Round die

	Art.-No.
1x BSW 1/4	22414
1x BSW 5/16	22416
1x BSW 3/8	22418
1x BSW 7/16	22420
1x BSW 1/2	22422
1x BSW 5/8	22426
1x BSW 3/4	22430
1x BSW 7/8	22434
1x BSW 1"	22438

Contents:

	Art.-No.
1x Adjustable tap wrench, zinc die cast No. 1	13010
1x Adjustable tap wrench, zinc die cast No. 4	13040
1x Die stock, zinc die cast 20x7 mm	15003
1x Die stock, zinc die cast 25x9 mm	15004
1x Die stock, zinc die cast 30x11 mm	15005
1x Die stock, zinc die cast 38x14 mm	15007
1x Die stock, zinc die cast 45x18 mm	15009
1x Die stock, zinc die cast 55x22 mm	15011

48035 - set of 62 pcs. BSW 1/4 - 1.1/2

Contents: HSS-G Hand taps

(sets of 3 pcs.)	Art.-No.
1x BSW 1/4	22314
1x BSW 5/16	22316
1x BSW 3/8	22318
1x BSW 7/16	22320
1x BSW 1/2	22322
1x BSW 5/8	22326
1x BSW 3/4	22330
1x BSW 7/8	22334
1x BSW 1"	22338
1x BSW 1.1/8	22342
1x BSW 1.1/4	22346
1x BSW 1.3/8	22350
1x BSW 1.1/2	22354

Contents: HSS Round die

	Art.-No.
1x BSW 1/4	22414
1x BSW 5/16	22416
1x BSW 3/8	22418
1x BSW 7/16	22420
1x BSW 1/2	22422
1x BSW 5/8	22426
1x BSW 3/4	22430
1x BSW 7/8	22434
1x BSW 1"	22438
1x BSW 1.1/8	22442
1x BSW 1.1/4	22446
1x BSW 1.3/8	22450
1x BSW 1.1/2	22452

Contents:

	Art.-No.
1x Adjustable tap wrench, zinc die cast No. 1	13010
1x Adjustable tap wrench, zinc die cast No. 3	13030
1x Adjustable tap wrench, zinc die cast No. 5	13050
1x Die stock, zinc die cast 20x7 mm	15003
1x Die stock, zinc die cast 25x9 mm	15004
1x Die stock, zinc die cast 30x11 mm	15005
1x Die stock, zinc die cast 38x14 mm	15007
1x Die stock, zinc die cast 45x18 mm	15009
1x Die stock, zinc die cast 55x22 mm	15011
1x Die stock, zinc die cast 65x25 mm	15013



48041 - set of 22 pcs. BSF 1/4 - 1/2

Contents: HSS-G Hand taps

(sets of 2 pcs.)	Art.-No.
1x BSF 1/4	22714
1x BSF 5/16	22716
1x BSF 3/8	22718
1x BSF 7/16	22720
1x BSF 1/2	22722

Contents: HSS Round die

	Art.-No.
1x BSF 1/4	22814
1x BSF 5/16	22816
1x BSF 3/8	22818
1x BSF 7/16	22820
1x BSF 1/2	22822

Contents:

	Art.-No.
1x Adjustable tap wrench, zinc die cast No. 1	13010
1x Adjustable tap wrench, zinc die cast No. 2	13020
1x Die stock, zinc die cast 20x7 mm	15003
1x Die stock, zinc die cast 25x9 mm	15004
1x Die stock, zinc die cast 30x11 mm	15005
1x Die stock, zinc die cast 38x10 mm	15006
1x Tap holder with ratchet, size 1	10001

48042 - set of 28 pcs. BSF 1/4 - 3/4

Contents: HSS-G Hand taps

(sets of 2 pcs.)	Art.-No.
1x BSF 1/4	22714
1x BSF 5/16	22716
1x BSF 3/8	22718
1x BSF 7/16	22720
1x BSF 1/2	22722
1x BSF 5/8	22726
1x BSF 3/4	22730

Contents: HSS Round die

	Art.-No.
1x BSF 1/4	22814
1x BSF 5/16	22816
1x BSF 3/8	22818
1x BSF 7/16	22820
1x BSF 1/2	22822
1x BSF 5/8	22826
1x BSF 3/4	22830

Contents:

	Art.-No.
1x Adjustable tap wrench, zinc die cast No. 1	13010
1x Adjustable tap wrench, zinc die cast No. 3	13030
1x Die stock, zinc die cast 20x7 mm	15003
1x Die stock, zinc die cast 25x9 mm	15004
1x Die stock, zinc die cast 30x11 mm	15005
1x Die stock, zinc die cast 38x10 mm	15006
1x Die stock, zinc die cast 45x14 mm	15008



48044 - set of 35 pcs. BSF 1/4 - 1"

Contents: HSS-G Hand taps

(sets of 2 pcs.)	Art.-No.
1x BSF 1/4	22714
1x BSF 5/16	22716
1x BSF 3/8	22718
1x BSF 7/16	22720
1x BSF 1/2	22722
1x BSF 5/8	22726
1x BSF 3/4	22730
1x BSF 7/8	22734
1x BSF 1"	22738

Contents: HSS Round die

	Art.-No.
1x BSF 1/4	22814
1x BSF 5/16	22816
1x BSF 3/8	22818
1x BSF 7/16	22820
1x BSF 1/2	22822
1x BSF 5/8	22826
1x BSF 3/4	22830
1x BSF 7/8	22834
1x BSF 1"	22838

Contents:

	Art.-No.
1x Adjustable tap wrench, zinc die cast No. 1	13010
1x Adjustable tap wrench, zinc die cast No. 4	13040
1x Die stock, zinc die cast 20x7 mm	15003
1x Die stock, zinc die cast 25x9 mm	15004
1x Die stock, zinc die cast 30x11 mm	15005
1x Die stock, zinc die cast 38x10 mm	15006
1x Die stock, zinc die cast 45x14 mm	15008
1x Die stock, zinc die cast 55x16 mm	15010

48046 - set of 56 pcs. BSW+BSF 1/4 - 3/4

Contents: HSS-G Hand taps

(sets of 3 pcs.)	Art.-No.
1x BSW 1/4	22314
1x BSW 5/16	22316
1x BSW 3/8	22318
1x BSW 7/16	22320
1x BSW 1/2	22322
1x BSW 5/8	22326
1x BSW 3/4	22330
(sets of 2 pcs.)	
1x BSF 1/4	22714
1x BSF 5/16	22716
1x BSF 3/8	22718
1x BSF 7/16	22720
1x BSF 1/2	22722
1x BSF 5/8	22726
1x BSF 3/4	22730

Contents: HSS Round die

	Art.-No.
1x BSW 1/4	22414
1x BSW 5/16	22416
1x BSW 3/8	22418
1x BSW 7/16	22420
1x BSW 1/2	22422
1x BSW 5/8	22426
1x BSW 3/4	22430
1x BSF 1/4	22814
1x BSF 5/16	22816
1x BSF 3/8	22818
1x BSF 7/16	22820
1x BSF 1/2	22822
1x BSF 5/8	22826
1x BSF 3/4	22830

Contents:

	Art.-No.
1x Adjustable tap wrench, zinc die cast No. 1	13010
1x Adjustable tap wrench, zinc die cast No. 3	13030
1x Die stock, zinc die cast 20x7 mm	15003
1x Die stock, zinc die cast 25x9 mm	15004
1x Die stock, zinc die cast 30x11 mm	15005
1x Die stock, zinc die cast 38x14 mm	15007
1x Die stock, zinc die cast 45x18 mm	15009



Hand taps and round dies, UNC / UNF

Type of thread	Standard	Material	Packing
Unified Coarse thread ANSI B 1.1 + Unified Fine thread ANSI B 1.1	DIN Standard	HSS-G	in metal case

All threading tools, threading tool holder and accessories can also be ordered separately.

Application/for general use:

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand
- HSS-G Hand taps acc. to ≈ DIN 352*
- HSS-G Hand taps acc. to ≈ DIN 2181**
- HSS Round dies acc. to DIN 223 (DIN EN 22568)

UNC / UNF

Sets (8):

	Art. -No.
Hand taps and round dies (set of 27 pcs.) UNC 1/4 - 1/2	48050*
Hand taps and round dies (set of 35 pcs.) UNC 1/4 - 3/4	48051*
Hand taps and round dies (set of 44 pcs.) UNC 1/4 - 1"	48053*
Hand taps and round dies (set of 62 pcs.) UNC 1/4 - 1.1/2	48054*
Hand taps and round dies (set of 22 pcs.) UNF 1/4 - 1/2	48060**
Hand taps and round dies (set of 28 pcs.) UNF 1/4 - 3/4	48061**
Hand taps and round dies (set of 35 pcs.) UNF 1/4 - 1"	48063**
Hand taps and round dies (set of 56 pcs.) UNC+UNF 1/4 - 3/4	48066*/**

[48050](#) - set of 27 pcs. UNC 1/4 - 1/2

Contents:

HSS-G Hand taps (sets of 3 pcs.)

	Art.-No.
1x UNC 1/4	23314
1x UNC 5/16	23316
1x UNC 3/8	23318
1x UNC 7/16	23320
1x UNC 1/2	23322

Contents:

HSS Round die

	Art.-No.
1x UNC 1/4	23414
1x UNC 5/16	23416
1x UNC 3/8	23418
1x UNC 7/16	23420
1x UNC 1/2	23422

Contents:

	Art.-No.
1x Adjustable tap wrench, zinc die cast No. 1	13010
1x Adjustable tap wrench, zinc die cast No. 2	13020
1x Die stock, zinc die cast 20x7 mm	15003
1x Die stock, zinc die cast 25x9 mm	15004
1x Die stock, zinc die cast 30x11 mm	15005
1x Die stock, zinc die cast 38x14 mm	15007
1x Tap holder with ratchet, size 1	10001



48051 - set of 35 pcs. UNC 1/4 - 3/4

Contents: HSS-G Hand taps

(sets of 3 pcs.)	Art.-No.
1x UNC 1/4	23314
1x UNC 5/16	23316
1x UNC 3/8	23318
1x UNC 7/16	23320
1x UNC 1/2	23322
1x UNC 5/8	23326
1x UNC 3/4	23330

Contents: HSS Round die

	Art.-No.
1x UNC 1/4	23414
1x UNC 5/16	23416
1x UNC 3/8	23418
1x UNC 7/16	23420
1x UNC 1/2	23422
1x UNC 5/8	23426
1x UNC 3/4	23430

Contents:

	Art.-No.
1x Adjustable tap wrench, zinc die cast No. 1	13010
1x Adjustable tap wrench, zinc die cast No. 3	13030
1x Die stock, zinc die cast 20x7 mm	15003
1x Die stock, zinc die cast 25x9 mm	15004
1x Die stock, zinc die cast 30x11 mm	15005
1x Die stock, zinc die cast 38x14 mm	15007
1x Die stock, zinc die cast 45x18 mm	15009

48053 - set of 44 pcs. UNC 1/4 - 1"

Contents: HSS-G Hand taps

(sets of 3 pcs.)	Art.-No.
1x UNC 1/4	23314
1x UNC 5/16	23316
1x UNC 3/8	23318
1x UNC 7/16	23320
1x UNC 1/2	23322
1x UNC 5/8	23326
1x UNC 3/4	23330
1x UNC 7/8	23334
1x UNC 1"	23338

Contents: HSS Round die

	Art.-No.
1x UNC 1/4	23414
1x UNC 5/16	23416
1x UNC 3/8	23418
1x UNC 7/16	23420
1x UNC 1/2	23422
1x UNC 5/8	23426
1x UNC 3/4	23430
1x UNC 7/8	23434
1x UNC 1"	23438

Contents:

	Art.-No.
1x Adjustable tap wrench, zinc die cast No. 1	13010
1x Adjustable tap wrench, zinc die cast No. 4	13040
1x Die stock, zinc die cast 20x7 mm	15003
1x Die stock, zinc die cast 25x9 mm	15004
1x Die stock, zinc die cast 30x11 mm	15005
1x Die stock, zinc die cast 38x14 mm	15007
1x Die stock, zinc die cast 45x18 mm	15009
1x Die stock, zinc die cast 55x22 mm	15011



48054 - set of 62 pcs. UNC 1/4 - 1.1/2

Contents: HSS-G Hand taps

(sets of 3 pcs.) Art.-No.

1x UNC 1/4	23314
1x UNC 5/16	23316
1x UNC 3/8	23318
1x UNC 7/16	23320
1x UNC 1/2	23322
1x UNC 5/8	23326
1x UNC 3/4	23330
1x UNC 7/8	23334
1x UNC 1"	23338
1x UNC 1.1/8	23342
1x UNC 1.1/4	23346
1x UNC 1.3/8	23350
1x UNC 1.1/2	23354

Contents: HSS Round die

Art.-No.

1x UNC 1/4	23414
1x UNC 5/16	23416
1x UNC 3/8	23418
1x UNC 7/16	23420
1x UNC 1/2	23422
1x UNC 5/8	23426
1x UNC 3/4	23430
1x UNC 7/8	23434
1x UNC 1"	23438
1x UNC 1.1/8	23442
1x UNC 1.1/4	23446
1x UNC 1.3/8	23450
1x UNC 1.1/2	23454

Contents:

Art.-No.

1x Adjustable tap wrench, zinc die cast No. 1	13010
1x Adjustable tap wrench, zinc die cast No. 3	13030
1x Adjustable tap wrench, zinc die cast No. 5	13050
1x Die stock, zinc die cast 20x7 mm	15003
1x Die stock, zinc die cast 25x9 mm	15004
1x Die stock, zinc die cast 30x11 mm	15005
1x Die stock, zinc die cast 38x14 mm	15007
1x Die stock, zinc die cast 45x18 mm	15009
1x Die stock, zinc die cast 55x22 mm	15011
1x Die stock, zinc die cast 65x25 mm	15013

48060 - set of 22 pcs. UNF 1/4 - 1/2

Contents: HSS-G Hand taps

(sets of 2 pcs.) Art.-No.

1x UNF 1/4	24314
1x UNF 5/16	24316
1x UNF 3/8	24318
1x UNF 7/16	24320
1x UNF 1/2	24322

Contents: HSS Round die

Art.-No.

1x UNF 1/4	24414
1x UNF 5/16	24416
1x UNF 3/8	24418
1x UNF 7/16	24420
1x UNF 1/2	24422

Contents:

Art.-No.

1x Adjustable tap wrench, zinc die cast No. 1	13010
1x Adjustable tap wrench, zinc die cast No. 2	13020
1x Die stock, zinc die cast 20x7 mm	15003
1x Die stock, zinc die cast 25x9 mm	15004
1x Die stock, zinc die cast 30x11 mm	15005
1x Die stock, zinc die cast 38x10 mm	15006
1x Tap holder with ratchet, size 1	10001



48061 - set of 28 pcs. UNF 1/4 - 3/4

Contents: HSS-G Hand taps

(sets of 2 pcs.)	Art.-No.
1x UNF 1/4	24314
1x UNF 5/16	24316
1x UNF 3/8	24318
1x UNF 7/16	24320
1x UNF 1/2	24322
1x UNF 5/8	24326
1x UNF 3/4	24330

Contents: HSS Round die

	Art.-No.
1x UNF 1/4	24414
1x UNF 5/16	24416
1x UNF 3/8	24418
1x UNF 7/16	24420
1x UNF 1/2	24422
1x UNF 5/8	24426
1x UNF 3/4	24430

Contents:

	Art.-No.
1x Adjustable tap wrench, zinc die cast No. 1	13010
1x Adjustable tap wrench, zinc die cast No. 3	13030
1x Die stock, zinc die cast 20x7 mm	15003
1x Die stock, zinc die cast 25x9 mm	15004
1x Die stock, zinc die cast 30x11 mm	15005
1x Die stock, zinc die cast 38x10 mm	15006
1x Die stock, zinc die cast 45x14 mm	15008

48063 - set of 35 pcs. UNF 1/4 - 1"

Contents: HSS-G Hand taps

(sets of 2 pcs.)	Art.-No.
1x UNF 1/4	24314
1x UNF 5/16	24316
1x UNF 3/8	24318
1x UNF 7/16	24320
1x UNF 1/2	24322
1x UNF 5/8	24326
1x UNF 3/4	24330
1x UNF 7/8	24334
1x UNF 1"	24338

Contents: HSS Round die

	Art.-No.
1x UNF 1/4	24414
1x UNF 5/16	24416
1x UNF 3/8	24418
1x UNF 7/16	24420
1x UNF 1/2	24422
1x UNF 5/8	24426
1x UNF 3/4	24430
1x UNF 7/8	24434
1x UNF 1"	24438

Contents:

	Art.-No.
1x Adjustable tap wrench, zinc die cast No. 1	13010
1x Adjustable tap wrench, zinc die cast No. 4	13040
1x Die stock, zinc die cast 20x7 mm	15003
1x Die stock, zinc die cast 25x9 mm	15004
1x Die stock, zinc die cast 30x11 mm	15005
1x Die stock, zinc die cast 38x10 mm	15006
1x Die stock, zinc die cast 45x14 mm	15008
1x Die stock, zinc die cast 55x16 mm	15010



48066 - set of 56 pcs. UNC+UNF 1/4 - 3/4

Contents:

HSS-G Hand taps

(sets of 3 pcs.) Art.-No.

1x UNC 1/4 [23314](#)

1x UNC 5/16 [23316](#)

1x UNC 3/8 [23318](#)

1x UNC 7/16 [23320](#)

1x UNC 1/2 [23322](#)

1x UNC 5/8 [23326](#)

1x UNC 3/4 [23330](#)

(sets of 2 pcs.)

1x UNF 1/4 [24014](#)

1x UNF 5/16 [24016](#)

1x UNF 3/8 [24018](#)

1x UNF 7/16 [24020](#)

1x UNF 1/2 [24022](#)

1x UNF 5/8 [24026](#)

1x UNF 3/4 [24030](#)

Contents:

HSS Round dies

Art.-No.

1x UNC 1/4 [23414](#)

1x UNC 5/16 [23416](#)

1x UNC 3/8 [23418](#)

1x UNC 7/16 [23420](#)

1x UNC 1/2 [23422](#)

1x UNC 5/8 [23426](#)

1x UNC 3/4 [23430](#)

1x UNF 1/4 [24414](#)

1x UNF 5/16 [24416](#)

1x UNF 3/8 [24418](#)

1x UNF 7/16 [24420](#)

1x UNF 1/2 [24422](#)

1x UNF 5/8 [24426](#)

1x UNF 3/4 [24430](#)

Contents:

Art.-No.

1x Adjustable tap wrench,
zinc die cast No. 1 [13010](#)

1x Adjustable tap wrench,
zinc die cast No. 3 [13030](#)

1x Die stock,
zinc die cast 20x7 mm [15003](#)

1x Die stock,
zinc die cast 25x9 mm [15004](#)

1x Die stock,
zinc die cast 30x11 mm [15005](#)

1x Die stock,
zinc die cast 38x14 mm [15007](#)

1x Die stock,
zinc die cast 45x18 mm [15009](#)



Hand taps and round dies, G (BSP) / NPT

Type of thread	Standard	Material	Packing
Pipe-thread DIN ISO 228 + american tapered pipe thread, taper 1:16	DIN Standard	HSS-G	in metal case

All threading tools, threading tool holder and accessories can also be ordered separately.

Application/for general use:

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand
- HSS-G Hand taps acc. to DIN 5157*
- HSS Round dies acc. to DIN 5158 (DIN EN 24231)*

G (BSP) / NPT

Sets (5):

	Art. -No.
Hand taps and round dies (set of 26 pcs.) G (BSP) 1/8 - 1"	48020 *
Hand taps and round dies (set of 32 pcs.) G (BSP) 1/8 - 1"	48021 *
Hand taps and round dies (set of 30 pcs.) G (BSP) 1/4 - 1.1/2	48022 *
Short machine taps and round dies (set of 20 pcs.) NPT 1/8 - 1"	48025
Short machine taps and round dies (set of 29 pcs.) NPT 1/8 - 2"	48027

[48020](#) - set of 26 pcs. UNC G (BSP) 1/8 - 1"

Contents:

HSS-G Hand taps

(sets of 2 pcs.)	Art.-No.
1x G (BSP) 1/8	25312
1x G (BSP) 1/4	25314
1x G (BSP) 3/8	25316
1x G (BSP) 1/2	25318
1x G (BSP) 3/4	25322
1x G (BSP) 1"	25326

Contents:

HSS Round dies

	Art.-No.
1x G (BSP) 1/8	25412
1x G (BSP) 1/4	25414
1x G (BSP) 3/8	25416
1x G (BSP) 1/2	25418
1x G (BSP) 3/4	25422
1x G (BSP) 1"	25426

Contents:

	Art.-No.
1x Adjustable tap wrench, zinc die cast No. 1	13010
1x Adjustable tap wrench, zinc die cast No. 3	13030
1x Adjustable tap wrench, zinc die cast No. 5	13040
1x Die stock, zinc die cast 30x11 mm	15005
1x Die stock, zinc die cast 38x10 mm	15006
1x Die stock, zinc die cast 45x14 mm	15008
1x Die stock, zinc die cast 55x16 mm	15010
1x Die stock, zinc die cast 65x18 mm	15012



48021 - set of 32 pcs. UNC G (BSP) 1/8 - 1"

Contents: HSS-G Hand taps

(sets of 2 pcs.)	Art.-No.
1x G (BSP) 1/8	25312
1x G (BSP) 1/4	25314
1x G (BSP) 3/8	25316
1x G (BSP) 1/2	25318
1x G (BSP) 5/8	25320
1x G (BSP) 3/4	25322
1x G (BSP) 7/8	25324
1x G (BSP) 1"	25326

Contents: HSS Round die

	Art.-No.
1x G (BSP) 1/8	25412
1x G (BSP) 1/4	25414
1x G (BSP) 3/8	25416
1x G (BSP) 1/2	25418
1x G (BSP) 5/8	25420
1x G (BSP) 3/4	25422
1x G (BSP) 7/8	25424
1x G (BSP) 1"	25426

Contents:

	Art.-No.
1x Adjustable tap wrench, zinc die cast No. 1	13010
1x Adjustable tap wrench, zinc die cast No. 3	13030
1x Adjustable tap wrench, zinc die cast No. 5	13050
1x Die stock, zinc die cast 30x11 mm	15005
1x Die stock, zinc die cast 38x10 mm	15006
1x Die stock, zinc die cast 45x14 mm	15008
1x Die stock, zinc die cast 55x16 mm	15010
1x Die stock, zinc die cast 65x18 mm	15012

48022 - set of 30 pcs. UNC G (BSP) 1/4 - 1.1/2

Contents: HSS-G Hand taps

(sets of 2 pcs.)	Art.-No.
1x G (BSP) 1/4	25314
1x G (BSP) 3/8	25316
1x G (BSP) 1/2	25318
1x G (BSP) 3/4	25322
1x G (BSP) 1"	25326
1x G (BSP) 1.1/4	25334
1x G (BSP) 1.1/2	25342

Contents: HSS Round die

	Art.-No.
1x G (BSP) 1/4	25414
1x G (BSP) 3/8	25416
1x G (BSP) 1/2	25418
1x G (BSP) 3/4	25422
1x G (BSP) 1"	25426
1x G (BSP) 1.1/4	25434
1x G (BSP) 1.1/2	25442

Contents:

	Art.-No.
1x Adjustable tap wrench, zinc die cast No. 2	13020
1x Adjustable tap wrench, zinc die cast No. 4	13040
1x Adjustable tap wrench, zinc die cast No. 7	14070
1x Die stock, zinc die cast 38x10 mm	15006
1x Die stock, zinc die cast 45x14 mm	15008
1x Die stock, zinc die cast 55x16 mm	15010
1x Die stock, zinc die cast 65x18 mm	15012
1x Die Stock, steel 75x20 mm	15214
1x Die Stock, steel 90x22 mm	15216



48025 - set of 20 pcs. UNC NPT 1/8 - 1"

Contents:

HSS-G Short Machine Taps

Form C

	Art.-No.
NPT 1/8	63512
NPT 1/4	63514
NPT 3/8	63516
NPT 1/2	63518
NPT 3/4	63522
NPT 1"	63526

Contents:

HSS Round die

	Art.-No.
NPT 1/8	23612
NPT 1/4	23614
NPT 3/8	23616
NPT 1/2	23618
NPT 3/4	23622
NPT 1"	23626

Contents:

	Art.-No.
1x Adjustable tap wrench, zinc die cast No. 1	13010
1x Adjustable tap wrench, zinc die cast No. 3	13030
1x Adjustable tap wrench, zinc die cast No. 5	13050
1x Die stock, zinc die cast 30x11 mm	15005
1x Die stock, zinc die cast 38x14 mm	15007
1x Die stock, zinc die cast 45x18 mm	15009
1x Die stock, zinc die cast 55x22 mm	15011
1x Die stock, zinc die cast 65x25 mm	15013

48027 - set of 29 pcs. UNC NPT 1/8 - 2"

Contents:

HSS-G Short Machine Taps

Form C

	Art.-No.
NPT 1/8	63512
NPT 1/4	63514
NPT 3/8	63516
NPT 1/2	63518
NPT 3/4	63522
NPT 1"	63526
NPT 1.1/4	63534
NPT 1.1/2	63542
NPT 2"	63554

Contents:

HSS Round die

	Art.-No.
NPT 1/8	23612
NPT 1/4	23614
NPT 3/8	23616
NPT 1/2	23618
NPT 3/4	23622
NPT 1"	23626
NPT 1.1/4	23634
NPT 1.1/2	23642
NPT 2"	23654

Contents:

	Art.-No.
1x Adjustable tap wrench, zinc die cast No. 2	13020
1x Adjustable tap wrench, zinc die cast No. 4	13040
1x Adjustable tap wrench, zinc die cast No. 7	14070
1x Die stock, zinc die cast 30x11 mm	15005
1x Die stock, zinc die cast 38x14 mm	15007
1x Die stock, zinc die cast 45x18 mm	15009
1x Die stock, zinc die cast 55x22 mm	15011
1x Die stock, zinc die cast 65x25 mm	15013
1x Die stock, steel 75x30 mm	15215
1x Die stock, steel 90x36 mm	15217
1x Die stock, steel 105x36 mm	15219



Threading tools in drillbox



All threading tools, threading tool holder and accessories can also be ordered separately.

- Tap and die sets for metric ISO-threads DIN 13
- In original drillbox®
- High quality metal cassettes "Made in Germany"
- Variations in HSS-G, HSS-E and for metric left-hand threads (LH)
- reg. Trademark by drillbox GmbH, 91583 Schillingfürst, Germany.

Threading tools in drillbox

Type of thread	Standard	Material	Packing
metric ISO thread DIN 13	DIN Standard	HSS-G	in drillbox metal case

Sets (10):

	Art. -No.
P.V.1 Hand taps and round dies (set of 43 pcs.) incl. drills M 3 - M 12	49101
Hand taps and round dies (set of 35 pcs.) M 3 - M 12	49107
Hand taps and round dies (set of 43 pcs.) incl. drills HSS-E M 3 - M 12	49151
Hand taps and round dies, left hand (set of 43 pcs.) incl. drills M 3 LH - M 12 LH	49171
F.Z.1 Hand taps and round dies (set of 50 pcs.) incl. drills M 3 - M 12	49150
S.F.1 Hand taps and round dies (set of 50 pcs.) incl. drills M 3 - M 12	49106
Hand taps and round dies (set of 52 pcs.) HSS-E M 3 - M 20	49251
Hand taps and round dies, left hand (set of 52 pcs.) M 3 LH - M 20 LH	49271
P.V.5 Hand taps and round dies (set of 52 pcs.) M 3 - M 20	49205
P.V.15 Hand taps and round dies (set of 31 pcs.) M 3 - M 12	49505



49101 - P.V.1 set of 43 pcs. incl. drills M 3 – M 12

Contents:

HSS-G Hand taps

(sets of 3 pcs.) Art.-No.

1x M 3	27326
1x M 4	27330
1x M 5	27334
1x M 6	27338
1x M 8	27342
1x M 10	27346
1x M 12	27350

Contents:

HSS Round die

Art.-No.

1x M 3	27426
1x M 4	27430
1x M 5	27434
1x M 6	27438
1x M 8	27442
1x M 10	27446
1x M 12	27450

Application/for general use:

- › non abrasive material up to 900 N/mm²
- › unalloyed and low alloyed steel
- › for through and blind holes
- › for thread cutting by hand
- › the most popular dimensions in one case
- › HSS-G Hand taps acc. to DIN 352
- › HSS Round dies acc. to DIN 223 (DIN EN 22568)

+ HSS Twist Drill:

1x 2,50 mm (M 3)
1x 3,30 mm (M 4)
1x 4,20 mm (M 5)
1x 5,00 mm (M 6)
1x 6,80 mm (M 8)
1x 8,50 mm (M 10)
1x 10,20 mm (M 12)

Contents:

Art.-No.

1x Adjustable tap wrench, zinc die cast No. 1	13010
1x Adjustable tap wrench, zinc die cast No. 2	13020
1x Die stock, zinc die cast 20x5 mm	15002
1x Die stock, zinc die cast 20x7 mm	15003
1x Die stock, zinc die cast 25x9 mm	15004
1x Die stock, zinc die cast 30x11 mm	15005
1x Die stock, zinc die cast 38x14 mm	15007
1x Tap holder with ratchet, size 1	10001

49107 - set of 35 pcs. M 3 – M 12

Contents:

HSS-G Hand taps

(sets of 3 pcs.) Art.-No.

1x M 3	27326
1x M 4	27330
1x M 5	27334
1x M 6	27338
1x M 8	27342
1x M 10	27346
1x M 12	27350

Contents:

HSS Round die

Art.-No.

1x M 3	27426
1x M 4	27430
1x M 5	27434
1x M 6	27438
1x M 8	27442
1x M 10	27446
1x M 12	27450

Application/for general use:

- › non abrasive material up to 900 N/mm²
- › unalloyed and low alloyed steel
- › for through and blind holes
- › for thread cutting by hand
- › the most popular dimensions in one case
- › HSS-G Hand taps acc. to DIN 352
- › HSS Round dies acc. to DIN 223 (DIN EN 22568)

Contents:

Art.-No.

1x Adjustable tap wrench, zinc die cast No. 1	13010
1x Adjustable tap wrench, zinc die cast No. 2	13020
1x Die stock, zinc die cast 20x5 mm	15002
1x Die stock, zinc die cast 20x7 mm	15003
1x Die stock, zinc die cast 25x9 mm	15004
1x Die stock, zinc die cast 30x11 mm	15005
1x Die stock, zinc die cast 38x14 mm	15007



49151 - set of 43 pcs. incl. drills HSS-E M 3 - M 12

Contents: HSS-E Hand taps

(sets of 3 pcs.)	Art.-No.
1x M 3	57326
1x M 4	57330
1x M 5	57334
1x M 6	57338
1x M 8	57342
1x M 10	57346
1x M 12	57350

Contents: HSS-E Round die

	Art.-No.
1x M 3	57426
1x M 4	57430
1x M 5	57434
1x M 6	57438
1x M 8	57442
1x M 10	57446
1x M 12	57450

Contents:	Art.-No.
1x Adjustable tap wrench, zinc die cast No. 1	13010
1x Adjustable tap wrench, zinc die cast No. 2	13020
1x Die stock, zinc die cast 20x5 mm	15002
1x Die stock, zinc die cast 20x7 mm	15003
1x Die stock, zinc die cast 25x9 mm	15004
1x Die stock, zinc die cast 30x11 mm	15005
1x Die stock, zinc die cast 38x14 mm	15007
1x Tap holder with ratchet, size 1	10001

Application/for general use:

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand
- the most popular dimensions in one case
- HSS-E Hand taps acc. to DIN 352
- HSS-E Round dies acc. to DIN 223 (DIN EN 22568)

+ HSS Twist Drill:

1x 2,50 mm (M 3)
1x 3,30 mm (M 4)
1x 4,20 mm (M 5)
1x 5,00 mm (M 6)
1x 6,80 mm (M 8)
1x 8,50 mm (M 10)
1x 10,20 mm (M 12)

49171 - set of 43 pcs. incl. drills M 3 LH - M 12 LH

Contents: HSS-G Hand taps

(sets of 3 pcs.)	Art.-No.
1x M 3 LH	27026
1x M 4 LH	27030
1x M 5 LH	27034
1x M 6 LH	27038
1x M 8 LH	27042
1x M 10 LH	27046
1x M 12 LH	27050

Contents: HSS Round die

	Art.-No.
1x M 3 LH	27226
1x M 4 LH	27230
1x M 5 LH	27234
1x M 6 LH	27238
1x M 8 LH	27242
1x M 10 LH	27246
1x M 12 LH	27250

Contents:	Art.-No.
1x Adjustable tap wrench, zinc die cast No. 1	13010
1x Adjustable tap wrench, zinc die cast No. 2	13020
1x Die stock, zinc die cast 20x5 mm	15002
1x Die stock, zinc die cast 20x7 mm	15003
1x Die stock, zinc die cast 25x9 mm	15004
1x Die stock, zinc die cast 30x11 mm	15005
1x Die stock, zinc die cast 38x14 mm	15007
1x Tap holder with ratchet, size 1	10001

Application/for general use:

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand
- the most popular dimensions in one case
- HSS-G Hand taps acc. to DIN 352
- HSS Round dies acc. to DIN 223 (DIN EN 22568)

+ HSS Twist Drill:

1x 2,50 mm (M 3)
1x 3,30 mm (M 4)
1x 4,20 mm (M 5)
1x 5,00 mm (M 6)
1x 6,80 mm (M 8)
1x 8,50 mm (M 10)
1x 10,20 mm (M 12)



49150 - F.Z.1 set of 50 pcs. incl. drills M 3 - M 12

Contents:

HSS-E VAP Hand taps

(sets of 3 pcs.) Art.-No.

1x M 3	57726
1x M 4	57730
1x M 5	57734
1x M 6	57738
1x M 8	57742
1x M 10	57746
1x M 12	57750

Contents:

HSS-E Round die

1x M 3	57426
1x M 4	57430
1x M 5	57434
1x M 6	57438
1x M 8	57442
1x M 10	57446
1x M 12	57450

+ HSS Twist Drill:

1x 2,50 mm (M 3)
1x 3,30 mm (M 4)
1x 4,20 mm (M 5)
1x 5,00 mm (M 6)
1x 6,80 mm (M 8)
1x 8,50 mm (M 10)
1x 10,20 mm (M 12)

Application/for general use:

- › non abrasive material up to 900 N/mm²
- › unalloyed and low alloyed steel
- › for through and blind holes
- › for thread cutting by hand
- › small and handy problemsolver for standard application
- › Rougher piloted
- › 7 Guides for round dies
- › HSS-E Hand taps acc. to DIN 352
- › HSS Round dies acc. to DIN 223 (DIN EN 22568)
- › the most popular dimensions in one case

Contents:

1x Guides for round dies (set of 7 pcs.) M 3 - M 12	15100
1x Adjustable tap wrench, zinc die cast No. 1	13010
1x Adjustable tap wrench, zinc die cast No. 2	13020
1x Die stock, zinc die cast 20x5 mm	15002
1x Die stock, zinc die cast 20x7 mm	15003
1x Die stock, zinc die cast 25x9 mm	15004
1x Die stock, zinc die cast 30x11 mm	15005
1x Die stock, zinc die cast 38x14 mm	15007
1x Tap holder with ratchet, size 1	10001

49106 - S.F.1 set of 50 pcs. incl. drills M 3 - M 12

Contents:

HSS-G Hand taps

(sets of 3 pcs.) Art.-No.

1x M 3	27326
1x M 4	27330
1x M 5	27334
1x M 6	27338
1x M 8	27342
1x M 10	27346
1x M 12	27350

Contents:

HSS Round die

1x M 3	27426
1x M 4	27430
1x M 5	27434
1x M 6	27438
1x M 8	27442
1x M 10	27446
1x M 12	27450

+ HSS Twist Drill:

1x 2,50 mm (M 3)
1x 3,30 mm (M 4)
1x 4,20 mm (M 5)
1x 5,00 mm (M 6)
1x 6,80 mm (M 8)
1x 8,50 mm (M 10)
1x 10,20 mm (M 12)

Application/for general use:

- › non abrasive material up to 900 N/mm²
- › unalloyed and low alloyed steel
- › for through and blind holes
- › for thread cutting by hand
- › small and handy problemsolver for standard application
- › the most popular dimensions in one case
- › 7 Guides for round dies
- › HSS-G Hand taps acc. to DIN 352
- › HSS Round dies with gun nose acc. to DIN 223 (DIN EN 22568)

Contents:

1x Guides for round dies (set of 7 pcs.) M 3 - M 12	15100
1x Adjustable tap wrench, zinc die cast No. 1	13010
1x Adjustable tap wrench, zinc die cast No. 2	13020
1x Die stock, zinc die cast 20x5 mm	15002
1x Die stock, zinc die cast 20x7 mm	15003
1x Die stock, zinc die cast 25x9 mm	15004
1x Die stock, zinc die cast 30x11 mm	15005
1x Die stock, zinc die cast 38x14 mm	15007
1x Tap holder with ratchet, size 1	10001



49251 - set of 52 pcs. HSS-E M 3 – M 20

Contents: HSS-E Hand taps (sets of 3 pcs.)		Contents: HSS-E Round die		Contents:	
	Art.-No.		Art.-No.		Art.-No.
1x M 3	57326	1x M 3	57426	1x Adjustable tap wrench, zinc die cast No. 1	13010
1x M 4	57330	1x M 4	57430	1x Adjustable tap wrench, zinc die cast No. 3	13030
1x M 5	57334	1x M 5	57434	1x Die stock, zinc die cast 20x5 mm	15002
1x M 6	57338	1x M 6	57438	1x Die stock, zinc die cast 20x7 mm	15003
1x M 8	57342	1x M 8	57442	1x Die stock, zinc die cast 25x9 mm	15004
1x M 10	57346	1x M 10	57446	1x Die stock, zinc die cast 30x11 mm	15005
1x M 12	57350	1x M 12	57450	1x Die stock, zinc die cast 38x14 mm	15007
1x M 14	57354	1x M 14	57454	1x Die stock, zinc die cast 45x18 mm	15009
1x M 16	57358	1x M 16	57458		
1x M 18	57362	1x M 18	57462		
1x M 20	57366	1x M 20	57466		

Application/for general use:

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

- the most popular dimensions in one case
- HSS-E Hand taps acc. to DIN 352
- HSS-E Round dies acc. to DIN 223 (DIN EN 22568)

49271 - set of 52 pcs. M 3 LH – M 20 LH

Contents: HSS-G Hand taps (sets of 3 pcs.)		Contents: HSS Round die		Contents:	
	Art.-No.		Art.-No.		Art.-No.
1x M 3 LH	27026	1x M 3 LH	27226	1x Adjustable tap wrench, zinc die cast No. 1	13010
1x M 4 LH	27030	1x M 4 LH	27230	1x Adjustable tap wrench, zinc die cast No. 3	13030
1x M 5 LH	27034	1x M 5 LH	27234	1x Die stock, zinc die cast 20x5 mm	15002
1x M 6 LH	27038	1x M 6 LH	27238	1x Die stock, zinc die cast 20x7 mm	15003
1x M 8 LH	27042	1x M 8 LH	27242	1x Die stock, zinc die cast 25x9 mm	15004
1x M 10 LH	27046	1x M 10 LH	27246	1x Die stock, zinc die cast 30x11 mm	15005
1x M 12 LH	27050	1x M 12 LH	27250	1x Die stock, zinc die cast 38x14 mm	15007
1x M 14 LH	27054	1x M 14 LH	27254	1x Die stock, zinc die cast 45x18 mm	15009
1x M 16 LH	27058	1x M 16 LH	27258		
1x M 18 LH	27062	1x M 18 LH	27262		
1x M 20 LH	27066	1x M 20 LH	27266		

Application/for general use:

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

- the most popular dimensions in one case
- HSS-G Hand taps acc. to DIN 352
- HSS Round dies acc. to DIN 223 (DIN EN 22568)



49205 - P.V.5 set of 52 pcs. M 3 – M 20

Contents:

HSS-G Hand taps

(sets of 3 pcs.) Art.-No.

1x M 3 [27326](#)

1x M 4 [27330](#)

1x M 5 [27334](#)

1x M 6 [27338](#)

1x M 8 [27342](#)

1x M 10 [27346](#)

1x M 12 [27350](#)

1x M 14 [27354](#)

1x M 16 [27358](#)

1x M 18 [27362](#)

1x M 20 [27366](#)

Contents:

HSS Round die

Art.-No.

1x M 3 [27426](#)

1x M 4 [27430](#)

1x M 5 [27434](#)

1x M 6 [27438](#)

1x M 8 [27442](#)

1x M 10 [27446](#)

1x M 12 [27450](#)

1x M 14 [27454](#)

1x M 16 [27458](#)

1x M 18 [27462](#)

1x M 20 [27466](#)

Contents:

1x Adjustable tap wrench, zinc die cast No. 1 [13010](#)

1x Adjustable tap wrench, zinc die cast No. 3 [13030](#)

1x Die stock, zinc die cast 20x5 mm [15002](#)

1x Die stock, zinc die cast 20x7 mm [15003](#)

1x Die stock, zinc die cast 25x9 mm [15004](#)

1x Die stock, zinc die cast 30x11 mm [15005](#)

1x Die stock, zinc die cast 38x14 mm [15007](#)

1x Die stock, zinc die cast 45x18 mm [15009](#)

Application/for general use:

- › non abrasive material up to 900 N/mm²
- › unalloyed and low alloyed steel
- › for through and blind holes
- › for thread cutting by hand
- › small and handy problemsolver for standard application

- › the most popular dimensions in one case
- › HSS-G Hand taps acc. to DIN 352
- › HSS Round dies acc. to DIN 223 (DIN EN 22568)

49505 - P.V.15 set of 31 pcs. M 3 – M 12

Contents:

HSS-G Hand taps

(sets of 3 pcs.) Art.-No.

1x M 3 [27326](#)

1x M 4 [27330](#)

1x M 5 [27334](#)

1x M 6 [27338](#)

1x M 8 [27342](#)

1x M 10 [27346](#)

1x M 12 [27350](#)

Contents:

HSS Round die

Art.-No.

1x M 3 [27826](#)

1x M 4 [27830](#)

1x M 5 [27834](#)

1x M 6 [27838](#)

1x M 8 [27842](#)

1x M 10 [27846](#)

1x M 12 [27850](#)

Contents:

1x Adjustable tap wrench, zinc die cast No. 1.1/2 [13015](#)

1x Die stock, zinc die cast 25x9 mm [15004](#)

1x Tap holder with ratchet, size 1 [10001](#)

Application/for general use:

- › non abrasive material up to 900 N/mm²
- › unalloyed and low alloyed steel
- › for through and blind holes
- › for thread cutting by hand
- › the most popular dimensions in one case
- › HSS-G Hand taps acc. to DIN 352
- › HSS Round dies acc. to DIN 223 (DIN EN 22568)



Left hand (LH)



metrisches ISO-Gewinde DIN 13

Gewindeschneidwerkzeugsätze für metrisches Linksgewinde (LH).

- Gewindeschneidsätze in DIN-Ausführung
- für Durchgangs- und Sacklöcher
- für gut zerspanbare Werkstoffe bis 900 N/mm²

Gewindewerkzeuge in den gängigsten Abmessungen von M 3 bis M 12 Linksgewinde in stabilen Kassetten vereint.

Sets (4):

	Art. -No.
Hand taps and round dies, left hand (set of 43 pcs.) incl. drills M 3 LH - M 12 LH	49171
Hand taps and round dies, left hand (set of 52 pcs.) M 3 LH - M 20 LH	49271
Round dies, left hand (set of 19 pcs.) incl. guides M 3 LH - M 12 LH	49598
Hand taps, left hand (set of 23 pcs.) incl. ratchet M 3 LH - M 12 LH	47075



Glossary

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A

ACME

American Trapezoidal thread (ACME)

Thread angle 29°, ANSI B 1.5 - 1977 (e.g. 3/4 - 6 ACME)

- ACME-C = centralizing
- ACME-G = for general purpose

B

BA - British Association-thread

British Association-thread (BA)

Thread angle: 47°30', BS 949

Application example:

The BA thread is used in different technical fields like technical instruments, clocks, watches, but also for e.g. the BA 2 thread for the tip of darts.

BC - Cycle thread

Japanese and Korean thread for bicycles (BC)

Thread angle 60°

Standard: JIS B 0025, KS B 0026 (e.g. BC 5/16)

C

C Mount

Thread for motion-picture cameras (16 mm)

ANSI/SMPTE 76-1985

Thread angle 60°

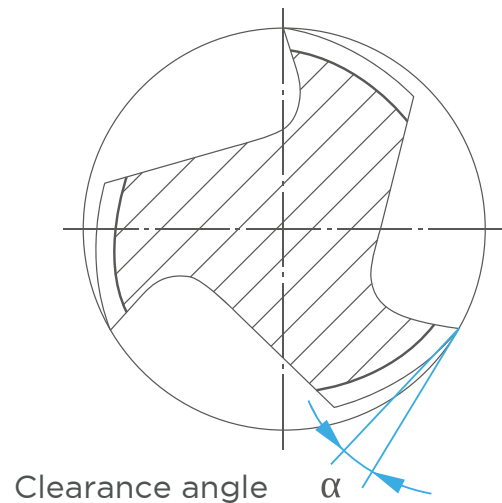


Clearance angle

The size of the clearance angle on the screw tap determines the friction between the thread flanks of the work piece and the tool.

The tap relief on the edge of the screw taps creates the clearance angle.

Through this, the danger of clamping and of breaking the tool on the screw tap are reduced.



D

D Mount

Thread for motion-picture cameras (8 mm)

ANSI/SMPTE 76-1985

Thread angle 60° (5/8-32)

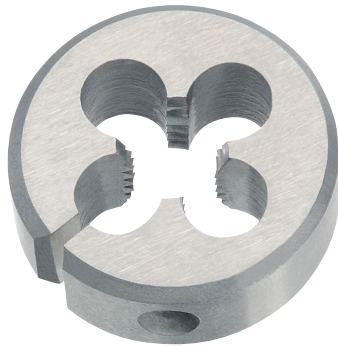
Dies (Round dies)

These are thread cutting tools used for producing external threads. Round dies are round and usually have three or more cutting edges. They are either used for manual use of die holders or clamped into the quill to use in a turning lathe.

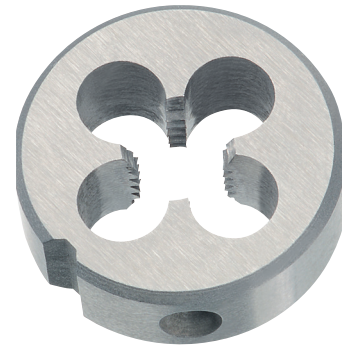
The chips are discharged through the plane holes in round dies. Round dies are available slotted (style A) or closed (style B), with closed being the most commonly used style. The groove in style A round dies allows these to be adjusted if worn.



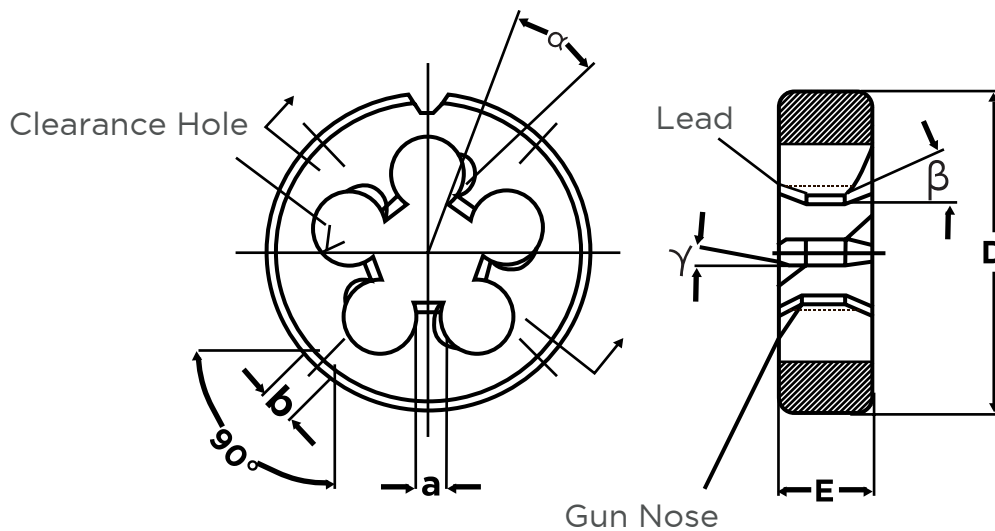
Round die Form A (split)



Round die Form B (solid)



Dimensioning of round dies



- D = Outside diameter
- E = Width of die
- a = Width of land
- b = Hole for holding screws

- α = Rake angle
- β = Lead angle
- γ = Angle of gun nose

E

E con - Tapered thread for cylinder valves

Tapered thread for cylinder valves

- acc. to DIN-EN 144-1, DIN-EN-ISO 11116-1
- Thread angle 55° (e.g. E 17 con)



H

HSS (High Speed Steel)

HSS (High Speed Steel) are high-alloyed tool steels which are primarily used for machining and moulding. High-speed steels contain 0.7 to 1.4% carbon, approx. 4% chromium and different amounts of tungsten, molybdenum, vanadium and cobalt.

These steels have a high hot-hardness, high-temperature strength, ductility and tempering resistance due to these elements. High-speed steels have an acronym made up of the symbol HS and the alloy contents in the order tungsten, molybdenum, vanadium and cobalt.

Examples:

- HS6-5-2C (Material number 1.3343)
Hardening temperature: 1190-1230°C
Annealing temperature: 540-560°C
Application: e.g. Jobber and twist drills, reamer, milling tools
- HS6-5-2-5 (Material number 1.3243)
Hardening temperature: 1210-1250°C
Annealing temperature: 550-570°C
Application: e.g. High demanded jobber drills with high ductility
- HS10-4-3-10 (Material number 1.3207)
Hardening temperature: 1210-1250°C
Annealing temperature: 550-570°C
Application: e.g. Turning tools for automatic operating mode
- HS2-9-2 (Material number 1.3348)
Hardening temperature: 1190-1230°C
Annealing temperature: 540-580°C
Application: e.g. Milling tools, Twist drills and all kind of taps with high tempering resistance and ductility



P

Pitch per inch into mm

Conversion table for some common pitches per inch (P) into mm

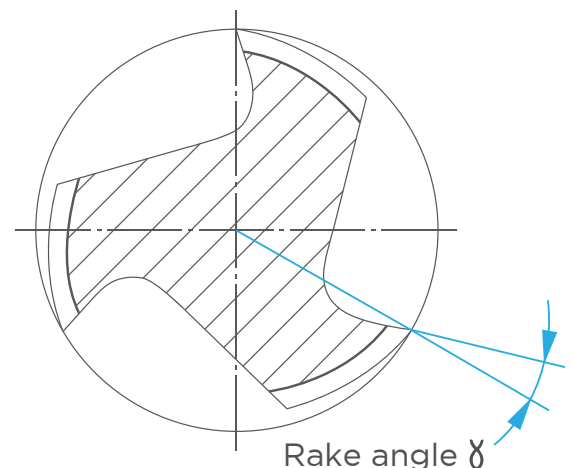
P (Gg/1")	mm	P (Gg/1")	mm	P (Gg/1")	mm
100	0,254 000	24	1,058 333	5	5,080 000
96	0,264 583	22	1,154 545	4.1/2	5,644 444
80	0,317 500	20	1,270 000	4	6,350 000
72	0,352 778	19	1,336 842	3.1/2	7,257 143
64	0,396 875	18	1,411 111	3.1/4	7,815 385
60	0,423 333	16	1,587 500	3	8,466 667
56	0,453 571	14	1,814 286	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 0,91	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		

R

Rake angle

When thread cutting, we adjust the cutting process mainly in accordance with the size of the rake angle.

While for long-chipping materials (e.g. aluminium or copper alloys) a large rake angle should be chosen, for hard and brittle materials, screw taps with a small rake angle must be used.





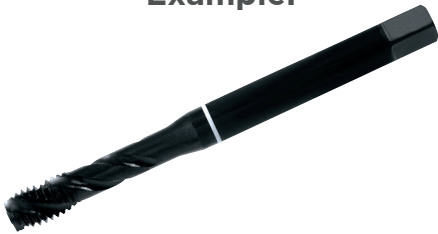
S

Steam tempering (vap)

Threading tools with steam tempered (VAP) surface

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.

Example:



VÖLKEL White RING machine taps, steam tempered:

- Heat resistant steel, long-chipping
- Stainless steel (INOX), long-chipping
- Materials up to 1000 N/mm²
- Chrome-nickel (Cr) alloys

T

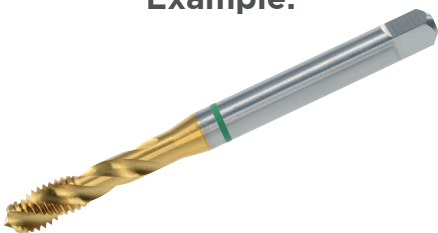
TiN (Titanium Nitride)

Threading tools with Titanium nitride coating (TiN)

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. It is a hard surface coating with a micro-hardness of about 2,600 HV. Withstands temperature up to about 450°C. Suitable for all materials up to about 1,000 N/mm² and the friction value against steel (dry) is 0.4.

Example:



VOELKEL GREEN RING machine taps HSSE-PM-TiN

- Non abrasive material up to 1000 N/mm²
- Stainless and alloyed steels
- Unalloyed and low alloyed steel
- Copper and aluminium-alloys



W

W - Whitworth thread

Whitworth thread, named after Sir Joseph Whitworth and introduced in 1841, was the first standardized thread in the world. It was standardized in Germany according to DIN 11, withdrawn in 1970, had a flank angle of 55° (e.g. W3/8") and was replaced by BSW thread.

or

W 80 x 1/11", thread for valve nuts, neck rings and protection caps on pressurized gas cylinders, DIN 4668, Sept. 1968, thread profile according to Whitworth pipe thread, flank angle 55° , gas cylinders, thread for nozzles, neck rings and protection caps, outer diameter 80mm, flank diameter 78.521 mm, core diameter 77.042mm.

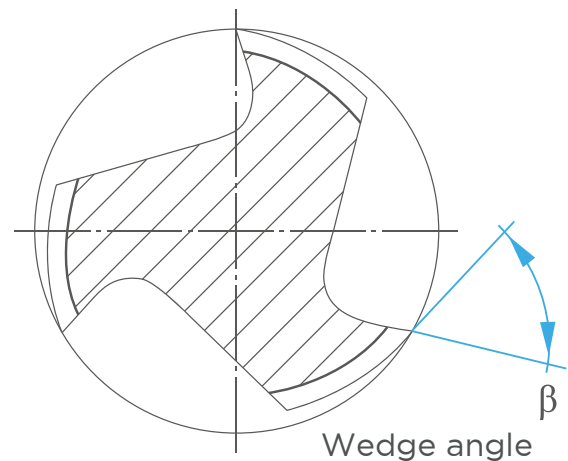
or

Historical Whitworth fine thread 2 from 20 to 189 mm diameter, DIN 240 February 1923, thread profile according to DIN 11, flank angle 55° (e.g. W 60 x 1/6").

Wedge angle

The cutting wedge of a screw tap is identified as the wedge angle. The larger the wedge angle is, the more stable the cutting wedge is. For this reason, screw taps with a high wedge angle are chosen for hard and brittle raw materials.

The larger the wedge angle, the smaller the size of the flute. For long-chipping and tough raw materials the chipping tends to jam in the chip space. For this reason it is important with these materials to use a screw tap with a larger chip space than with screw taps with stable cutting wedges.



SNITTAPPE

ALT I GEVINDVÆRKTØJER

