VÖLKEL

THREADING SOLUTIONS

VD 2020

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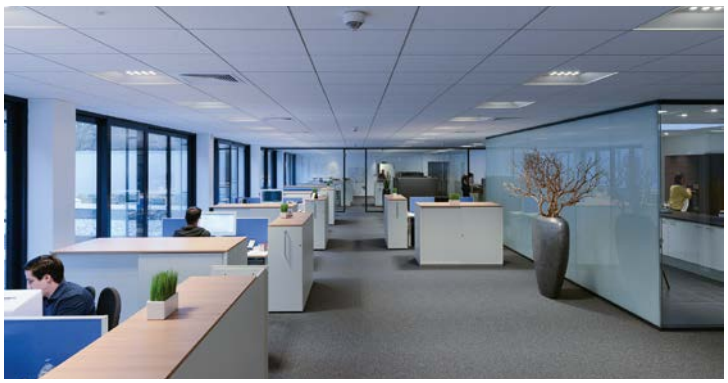

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SINCE 1915
VÖLKEL THREADING SOLUTIONS
– WORLDWIDE COMPETENCE IN THREAD-CUTTING TOOLS

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

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

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

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

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

because available

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

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

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

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

because reliable

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

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

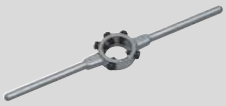
…poiché manteniamo le promesse e potete contare su una qualità e un servizio sempre costante

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

because you

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

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

Die Stocks - Tap Wrenches **Porta-utensili**	**9 - 13**	
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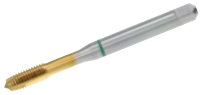
Machine Taps with coloured ring **Maschi a macchina con collarini colorati**	**133 - 155**	
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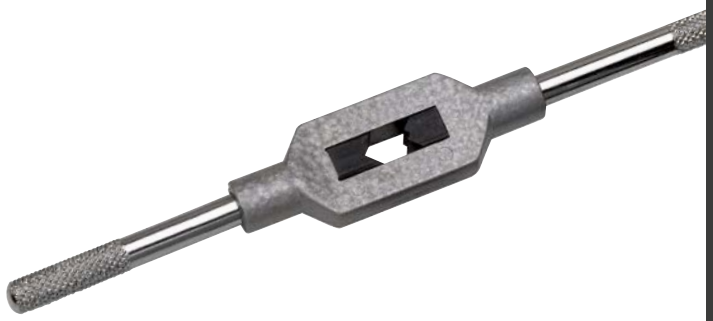
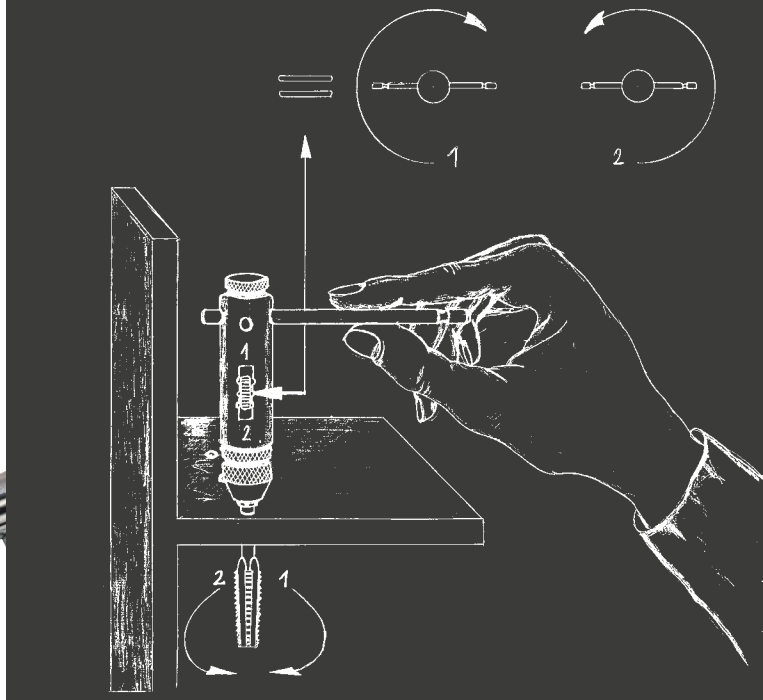
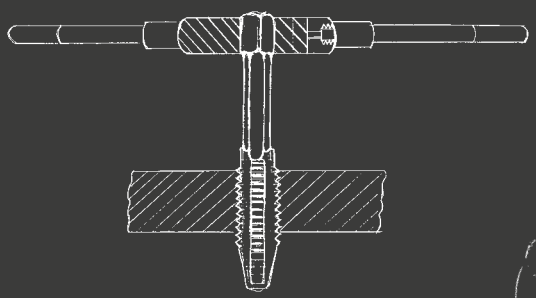
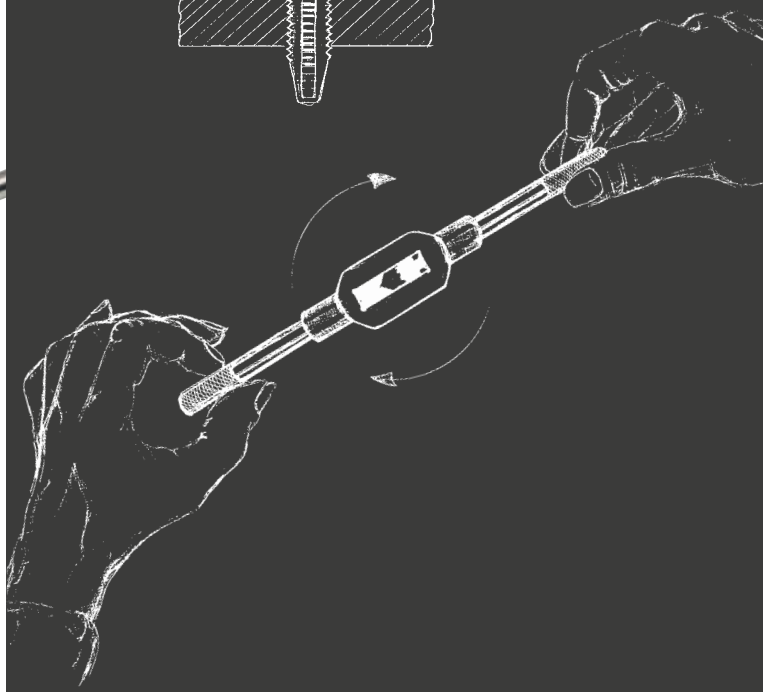
INDEX	G BSP	Rc BSPT	Rp BSPP	PG	Tr	NPT	NPTF	NPS	Rd	FG	BSC	Vg

DIE STOCKS - TAP WRENCHES
PORTA-UTENSILI









DIE STOCKS - TAP WRENCHES
PORTA-UTENSILI

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Tap Holder with Ratchet
for right- and left-hand-turn
all steel quality

Giramaschi con mandrino
per uso fisso, destro e sinistro
esecuzione acciaio

No.	for Taps		Square mm	Length mm	Weight kg		Art.-No.	€//Piece
1	M 3-10	1/8-3/8	2.4-5.5	85	0,165	10	10001	8,50
2	M 5-12	7/32-1/2	4.5-8.0	100	0,310	10	10002	10,50
10	M 3-10	1/8-3/8	2.4-5.5	250	0,250	10	10010	14,00
20	M 5-12	7/32-1/2	4.5-8.0	300	0,440	10	10020	17,00
Jaws and Spring for No. 1 und 10						10	10091	1,50
Jaws and Spring for No. 2 und 20						10	10092	2,50

Die Stocks
Inch - with 3 screws

Portafiliere misura
pollice con 3 vite

Ø	mm	inch/pollice	Length mm	Weight kg		Art.-No.	€//Piece
13/16"	20.6 x 6.35	13/16 x 1/4	200	0,060	5	15520	3,00
1"	25.4 x 9.5	1" x 3/8	224	0,100	5	15525	3,70
1.5/16"	33.4 x 11.1	1.5/16 x 7/16	270	0,180	5	15533	6,30
1.1/2"	38.1 x 12.7	1.1/2 x 1/2	315	0,320	5	15538	9,50
2"	50.8 x 15.9	2" x 5/8	560	0,900	1	15550	15,50
2.1/4"	57.1 x 17.5	2.1/4 x 11/16	560	0,900	1	15557	15,70
2.1/2"	63.5 x 19.0	2.1/2 x 3/4	630	1,400	1	15563	22,00
3"	76.2 x 22.2	3" x 7/8	900	2,200	1	15576	61,00
3.1/2"	88.9 x 25.4	3.1/2" x 1"	900	3,300	1	15588	63,00
4"	101.6 x 25.4	4" x 1"	1000	3,600	1	15599	191,00

Die Stocks
DIN 225 (DIN EN 22568), Zinc die cast

Portafiliere
DIN 225 (DIN EN 22568), pressogetto di zinco

Ø x mm	for round Dies DIN 223 (DIN EN 22568)		Length mm	Weight kg		Art.-No.	€//Piece
16 x 5	M 1-2.6	BSW 1/16-3/32	160	0,050	5	15001	3,00
20 x 5	M 3-4	BSW 1/8-5/32	200	0,065	5	15002	3,00
20 x 7	M 4.5-6	BSW 3/16-1/4	200	0,065	5	15003	3,00
25 x 9	M 7-9	BSW 5/16	224	0,105	5	15004	3,70
30 x 11	M 10-11	BSW 3/8-7/16	280	0,190	5	15005	5,90
38 x 10	Mf 12-15	G 1/4	315	0,340	5	15006	9,70
38 x 14	M 12-14	BSW 1/2-9/16	315	0,340	5	15007	9,70
45 x 14	Mf 16-20	G 3/8-1/2	450	0,650	1	15008	11,90
45 x 18	M 16-20	BSW 5/8-13/16	450	0,650	1	15009	11,90
55 x 16	Mf 22-26	G 5/8-3/4	560	0,900	1	15010	15,70
55 x 22	M 22-24	BSW 7/8-1"	560	0,900	1	15011	15,70
65 x 18	Mf 27-36	G 7/8-1"	630	1,400	1	15012	22,00
65 x 25	M 27-36	BSW 1.1/8-1.3/8	630	1,400	1	15013	22,00

Die Stocks
DIN 225 (DIN EN 22568), STEEL

Portafiliere
DIN 225 (DIN EN 22568), esecuzione acciaio

Ø x mm	for round Dies DIN 223 (DIN EN 22568)		Length mm	Weight kg		Art.-No.	€//Piece
45 x 18	M 16-20	BSW 5/8-13/16	450	0,650	1	15209	22,00
55 x 22	M 22-24	BSW 7/8-1"	560	0,900	1	15211	31,00
65 x 25	M 27-36	BSW 1.1/8-1.3/8	630	1,400	1	15213	39,00
75 x 20	Mf 38-42	G 1.1/8-1.1/4	800	2,250	1	15214	64,00
75 x 30	M 38-42	BSW 1.1/2-1.5/8	800	2,100	1	15215	64,00
90 x 22	Mf 45-52	G 1.3/8-1.5/8	900	3,200	1	15216	82,00
90 x 36	M 45-52	BSW 1.3/4-2"	900	3,000	1	15217	82,00
105 x 22	Mf 54-63	G 1.3/4-2"	975	3,500	1	15218	98,00
105 x 36	M 54-63	BSW 2.1/4"-2.1/2"	975	3,500	1	15219	98,00
120 x 22	Mf 64-71	G 2.1/4-2.3/4	956	3,170	1	15220	280,00
120 x 36	M 64-71	BSW 2.3/4"	956	3,910	1	15221	280,00
130 x 25		G 3"	966	3,505	1	15222	350,00
130 x 36			966	4,025	1	15223	350,00
140 x 22			976	3,620	1	15224	450,00
150 x 25		G 3.1/2"	986	3,950	1	15226	495,00
160 x 25		G 4"	996	4,115	1	15228	680,00

Adjustable Tap Wrenches
DIN 1814 Zinc die cast

Giramaschi regolabili
DIN 1814, lega leggera

No.	for Taps			Square mm	Length mm	Weight kg		Art.-No.	€//Piece
0	M 1-8	1/16-1/4		2.0-5.0	130	0,050	5	13000	3,80
1	M 1-10	1/16-3/8	G 1/8	2.0-6.3	176	0,095	5	13010	4,00
1.1/2	M 1-12	1/16-1/2	G 1/8	2.1-8.0	176	0,120	5	13015	4,00
2	M 4-12	5/32-1/2	G 1/8	3.0-9.0	280	0,285	5	13020	6,60
3	M 5-20	7/32-3/4	G 1/8-1/2	4.9-12	380	0,660	1	13030	13,00
4	M 11-27	7/16-1"	G 1/4-3/4	5.5-16	505	1,500	1	13040	24,50
5 L	M 13-32	1/2 -1.1/4	G 1/4-1"	7-20	700	1,800	1	13050	34,00

Adjustable Tap Wrenches
DIN 1814, STEEL

Giramaschi regolabili
DIN 1814, esecuzione acciaio

No.	for Taps			Square mm	Length mm	Weight kg		Art.-No.	€//Piece
0	M 1-8	1/16-1/4		2.0-5.0	130	0,050	5	14000	6,20
1	M 1-10	1/16-3/8		2.0-6.3	176	0,106	5	14010	6,60
1.1/2	M 1-12	1/16-1/2	G 1/8	2.1-8.0	176	0,104	5	14015	6,60
2	M 4-12	5/32-1/2	G 1/8	3.0-9.0	280	0,300	5	14020	12,80
3	M 5-20	7/32-3/4	G 1/8-1/2	4.9-12	380	0,700	1	14030	23,10
4	M 11-27	7/16-1"	G 1/4-3/4	5.5-16	500	1,410	1	14040	40,00
5	M 13-32	1/2-1.1/4	G 1/4-1"	7-20	700	1,650	1	14050	50,00
6	M 18-42	3/4-1.1/2	G 1/2-1.1/4	11-24	1000	3,250	1	14060	85,00
7	M 27-52	1.1/8-2"	G 3/4-1.3/4	16-32	1250	3,700	1	14070	95,00
8	M 27-64	1.1/8"-3"	G 3/4-3"	16-40	1250	9,100	1	14080	230,00
9	M 39-110		G 1 1/4-4"	22-50	1300	10,260	1	14090	295,00

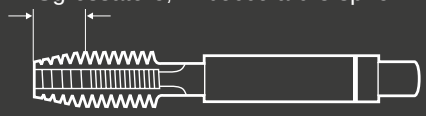
Tap Extensions
DIN 377, Squares according to DIN 10

Prolunghe per maschi
DIN 377, Quadro in base a DIN 10

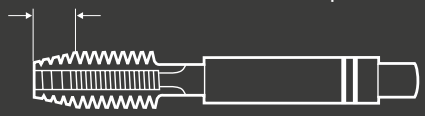
Square mm	L1	for DIN 352	Art.-No.	€//Piece
2.1	60	M 1-2.6	14521	3,00
2.4	70		14524	3,00
2.7	80	M 3	14527	3,00
3.0	90	M 3.5	14530	3,00
3.4	95	M 4	14534	3,00
3.8	100		14538	3,60
4.3	105		14543	4,20
4.9	110	M 4.5-8	14549	3,40
5.5	115	M 9-10	14555	3,80
6.2	120	M 11	14562	4,10
7.0	125	M 12	14570	5,10
8.0	125		14580	6,30
9.0	130	M 14-16	14590	7,00
10.0	140		14610	9,20
11.0	150	M 18	14611	11,00
12.0	155	M 20	14612	14,40
13.0	165		14613	16,30
14.5	175	M 22-24	14614	20,00
16.0	180	M 27	14616	21,00
18.0	200	M 30	14618	24,70
20.0	220	M 33	14620	32,00
22.0	220	M 36	14622	44,10
24.0	235	M 39-42	14624	58,00
26.0	250		14626	75,00
29.0	265	M 45-48	14629	88,00
32.0	285	M 52	14632	125,00

HAND TAPS
MASCHI A MANO

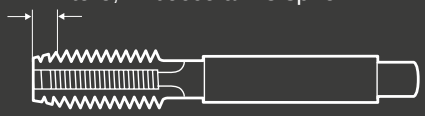
Nr. 1
Rougher, 6-8 Threads Lead
Sgrossatore, Imbocco a 6-8 spire



Nr. 2
Intermediate, 4-5 Threads Lead
Intermedio, Imbocco a 4-5 spire

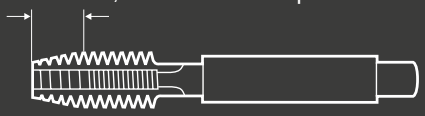


Nr. 3
Finisher, 2-3 Threads Lead
Finitore, Imbocco a 2-3 spire

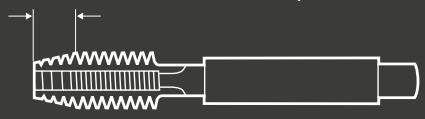


NON-SERIAL FORM
VERSIONE CONICA

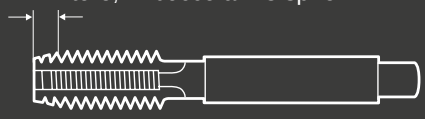
Nr. 1 - Form A
Finisher, 6-8 Threads Lead
Finitore, Imbocco a 6-8 spire



Nr. 2 - Form D
Finisher, 4-5 Threads Lead
Finitore, Imbocco a 4-5 spire



Nr. 3 - Form C
Finisher, 2-3 Threads Lead
Finitore, Imbocco a 2-3 spire



HAND TAPS
MASCHI A MANO

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

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

Applicazione HSS-G:
- e per uso universale
- Materiali con buona truciodibilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati

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

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

Hand Taps
metric ISO-thread DIN 13

Maschi a mano
filettatura metrica ISO DIN 13

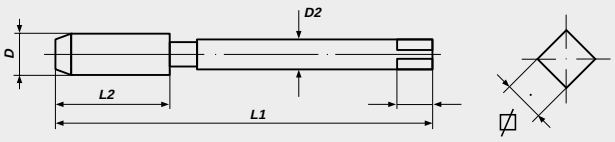
DIN 352 HSS-G Tol. ISO2/6H

M

Nominal Diameter D		L 1	L 2	D 2	⌀	Art.-No.	€	€
M	1 x 0.25	32	5.5	2.5	2.1	27302	6,00	18,00
M	1.1 x 0.25	32	5.5	2.5	2.1	27304	6,00	18,00
M	1.2 x 0.25	32	5.5	2.5	2.1	27306	6,00	18,00
M	1.4 x 0.3	32	7.0	2.5	2.1	27308	6,00	18,00
M	1.6 x 0.35	32	8.0	2.5	2.1	27310	6,00	18,00
M	1.7 x 0.35	32	8.0	2.5	2.1	27312	6,00	18,00
M	1.8 x 0.35	32	8.0	2.5	2.1	27314	6,00	18,00
M	2 x 0.4	36	8.0	2.8	2.1	27316	4,40	13,20
M	2.2 x 0.45	36	9.0	2.8	2.1	27318	4,40	13,20
M	2.3 x 0.4	36	9.0	2.8	2.1	27320	4,40	13,20
M	2.5 x 0.45	40	9.0	2.8	2.1	27322	4,40	13,20
M	2.6 x 0.45	40	9.0	2.8	2.1	27324	4,40	13,20
M	3 x 0.5	40	11.0	3.5	2.7	27326	2,30	6,90
M	3.5 x 0.6	45	13.0	4.0	3.0	27328	3,40	10,20
M	4 x 0.7	45	13.0	4.5	3.4	27330	2,30	6,90
M	4.5 x 0.75	50	16.0	6.0	4.9	27332	3,40	10,20
M	5 x 0.8	50	16.0	6.0	4.9	27334	2,50	7,50
M	5.5 x 0.9	50	18.0	6.0	4.9	27336	4,10	12,30
M	6 x 1.0	50	19.0	6.0	4.9	27338	2,50	7,50
M	7 x 1.0	50	19.0	6.0	4.9	27340	4,10	12,30
M	8 x 1.25	56	22.0	6.0	4.9	27342	3,20	9,60
M	9 x 1.25	63	22.0	7.0	5.5	27344	5,50	16,50
M	10 x 1.5	70	24.0	7.0	5.5	27346	4,30	12,90
M	11 x 1.5	70	24.0	8.0	6.2	27348	7,00	21,00
M	12 x 1.75	75	29.0	9.0	7.0	27350	5,60	16,80
M	14 x 2.0	80	30.0	11.0	9.0	27354	6,40	19,20
M	15 x 2.0	80	32.0	12.0	9.0	27356	7,60	22,80
M	16 x 2.0	80	32.0	12.0	9.0	27358	8,00	24,00
M	18 x 2.5	95	40.0	14.0	11.0	27362	10,50	31,50
M	20 x 2.5	95	40.0	16.0	12.0	27366	12,00	36,00
M	22 x 2.5	100	40.0	18.0	14.5	27370	15,00	45,00
M	24 x 3.0	110	50.0	18.0	14.5	27374	18,00	54,00
M	27 x 3.0	110	50.0	20.0	16.0	27376	28,00	84,00
M	30 x 3.5	125	56.0	22.0	18.0	27378	38,00	114,00
M	33 x 3.5	125	56.0	25.0	20.0	27380	49,00	147,00
M	36 x 4.0	150	63.0	28.0	22.0	27382	59,00	177,00
M	39 x 4.0	150	63.0	32.0	24.0	27384	76,00	228,00
M	42 x 4.5	150	63.0	32.0	24.0	27386	85,00	255,00
M	45 x 4.5	160	70.0	36.0	29.0	27388	103,00	309,00
M	48 x 5.0	180	75.0	36.0	29.0	27390	146,00	438,00
M	52 x 5.0	180	75.0	40.0	32.0	27392	146,00	438,00
M	56 x 5.5	200	85.0	45.0	35.0	27394	185,00	555,00
M	60 x 5.5	200	85.0	45.0	35.0	27396	252,00	756,00
M	64 x 6.0	220	90.0	50.0	39.0	27398	280,00	840,00
M	68 x 6.0	220	90.0	50.0	39.0	27399	350,00	1.050,00

How to order / esempio come ordinare:

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



Hand Taps
metric ISO-thread DIN 13

Maschi a mano
filettatura metrica ISO DIN 13

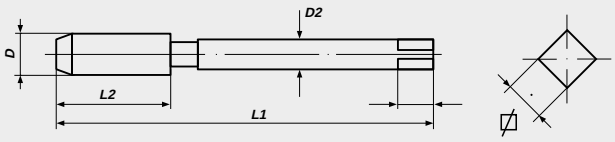
DIN 352 HSS-G Tol. ISO2/6H

M

Nominal Diameter D		L 1	L 2	D 2	⧄	Art.-No.	€	€
M	72 x 6.0	240	80.0	50.0	39.0	28130	420,00	1.260,00
M	76 x 6.0	240	80.0	50.0	39.0	28131	770,00	2.310,00
M	80 x 6.0	260	85.0	50.0	39.0	28132	850,00	2.550,00
M	84 x 6.0	260	85.0	50.0	39.0	28133	980,00	2.940,00
M	88 x 6.0	260	85.0	50.0	39.0	28134	1.300,00	3.900,00
M	90 x 6.0	260	85.0	50.0	39.0	28135	1.400,00	4.200,00
M	92 x 6.0	280	90.0	56.0	44.0	28136	1.500,00	4.500,00
M	96 x 6.0	280	90.0	56.0	44.0	28137	1.700,00	5.100,00
M	100 x 6.0	280	90.0	56.0	44.0	28138	1.900,00	5.700,00

How to order / esempio come ordinare:

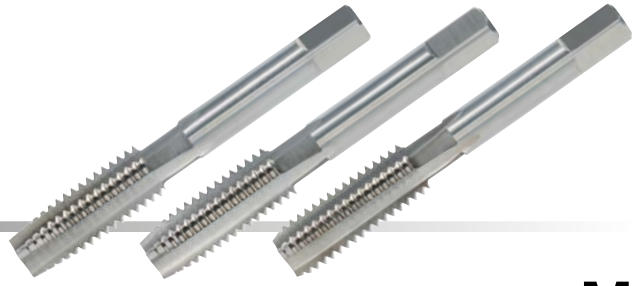
M3	=	27326
M3, No. 1	=	27326-1
M3, No. 2	=	27326-2
M3, No. 3	=	27326-3



VÖLKEL
THREADING SOLUTIONS

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

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



DIN 352 HSS-G Tol. ISO2/6H

M

Nominal Diameter D		L 1	L 2	D 2	⊠	Art.-No.	€	€
M	2 x 0.4	36	8	2.8	2.1	27616	4,40	13,20
M	2.5 x 0.45	40	9	2.8	2.1	27622	4,40	13,20
M	3 x 0.5	40	11	3.5	2.7	27626	2,30	6,90
M	4 x 0.7	45	13	4.5	3.4	27630	2,30	6,90
M	5 x 0.8	50	16	6.0	4.9	27634	2,50	7,50
M	6 x 1.0	50	19	6.0	4.9	27638	2,50	7,50
M	8 x 1.25	56	22	6.0	4.9	27642	3,20	9,60
M	9 x 1.25	63	22	7.0	5.5	27644	5,50	16,50
M	10 x 1.5	70	24	7.0	5.5	27646	4,30	12,90
M	11 x 1.5	70	24	8.0	6.2	27648	7,00	21,00
M	12 x 1.75	75	29	9.0	7.0	27650	5,60	16,80
M	13 x 1.75	75	29	9.0	7.0	27652	7,80	23,40
M	14 x 2.0	80	30	11.0	9.0	27654	6,40	19,20
M	16 x 2.0	80	32	12.0	9.0	27658	8,00	24,00
M	18 x 2.5	95	40	14.0	11.0	27662	10,50	31,50
M	19 x 2.5	95	40	14.0	11.0	27664	14,50	43,50
M	20 x 2.5	95	40	16.0	12.0	27666	12,00	36,00
M	22 x 2.5	100	40	18.0	14.5	27670	15,00	45,00
M	24 x 3.0	110	50	18.0	14.5	27674	18,00	54,00
M	27 x 3.0	110	50	20.0	16.0	27676	28,00	84,00
M	30 x 3.5	125	56	22.0	18.0	27678	38,00	114,00
M	33 x 3.5	125	56	25.0	20.0	27680	49,00	147,00
M	36 x 4.0	150	63	28.0	22.0	27682	59,00	177,00
M	39 x 4.0	150	63	32.0	24.0	27684	76,00	228,00
M	42 x 4.5	150	63	32.0	24.0	27686	85,00	255,00
M	3 x 0.6	40	11	3.5	2.7	27627	4,40	13,20
M	4 x 0.75	45	13	4.5	3.4	27631	4,40	13,20
M	5 x 0.9	50	16	6.0	4.9	27635	4,50	13,50

Application:

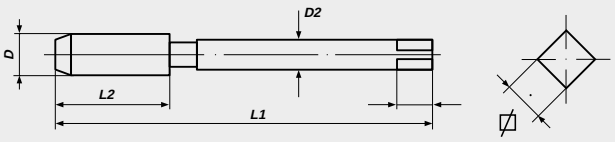
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

Applicazione:

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

How to order / esempio come ordinare:

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



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

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

ISO 529 HSS-G Tol. ISO2/6H

M

Nominal Diameter D	L 1	L 2	D 2	⊡	Art.-No.	€	€
M 3 x 0.5	48	11	3.15	2.5	80426	2,70	8,10
M 4 x 0.7	53	13	4.0	3.15	80430	2,70	8,10
M 5 x 0.8	58	16	5.0	4.0	80434	3,00	9,00
M 6 x 1.0	66	19	6.3	5.0	80438	3,00	9,00
M 8 x 1.25	72	22	8.0	6.3	80442	4,00	12,00
M 10 x 1.5	80	24	10.0	8.0	80446	5,50	16,50
M 12 x 1.75	89	29	9.0	7.1	80450	7,00	21,00
M 14 x 2.0	95	30	11.2	9.0	80454	7,70	23,10
M 16 x 2.0	102	32	12.5	10.0	80458	10,00	30,00
M 18 x 2.5	110	37	14.0	11.2	80462	14,00	42,00
M 20 x 2.5	112	37	14.0	11.2	80466	15,50	46,50
M 22 x 2.5	118	38	16.0	12.5	80470	17,80	53,40
M 24 x 3.0	130	45	18.0	14.0	80474	22,00	66,00

Application:

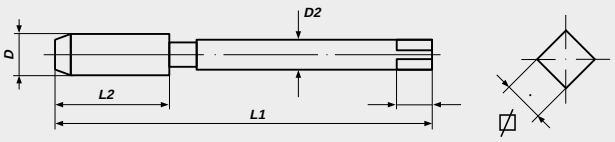
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

Applicazione:

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

How to order / esempio come ordinare:

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



VÖLKEL
THREADING SOLUTIONS

Hand Taps
metric-fine ISO-thread DIN 13

Maschi a mano
filettatura metrica fine ISO DIN 13

DIN 2181 HSS-G Tol. ISO2/6H

Mf

Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€	€
M 2.5 x 0.35	40	9	2.8	2.1	26304	6,70	13,40
M 2.6 x 0.35	40	9	2.8	2.1	26305	6,70	13,40
M 3 x 0.35	40	9	3.5	2.7	26308	6,70	13,40
M 3.5 x 0.35	45	10	4.0	3.0	26309	6,70	13,40
M 4 x 0.35	45	10	4.5	3.4	26310	6,70	13,40
M 4 x 0.5	45	10	4.5	3.4	26312	6,70	13,40
M 4.5 x 0.5	50	12	6.0	4.9	26313	6,70	13,40
M 5 x 0.5	50	12	6.0	4.9	26314	6,70	13,40
M 5 x 0.75	50	12	6.0	4.9	26316	6,70	13,40
M 5.5 x 0.5	50	12	6.0	4.9	26315	6,70	13,40
M 6 x 0.5	50	14	6.0	4.9	26317	6,70	13,40
M 6 x 0.75	50	14	6.0	4.9	26318	6,00	12,00
M 7 x 0.5	50	14	6.0	4.9	26319	6,00	12,00
M 7 x 0.75	50	14	6.0	4.9	26320	6,00	12,00
M 8 x 0.5	50	19	6.0	4.9	26322	6,00	12,00
M 8 x 0.75	50	19	6.0	4.9	26324	6,00	12,00
M 8 x 1.0	56	22	6.0	4.9	26326	6,00	12,00
M 9 x 0.5	56	19	7.0	5.5	26327	6,70	13,40
M 9 x 0.75	56	19	7.0	5.5	26328	6,70	13,40
M 9 x 1.0	63	20	7.0	5.5	26330	6,70	13,40
M 10 x 0.5	63	20	7.0	5.5	26331	6,70	13,40
M 10 x 0.75	63	20	7.0	5.5	26332	6,70	13,40
M 10 x 1.0	63	20	7.0	5.5	26336	6,00	12,00
M 10 x 1.25	70	24	7.0	5.5	26338	6,70	13,40
M 11 x 0.75	63	20	8.0	6.2	26339	8,70	17,40
M 11 x 1.0	63	20	8.0	6.2	26340	8,70	17,40
M 11 x 1.25	63	22	8.0	6.2	26342	8,70	17,40
M 12 x 0.5	70	22	9.0	7.0	26345	8,70	17,40
M 12 x 0.75	70	22	9.0	7.0	26343	8,70	17,40
M 12 x 1.0	70	22	9.0	7.0	26344	8,70	17,40
M 12 x 1.25	70	22	9.0	7.0	26346	8,70	17,40
M 12 x 1.5	70	22	9.0	7.0	26348	7,90	15,80
M 13 x 0.5	70	22	11.0	9.0	26347	13,30	26,60
M 13 x 0.75	70	22	11.0	9.0	26349	13,30	26,60
M 13 x 1.0	70	22	11.0	9.0	26350	13,30	26,60
M 13 x 1.5	70	22	11.0	9.0	26351	13,30	26,60
M 14 x 0.5	70	22	11.0	9.0	26355	13,30	26,60

►►►

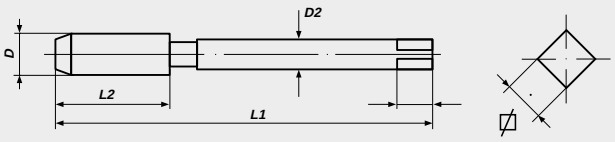
Application:

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

Applicazione:

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

How to order / esempio come ordinare:
M3 x 0.35 = 26308
M3 x 0.35, No. 1 = 26308-1
M3 x 0.35, No. 2 = 26308-2



Hand Taps
metric-fine ISO-thread DIN 13

Maschi a mano
filettatura metrica fine ISO DIN 13

DIN 2181 HSS-G Tol. ISO2/6H

Mf

Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€	€
M 14 x 0.75	70	22	11.0	9.0	26352	13,30	26,60
M 14 x 1.0	70	22	11.0	9.0	26353	13,30	26,60
M 14 x 1.25	70	22	11.0	9.0	26354	10,00	20,00
M 14 x 1.5	70	22	11.0	9.0	26356	8,60	17,20
M 15 x 0.75	70	22	12.0	9.0	26357	14,70	29,40
M 15 x 1.0	70	22	12.0	9.0	26358	14,70	29,40
M 15 x 1.5	70	22	12.0	9.0	26360	14,70	29,40
M 16 x 0.5	70	22	12.0	9.0	26361	14,70	29,40
M 16 x 0.75	70	22	12.0	9.0	26363	14,70	29,40
M 16 x 1.0	70	22	12.0	9.0	26362	14,70	29,40
M 16 x 1.25	70	22	12.0	9.0	26364	14,70	29,40
M 16 x 1.5	70	22	12.0	9.0	26366	10,50	21,00
M 17 x 1.0	70	22	12.0	9.0	26368	16,10	32,20
M 17 x 1.5	70	22	12.0	9.0	26369	16,10	32,20
M 18 x 0.5	80	22	14.0	11.0	26367	16,10	32,20
M 18 x 0.75	80	22	14.0	11.0	26373	16,10	32,20
M 18 x 1.0	80	22	14.0	11.0	26370	16,10	32,20
M 18 x 1.25	80	22	14.0	11.0	26371	16,10	32,20
M 18 x 1.5	80	22	14.0	11.0	26372	12,10	24,20
M 18 x 2.0	80	22	14.0	11.0	26374	16,10	32,20
M 19 x 1.0	80	22	14.0	11.0	26375	20,20	40,40
M 19 x 1.5	80	22	14.0	11.0	26376	20,20	40,40
M 20 x 0.5	80	22	16.0	12.0	26377	20,20	40,40
M 20 x 0.75	80	22	16.0	12.0	26379	20,20	40,40
M 20 x 1.0	80	22	16.0	12.0	26378	20,20	40,40
M 20 x 1.25	80	22	16.0	12.0	26380	20,20	40,40
M 20 x 1.5	80	22	16.0	12.0	26384	14,70	29,40
M 20 x 2.0	80	22	16.0	12.0	26386	20,20	40,40
M 21 x 1.0	80	22	16.0	12.0	26387	20,90	41,80
M 21 x 1.5	80	22	16.0	12.0	26388	20,90	41,80
M 22 x 0.5	80	22	18.0	14.5	26389	20,90	41,80
M 22 x 0.75	80	22	18.0	14.5	26391	20,90	41,80
M 22 x 1.0	80	22	18.0	14.5	26390	20,90	41,80
M 22 x 1.25	80	22	18.0	14.5	26392	20,90	41,80
M 22 x 1.5	80	22	18.0	14.5	26394	20,90	41,80
M 22 x 2.0	80	22	18.0	14.5	26396	20,90	41,80
M 23 x 1.0	80	22	18.0	14.5	26397	28,00	56,00
M 23 x 1.5	80	22	18.0	14.5	26398	28,00	56,00
M 24 x 0.5	90	22	18.0	14.5	26501	28,00	56,00
M 24 x 0.75	90	22	18.0	14.5	26503	28,00	56,00
M 24 x 1.0	90	22	18.0	14.5	26500	28,00	56,00
M 24 x 1.25	90	22	18.0	14.5	26502	28,00	56,00
M 24 x 1.5	90	22	18.0	14.5	26504	22,00	44,00
M 24 x 2.0	90	22	18.0	14.5	26506	28,00	56,00
M 25 x 1.0	90	22	18.0	14.5	26507	41,00	82,00
M 25 x 1.5	90	22	18.0	14.5	26508	41,00	82,00
M 26 x 1.0	90	22	18.0	14.5	26510	41,00	82,00
M 26 x 1.5	90	22	18.0	14.5	26512	41,00	82,00
M 26 x 2.0	90	22	18.0	14.5	26514	41,00	82,00
M 27 x 1.0	90	22	20.0	16.0	26516	41,00	82,00

VÖLKEL THREADING SOLUTIONS

Hand Taps
metric-fine ISO-thread DIN 13

Maschi a mano
filettatura metrica fine ISO DIN 13

DIN 2181 HSS-G Tol. ISO2/6H

Mf

Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€	€
M 27 x 1.5	90	22	20.0	16.0	26517	41,00	82,00
M 27 x 2.0	90	22	20.0	16.0	26518	48,50	97,00
M 28 x 1.0	90	22	20.0	16.0	26520	48,50	97,00
M 28 x 1.5	90	22	20.0	16.0	26522	48,50	97,00
M 28 x 2.0	90	22	20.0	16.0	26524	48,50	97,00
M 29 x 1.5	90	22	22.0	18.0	26526	48,50	97,00
M 30 x 1.0	90	22	22.0	18.0	26528	57,00	114,00
M 30 x 1.5	90	22	22.0	18.0	26530	57,00	114,00
M 30 x 2.0	90	22	22.0	18.0	26532	57,00	114,00
M 30 x 2.5	125	56	22.0	18.0	26533	57,00	114,00
M 30 x 3.0	125	56	22.0	18.0	26534	57,00	114,00
M 32 x 1.0	90	22	22.0	18.0	26539	57,00	114,00
M 32 x 1.5	90	22	22.0	18.0	26536	57,00	114,00
M 32 x 2.0	90	22	22.0	18.0	26535	57,00	114,00
M 32 x 3.0	125	56	22.0	18.0	26537	57,00	114,00
M 33 x 1.5	100	25	25.0	20.0	26538	57,00	114,00
M 33 x 2.0	100	25	25.0	20.0	26540	70,00	140,00
M 33 x 3.0	125	56	25.0	20.0	26542	70,00	140,00
M 34 x 1.0	100	25	28.0	22.0	26543	70,00	140,00
M 34 x 1.5	100	25	28.0	22.0	26544	70,00	140,00
M 34 x 2.0	125	40	28.0	22.0	26546	70,00	140,00
M 35 x 1.0	100	25	28.0	22.0	26547	70,00	140,00
M 35 x 1.5	100	25	28.0	22.0	26548	70,00	140,00
M 35 x 2.0	125	40	28.0	22.0	26549	70,00	140,00
M 36 x 1.0	100	25	28.0	22.0	26551	73,00	146,00
M 36 x 1.5	100	25	28.0	22.0	26550	73,00	146,00
M 36 x 2.0	125	40	28.0	22.0	26552	73,00	146,00
M 36 x 3.0	125	40	28.0	22.0	26554	73,00	146,00
M 37 x 1.5	100	25	28.0	22.0	26553	91,00	182,00
M 38 x 1.0	100	25	28.0	22.0	26555	91,00	182,00
M 38 x 1.5	100	25	28.0	22.0	26556	91,00	182,00
M 38 x 2.0	125	40	28.0	22.0	26557	91,00	182,00
M 38 x 3.0	125	40	28.0	22.0	26559	91,00	182,00
M 39 x 1.5	110	25	32.0	24.0	26558	91,00	182,00
M 39 x 2.0	125	40	32.0	24.0	26560	91,00	182,00
M 39 x 3.0	125	40	32.0	24.0	26562	91,00	182,00
M 40 x 1.0	110	25	32.0	24.0	26563	91,00	182,00
M 40 x 1.5	110	25	32.0	24.0	26564	91,00	182,00
M 40 x 2.0	125	40	32.0	24.0	26566	91,00	182,00
M 40 x 3.0	125	40	32.0	24.0	26568	91,00	182,00
M 42 x 1.0	110	25	32.0	24.0	26569	91,00	182,00
M 42 x 1.5	110	25	32.0	24.0	26570	91,00	182,00
M 42 x 2.0	125	40	32.0	24.0	26572	95,00	190,00
M 42 x 3.0	125	40	32.0	24.0	26574	95,00	190,00
M 44 x 1.5	110	25	36.0	29.0	26571	107,00	214,00
M 44 x 2.0	125	40	36.0	29.0	26573	107,00	214,00
M 45 x 1.0	110	25	36.0	29.0	26575	107,00	214,00
M 45 x 1.5	110	25	36.0	29.0	26576	107,00	214,00
M 45 x 2.0	125	40	36.0	29.0	26578	107,00	214,00
M 45 x 3.0	125	40	36.0	29.0	26580	107,00	214,00

Hand Taps
metric-fine ISO-thread DIN 13

Maschi a mano
filettatura metrica fine ISO DIN 13

DIN 2181 HSS-G Tol. ISO2/6H

Mf

Nominal Diameter D	L 1	L 2	D 2	⌀	Art.-No.	€	€
M 46 x 1.5	140	40	36	29.0	26581	107,00	214,00
M 48 x 1.0	140	40	36	29.0	26583	128,00	256,00
M 48 x 1.5	140	40	36	29.0	26582	128,00	256,00
M 48 x 2.0	140	40	36	29.0	26584	128,00	256,00
M 48 x 3.0	140	40	36	29.0	26586	128,00	256,00
M 50 x 1.5	140	40	36	29.0	26588	140,00	280,00
M 50 x 2.0	140	40	36	29.0	26590	140,00	280,00
M 50 x 3.0	140	40	36	29.0	26592	140,00	280,00
M 52 x 1.5	140	40	40	32.0	26594	168,00	336,00
M 52 x 2.0	140	40	40	32.0	26596	168,00	336,00
M 52 x 3.0	140	40	40	32.0	26598	168,00	336,00
M 54 x 1.0	140	32	40	32.0	28118	182,00	364,00
M 54 x 1.5	140	32	40	32.0	28001	182,00	364,00
M 54 x 2.0	140	36	40	32.0	28002	182,00	364,00
M 54 x 3.0	140	40	40	32.0	28003	182,00	364,00
M 54 x 4.0	180	50	40	32.0	28004	182,00	364,00
M 55 x 1.5	140	32	40	32.0	28005	208,00	416,00
M 55 x 2.0	140	36	40	32.0	28006	208,00	416,00
M 55 x 3.0	140	40	40	32.0	28007	208,00	416,00
M 55 x 4.0	180	50	40	32.0	28008	208,00	416,00
M 56 x 1.0	140	32	40	32.0	28119	231,00	462,00
M 56 x 1.5	140	32	40	32.0	28009	234,00	468,00
M 56 x 2.0	140	36	40	32.0	28010	234,00	468,00
M 56 x 3.0	140	40	40	32.0	28011	234,00	468,00
M 56 x 4.0	180	50	40	32.0	28012	234,00	468,00
M 58 x 1.0	160	32	45	35.0	28120	250,00	500,00
M 58 x 1.5	160	32	45	35.0	28013	238,00	476,00
M 58 x 2.0	160	36	45	35.0	28014	238,00	476,00
M 58 x 3.0	160	40	45	35.0	28015	238,00	476,00
M 58 x 4.0	200	55	45	35.0	28016	238,00	476,00
M 60 x 1.5	160	34	45	35.0	28017	249,00	498,00
M 60 x 2.0	160	36	45	35.0	28018	249,00	498,00
M 60 x 3.0	160	40	45	35.0	28019	249,00	498,00
M 60 x 4.0	200	55	45	35.0	28020	249,00	498,00
M 62 x 1.5	160	34	50	39.0	28021	285,00	570,00
M 62 x 2.0	160	36	50	39.0	28022	285,00	570,00
M 62 x 3.0	180	45	50	39.0	28023	285,00	570,00
M 62 x 4.0	220	55	50	39.0	28024	285,00	570,00
M 63 x 1.5	160	32	50	39.0	28025	293,00	586,00
M 64 x 1.5	160	34	50	39.0	28026	293,00	586,00
M 64 x 2.0	160	36	50	39.0	28027	293,00	586,00
M 64 x 3.0	180	45	50	39.0	28028	293,00	586,00
M 64 x 4.0	220	60	50	39.0	28029	298,00	596,00
M 65 x 1.5	160	34	50	39.0	28030	310,00	620,00
M 65 x 2.0	160	36	50	39.0	28031	310,00	620,00
M 65 x 3.0	180	45	50	39.0	28032	310,00	620,00
M 65 x 4.0	220	60	50	39.0	28033	310,00	620,00
M 68 x 1.5	160	36	50	39.0	28034	320,00	640,00
M 68 x 2.0	160	40	50	39.0	28035	320,00	640,00
M 68 x 3.0	180	50	50	39.0	28036	320,00	640,00

VÖLKEL
THREADING SOLUTIONS

Hand Taps
metric-fine ISO-thread DIN 13

Maschi a mano
filettatura metrica fine ISO DIN 13

DIN 2181 HSS-G Tol. ISO2/6H

Mf

Nominal Diameter D	L 1	L 2	D 2	⌀	Art.-No.	€	€
M 68 x 4.0	220	60	50	39.0	28037	320,00	640,00
M 70 x 1.5	160	36	50	39.0	28038	560,00	1.120,00
M 70 x 2.0	160	40	50	39.0	28039	560,00	1.120,00
M 70 x 3.0	200	50	50	39.0	28040	635,00	1.270,00
M 70 x 4.0	240	60	50	39.0	28041	635,00	1.270,00
M 72 x 1.5	160	36	50	39.0	28042	560,00	1.120,00
M 72 x 2.0	160	40	50	39.0	28043	560,00	1.120,00
M 72 x 3.0	200	50	50	39.0	28044	635,00	1.270,00
M 72 x 4.0	240	60	50	39.0	28045	635,00	1.270,00
M 74 x 1.5	160	36	50	39.0	28046	620,00	1.240,00
M 74 x 2.0	160	40	50	39.0	28047	620,00	1.240,00
M 74 x 3.0	200	50	50	39.0	28048	730,00	1.460,00
M 74 x 4.0	240	60	50	39.0	28049	730,00	1.460,00
M 75 x 1.5	160	36	50	39.0	28050	625,00	1.250,00
M 75 x 2.0	160	40	50	39.0	28051	625,00	1.250,00
M 75 x 3.0	200	50	50	39.0	28052	735,00	1.470,00
M 75 x 4.0	240	60	50	39.0	28053	735,00	1.470,00
M 76 x 1.5	160	36	50	39.0	28054	635,00	1.270,00
M 76 x 2.0	160	40	50	39.0	28055	635,00	1.270,00
M 76 x 3.0	220	50	50	39.0	28056	785,00	1.570,00
M 76 x 4.0	260	60	50	39.0	28057	785,00	1.570,00
M 78 x 1.5	160	36	50	39.0	28058	635,00	1.270,00
M 78 x 2.0	160	40	50	39.0	28059	635,00	1.270,00
M 78 x 3.0	220	55	50	39.0	28060	785,00	1.570,00
M 78 x 4.0	260	65	50	39.0	28061	785,00	1.570,00
M 80 x 1.5	160	36	50	39.0	28062	690,00	1.380,00
M 80 x 2.0	160	40	50	39.0	28063	690,00	1.380,00
M 80 x 3.0	220	55	50	39.0	28064	860,00	1.720,00
M 80 x 4.0	260	65	50	39.0	28065	860,00	1.720,00
M 82 x 1.5	160	36	50	39.0	28066	690,00	1.380,00
M 82 x 2.0	160	40	50	39.0	28067	690,00	1.380,00
M 82 x 3.0	220	55	50	39.0	28068	860,00	1.720,00
M 82 x 4.0	260	65	50	39.0	28069	860,00	1.720,00
M 84 x 1.5	160	36	50	39.0	28070	805,00	1.610,00
M 84 x 2.0	160	40	50	39.0	28071	805,00	1.610,00
M 84 x 3.0	220	55	50	39.0	28072	972,00	1.944,00
M 84 x 4.0	260	65	50	39.0	28073	972,00	1.944,00
M 85 x 1.5	160	36	50	39.0	28074	1.050,00	2.100,00
M 85 x 2.0	160	40	50	39.0	28075	1.050,00	2.100,00
M 85 x 3.0	220	55	50	39.0	28076	1.300,00	2.600,00
M 85 x 4.0	260	65	50	39.0	28077	1.300,00	2.600,00
M 86 x 1.5	160	36	50	39.0	28078	1.050,00	2.100,00
M 86 x 2.0	160	40	50	39.0	28079	1.050,00	2.100,00
M 86 x 3.0	220	55	50	39.0	28080	1.280,00	2.560,00
M 86 x 4.0	260	65	50	39.0	28081	1.280,00	2.560,00
M 88 x 1.5	160	38	50	39.0	28082	1.150,00	2.300,00
M 88 x 2.0	160	40	50	39.0	28083	1.150,00	2.300,00
M 88 x 3.0	220	55	50	39.0	28084	1.320,00	2.640,00
M 88 x 4.0	260	65	50	39.0	28085	1.320,00	2.640,00
M 90 x 1.5	160	38	50	39.0	28086	1.200,00	2.400,00

Hand Taps
metric-fine ISO-thread DIN 13

Maschi a mano
filettatura metrica fine ISO DIN 13

DIN 2181 HSS-G Tol. ISO2/6H

Mf

Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€	€
M 90 x 2.0	160	40	50	39.0	28087	1.180,00	2.360,00
M 90 x 3.0	220	55	50	39.0	28088	1.410,00	2.820,00
M 90 x 4.0	260	65	50	39.0	28089	1.410,00	2.820,00
M 92 x 1.5	180	40	56	44.0	28090	1.200,00	2.400,00
M 92 x 2.0	180	45	56	44.0	28091	1.200,00	2.400,00
M 92 x 3.0	240	60	56	44.0	28092	1.520,00	3.040,00
M 92 x 4.0	280	70	56	44.0	28093	1.520,00	3.040,00
M 95 x 1.5	180	40	56	44.0	28094	1.290,00	2.580,00
M 95 x 2.0	180	45	56	44.0	28095	1.290,00	2.580,00
M 95 x 3.0	240	60	56	44.0	28096	1.700,00	3.400,00
M 95 x 4.0	280	70	56	44.0	28097	1.660,00	3.320,00
M 96 x 1.5	180	40	56	44.0	28098	1.300,00	2.600,00
M 96 x 2.0	180	45	56	44.0	28099	1.300,00	2.600,00
M 96 x 3.0	240	60	56	44.0	28100	1.700,00	3.400,00
M 96 x 4.0	280	70	56	44.0	28101	1.700,00	3.400,00
M 98 x 1.5	180	40	56	44.0	28102	1.400,00	2.800,00
M 98 x 2.0	180	45	56	44.0	28103	1.400,00	2.800,00
M 98 x 3.0	240	60	56	44.0	28104	1.850,00	3.700,00
M 98 x 4.0	280	70	56	44.0	28105	1.850,00	3.700,00
M 100 x 1.5	180	45	56	44.0	28106	1.600,00	3.200,00
M 100 x 2.0	180	50	56	44.0	28107	1.600,00	3.200,00
M 100 x 3.0	240	65	56	44.0	28108	1.950,00	3.900,00
M 100 x 4.0	280	75	56	44.0	28109	1.950,00	3.900,00
M 105 x 1.5	180	45	56	44.0	28110	1.730,00	3.460,00
M 105 x 2.0	180	50	56	44.0	28111	1.730,00	3.460,00
M 105 x 3.0	240	65	56	44.0	28112	2.100,00	4.200,00
M 105 x 4.0	280	75	56	44.0	28113	2.100,00	4.200,00
M 110 x 1.5	180	45	56	44.0	28114	1.900,00	3.800,00
M 110 x 2.0	180	50	56	44.0	28115	1.900,00	3.800,00
M 110 x 3.0	240	65	56	44.0	28116	2.350,00	4.700,00
M 110 x 4.0	280	75	56	44.0	28117	2.350,00	4.700,00

VÖLKEL
THREADING SOLUTIONS

Hand Taps
Whitworth-thread BS 84

Maschi a mano
filettatura Whitworth BS 84

≈ DIN 352 HSS-G Tol. med

BSW

Nominal Diameter D		L 1	L 2	D 2	⊡	Art.-No.	€	€
BSW	1/16 x 60	36	10	2.5	2.1	22302	6,00	18,00
BSW	3/32 x 48	36	10	2.8	2.1	22304	4,80	14,40
BSW	1/8 x 40	40	12	3.5	2.7	22306	4,30	12,90
BSW	5/32 x 32	45	14	4.5	3.4	22308	4,30	12,90
BSW	3/16 x 24	50	18	6.0	4.9	22310	4,20	12,60
BSW	7/32 x 24	50	18	6.0	4.9	22312	4,20	12,60
BSW	1/4 x 20	50	19	6.0	4.9	22314	4,20	12,60
BSW	5/16 x 18	56	22	6.0	4.9	22316	4,70	14,10
BSW	3/8 x 16	70	24	7.0	5.5	22318	5,20	15,60
BSW	7/16 x 14	70	24	8.0	6.2	22320	6,60	19,80
BSW	1/2 x 12	75	29	9.0	7.0	22322	8,00	24,00
BSW	9/16 x 12	80	30	11.0	9.0	22324	10,50	31,50
BSW	5/8 x 11	80	32	12.0	9.0	22326	11,80	35,40
BSW	3/4 x 10	95	40	14.0	11.0	22330	15,80	47,40
BSW	7/8 x 9	100	40	18.0	14.5	22334	21,00	63,00
BSW	1" x 8	110	50	18.0	14.5	22338	24,20	72,60
BSW	1.1/8 x 7	132	56	22.0	18.0	22342	37,30	111,90
BSW	1.1/4 x 7	132	56	22.0	18.0	22346	42,00	126,00
BSW	1.3/8 x 6	150	63	28.0	22.0	22350	54,60	163,80
BSW	1.1/2 x 6	150	63	32.0	24.0	22354	63,00	189,00
BSW	1.5/8 x 5	160	70	32.0	24.0	22358	126,00	378,00
BSW	1.3/4 x 5	160	70	36.0	29.0	22362	126,00	378,00
BSW	1.7/8 x 4.1/2	190	80	36.0	29.0	22366	164,00	492,00
BSW	2" x 4.1/2	190	80	40.0	32.0	22370	164,00	492,00
BSW	2.1/4 x 4	220	80	45.0	35.0	22372	390,00	1.170,00
BSW	2.1/2 x 4	220	80	50.0	39.0	22374	520,00	1.560,00
BSW	2.3/4 x 3.1/2	240	80	50.0	39.0	22376	1.300,00	3.900,00
BSW	3" x 3.1/2	260	80	50.0	39.0	22378	1.600,00	4.800,00

Application:

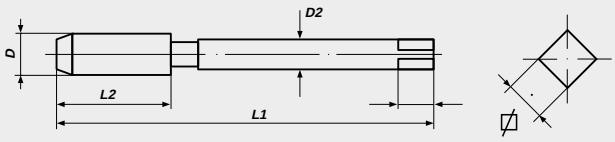
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

Applicazione:

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

How to order / esempio come ordinare:

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



Hand Taps
British-Standard-Fine-thread BS 84

Maschi a mano
filettatura Whitworth fine BS 84

≈ DIN 2181 HSS-G Tol. med

BSF

Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€	€
BSF 3/16 x 32	50	14	6.0	4.9	22710	4,20	8,40
BSF 1/4 x 26	50	18	6.0	4.9	22714	4,20	8,40
BSF 5/16 x 22	56	22	6.0	4.9	22716	4,70	9,40
BSF 3/8 x 20	63	22	7.0	5.5	22718	5,20	10,40
BSF 7/16 x 18	63	22	8.0	6.2	22720	6,60	13,20
BSF 1/2 x 16	75	24	9.0	7.0	22722	8,00	16,00
BSF 9/16 x 16	80	28	11.0	9.0	22724	10,50	21,00
BSF 5/8 x 14	80	28	12.0	9.0	22726	11,80	23,60
BSF 3/4 x 12	95	32	14.0	11.0	22730	15,80	31,60
BSF 7/8 x 11	100	36	18.0	14.5	22734	21,00	42,00
BSF 1" x 10	110	40	18.0	14.5	22738	24,20	48,40

Application:

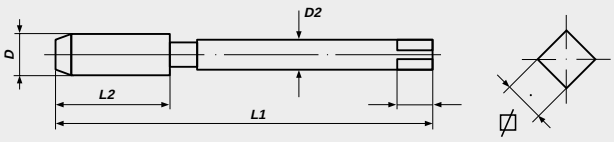
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

Applicazione:

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

How to order / esempio come ordinare:

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



VÖLKEL
THREADING SOLUTIONS

Hand Taps, *non-serial form*
BA-thread BS 93

Maschi a mano, *versione conica*
filettatura BA, BS 93

ISO 529 HSS-G Tol. med.

BA

Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€	€
BA 0	66	19	6.3	5.0	89400	5,80	17,40
BA 1	62	17	5.6	4.5	89401	5,80	17,40
BA 2	58	16	5.0	4.0	89402	5,80	17,40
BA 3	53	13	4.5	3.55	89403	5,80	17,40
BA 4	50	13	3.55	2.8	89404	5,80	17,40
BA 5	48	11	3.15	2.5	89405	5,80	17,40
BA 6	45	9.5	2.8	2.24	89406	5,80	17,40

Application:

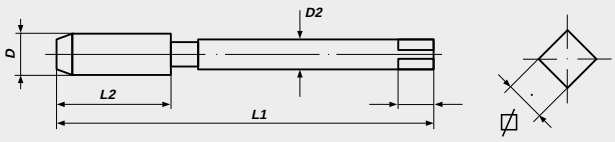
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

Applicazione:

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

How to order / esempio come ordinare:

BA 6	=	89406
BA 6, No. 1	=	89406-1
BA 6, No. 2	=	89406-2
BA 6, No. 3	=	89406-3



Hand Taps
Unified Coarse thread ANSI B 1.1

Maschi a mano
filettatura unificata, serie grossa ANSI B1.1

≈ DIN 352 HSS-G Tol. 2B

UNC

Nominal Diameter D	L 1	L 2	D 2	⊡	Art.-No.	€	€
UNC Nr. 1 x 64	32	10	2.5	2.1	23301	6,00	18,00
UNC Nr. 2 x 56	36	11	2.8	2.1	23302	6,00	18,00
UNC Nr. 3 x 48	36	11	2.8	2.1	23303	6,00	18,00
UNC Nr. 4 x 40	40	12	3.5	2.7	23304	5,00	15,00
UNC Nr. 5 x 40	40	12	3.5	2.7	23305	4,20	12,60
UNC Nr. 6 x 32	45	14	4.0	3.0	23306	4,20	12,60
UNC Nr. 8 x 32	45	14	4.5	3.4	23308	4,20	12,60
UNC Nr. 10 x 24	50	16	6.0	4.9	23310	4,20	12,60
UNC Nr. 12 x 24	50	18	6.0	4.9	23312	4,20	12,60
UNC 1/4 x 20	50	19	6.0	4.9	23314	4,20	12,60
UNC 5/16 x 18	56	22	6.0	4.9	23316	4,70	14,10
UNC 3/8 x 16	70	24	7.0	5.5	23318	5,20	15,60
UNC 7/16 x 14	70	24	8.0	6.2	23320	6,60	19,80
UNC 1/2 x 13	75	29	9.0	7.0	23322	8,00	24,00
UNC 9/16 x 12	80	30	11.0	9.0	23324	10,50	31,50
UNC 5/8 x 11	80	32	12.0	9.0	23326	11,80	35,40
UNC 3/4 x 10	95	40	14.0	11.0	23330	15,80	47,40
UNC 7/8 x 9	100	40	18.0	14.5	23334	21,00	63,00
UNC 1" x 8	110	50	18.0	14.5	23338	24,20	72,60
UNC 1.1/8 x 7	132	56	22.0	18.0	23342	37,30	111,90
UNC 1.1/4 x 7	132	56	22.0	18.0	23346	42,00	126,00
UNC 1.3/8 x 6	150	63	28.0	22.0	23350	54,60	163,80
UNC 1.1/2 x 6	150	63	32.0	24.0	23354	63,00	189,00
UNC 1.5/8 x 5	160	70	32.0	24.0	23358	126,00	378,00
UNC 1.3/4 x 5	160	70	36.0	29.0	23362	126,00	378,00
UNC 1.7/8 x 4.1/2	190	80	36.0	29.0	23366	164,00	492,00
UNC 2" x 4.1/2	190	80	40.0	32.0	23370	164,00	492,00
UNC 2.1/4 x 4.1/2	220	80	45.0	35.0	23372	390,00	1.170,00
UNC 2.1/2 x 4	220	80	50.0	39.0	23374	520,00	1.560,00
UNC 2.3/4 x 4	240	80	50.0	39.0	23376	1.300,00	3.900,00
UNC 3" x 4	260	80	50.0	39.0	23378	1.600,00	4.800,00

Application:

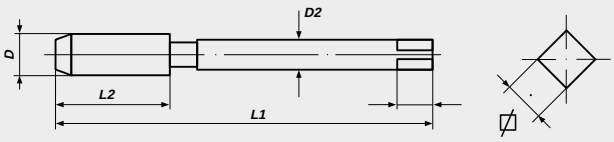
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

Applicazione:

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

How to order / esempio come ordinare:

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



VÖLKEL
THREADING SOLUTIONS

Hand Taps
Unified Fine thread ANSI B 1.1

Maschi a mano
filettatura unificata, serie fina ANSI B1.1

≈ DIN 2181 HSS-G Tol. 2B

UNF

Nominal Diameter D	L 1	L 2	D 2	⌀	Art.-No.	€	€
UNF Nr. 0 x 80	28	8	2.5	2.1	24300	6,00	12,00
UNF Nr. 1 x 72	32	9	2.8	2.1	24301	6,00	12,00
UNF Nr. 2 x 64	32	10	2.8	2.1	24302	6,00	12,00
UNF Nr. 3 x 56	32	10	2.8	2.1	24303	6,00	12,00
UNF Nr. 4 x 48	36	11	3.5	2.7	24304	5,00	10,00
UNF Nr. 5 x 44	36	11	3.5	2.7	24305	4,20	8,40
UNF Nr. 6 x 40	40	12	4.5	3.4	24306	4,20	8,40
UNF Nr. 8 x 36	40	12	4.5	3.4	24308	4,20	8,40
UNF Nr. 10 x 32	45	14	6.0	4.9	24310	4,20	8,40
UNF Nr. 12 x 28	50	14	6.0	4.9	24312	4,20	8,40
UNF 1/4 x 28	50	18	6.0	4.9	24314	4,20	8,40
UNF 5/16 x 24	56	22	6.0	4.9	24316	4,70	9,40
UNF 3/8 x 24	63	22	7.0	5.5	24318	5,20	10,40
UNF 7/16 x 20	63	22	8.0	6.2	24320	6,60	13,20
UNF 1/2 x 20	75	24	9.0	7.0	24322	8,00	16,00
UNF 9/16 x 18	80	28	11.0	9.0	24324	10,50	21,00
UNF 5/8 x 18	80	28	12.0	9.0	24326	11,80	23,60
UNF 3/4 x 16	95	32	14.0	11.0	24330	15,80	31,60
UNF 7/8 x 14	100	36	18.0	14.5	24334	21,00	42,00
UNF 1" x 12	110	40	18.0	14.5	24338	24,20	48,40
UNF 1" x 14	110	40	18.0	14.5	24340	26,20	52,40
UNF 1.1/8 x 12	110	50	22.0	18.0	24342	37,30	74,60
UNF 1.1/4 x 12	132	56	22.0	18.0	24346	42,00	84,00
UNF 1.3/8 x 12	132	56	28.0	22.0	24350	54,60	109,20
UNF 1.1/2 x 12	150	63	32.0	24.0	24354	63,00	126,00

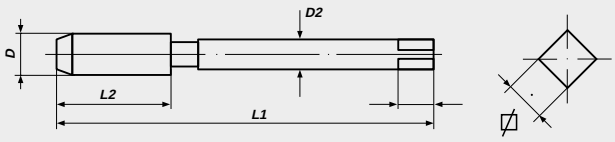
Application:

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

Applicazione:

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

How to order / esempio come ordinare:
UNF 1/4 = 24314
UNF 1/4, No. 1 = 24314-1
UNF 1/4, No. 3 = 24314-3



Hand Taps, *non-serial form*
Unified Extra Fine thread ANSI B 1.1

Maschi a mano, *versione conica*
filettatura unificata, serie extra-fina ANSI B1.1

ISO 529 HSS-G Tol. 2B

UNEF

Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€	€
UNEF 1/4 x 32	66	19	6.3	5.0	83821	4,80	14,40
UNEF 5/16 x 32	72	22	8.0	6.3	83822	5,40	16,20
UNEF 3/8 x 32	80	24	10.0	8.0	83823	6,10	18,30
UNEF 7/16 x 28	85	25	8.0	6.3	83824	7,60	22,80
UNEF 1/2 x 28	89	29	9.0	7.1	83825	9,00	27,00
UNEF 9/16 x 24	95	30	11.2	9.0	83826	12,60	37,80
UNEF 5/8 x 24	102	32	12.5	10.0	83827	14,20	42,60
UNEF 3/4 x 20	112	37	14.0	11.2	83829	19,00	57,00
UNEF 7/8 x 20	118	38	16.0	12.5	83831	25,50	76,50
UNEF 1" x 20	130	45	16.0	14.0	83833	29,20	87,60

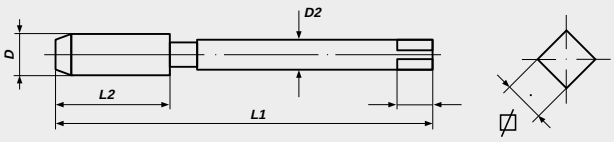
Application:

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

Applicazione:

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

How to order / esempio come ordinare:
UNEF 1/4 = 83821
UNEF 1/4, No. 1 = 83821-1
UNEF 1/4, No. 2 = 83821-2
UNEF 1/4, No. 3 = 83821-3



VÖLKEL
THREADING SOLUTIONS

Hand Taps
Pipe-thread DIN ISO 228

Maschi a mano
filettatura per tubi gas DIN ISO 228

DIN 5157 HSS-G

G (BSP)

Nominal Diameter D		L 1	L 2	D 2	⌀	Art.-No.	€	€
G	1/8 x 28	63	20	7	5.5	25312	5,50	11,00
G	1/4 x 19	70	22	11	9.0	25314	6,20	12,40
G	3/8 x 19	70	22	12	9.0	25316	9,00	18,00
G	1/2 x 14	80	22	16	12.0	25318	12,80	25,60
G	5/8 x 14	80	22	18	14.5	25320	18,10	36,20
G	3/4 x 14	90	22	20	16.0	25322	18,10	36,20
G	7/8 x 14	90	22	22	18.0	25324	30,50	61,00
G	1" x 11	100	25	25	20.0	25326	30,50	61,00
G	1.1/8 x 11	125	40	28	22.0	25330	53,00	106,00
G	1.1/4 x 11	125	40	32	24.0	25334	53,00	106,00
G	1.3/8 x 11	140	40	36	29.0	25338	72,50	145,00
G	1.1/2 x 11	140	40	36	29.0	25342	72,50	145,00
G	1.5/8 x 11	140	40	40	32.0	25346	145,00	290,00
G	1.3/4 x 11	140	40	40	32.0	25350	145,00	290,00
G	2" x 11	160	40	45	35.0	25354	150,00	300,00
G	2.1/4 x 11	160	40	50	39.0	25358	328,00	656,00
G	2.1/2 x 11	160	40	50	39.0	25362	460,00	920,00
G	2.3/4 x 11	160	40	50	39.0	25366	768,00	1.536,00
G	3" x 11	160	40	50	39.0	25370	895,00	1.790,00
G	3.1/2 x 11	180	45	56	44.0	25374	1.410,00	2.820,00
G	4" x 11	180	45	56	44.0	25378	1.760,00	3.520,00

Application:

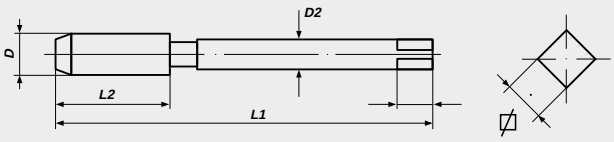
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

Applicazione:

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

How to order / esempio come ordinare:

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



Hand Taps
armoured tube thread DIN 40 430

Maschi a mano
filettatura per tubi corazzati DIN 40 430

DIN 40432 HSS-G

PG

Nominal Diameter D		L 1	L 2	D 2	⧄	Art.-No.	€	€
PG	7 x 20	70	22	9.0	7.0	25707	10,50	21,00
PG	9 x 18	70	22	12.0	9.0	25709	14,00	28,00
PG	11 x 18	80	22	14.0	11.0	25711	23,10	46,20
PG	13.5 x 18	80	22	16.0	12.0	25713	27,30	54,60
PG	16 x 18	80	22	18.0	14.5	25716	33,10	66,20
PG	21 x 16	90	22	22.0	18.0	25721	45,20	90,40
PG	29 x 16	100	25	28.0	22.0	25729	75,00	150,00
PG	36 x 16	140	40	36.0	29.0	25736	120,00	240,00
PG	42 x 16	140	40	40.0	32.0	25742	190,00	380,00
PG	48 x 16	160	40	45.0	35.0	25748	225,00	450,00

Application:

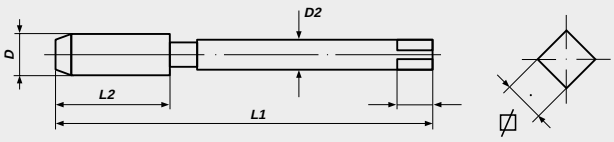
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

Applicazione:

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

How to order / esempio come ordinare:

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



VÖLKEL
THREADING SOLUTIONS

Hand Taps
trapezoidal thread DIN 103

Maschi a mano
filettatura trapeziodale metrica ISO 103

HSS-G Tol. 7H

Tr

Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€	€
Tr 10 x 2	90	34	7	5.5	25108	98,00	294,00
Tr 10 x 3	100	40	7	5.5	25112	98,00	294,00
Tr 12 x 3	110	40	8	6.2	25116	102,00	306,00
Tr 14 x 3	130	45	10	8.0	25120	130,00	390,00
Tr 14 x 4	130	55	10	8.0	25124	130,00	390,00
Tr 16 x 4	140	55	11	9.0	25128	130,00	390,00
Tr 18 x 4	150	55	12	9.0	25132	185,00	555,00
Tr 20 x 4	160	55	14	11.0	25136	195,00	585,00
Tr 22 x 5	175	65	16	12.0	25140	247,00	741,00
Tr 24 x 5	190	65	18	14.5	25144	271,00	813,00
Tr 26 x 5	210	70	20	16.0	25148	301,00	903,00
Tr 28 x 5	220	70	22	18.0	25152	328,00	984,00
Tr 30 x 6	240	80	22	18.0	25156	350,00	1.050,00
Tr 32 x 6	255	80	25	20.0	25160	426,00	1.278,00

Application:

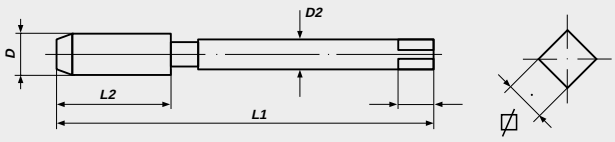
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

Applicazione:

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

How to order / esempio come ordinare:

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



Hand Taps
metric ISO-thread DIN 13

Maschi a mano
filettatura metrica ISO DIN 13

DIN 352 HSS-E Tol. ISO2/6H

M

Nominal Diameter D	L 1	L 2	D 2	⊠	Art.-No.	€	€
M 3 x 0.5	40	11	3.5	2.7	57326	4,30	12,90
M 4 x 0.7	45	13	4.5	3.4	57330	4,40	13,20
M 5 x 0.8	50	16	6.0	4.9	57334	4,60	13,80
M 6 x 1.0	50	19	6.0	4.9	57338	4,60	13,80
M 8 x 1.25	56	22	6.0	4.9	57342	6,30	18,90
M 10 x 1.5	70	24	7.0	5.5	57346	8,20	24,60
M 12 x 1.75	75	29	9.0	7.0	57350	10,20	30,60
M 14 x 2.0	80	30	11.0	9.0	57354	11,60	34,80
M 16 x 2.0	80	32	12.0	9.0	57358	15,00	45,00
M 18 x 2.5	95	40	14.0	11.0	57362	19,00	57,00
M 20 x 2.5	95	40	16.0	12.0	57366	22,00	66,00
M 22 x 2.5	100	40	18.0	14.5	57370	26,50	79,50
M 24 x 3.0	110	50	18.0	14.5	57374	33,00	99,00
M 27 x 3.0	110	50	20.0	16.0	57376	50,00	150,00
M 30 x 3.5	125	56	22.0	18.0	57378	68,00	204,00

Application:

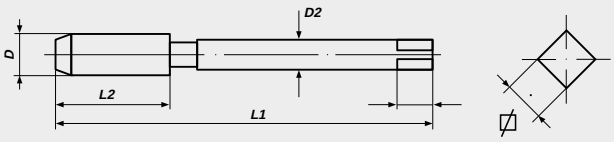
- high cutting ability
- abrasive material
- steels up to 1200 N/mm²
- and general use

Applicazione:

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

How to order / esempio come ordinare:

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



VÖLKEL
THREADING SOLUTIONS

Hand Taps
metric ISO-thread DIN 13
Rougher piloted

Maschi a mano
filettatura metrica ISO DIN 13
Sgrossatore con guida

DIN 352 HSS-E Tol. ISO2/6H

M

Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€	€
M 3 x 0.5	40	11	3.5	2.7	57726	6,90	20,70
M 4 x 0.7	45	13	4.5	3.4	57730	7,00	21,00
M 5 x 0.8	50	16	6.0	4.9	57734	7,40	22,20
M 6 x 1.0	50	19	6.0	4.9	57738	7,40	22,20
M 8 x 1.25	56	22	6.0	4.9	57742	10,10	30,30
M 10 x 1.5	70	24	7.0	5.5	57746	13,20	39,60
M 12 x 1.75	75	29	9.0	7.0	57750	16,30	48,90

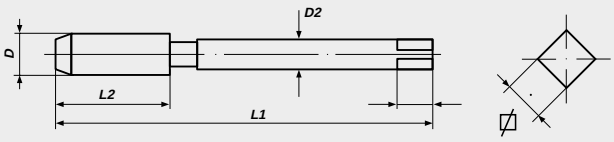
Application:
wear resistant steel up to 1400 N/mm²
- high alloy steel
- heat resistant steel
- stainless steel
- alloy tool steel
- cast iron

Surface treatment: steam tempered

Applicazione:
Acciaio ad alta resistenza R a 1.400 N/mm²
- Acciaio alto legato
- Acciaio resistenti al calore
- Acciaio inossidabili
- Acciaio per utensili legato
- Ghisia grigia

Superficie: vaporizzato

How to order / esempio come ordinare:
M 3 = 57726
M 3, No. 1 = 57726-1
M 3, No. 2 = 57726-2
M 3, No. 3 = 57726-3



Hand Taps
metric-fine ISO-thread DIN 13

Maschi a mano
filettatura metrica ISO DIN 13

DIN 2181 HSS-E Tol. ISO2/6H

Mf

Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€	€
M 6 x 0.75	50	14	6.0	4.9	56318	8,00	16,00
M 8 x 0.75	50	19	6.0	4.9	56324	8,00	16,00
M 8 x 1.0	56	22	6.0	4.9	56326	8,00	16,00
M 10 x 1.0	63	20	7.0	5.5	56336	8,70	17,40
M 10 x 1.25	70	24	7.0	5.5	56338	10,00	20,00
M 12 x 1.0	70	22	9.0	7.0	56344	12,10	24,20
M 12 x 1.25	70	22	9.0	7.0	56346	12,10	24,20
M 12 x 1.5	70	22	9.0	7.0	56348	12,10	24,20
M 14 x 1.25	70	22	11.0	9.0	56354	14,00	28,00
M 14 x 1.5	70	22	11.0	9.0	56356	12,70	25,40
M 16 x 1.5	70	22	12.0	9.0	56366	16,10	32,20
M 18 x 1.5	80	22	14.0	11.0	56372	18,50	37,00
M 18 x 2.0	80	22	14.0	11.0	56374	22,40	44,80
M 20 x 1.5	80	22	16.0	12.0	56384	21,00	42,00
M 20 x 2.0	80	22	16.0	12.0	56386	28,00	56,00
M 22 x 1.5	80	22	18.0	14.5	56394	26,20	52,40
M 22 x 2.0	80	22	18.0	14.5	56396	28,00	56,00
M 24 x 1.5	90	22	18.0	14.5	56504	35,00	70,00

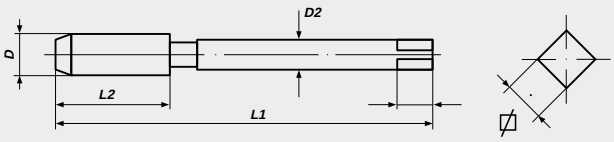
Application:

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

Applicazione:

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

How to order / esempio come ordinare:
M 6 x 0.75 = 56318
M 6 x 0.75, No. 1 = 56318-1
M 6 x 0.75, No. 2 = 56318-2



VÖLKEL
THREADING SOLUTIONS

Hand Taps
Pipe-thread DIN ISO 228

Maschi a mano
filettatura per tubi gas DIN ISO 228

DIN 5157 HSS-E

G (BSP)

Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€	€
G 1/8 x 28	63	20	7.0	5.5	55312	8,00	16,00
G 1/4 x 19	70	22	11.0	9.0	55314	10,00	20,00
G 3/8 x 19	70	22	12.0	9.0	55316	14,20	28,40
G 1/2 x 14	80	22	16.0	12.0	55318	22,00	44,00
G 3/4 x 14	90	22	20.0	16.0	55322	26,70	53,40
G 1" x 11	100	25	25.0	20.0	55326	46,00	92,00

Application:

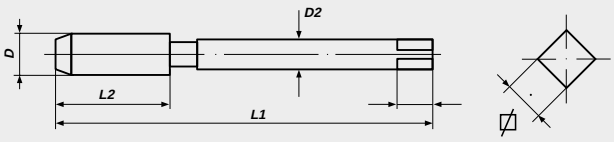
- high cutting ability
- abrasive material
- steels up to 1200 N/mm²
- and general use

Applicazione:

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

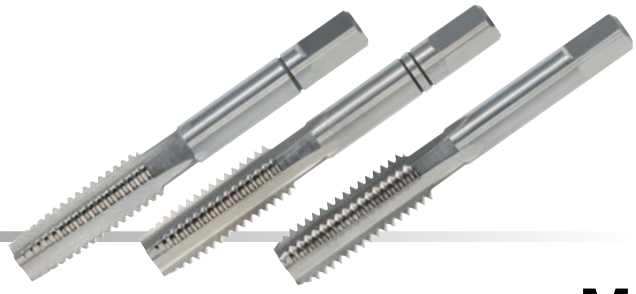
How to order / esempio come ordinare:

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



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

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



DIN 352 HSS-G Tol. ISO2/6H

M

Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€	€
M 3 x 0.5	40	11	3.5	2.7	27026	3,90	11,70
M 4 x 0.7	45	13	4.5	3.4	27030	3,90	11,70
M 5 x 0.8	50	16	6.0	4.9	27034	4,50	13,50
M 6 x 1.0	50	19	6.0	4.9	27038	4,70	14,10
M 8 x 1.25	56	22	6.0	4.9	27042	5,30	15,90
M 10 x 1.5	70	24	7.0	5.5	27046	7,30	21,90
M 12 x 1.75	75	29	9.0	7.0	27050	9,50	28,50
M 14 x 2.0	80	30	11.0	9.0	27054	10,60	31,80
M 16 x 2.0	80	32	12.0	9.0	27058	13,20	39,60
M 18 x 2.5	95	40	14.0	11.0	27062	17,00	51,00
M 20 x 2.5	95	40	16.0	12.0	27066	19,00	57,00
M 22 x 2.5	100	40	18.0	14.5	27070	23,20	69,60
M 24 x 3.0	110	50	18.0	14.5	27074	29,00	87,00
M 27 x 3.0	110	50	20.0	16.0	27076	47,00	141,00
M 30 x 3.5	125	56	22.0	18.0	27078	58,00	174,00
M 33 x 3.5	125	56	25.0	20.0	27080	78,00	234,00
M 36 x 4.0	150	63	28.0	22.0	27082	94,00	282,00
M 39 x 4.0	150	63	32.0	24.0	27084	120,00	360,00
M 42 x 4.5	150	63	32.0	24.0	27086	137,00	411,00
M 45 x 4.5	160	70	36.0	29.0	27088	165,00	495,00
M 48 x 5.0	180	75	36.0	29.0	27090	234,00	702,00
M 52 x 5.0	180	75	40.0	32.0	27092	234,00	702,00

Application:

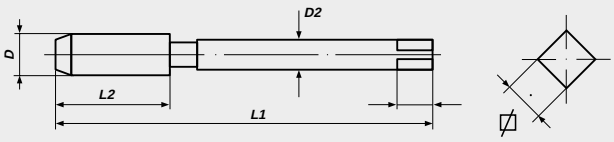
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

Applicazione:

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

How to order / esempio come ordinare:

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



VÖLKEL
THREADING SOLUTIONS

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

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

DIN 2181 HSS-G Tol. ISO2/6H

Mf

Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€	€
M 6 x 0.75	50	14	6.0	4.9	26007	8,90	17,80
M 8 x 0.75	50	19	6.0	4.9	26010	8,90	17,80
M 8 x 1.0	56	22	6.0	4.9	26011	8,90	17,80
M 10 x 1.0	63	20	7.0	5.5	26015	8,90	17,80
M 10 x 1.25	70	24	7.0	5.5	26016	10,00	20,00
M 12 x 1.0	70	22	9.0	7.0	26020	13,20	26,40
M 12 x 1.25	70	22	9.0	7.0	26021	13,20	26,40
M 12 x 1.5	70	22	9.0	7.0	26022	12,10	24,20
M 14 x 1.25	70	22	11.0	9.0	26027	14,70	29,40
M 14 x 1.5	70	22	11.0	9.0	26028	13,20	26,40
M 16 x 1.0	70	22	12.0	9.0	26031	22,00	44,00
M 16 x 1.5	70	22	12.0	9.0	26033	15,80	31,60
M 18 x 1.5	80	22	14.0	11.0	26036	18,50	37,00
M 20 x 1.5	80	22	16.0	12.0	26040	22,00	44,00
M 22 x 1.5	80	22	18.0	14.5	26045	29,00	58,00
M 24 x 1.5	90	22	18.0	14.5	26050	32,00	64,00
M 24 x 2.0	90	22	18.0	14.5	26051	42,00	84,00
M 30 x 1.5	90	22	22.0	18.0	26063	85,00	170,00
M 30 x 2.0	90	22	22.0	18.0	26064	85,00	170,00

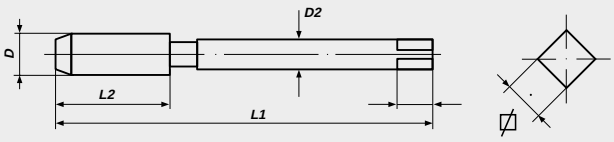
Application:

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

Applicazione:

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

How to order / esempio come ordinare:
M 6 x 0.75 = 26007
M 6 x 0.75, No. 1 = 26007-1
M 6 x 0.75, No. 2 = 26007-2



Hand Taps, *Left Hand*
Whitworth-thread BS 84

Maschi a mano, *filetto sinistro*
filettatura Whitworth BS 84

≈ DIN 352 HSS-G Tol. med

BSW

Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€	€
BSW 1/8 x 40	40	12	3.5	2.7	22006	6,90	20,70
BSW 5/32 x 32	45	14	4.5	3.4	22008	6,90	20,70
BSW 3/16 x 24	50	18	6.0	4.9	22010	6,90	20,70
BSW 1/4 x 20	50	19	6.0	4.9	22014	6,90	20,70
BSW 5/16 x 18	56	22	6.0	4.9	22016	7,20	21,60
BSW 3/8 x 16	70	24	7.0	5.5	22018	8,40	25,20
BSW 7/16 x 14	70	24	8.0	6.2	22020	10,30	30,90
BSW 1/2 x 12	75	29	9.0	7.0	22022	12,30	36,90
BSW 9/16 x 12	80	30	11.0	9.0	22024	16,00	48,00
BSW 5/8 x 11	80	32	12.0	9.0	22026	18,20	54,60
BSW 3/4 x 10	95	40	14.0	11.0	22030	24,30	72,90
BSW 7/8 x 9	100	40	18.0	14.5	22034	30,30	90,90
BSW 1" x 8	110	50	18.0	14.5	22038	36,40	109,20

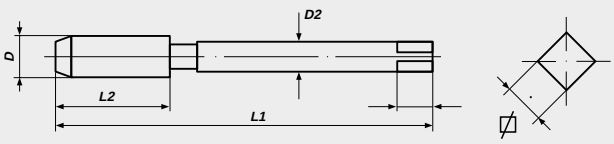
Application:

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

Applicazione:

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

How to order / esempio come ordinare:
BSW 1/8 = 22006
BSW 1/8, No. 1 = 22006-1
BSW 1/8, No. 2 = 22006-2
BSW 1/8, No. 3 = 22006-3



VÖLKEL
THREADING SOLUTIONS

Hand Taps, *Left Hand*

Unified thread ANSI B 1.1

Maschi a mano, *filetto sinistro*

filettatura unificata ANSI B1.1

≈ DIN 352 HSS-G Tol. 2B

UNC / UNF

Nominal Diameter D		L 1	L 2	D 2	⊠	Art.-No.	€	€
UNC 3-pcs								
UNC	Nr. 6 x 32	45	14	4.0	3.0	23006	10,90	32,70
UNC	Nr. 8 x 32	45	14	4.5	3.4	23008	10,90	32,70
UNC	Nr. 10 x 24	50	16	6.0	4.9	23010	10,90	32,70
UNC	Nr. 12 x 24	50	18	6.0	4.9	23012	10,90	32,70
UNC	1/4 x 20	50	19	6.0	4.9	23014	6,90	20,70
UNC	5/16 x 18	56	22	6.0	4.9	23016	7,20	21,60
UNC	3/8 x 16	70	24	7.0	5.5	23018	8,40	25,20
UNC	7/16 x 14	70	24	8.0	6.2	23020	10,30	30,90
UNC	1/2 x 13	75	29	9.0	7.0	23022	12,30	36,90
UNC	9/16 x 12	80	30	11.0	9.0	23024	16,00	48,00
UNC	5/8 x 11	80	32	12.0	9.0	23026	18,20	54,60
UNC	3/4 x 10	95	40	14.0	11.0	23030	24,30	72,90
UNC	7/8 x 9	100	40	18.0	14.5	23034	30,30	90,90
UNC	1" x 8	110	50	18.0	14.5	23038	36,40	109,20
UNF 2-pcs								
UNF	Nr. 10 x 32	45	14	6.0	4.9	24010	10,90	21,80
UNF	1/4 x 28	50	18	6.0	4.9	24014	6,90	13,80
UNF	5/16 x 24	56	22	6.0	4.9	24016	7,20	14,40
UNF	3/8 x 24	63	22	7.0	5.5	24018	8,40	16,80
UNF	7/16 x 20	63	22	8.0	6.2	24020	10,30	20,60
UNF	1/2 x 20	75	24	9.0	7.0	24022	12,30	24,60
UNF	9/16 x 18	80	28	11.0	9.0	24024	16,00	32,00
UNF	5/8 x 18	80	28	12.0	9.0	24026	18,20	36,40
UNF	3/4 x 16	95	32	14.0	11.0	24030	24,30	48,60
UNF	7/8 x 14	100	36	18.0	14.5	24034	30,30	60,60
UNF	1" x 12	110	40	18.0	14.5	24038	36,40	72,80

Application:

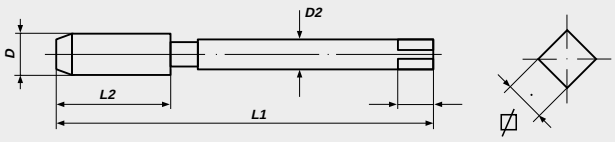
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

Applicazione:

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

How to order / esempio come ordinare:

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



Hand Taps, *Left Hand*
Pipe-thread DIN ISO 228

Maschi a mano, *filetto sinistro*
filettatura per tubi gas DIN ISO 228

DIN 5157 HSS-G

G (BSP)

Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€	€
G 1/8 x 28	63	20	7.0	5.5	25012	8,40	16,80
G 1/4 x 19	70	22	11.0	9.0	25014	9,50	19,00
G 3/8 x 19	70	22	12.0	9.0	25016	13,70	27,40
G 1/2 x 14	80	22	16.0	12.0	25018	17,80	35,60
G 5/8 x 14	80	22	18.0	14.5	25020	27,30	54,60
G 3/4 x 14	90	22	20.0	16.0	25022	27,30	54,60
G 1" x 11	100	25	25.0	20.0	25026	46,20	92,40
G 1.1/8 x 11	125	40	28.0	22.0	25030	80,00	160,00
G 1.1/4 x 11	125	40	32.0	24.0	25034	80,00	160,00
G 1.3/8 x 11	140	40	36.0	29.0	25038	106,00	212,00
G 1.1/2 x 11	140	40	36.0	29.0	25042	106,00	212,00
G 1.3/4 x 11	140	40	40.0	32.0	25050	218,00	436,00
G 2" x 11	160	40	45.0	35.0	25054	218,00	436,00

Application:

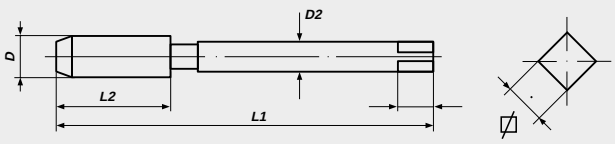
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

Applicazione:

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

How to order / esempio come ordinare:

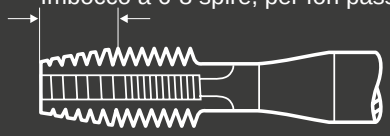
G 1/4	=	25014
G 1/4, No. 1	=	25014-1
G 1/4, No. 2	=	25014-2



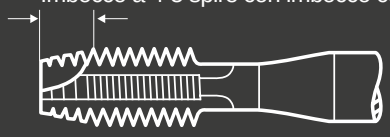
SHORT MACHINE TAPS
MASCHI A MACCHINA CORTI

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

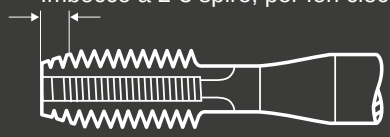
Form A
6-8 Threads Lead, for short through holes
Imbocco a 6-8 spire, per fori passanti corti



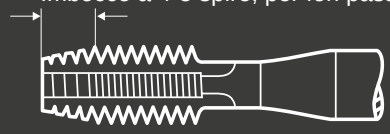
Form B
4-5 Threads Lead with Spiral Point for through holes
Imbocco a 4-5 spire con imbocco corretto, per tutti i fori passanti



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

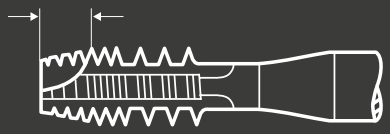


Form D
4-5 Threads Lead, for through and blind holes
Imbocco a 4-5 spire, per fori passante e ciechi



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

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



SHORT MACHINE TAPS
MASCHI A MACCHINA CORTI

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

VÖLKEL
THREADING SOLUTIONS

Short Machine Taps
metric ISO-thread DIN 13

Maschi a macchina corti
filettatura metrica ISO DIN 13

DIN 352 HSS-E Tol. ISO2/6H

M

Nominal Diameter D		L 1	L 2	D 2	⧄	Art.-No.	€
Spiral Point / Forma B con imbocco corretto							
M	3 x 0.5	40	11	3.5	2.7	61526	3,70
M	4 x 0.7	45	13	4.5	3.4	61530	3,70
M	5 x 0.8	48	16	6.0	4.9	61534	4,00
M	6 x 1.0	50	19	6.0	4.9	61538	4,30
M	8 x 1.25	56	22	6.0	4.9	61542	5,10
M	10 x 1.5	70	24	7.0	5.5	61546	6,20
M	12 x 1.75	75	29	9.0	7.0	61550	8,90
M	14 x 2.0	80	30	11.0	9.0	61554	10,50
M	16 x 2.0	80	32	12.0	9.0	61558	14,50
M	18 x 2.5	95	40	14.0	11.0	61562	18,00
M	20 x 2.5	95	40	16.0	12.0	61566	20,00
M	22 x 2.5	100	40	18.0	14.5	61570	28,50
M	24 x 3.0	110	50	18.0	14.5	61574	32,00
35° Spiral Flute / Forma C, spirale destra a 35°							
M	3 x 0.5	40	11	3.5	2.7	61726	4,70
M	4 x 0.7	45	13	4.5	3.4	61730	4,70
M	5 x 0.8	48	16	6.0	4.9	61734	5,10
M	6 x 1.0	50	19	6.0	4.9	61738	5,30
M	8 x 1.25	56	22	6.0	4.9	61742	6,20
M	10 x 1.5	70	24	7.0	5.5	61746	7,30
M	12 x 1.75	75	29	9.0	7.0	61750	9,50
with interrupted threads / Forma B, con denti alternati							
M	3 x 0.5	40	11	3.5	2.7	61926	5,90
M	4 x 0.7	45	13	4.5	3.4	61930	5,90
M	5 x 0.8	48	16	6.0	4.9	61934	6,20
M	6 x 1.0	50	19	6.0	4.9	61938	6,20
M	8 x 1.25	56	22	6.0	4.9	61942	6,70
M	10 x 1.5	70	24	7.0	5.5	61946	8,20
M	12 x 1.75	75	29	9.0	7.0	61950	10,50

Application:

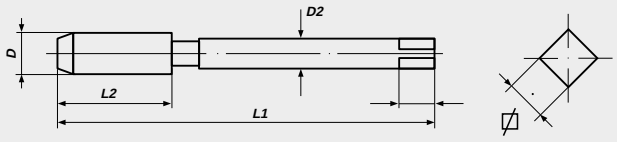
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for thread cutting by hand and machine

Spiral Point: for through holes
Spiral Flute: for blind holes
Form B-AZ: for through holes

Applicazione:

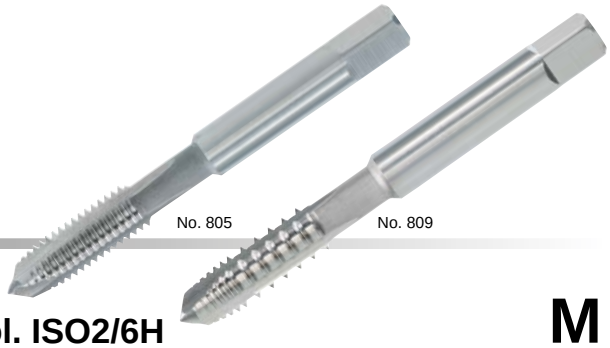
per uso universale
- Materiali con buona truciodibilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per uso manuale e con macchina

Forma B: per fori passanti
35° RSP: per fori ciechi
Forma B-AZ: per fori passanti



Machine Taps
metric ISO-thread DIN 13

Maschi a macchina corti
filettatura metrica ISO DIN 13



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

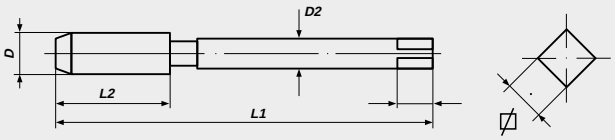
Nominal Diameter D		L 1	L 2	D 2	⧄	Art.-No.	€
M	2 x 0.4	41.0	8.0	2.50	2.00	80516	6,50
M	2.5 x 0.45	44.5	9.5	2.80	2.24	80522	6,50
M	2.6 x 0.45	44.5	9.5	2.90	2.24	80524	6,50
M	3 x 0.5	48.0	11.0	3.15	2.50	80526	3,80
M	3.5 x 0.6	50.0	13.0	3.55	2.80	80528	4,00
M	4 x 0.7	53.0	13.0	4.00	3.15	80530	3,80
M	5 x 0.8	58.0	16.0	5.00	4.00	80534	4,10
M	6 x 1.0	66.0	19.0	6.30	5.00	80538	4,20
M	8 x 1.25	72.0	22.0	8.00	6.30	80542	5,50
M	10 x 1.5	80.0	24.0	10.00	8.00	80546	6,70
M	12 x 1.75	89.0	29.0	9.00	7.10	80550	9,40
M	14 x 2.0	95.0	30.0	11.20	9.00	80554	11,00
M	16 x 2.0	102.0	32.0	12.50	10.00	80558	13,30
M	18 x 2.5	110.0	37.0	14.00	11.20	80562	19,10
M	20 x 2.5	112.0	37.0	14.00	11.20	80566	21,50
M	22 x 2.5	118.0	38.0	16.00	12.50	80570	25,40
M	24 x 3.0	130.0	45.0	18.00	14.00	80574	29,00
M	27 x 3.0	135.0	45.0	20.00	16.00	80576	40,50
M	30 x 3.5	138.0	48.0	20.00	16.00	80578	54,00
with interrupted threads / con denti alternati							
M	3 x 0.5	48.0	11.0	3.15	2.50	80926	5,80
M	4 x 0.7	53.0	13.0	4.00	3.15	80930	5,80
M	5 x 0.8	58.0	16.0	5.00	4.00	80934	6,20
M	6 x 1.0	66.0	19.0	6.30	5.00	80938	6,40
M	7 x 1.0	66.0	19.0	7.10	5.60	80940	7,30
M	8 x 1.25	72.0	22.0	8.00	6.30	80942	6,80
M	10 x 1.5	80.0	24.0	10.0	8.00	80946	8,20
M	12 x 1.75	89.0	29.0	9.00	7.10	80950	12,90
M	14 x 2.0	95.0	30.0	11.20	9.00	80954	14,50
M	16 x 2.0	102.0	32.0	12.50	10.00	80958	16,00
M	18 x 2.5	110.0	37.0	14.00	11.20	80962	23,50
M	20 x 2.5	112.0	37.0	14.00	11.20	80966	27,00
M	22 x 2.5	118.0	38.0	16.00	12.50	80970	30,00
M	24 x 3.0	130.0	45.0	18.00	14.00	80974	34,00

Application:

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

Applicazione:

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



Machine Taps
metric ISO-thread DIN 13

Maschi a macchina corti
filettatura metrica ISO DIN 13

ISO 529 Form C/35°RSP HSS-G Tol. ISO2/6H

M

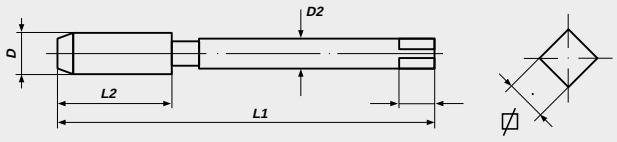
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
M 2.5 x 0.45	44.5	9.5	2.80	2.24	80722	8,30
M 2.6 x 0.45	44.5	9.5	2.90	2.24	80724	8,30
M 3 x 0.5	48.0	11.0	3.15	2.50	80726	5,00
M 4 x 0.7	53.0	13.0	4.00	3.15	80730	5,00
M 5 x 0.8	58.0	16.0	5.00	4.00	80734	5,00
M 6 x 1.0	66.0	19.0	6.30	5.00	80738	5,10
M 8 x 1.25	72.0	22.0	8.00	6.30	80742	6,10
M 10 x 1.5	80.0	24.0	10.00	8.00	80746	7,80
M 12 x 1.75	89.0	29.0	9.00	7.10	80750	10,10
M 14 x 2.0	95.0	30.0	11.20	9.00	80754	14,40
M 16 x 2.0	102.0	32.0	12.50	10.00	80758	16,00
M 18 x 2.5	110.0	37.0	14.00	11.20	80762	23,50
M 20 x 2.5	112.0	37.0	14.00	11.20	80766	26,60
M 22 x 2.5	118.0	38.0	16.00	12.50	80770	30,00
M 24 x 3.0	130.0	45.0	18.00	14.00	80774	34,00
M 27 x 3.0	135.0	45.0	20.00	16.00	80776	49,00
M 30 x 3.5	138.0	48.0	20.00	16.00	80778	64,00

Application:

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

Applicazione:

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



Short Machine Taps
metric-fine ISO-thread DIN 13

Maschi a macchina corti
filettatura metrica fine ISO DIN 13

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

Mf

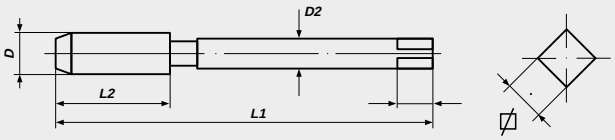
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
M 6 x 0.75	50	14	6.0	4.9	66318	6,00
M 8 x 0.75	50	19	6.0	4.9	66324	6,00
M 8 x 1.0	56	22	6.0	4.9	66326	6,00
M 9 x 0.75	56	19	7.0	5.5	66328	6,70
M 9 x 1.0	63	20	7.0	5.5	66330	6,70
M 10 x 0.75	63	20	7.0	5.5	66332	6,70
M 10 x 1.0	63	20	7.0	5.5	66336	6,00
M 10 x 1.25	70	24	7.0	5.5	66338	6,70
M 12 x 0.5	70	22	9.0	7.0	66345	8,70
M 12 x 0.75	70	22	9.0	7.0	66343	8,70
M 12 x 1.0	70	22	9.0	7.0	66344	8,70
M 12 x 1.25	70	22	9.0	7.0	66346	8,70
M 12 x 1.5	70	22	9.0	7.0	66348	7,90
M 13 x 1.0	70	22	11.0	9.0	66350	13,30
M 13 x 1.5	70	22	11.0	9.0	66351	13,30
M 14 x 1.0	70	22	11.0	9.0	66353	13,30
M 14 x 1.25	70	22	11.0	9.0	66354	10,00
M 14 x 1.5	70	22	11.0	9.0	66356	8,60
M 15 x 1.5	70	22	12.0	9.0	66360	14,70
M 16 x 1.5	70	22	12.0	9.0	66366	10,50
M 18 x 1.0	80	22	14.0	11.0	66370	16,10
M 18 x 1.5	80	22	14.0	11.0	66372	12,10
M 20 x 1.5	80	22	16.0	12.0	66384	14,70
M 20 x 2.0	80	22	16.0	12.0	66386	20,20
M 22 x 1.5	80	22	18.0	14.5	66394	20,90
M 22 x 2.0	80	22	18.0	14.5	66396	20,90
M 24 x 1.5	90	22	18.0	14.5	66504	22,00
M 24 x 2.0	90	22	18.0	14.5	66506	28,00
M 25 x 1.5	90	22	18.0	14.5	66508	41,00
M 26 x 1.5	90	22	18.0	14.5	66512	41,00
M 27 x 1.5	90	22	20.0	16.0	66517	41,00
M 28 x 1.5	90	22	20.0	16.0	66522	48,50
M 30 x 1.5	90	22	22.0	18.0	66530	57,00
M 30 x 2.0	90	22	22.0	18.0	66532	57,00
M 32 x 1.5	90	22	22.0	18.0	66536	57,00

Application:

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

Applicazione:

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



Short Machine Taps
Whitworth-thread BS 84

Maschi a macchina corti
filettatura Whitworth BS 84

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

Nominal Diameter S	L 1	L 2	D 2	⧄	Art.-No.	€
BSW 1/8 x 40	40	12	3.5	2.7	62306	4,30
BSW 3/16 x 24	50	18	6.0	4.9	62310	4,20
BSW 1/4 x 20	50	19	6.0	4.9	62314	4,20
BSW 5/16 x 18	56	22	6.0	4.9	62316	4,70
BSW 3/8 x 16	70	24	7.0	5.5	62318	5,20
BSW 7/16 x 14	70	24	8.0	6.2	62320	6,60
BSW 1/2 x 12	75	29	9.0	7.0	62322	8,00
BSW 9/16 x 12	80	30	11.0	9.0	62324	10,50
BSW 5/8 x 11	80	32	12.0	9.0	62326	11,80
BSW 3/4 x 10	95	40	14.0	11.0	62330	15,80
BSW 7/8 x 9	100	40	18.0	14.5	62334	21,00
BSW 1" x 8	110	50	18.0	14.5	62338	24,20

Short Machine Taps
tapered Whitworth screw thread for gas cylinders
taper 3:25, DIN 477

Maschi a macchina corti
filettatura Whitworth conica per bombola di gas
cono 3:25, DIN 477

≈ **DIN 352** **Form C** **HSS-G** **W**

Nominal Diameter S	L 1	L 2	D 2	⧄	Art.-No.	€
W 19,8 x 14	90	32	16	12	62397	142,00
W 28,8 x 14	100	40	20	16	62398	160,00
W 31,3 x 14	110	40	22	18	62399	184,00

Short Machine Taps
Unified Coarse and Fine thread ANSI B 1.1

Maschi macchina corti
filettatura unificata, serie grossa e fina ANSI B1.1

≈ DIN 352 Form D HSS-G Tol. 2B

UNC / UNF

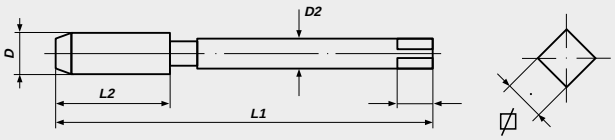
Nominal Diameter S	L 1	L 2	D 2	⧄	Art.-No.	€
UNC						
UNC 1/4 x 20	50	19	6.0	4.9	63314	4,20
UNC 5/16 x 18	56	22	6.0	4.9	63316	4,70
UNC 3/8 x 16	70	24	7.0	5.5	63318	5,20
UNC 7/16 x 14	70	24	8.0	6.2	63320	6,60
UNC 1/2 x 13	75	29	9.0	7.0	63322	8,00
UNC 9/16 x 12	80	30	11.0	9.0	63324	10,50
UNC 5/8 x 11	80	32	12.0	9.0	63326	11,80
UNC 3/4 x 10	95	40	14.0	11.0	63330	15,80
UNC 7/8 x 9	100	40	18.0	14.5	63334	21,00
UNC 1" x 8	110	50	18.0	14.5	63338	24,20
UNF						
UNF 1/4 x 28	50	18	6.0	4.9	64314	4,20
UNF 5/16 x 24	56	22	6.0	4.9	64316	4,70
UNF 3/8 x 24	63	22	7.0	5.5	64318	5,20
UNF 7/16 x 20	63	22	8.0	6.2	64320	6,60
UNF 1/2 x 20	75	24	9.0	7.0	64322	8,00
UNF 9/16 x 18	80	28	11.0	9.0	64324	10,50
UNF 5/8 x 18	80	28	12.0	9.0	64326	11,80
UNF 3/4 x 16	95	32	14.0	11.0	64330	15,80
UNF 7/8 x 14	100	36	18.0	14.5	64334	21,00
UNF 1" x 12	110	40	18.0	14.5	64338	24,20

Application:

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

Applicazione:

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



VÖLKEL
THREADING SOLUTIONS

Short Machine Taps
Pipe-thread DIN ISO 228

Maschi a macchina corti
filettatura per tubi gas DIN ISO 228

DIN 5157 Form D HSS-G

G (BSP)

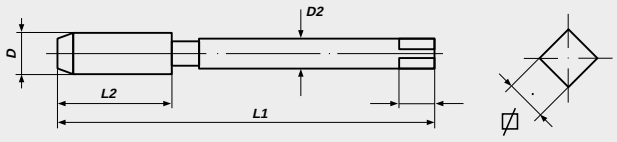
Nominal Diameter S		L 1	L 2	D 2	⊡	Art.-No.	€
G	1/8 x 28	63	20	7	5.5	65312	5,50
G	1/4 x 19	70	22	11	9.0	65314	6,20
G	3/8 x 19	70	22	12	9.0	65316	9,00
G	1/2 x 14	80	22	16	12.0	65318	12,80
G	3/4 x 14	90	22	20	16.0	65322	18,10
G	1" x 11	100	25	25	20.0	65326	30,50
G	1.1/4 x 11	125	40	32	24.0	65334	53,00
G	1.1/2 x 11	140	40	36	29.0	65342	72,50
G	1.3/4 x 11	140	40	40	32.0	65350	145,00
G	2" x 11	160	40	45	35.0	65354	150,00
G	2.1/4 x 11	160	40	50	39.0	65358	328,00
G	2.1/2 x 11	160	40	50	39.0	65362	460,00
G	2.3/4 x 11	160	40	50	39.0	65366	768,00
G	3" x 11	160	40	50	39.0	65370	895,00
G	3.1/2 x 11	180	45	56	44.0	65374	1.410,00
G	4" x 11	180	45	56	44.0	65378	1.760,00

Application:

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

Applicazione:

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



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

Maschi a macchina corti
filettatura conica per tubi, cono 1:16

HSS-G / HSSE

Rc (BSPT)

Nominal Diameter S	L 1	L 2	D 2	⧄	Art.-No.	€
Form C, HSS-G						
PT 1/8 x 28	65	19.0	7.0	5.5	63712	7,90
PT 1/4 x 19	70	25.0	11.0	9.0	63714	9,20
PT 3/8 x 19	75	26.0	12.0	9.0	63716	14,50
PT 1/2 x 14	80	31.0	16.0	12.0	63718	18,20
PT 5/8 x 14	90	32.0	18.0	14.5	63720	26,70
PT 3/4 x 14	100	33.0	20.0	16.0	63722	26,70
PT 1" x 11	110	38.0	25.0	20.0	63726	40,30
Form B, HSSE, Spiral Point / con imbocco corretto						
PT 1/16 x 28	55	17.5	8.0	6.0	97502	7,90
PT 1/8 x 28	55	19.0	8.0	6.0	97506	8,20
PT 1/4 x 19	62	28.0	11.0	9.0	97514	9,50
PT 3/8 x 19	65	28.0	14.0	11.0	97518	16,80
PT 1/2 x 14	80	35.0	18.0	14.0	97522	24,20
PT 3/4 x 14	85	35.0	23.0	17.0	97530	36,30
PT 1" x 11	95	45.0	26.0	21.0	97538	55,00
PT 1.1/4 x 11	105	45.0	32.0	26.0	97546	82,00
PT 1.1/2 x 11	110	45.0	38.0	29.0	97554	117,00
PT 2" x 11	120	50.0	46.0	35.0	97570	205,00
Form C, HSSE, 35° Spiral Flute / spirale destra a 35°						
PT 1/16 x 28	55	17.5	8.0	6.0	97702	7,90
PT 1/8 x 28	55	19.0	8.0	6.0	97706	8,20
PT 1/4 x 19	62	28.0	11.0	9.0	97714	9,50
PT 3/8 x 19	65	28.0	14.0	11.0	97718	16,80
PT 1/2 x 14	80	35.0	18.0	14.0	97722	24,20
PT 3/4 x 14	85	35.0	23.0	17.0	97730	36,30
PT 1" x 11	95	45.0	26.0	21.0	97738	55,00
PT 1.1/4 x 11	105	45.0	32.0	26.0	97746	82,00
PT 1.1/2 x 11	110	45.0	38.0	29.0	97754	117,00
PT 2" x 11	120	50.0	46.0	35.0	97770	205,00

Application:

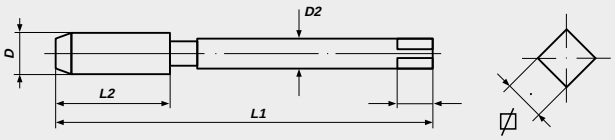
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for thread cutting by hand and machine

Form C: for through and blind holes
Spiral Point: for through holes
Spiral Flute: for blind holes

Applicazione:

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

Forma C: per fori passanti e ciechi
Forma B: per fori passanti
35° RSP: per fori ciechi



VÖLKEL
THREADING SOLUTIONS

Short Machine Taps
Pipe-thread ISO 7-1 (DIN EN 10226-1)

Maschi a macchina corti
filettatura cilindrica per tubi ISO 7-1 (DIN EN 10226-1)

HSS-G

Rp (BSPP)

Nominal Diameter S	L 1	L 2	D 2	⧄	Art.-No.	€
Form C						
PS 1/16 x 28	55	19	6.5	5.0	95402	6,60
PS 1/8 x 28	55	19	8.0	6.0	95406	6,60
PS 1/4 x 19	62	28	11.0	9.0	95414	8,10
PS 3/8 x 19	65	28	14.0	11.0	95418	13,00
PS 1/2 x 14	80	35	18.0	14.0	95422	20,00
PS 3/4 x 14	85	35	23.0	17.0	95430	34,50
PS 1" x 11	95	45	26.0	21.0	95438	45,00
PS 1.1/4 x 11	105	45	32.0	26.0	95446	68,00
PS 1.1/2 x 11	110	45	38.0	29.0	95454	94,00
PS 2" x 11	120	50	46.0	35.0	95470	143,00
Form C, 35° Spiral Flute / spirale destra a 35°						
PS 1/16 x 28	55	19	6.5	5.0	95702	7,30
PS 1/8 x 28	55	19	8.0	6.0	95706	7,30
PS 1/4 x 19	62	28	11.0	9.0	95714	8,70
PS 3/8 x 19	65	28	14.0	11.0	95718	14,00
PS 1/2 x 14	80	35	18.0	14.0	95722	22,00
PS 3/4 x 14	85	35	23.0	17.0	95730	32,00
PS 1" x 11	95	45	26.0	21.0	95738	50,00
PS 1.1/4 x 11	105	45	32.0	26.0	95746	74,00
PS 1.1/2 x 11	110	45	38.0	29.0	95754	103,00
PS 2" x 11	120	50	46.0	35.0	95770	155,00

Application:

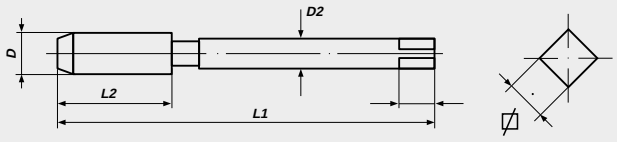
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for thread cutting by hand and machine

Form C: for through and blind holes
Spiral Flute: for blind holes

Applicazione:

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

Forma C: per fori passanti e ciechi
35° RSP: per fori ciechi



Short Machine Taps
armoured tube thread DIN 40 430

Maschi a macchina corti
filettatura per tubi corazzati DIN 40 430

DIN 40432 Form D HSS-G

PG

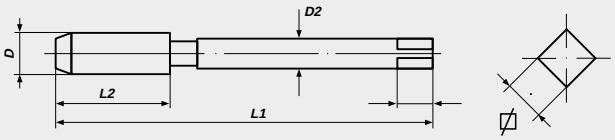
Nominal Diameter S	L 1	L 2	D 2	⧄	Art.-No.	€
PG 7 x 20	70	22	9.0	7.0	65707	10,50
PG 9 x 18	70	22	12.0	9.0	65709	14,00
PG 11 x 18	80	22	14.0	11.0	65711	23,10
PG 13.5 x 18	80	22	16.0	12.0	65713	27,30
PG 16 x 18	80	22	18.0	14.5	65716	33,10
PG 21 x 16	90	22	22.0	18.0	65721	45,20
PG 29 x 16	100	25	28.0	22.0	65729	75,00
PG 36 x 16	140	40	36.0	29.0	65736	120,00
PG 42 x 16	140	40	40.0	32.0	65742	190,00
PG 48 x 16	160	40	45.0	35.0	65748	225,00

Application:

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

Applicazione:

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



VÖLKEL
THREADING SOLUTIONS

Short Machine Taps
american tapered pipe thread, taper 1:16

Maschi a macchina corti
filettatura americana conica per tubi, cono 1:16

HSS-G

NPT

Nominal Diameter S	L 1	L 2	D 2	⧄	Art.-No.	€
Form C						
NPT 1/16 x 27	65	19	7	5.5	63510	15,50
NPT 1/8 x 27	65	19	7	5.5	63512	13,00
NPT 1/4 x 18	70	25	11	9.0	63514	14,50
NPT 3/8 x 18	75	26	12	9.0	63516	20,00
NPT 1/2 x 14	80	31	16	12.0	63518	25,00
NPT 3/4 x 14	100	33	20	16.0	63522	33,50
NPT 1" x 11.5	110	38	25	20.0	63526	52,50
NPT 1.1/4 x 11.5	125	41	32	24.0	63534	80,00
NPT 1.1/2 x 11.5	140	42	36	29.0	63542	150,00
NPT 2" x 11.5	160	44	36	29.0	63554	185,00
Form B, Spiral Point / con imbocco corretto						
NPT 1/16 x 27	55	17.5	8.0	6.0	98502	19,00
NPT 1/8 x 27	55	19.0	8.0	6.0	98506	15,30
NPT 1/4 x 18	62	28.0	11.0	9.0	98514	18,00
NPT 3/8 x 18	65	28.0	14.0	11.0	98518	23,00
NPT 1/2 x 14	80	35.0	18.0	14.0	98522	28,90
NPT 3/4 x 14	85	35.0	23.0	17.0	98530	38,50
NPT 1" x 11.5	95	45.0	26.0	21.0	98538	62,00
NPT 1.1/4 x 11.5	105	45.0	32.0	26.0	98546	92,40
NPT 1.1/2 x 11.5	110	45.0	38.0	29.0	98554	154,00
NPT 2" x 11.5	120	50.0	46.0	35.0	98570	205,00
Form C, 35° Spiral Flute / spirale destra a 35°						
NPT 1/16 x 27	55	17.5	8.0	6.0	98702	20,00
NPT 1/8 x 27	55	19.0	8.0	6.0	98706	16,00
NPT 1/4 x 18	62	28.0	11.0	9.0	98714	18,00
NPT 3/8 x 18	65	28.0	14.0	11.0	98718	24,20
NPT 1/2 x 14	80	35.0	18.0	14.0	98722	30,00
NPT 3/4 x 14	85	35.0	23.0	17.0	98730	41,00
NPT 1" x 11.5	95	45.0	26.0	21.0	98738	65,00
NPT 1.1/4 x 11.5	105	45.0	32.0	26.0	98746	97,00
NPT 1.1/2 x 11.5	110	45.0	38.0	29.0	98754	162,00
NPT 2" x 11.5	120	50.0	46.0	35.0	98770	210,00

Application:

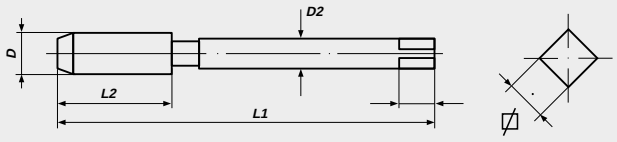
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for thread cutting by hand and machine

Form C: for through and blind holes
Spiral Point: for through holes
Spiral Flute: for blind holes

Applicazione:

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

Forma C: per fori passanti e ciechi
Forma B: per fori passanti
35° RSP: per fori ciechi



Short Machine Taps, *Left Hand*
american tapered pipe thread, taper 1:16

Maschi a macchina corti, *filetto sinistro*
filettatura americana conica per tubi, cono 1:16

Form C HSS-G

NPT

Nominal Diameter S	L 1	L 2	D 2	⧄	Art.-No.	€
NPT 1/8 x 27	65	19	7	5.5	63002	20,00
NPT 1/4 x 18	70	25	11	9.0	63003	21,50
NPT 3/8 x 18	75	26	12	9.0	63004	30,50
NPT 1/2 x 14	80	31	16	12.0	63005	37,80
NPT 3/4 x 14	100	33	20	16.0	63007	49,50
NPT 1" x 11.5	110	38	25	20.0	63009	80,00
NPT 1.1/4 x 11.5	125	41	32	24.0	63011	120,00
NPT 1.1/2 x 11.5	140	42	36	29.0	63013	226,00

Application:

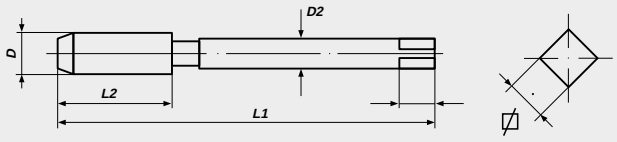
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for thread cutting by hand and machine

Form C: for through and blind holes

Applicazione:

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

Forma C: per fori passanti e ciechi



VÖLKEL
THREADING SOLUTIONS

Short Machine Taps
american tapered pipe thread, taper 1:16

Maschi a macchina corti
filettatura americana conica per tubi, cono 1:16

HSS-E

NPTF

Nominal Diameter S	L 1	L 2	D 2	⧄	Art.-No.	€
Form B, Spiral Point / con imbocco corretto						
NPTF 1/16 x 27	55	19	6.5	5.0	98571	19,00
NPTF 1/8 x 27	55	19	8.0	6.0	98572	15,30
NPTF 1/4 x 18	62	28	11.0	9.0	98574	18,00
NPTF 3/8 x 18	65	28	14.0	11.0	98576	23,00
NPTF 1/2 x 14	80	35	18.0	14.0	98578	28,90
NPTF 3/4 x 14	85	35	23.0	17.0	98580	38,50
NPTF 1" x 11.5	95	45	26.0	21.0	98582	62,00
NPTF 1.1/4 x 11.5	105	45	32.0	26.0	98584	92,40
NPTF 1.1/2 x 11.5	110	45	38.0	29.0	98586	154,00
NPTF 2" x 11.5	120	50	46.0	35.0	98588	205,00
Form C, 35° Spiral Flute / spirale destra a 35°						
NPTF 1/8 x 27	55	19	8.0	6.0	98772	16,00
NPTF 1/4 x 18	62	28	11.0	9.0	98774	18,00
NPTF 3/8 x 18	65	28	14.0	11.0	98776	24,20
NPTF 1/2 x 14	80	35	18.0	14.0	98778	30,00
NPTF 3/4 x 14	85	35	23.0	17.0	98780	41,00
NPTF 1" x 11.5	95	45	26.0	21.0	98782	65,00

Application:

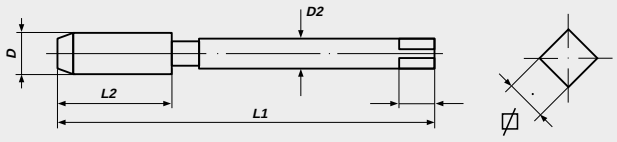
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for thread cutting by hand and machine

Spiral Point: for through holes
Spiral Flute: for blind holes

Applicazione:

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

Forma B: per fori passanti
35° RSP: per fori ciechi



Short Machine Taps
american straight pipe thread

Maschi a macchina corti
filettatura americana cilindrica per tubi

HSS-E

NPS

Nominal Diameter S	L 1	L 2	D 2	⧄	Art.-No.	€
Form C						
NPS 1/16 x 27	54	17.5	8.0	6.0	99402	16,00
NPS 1/8 x 27	55	19.0	8.0	6.0	99406	13,80
NPS 1/4 x 18	62	28.0	11.0	9.0	99414	16,20
NPS 3/8 x 18	65	28.0	14.0	11.0	99418	19,60
NPS 1/2 x 14	80	35.0	18.0	14.0	99422	24,30
NPS 3/4 x 14	85	35.0	23.0	17.0	99430	32,00
NPS 1" x 11.5	95	45.0	26.0	21.0	99438	51,00
NPS 1.1/4 x 11.5	105	45.0	32.0	26.0	99446	77,00
NPS 1.1/2 x 11.5	110	45.0	38.0	29.0	99454	172,00
NPS 2" x 11.5	120	50.0	46.0	35.0	99470	276,00
Form C, 35° Spiral Flute / spirale destra a 35°						
NPS 1/16 x 27	54	17.5	8.0	6.0	99702	18,00
NPS 1/8 x 27	55	19.0	8.0	6.0	99706	15,80
NPS 1/4 x 18	62	28.0	11.0	9.0	99714	17,70
NPS 3/8 x 18	65	28.0	14.0	11.0	99718	22,00
NPS 1/2 x 14	80	35.0	18.0	14.0	99722	28,90
NPS 3/4 x 14	85	35.0	23.0	17.0	99730	36,20
NPS 1" x 11.5	95	45.0	26.0	21.0	99738	62,00
NPS 1.1/4 x 11.5	105	45.0	32.0	26.0	99746	94,00
NPS 1.1/2 x 11.5	110	45.0	38.0	29.0	99754	186,00
NPS 2" x 11.5	120	50.0	46.0	35.0	99770	302,00

Application:

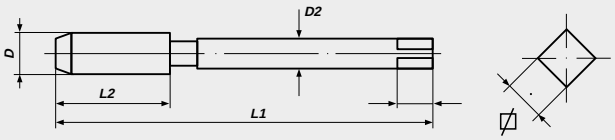
for general
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for thread cutting by hand and machine

Form C: for through and blind holes
Spiral Flute: for blind holes

Applicazione:

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

Forma C: per fori passanti e ciechi
35° RSP: per fori ciechi



HEX TAP DS

Benefit:

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

Vantaggi:

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

BIT EDITION
EDIZIONE BIT

	M	Mf	UNC UNF	UN	BSW	G(BSP)
HexTap	63	64 - 67		68		68
Combined Bits Maschi combinati	69		70			
TriBit²	71					
Drill Bits Punte elicoidale con attacco esagonale 1/4”	71-72					
Countersink Bits Frese per svasare con attacco esagonale 1/4	72					
Combined Machine Tap Maschi combinati con punte	73				73	

HexTap S

Technical Information:

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

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

HexTap S

Informazioni tecniche:

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

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

HexTap DS

Application:

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

HexTap DS

Applicazione:

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

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

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

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

HexTap S
maschi con attacco esagonale 1/4”
filettatura metrica ISO DIN 13

HSS-G Tol. ISO2/6H M

Size	Typ	L 1	L 2	SW1	Art.-No.	€
M 3	S	33.0	11	1/4"	67026	3,40
M 3.5	S	33.5	10	1/4"	67028	4,60
M 4	S	35.0	12	1/4"	67030	3,40
M 4.5	S	35.0	12	1/4"	67032	4,60
M 5	S	36.0	15	1/4"	67034	4,30
M 5.5	S	35.0	15	1/4"	67036	5,20
M 6	S	39.0	18	1/4"	67038	4,30
M 7	S	37.5	16	1/4"	67040	5,70
M 8	S	40.0	19	1/4"	67042	6,10
M 9	S	40.5	18	1/4"	67044	8,80
M 10	S	41.0	21	1/4"	67046	7,20

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

HexTap DS
maschi doppio, Multi-Drive
filettatura metrica ISO DIN 13

HSS-G Tol. ISO2/6H M

Size	Typ	L 1	L 2	SW1	SW2	Art.-No.	€
M 11	DS	70	22	8	4	67048	15,30
M 12	DS	70	22	8	4	67050	15,30
M 14	DS	70	22	10	4	67051	17,40
M 16	DS	70	22	10	4	67052	20,00
M 18	DS	80	24	13	5	67053	22,00
M 20	DS	80	24	13	6	67054	24,20
M 22	DS	80	24	15	6	67055	30,50
M 24	DS	90	27	15	8	67056	35,70
M 27	DS	90	27	19	8	67057	56,00
M 30	DS	90	27	19	10	67058	70,00
M 33	DS	100	29	24	10	67059	90,00
M 36	DS	100	29	24	10	67060	108,00
M 39	DS	110	32	27	12	67061	140,00
M 42	DS	110	27	27	12	67062	160,00
M 45	DS	110	27	32	17	67063	192,00
M 48	DS	140	42	32	17	67064	270,00
M 52	DS	140	42	36	19	67065	270,00

HexTap S

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

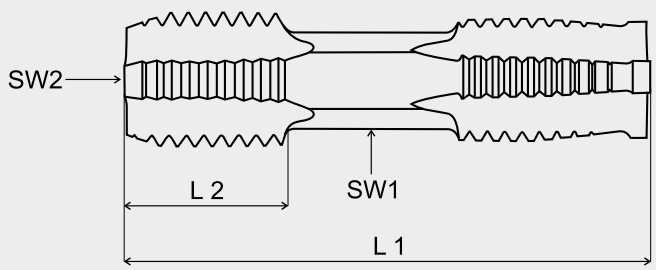
HexTap S

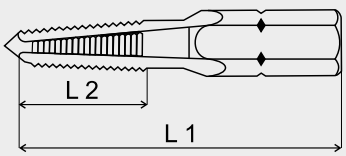
maschi con attacco esagonale 1/4”
filettatura metrica fine ISO DIN 13

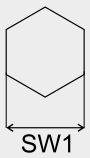
HSS-G Tol. ISO2/6H

Mf

Size	Typ	L 1	L 2	SW1	Art.-No.	€
M 3 x 0.35	S	33.0	11	1/4"	67700	4,40
M 3.5 x 0.35	S	33.5	10	1/4"	67701	4,40
M 4 x 0.35	S	35.0	12	1/4"	67702	4,40
M 4 x 0.5	S	35.0	12	1/4"	67703	4,40
M 4.5 x 0.5	S	35.0	12	1/4"	67704	5,00
M 5 x 0.5	S	36.0	15	1/4"	67705	5,00
M 5 x 0.75	S	36.0	15	1/4"	67706	5,00
M 5.5 x 0.5	S	35.0	15	1/4"	67707	5,00
M 6 x 0.5	S	39.0	18	1/4"	67708	5,00
M 6 x 0.75	S	39.0	18	1/4"	67709	5,00
M 7 x 0.5	S	37.5	16	1/4"	67710	6,60
M 7 x 0.75	S	37.5	16	1/4"	67711	6,60
M 8 x 0.5	S	40.0	19	1/4"	67712	6,60
M 8 x 0.75	S	40.0	19	1/4"	67713	6,60
M 8 x 1.0	S	40.0	19	1/4"	67714	6,60
M 9 x 0.5	S	40.5	18	1/4"	67715	8,60
M 9 x 0.75	S	40.5	18	1/4"	67716	8,60
M 9 x 1.0	S	40.5	18	1/4"	67717	8,60
M 10 x 0.5	S	41.0	21	1/4"	67718	8,60
M 10 x 0.75	S	41.0	21	1/4"	67719	8,60
M 10 x 1.0	S	41.0	21	1/4"	67720	8,60
M 10 x 1.25	S	41.0	21	1/4"	67721	8,60







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

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

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

Size		Typ	L 1	L 2	SW1	SW2	Art.-No.	€
M	11 x 0.75	DS	70	22	8	4	67722	16,60
M	11 x 1.0	DS	70	22	8	4	67723	16,60
M	11 x 1.25	DS	70	22	8	4	67724	16,60
M	12 x 0.5	DS	70	22	8	4	67725	16,60
M	12 x 0.75	DS	70	22	8	4	67726	16,60
M	12 x 1	DS	70	22	8	4	67727	16,60
M	12 x 1.25	DS	70	22	8	4	67728	16,60
M	12 x 1.5	DS	70	22	8	4	67729	15,40
M	13 x 0.5	DS	70	22	10	4	67730	24,20
M	13 x 0.75	DS	70	22	10	4	67731	24,20
M	13 x 1.0	DS	70	22	10	4	67732	24,20
M	13 x 1.5	DS	70	22	8	4	67733	24,20
M	14 x 0.5	DS	70	22	10	4	67734	24,20
M	14 x 0.75	DS	70	22	10	4	67735	24,20
M	14 x 1.0	DS	70	22	10	4	67736	24,20
M	14 x 1.25	DS	70	22	10	4	67737	19,30
M	14 x 1.5	DS	70	22	10	4	67738	16,60
M	15 x 0.75	DS	70	22	12	4	67739	27,00
M	15 x 1.0	DS	70	22	12	4	67740	27,00
M	15 x 1.5	DS	70	22	10	4	67741	27,00
M	16 x 0.5	DS	70	22	12	4	67742	27,00
M	16 x 0.75	DS	70	22	12	4	67743	27,00
M	16 x 1	DS	70	22	12	4	67744	27,00
M	16 x 1.25	DS	70	22	12	4	67745	27,00
M	16 x 1.5	DS	70	22	12	4	67746	20,40
M	17 x 1.0	DS	80	24	13	5	67747	29,20
M	17 x 1.5	DS	80	24	13	5	67748	29,20
M	18 x 0.5	DS	80	24	13	5	67749	29,20
M	18 x 0.75	DS	80	24	13	5	67750	29,20
M	18 x 1.0	DS	80	24	13	5	67751	29,20
M	18 x 1.25	DS	80	24	13	5	67752	29,20
M	18 x 1.5	DS	80	24	13	5	67753	23,10
M	18 x 2.0	DS	80	24	13	5	67754	29,20
M	19 x 1.0	DS	80	24	15	6	67755	36,60
M	19 x 1.5	DS	80	24	15	6	67756	36,60
M	20 x 0.5	DS	80	24	15	6	67757	36,60
M	20 x 0.75	DS	80	24	15	6	67758	36,60
M	20 x 1.0	DS	80	24	15	6	67759	36,60
M	20 x 1.25	DS	80	24	15	6	67760	36,60
M	20 x 1.5	DS	80	24	15	6	67761	28,40
M	20 x 2.0	DS	80	24	15	6	67762	36,60
M	21 x 1.0	DS	80	24	15	6	67763	38,00
M	21 x 1.5	DS	80	24	15	6	67764	38,00
M	22 x 0.5	DS	80	24	17	6	67765	39,00
M	22 x 0.75	DS	80	24	17	6	67766	39,00
M	22 x 1.0	DS	80	24	17	6	67767	39,00
M	22 x 1.25	DS	80	24	17	6	67768	39,00
M	22 x 1.5	DS	80	24	17	6	67769	39,00
M	22 x 2.0	DS	80	24	17	6	67770	39,00

VÖLKEL THREADING SOLUTIONS

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

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

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

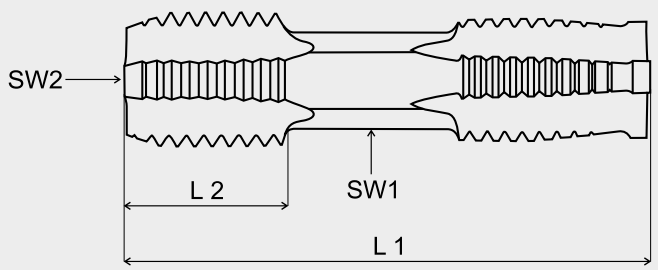
Size		Typ	L 1	L 2	SW1	SW2	Art.-No.	€
M	23 x 1.0	DS	80	24	17	6	67771	51,00
M	23 x 1.5	DS	80	24	17	6	67772	51,00
M	24 x 0.5	DS	80	24	19	8	67773	51,00
M	24 x 0,75	DS	80	24	19	8	67774	51,00
M	24 x 1.0	DS	80	24	19	8	67775	51,00
M	24 x 1,25	DS	80	24	19	8	67776	51,00
M	24 x 1.5	DS	90	27	19	8	67777	40,50
M	24 x 2.0	DS	90	27	17	8	67778	51,00
M	25 x 1.0	DS	90	27	19	8	67779	75,00
M	25 x 1.5	DS	90	27	19	8	67780	75,00
M	26 x 1.0	DS	90	27	19	8	67781	75,00
M	26 x 1.5	DS	90	27	19	8	67782	75,00
M	26 x 2.0	DS	90	27	19	8	67783	75,00
M	27 x 1.0	DS	90	27	19	8	67784	75,00
M	27 x 1.5	DS	90	27	19	8	67785	75,00
M	27 x 2.0	DS	90	27	19	8	67786	88,00
M	28 x 1.0	DS	90	27	19	8	67787	88,00
M	28 x 1.5	DS	90	27	19	8	67788	88,00
M	28 x 2.0	DS	90	27	19	8	67789	88,00
M	29 x 1.5	DS	90	27	19	8	67790	88,00
M	30 x 1.0	DS	90	27	24	10	67791	104,00
M	30 x 1.5	DS	90	27	24	10	67792	104,00
M	30 x 2.0	DS	90	27	24	10	67793	104,00
M	30 x 2.5	DS	90	27	22	10	67794	104,00
M	30 x 3.0	DS	90	27	22	10	67795	104,00
M	32 x 1.0	DS	90	27	24	10	67796	104,00
M	32 x 1.5	DS	90	27	24	10	67797	104,00
M	32 x 2.0	DS	90	27	24	10	67798	104,00
M	32 x 3.0	DS	90	27	24	10	67799	104,00
M	33 x 1.5	DS	100	29	24	10	67800	104,00
M	33 x 2.0	DS	100	29	24	10	67801	126,00
M	33 x 3.0	DS	100	29	24	10	67802	126,00
M	34 x 1.0	DS	100	29	27	10	67803	126,00
M	34 x 1.5	DS	100	29	27	10	67804	126,00
M	34 x 2.0	DS	100	29	27	10	67805	126,00
M	35 x 1.0	DS	100	29	27	10	67806	126,00
M	35 x 1.5	DS	100	29	27	10	67807	126,00
M	35 x 2.0	DS	100	29	27	10	67808	126,00
M	36 x 1.0	DS	100	29	27	10	67809	133,00
M	36 x 1.5	DS	100	29	27	10	67810	133,00
M	36 x 2.0	DS	100	29	27	10	67811	133,00
M	36 x 3.0	DS	100	29	27	10	67812	133,00
M	37 x 1.5	DS	100	29	27	10	67813	164,00
M	38 x 1.0	DS	110	32	27	12	67814	164,00
M	38 x 1.5	DS	110	32	27	12	67815	164,00
M	38 x 2.0	DS	110	32	27	12	67816	164,00
M	38 x 3.0	DS	110	32	27	12	67817	164,00
M	39 x 1.5	DS	110	32	32	12	67818	164,00
M	39 x 2.0	DS	110	32	27	12	67819	164,00

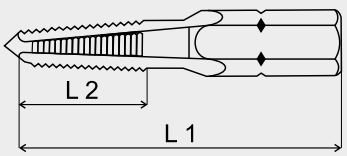
HexTap DS
Double Ended Tap, Multi-Drive

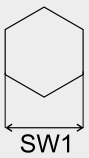
HexTap DS
maschi doppio, Multi-Drive

HSS-G **Mf Tol. ISO2/6H** **UN Tol. 2B** **Mf**

Size		Typ	L 1	L 2	SW1	SW2	Art.-No.	€
M	39 x 3.0	DS	110	32	27	12	67820	164,00
M	40 x 1.0	DS	110	32	32	12	67821	164,00
M	40 x 1.5	DS	110	32	32	12	67822	164,00
M	40 x 2.0	DS	110	32	32	12	67823	164,00
M	40 x 3.0	DS	110	32	27	12	67824	164,00
M	42 x 1.0	DS	110	32	32	12	67825	164,00
M	42 x 1.5	DS	110	27	32	12	67828	164,00
M	42 x 2.0	DS	110	27	32	12	67826	172,00
M	42 x 3.0	DS	110	27	32	12	67827	172,00
M	44 x 1.5	DS	110	27	36	12	67829	194,00
M	44 x 2.0	DS	110	27	36	12	67830	194,00
M	45 x 1.0	DS	110	27	36	17	67831	194,00
M	45 x 1.5	DS	110	27	36	17	67832	194,00
M	45 x 2.0	DS	110	27	36	17	67833	194,00
M	45 x 3.0	DS	110	27	36	17	67834	194,00
M	46 x 1.5	DS	110	27	36	17	67835	194,00
M	48 x 1.0	DS	140	45	36	17	67836	232,00
M	48 x 1.5	DS	140	45	36	17	67837	232,00
M	48 x 2.0	DS	140	45	36	17	67838	232,00
M	48 x 3.0	DS	140	45	36	17	67839	232,00
M	50 x 1.5	DS	140	42	41	17	67840	254,00
M	50 x 2.0	DS	140	42	41	17	67841	254,00
M	50 x 3.0	DS	140	42	36	17	67842	254,00
M	52 x 1.5	DS	140	42	41	19	67843	304,00
M	52 x 2.0	DS	140	42	41	19	67844	304,00
M	52 x 3.0	DS	140	42	41	19	67845	304,00
M	63 x 1.5	DS	160	47	50	19	67846	498,00

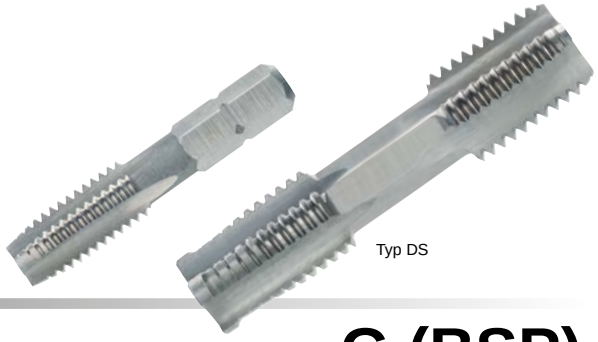






HexTap S
Threading-Bit, 1/4" Hexagon Shank
Pipe-thread DIN ISO 228

HexTap S
maschi con attacco esagonale 1/4”
filettatura per tubi gas DIN ISO 228



HSS-G

G (BSP)

Size	Typ	L 1	L 2	SW1	Art.-No.	€
G 1/8	S	40,5	17	1/4"	67870	7,30
G 1/4	DS	70	22	8	67871	13,50
G 3/8	DS	70	22	12	67872	18,00
G 1/2	DS	80	24	15	67873	24,30
G 3/4	DS	90	27	19	67874	36,50
G 1"	DS	100	29	24	67875	62,00
G 1.1/4	DS	110	27	32	67876	108,00
G 1.1/2	DS	140	42	36	67877	142,00
G 2"	DS	160	47	41	67878	284,00

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

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

HSS-G

UN

Size	Typ	L 1	L 2	SW1	SW2	Art.-No.	€
UN 1" x 8	DS	90	27	19	8	67901	75,00
UN 1.1/8 x 8	DS	90	27	19	8	67902	88,00
UN 1.1/4 x 8	DS	90	27	24	10	67903	104,00
UN 1.3/8 x 8	DS	100	29	27	10	67904	125,50
UN 1.1/2 x 8	DS	110	32	27	12	67905	163,00
UN 1.5/8 x 8	DS	110	32	32	12	67906	227,00
UN 1.3/4 x 8	DS	110	27	36	17	67907	227,00
UN 1.7/8 x 8	DS	140	45	36	17	67908	300,00
UN 2" x 8	DS	140	42	36	17	67909	303,00

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

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

HSS-G Tol. ISO2/6H

M

Nominal Diameter D	D 1	L 1	⬡	Art.-No.	€
M 3 x 0.5	2.5	36	1/4"	67226	6,40
M 4 x 0.7	3.3	39	1/4"	67230	6,40
M 5 x 0.8	4.2	41	1/4"	67234	6,40
M 6 x 1.0	5.0	44	1/4"	67238	6,40
M 8 x 1.25	6.8	50	1/4"	67242	8,80
M 10 x 1.5	8.5	59	1/4"	67246	10,60
TIN					
M 3 x 0.5	2.5	36	1/4"	67210	11,90
M 4 x 0.7	3.3	39	1/4"	67211	11,90
M 5 x 0.8	4.2	41	1/4"	67212	11,90
M 6 x 1.0	5.0	44	1/4"	67213	11,90
M 8 x 1.25	6.8	50	1/4"	67214	16,00
M 10 x 1.5	8.5	59	1/4"	67215	22,00

Technical Information:

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

Informazioni tecniche:

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

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

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

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

HSS-G **Tol. 2B**

UNC / UNF

Nominal Diameter D	D 1	L 1	⬡	Art.-No.	€
UNC					
UNC Nr. 4 x 40	2.3	36	1/4"	67280	9,00
UNC Nr. 5 x 40	2.6	36	1/4"	67281	9,00
UNC Nr. 6 x 32	2.85	39	1/4"	67282	9,00
UNC Nr. 8 x 32	3.5	39	1/4"	67283	9,00
UNC Nr. 10 x 24	3.9	41	1/4"	67284	9,00
UNC Nr. 12 x 24	4.5	41	1/4"	67285	9,00
UNC 1/4 x 20	5.2	44	1/4"	67286	9,00
UNC 5/16 x 18	6.6	50	1/4"	67287	12,00
UNC 3/8 x 16	8.0	59	1/4"	67288	15,00
UNF					
UNF Nr. 4 x 48	2.4	36	1/4"	67290	9,00
UNF Nr. 5 x 44	2.7	36	1/4"	67291	9,00
UNF Nr. 6 x 40	3.0	39	1/4"	67292	9,00
UNF Nr. 8 x 36	3.5	39	1/4"	67293	9,00
UNF Nr. 10 x 32	4.1	41	1/4"	67294	9,00
UNF Nr. 12 x 28	4.7	41	1/4"	67295	9,00
UNF 1/4 x 28	5.5	44	1/4"	67296	9,00
UNF 5/16 x 24	6.9	50	1/4"	67297	12,00
UNF 3/8 x 24	8.5	59	1/4"	67298	15,00

TriBit²
One Box for all occasions
Drilling, Tapping, Deburring
Combined and specific tools

TriBit²
una cassetta in ogni caso
foratura, filettare, sbarbare
utensili combinato e speciale

HSS-G

Tol. ISO2/6H

M

Nominal Diameter D					Art.-No.	€
M 3 x 0.5	2.5 mm	6.3 mm	M 3	M 3	67403	20,90
M 4 x 0.7	3.3 mm	8.3 mm	M 4	M 4	67404	20,90
M 5 x 0.8	4.2 mm	10.4 mm	M 5	M 5	67405	22,00
M 6 x 1.0	5.0 mm	12.4 mm	M 6	M 6	67406	22,50
M 8 x 1.25	6.8 mm	16.5 mm	M 8	M 8	67408	28,50
M 10 x 1.5	8.5 mm	20.5 mm	M 10	M 10	67410	33,00

Wood Drill Bits
with 1/4" Hexagon Drive

Punte per legna
con attacco esagonale 1/4”

HSS-G

Nominal Diameter D	L 1	S 2	⬡	Art.-No.	€
3.0 mm	38	16	1/4"	67630	3,10
4.0 mm	44	20	1/4"	67640	3,10
5.0 mm	50	26	1/4"	67650	3,10
6.0 mm	50	26	1/4"	67660	3,20
8.0 mm	51	32	1/4"	67680	3,75
10.0 mm	54	38	1/4"	67698	4,85

Drill Bits
with 1/4" Hexagon Drive

Punte elicoidale
con attacco esagonale 1/4”

HSS-G

M

Nominal Diameter D		L 1	S 2	⬡	Art.-No.	€
1.0 mm		32	7	1/4"	67110	3,20
1.5 mm		32	10	1/4"	67115	3,20
2.0 mm		34	12	1/4"	67120	3,20
2.5 mm	(M3)	36	14	1/4"	67125	3,20
3.0 mm		38	16	1/4"	67130	3,20
3.3 mm	(M4)	40	18	1/4"	67133	3,20
3.5 mm		40	18	1/4"	67135	3,20
4.0 mm		44	20	1/4"	67140	3,20
4.2 mm	(M5)	45	20	1/4"	67142	3,20
4.5 mm		46	24	1/4"	67145	3,20
5.0 mm	(M6)	50	26	1/4"	67150	3,20
5.5 mm		50	26	1/4"	67155	3,30
6.0 mm		50	26	1/4"	67160	3,30
6.5 mm		50	30	1/4"	67165	3,30
6.8 mm	(M8)	50	30	1/4"	67168	3,30
7.0 mm		50	30	1/4"	67170	3,30
7.5 mm		51	32	1/4"	67175	3,90
8.0 mm		51	32	1/4"	67180	3,90
8.5 mm	(M10)	53	33	1/4"	67185	4,50
9.0 mm		53	33	1/4"	67190	4,50
9.5 mm		54	38	1/4"	67195	5,00
10.0 mm		54	38	1/4"	67198	5,00
10.2 mm	(M12)	54	38	1/4"	67199	5,00

Countersink Bits
90° - 3 Flutes
with 1/4" Hexagon Drive

Frese per svasare
90° - 3 taglienti
con attacco esagonale ¼”

HSS

Nominal Diameter D	L 1	⬡	Art.-No.	€
6.3 mm	31	1/4"	67306	8,10
8.3 mm	31	1/4"	67308	8,10
10.4 mm	34	1/4"	67310	9,00
12.4 mm	35	1/4"	67312	9,50
16.5 mm	40	1/4"	67316	11,40
20.5 mm	41	1/4"	67320	14,30

Combined Machine Tap
metric ISO-thread DIN 13

Maschi combinati con punte
filettatura metrica ISO DIN 13

HSS-E

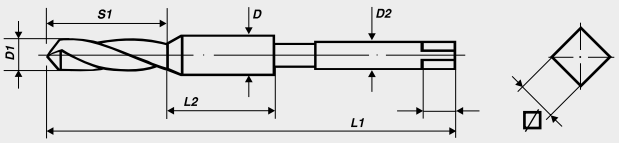
Nominal Diameter D		L 1	S 1	L 2	D 1	D 2	⧄	Art.-No.	€
M	Tol. ISO2/6H								
M	3 x 0.5	56	16	11	2.5	3.0	2.4	37026	16,20
M	4 x 0.7	63	18	14	3.3	4.0	3.0	37030	16,20
M	5 x 0.8	71	20	18	4.2	5.0	3.8	37034	16,20
M	6 x 1.0	80	22	22	5.0	6.0	4.9	37038	18,00
M	8 x 1.25	95	26	25	6.8	8.0	6.2	37042	20,60
M	10 x 1.5	106	30	31	8.5	10.0	8.0	37046	22,60
M	12 x 1.75	115	32	35	10.2	12.0	9.0	37050	26,50
SET									
M	3 - 12		M 3-4-5-6-8-10-12					47837	133,00
BSW	Tol. med.								
BSW	1/8 x 40	56	16	11	2.6	3.0	2.4	70006	16,50
BSW	5/32 x 32	63	18	14	3.2	4.0	3.0	70008	16,50
BSW	3/16 x 24	71	20	18	3.7	5.0	3.8	70010	16,50
BSW	1/4 x 20	80	22	22	5.1	6.0	4.9	70014	18,70
BSW	5/16 x 18	95	26	25	6.5	8.0	6.2	70016	20,90
BSW	3/8 x 16	106	30	31	7.9	10.0	8.0	70018	23,00
BSW	1/2 x 12	115	32	35	10.5	12.0	9.0	70022	28,00
SET									
BSW 1/8 - 1/2			BSW 1/8-5/32-3/16-1/4-5/16-3/8-1/2					47870	127,00

Application:

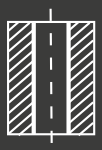
The Combined Tap enables the user to produce the tapping drill hole and the through thread in one operation without any tool changing.
The tool incorporates a twist drill before the thread-tapping part. It is possible with this tool to produce through threads up to a maximum threaded depth of 2 x D.
The Combined Tap is suitable for universal use in materials of medium mechanical strenght:
non-alloyed and alloyed steel sorts up to 600 N/mm², malleable cast iron, nodulized graphite cast iron, copper, brass, aluminium, aluminium-magnesium and zinc alloys, red bronze, electron metal, pressure-cast zinc.
It is sensible to use this tool on machines possesing an RPM switchover facility for drilling and tapping.
The feed rate must be adapted to the particular operation required - drilling or tapping.
Tapping chucks with pressure compensation may not be used.

Applicazioni:

Combinazione di maschio con punta per forare e maschiare velocemente in un'unica operazione, senza cambiare l'utensile. Una punta elicoidale precede il maschio.
Possono essere realizzati unicamente filetti per fori passanti con profondità massima pari a 2xD. I maschi combinati possono essere utilizzati per uso universale su materiali di media resistenza: acciai legati e non legati fino a 600 N/mm², ghisa, ghisa sferoidale, rame, ottone, alluminio, leghe di alluminio e magnesio, leghe di zinco, ghisa rossa, elektron e ghisa pressofusa allo zinco.
La velocità di taglio e l'avanzamento dovranno essere adattati secondo l'operazione svolta, foratura o maschiatura. Pertanto questi utensili vanno impiegati su macchine a velocità variabile con possibilità di regolazione dei numeri di giri. Non utilizzare con mandrini a compensazione di pressione.

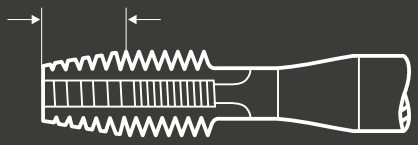


MACHINE TAPS HSS-E
MASCHI A MACCHINA HSS-E

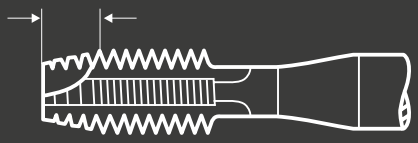


Through hole
per fori passanti

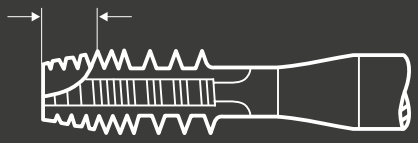
Form A
6-8 Threads Lead
Imbocco a 6-8 spire



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

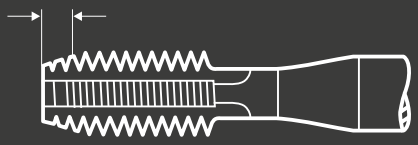


Form B-AZ
4-5 Threads Lead, Spiral Point with interrupted threads
Imbocco a 4-5 spire con imbocco corretto e denti alternati per fori passanti

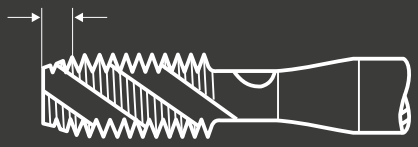


Blind hole
per fori ciechi

Form C
2-3 Threads Lead
Imbocco a 2-3 spire



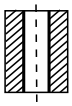
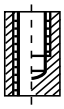
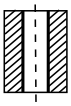
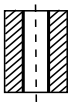
Form C/RSP
2-3 Threads Lead, 35° Spiral Flute
Imbocco a 2-3 spire spirale destra a 35°



MACHINE TAPS HSS-E
MASCHI A MACCHINA HSS-E

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

RECOMMENDED APPLICATION OF MACHINE TAPS
APPLICAZIONE RACCOMANDATA PER MASCHI A MACCHINA

Art.-No. M	373/383	374/384	375/385	376/386	377/387	379/389
Art.-No. Mf		394	395		397	
Art.-No. BSW			705/715		707/717	
Art.-No. UNC			745/755		747/757	
Art.-No. UNF			765/775		767/777	
Art.-No. G (BSP)		784	785		787	
Form/Forma	**A**	**C**	**B**	**15°RSP**	**35°RSP**	**B-AZ**
Typ of hole/Tipo di fori						
Material/Materiale						
Structural Steel up to 500N/mm² Acciaio da costruzione a 500 N/mm²	○	○	○	○	○	○
Structural Steel over 500 N/mm² Acciaio da costruzione da 500 N/mm²	○	○	○	○	○	
Free-cutting Steel Acciaio automatici			○		○	
Cementation Steel, heat treatable Steel Acciaio da cementazione, Acciai bonificato			○		○	○
Tool Steel Acciaio utensili			○		○	
Stainless Steel Acciaio inossidabile			○		○	○
Cast Steel Ghisa acciaiosa			○	○	○	
Cast Iron, spheroidal graphite Iron Ghisa grigia / Ghisa sferoidale		○				
Malleable Cast Iron Ghisa temprata	○	○	○	○	○	
Brass, short-chipping Ottone, truciolo corto		○				
Brass, long-chipping Ottone, truciolo lungo			○	○	○	
Bronzes Bronzo			○		○	
Copper Rame			○	○	○	
Al-alloys, short-chipping Alluminio, truciolo corto		○	○		○	
Al-alloys, long-chipping Alluminio, truciolo lungo			○	○	○	○
Zinc Alloys Leghe forgiate			○	○	○	
Magnesium Alloys Leghe di magnesio		○	○		○	○
Thermoplastics Materiali plastici, materiali termoplastici			○		○	
Thermosetting Plastics Materiali plastici, materiali termodurenti		○				

Standard TwinBox

Machine Tap + Twist Drill
metric ISO-thread DIN 13

TwinBox Standard

Maschi a macchina + punte
filettatura metrica ISO DIN 13

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

M

Nominal Diameter D				Art.-No.	€
Form B, Spiral Point / con imbocco corretto					
M	3 x 0.5	DIN 371	2.5 mm	37590	6,40
M	4 x 0.7	DIN 371	3.3 mm	37591	6,50
M	5 x 0.8	DIN 371	4.2 mm	37592	7,20
M	6 x 1.0	DIN 371	5.0 mm	37593	7,30
M	8 x 1.25	DIN 371	6.8 mm	37594	9,30
M	10 x 1.5	DIN 371	8.5 mm	37595	12,00
M	12 x 1.75	DIN 376	10.2 mm	38596	15,00
M	14 x 2.0	DIN 376	12.0 mm	38597	21,00
M	16 x 2.0	DIN 376	14.0 mm	38598	26,70
Form C, Spiral Flute / spirale destra a 35°					
M	3 x 0.5	DIN 371	2.5 mm	37790	7,60
M	4 x 0.7	DIN 371	3.3 mm	37791	7,70
M	5 x 0.8	DIN 371	4.2 mm	37792	8,40
M	6 x 1.0	DIN 371	5.0 mm	37793	8,50
M	8 x 1.25	DIN 371	6.8 mm	37794	10,70
M	10 x 1.5	DIN 371	8.5 mm	37795	13,80
M	12 x 1.75	DIN 376	10.2 mm	38796	17,20
M	14 x 2.0	DIN 376	12.0 mm	38797	23,00
M	16 x 2.0	DIN 376	14.0 mm	38798	30,00

Application:

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

Spiral Point for through holes
Spiral Flute for blind holes

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

Applicazione:

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

Forma B per fori passanti
35° per fori ciechi

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

VÖLKEL
THREADING SOLUTIONS

Machine Taps
metric ISO-thread DIN 13

Maschi a macchina
filettatura metrica ISO DIN 13

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

M

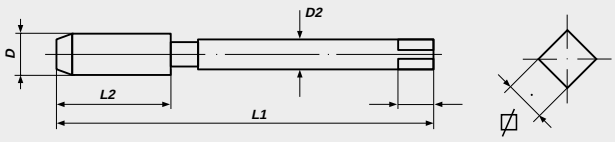
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
DIN 371						
M 2 x 0.4	45	8	2.8	2.1	37316	7,00
M 2.3 x 0.4	45	9	2.8	2.1	37318	7,00
M 2.5 x 0.45	50	9	2.8	2.1	37322	7,00
M 2.6 x 0.45	50	9	2.8	2.1	37324	7,00
M 3 x 0.5	56	11	3.5	2.7	37326	5,60
M 4 x 0.7	63	13	4.5	3.4	37330	5,60
M 5 x 0.8	70	16	6.0	4.9	37334	6,00
M 6 x 1.0	80	19	6.0	4.9	37338	6,00
M 8 x 1.25	90	22	8.0	6.2	37342	7,50
M 10 x 1.5	100	24	10.0	8.0	37346	9,30
DIN 376						
M 2 x 0.4	45	8	1.4	—	38316	7,00
M 3 x 0.5	56	11	2.2	—	38326	6,20
M 4 x 0.7	63	13	2.8	2.1	38330	6,20
M 5 x 0.8	70	16	3.5	2.7	38334	6,50
M 6 x 1.0	80	19	4.5	3.4	38338	6,50
M 8 x 1.25	90	22	6.0	4.9	38342	7,80
M 10 x 1.5	100	24	7.0	5.5	38346	9,80
M 12 x 1.75	110	29	9.0	7.0	38350	11,00
M 14 x 2.0	110	30	11.0	9.0	38354	14,50
M 16 x 2.0	110	32	12.0	9.0	38358	16,00
M 18 x 2.5	125	34	14.0	11.0	38362	23,00
M 20 x 2.5	140	34	16.0	12.0	38366	32,00
M 22 x 2.5	140	34	18.0	14.5	38370	35,00
M 24 x 3.0	160	38	18.0	14.5	38374	38,00
M 27 x 3.0	160	38	20.0	16.0	38376	60,00
M 30 x 3.5	180	45	22.0	18.0	38378	64,00
SET						
M 3 - 12	M 3-4-5-6-8-10 (DIN 371), M 12 (DIN 376)				47813	55,00

Application:

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

Applicazione:

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



Machine Taps
metric ISO-thread DIN 13

Maschi a macchina
filettatura metrica ISO DIN 13

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

M

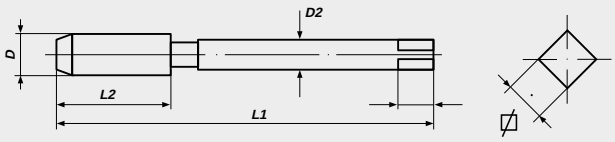
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
DIN 371						
M 2 x 0.4	45	8	2.8	2.1	37416	7,00
M 2.3 x 0.4	45	9	2.8	2.1	37418	7,00
M 2.5 x 0.45	50	9	2.8	2.1	37422	7,00
M 2.6 x 0.45	50	9	2.8	2.1	37424	7,00
M 3 x 0.5	56	11	3.5	2.7	37426	5,60
M 3.5 x 0.6	56	13	4.0	3.0	37428	6,30
M 4 x 0.7	63	13	4.5	3.4	37430	5,60
M 5 x 0.8	70	16	6.0	4.9	37434	6,00
M 6 x 1.0	80	19	6.0	4.9	37438	6,00
M 7 x 1.0	80	19	7.0	5.5	37440	8,30
M 8 x 1.25	90	22	8.0	6.2	37442	7,50
M 10 x 1.5	100	24	10.0	8.0	37446	9,30
DIN 376						
M 3 x 0.5	56	11	2.2	—	38426	6,20
M 4 x 0.7	63	13	2.8	2.1	38430	6,20
M 5 x 0.8	70	16	3.5	2.7	38434	6,50
M 6 x 1.0	80	19	4.5	3.4	38438	6,50
M 8 x 1.25	90	22	6.0	4.9	38442	7,80
M 10 x 1.5	100	24	7.0	5.5	38446	9,80
M 11 x 1.5	100	24	8.0	6.2	38448	11,00
M 12 x 1.75	110	29	9.0	7.0	38450	11,00
M 14 x 2.0	110	30	11.0	9.0	38454	14,50
M 16 x 2.0	110	32	12.0	9.0	38458	16,00
M 18 x 2.5	125	34	14.0	11.0	38462	23,00
M 20 x 2.5	140	34	16.0	12.0	38466	32,00
M 22 x 2.5	140	34	18.0	14.5	38470	35,00
M 24 x 3.0	160	38	18.0	14.5	38474	38,00
M 27 x 3.0	160	38	20.0	16.0	38476	60,00
M 30 x 3.5	180	45	22.0	18.0	38478	64,00
M 33 x 3.5	180	50	25.0	20.0	38480	90,00
M 36 x 4.0	200	56	28.0	22.0	38482	146,00
M 39 x 4.0	200	60	32.0	24.0	38484	185,00
M 42 x 4.5	200	60	32.0	24.0	38486	217,00
M 45 x 4.5	220	65	36.0	29.0	38488	250,00
M 48 x 5.0	250	70	36.0	29.0	38490	270,00
M 52 x 5.0	250	70	40.0	32.0	38492	330,00
SET						
M 3 - 12	M 3-4-5-6-8-10 (DIN 371), M 12 (DIN 376)				47814	55,00

Application:

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

Applicazione:

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



VÖLKEL
THREADING SOLUTIONS

Machine Taps
metric ISO-thread DIN 13

Maschi a macchina
filettatura metrica ISO DIN 13

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

M

Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
M 1 x 0.25	40	5	2.5	2.1	37502	20,00
M 1.1 x 0.25	40	5	2.5	2.1	37504	20,00
M 1.2 x 0.25	40	5	2.5	2.1	37506	20,00
M 1.4 x 0.3	40	7	2.5	2.1	37508	17,50
M 1.6 x 0.35	40	8	2.5	2.1	37510	17,50
M 1.7 x 0.35	40	8	2.5	2.1	37512	17,50
M 1.8 x 0.35	40	8	2.5	2.1	37514	17,50
M 2 x 0.4	45	8	2.8	2.1	37516	7,50
M 2.5 x 0.45	50	9	2.8	2.1	37522	7,50
M 3 x 0.5	56	11	3.5	2.7	37526	5,90
M 3.5 x 0.6	56	13	4.0	3.0	37528	6,50
M 4 x 0.7	63	13	4.5	3.4	37530	5,90
M 5 x 0.8	70	16	6.0	4.9	37534	6,30
M 6 x 1.0	80	19	6.0	4.9	37538	6,30
M 7 x 1.0	80	19	7.0	5.5	37540	9,00
M 8 x 1.25	90	22	8.0	6.2	37542	7,80
M 10 x 1.5	100	24	10.0	8.0	37546	9,80
TIN						
M 3 x 0.5	56	11	3.5	2.7	31526	9,00
M 4 x 0.7	63	13	4.5	3.4	31530	9,00
M 5 x 0.8	70	16	6.0	4.9	31534	9,40
M 6 x 1.0	80	19	6.0	4.9	31538	10,00
M 8 x 1.25	90	22	8.0	6.2	31542	12,50
M 10 x 1.5	100	24	10.0	8.0	31546	16,30
VAP						
M 3 x 0.5	56	11	3.5	2.7	31570	6,50
M 4 x 0.7	63	13	4.5	3.4	31571	6,50
M 5 x 0.8	70	16	6.0	4.9	31572	6,90
M 6 x 1.0	80	19	6.0	4.9	31573	6,90
M 8 x 1.25	90	22	8.0	6.2	31574	8,60
M 10 x 1.5	100	24	10.0	8.0	31575	10,80

Application:

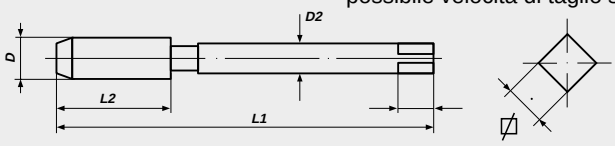
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through holes

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

Applicazione:

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

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



Machine Taps
metric ISO-thread DIN 13

Maschi a macchina
filettatura metrica ISO DIN 13

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

M

Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
M 3 x 0.5	56	11	2.2	—	38526	6,40
M 4 x 0.7	63	13	2.8	2.1	38530	6,40
M 5 x 0.8	70	16	3.5	2.7	38534	6,90
M 6 x 1.0	80	19	4.5	3.4	38538	6,90
M 8 x 1.25	90	22	6.0	4.9	38542	8,50
M 9 x 1.25	90	22	7.0	5.5	38544	10,20
M 10 x 1.5	100	24	7.0	5.5	38546	10,20
M 12 x 1.75	110	29	9.0	7.0	38550	11,80
M 14 x 2.0	110	30	11.0	9.0	38554	15,00
M 16 x 2.0	110	32	12.0	9.0	38558	17,00
M 18 x 2.5	125	34	14.0	11.0	38562	24,00
M 20 x 2.5	140	34	16.0	12.0	38566	32,00
M 22 x 2.5	140	34	18.0	14.5	38570	37,00
M 24 x 3.0	160	38	18.0	14.5	38574	39,00
M 27 x 3.0	160	38	20.0	16.0	38576	65,00
M 30 x 3.5	180	45	22.0	18.0	38578	67,00
M 33 x 3.5	180	50	25.0	20.0	38580	94,00
M 36 x 4.0	200	56	28.0	22.0	38582	153,00
M 39 x 4.0	200	60	32.0	24.0	38584	197,00
M 42 x 4.5	200	60	32.0	24.0	38586	230,00
M 45 x 4.5	220	65	36.0	29.0	38588	260,00
M 48 x 5.0	250	70	36.0	29.0	38590	285,00
M 52 x 5.0	250	70	40.0	32.0	38592	348,00
TIN						
M 12 x 1.75	110	29	9.0	7.0	31550	21,70
M 14 x 2.0	110	30	11.0	9.0	31554	26,00
M 16 x 2.0	110	32	12.0	9.0	31558	29,00
M 18 x 2.5	125	34	14.0	11.0	31562	39,90
M 20 x 2.5	140	34	16.0	12.0	31566	47,90
VAP						
M 12 x 1.75	110	29	9.0	7.0	31576	13,00
M 14 x 2.0	110	30	11.0	9.0	31577	16,50
M 16 x 2.0	110	32	12.0	9.0	31578	18,70
M 18 x 2.5	125	34	14.0	11.0	31579	26,40
M 20 x 2.5	140	34	16.0	12.0	31580	35,20

Application:

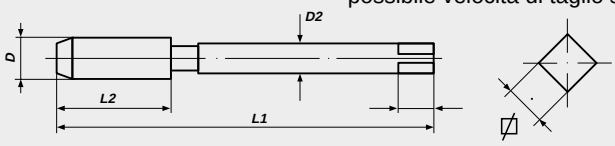
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through holes

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

Applicazione:

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

rivestimento TIN
- migliore resistenza all‘ abrasione e alla rottura
- eccellente uniformità
- possibile velocità di taglio superiore



VÖLKEL
THREADING SOLUTIONS

Machine Taps
metric ISO-thread DIN 13

Maschi a macchina
filettatura metrica ISO DIN 13

DIN 371 Form C/35°RSP HSS-E Tol. ISO2/6H

M

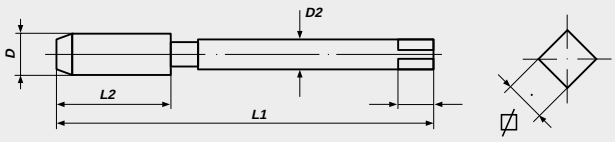
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
M 1 x 0.25	40	4	2.5	2.1	37702	22,00
M 1.1 x 0.25	40	4	2.5	2.1	37704	22,00
M 1.2 x 0.25	40	4	2.5	2.1	37706	22,00
M 1.4 x 0.3	40	5	2.5	2.1	37708	20,00
M 1.6 x 0.35	40	6	2.5	2.1	37710	20,00
M 1.7 x 0.35	40	6	2.5	2.1	37712	20,00
M 1.8 x 0.35	40	6	2.5	2.1	37714	20,00
M 2 x 0.4	45	6	2.8	2.1	37716	8,20
M 2.5 x 0.45	50	6	2.8	2.1	37722	8,20
M 3 x 0.5	56	6	3.5	2.7	37726	7,10
M 3.5 x 0.6	56	6	4.0	3.0	37728	7,80
M 4 x 0.7	63	7	4.5	3.4	37730	7,10
M 5 x 0.8	70	8	6.0	4.9	37734	7,80
M 6 x 1.0	80	10	6.0	4.9	37738	7,80
M 7 x 1.0	80	12	7.0	5.5	37740	10,80
M 8 x 1.25	90	14	8.0	6.2	37742	9,40
M 10 x 1.5	100	16	10.0	8.0	37746	11,80
TIN						
M 3 x 0.5	56	6	3.5	2.7	31726	10,20
M 4 x 0.7	63	7	4.5	3.4	31730	10,20
M 5 x 0.8	70	8	6.0	4.9	31734	10,90
M 6 x 1.0	80	10	6.0	4.9	31738	11,50
M 8 x 1.25	90	14	8.0	6.2	31742	14,10
M 10 x 1.5	100	16	10.0	8.0	31746	18,30
VAP						
M 3 x 0.5	56	6	3.5	2.7	31770	7,80
M 4 x 0.7	63	7	4.5	3.4	31771	7,80
M 5 x 0.8	70	8	6.0	4.9	31772	8,60
M 6 x 1.0	80	10	6.0	4.9	31773	8,60
M 8 x 1.25	90	14	8.0	6.2	31774	10,30
M 10 x 1.5	100	16	10.0	8.0	31775	13,00

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

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

Applicazione:
per uso universale
- Materiali con buona truciodibilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per fori ciechi

rivestimento TIN:
- migliore resistenza all‘ abrasione e alla rottura
- eccellente uniformità
- possibile velocità di taglio superiore



Machine Taps
metric ISO-thread DIN 13

Maschi a macchina
filettatura metrica ISO DIN 13

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

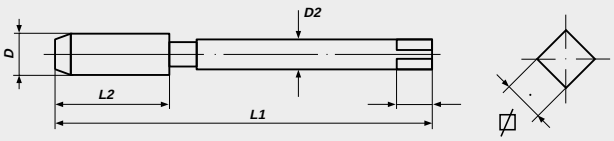
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
M 3 x 0.5	56	6	2.2	—	38726	7,80
M 4 x 0.7	63	7	2.8	2.1	38730	7,80
M 5 x 0.8	70	8	3.5	2.7	38734	8,20
M 6 x 1.0	80	10	4.5	3.4	38738	8,20
M 8 x 1.25	90	14	6.0	4.9	38742	10,00
M 10 x 1.5	100	16	7.0	5.5	38746	12,00
M 12 x 1.75	110	18	9.0	7.0	38750	14,00
M 14 x 2.0	110	20	11.0	9.0	38754	18,00
M 16 x 2.0	110	22	12.0	9.0	38758	20,00
M 18 x 2.5	125	25	14.0	11.0	38762	29,50
M 20 x 2.5	140	25	16.0	12.0	38766	39,00
M 22 x 2.5	140	27	18.0	14.5	38770	46,00
M 24 x 3.0	160	30	18.0	14.5	38774	48,00
M 27 x 3.0	160	30	20.0	16.0	38776	78,00
M 30 x 3.5	180	35	22.0	18.0	38778	82,00
M 33 x 3.5	180	35	25.0	20.0	38780	117,00
M 36 x 4.0	200	40	28.0	22.0	38782	185,00
M 39 x 4.0	200	40	32.0	24.0	38784	235,00
M 42 x 4.5	200	45	32.0	24.0	38786	280,00
M 45 x 4.5	220	45	36.0	29.0	38788	315,00
M 48 x 5.0	250	50	36.0	29.0	38790	345,00
M 52 x 5.0	250	50	40.0	32.0	38792	410,00
TIN						
M 12 x 1.75	110	18	9.0	7.0	31750	23,90
M 14 x 2.0	110	20	11.0	9.0	31754	29,00
M 16 x 2.0	110	22	12.0	9.0	31758	32,00
M 18 x 2.5	125	25	14.0	11.0	31762	45,40
M 20 x 2.5	140	25	16.0	12.0	31766	54,90
VAP						
M 12 x 1.75	110	18	9.0	7.0	31776	15,40
M 14 x 2.0	110	20	11.0	9.0	31777	19,80
M 16 x 2.0	110	22	12.0	9.0	31778	22,00
M 18 x 2.5	125	25	14.0	11.0	31779	32,50
M 20 x 2.5	140	25	16.0	12.0	31780	42,90

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

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

Applicazione:
per uso universale
- Materiali con buona truciodibilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per fori ciechi

rivestimento TIN:
- migliore resistenza all‘ abrasione e alla rottura
- eccellente uniformità
- possibile velocità di taglio superiore



Machine Taps
metric ISO-thread DIN 13

Maschi a macchina
filettatura metrica ISO DIN 13

DIN 371/376 Form C/15°RSP HSS-E Tol. ISO2/6H

M

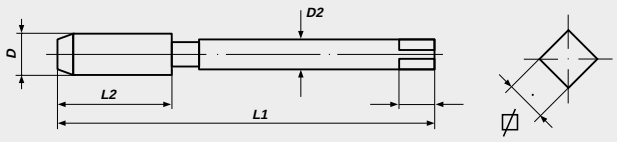
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
DIN 371						
M 3 x 0.5	56	11	3.5	2.7	37626	8,80
M 3.5 x 0.6	56	13	4.0	3.0	37628	9,10
M 4 x 0.7	63	13	4.5	3.4	37630	8,80
M 5 x 0.8	70	16	6.0	4.9	37634	9,40
M 6 x 1.0	80	19	6.0	4.9	37638	9,40
M 7 x 1.0	80	19	7.0	5.5	37640	11,90
M 8 x 1.25	90	22	8.0	6.2	37642	11,60
M 10 x 1.5	100	24	10.0	8.0	37646	13,40
DIN 376						
M 3 x 0.5	56	11	2.2	—	38626	8,80
M 4 x 0.7	63	13	2.8	2.1	38630	8,80
M 5 x 0.8	70	16	3.5	2.7	38634	9,40
M 6 x 1.0	80	19	4.5	3.4	38638	9,40
M 8 x 1.25	90	22	6.0	4.9	38642	11,60
M 10 x 1.5	100	24	7.0	5.5	38646	13,40
M 12 x 1.75	110	29	9.0	7.0	38650	16,00
M 14 x 2.0	110	30	11.0	9.0	38654	21,50
M 16 x 2.0	110	32	12.0	11.0	38658	23,30
M 18 x 2.5	125	34	14.0	11.0	38662	33,50
M 20 x 2.5	140	34	16.0	12.0	38666	43,50
M 22 x 2.5	140	34	18.0	14.5	38670	50,00
M 24 x 3.0	160	38	18.0	14.5	38674	53,00
SET						
M 3 - 12	M 3-4-5-6-8-10 (DIN 371), M 12 (DIN 376)				47816	73,00

Application:

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

Applicazione:

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



Machine Taps
metric ISO-thread DIN 13

Maschi a macchina
filettatura metrica ISO DIN 13

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

M

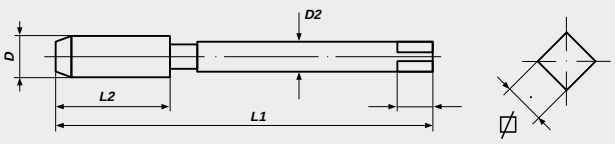
Nominal Diameter D	L 1	L 2	D 2	⌀	Art.-No.	€
DIN 371						
M 3 x 0.5	56	11	3.5	2.7	37926	8,20
M 4 x 0.7	63	13	4.5	3.4	37930	8,20
M 5 x 0.8	70	16	6.0	4.9	37934	8,80
M 6 x 1.0	80	19	6.0	4.9	37938	8,80
M 8 x 1.25	90	22	8.0	6.2	37942	10,90
M 10 x 1.5	100	24	10.0	8.0	37946	13,00
DIN 376						
M 3 x 0.5	56	11	2.2	—	38926	8,80
M 4 x 0.7	63	13	2.8	2.1	38930	8,80
M 5 x 0.8	70	16	3.5	2.7	38934	9,20
M 6 x 1.0	80	19	4.5	3.4	38938	9,20
M 8 x 1.25	90	22	6.0	4.9	38942	11,50
M 10 x 1.5	100	24	7.0	5.5	38946	13,80
M 12 x 1.75	110	29	9.0	7.0	38950	16,00
M 14 x 2.0	110	30	11.0	9.0	38954	21,50
M 16 x 2.0	110	32	12.0	9.0	38958	23,00
M 18 x 2.5	125	34	14.0	11.0	38962	32,50
M 20 x 2.5	140	34	16.0	12.0	38966	43,00
M 22 x 2.5	140	34	18.0	14.5	38970	50,00
M 24 x 3.0	160	38	18.0	14.5	38974	53,00
SET						
M 3 - 12	M 3-4-5-6-8-10 (DIN 371), M 12 (DIN 376)				47819	77,00

Application:

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

Applicazione:

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



VÖLKEL
THREADING SOLUTIONS

Machine Taps, *extra long*
metric ISO-thread DIN 13

Maschi a macchina, *extra lungo*
filettatura metrica ISO DIN 13

≈ DIN 371 Form B HSS-E Tol. ISO2/6H

M

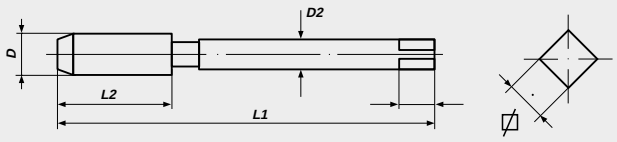
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
100 mm						
M 3 x 0.5	100	11	3.5	2.7	32010	8,40
M 4 x 0.7	100	13	4.5	3.4	32011	8,40
M 5 x 0.8	100	16	6.0	4.9	32012	8,90
M 6 x 1.0	100	19	6.0	4.9	32013	8,90
M 8 x 1.25	100	22	8.0	6.2	32014	10,70
M 10 x 1.5	100	24	10.0	8.0	32015	11,20
M 12 x 1.75	100	29	12.0	9.0	32016	12,60
120 mm						
M 4 x 0.7	120	13	4.5	3.4	32021	8,90
M 5 x 0.8	120	16	6.0	4.9	32022	9,70
M 6 x 1.0	120	19	6.0	4.9	32023	9,70
M 8 x 1.25	120	22	8.0	6.2	32024	11,30
M 10 x 1.5	120	24	10.0	8.0	32025	12,80
M 12 x 1.75	120	29	12.0	9.0	32026	14,90
150 mm						
M 4 x 0.7	150	13	4.5	3.4	32031	9,40
M 5 x 0.8	150	16	6.0	4.9	32032	10,40
M 6 x 1.0	150	19	6.0	4.9	32033	10,40
M 8 x 1.25	150	22	8.0	6.2	32034	12,70
M 10 x 1.5	150	24	10.0	8.0	32035	15,50
M 12 x 1.75	150	29	12.0	9.0	32036	18,20
150 mm with reduced shank / con gambo passante						
M 4 x 0.7	150	13	2.8	2.1	32071	9,40
M 5 x 0.8	150	16	3.5	2.7	32072	10,40
M 6 x 1.0	150	19	4.5	3.4	32073	10,40
M 8 x 1.25	150	22	6.0	4.9	32074	12,70
M 10 x 1.5	150	24	7.0	5.5	32075	15,50
M 12 x 1.75	150	29	9.0	7.0	32076	18,20

Application:

for general use in awkward places
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through holes

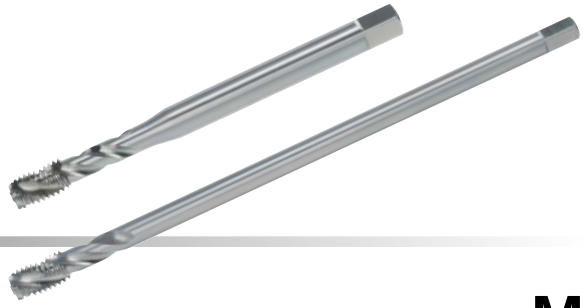
Applicazione:

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



Machine Taps, *extra long*
metric ISO-thread DIN 13

Maschi a macchina, *extra lungo*
filettatura metrica ISO DIN 13



≈ DIN 371 Form C/35°RSP HSS-E Tol. ISO2/6H

M

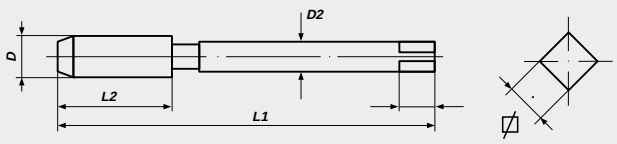
Nominal Diameter D	L 1	L 2	D 2	⌀	Art.-No.	€
100 mm						
M 3 x 0.5	100	6	3.5	2.7	32040	10,10
M 4 x 0.7	100	7	4.5	3.4	32041	10,10
M 5 x 0.8	100	8	6.0	4.9	32042	10,90
M 6 x 1.0	100	10	6.0	4.9	32043	10,90
M 8 x 1.25	100	14	8.0	6.2	32044	12,60
M 10 x 1.5	100	16	10.0	8.0	32045	13,60
M 12 x 1.75	100	18	12.0	9.0	32046	13,80
120 mm						
M 4 x 0.7	120	7	4.5	3.4	32051	10,50
M 5 x 0.8	120	8	6.0	4.9	32052	11,60
M 6 x 1.0	120	10	6.0	4.9	32053	11,60
M 8 x 1.25	120	14	8.0	6.2	32054	13,30
M 10 x 1.5	120	16	10.0	8.0	32055	15,20
M 12 x 1.75	120	18	12.0	9.0	32056	16,10
150 mm						
M 4 x 0.7	150	7	4.5	3.4	32061	10,90
M 5 x 0.8	150	8	6.0	4.9	32062	12,40
M 6 x 1.0	150	10	6.0	4.9	32063	12,40
M 8 x 1.25	150	14	8.0	6.2	32064	14,70
M 10 x 1.5	150	16	10.0	8.0	32065	17,80
M 12 x 1.75	150	18	12.0	9.0	32066	19,30
150 mm with reduced shank / con gambo passante						
M 4 x 0.7	150	7	2.8	2.1	32081	10,90
M 5 x 0.8	150	8	3.5	2.7	32082	12,40
M 6 x 1.0	150	10	4.5	3.4	32083	12,40
M 8 x 1.25	150	14	6.0	4.9	32084	14,70
M 10 x 1.5	150	16	7.0	5.5	32085	17,80
M 12 x 1.75	150	18	9.0	7.0	32086	19,30

Application:

for general use in awkward places
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for blind holes

Applicazione:

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



Machine Taps, *with oversize*

metric ISO-thread DIN 13

Maschi a macchina, *tolleranza maggiorata*

filettatura metrica ISO DIN 13

DIN 371/376 Form B HSS-E

M

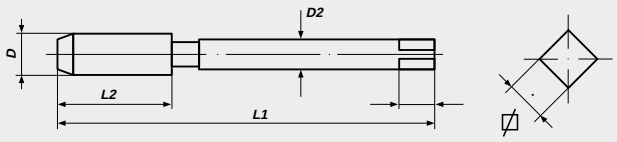
Nominal Diameter D		L 1	L 2	D 2	⌀	Art.-No.	€
6G		DIN 371					
M	2.5 x 0.45	50	9	2.8	2.1	32522	7,90
M	3 x 0.5	56	11	3.5	2.7	32526	7,90
M	4 x 0.7	63	13	4.5	3.4	32530	7,90
M	5 x 0.8	70	16	6.0	4.9	32534	8,20
M	6 x 1.0	80	19	6.0	4.9	32538	8,20
M	8 x 1.25	90	22	8.0	6.2	32542	10,10
M	10 x 1.5	100	24	10.0	8.0	32546	11,60
		DIN 376					
M	12 x 1.75	110	29	9.0	7.0	32550	13,90
M	14 x 2.0	110	30	11.0	9.0	32554	20,00
M	16 x 2.0	110	32	12.0	9.0	32558	23,10
M	18 x 2.5	125	34	14.0	11.0	32562	31,50
M	20 x 2.5	140	34	16.0	12.0	32566	44,10
7G		DIN 371					
M	3 x 0.5	56	11	3.5	2.7	32503	8,00
M	4 x 0.7	63	13	4.5	3.4	32504	8,00
M	5 x 0.8	70	16	6.0	4.9	32505	8,40
M	6 x 1.0	80	19	6.0	4.9	32506	8,40
M	8 x 1.25	90	22	8.0	6.2	32508	10,70
M	10 x 1.5	100	24	10.0	8.0	32510	12,70
		DIN 376					
M	12 x 1.75	110	29	9.0	7.0	32512	14,70
+ 0,1 mm		DIN 371					
M	3 x 0.5	56	11	3.5	2.7	32583	8,00
M	4 x 0.7	63	13	4.5	3.4	32584	8,00
M	5 x 0.8	70	16	6.0	4.9	32585	8,40
M	6 x 1.0	80	19	6.0	4.9	32586	8,40
M	8 x 1.25	90	22	8.0	6.2	32588	10,70
M	10 x 1.5	100	24	10.0	8.0	32590	12,70
		DIN 376					
M	12 x 1.75	110	29	9.0	7.0	32592	14,70

Application:

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

Applicazione:

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



Machine Taps, *with undersize*
metric ISO-thread DIN13

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

DIN 371/376 Form B HSS-E Tol. ISO1/4H

M

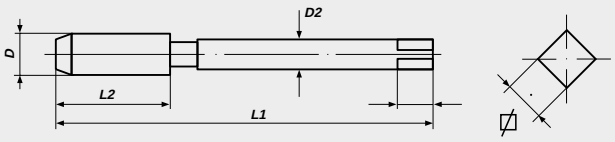
Nominal Diameter D		L 1	L 2	D 2	☐	Art.-No.	€
4H		DIN 371					
M	3 x 0.5	56	11	3.5	2.7	32612	8,00
M	4 x 0.7	63	13	4.5	3.4	32614	8,00
M	5 x 0.8	70	16	6.0	4.9	32616	8,40
M	6 x 1.0	80	19	6.0	4.9	32618	8,40
M	8 x 1.25	90	22	8.0	6.2	32620	10,70
M	10 x 1.5	100	24	10.0	8.0	32622	12,70
		DIN 376					
M	12 x 1.75	110	29	9.0	7.0	32624	14,70
M	14 x 2.0	110	30	11.0	9.0	32625	20,00
M	16 x 2.0	110	32	12.0	9.0	32626	23,10

Application:

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

Applicazione:

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



Machine Taps, *with oversize*

metric ISO-thread DIN 13

Maschi a macchina, *tolleranza maggiorata*

filettatura metrica ISO DIN 13

DIN 371/376 Form C/35°RSP HSS-E

M

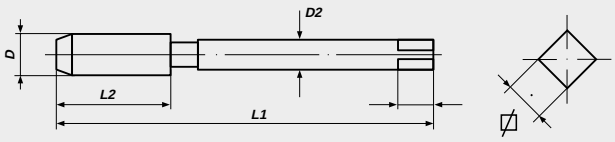
Nominal Diameter D		L 1	L 2	D 2	⧄	Art.-No.	€
6G		DIN 371					
M	3 x 0.5	56	6	3.5	2.7	32726	9,50
M	4 x 0.7	63	7	4.5	3.4	32730	9,50
M	5 x 0.8	70	8	6.0	4.9	32734	9,90
M	6 x 1.0	80	10	6.0	4.9	32738	9,90
M	8 x 1.25	90	14	8.0	6.2	32742	12,10
M	10 x 1.5	100	16	10.0	8.0	32746	14,00
		DIN 376					
M	12 x 1.75	110	18	9.0	7.0	32750	15,20
M	14 x 2.0	110	20	11.0	9.0	32754	22,00
M	16 x 2.0	110	22	12.0	9.0	32758	23,00
M	18 x 2.5	125	25	14.0	11.0	32762	34,50
M	20 x 2.5	140	25	16.0	12.0	32766	48,00
7G		DIN 371					
M	3 x 0.5	56	6	3.5	2.7	32703	9,70
M	4 x 0.7	63	7	4.5	3.4	32704	9,70
M	5 x 0.8	70	8	6.0	4.9	32705	10,40
M	6 x 1.0	80	10	6.0	4.9	32706	10,40
M	8 x 1.25	90	14	8.0	6.2	32708	13,40
M	10 x 1.5	100	16	10.0	8.0	32710	15,80
		DIN 376					
M	12 x 1.75	110	18	9.0	7.0	32712	17,00
+ 0,1 mm		DIN 371					
M	3 x 0.5	56	6	3.5	2.7	32783	9,70
M	4 x 0.7	63	7	4.5	3.4	32784	9,70
M	5 x 0.8	70	8	6.0	4.9	32785	10,40
M	6 x 1.0	80	10	6.0	4.9	32786	10,40
M	8 x 1.25	90	14	8.0	6.2	32788	13,40
M	10 x 1.5	100	16	10.0	8.0	32790	15,80
		DIN 376					
M	12 x 1.75	110	18	9.0	7.0	32792	17,00

Application:

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

Applicazione:

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



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

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

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

M

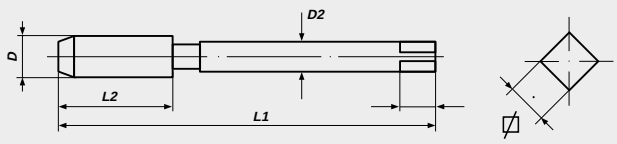
Nominal Diameter D	L 1	L 2	D 2	⌀	Art.-No.	€
4H	DIN 371					
M 3 x 0.5	56	6	3.5	2.7	32652	9,70
M 4 x 0.7	63	7	4.5	3.4	32654	9,70
M 5 x 0.8	70	8	6.0	4.9	32656	10,40
M 6 x 1.0	80	10	6.0	4.9	32658	10,40
M 8 x 1.25	90	14	8.0	6.2	32660	13,40
M 10 x 1.5	100	16	10.0	8.0	32662	15,80
	DIN 376					
M 12 x 1.75	110	18	9.0	7.0	32664	17,00
M 14 x 2.0	110	20	11.0	9.0	32665	24,20
M 16 x 2.0	110	22	12.0	9.0	32666	25,20

Application:

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

Applicazione:

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



VÖLKEL THREADING SOLUTIONS

Machine Taps
metric-fine ISO-thread DIN 13

Maschi a macchina
filettatura metrica fine ISO DIN 13

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

Nominal Diameter D	L 1	L 2	D 2	⌀	Art.-No.	€
M 4 x 0.35	63	10	2.8	2.1	39402	10,90
M 5 x 0.5	70	12	3.5	2.7	39404	10,90
M 6 x 0.75	80	14	4.5	3.4	39407	10,90
M 8 x 0.75	80	19	6.0	4.9	39410	10,90
M 8 x 1.0	90	22	6.0	4.9	39411	10,90
M 10 x 1.0	90	20	7.0	5.5	39415	13,10
M 10 x 1.25	100	24	7.0	5.5	39416	13,10
M 12 x 1.0	100	22	9.0	7.0	39420	17,00
M 12 x 1.25	100	22	9.0	7.0	39421	17,50
M 12 x 1.5	100	22	9.0	7.0	39422	17,00
M 14 x 1.0	100	22	11.0	9.0	39426	21,10
M 14 x 1.25	100	22	11.0	9.0	39427	21,10
M 14 x 1.5	100	22	11.0	9.0	39428	21,10
M 16 x 1.0	100	22	12.0	9.0	39431	25,00
M 16 x 1.5	100	22	12.0	9.0	39433	25,00
M 18 x 1.0	110	25	14.0	11.0	39434	29,70
M 18 x 1.5	110	25	14.0	11.0	39436	29,70
M 18 x 2.0	125	34	14.0	11.0	39437	29,70
M 20 x 1.0	125	25	16.0	12.0	39438	32,30
M 20 x 1.25	125	25	16.0	12.0	39439	32,30
M 20 x 1.5	125	25	16.0	12.0	39440	32,30
M 20 x 2.0	140	34	16.0	12.0	39441	32,30
M 22 x 1.0	125	25	18.0	14.5	39443	41,00
M 22 x 1.5	125	25	18.0	14.5	39445	41,00
M 22 x 2.0	140	34	18.0	14.5	39446	41,00
M 24 x 1.0	140	28	18.0	14.5	39448	48,00
M 24 x 1.5	140	28	18.0	14.5	39450	48,00
M 24 x 2.0	140	28	18.0	14.5	39451	48,00
M 25 x 1.0	140	28	18.0	14.5	39452	48,00
M 26 x 1.5	140	28	18.0	14.5	39454	48,00
M 27 x 1.5	140	28	20.0	16.0	39456	60,00
M 27 x 2.0	140	28	20.0	16.0	39457	60,00
M 28 x 1.5	140	28	20.0	16.0	39459	60,00
M 30 x 1.5	150	28	22.0	18.0	39463	69,00
M 30 x 2.0	150	28	22.0	18.0	39464	69,00
M 32 x 1.5	150	28	22.0	18.0	39466	88,00
M 32 x 2.0	150	28	22.0	18.0	39467	88,00
M 33 x 2.0	160	30	25.0	20.0	39468	88,00
M 35 x 1.5	170	30	28.0	22.0	39472	88,00
M 36 x 1.5	170	30	28.0	22.0	39473	110,00
M 36 x 2.0	170	30	28.0	22.0	39474	110,00
M 38 x 1.5	170	30	28.0	22.0	39476	118,00
M 40 x 1.5	170	30	32.0	24.0	39480	128,00
M 42 x 1.5	170	30	32.0	24.0	39483	142,00
M 45 x 1.5	180	32	36.0	29.0	39486	166,00
M 48 x 1.5	190	32	36.0	29.0	39489	202,00
M 50 x 1.5	190	32	36.0	29.0	39494	233,00
M 52 x 1.5	190	32	40.0	32.0	39497	256,00

Machine Taps
metric-fine ISO-thread DIN 13

Maschi a macchina
filettatura metrica fine ISO DIN 13

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

Mf

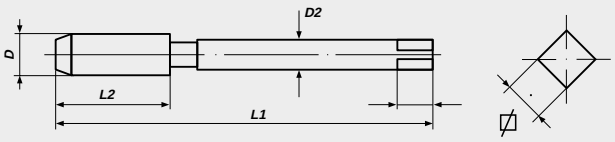
Nominal Diameter D		L 1	L 2	D 2	⌀	Art.-No.	€
M	3 x 0.35	56	9	2.2	-	39501	12,20
M	4 x 0.35	63	10	2.8	2.1	39502	12,20
M	4 x 0.5	63	10	2.8	2.1	39503	12,20
M	5 x 0.5	70	12	3.5	2.7	39504	12,20
M	5 x 0.75	70	12	3.5	2.7	39505	12,20
M	6 x 0.5	80	14	4.5	3.4	39506	12,20
M	6 x 0.75	80	14	4.5	3.4	39507	12,20
M	7 x 0.75	80	14	5.5	4.3	39508	12,20
M	8 x 0.5	80	19	6.0	4.9	39509	12,20
M	8 x 0.75	80	19	6.0	4.9	39510	12,20
M	8 x 1.0	90	22	6.0	4.9	39511	12,20
M	9 x 0.75	80	19	7.0	5.5	39512	12,20
M	9 x 1.0	90	22	7.0	5.5	39513	12,20
M	10 x 0.75	90	20	7.0	5.5	39514	14,10
M	10 x 1.0	90	20	7.0	5.5	39515	14,10
M	10 x 1.25	100	24	7.0	5.5	39516	14,10
M	11 x 1.0	90	20	8.0	6.2	39517	19,40
M	11 x 1.25	90	22	8.0	6.2	39518	19,40
M	12 x 0.75	100	22	9.0	7.0	39519	19,40
M	12 x 1.0	100	22	9.0	7.0	39520	19,40
M	12 x 1.25	100	22	9.0	7.0	39521	19,40
M	12 x 1.5	100	22	9.0	7.0	39522	19,40
M	13 x 1.0	100	22	11.0	9.0	39523	25,00
M	13 x 1.5	100	22	11.0	9.0	39524	25,00
M	14 x 0.75	100	22	11.0	9.0	39525	25,00
M	14 x 1.0	100	22	11.0	9.0	39526	25,00
M	14 x 1.25	100	22	11.0	9.0	39527	25,00
M	14 x 1.5	100	22	11.0	9.0	39528	25,00
M	15 x 1.0	100	22	12.0	9.0	39529	27,50
M	15 x 1.5	100	22	12.0	9.0	39530	27,50
M	16 x 1.0	100	22	12.0	9.0	39531	28,00
M	16 x 1.25	100	22	12.0	9.0	39532	28,00
M	16 x 1.5	100	22	12.0	9.0	39533	28,00
M	18 x 1.0	110	25	14.0	11.0	39534	34,00
M	18 x 1.25	110	25	14.0	11.0	39535	34,00
M	18 x 1.5	110	25	14.0	11.0	39536	34,00
M	18 x 2.0	125	34	14.0	11.0	39537	34,00

Application:

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

Applicazione:

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



Machine Taps
metric-fine ISO-thread DIN 13

Maschi a macchina
filettatura metrica fine ISO DIN 13

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

Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
M 20 x 1.0	125	25	16.0	12.0	39538	38,00
M 20 x 1.25	125	25	16.0	12.0	39539	38,00
M 20 x 1.5	125	25	16.0	12.0	39540	38,00
M 20 x 2.0	140	34	16.0	12.0	39541	38,00
M 21 x 1.5	125	25	16.0	12.0	39542	38,00
M 22 x 1.0	125	25	18.0	14.5	39543	46,00
M 22 x 1.25	125	25	18.0	14.5	39544	46,00
M 22 x 1.5	125	25	18.0	14.5	39545	46,00
M 22 x 2.0	140	34	18.0	14.5	39546	46,00
M 23 x 1.5	125	25	18.0	14.5	39547	54,00
M 24 x 1.0	140	28	18.0	14.5	39548	54,00
M 24 x 1.25	140	28	18.0	14.5	39549	54,00
M 24 x 1.5	140	28	18.0	14.5	39550	54,00
M 24 x 2.0	140	28	18.0	14.5	39551	54,00
M 25 x 1.0	140	28	18.0	14.5	39552	57,00
M 25 x 1.5	140	28	18.0	14.5	39553	57,00
M 26 x 1.0	140	28	18.0	14.5	3955X	57,00
M 26 x 1.5	140	28	18.0	14.5	39554	57,00
M 26 x 2.0	140	28	18.0	14.5	39555	57,00
M 27 x 1.0	140	28	20.0	16.0	39500	68,00
M 27 x 1.5	140	28	20.0	16.0	39556	68,00
M 27 x 2.0	140	28	20.0	16.0	39557	68,00
M 28 x 1.0	140	28	20.0	16.0	39558	68,00
M 28 x 1.5	140	28	20.0	16.0	39559	68,00
M 28 x 2.0	140	28	20.0	16.0	39560	68,00
M 29 x 1.5	150	28	22.0	18.0	39561	77,00
M 30 x 1.0	150	28	22.0	18.0	39562	77,00
M 30 x 1.5	150	28	22.0	18.0	39563	77,00
M 30 x 2.0	150	28	22.0	18.0	39564	77,00
M 30 x 2.5	180	45	22.0	18.0	3956X	77,00
M 30 x 3.0	180	45	22.0	18.0	39565	77,00
M 32 x 1.5	150	28	22.0	18.0	39566	94,00
M 32 x 2.0	150	28	22.0	18.0	39567	94,00
M 32 x 3.0	180	50	22.0	18.0	39592	94,00
M 33 x 1.5	160	30	25.0	20.0	39593	94,00
M 33 x 2.0	160	30	25.0	20.0	39568	94,00
M 33 x 3.0	180	50	25.0	20.0	39569	94,00

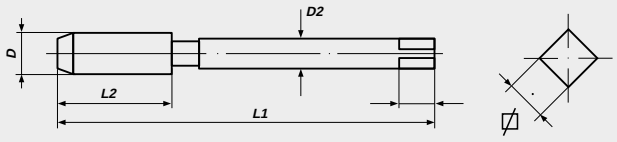
►►►

Application:

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

Applicazione:

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



Machine Taps
metric-fine ISO-thread DIN 13

Maschi a macchina
filettatura metrica fine ISO DIN 13

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

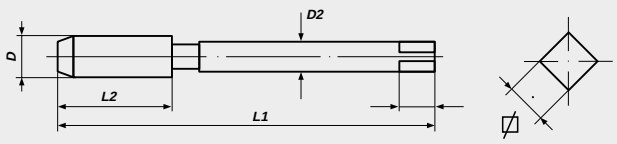
Nominal Diameter D	L 1	L 2	D 2	⌀	Art.-No.	€
M 34 x 1.5	170	30	28.0	22.0	39570	94,00
M 34 x 2.0	170	30	28.0	22.0	39571	94,00
M 35 x 1.5	170	30	28.0	22.0	39572	94,00
M 36 x 1.5	170	30	28.0	22.0	39573	118,00
M 36 x 2.0	170	30	28.0	22.0	39574	118,00
M 36 x 3.0	200	56	28.0	22.0	39575	118,00
M 38 x 1.5	170	30	28.0	22.0	39576	125,00
M 39 x 1.5	170	30	32.0	24.0	39577	125,00
M 39 x 2.0	170	30	32.0	24.0	39578	125,00
M 39 x 3.0	200	60	32.0	24.0	39579	125,00
M 40 x 1.5	170	30	32.0	24.0	39580	138,00
M 40 x 2.0	170	30	32.0	24.0	39581	138,00
M 40 x 3.0	200	60	32.0	24.0	39582	138,00
M 42 x 1.5	170	30	32.0	24.0	39583	156,00
M 42 x 2.0	170	30	32.0	24.0	39584	156,00
M 42 x 3.0	200	60	32.0	24.0	39585	156,00
M 45 x 1.5	180	32	36.0	29.0	39586	182,00
M 45 x 2.0	180	32	36.0	29.0	39587	182,00
M 45 x 3.0	200	50	36.0	29.0	39588	182,00
M 48 x 1.5	190	32	36.0	29.0	39589	218,00
M 48 x 2.0	190	32	36.0	29.0	39590	218,00
M 48 x 3.0	225	50	36.0	29.0	39591	218,00
M 50 x 1.5	190	32	36.0	29.0	39594	256,00
M 50 x 2.0	190	32	36.0	29.0	39595	256,00
M 50 x 3.0	225	50	36.0	29.0	39596	256,00
M 52 x 1.5	190	32	40.0	32.0	39597	280,00
M 52 x 2.0	190	32	40.0	32.0	39598	280,00
M 52 x 3.0	225	50	40.0	32.0	39599	280,00
M 63 x 1.5	275	50	50.0	39.0	3959X	498,00

Application:

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

Applicazione:

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



Machine Taps
metric-fine ISO-thread DIN 13

Maschi a macchina
filettatura metrica fine ISO DIN 13

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

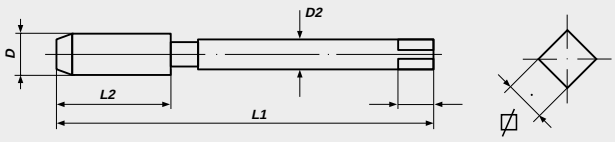
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
M 3 x 0.35	56	5	2.2	-	39701	13,80
M 4 x 0.35	63	5	2.8	2.1	39702	13,80
M 4 x 0.5	63	5	2.8	2.1	39703	13,80
M 5 x 0.5	70	5	3.5	2.7	39704	13,80
M 5 x 0.75	70	8	3.5	2.7	39705	13,80
M 6 x 0.5	80	5	4.5	3.4	39706	13,80
M 6 x 0.75	80	8	4.5	3.4	39707	13,80
M 7 x 0.75	80	8	5.5	4.3	39708	13,80
M 8 x 0.5	80	8	6.0	4.9	39709	13,80
M 8 x 0.75	80	8	6.0	4.9	39710	13,80
M 8 x 1.0	90	10	6.0	4.9	39711	13,80
M 9 x 0.75	80	10	7.0	5.5	39712	13,80
M 9 x 1.0	90	10	7.0	5.5	39713	13,80
M 10 x 0.75	90	10	7.0	5.5	39714	16,30
M 10 x 1.0	90	10	7.0	5.5	39715	16,30
M 10 x 1.25	100	16	7.0	5.5	39716	16,30
M 11 x 1.0	90	11	8.0	6.2	39717	21,00
M 11 x 1.25	90	14	8.0	6.2	39718	21,00
M 12 x 0.75	100	10	9.0	7.0	39719	21,00
M 12 x 1.0	100	11	9.0	7.0	39720	21,00
M 12 x 1.25	100	15	9.0	7.0	39721	21,00
M 12 x 1.5	100	15	9.0	7.0	39722	21,00
M 13 x 1.0	100	11	11.0	9.0	39723	25,70
M 13 x 1.5	100	15	11.0	9.0	39724	25,70
M 14 x 0.75	100	10	11.0	9.0	39725	25,70
M 14 x 1.0	100	11	11.0	9.0	39726	25,70
M 14 x 1.25	100	15	11.0	9.0	39727	25,70
M 14 x 1.5	100	15	11.0	9.0	39728	25,70
M 15 x 1.0	100	12	12.0	9.0	39729	29,80
M 15 x 1.5	100	15	12.0	9.0	39730	29,80
M 16 x 1.0	100	12	12.0	9.0	39731	29,80
M 16 x 1.25	100	15	12.0	9.0	39732	29,80
M 16 x 1.5	100	15	12.0	9.0	39733	29,80
M 18 x 1.0	110	13	14.0	11.0	39734	37,90
M 18 x 1.25	110	15	14.0	11.0	39735	37,90
M 18 x 1.5	110	17	14.0	11.0	39736	37,90
M 18 x 2.0	125	20	14.0	11.0	39737	37,90

Application:

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

Applicazione:

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



Machine Taps
metric-fine ISO-thread DIN 13

Maschi a macchina
filettatura metrica fine ISO DIN 13

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

Nominal Diameter D	L 1	L 2	D 2	⌀	Art.-No.	€
M 20 x 1.0	125	14	16.0	12.0	39738	42,00
M 20 x 1.25	125	17	16.0	12.0	39739	42,00
M 20 x 1.5	125	17	16.0	12.0	39740	42,00
M 20 x 2.0	140	20	16.0	12.0	39741	42,00
M 21 x 1.5	125	17	16.0	12.0	39742	42,00
M 22 x 1.0	125	14	18.0	14.5	39743	51,00
M 22 x 1.25	125	17	18.0	14.5	39744	51,00
M 22 x 1.5	125	17	18.0	14.5	39745	51,00
M 22 x 2.0	140	20	18.0	14.5	39746	51,00
M 23 x 1.5	125	17	18.0	14.5	39747	61,00
M 24 x 1.0	140	15	18.0	14.5	39748	61,00
M 24 x 1.25	140	17	18.0	14.5	39749	61,00
M 24 x 1.5	140	20	18.0	14.5	39750	61,00
M 24 x 2.0	140	20	18.0	14.5	39751	61,00
M 25 x 1.0	140	15	18.0	14.5	39752	64,00
M 25 x 1.5	140	20	18.0	14.5	39753	64,00
M 26 x 1.0	140	15	18.0	14.5	3975X	64,00
M 26 x 1.5	140	20	18.0	14.5	39754	64,00
M 26 x 2.0	140	20	18.0	14.5	39755	64,00
M 27 x 1.0	140	15	20.0	16.0	39700	74,00
M 27 x 1.5	140	20	20.0	16.0	39756	73,00
M 27 x 2.0	140	20	20.0	16.0	39757	73,00
M 28 x 1.0	140	15	20.0	16.0	39758	73,00
M 28 x 1.5	140	20	20.0	16.0	39759	73,00
M 28 x 2.0	140	20	20.0	16.0	39760	73,00
M 29 x 1.5	150	22	22.0	18.0	39761	84,00
M 30 x 1.0	150	17	22.0	18.0	39762	84,00
M 30 x 1.5	150	22	22.0	18.0	39763	84,00
M 30 x 2.0	150	22	22.0	18.0	39764	84,00
M 30 x 2.5	180	27	22.0	18.0	3976X	84,00
M 30 x 3.0	180	30	22.0	18.0	39765	84,00
M 32 x 1.5	150	22	22.0	18.0	39766	104,00
M 32 x 2.0	150	22	22.0	18.0	39767	104,00
M 32 x 3.0	180	30	22.0	18.0	39792	104,00
M 33 x 1.5	160	24	25.0	20.0	39793	104,00
M 33 x 2.0	160	24	25.0	20.0	39768	104,00
M 33 x 3.0	180	30	25.0	20.0	39769	104,00

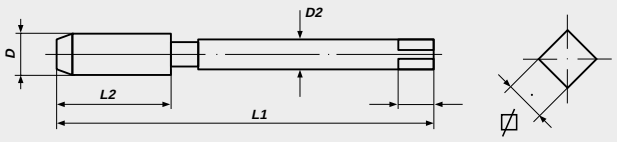
►►►

Application:

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

Applicazione:

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



VÖLKEL
THREADING SOLUTIONS

Machine Taps
metric-fine ISO-thread DIN 13

Maschi a macchina
filettatura metrica fine ISO DIN 13

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

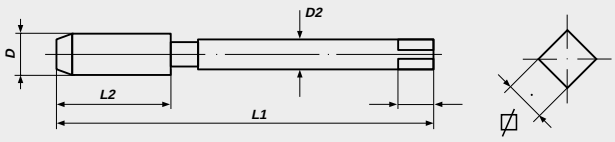
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
M 34 x 1.5	170	24	28.0	22.0	39770	104,00
M 34 x 2.0	170	24	28.0	22.0	39771	104,00
M 35 x 1.5	170	24	28.0	22.0	39772	104,00
M 36 x 1.5	170	24	28.0	22.0	39773	132,00
M 36 x 2.0	170	24	28.0	22.0	39774	132,00
M 36 x 3.0	200	30	28.0	22.0	39775	132,00
M 38 x 1.5	170	24	28.0	22.0	39776	139,00
M 39 x 1.5	170	25	32.0	24.0	39777	139,00
M 39 x 2.0	170	25	32.0	24.0	39778	139,00
M 39 x 3.0	200	30	32.0	24.0	39779	139,00
M 40 x 1.5	170	25	32.0	24.0	39780	154,00
M 40 x 2.0	170	25	32.0	24.0	39781	154,00
M 40 x 3.0	200	30	32.0	24.0	39782	154,00
M 42 x 1.5	170	25	32.0	24.0	39783	172,00
M 42 x 2.0	170	25	32.0	24.0	39784	172,00
M 42 x 3.0	200	30	32.0	24.0	39785	172,00
M 45 x 1.5	180	27	36.0	29.0	39786	201,00
M 45 x 2.0	180	27	36.0	29.0	39787	201,00
M 45 x 3.0	200	30	36.0	29.0	39788	201,00
M 48 x 1.5	190	27	36.0	29.0	39789	240,00
M 48 x 2.0	190	27	36.0	29.0	39790	240,00
M 48 x 3.0	225	33	36.0	29.0	39791	240,00
M 50 x 1.5	190	27	36.0	29.0	39794	280,00
M 50 x 2.0	190	27	36.0	29.0	39795	280,00
M 50 x 3.0	225	33	36.0	29.0	39796	280,00
M 52 x 1.5	190	27	40.0	32.0	39797	310,00
M 52 x 2.0	190	27	40.0	32.0	39798	310,00
M 52 x 3.0	225	33	40.0	32.0	39799	310,00
M 63 x 1.5	275	40	50.0	39.0	3979X	530,00

Application:

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

Applicazione:

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



Machine Taps
Withworth-thread BS 84

Maschi a macchina
filettatura Whitworth BS 84

≈ DIN 371/376 Form B HSS-E Tol. med. BSW

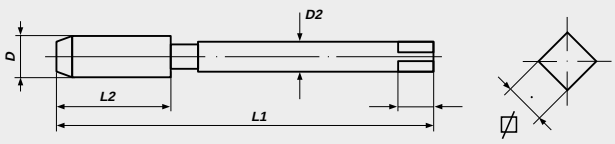
Nominal Diameter D	L 1	L 2	D 2	⌀	Art.-No.	€
≈ DIN 371						
BSW 1/8 x 40	56	11	3.5	2.7	70506	8,60
BSW 5/32 x 32	63	13	4.5	3.4	70508	8,60
BSW 3/16 x 24	70	15	6.0	4.9	70510	8,60
BSW 1/4 x 20	80	17	7.0	5.5	70514	8,60
BSW 5/16 x 18	90	20	8.0	6.2	70516	10,90
BSW 3/8 x 16	100	22	9.0	7.0	70518	12,20
BSW 7/16 x 14	100	22	11.0	9.0	70520	14,50
BSW 1/2 x 12	110	25	12.0	9.0	70522	14,50
≈ DIN 376						
BSW 1/4 x 20	80	17	4.5	3.4	71514	8,60
BSW 5/16 x 18	90	20	6.0	4.9	71516	10,90
BSW 3/8 x 16	100	22	7.0	5.5	71518	12,20
BSW 7/16 x 14	100	22	8.0	6.2	71520	14,50
BSW 1/2 x 12	110	25	9.0	7.0	71522	14,50
BSW 9/16 x 12	110	26	11.0	9.0	71524	22,10
BSW 5/8 x 11	110	27	12.0	9.0	71526	22,10
BSW 3/4 x 10	125	30	14.0	11.0	71530	43,00
BSW 7/8 x 9	140	32	18.0	14.5	71534	52,00
BSW 1" x 8	160	36	20.0	16.0	71538	59,00
BSW 1.1/4 x 7	180	40	22.0	18.0	71546	82,50
BSW 1.3/8 x 6	200	50	28.0	22.0	71550	172,00
BSW 1.1/2 x 6	200	50	32.0	24.0	71554	172,00

Application:

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

Applicazione:

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



VÖLKEL
THREADING SOLUTIONS

Machine Taps
Withworth-thread BS 84

Maschi a macchina
filettatura Whitworth BS 84

≈ DIN 371/376 Form C/35° RSP HSS-E Tol. med. BSW

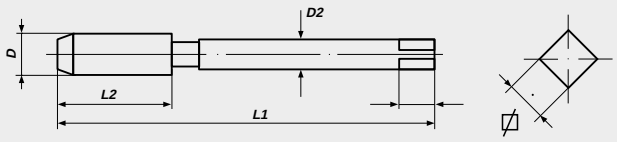
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
≈ DIN 371						
BSW 1/8 x 40	56	7	3.5	2.7	70706	10,70
BSW 5/32 x 32	63	7	4.5	3.4	70708	10,70
BSW 3/16 x 24	70	10	6.0	4.9	70710	10,70
BSW 1/4 x 20	80	13	7.0	5.5	70714	10,70
BSW 5/16 x 18	90	14	8.0	6.2	70716	13,40
BSW 3/8 x 16	100	16	9.0	7.0	70718	14,70
BSW 7/16 x 14	100	17	11.0	9.0	70720	18,10
BSW 1/2 x 12	110	20	12.0	9.0	70722	18,10
≈ DIN 376						
BSW 1/4 x 20	80	13	4.5	3.4	71714	10,70
BSW 5/16 x 18	90	14	6.0	4.9	71716	13,40
BSW 3/8 x 16	100	16	7.0	5.5	71718	14,70
BSW 7/16 x 14	100	17	8.0	6.2	71720	18,10
BSW 1/2 x 12	110	20	9.0	7.0	71722	18,10
BSW 9/16 x 12	110	20	11.0	9.0	71724	26,70
BSW 5/8 x 11	110	22	12.0	9.0	71726	26,70
BSW 3/4 x 10	125	25	14.0	11.0	71730	53,20
BSW 7/8 x 9	140	27	18.0	14.5	71734	65,00
BSW 1" x 8	160	30	20.0	16.0	71738	73,00
BSW 1.1/4 x 7	180	35	22.0	18.0	71746	93,00
BSW 1.3/8 x 6	200	40	28.0	22.0	71750	203,00
BSW 1.1/2 x 6	200	40	32.0	24.0	71754	203,00

Application:

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

Applicazione:

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



Machine Taps
Unified Coarse thread ANSI B 1.1

Maschi a macchina
filettatura unificata, serie grossa ANSI B1.1

≈ DIN 371/376 Form B HSS-E Tol. 2B

UNC

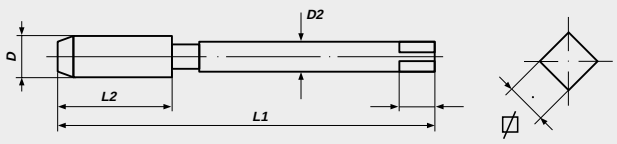
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
≈ DIN 371						
UNC No. 4 x 40	50	10	3.5	2.7	74504	8,60
UNC No. 5 x 40	56	11	3.5	2.7	74505	8,60
UNC No. 6 x 32	56	12	4.0	3.0	74506	8,60
UNC No. 8 x 32	63	13	4.5	3.4	74508	8,60
UNC No. 10 x 24	70	15	6.0	4.9	74510	8,60
UNC No. 12 x 24	70	16	6.0	4.9	74512	8,60
UNC 1/4 x 20	80	17	7.0	5.5	74514	8,60
UNC 5/16 x 18	90	20	8.0	6.2	74516	10,90
UNC 3/8 x 16	100	22	9.0	7.0	74518	12,20
≈ DIN 376						
UNC No. 4 x 40	50	10	1.8	-	75504	8,60
UNC No. 5 x 40	56	11	2.2	1.8	75505	8,60
UNC No. 6 x 32	56	12	2.5	2.1	75506	8,60
UNC No. 8 x 32	63	13	2.8	2.1	75508	8,60
UNC No. 10 x 24	70	15	3.5	2.7	75510	8,60
UNC No. 12 x 24	70	16	3.5	2.7	75512	8,60
UNC 1/4 x 20	80	17	4.5	3.4	75514	8,60
UNC 5/16 x 18	90	20	6.0	4.9	75516	10,90
UNC 3/8 x 16	100	22	7.0	5.5	75518	12,20
UNC 7/16 x 14	100	22	8.0	6.2	75520	14,50
UNC 1/2 x 13	110	25	9.0	7.0	75522	14,50
UNC 9/16 x 12	110	26	11.0	9.0	75524	22,10
UNC 5/8 x 11	110	27	12.0	9.0	75526	22,10
UNC 3/4 x 10	125	30	14.0	11.0	75530	43,00
UNC 7/8 x 9	140	32	18.0	14.5	75534	52,00
UNC 1" x 8	160	36	20.0	16.0	75538	59,00
UNC 1.1/4 x 7	180	40	22.0	18.0	75546	82,50
UNC 1.1/2 x 6	200	50	32.0	24.0	75554	172,00
UNC 1.3/4 x 5	220	65	36.0	29.0	75562	295,00
UNC 2" x 4.1/2	250	70	40.0	32.0	75570	426,00

Application:

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

Applicazione:

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



Machine Taps
Unified Coarse thread ANSI B 1.1

Maschi a macchina
filettatura unificata, serie grossa ANSI B1.1

≈ DIN 371/376 Form C/35° RSP HSS-E Tol. 2B UNC

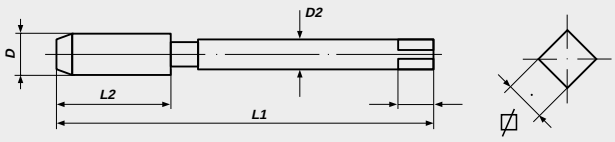
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
≈ DIN 371						
UNC No. 4 x 40	50	6	3.5	2.7	74704	10,70
UNC No. 5 x 40	56	7	3.5	2.7	74705	10,70
UNC No. 6 x 32	56	7	4.0	3.0	74706	10,70
UNC No. 8 x 32	63	8	4.5	3.4	74708	10,70
UNC No. 10 x 24	70	10	6.0	4.9	74710	10,70
UNC No. 12 x 24	70	10	6.0	4.9	74712	10,70
UNC 1/4 x 20	80	13	7.0	5.5	74714	10,70
UNC 5/16 x 18	90	14	8.0	6.2	74716	13,40
UNC 3/8 x 16	100	16	9.0	7.0	74718	14,70
≈ DIN 376						
UNC No. 4 x 40	50	6	1.8	-	75704	10,70
UNC No. 5 x 40	56	7	2.2	1.8	75705	10,70
UNC No. 6 x 32	56	7	2.5	2.1	75706	10,70
UNC No. 8 x 32	63	8	2.8	2.1	75708	10,70
UNC No. 10 x 24	70	10	3.5	2.7	75710	10,70
UNC No. 12 x 24	70	10	3.5	2.7	75712	10,70
UNC 1/4 x 20	80	13	4.5	3.4	75714	10,70
UNC 5/16 x 18	90	14	6.0	4.9	75716	13,40
UNC 3/8 x 16	100	16	7.0	5.5	75718	14,70
UNC 7/16 x 14	100	17	8.0	6.2	75720	18,10
UNC 1/2 x 13	110	20	9.0	7.0	75722	18,10
UNC 9/16 x 12	110	20	11.0	9.0	75724	26,70
UNC 5/8 x 11	110	22	12.0	9.0	75726	26,70
UNC 3/4 x 10	125	25	14.0	11.0	75730	53,20
UNC 7/8 x 9	140	27	18.0	14.5	75734	65,00
UNC 1" x 8	160	30	20.0	16.0	75738	73,00
UNC 1.1/4 x 7	180	35	22.0	18.0	75746	93,00
UNC 1.1/2 x 6	200	40	32.0	24.0	75754	203,00
UNC 1.3/4 x 5	220	45	36.0	29.0	75762	320,00
UNC 2" x 4.1/2	250	50	40.0	32.0	75770	454,00

Application:

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

Applicazione:

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



Machine Taps
Unified Fine thread ANSI B 1.1

Maschi a macchina
filettatura unificata, serie fina ANSI B1.1

≈ DIN 371/376 Form B HSS-E Tol. 2B

UNF

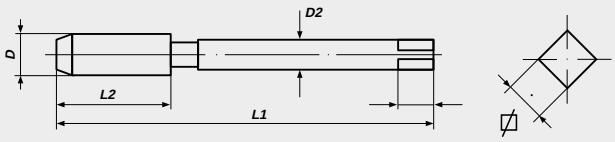
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
≈ DIN 371						
UNF No. 4 x 48	50	10	3.5	2.7	76504	8,60
UNF No. 5 x 44	56	11	3.5	2.7	76505	8,60
UNF No. 6 x 40	56	12	4.0	3.0	76506	8,60
UNF No. 8 x 36	63	13	4.5	3.4	76508	8,60
UNF No. 10 x 32	70	15	6.0	4.9	76510	8,60
UNF No. 12 x 28	70	16	6.0	4.9	76512	8,60
UNF 1/4 x 28	80	17	7.0	5.5	76514	8,60
UNF 5/16 x 24	90	17	8.0	6.2	76516	10,90
UNF 3/8 x 24	100	18	9.0	7.0	76518	12,20
≈ DIN 376						
UNF 7/16 x 20	100	22	8.0	6.2	77520	14,50
UNF 1/2 x 20	100	22	9.0	7.0	77522	14,50
UNF 9/16 x 18	100	22	11.0	9.0	77524	22,10
UNF 5/8 x 18	100	22	12.0	9.0	77526	22,10
UNF 3/4 x 16	110	25	14.0	11.0	77530	43,00
UNF 7/8 x 14	140	26	18.0	14.5	77534	52,00
UNF 1" x 14	150	28	20.0	16.0	77540	59,00
UNF 1" x 12	150	28	20.0	16.0	77538	59,00
UNF 1.1/4 x 12	150	30	22.0	18.0	77546	82,50
UNF 1.1/2 x 12	170	33	32.0	24.0	77554	172,00

Application:

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

Applicazione:

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



Machine Taps
Unified Fine thread ANSI B 1.1

Maschi a macchina
filettatura unificata, serie fina ANSI B1.1

≈ DIN 371/376 Form C/35° RSP HSS-E Tol. 2B UNF

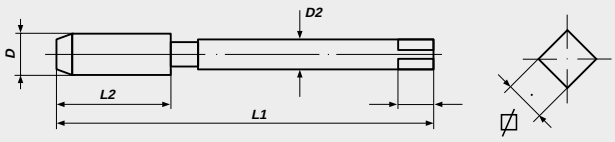
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
≈ DIN 371						
UNF No. 4 x 48	50	6	3.5	2.7	76704	10,70
UNF No. 5 x 44	56	7	3.5	2.7	76705	10,70
UNF No. 6 x 40	56	7	4.0	3.0	76706	10,70
UNF No. 8 x 36	63	8	4.5	3.4	76708	10,70
UNF No. 10 x 32	70	10	6.0	4.9	76710	10,70
UNF No. 12 x 28	70	10	6.0	4.9	76712	10,70
UNF 1/4 x 28	80	10	7.0	5.5	76714	10,70
UNF 5/16 x 24	90	10	8.0	6.2	76716	13,40
UNF 3/8 x 24	100	10	9.0	7.0	76718	14,70
≈ DIN 376						
UNF 7/16 x 20	100	13	8.0	6.2	77720	18,10
UNF 1/2 x 20	100	13	9.0	7.0	77722	18,10
UNF 9/16 x 18	100	15	11.0	9.0	77724	26,70
UNF 5/8 x 18	100	15	12.0	9.0	77726	26,70
UNF 3/4 x 16	110	17	14.0	11.0	77730	53,20
UNF 7/8 x 14	140	17	18.0	14.5	77734	65,00
UNF 1" x 14	150	20	20.0	16.0	77740	73,00
UNF 1" x 12	150	20	20.0	16.0	77738	73,00
UNF 1.1/4 x 12	150	22	22.0	18.0	77746	93,00
UNF 1.1/2 x 12	170	25	32.0	24.0	77754	203,00

Application:

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

Applicazione:

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



Machine Taps
Unified thread ANSI B 1.1

Maschi a macchina
filettatura unificata ANSI B1.1

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

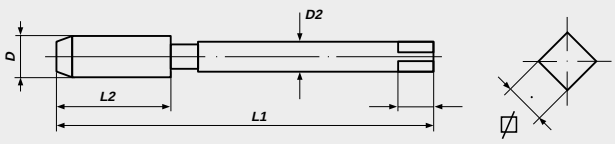
Nominal Diameter D	L 1	L 2	D 2	⌀	Art.-No.	€
8-UN						
UN 1.1/16 x 8	138	48	20.0	16.0	83101	61,00
UN 1.1/8 x 8	138	48	20.0	16.0	83102	61,00
UN 1.3/16 x 8	151	51	22.4	18.0	83103	71,40
UN 1.1/4 x 8	151	51	22.4	18.0	83104	71,40
UN 1.5/16 x 8	162	57	25.0	20.0	83105	90,00
UN 1.3/8 x 8	162	57	25.0	20.0	83106	90,00
UN 1.1/2 x 8	170	60	28.0	22.4	83107	116,00
UN 1.5/8 x 8	170	60	28.0	22.4	83108	137,00
UN 1.3/4 x 8	187	67	31.5	25.0	83109	160,00
UN 1.7/8 x 8	187	67	31.5	25.0	83110	242,00
UN 2" x 8	200	70	35.5	28.0	83111	242,00
UN 2.1/8 x 8	200	70	35.5	28.0	83112	480,00
UN 2.1/4 x 8	221	76	40.0	31.5	83113	480,00
UN 2.1/2 x 8	224	79	40.0	31.5	83115	700,00
UN 2.3/4 x 8	234	79	45.0	35.5	83116	770,00
UN 3" x 8	258	83	50.0	40.0	83117	865,00
UN 3.1/4 x 8	261	86	50.0	40.0	83118	865,00
UN 3.1/2 x 8	261	86	50.0	40.0	83119	1.020,00
UN 3.3/4 x 8	279	89	56.0	45.0	83120	1.250,00
UN 4" x 8	279	89	56.0	45.0	83121	1.250,00
12-UN						
UN 1.5/8 x 12	170	60	28.0	22.4	83301	137,00
UN 1.3/4 x 12	187	67	31.5	25.0	83302	160,00
UN 1.7/8 x 12	187	67	31.5	25.0	83303	242,00
UN 2" x 12	200	70	35.5	28.0	83304	242,00
UN 2.1/8 x 12	200	70	35.5	28.0	83305	480,00
UN 2.1/4 x 12	221	76	40.0	31.5	83306	480,00
UN 2.1/2 x 12	224	79	40.0	31.5	83308	700,00
UN 2.3/4 x 12	234	79	45.0	35.5	83309	770,00
UN 3" x 12	258	83	50.0	40.0	83310	865,00
UN 3.1/4 x 12	261	86	50.0	40.0	83311	865,00
UN 3.1/2 x 12	261	86	50.0	40.0	83312	1.020,00
UN 3.3/4 x 12	279	89	56.0	45.0	83313	1.250,00
UN 4" x 12	279	89	56.0	45.0	83314	1.250,00

Application:

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

Applicazione:

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



VÖLKEL
THREADING SOLUTIONS

Machine Taps
Unified thread ANSI B 1.1

Maschi a macchina
filettatura unificata ANSI B1.1

ISO 529 Form C/35° RSP HSS-E Tol. 2B UN

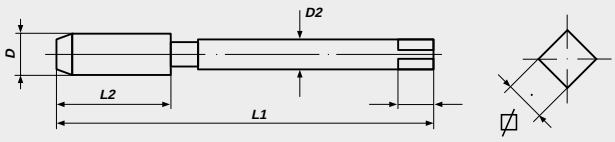
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
8-UN						
UN 1.1/16 x 8	138	48	20.0	16.0	83151	77,00
UN 1.1/8 x 8	138	48	20.0	16.0	83152	77,00
UN 1.3/16 x 8	151	51	22.4	18.0	83153	90,00
UN 1.1/4 x 8	151	51	22.4	18.0	83154	90,00
UN 1.5/16 x 8	162	57	25.0	20.0	83155	112,00
UN 1.3/8 x 8	162	57	25.0	20.0	83156	112,00
UN 1.1/2 x 8	170	60	28.0	22.4	83157	145,00
UN 1.5/8 x 8	170	60	28.0	22.4	83158	170,00
UN 1.3/4 x 8	187	67	31.5	25.0	83159	198,00
UN 1.7/8 x 8	187	67	31.5	25.0	83160	305,00
UN 2" x 8	200	70	35.5	28.0	83161	305,00
UN 2.1/8 x 8	200	70	35.5	28.0	83162	602,00
UN 2.1/4 x 8	221	76	40.0	31.5	83163	602,00
UN 2.1/2 x 8	224	79	40.0	31.5	83165	875,00
UN 2.3/4 x 8	234	79	45.0	35.5	83166	970,00
UN 3" x 8	258	83	50.0	40.0	83167	1.080,00
UN 3.1/4 x 8	261	86	50.0	40.0	83168	1.080,00
UN 3.1/2 x 8	261	86	50.0	40.0	83169	1.260,00
UN 3.3/4 x 8	279	89	56.0	45.0	83170	1.580,00
UN 4" x 8	279	89	56.0	45.0	83171	1.580,00
12-UN						
UN 1.5/8 x 12	170	60	28.0	22.4	83351	170,00
UN 1.3/4 x 12	187	67	31.5	25.0	83352	198,00
UN 1.7/8 x 12	187	67	31.5	25.0	83353	305,00
UN 2" x 12	200	70	35.5	28.0	83354	305,00
UN 2.1/8 x 12	200	70	35.5	28.0	83355	602,00
UN 2.1/4 x 12	221	76	40.0	31.5	83356	602,00
UN 2.1/2 x 12	224	79	40.0	31.5	83358	875,00
UN 2.3/4 x 12	234	79	45.0	35.5	83359	970,00
UN 3" x 12	258	83	50.0	40.0	83360	1.080,00
UN 3.1/4 x 12	261	86	50.0	40.0	83361	1.080,00
UN 3.1/2 x 12	261	86	50.0	40.0	83362	1.260,00
UN 3.3/4 x 12	279	89	56.0	45.0	83363	1.580,00
UN 4" x 12	279	89	56.0	45.0	83364	1.580,00

Application:

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

Applicazione:

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



Machine Taps
Unified Extra Fine thread ANSI B 1.1

Maschi a macchina
filettatura unificata, serie extra-fina ANSI B1.1

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

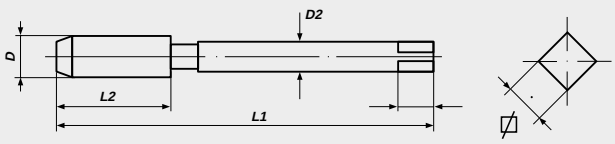
Nominal Diameter D		L 1	L 2	D 2	⌀	Art.-No.	€
UNEF	Nr.12 x 32	62	17	5.6	4.5	83320	8,80
UNEF	1/4 x 32	66	19	6.3	5.0	83321	7,90
UNEF	5/16 x 32	72	22	8.0	6.3	83322	9,90
UNEF	3/8 x 32	80	24	10.0	8.0	83323	11,30
UNEF	7/16 x 28	85	25	8.0	6.3	83324	13,30
UNEF	1/2 x 28	89	29	9.0	7.1	83325	13,30
UNEF	9/16 x 24	95	30	11.2	9.0	83326	20,00
UNEF	5/8 x 24	102	32	12.5	10.0	83327	20,40
UNEF	11/16 x 24	112	37	14.0	11.2	83328	37,80
UNEF	3/4 x 20	112	37	14.0	11.2	83329	37,80
UNEF	13/16 x 20	118	38	16.0	12.5	83330	46,20
UNEF	7/8 x 20	118	38	16.0	12.5	83331	46,20
UNEF	15/16 x 20	130	45	18.0	14.0	83332	53,00
UNEF	1" x 20	130	45	18.0	14.0	83333	53,00
UNEF	1.1/16 x 18	138	48	20.0	16.0	83334	61,00
UNEF	1.1/8 x 18	138	48	20.0	16.0	83335	61,00
UNEF	1.3/16 x 18	151	51	22.4	18.0	83336	71,50
UNEF	1.1/4 x 18	151	51	22.4	18.0	83337	71,50
UNEF	1.5/16 x 18	162	57	25.0	20.0	83338	90,00
UNEF	1.3/8 x 18	162	57	25.0	20.0	83339	90,00
UNEF	1.7/16 x 18	170	60	28.0	22.4	83340	116,00
UNEF	1.1/2 x 18	170	60	28.0	22.4	83341	116,00
UNEF	1.9/16 x 18	170	60	28.0	22.4	83342	137,00
UNEF	1.5/8 x 18	170	60	28.0	22.4	83343	137,00
UNEF	1.11/16 x 18	187	67	31.5	25.0	83344	158,00
UNEF	1.3/4 x 18	187	67	31.5	25.0	83345	158,00
UNEF	2" x 18	200	70	35.5	28.0	83346	242,00

Application:

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

Applicazione:

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



VÖLKEL THREADING SOLUTIONS

Maschine Taps
Unified Extra Fine thread ANSI B 1.1

Maschi a macchina
filettatura unificata, serie extra-fina ANSI B1.1

ISO 529 Form C/35°RSP HSS-E Tol. 2B UNEF

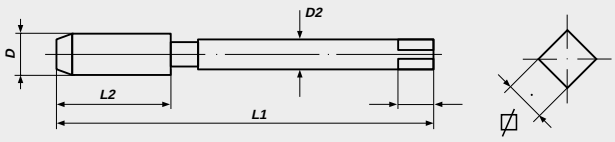
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
UNEF Nr. 12 x 32	62	17	5.6	4.5	83370	10,90
UNEF 1/4 x 32	66	19	6.3	5.0	83371	9,80
UNEF 5/16 x 32	72	22	8.0	6.3	83372	12,40
UNEF 3/8 x 32	80	24	10.0	8.0	83373	14,00
UNEF 7/16 x 28	85	25	8.0	6.3	83374	16,50
UNEF 1/2 x 28	89	29	9.0	7.1	83375	16,50
UNEF 9/16 x 24	95	30	11.2	9.0	83376	24,70
UNEF 5/8 x 24	102	32	12.5	10.0	83377	24,70
UNEF 11/16 x 24	112	37	14.0	11.2	83378	47,30
UNEF 3/4 x 20	112	37	14.0	11.2	83379	47,30
UNEF 13/16 x 20	118	38	16.0	12.5	83380	58,00
UNEF 7/8 x 20	118	38	16.0	12.5	83381	58,00
UNEF 15/16 x 20	130	45	18.0	14.0	83382	66,00
UNEF 1" x 20	130	45	18.0	14.0	83383	66,00

Application:

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

Applicazione:

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



Machine Taps
Unified thread ANSI B 1.1

Maschi a macchina
filettatura unificata ANSI B1.1

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

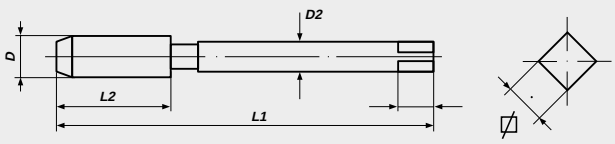
Nominal Diameter D		L 1	L 2	D 2	⌀	Art.-No.	€
UNS							
UNS	1/4 x 24	66	19	6.3	5.0	83201	7,90
UNS	1/4 x 36	66	19	6.3	5.0	83202	7,90
UNS	1/4 x 40	66	19	6.3	5.0	83203	7,90
UNS	3/8 x 27	80	24	10.0	8.0	83204	11,30
UNS	7/16 x 24	85	25	8.0	6.3	83205	13,30
UNS	1/2 x 24	89	29	9.0	7.1	83206	13,30
UNS	5/8 x 27	102	32	12.5	10.0	83207	20,40
UNS	3/4 x 24	112	37	14.0	11.2	83208	37,80
UNS	7/8 x 18	118	38	16.0	12.5	83209	46,20
UNS	1" x 14	130	45	18.0	14.0	83210	53,00
UN							
UN	5/16 x 20	72	22	8.0	6.3	83220	10,00
UN	5/16 x 28	72	22	8.0	6.3	83221	10,00
UN	3/8 x 20	80	24	10.0	8.0	83222	11,30
UN	3/8 x 28	80	24	10.0	8.0	83223	11,30
UN	7/16 x 32	85	25	8.0	6.3	83224	13,30
UN	1/2 x 32	89	29	9.0	7.1	83225	13,30
UN	9/16 x 20	95	30	11.2	9.0	83226	20,00
UN	9/16 x 28	95	30	11.2	9.0	83227	20,00
UN	9/16 x 32	95	30	11.2	9.0	83228	20,00
UN	5/8 x 20	102	32	12.5	10.0	83229	20,50
UN	5/8 x 28	102	32	12.5	10.0	83230	20,50
UN	11/16 x 20	112	37	14.0	11.2	83231	37,80
UN	11/16 x 16	112	37	14.0	11.2	83232	37,80
UN	1" x 32	130	45	18.0	14.0	83233	52,50

Application:

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

Applicazione:

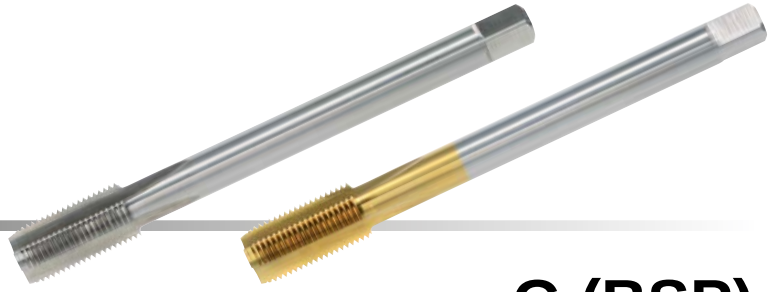
per uso universale
- Materiali con buona truciodibilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per fori passanti



VÖLKEL THREADING SOLUTIONS

Machine Taps
Pipe-thread DIN ISO 228

Maschi a macchina
filettatura per tubi gas DIN ISO 228



DIN 5156 Form C HSS-E

G (BSP)

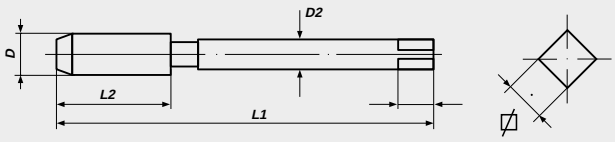
Nominal Diameter D		L 1	L 2	D 2	⧄	Art.-No.	€
G	1/8 x 28	90	20	7.0	5.5	78412	13,40
G	1/4 x 19	100	22	11.0	9.0	78414	16,50
G	3/8 x 19	100	22	12.0	9.0	78416	20,00
G	1/2 x 14	125	25	16.0	12.0	78418	29,40
G	5/8 x 14	125	25	18.0	14.5	78420	33,00
G	3/4 x 14	140	28	20.0	16.0	78422	43,60
G	7/8 x 14	150	28	22.0	18.0	78424	54,30
G	1" x 11	160	30	25.0	20.0	78426	63,00
G	1.1/8 x 11	170	30	28.0	22.0	78430	88,00
G	1.1/4 x 11	170	30	32.0	24.0	78434	120,00
G	1.3/8 x 11	180	32	36.0	29.0	78438	140,00
G	1.1/2 x 11	190	32	36.0	29.0	78442	166,00
G	1.3/4 x 11	190	32	40.0	32.0	78450	218,00
G	2" x 11	220	40	45.0	35.0	78454	230,00
TIN							
G	1/8 x 28	90	20	7.0	5.5	78413	19,90
G	1/4 x 19	100	22	11.0	9.0	78415	27,50
G	3/8 x 19	100	22	12.0	9.0	78417	35,90
G	1/2 x 14	125	25	16.0	12.0	78419	61,40
G	3/4 x 14	140	28	20.0	16.0	78423	86,80
G	1" x 11	160	30	25.0	20.0	78427	129,00

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

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

Applicazione:
per uso universale
- Materiali con buona truciodibilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per fori ciechi

rivestimento TIN
- migliore resistenza all‘ abrasione e alla rottura
- eccellente uniformità
- possibile velocità di taglio superiore



Machine Taps
Pipe-thread DIN ISO 228

Maschi a macchina
filettatura per tubi gas DIN ISO 228

DIN 5156 Form B HSS-E

G (BSP)

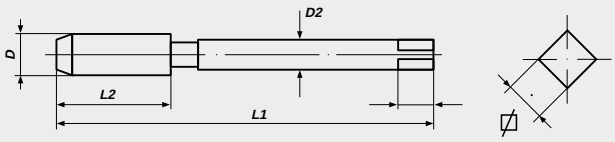
Nominal Diameter D		L 1	L 2	D 2	⌀	Art.-No.	€
G	1/8 x 28	90	20	7.0	5.5	78512	14,00
G	1/4 x 19	100	22	11.0	9.0	78514	17,70
G	3/8 x 19	100	22	12.0	9.0	78516	21,00
G	1/2 x 14	125	25	16.0	12.0	78518	31,00
G	5/8 x 14	125	25	18.0	14.5	78520	36,00
G	3/4 x 14	140	28	20.0	16.0	78522	46,00
G	7/8 x 14	150	28	22.0	18.0	78524	58,00
G	1" x 11	160	30	25.0	20.0	78526	72,00
G	1.1/8 x 11	170	30	28.0	22.0	78530	106,00
G	1.1/4 x 11	170	30	32.0	24.0	78534	126,00
G	1.3/8 x 11	180	32	36.0	29.0	78538	167,00
G	1.1/2 x 11	190	32	36.0	29.0	78542	181,00
G	1.3/4 x 11	190	32	40.0	32.0	78550	262,00
G	2" x 11	220	40	45.0	35.0	78554	290,00
TIN							
G	1/8 x 28	90	20	7.0	5.5	78513	20,50
G	1/4 x 19	100	22	11.0	9.0	78515	28,70
G	3/8 x 19	100	22	12.0	9.0	78517	36,90
G	1/2 x 14	125	25	16.0	12.0	78519	63,00
G	3/4 x 14	140	28	20.0	16.0	78523	89,20
G	1" x 11	160	30	25.0	20.0	78527	138,00

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

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

Applicazione:
per uso universale
- Materiali con buona truciodibilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per fori passanti

rivestimento TIN:
- migliore resistenza all‘ abrasione e alla rottura
- eccellente uniformità
- possibile velocità di taglio superiore



VÖLKEL
THREADING SOLUTIONS

Machine Taps
Pipe-thread DIN ISO 228

Maschi a macchina
filettatura per tubi gas DIN ISO 228

DIN 5156 Form C/35° RSP HSS-E G (BSP)

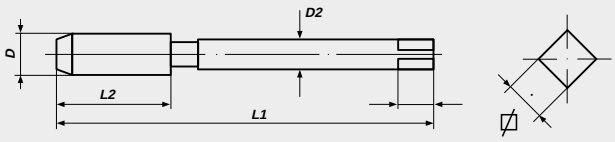
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
G 1/8 x 28	90	20	7.0	5.5	78712	15,40
G 1/4 x 19	100	22	11.0	9.0	78714	19,50
G 3/8 x 19	100	22	12.0	9.0	78716	25,00
G 1/2 x 14	125	25	16.0	12.0	78718	35,00
G 5/8 x 14	125	25	18.0	14.5	78720	41,00
G 3/4 x 14	140	28	20.0	16.0	78722	52,00
G 7/8 x 14	150	28	22.0	18.0	78724	64,00
G 1" x 11	160	30	25.0	20.0	78726	80,00
G 1.1/8 x 11	170	30	28.0	22.0	78730	117,00
G 1.1/4 x 11	170	30	32.0	24.0	78734	140,00
G 1.3/8 x 11	180	32	36.0	29.0	78738	184,00
G 1.1/2 x 11	190	32	36.0	29.0	78742	200,00
G 1.3/4 x 11	190	32	40.0	32.0	78750	288,00
G 2" x 11	220	40	45.0	35.0	78754	320,00
TIN						
G 1/8 x 28	90	20	7.0	5.5	78713	21,90
G 1/4 x 19	100	22	11.0	9.0	78715	30,50
G 3/8 x 19	100	22	12.0	9.0	78717	40,90
G 1/2 x 14	125	25	16.0	12.0	78719	67,00
G 3/4 x 14	140	28	20.0	16.0	78723	95,20
G 1" x 11	160	30	25.0	20.0	78727	146,00

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

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

Applicazione:
per uso universale
- Materiali con buona truciodibilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per fori ciechi

rivestimento TIN:
- migliore resistenza all‘ abrasione e alla rottura
- eccellente uniformità
- possibile velocità di taglio superiore



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

Maschi a macchina
filettatura conica per tubi, cono 1:16

DIN 5156 **Form C** **HSS-E**

Rc (BSPT)

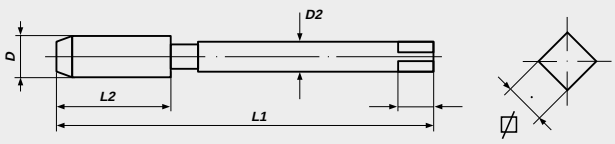
Nominal Diameter D	L 1	L 2	D 2	⊠	Art.-No.	€
Rc 1/8 x 28	90	20	7.0	5.5	73404	16,80
Rc 1/4 x 19	100	22	11.0	9.0	73406	21,00
Rc 3/8 x 19	100	22	12.0	9.0	73408	26,30
Rc 1/2 x 14	125	28	16.0	12.0	73410	37,00
Rc 3/4 x 14	140	28	20.0	16.0	73412	56,00
Rc 1" x 11	160	38	25.0	20.0	73414	80,00

Application:

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

Applicazione:

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



VÖLKEL
THREADING SOLUTIONS

Machine Taps
american tapered pipe thread, taper 1:16

Maschi a macchina
filettatura americana conica per tubi, cono 1:16

Form C HSS-E

NPT

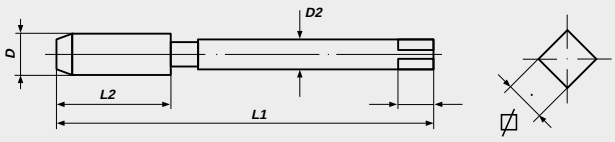
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
NPT 1/16 x 27	90	20	6.0	4.9	73432	22,30
NPT 1/8 x 27	90	20	7.0	5.5	73434	16,80
NPT 1/4 x 18	100	22	11.0	9.0	73436	21,00
NPT 3/8 x 18	100	22	12.0	9.0	73438	26,30
NPT 1/2 x 14	125	28	16.0	12.0	73440	37,00
NPT 3/4 x 14	140	28	20.0	16.0	73442	56,00
NPT 1" x 11.5	160	38	25.0	20.0	73444	80,00

Application:

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

Applicazione:

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



Machine Taps
Knuckle thread DIN 405

Maschi a macchina
filettatura rotunda DIN 405

DIN 374 Form C HSS-E Tol. 7H

Rd

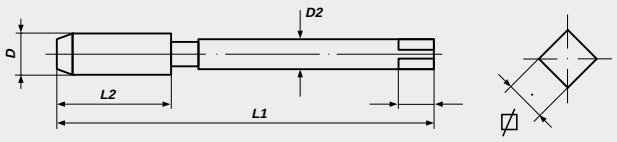
Nominal Diameter D	L 1	L 2	D 2	⌀	Art.-No.	€
Rd 8 x 1/10	90	26	6.0	4.9	79440	73,50
Rd 9 x 1/10	90	26	7.0	5.5	79441	73,50
Rd 10 x 1/10	100	28	7.0	5.5	79442	73,50
Rd 11 x 1/10	100	28	8.0	6.2	79443	90,00
Rd 12 x 1/10	110	28	9.0	7.0	79444	100,00
Rd 14 x 1/8	110	32	11.0	9.0	79445	126,00
Rd 16 x 1/8	110	32	12.0	9.0	79446	132,00
Rd 18 x 1/8	125	32	14.0	11.0	79447	158,00
Rd 20 x 1/8	140	32	16.0	12.0	79448	158,00
Rd 22 x 1/8	140	32	18.0	14.5	79449	205,00
Rd 24 x 1/8	160	34	18.0	14.5	79450	247,00
Rd 26 x 1/8	160	36	20.0	16.0	79451	289,00
Rd 28 x 1/8	160	36	20.0	16.0	79452	310,00
Rd 30 x 1/8	180	36	22.0	18.0	79453	326,00
Rd 32 x 1/8	180	36	25.0	20.0	79454	436,00
Rd 34 x 1/8	200	36	28.0	22.0	79455	495,00
Rd 36 x 1/8	200	36	28.0	22.0	79456	499,00
Rd 38 x 1/8	200	38	28.0	22.0	79457	578,00
Rd 40 x 1/6	200	50	32.0	24.0	79458	683,00
Rd 42 x 1/6	200	50	32.0	24.0	79459	788,00
Rd 44 x 1/6	200	50	36.0	29.0	79460	945,00

Application:

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

Applicazione:

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



Machine Taps
Cycle thread DIN 79012

Maschi a macchina
filettatura per biciclette DIN 79012

DIN 374 Form C HSS-E Tol. medium FG

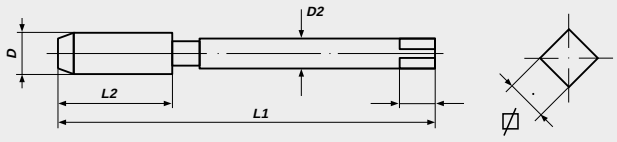
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
FG 2 x 56	45	8	2.8	2.1	79401	80,00
FG 2.3 x 56	45	8	2.8	2.1	79402	80,00
FG 2.6 x 56	56	8	3.5	2.7	79403	80,00
FG 6.35 x 26	80	14	7.0	5.5	79404	70,00
FG 7.9 x 26	90	16	8.0	6.2	79405	75,00
FG 9.5 x 26	90	16	7.0	5.5	79406	75,00
FG 14.3 x 20	100	22	11.0	9.0	79407	80,00
FG 14.3 x 20 - LH	100	22	11.0	9.0	79408	90,00
FG 25.4 x 24	140	24	18.0	14.5	79409	130,00

Application:

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

Applicazione:

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



Machine Taps
Cycle thread BS 811

Maschi a macchina
filettatura inglese per biciclette BS 811

DIN 374 Form C HSS-E Tol. medium BSC

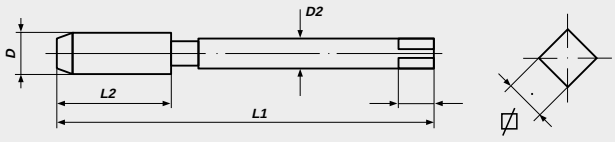
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
BSC 1/4 x 26	80	14	7.0	5.5	79420	70,00
BSC 5/16 x 26	90	16	8.0	6.2	79421	75,00
BSC 3/8 x 26	90	16	7.0	5.5	79422	80,00
BSC 9/16 x 20	100	22	11.0	9.0	79423	80,00
BSC 9/16 x 20 - LH	100	22	11.0	9.0	79424	90,00
BSC 1" x 24	140	24	18.0	14.5	79425	130,00

Application:

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

Applicazione:

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



Machine Taps
Valve thread DIN 7756

Maschi a macchina
filettatura per valvole DIN 7756

DIN 374 Form C HSS-E Tol. medium Vg

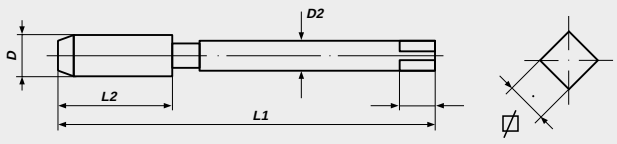
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
Vg 5 x 36	70	12	6.0	4.9	79430	65,00
Vg 5.2 x 24	80	17	6.0	4.9	79431	65,00
Vg 6 x 32	80	14	7.0	5.5	79432	72,50
Vg 8 x 32	80	16	8.0	6.2	79433	74,00
Vg 10 x 28	90	18	8.0	6.2	79434	80,00
Vg 12 x 26	100	22	9.0	7.0	79435	90,00

Application:

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

Applicazione:

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



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

Maschi a macchina, *filetto sinistro*
filettatura metrica ISO DIN 13

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

M

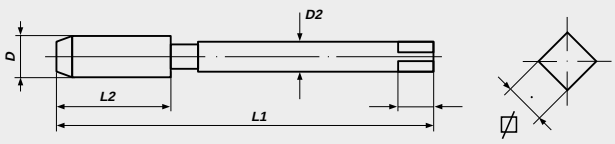
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
DIN 371						
M 3 x 0.5	56	11	3.5	2.7	33426	9,70
M 4 x 0.7	63	13	4.5	3.4	33430	9,70
M 5 x 0.8	70	16	6.0	4.9	33434	10,10
M 6 x 1.0	80	19	6.0	4.9	33438	10,10
M 8 x 1.25	90	22	8.0	6.2	33442	12,10
M 10 x 1.5	100	24	10.0	8.0	33446	13,80
DIN 376						
M 12 x 1.75	110	29	9.0	7.0	34450	16,40
M 14 x 2.0	110	30	11.0	9.0	34454	24,30
M 16 x 2.0	110	32	12.0	9.0	34458	27,50
M 18 x 2.5	125	34	14.0	11.0	34462	37,50
M 20 x 2.5	140	34	16.0	12.0	34466	53,00
M 22 x 2.5	140	34	18.0	14.5	34470	55,30
M 24 x 3.0	160	38	18.0	14.5	34474	57,50

Application:

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

Applicazione:

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



Machine Taps, *Left Hand*

metric ISO-thread DIN 13

Maschi a macchina, *filetto sinistro*

filettatura metrica ISO DIN 13

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

M

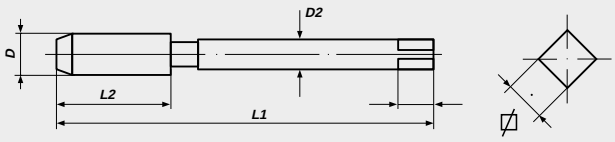
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
DIN 371						
M 3 x 0.5	56	11	3.5	2.7	33526	11,00
M 4 x 0.7	63	13	4.5	3.4	33530	11,00
M 5 x 0.8	70	16	6.0	4.9	33534	11,50
M 6 x 1.0	80	19	6.0	4.9	33538	11,50
M 7 x 1.0	80	19	7.0	5.5	33540	14,90
M 8 x 1.25	90	22	8.0	6.2	33542	14,00
M 10 x 1.5	100	24	10.0	8.0	33546	15,80
DIN 376						
M 3 x 0.5	56	11	2.2	—	34526	11,00
M 4 x 0.7	63	13	2.8	2.1	34530	11,00
M 5 x 0.8	70	16	3.5	2.7	34534	11,50
M 6 x 1.0	80	19	4.5	3.4	34538	11,50
M 8 x 1.25	90	22	6.0	4.9	34542	14,00
M 10 x 1.5	100	24	7.0	5.5	34546	15,80
M 12 x 1.75	110	29	9.0	7.0	34550	19,90
M 14 x 2.0	110	30	11.0	9.0	34554	25,20
M 16 x 2.0	110	32	12.0	9.0	34558	29,20
M 18 x 2.5	125	34	14.0	11.0	34562	39,70
M 20 x 2.5	140	34	16.0	12.0	34566	56,20
M 22 x 2.5	140	34	18.0	14.5	34570	62,00
M 24 x 3.0	160	38	18.0	14.5	34574	67,00
M 27 x 3.0	160	38	20.0	16.0	34576	110,00
M 30 x 3.5	180	45	22.0	18.0	34578	115,00
M 33 x 3.5	180	50	25.0	20.0	34580	156,00
M 36 x 4.0	200	56	28.0	22.0	34582	261,00
M 39 x 4.0	200	60	32.0	24.0	34584	328,00
M 42 x 4.5	200	60	32.0	24.0	34586	390,00
M 45 x 4.5	220	65	36.0	29.0	34588	430,00
M 48 x 5.0	250	70	36.0	29.0	34590	475,00
M 52 x 5.0	250	70	40.0	32.0	34592	562,00

Application:

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

Applicazione:

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



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

Maschi a macchina, *filetto sinistro*
filettatura metrica ISO DIN 13

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

M

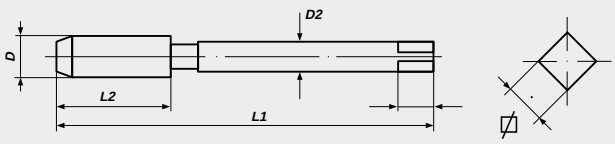
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
DIN 371						
M 3 x 0.5	56	6	3.5	2.7	33726	12,90
M 4 x 0.7	63	7	4.5	3.4	33730	12,90
M 5 x 0.8	70	8	6.0	4.9	33734	13,80
M 6 x 1.0	80	10	6.0	4.9	33738	13,80
M 8 x 1.25	90	14	8.0	6.2	33742	16,50
M 10 x 1.5	100	16	10.0	8.0	33746	18,80
DIN 376						
M 3 x 0.5	56	6	2.2	—	34726	12,90
M 4 x 0.7	63	7	2.8	2.1	34730	12,90
M 5 x 0.8	70	8	3.5	2.7	34734	13,80
M 6 x 1.0	80	10	4.5	3.4	34738	13,80
M 8 x 1.25	90	14	6.0	4.9	34742	16,50
M 10 x 1.5	100	16	7.0	5.5	34746	18,80
M 12 x 1.75	110	18	9.0	7.0	34750	21,40
M 14 x 2.0	110	20	11.0	9.0	34754	27,30
M 16 x 2.0	110	22	12.0	9.0	34758	31,50
M 18 x 2.5	125	25	14.0	11.0	34762	42,00
M 20 x 2.5	140	25	16.0	12.0	34766	60,00
M 22 x 2.5	140	27	18.0	14.5	34770	67,20
M 24 x 3.0	160	30	18.0	14.5	34774	69,30
M 27 x 3.0	160	30	20.0	16.0	34776	119,00
M 30 x 3.5	180	35	22.0	18.0	34778	123,00
M 33 x 3.5	180	35	25.0	20.0	34780	171,00
M 36 x 4.0	200	40	28.0	22.0	34782	288,00
M 39 x 4.0	200	40	32.0	24.0	34784	354,00
M 42 x 4.5	200	45	32.0	24.0	34786	413,00
M 45 x 4.5	220	45	36.0	29.0	34788	469,00
M 48 x 5.0	250	50	36.0	29.0	34790	512,00
M 52 x 5.0	250	50	40.0	32.0	34792	598,00

Application:

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

Applicazione:

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



VÖLKEL
THREADING SOLUTIONS

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

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

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

Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
M 3 x 0.35	56	9	2.2	-	34801	26,20
M 4 x 0.35	63	10	2.8	2.1	34802	26,20
M 4 x 0.5	63	10	2.8	2.1	34803	26,20
M 5 x 0.5	70	12	3.5	2.7	34804	26,20
M 5 x 0.75	70	12	3.5	2.7	34805	26,20
M 6 x 0.5	80	14	4.5	3.4	34806	26,20
M 6 x 0.75	80	14	4.5	3.4	34807	26,20
M 7 x 0.75	80	14	5.5	4.3	34808	26,20
M 8 x 0.5	80	19	6.0	4.9	34809	26,20
M 8 x 0.75	80	19	6.0	4.9	34810	26,20
M 8 x 1.0	90	22	6.0	4.9	34811	26,20
M 9 x 0.75	80	19	7.0	5.5	34812	26,20
M 9 x 1.0	90	22	7.0	5.5	34813	26,20
M 10 x 0.75	90	20	7.0	5.5	34814	29,20
M 10 x 1.0	90	20	7.0	5.5	34815	29,20
M 10 x 1.25	100	24	7.0	5.5	34816	29,20
M 11 x 1.0	90	20	8.0	6.2	34817	40,80
M 11 x 1.25	90	22	8.0	6.2	34818	40,80
M 12 x 0.75	100	22	9.0	7.0	34819	40,80
M 12 x 1.0	100	22	9.0	7.0	34820	40,80
M 12 x 1.25	100	22	9.0	7.0	34821	40,80
M 12 x 1.5	100	22	9.0	7.0	34822	40,80
M 13 x 1.0	100	22	11.0	9.0	34823	49,60
M 13 x 1.5	100	22	11.0	9.0	34824	49,60
M 14 x 0.75	100	22	11.0	9.0	34825	49,60
M 14 x 1.0	100	22	11.0	9.0	34826	49,60
M 14 x 1.25	100	22	11.0	9.0	34827	49,60
M 14 x 1.5	100	22	11.0	9.0	34828	49,60
M 15 x 1.0	100	22	12.0	9.0	34829	57,50
M 15 x 1.5	100	22	12.0	9.0	34830	57,50
M 16 x 1.0	100	22	12.0	9.0	34831	57,50
M 16 x 1.25	100	22	12.0	9.0	34832	57,50
M 16 x 1.5	100	22	12.0	9.0	34833	57,50
M 18 x 1.0	110	25	14.0	11.0	34834	69,00
M 18 x 1.25	110	25	14.0	11.0	34835	69,00
M 18 x 1.5	110	25	14.0	11.0	34836	69,00
M 18 x 2.0	125	34	14.0	11.0	34837	69,00

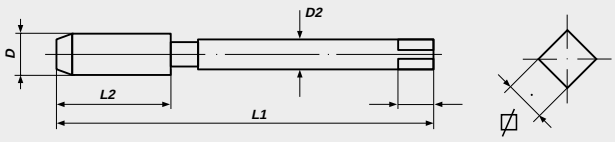
►►►

Application:

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

Applicazione:

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



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

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

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

Nominal Diameter D		L 1	L 2	D 2	⌀	Art.-No.	€
M	20 x 1.0	125	25	16.0	12.0	34838	76,00
M	20 x 1.25	125	25	16.0	12.0	34839	76,00
M	20 x 1.5	125	25	16.0	12.0	34840	76,00
M	20 x 2.0	140	34	16.0	12.0	34841	76,00
M	21 x 1.5	125	25	16.0	12.0	34842	76,00
M	22 x 1.0	125	25	18.0	14.5	34843	95,00
M	22 x 1.25	125	25	18.0	14.5	34844	95,00
M	22 x 1.5	125	25	18.0	14.5	34845	95,00
M	22 x 2.0	140	34	18.0	14.5	34846	95,00
M	23 x 1.5	125	25	18.0	14.5	34847	110,00
M	24 x 1.0	140	28	18.0	14.5	34848	110,00
M	24 x 1.25	140	28	18.0	14.5	34849	110,00
M	24 x 1.5	140	28	18.0	14.5	34850	110,00
M	24 x 2.0	140	28	18.0	14.5	34851	110,00
M	25 x 1.0	140	28	18.0	14.5	34852	110,00
M	25 x 1.5	140	28	18.0	14.5	34853	110,00
M	26 x 1.0	140	28	18.0	14.5	3485X	110,00
M	26 x 1.5	140	28	18.0	14.5	34854	110,00
M	26 x 2.0	140	28	18.0	14.5	34855	110,00
M	27 x 1.0	140	28	20.0	16.0	34800	139,00
M	27 x 1.5	140	28	20.0	16.0	34856	139,00
M	27 x 2.0	140	28	20.0	16.0	34857	139,00
M	28 x 1.0	140	28	20.0	16.0	34858	139,00
M	28 x 1.5	140	28	20.0	16.0	34859	139,00
M	28 x 2.0	140	28	20.0	16.0	34860	139,00
M	29 x 1.5	150	28	22.0	18.0	34861	158,50
M	30 x 1.0	150	28	22.0	18.0	34862	158,50
M	30 x 1.5	150	28	22.0	18.0	34863	158,50
M	30 x 2.0	150	28	22.0	18.0	34864	158,50
M	30 x 2.5	180	45	22.0	18.0	3486X	158,50
M	30 x 3.0	180	45	22.0	18.0	34865	158,50
M	32 x 1.5	150	28	22.0	18.0	34866	196,00
M	32 x 2.0	150	28	22.0	18.0	34867	196,00
M	32 x 3.0	180	50	22.0	18.0	34892	196,00
M	33 x 1.5	160	30	25.0	20.0	34893	196,00
M	33 x 2.0	160	30	25.0	20.0	34868	196,00
M	33 x 3.0	180	50	25.0	20.0	34869	196,00

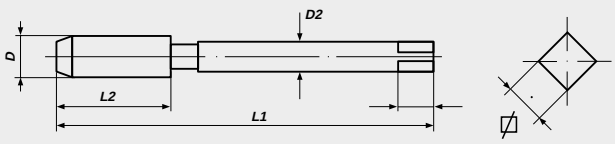
►►►

Application:

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

Applicazione:

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



VÖLKEL
THREADING SOLUTIONS

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

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

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

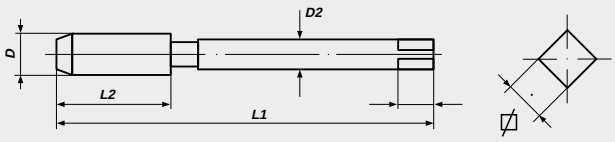
Nominal Diameter D	L 1	L 2	D 2	⌀	Art.-No.	€
M 34 x 1.5	170	30	28.0	22.0	34870	196,00
M 34 x 2.0	170	30	28.0	22.0	34871	196,00
M 35 x 1.5	170	30	28.0	22.0	34872	196,00
M 36 x 1.5	170	30	28.0	22.0	34873	246,00
M 36 x 2.0	170	30	28.0	22.0	34874	246,00
M 36 x 3.0	200	56	28.0	22.0	34875	246,00
M 38 x 1.5	170	30	28.0	22.0	34876	260,00
M 39 x 1.5	170	30	32.0	24.0	34877	260,00
M 39 x 2.0	170	30	32.0	24.0	34878	260,00
M 39 x 3.0	200	60	32.0	24.0	34879	260,00
M 40 x 1.5	170	30	32.0	24.0	34880	285,00
M 40 x 2.0	170	30	32.0	24.0	34881	285,00
M 40 x 3.0	200	60	32.0	24.0	34882	285,00
M 42 x 1.5	170	30	32.0	24.0	34883	318,00
M 42 x 2.0	170	30	32.0	24.0	34884	318,00
M 42 x 3.0	200	60	32.0	24.0	34885	318,00
M 45 x 1.5	180	32	36.0	29.0	34886	375,00
M 45 x 2.0	180	32	36.0	29.0	34887	375,00
M 45 x 3.0	200	50	36.0	29.0	34888	375,00
M 48 x 1.5	190	32	36.0	29.0	34889	452,00
M 48 x 2.0	190	32	36.0	29.0	34890	452,00
M 48 x 3.0	225	50	36.0	29.0	34891	452,00
M 50 x 1.5	190	32	36.0	29.0	34894	525,00
M 50 x 2.0	190	32	36.0	29.0	34895	525,00
M 50 x 3.0	225	50	36.0	29.0	34896	525,00
M 52 x 1.5	190	32	40.0	32.0	34897	580,00
M 52 x 2.0	190	32	40.0	32.0	34898	580,00
M 52 x 3.0	225	50	40.0	32.0	34899	580,00

Application:

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

Applicazione:

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



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

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

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

Nominal Diameter D		L 1	L 2	D 2	⧄	Art.-No.	€
M	3 x 0.35	56	5	2.2	-	34901	29,20
M	4 x 0.35	63	5	2.8	2.1	34902	29,20
M	4 x 0.5	63	5	2.8	2.1	34903	29,20
M	5 x 0.5	70	5	3.5	2.7	34904	29,20
M	5 x 0.75	70	8	3.5	2.7	34905	29,20
M	6 x 0.5	80	5	4.5	3.4	34906	29,20
M	6 x 0.75	80	8	4.5	3.4	34907	29,20
M	7 x 0.75	80	8	5.5	4.3	34908	29,20
M	8 x 0.5	80	8	6.0	4.9	34909	29,20
M	8 x 0.75	80	8	6.0	4.9	34910	29,20
M	8 x 1.0	90	10	6.0	4.9	34911	29,20
M	9 x 0.75	80	10	7.0	5.5	34912	29,20
M	9 x 1.0	90	10	7.0	5.5	34913	29,20
M	10 x 0.75	90	10	7.0	5.5	34914	35,30
M	10 x 1.0	90	10	7.0	5.5	34915	35,30
M	10 x 1.25	100	16	7.0	5.5	34916	35,30
M	11 x 1.0	90	11	8.0	6.2	34917	45,20
M	11 x 1.25	90	14	8.0	6.2	34918	45,20
M	12 x 0.75	100	10	9.0	7.0	34919	45,20
M	12 x 1.0	100	11	9.0	7.0	34920	45,20
M	12 x 1.25	100	15	9.0	7.0	34921	45,20
M	12 x 1.5	100	15	9.0	7.0	34922	45,20
M	13 x 1.0	100	11	11.0	9.0	34923	55,20
M	13 x 1.5	100	15	11.0	9.0	34924	55,20
M	14 x 0.75	100	10	11.0	9.0	34925	55,20
M	14 x 1.0	100	11	11.0	9.0	34926	55,20
M	14 x 1.25	100	15	11.0	9.0	34927	55,20
M	14 x 1.5	100	15	11.0	9.0	34928	55,20
M	15 x 1.0	100	12	12.0	9.0	34929	63,30
M	15 x 1.5	100	15	12.0	9.0	34930	63,30
M	16 x 1.0	100	12	12.0	9.0	34931	63,30
M	16 x 1.25	100	15	12.0	9.0	34932	63,30
M	16 x 1.5	100	15	12.0	9.0	34933	63,30
M	18 x 1.0	110	13	14.0	11.0	34934	78,50
M	18 x 1.25	110	15	14.0	11.0	34935	78,50
M	18 x 1.5	110	17	14.0	11.0	34936	78,50
M	18 x 2.0	125	20	14.0	11.0	34937	78,50

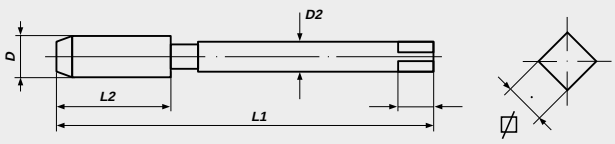
►►►

Application:

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

Applicazione:

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



VÖLKEL
THREADING SOLUTIONS

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

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

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

Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
M 20 x 1.0	125	14	16.0	12.0	34938	87,60
M 20 x 1.25	125	17	16.0	12.0	34939	87,60
M 20 x 1.5	125	17	16.0	12.0	34940	87,60
M 20 x 2.0	140	20	16.0	12.0	34941	87,60
M 21 x 1.5	125	17	16.0	12.0	34942	87,60
M 22 x 1.0	125	14	18.0	14.5	34943	105,00
M 22 x 1.25	125	17	18.0	14.5	34944	105,00
M 22 x 1.5	125	17	18.0	14.5	34945	105,00
M 22 x 2.0	140	20	18.0	14.5	34946	105,00
M 23 x 1.5	125	17	18.0	14.5	34947	126,00
M 24 x 1.0	140	15	18.0	14.5	34948	126,00
M 24 x 1.25	140	17	18.0	14.5	34949	126,00
M 24 x 1.5	140	20	18.0	14.5	34950	126,00
M 24 x 2.0	140	20	18.0	14.5	34951	126,00
M 25 x 1.0	140	15	18.0	14.5	34952	126,00
M 25 x 1.5	140	20	18.0	14.5	34953	126,00
M 26 x 1.0	140	15	18.0	14.5	3495X	126,00
M 26 x 1.5	140	20	18.0	14.5	34954	126,00
M 26 x 2.0	140	20	18.0	14.5	34955	126,00
M 27 x 1.0	140	15	20.0	16.0	34900	153,00
M 27 x 1.5	140	20	20.0	16.0	34956	153,00
M 27 x 2.0	140	20	20.0	16.0	34957	153,00
M 28 x 1.0	140	15	20.0	16.0	34958	153,00
M 28 x 1.5	140	20	20.0	16.0	34959	153,00
M 28 x 2.0	140	20	20.0	16.0	34960	153,00
M 29 x 1.5	150	22	22.0	18.0	34961	174,00
M 30 x 1.0	150	17	22.0	18.0	34962	174,00
M 30 x 1.5	150	22	22.0	18.0	34963	174,00
M 30 x 2.0	150	22	22.0	18.0	34964	174,00
M 30 x 2.5	180	27	22.0	18.0	3496X	174,00
M 30 x 3.0	180	30	22.0	18.0	34965	174,00
M 32 x 1.5	150	22	22.0	18.0	34966	217,00
M 32 x 2.0	150	22	22.0	18.0	34967	217,00
M 32 x 3.0	180	30	22.0	18.0	34992	217,00
M 33 x 1.5	160	24	25.0	20.0	34993	217,00
M 33 x 2.0	160	24	25.0	20.0	34968	217,00
M 33 x 3.0	180	30	25.0	20.0	34969	217,00

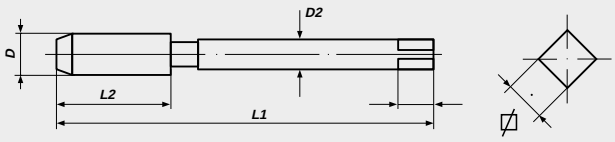
►►►

Application:

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

Applicazione:

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



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

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

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

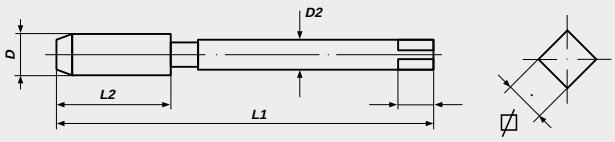
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
M 34 x 1.5	170	24	28.0	22.0	34970	217,00
M 34 x 2.0	170	24	28.0	22.0	34971	217,00
M 35 x 1.5	170	24	28.0	22.0	34972	217,00
M 36 x 1.5	170	24	28.0	22.0	34973	275,00
M 36 x 2.0	170	24	28.0	22.0	34974	275,00
M 36 x 3.0	200	30	28.0	22.0	34975	275,00
M 38 x 1.5	170	24	28.0	22.0	34976	287,00
M 39 x 1.5	170	25	32.0	24.0	34977	287,00
M 39 x 2.0	170	25	32.0	24.0	34978	287,00
M 39 x 3.0	200	30	32.0	24.0	34979	287,00
M 40 x 1.5	170	25	32.0	24.0	34980	312,00
M 40 x 2.0	170	25	32.0	24.0	34981	312,00
M 40 x 3.0	200	30	32.0	24.0	34982	312,00
M 42 x 1.5	170	25	32.0	24.0	34983	353,00
M 42 x 2.0	170	25	32.0	24.0	34984	353,00
M 42 x 3.0	200	30	32.0	24.0	34985	353,00
M 45 x 1.5	180	27	36.0	29.0	34986	415,00
M 45 x 2.0	180	27	36.0	29.0	34987	415,00
M 45 x 3.0	200	30	36.0	29.0	34988	415,00
M 48 x 1.5	190	27	36.0	29.0	34989	495,00
M 48 x 2.0	190	27	36.0	29.0	34990	495,00
M 48 x 3.0	225	33	36.0	29.0	34991	495,00
M 50 x 1.5	190	27	36.0	29.0	34994	576,00
M 50 x 2.0	190	27	36.0	29.0	34995	576,00
M 50 x 3.0	225	33	36.0	29.0	34996	576,00
M 52 x 1.5	190	27	40.0	32.0	34997	631,00
M 52 x 2.0	190	27	40.0	32.0	34998	631,00
M 52 x 3.0	225	33	40.0	32.0	34999	631,00

Application:

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

Applicazione:

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



VÖLKEL
THREADING SOLUTIONS

Machine Taps, *Left Hand*
Whitworth-thread BS 84

Maschi a macchina, *filetto sinistro*
filettatura Whitworth BS 84

≈ DIN 371/376 Form B HSS-E

BSW

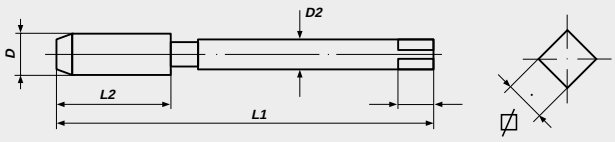
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
≈ DIN 371						
BSW 1/8 x 40	56	11	3.5	2.7	70201	12,90
BSW 5/32 x 32	63	13	4.5	3.4	70202	12,90
BSW 3/16 x 24	70	15	6.0	4.9	70203	12,90
BSW 1/4 x 20	80	17	7.0	5.5	70204	12,90
BSW 5/16 x 18	90	20	8.0	6.2	70205	16,40
BSW 3/8 x 16	100	22	9.0	7.0	70206	18,30
BSW 7/16 x 14	100	22	11.0	9.0	70207	21,80
≈ DIN 376						
BSW 1/2 x 12	110	25	9.0	7.0	70221	21,80
BSW 9/16 x 12	110	26	11.0	9.0	70222	33,10
BSW 5/8 x 11	110	27	12.0	9.0	70223	33,10
BSW 3/4 x 10	125	30	14.0	11.0	70224	64,00
BSW 7/8 x 9	140	32	18.0	14.5	70225	78,00
BSW 1" x 8	160	36	20.0	16.0	70226	89,00

Application:

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

Applicazione:

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



Machine Taps, *Left Hand*

Whitworth-thread BS 84

Maschi a macchina, *filetto sinistro*

filettatura Whitworth BS 84

≈ DIN 371/376 Form C/35° SP HSS-E BSW

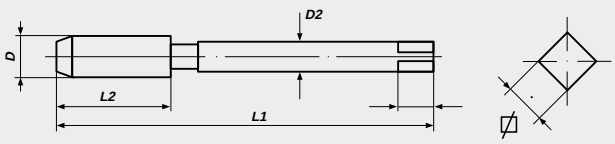
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
≈ DIN 371						
BSW 1/8 x 40	56	7	3.5	2.7	70209	16,10
BSW 5/32 x 32	63	7	4.5	3.4	70210	16,10
BSW 3/16 x 24	70	10	6.0	4.9	70211	16,10
BSW 1/4 x 20	80	13	7.0	5.5	70212	16,10
BSW 5/16 x 18	90	14	8.0	6.2	70213	20,00
BSW 3/8 x 16	100	16	9.0	7.0	70214	22,00
BSW 7/16 x 14	100	17	11.0	9.0	70215	27,10
≈ DIN 376						
BSW 1/2 x 12	110	20	9.0	7.0	70234	27,10
BSW 9/16 x 12	110	20	11.0	9.0	70235	40,00
BSW 5/8 x 11	110	22	12.0	9.0	70236	40,00
BSW 3/4 x 10	125	25	14.0	11.0	70237	80,00
BSW 7/8 x 9	140	27	18.0	14.5	70238	97,00
BSW 1" x 8	160	30	20.0	16.0	70239	110,00

Application:

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

Applicazione:

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



VÖLKEL THREADING SOLUTIONS

Machine Taps, *Left Hand*
Unified thread ANSI B1.1

Maschi a macchina, *filetto sinistro*
filettatura unificata ANSI B1.1

≈ DIN 371/376 Form B HSS-E Tol. 2B UNC/UNF

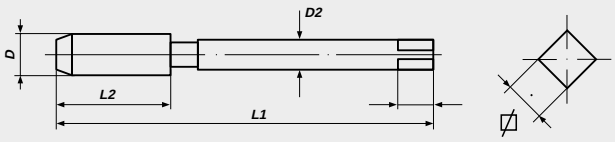
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
UNC ≈DIN 371						
UNC Nr. 6 x 32	56	12	4.0	3.0	74203	13,00
UNC Nr. 8 x 32	63	13	4.5	3.4	74204	13,00
UNC Nr. 10 x 24	70	15	6.0	4.9	74205	13,00
UNC 1/4 x 20	80	17	7.0	5.5	74207	13,00
UNC 5/16 x 18	90	20	8.0	6.2	74208	16,50
UNC 3/8 x 16	100	22	9.0	7.0	74209	18,30
≈DIN 376						
UNC 7/16 x 14	100	22	8.0	6.2	74228	21,80
UNC 1/2 x 13	110	25	9.0	7.0	74229	21,80
UNC 9/16 x 12	110	26	11.0	9.0	74230	33,10
UNC 5/8 x 11	110	27	12.0	9.0	74231	33,10
UNC 3/4 x 10	125	30	14.0	11.0	74232	64,00
UNC 7/8 x 9	140	32	18.0	14.5	74233	78,00
UNC 1" x 8	160	36	20.0	16.0	74234	88,50
UNF ≈DIN 371						
UNF Nr. 10 x 32	70	15	6.0	4.9	76205	13,00
UNF 1/4 x 28	80	17	7.0	5.5	76207	13,00
UNF 5/16 x 24	90	17	8.0	6.2	76208	16,50
UNF 3/8 x 24	100	18	9.0	7.0	76209	18,30
UNF 7/16 x 20	100	22	11.0	9.0	76210	21,80
≈DIN 376						
UNF 7/16 x 20	100	22	8.0	6.2	76220	21,80
UNF 1/2 x 20	100	22	9.0	7.0	76222	21,80
UNF 9/16 x 18	100	22	11.0	9.0	76223	33,10
UNF 5/8 x 18	100	22	12.0	9.0	76224	33,10
UNF 3/4 x 16	110	25	14.0	11.0	76225	64,00
UNF 7/8 x 14	140	26	18.0	14.5	76226	78,00
UNF 1" x 12	150	28	20.0	16.0	76227	88,50
UNF 1" x 14	150	28	20.0	16.0	76228	88,50

Application:

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

Applicazione:

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



Machine Taps, *Left Hand*
Unified thread ANSI B1.1

Maschi a macchina, *filetto sinistro*
filettatura unificata ANSI B1.1

≈ DIN 371/376 Form C/35° SP HSS-E Tol. 2B UNC/UNF

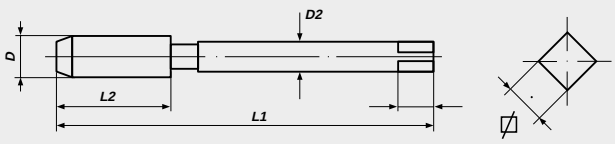
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
UNC ≈DIN 371						
UNC Nr. 6 x 32	56	7	4.0	3.0	74212	16,10
UNC Nr. 8 x 32	63	8	4.5	3.4	74213	16,10
UNC Nr. 10 x 24	70	10	6.0	4.9	74214	16,10
UNC 1/4 x 20	80	13	7.0	5.5	74216	16,10
UNC 5/16 x 18	90	14	8.0	6.2	74217	20,00
UNC 3/8 x 16	100	16	9.0	7.0	74218	22,10
≈DIN 376						
UNC 7/16 x 14	100	17	8.0	6.2	74248	27,10
UNC 1/2 x 13	110	20	9.0	7.0	74249	27,10
UNC 9/16 x 12	110	20	11.0	9.0	74250	40,00
UNC 5/8 x 11	110	22	12.0	9.0	74251	40,00
UNC 3/4 x 10	125	25	14.0	11.0	74252	80,00
UNC 7/8 x 9	140	27	18.0	14.5	74253	97,00
UNC 1" x 8	160	30	20.0	16.0	74254	110,00
UNF ≈DIN 371						
UNF Nr. 10 x 32	70	10	6.0	4.9	76215	16,10
UNF 1/4 x 28	80	10	7.0	5.5	76217	16,10
UNF 5/16 x 24	90	10	8.0	6.2	76218	20,00
UNF 3/8 x 24	100	10	9.0	7.0	76219	22,10
≈DIN 376						
UNF 1/2 x 20	100	13	9.0	7.0	76232	27,10
UNF 9/16 x 18	100	15	11.0	9.0	76233	40,00
UNF 5/8 x 18	100	15	12.0	9.0	76234	40,00
UNF 3/4 x 16	110	17	14.0	11.0	76235	80,00
UNF 7/8 x 14	140	17	18.0	14.5	76236	97,00
UNF 1" x 12	150	20	20.0	16.0	76237	110,00
UNF 1" x 14	150	20	20.0	16.0	76238	110,00

Application:

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

Applicazione:

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



VÖLKEL
THREADING SOLUTIONS

Machine Taps, *Left Hand*

Pipe-thread DIN ISO 228

Maschi a macchina, *filetto sinistro*

filettatura per tubi gas DIN ISO 228

DIN 5156 Form C HSS-E

G (BSP)

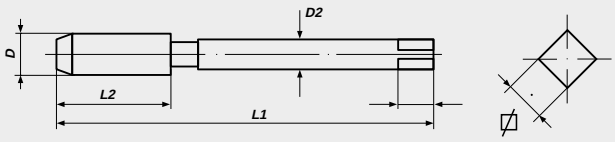
Nominal Diameter D	L 1	L 2	D 2	⊠	Art.-No.	€
G 1/8 x 28	90	20	7.0	5.5	78202	20,00
G 1/4 x 19	100	22	11.0	9.0	78203	24,70
G 3/8 x 19	100	22	12.0	9.0	78204	31,00
G 1/2 x 14	125	25	16.0	12.0	78205	43,60
G 5/8 x 14	125	25	18.0	14.5	78206	50,40
G 3/4 x 14	140	28	20.0	16.0	78207	64,00
G 1" x 11	160	30	25.0	20.0	78209	64,50

Application:

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

Applicazione:

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



MACHINE TAPS WITH COLOURED RING
MASCHI A MACCHINA CON COLLARINI COLORATI

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

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

Material **Materiali**	Cutting Speed Velocita di taglio V= m/min	coolants and lubrications Refrigerazione e lubrificante
Unalloyed steels, tensile strength < 800 N/mm² Acciai non legati, resistenza alla trazione < 800 N/mm²	10 - 18	drilling oil emulsion, cutting oil also with lubricity-increasing additives Emulsione, Olio da taglio con additivi che aumentano la lubrificazione
Machining steels, case hardening steels, tempered steels Acciai automatici, acciai da cementazione, acciai bonificati	10 - 18	
Unalloyed steels, tensile strength < 1000 N/mm² Acciai non legati, resistenza alla trazione < 1000 N/mm²	6 - 10	
Unalloyed and alloyed steels, tensile strength < 1200 N/mm² Acciai legati e non legati, resistenza alla trazione < 1200 N/mm²	3 - 5	thread cutting oil, cutting oil highly activated with special additives, solid lubricants Olio da taglio per maschiatura, Olio da taglio con additivi lubrificanti solidi
Unalloyed and alloyed steels, tensile strength > 1200 N/mm² Acciai legati e non legati, resistenza alla trazione > 1200 N/mm²	2 - 4	
Stainless and acid-resistant steels; VA-steels < 850 N/mm² Acciai inossidabili <850 N / mm²	2 - 4	
Rust- and acid-resistant steels with high chromium-nickel content, V4A steels Acciai inossidabili con alto contenuto in Cromo-Nickel, Acciai V4A	2 - 4	
Gray cast iron Ghisa grigia	8 - 16	thread cutting oil, special thread cutting oil and emulsion Olio da taglio per maschiatura ed emulsione
Graphite cast iron, malleable cast iron Ghisa sferoidale etemprata	8 - 16	
Copper alloys short chipping Leghe di rame, ottone a truciolo corto	18 - 24	thread cutting oil, emulsion Olio da taglio maschiatura, emulsione
Long-chipping brass Ottone a truciolo lungo	12 - 18	
Aluminium, magnesium, unalloyed Alluminio, Magnesio, non legato	20 - 30	thread cutting oil for non-ferrous metals, emulsion, petroleum Olio da taglio per maschiatura per metalli non ferrosi Emulsione, Petrolio
Aluminium alloys, Si < 0,5% Leghe di alluminio, Si < 0,5%	18 - 24	
Aluminium alloys, Si 0,5 - 10% Leghe di alluminio, Si 0,5 - 10%	14 - 18	
Aluminium alloys, Si > 10% Leghe di alluminio, Si > 10%	8 - 10	
Titanium alloys Leghe di titanio	2 - 4	oil, special thread cutting oil Olio, o da taglio speciale per maschiatura
Thermoplastics Termoplastiche	18 - 24	mold release oil, dry, oil mist, compressed air, emulsion Olio di distacco dallo stampo, secco, Olio nebulizzato, secco, aria compressa, emulsione
Thermosetting and fibre-reinforced plastics Duroplaste e plastica rinforzata con fibre	8 - 12	

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

Material **Materiali**	Green Ring collarino verde	Green Ring PM collarino verde PM	Blue Ring collarino blu	White Ring collarino bianco	Black Ring collarino nero	Yellow Ring collarino giallo	Orange Ring collarino arancion	Red Ring collarino rosso
Unalloyed steels, tensile strength < 800 N/mm² Acciai non legati, resistenza alla trazione < 800 N/mm²	●	PM						
Machining steels, case hardening steels, tempered steels Acciai automatici, acciai da cementazione, acciai bonificati	●	PM	●	○				
Unalloyed steels, tensile strength < 1000 N/mm² Acciai non legati, resistenza alla trazione < 1000 N/mm²	●	PM	●					
Unalloyed and alloyed steels, tensile strength < 1200 N/mm² Acciai legati e non legati, resistenza alla trazione < 1200 N/mm²		PM	●					○
Unalloyed and alloyed steels, tensile strength > 1200 N/mm² Acciai legati e non legati, resistenza alla trazione > 1200 N/mm²								●
Stainless and acid-resistant steels; VA-steels < 850 N/mm² Acciai inossidabili <850 N / mm²		PM	○	○				
Rust- and acid-resistant steels with high chromium-nickel content, V4A steels Acciai inossidabili con alto contenuto in Cromo-Nickel, Acciai V4A			●	○				
Gray cast iron Ghisa grigia					●			
Graphite cast iron, malleable cast iron Ghisa sferoidale etemprata	●	PM	●					
Copper alloys short chipping Leghe di rame, ottone a truciolo corto					○		●	
Long-chipping brass Ottone a truciolo lungo	○	PM						
Aluminium, magnesium, unalloyed Alluminio, Magnesio, non legato						●		
Aluminium alloys, Si < 0,5% Leghe di alluminio, Si < 0,5%			○			●		
Aluminium alloys, Si 0,5 - 10% Leghe di alluminio, Si 0,5 - 10%	○	PM	●			○		
Aluminium alloys, Si > 10% Leghe di alluminio, Si > 10%			●					
Titanium alloys Leghe di titanio			○	○				
Thermoplastics Termoplastiche	●	PM						
Thermosetting and fibre-reinforced plastics Duroplaste e plastica rinforzata con fibre			○		●			●

● = appropiate / idoneitá ottimale ○ = conditionally suitable / idoneitá limitata

Material No.	DIN	AISI	AFNOR	JIS	tensile strength N/mm² min./max.		recommendation 1	recommendation 2
1.0044	St 44-2	A 570:Gr.40	E-28-2	SM 41 B	410	560	Standard Form A-C-B-RSP	Green Ring
1.0060	St 60-2			SM 570	600	720	Standard Form A-C-B-RSP	Green Ring
1.0070	St 70-2				670	830	Standard Form A-C-B-RSP	Green Ring
1.0116	St 37-3	A 573;Gr.58	E 24-3;E 24-4		370	450	Standard Form A-C-B-RSP	Green Ring
1.0570	St 52-3		E 36-3;E 36-4	SM 50 YA	450	680	Standard Form A-C-B-RSP	Green Ring
1.0301	C 10	1010	AF 34 C 10	S 10 C	490	780	Standard Form A-C-B-RSP	Green Ring
1.0402	C 22	1020	AF 42 C 20		470	650	Standard Form A-C-B-RSP	Green Ring
1.0501	C 35	1035	AF 55 C 35		550	780	Standard Form A-C-B-RSP	Green Ring
1.0511	C 40	1040	AF 60 C 40		600	800	Standard Form A-C-B-RSP	Green Ring
1.0711	9S 20	1112		SUM 21	370	450	Green Ring	Standard Form B-RSP
1.0715	9SMn 28	1213	S 250	SUM 22	390	580	Green Ring	Standard Form B-RSP
1.0718	9SMnPb 28	12L13	S 250 Pb	SUM 22 L	380	810	Green Ring	Standard Form B-RSP
1.0726	35S 20	1140	35 MF 6		510	880	Green Ring	Standard Form B-RSP
1.0736	9SMn 36	1215	S 300		390	800	Green Ring	Standard Form B-RSP
1.0737	9SMnPb 36	12L14	S 300 Pb		390	800	Green Ring	Standard Form B-RSP
1.0712	13Cr 3				500	800	Green Ring	Standard Form B-RSP
1.1121	Ck 10	1010	XC 10	S 10 C	450	630	Green Ring	Standard Form B-RSP
1.1141	Ck 15	1015	XC 15;XC 18	S 15C;S 15 CK	450	630	Green Ring	Standard Form B-RSP
1.7131	16MnCr 5	5115	16 MC 5	SCR 415	500	700	Green Ring	Standard Form B-RSP
1.1151	Ck 22	1023	XC 25;XC 18	S 20 C; S 20 CK	470	650	Green Ring	Standard Form B-RSP
1.1158	Ck 25	1025	XC 25	S 25 C	500	700	Green Ring	Standard Form B-RSP
1.1183	Cf 35				540	780	Green Ring	Standard Form B-RSP
1.1191	Ck 45	1045	XC 42	S 45 C	650	850	Green Ring PM	Green Ring
1.1203	Ck 55	1055	XC 55	S 55 C	700	950	Green Ring PM	Green Ring
1.1213	Cf 53		XC 48 TS		650	800	Green Ring PM	Green Ring
1.1221	Ck 60	1060	XC 60	S 58 C	750	1000	Green Ring PM	Green Ring
1.5752	14NiCr 14 (ECN 35)	3310;9314	12 NC 15	SNC 815 (H)	880	1000	Green Ring PM	Green Ring
1.0401	C 15	1015	AF 34 C 12		600	900	Green Ring PM	Green Ring
1.0503	C 45	1045	AF 65 C 45	S 45 C	650	850	Green Ring PM	Green Ring
1.0535	C 55	1055			700	950	Green Ring PM	Green Ring
1.0601	C 60	1060	CC 55		750	1000	Green Ring PM	Green Ring
1.1157	40Mn 4	1039	35 M 5		800	1000	Green Ring PM	Green Ring
1.1181	Ck 35	1035	XC 38 H1;XC 32	S 35 C	550	780	Green Ring PM	Green Ring
1.6582	35CrNiMo 6	4340	35 NCD 6	SNCM 447	800	1000	Green Ring PM	Green Ring
1.7015	15Cr 3	5015	12 C 3	SCR 415 (H)	690	1000	Green Ring PM	Green Ring
1.7033	34Cr 4	5132	32 C 4	SCr 430 (H)	700	1000	Green Ring PM	Green Ring
1.7035	41Cr 4	5140	32 C 4	SCr 440 (H)	800	1000	Green Ring PM	Green Ring
1.7218	25CrMo 4	4130	25 CD 4 S	SCM 420;SCM 430	800	1000	Green Ring PM	Green Ring
1.7223	41CrMo 4	4142;4140	42 CD 4 TS	SCM 440	800	1000	Green Ring PM	Green Ring
1.7225	42CrMo 4	4142;4140	42 CD 4 TS	SCM 440	800	1000	Green Ring PM	Green Ring
1.7361	32CrMo 12		30 CD 12		690	1000	Green Ring PM	Green Ring
1.6582	35CrNiMo 6	4340	35 NCD 6	SNCM 447	1000	1200	Blue Ring	
1.8515	31 CrMo 12		30 CD 12		1000	1200	Blue Ring	
1.8519	31CrMo V 9				1000	1250	Blue Ring	
1.8523	39CrMoV 13 9				1000	1200	Blue Ring	
1.1157	40Mn 4	1039	35 M 5		1000	1100	Blue Ring	
1.6580	30CrNiMo 8		30 CND 8	SNCM 431	1000	1200	Blue Ring	
1.7218	25CrMo 4	4130	25 CD 4 S	SCM 420;SCM 430	1000	1100	Blue Ring	
1.7223	41CrMo 4	4142;4140	42 CD 4 TS	SCM 440	1000	1200	Blue Ring	
1.7225	42CrMo 4 V	4142;4140	42 CD 4 TS	SCM 440	1000	1200	Blue Ring	
1.2080	X210Cr 12	D 3	Z 200 C 12	SKD 1	830	830	Blue Ring	
1.2210	115CrV 3	L 2	100 C 3		730	730	Blue Ring	
1.2363	X100CrMoV 5 1	A 2	Z 100 CDV 5	SKD 12	760	760	Blue Ring	
1.2436	X210CRW 12			SKD 2	760	760	Blue Ring	
1.2510	100MnCrW 4	O 1	90 MWCV 5		720	720	Blue Ring	
1.2601	X165CrMoV 12		Z 160 CDV 12		760	760	Blue Ring	
1.2631	X50CrMoW 9 11				860	860	Blue Ring	
1.2842	90MnCrV 8	O2	90 M V 8		740	740	Blue Ring	
1.3207	S10-4-3-10		Z 130 WKCDV 10-10-04-040		1000	1200	Blue Ring	
1.8151	50CrV 4						Blue Ring	
1.8161	58CrV 4				1000	1200	Blue Ring	
1.2083	X42Cr 13		Z 40 C 14	SUS 420 J 2		770	Blue Ring	
1.2311	40CrMnMo 7					770	Blue Ring	
1.2316	X36CrMo 17					840	Blue Ring	
1.2343	X38CrMoV 5 1	H 11	Z 38 CDV 5	SKD 6		800	Blue Ring	
1.2344	X40CrMoV 5 1	H 13	Z 40 CDV 5	SKD 61		800	Blue Ring	
1.2365	X32CrMoV 3 3	H 10	Z 32 DCV 28	SKD 7		800	Blue Ring	
1.2542	45WCrV 7	S 1					Blue Ring	
1.2581	X30WCrV 9 3	H 21	Z 30 WCV 9			800	Blue Ring	
1.2713	55NiCrMoV 6	L 6	55 NCDV 7	SKT 4		800	Blue Ring	
1.2743	60NiCrMoV 12 4						Blue Ring	
1.2766	35NiCrMo 16						Blue Ring	
1.4973	NiCr19CoMo				1200	1320	Red Ring	
1.4980	X5NiCrTi26 15				930	1180	Red Ring	
1.6582	35CrNiMo 6	4340	35 NCD 6	SNCM 447	1200	1400	Red Ring	
1.2379	X155CrVMo 12 1	D 2	Z 160 CDV 12	SKD 11	1200	1400	Red Ring	
1.2714	56NiCrMoV 7				1200	1400	Red Ring	
1.8159	50CrV 4	6150	50 CV 4	SUP 10	1200	1300	Red Ring	
1.4006	X10Cr 13	410;CA-15	Z 12 C 13	SUS 410	450	650	Blue Ring	Blue Ring
1.4008	GX8CrNi 13				590	790	White Ring	Blue Ring
1.4021	X20Cr 13	420	Z 20 C 13	SUS 420 J 1	650	950	White Ring	Blue Ring
1.4027	GX20Cr 14		Z 20 C 13 M		590	700	White Ring	Blue Ring
1.4028	X30Cr 13	420	Z 30 C 13	SUS 420 J 2	600	780	White Ring	Blue Ring
1.4031	X39Cr 13	420	Z 40 C 14	SUS 420 J 2	560	800	White Ring	Blue Ring

Material No.	DIN	AISI	AFNOR	JIS	tensile strength N/mm² min./max.		recommendation 1	recommendation 2
1.4057	X17CrNi 162	431	Z 15 CN 16.02	SUS 431	650	850	Blue Ring	White Ring
1.4104	X14CrMoS 17	430 F	Z 13 CF 17	SUS 430 F	540	840	White Ring	Blue Ring
1.4125	X105CrMo 17	440 C	Z 100 CD 17	SUS 440 C	900	900	Blue Ring	White Ring
1.4301	X5CrNi18 10	304 (V2A)	Z 6 CN 18.09	SUS 304	500	700	White Ring	Blue Ring
1.4305	X8CrNiS 18 9	303	Z 10 CNF 18.09	SUS 303	500	750	White Ring	Blue Ring
1.4306	X2CrNi 19 11	304L (V2A)	Z 2 CN 18.10	SCS 19	460	850	White Ring	Blue Ring
1.4308	GX5CrNi 19 10		Z 6 CN 18.10 M		460	640	White Ring	Blue Ring
1.4310	X10CrNi 18 8	301	Z 11 CN 17-08	SUS 301	700	950	White Ring	Blue Ring
1.4311	X2CrNiN 18 10	304 LN	Z c2 CN 18.10	SUS 304 LN	550	760	White Ring	Blue Ring
1.4541	X10CrNiTi 18 9	321 (V2A)	Z 6 CNT 18.10	SUS 321	500	700	White Ring	Blue Ring
1.4401	X5CrNiMo 17 12 1	316 (V4A)	Z 6 CND 17.11	SUS 316	510	710	White Ring	Blue Ring
1.4404	X2CrNiMo 17 12 2	316L (V4A)	Z 2 CND 17.12	SUS 316 L	490	850	White Ring	Blue Ring
1.4406	X2CrNiMoN 17 12 2	316 LN	Z 2 CND 17.12 AZ	SUS 316 LN	580	800	White Ring	Blue Ring
1.4429	X2CrNiMoN 17 13 3	316 LN	Z 2 CND 17.13 AZ	SUS 316 LN	580	800	White Ring	Blue Ring
1.4435	X2CrNiMo 18 14 3	316 L	Z 2 CND 17.13	SCS 16;SUS 316 L	490	690	White Ring	Blue Ring
1.4436	X5CrNiM0 17 13 3	316	Z 2 CND 17.12	SUS 316	510	710	White Ring	Blue Ring
1.4438	X2CrNiMo 18 16	317 L	Z 2 CND 19.15	SUS 317 L	490	690	White Ring	Blue Ring
1.4449	X5CrNiMo 17 13	317					White Ring	Blue Ring
1.4460	X4CrNiMoN 27 5 2	329	Z 5 CDN 27-05	SUS 329 J 1	600	800	White Ring	Blue Ring
1.4462	X2CrNiMoN 22 5 3	2205	Z 3 CND 22-05 Az	SUS 329J3L	680	880	White Ring	Blue Ring
1.4503	X3NiCrCuMoTi 27 23				500	700	White Ring	Blue Ring
1.4505	X5NiCrMoCuNb 20 18				490	740	White Ring	Blue Ring
1.4510	X6CrTi 17	XM 8;430 TI	Z 8 CT 17	SUS 430 LX	450	600	White Ring	Blue Ring
1.4511	X6CrNb 17				450	600	White Ring	Blue Ring
1.4512	X6CrTi 12	409	Z 6 CT 12	SUH 409	330	560	Blue Ring	Blue Ring
1.4521	X2CrMoTi 18 2	444	Z 3 CDT 18-02	SUS 444	450	650	White Ring	Blue Ring
1.4542	X5CrNiCuPb 16 4	630	Z 7 CNU 15-05	SCS 630			White Ring	Blue Ring
1.4546	X5CrNiNb 18 10	348	Z 6 CNNb 18.10	SUS 347	410	610	White Ring	Blue Ring
1.4550	X6CrNiNb 18 10	347	Z 6 CN Nb 18.10	SUS 347	550	750	White Ring	Blue Ring
1.4552	GX5CrNiNb 19 10		Z 4 CN Nb 19.10 M		440	640	White Ring	Blue Ring
0.6015	GG15	A48-25 B	Ft 15 D	FC 15	110	150	Black Ring	
0.6020	GG20	A48-30 B	Ft 20 D	FC 20	150	200	Black Ring	
0.6025	GG25	A48-40 B	Ft 25 D	FC 25	200	250	Black Ring	
0.6030	GG30	A48-45 B	Ft 30 D	FC 30	240	270	Black Ring	
0.6035	GG35	A48-50 B	Ft 35 D	FC 35	280	320	Black Ring	
0.6040	GG40	A48-60 B	FT 40 D		350	450	Black Ring	
0.7040	GGG40	60-40-18	FGS 400-12	FCD 40	400	400	Standard Form A-C-B	Green Ring Form B
0.7050	GGG50	65-45-12	FGS 500-7	FCD 50	500	500	Standard Form A-C-B	Green Ring Form B
0.7060	GGG60	80-55-06	FGS 600-3	FCD 60	600	600	Standard Form A-C-B	Green Ring Form B
0.7070	GGG70	100-70-03	FGS 700-2	FCD 70	700	700	Standard Form A-C-B	Green Ring Form B
0.8035	GTW35-04	MB 350-4	MB35-7	FCMW 330	350	350	Standard Form A-C-B	Green Ring Form B
0.8055	GTS55-05				550	550	Standard Form A-C-B	Green Ring Form B
2.0401	CuZn39Pb 3 (MS58)	C 38500	MS58		630	630	Orange Ring	
2.0410	CuZn44Pb 2				630	630	Orange Ring	
2.0580	CuZn40MnPb				400	400	Orange Ring	
2.0250	CuZn 20						Standard Form C-B-B/ AZ-RSP	
2.0265	CuZn 30	C 26000	CuZn 30	C 2600			Standard Form C-B-B/ AZ-RSP	
2.0321	CuZn 37	C 27200	CuZn 37	C 2700			Standard Form C-B-B/ AZ-RSP	
2.0335	CuZn 36 (MS63)		Ms63	C 2700			Standard Form C-B-B/ AZ-RSP	
3.0250	AL 99.5 H		A 5	A1x1		350	Yellow Ring	Standard Form B-AZ
3.0280	AL 99.8 H						Yellow Ring	Standard Form B-AZ
3.0305	AL 99.9		A 9				Yellow Ring	Standard Form B-AZ
3.3308	AL 99.9 Mg 0,5						Yellow Ring	Standard Form B-AZ
3.0515	ALMn 1			144054			Yellow Ring	Standard Form B-AZ
3.0525	AlMn 1 Mg 05		A-M1G0,5				Yellow Ring	Standard Form B-AZ
3.0615	AlMgSi-Pb						Yellow Ring	Standard Form B-AZ
3.1325	AlCuMg 1		A-U4G				Yellow Ring	Standard Form B-AZ
3.1355	AlCuMg 2		A-U4G1	A3x4			Yellow Ring	Standard Form B-AZ
3.3315	AlMg 1		A-G0,5	A2x8			Yellow Ring	Standard Form B-AZ
3.4365	AlZnMgCu 1.5	7175	AZ 4 GU/9050 C				Yellow Ring	Standard Form B-AZ
3.2381	G-AlSi 10 Mg		A-S1OG				Blue Ring	
3.2383	G-AlSi 10 Mg (CU)	A 360.2	A-S1OGU				Blue Ring	
3.2581	G-AlSi 12	A 413.2	A-S13	AC3			Blue Ring	
3.2583	G-AlSi (CU)	A 413.1	A-S12U				Blue Ring	
3.2982	GD-AlSi 12 (CU)						Blue Ring	
3.5912	G-MgAl 9 Zn 1						Blue Ring	
3.2134	G-AlSi 5 Cu 1 Mg						Standard Form C-B-RSP	Blue Ring
3.2152	G-AlSi 6 Cu 4						Standard Form C-B-RSP	Blue Ring
3.2162	G-AlSi 8 Cu 3						Standard Form C-B-RSP	Blue Ring
3.2373	G-AlSi 9 Mg		A-S9G	AC4A			Standard Form C-B-RSP	Blue Ring
3.7115	TiAl 5 Sn 2				790	980	White Ring	
3.7165	TiAl 6 V 4	R56400	T-A6V		980	1140	Blue Ring	
3.7185	TiAl4Mo4Sn2				1000		Blue Ring	
	Polyamid						Standard Form B-RSP	Green Ring
	Polystyrol						Standard Form B-RSP	Green Ring
	Polyvinylchlorid						Standard Form B-RSP	Green Ring
	Ultramid						Standard Form B-RSP	Green Ring
CFK	Faserverstärkte				190	210	Black Ring	Red Ring
GFK	Kunsttoffe						Black Ring	Red Ring
	Bakelit						Black Ring	Red Ring
	Ferrozell						Black Ring	Red Ring
	Pertinax						Black Ring	Red Ring

GREEN RING-Machine Taps
metric ISO-thread DIN 13

Maschi a macchina con collarino verde
filettatura metrica ISO DIN 13

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

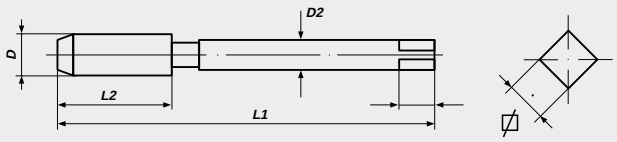
Nominal Diameter D	L 1	L 2	D 2	⌀	Art.-No.	€
DIN 371						
M 3 x 0.5	56	11	3.5	2.7	35326	8,90
M 4 x 0.7	63	13	4.5	3.4	35330	8,90
M 5 x 0.8	70	16	6.0	4.9	35334	9,70
M 6 x 1.0	80	19	6.0	4.9	35338	9,70
M 8 x 1.25	90	22	8.0	6.2	35342	11,20
M 10 x 1.5	100	24	10.0	8.0	35346	17,80
DIN 376						
M 12 x 1.75	110	29	9.0	7.0	35350	22,50
M 14 x 2.0	110	30	11.0	9.0	35354	23,00
M 16 x 2.0	110	32	12.0	9.0	35358	25,00
M 18 x 2.5	125	34	14.0	11.0	35362	37,00
M 20 x 2.5	140	34	16.0	12.0	35366	52,00
SET						
M 3 - 12	M 3-4-5-6-8-10 (DIN 371), M 12 (DIN 376)				47853	87,00

Application:

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

Applicazione:

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



GREEN RING-Machine Taps
metric ISO-thread DIN 13

Maschi a macchina con collarino verde
filettatura metrica ISO DIN 13

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

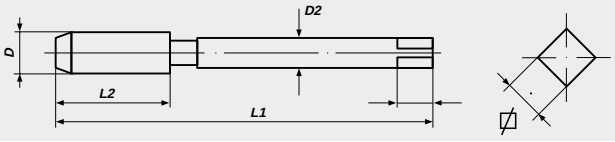
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
DIN 371						
M 3 x 0.5	56	6	3.5	2.7	36326	10,70
M 4 x 0.7	63	7	4.5	3.4	36330	10,70
M 5 x 0.8	70	8	6.0	4.9	36334	11,70
M 6 x 1.0	80	10	6.0	4.9	36338	11,70
M 8 x 1.25	90	14	8.0	6.2	36342	13,50
M 10 x 1.5	100	16	10.0	8.0	36346	20,00
DIN 376						
M 12 x 1.75	110	18	9.0	7.0	36350	25,00
M 14 x 2.0	110	20	11.0	9.0	36354	28,00
M 16 x 2.0	110	22	12.0	9.0	36358	33,00
M 18 x 2.5	125	25	14.0	11.0	36362	44,40
M 20 x 2.5	140	25	16.0	12.0	36366	60,00
SET						
M 3 - 12	M 3-4-5-6-8-10 (DIN 371), M 12 (DIN 376)				47863	103,00

Application:

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

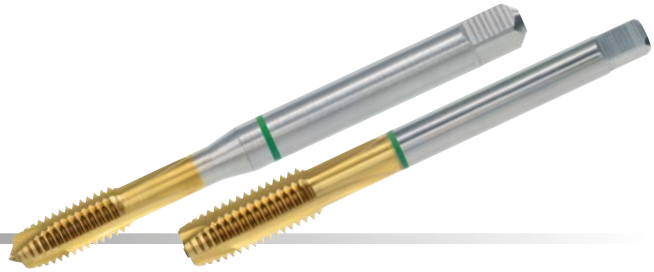
Applicazione:

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



GREEN RING-Machine Taps
metric ISO-thread DIN 13

Maschi a macchina con collarino verde
filettatura metrica ISO DIN 13



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

Nominal Diameter D	L 1	L 2	D 2	⌀	Art.-No.	€
DIN 371						
M 3 x 0.5	56	11	3.5	2.7	30031	18,00
M 4 x 0.7	63	13	4.5	3.4	30032	18,00
M 5 x 0.8	70	14	6.0	4.9	30033	19,00
M 6 x 1.0	80	16	6.0	4.9	30034	21,00
M 8 x 1.25	90	18	8.0	6.2	30035	25,00
M 10 x 1.5	100	22	10.0	8.0	30036	35,00
DIN 376						
M 12 x 1.75	110	29	9.0	7.0	30037	52,00
M 14 x 2.0	110	30	11.0	9.0	30038	77,00
M 16 x 2.0	110	32	12.0	9.0	30039	90,00

Application:
for general use
- non abrasive material up to 1.000 N/mm²
- stainless and alloyed steel
- unalloyed and low alloyed steel
- Copper– and Aluminium-alloys
- for through holes

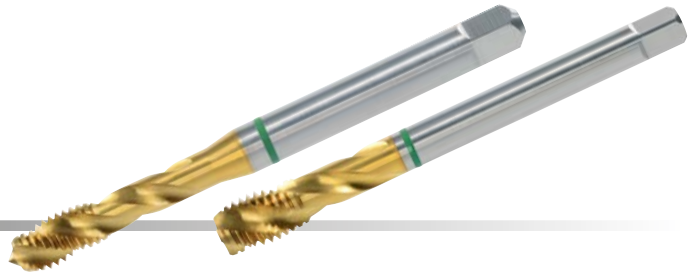
Advantages HSSE-PM-TIN
- increased wear resistance and toughness
- TiN-coating improves anti-friction properties, thereby improved wear-resistance and reduced tendency of build-up edge

Applicazione:
per uso universale
- Materiali con buona truciodibilità fino a 1.000 N/mm²
- Acciaio inossidabili e legati
- Acciaio non legati e scarsamente legati
- Leghe di rame e alluminio
- per fori passanti

Vantaggio HSSE-PM-TIN
- maggiore resistenza all‘ abrasione e tenacità
- migliore uniformità per mezzo di rivestimento TiN, riducendo così l’usare e ridotta tendenza di impasti per saldature

GREEN RING-Machine Taps
metric ISO-thread DIN 13

Maschi a macchina con collarino verde
filettatura metrica ISO DIN 13



DIN 371/376 Form C/39° RSP HSSE-PM-TIN Tol. ISO2/6H

Nominal Diameter D	L 1	L 2	D 2	⌀	Art.-No.	€
DIN 371						
M 3 x 0.5	56	6	3.5	2.7	30131	20,50
M 4 x 0.7	63	7	4.5	3.4	30132	20,50
M 5 x 0.8	70	8	6.0	4.9	30133	22,00
M 6 x 1.0	80	10	6.0	4.9	30134	24,50
M 8 x 1.25	90	14	8.0	6.2	30135	30,00
M 10 x 1.5	100	16	10.0	8.0	30136	38,50
DIN 371						
M 12 x 1.75	110	18	9.0	7.0	30137	53,00
M 14 x 2.0	110	20	11.0	9.0	30138	82,00
M 16 x 2.0	110	22	12.0	9.0	30139	92,50

Application:
for general use
- non abrasive material up to 1.000 N/mm²
- stainless and alloyed steel
- unalloyed and low alloyed steel
- Copper– and Aluminium-alloys
- for blind holes

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

Applicazione:
per uso universale
- Materiali con buona truciodibilità fino a 1.000 N/mm²
- Acciaio inossidabili e legati
- Acciaio non legati e scarsamente legati
- Leghe di rame e alluminio
- per fori ciechi

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

BLUE RING-Machine Taps
metric ISO-thread DIN 13

Maschi a macchina con collarino blu
filettatura metrica ISO DIN 13

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

Nominal Diameter D	L 1	L 2	D 2	⌀	Art.-No.	€
DIN 371						
M 3 x 0.5	56	11	3.5	2.7	35426	8,90
M 4 x 0.7	63	13	4.5	3.4	35430	8,90
M 5 x 0.8	70	16	6.0	4.9	35434	9,70
M 6 x 1.0	80	19	6.0	4.9	35438	9,70
M 8 x 1.25	90	22	8.0	6.2	35442	11,20
M 10 x 1.5	100	24	10.0	8.0	35446	17,80
DIN 376						
M 12 x 1.75	110	29	9.0	7.0	35450	22,50
M 14 x 2.0	110	30	11.0	9.0	35454	25,50
M 16 x 2.0	110	32	12.0	9.0	35458	27,50
M 18 x 2.5	125	34	14.0	11.0	35462	37,00
M 20 x 2.5	140	34	16.0	12.0	35466	52,00
SET						
M 3 - 12	M 3-4-5-6-8-10 (DIN 371), M 12 (DIN 376)				47854	87,00
TiCN						
DIN 371						
M 3 x 0.5	56	11	3.5	2.7	35427	12,00
M 4 x 0.7	63	13	4.5	3.4	35431	12,00
M 5 x 0.8	70	16	6.0	4.9	35435	12,80
M 6 x 1.0	80	19	6.0	4.9	35439	13,40
M 8 x 1.25	90	22	8.0	6.2	35443	15,90
M 10 x 1.5	100	24	10.0	8.0	35447	24,30
DIN 376						
M 12 x 1.75	110	29	9.0	7.0	35451	32,40
M 14 x 2.0	110	30	11.0	9.0	35455	36,50
M 16 x 2.0	110	32	12.0	9.0	35459	39,50
M 18 x 2.5	125	34	14.0	11.0	35463	52,90
M 20 x 2.5	140	34	16.0	12.0	35467	67,90

Application:

wear resistant steel up to 1200 N/mm²
- high alloy steel
- short chipping material
- short chipping stainless steel
- alloy tool steel
- for through holes

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

Applicazione:

Acciaio resistente all'usura a 1.200 N/mm²
- acciaio alto legato
- Materiali duro con truciolo corto
- Acciaio inossidabile con truciolo corto
- Acciaio utensili legati
- per fori passanti

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

BLUE RING-Machine Taps
metric ISO-thread DIN 13

Maschi a macchina con collarino blu
filettatura metrica ISO DIN 13

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

Nominal Diameter D	L 1	L 2	D 2	⌀	Art.-No.	€
DIN 371						
M 3 x 0.5	56	6	3.5	2.7	36426	10,70
M 4 x 0.7	63	7	4.5	3.4	36430	10,70
M 5 x 0.8	70	8	6.0	4.9	36434	11,70
M 6 x 1.0	80	10	6.0	4.9	36438	11,70
M 8 x 1.25	90	14	8.0	6.2	36442	13,50
M 10 x 1.5	100	16	10.0	8.0	36446	20,00
DIN 376						
M 12 x 1.75	110	18	9.0	7.0	36450	26,00
M 14 x 2.0	110	20	11.0	9.0	36454	28,00
M 16 x 2.0	110	22	12.0	9.0	36458	31,00
M 18 x 2.5	125	25	14.0	11.0	36462	43,00
M 20 x 2.5	140	25	16.0	12.0	36466	62,40
SET						
M 3 - 12	M 3-4-5-6-8-10 (DIN 371). M 12 (DIN 376)				47864	103,00

TiCN

DIN 371						
M 3 x 0.5	56	6	3.5	2.7	36427	13,80
M 4 x 0.7	63	7	4.5	3.4	36431	13,80
M 5 x 0.8	70	8	6.0	4.9	36435	14,80
M 6 x 1.0	80	10	6.0	4.9	36439	15,40
M 8 x 1.25	90	14	8.0	6.2	36443	18,20
M 10 x 1.5	100	16	10.0	8.0	36447	26,50
DIN 376						
M 12 x 1.75	110	18	9.0	7.0	36451	35,90
M 14 x 2.0	110	20	11.0	9.0	36455	39,00
M 16 x 2.0	110	22	12.0	9.0	36459	43,00
M 18 x 2.5	125	25	14.0	11.0	36463	58,90
M 20 x 2.5	140	25	16.0	12.0	36467	78,30

Application:

wear resistant steel up to 1200 N/mm²
- high alloy steel
- short chipping material
- short chipping stainless steel
- alloy tool steel
- for blind holes

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

Applicazione:

Acciaio resistente all'usura a 1.200 N/mm²
- acciaio alto legato
- Materiali duro con truciolo corto
- Acciaio inossidabile con truciolo corto
- Acciaio utensili legati
- per fori ciechi

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

WHITE RING-Machine Taps
metric ISO-thread DIN 13

Maschi a macchina con collarino bianco
filettatura metrica ISO DIN 13

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

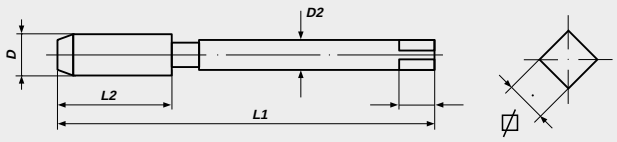
Nominal Diameter D	L 1	L 2	D 2	⌀	Art.-No.	€
DIN 371						
M 3 x 0.5	56	11	3.5	2.7	35226	9,70
M 4 x 0.7	63	13	4.5	3.4	35230	9,70
M 5 x 0.8	70	16	6.0	4.9	35234	10,60
M 6 x 1.0	80	19	6.0	4.9	35238	10,60
M 8 x 1.25	90	22	8.0	6.2	35242	12,60
M 10 x 1.5	100	24	10.0	8.0	35246	17,80
DIN 376						
M 12 x 1.75	110	29	9.0	7.0	35250	22,50
M 14 x 2.0	110	30	11.0	9.0	35254	25,50
M 16 x 2.0	110	32	12.0	9.0	35258	27,50
M 18 x 2.5	125	34	14.0	11.0	35262	37,00
M 20 x 2.5	140	34	16.0	12.0	35266	52,00
SET						
M 3 - 12	M 3-4-5-6-8-10 (DIN 371), M 12 (DIN 376)				47852	94,00

Application:

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

Applicazione:

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



WHITE RING-Machine Taps

Maschi a macchina con collarino bianco

Form B HSS-E

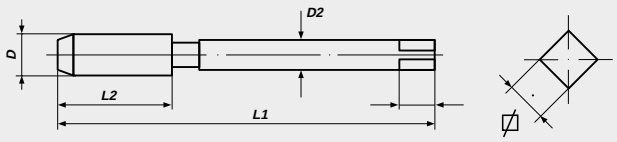
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
MF Tol. ISO2/6H DIN 374						
M 5 x 0.5	70	12	3.5	2.7	35903	16,50
M 6 x 0.75	80	14	4.5	3.4	35904	16,50
M 8 x 0.75	80	19	6.0	4.9	35906	16,50
M 8 x 1.0	90	22	6.0	4.9	35907	16,50
M 10 x 1.0	90	20	7.0	5.5	35909	19,30
M 10 x 1.25	100	24	7.0	5.5	35910	19,30
M 12 x 1.25	100	22	9.0	7.0	35913	26,40
M 12 x 1.5	100	22	9.0	7.0	35914	26,40
M 14 x 1.5	100	22	11.0	9.0	35917	33,00
M 16 x 1.5	100	22	12.0	9.0	35921	38,00
M 18 x 1.5	110	25	14.0	11.0	35925	46,20
M 20 x 1.5	125	25	16.0	12.0	35929	51,20
UNC Tol. 2B DIN 371						
UNC 1/4 x 20	80	17	7.0	5.5	35945	12,10
UNC 5/16 x 18	90	20	8.0	6.2	35946	15,40
UNC 3/8 x 16	100	22	9.0	7.0	35947	17,60
DIN 376						
UNC 7/16 x 14	100	22	8.0	6.2	35948	20,90
UNC 1/2 x 13	110	25	9.0	7.0	35949	20,90
UNF Tol. 2B DIN 371						
UNF 1/4 x 28	80	17	7.0	5.5	35965	12,10
UNF 5/16 x 24	90	17	8.0	6.2	35966	15,40
UNF 3/8 x 24	100	18	9.0	7.0	35967	17,60
DIN 376						
UNF 7/16 x 20	100	22	8.0	6.2	35968	20,90
UNF 1/2 x 20	100	22	9.0	7.0	35969	20,90
G (BSP) DIN 5156						
G 1/8 x 28	90	20	7.0	5.5	35992	19,80
G 1/4 x 19	100	22	11.0	9.0	35993	24,20
G 3/8 x 19	100	22	12.0	9.0	35994	28,60
G 1/2 x 14	125	25	16.0	12.0	35995	41,80

Application:

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

Applicazione:

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



WHITE RING-Machine Taps
metric ISO-thread DIN 13

Maschi a macchina con collarino bianco
filettatura metrica ISO DIN 13

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

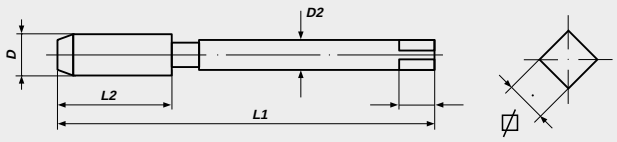
Nominal Diameter D	L 1	L 2	D 2	⌀	Art.-No.	€
DIN 371						
M 3 x 0.5	56	6	3.5	2.7	36226	11,60
M 4 x 0.7	63	7	4.5	3.4	36230	11,60
M 5 x 0.8	70	8	6.0	4.9	36234	12,70
M 6 x 1.0	80	10	6.0	4.9	36238	12,70
M 8 x 1.25	90	14	8.0	6.2	36242	15,10
M 10 x 1.5	100	16	10.0	8.0	36246	21,40
DIN 376						
M 12 x 1.75	110	18	9.0	7.0	36250	27,00
M 14 x 2.0	110	20	11.0	9.0	36254	30,60
M 16 x 2.0	110	22	12.0	9.0	36258	33,00
M 18 x 2.5	125	25	14.0	11.0	36262	44,40
M 20 x 2.5	140	25	16.0	12.0	36266	62,40
SET						
M 3 - 12	M 3-4-5-6-8-10 (DIN 371), M 12 (DIN 376)				47862	113,00

Application:

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

Applicazione:

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



WHITE RING-Machine Taps

Maschi a macchina con collarino bianco

Form C/39° RSP HSS-E

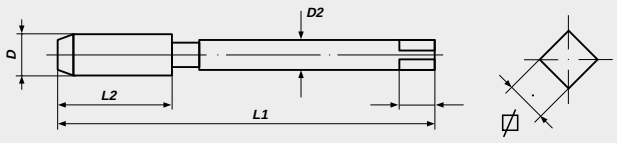
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
MF Tol. ISO2/6H DIN 374						
M 5 x 0.5	70	5	3.5	2.7	36903	18,70
M 6 x 0.75	80	8	4.5	3.4	36904	18,70
M 8 x 0.75	80	8	6.0	4.9	36906	18,70
M 8 x 1.0	90	10	6.0	4.9	36907	18,70
M 10 x 1.0	90	10	7.0	5.5	36909	22,50
M 10 x 1.25	100	16	7.0	5.5	36910	22,20
M 12 x 1.25	100	15	9.0	7.0	36913	28,60
M 12 x 1.5	100	15	9.0	7.0	36914	28,60
M 14 x 1.5	100	15	11.0	9.0	36917	35,20
M 16 x 1.5	100	15	12.0	9.0	36921	40,70
M 18 x 1.5	110	17	14.0	11.0	36925	50,60
M 20 x 1.5	125	17	16.0	12.0	36929	56,10
UNC Tol. 2B DIN 371						
UNC 1/4 x 20	80	13	7.0	5.5	36945	15,10
UNC 5/16 x 18	90	14	8.0	6.2	36946	18,20
UNC 3/8 x 16	100	16	9.0	7.0	36947	20,00
DIN 376						
UNC 7/16 x 14	100	17	8.0	6.2	36948	25,30
UNC 1/2 x 13	110	20	9.0	7.0	36949	25,30
UNF Tol. 2B DIN 371						
UNF 1/4 x 28	80	10	7.0	5.5	36965	15,10
UNF 5/16 x 24	90	10	8.0	6.2	36966	18,20
UNF 3/8 x 24	100	10	9.0	7.0	36967	20,00
DIN 376						
UNF 7/16 x 20	100	13	8.0	6.2	36968	25,30
UNF 1/2 x 20	100	13	9.0	7.0	36969	25,30
G (BSP) DIN 5156						
G 1/8 x 28	90	20	7.0	5.5	36992	22,00
G 1/4 x 19	100	22	11.0	9.0	36993	27,50
G 3/8 x 19	100	22	12.0	9.0	36994	37,70
G 1/2 x 14	125	25	16.0	12.0	36995	48,40

Application:

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

Applicazione:

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



BLACK RING-Machine Taps
metric ISO-thread DIN 13

Maschi a macchina con collarino nero
filettatura metrica ISO DIN 13

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

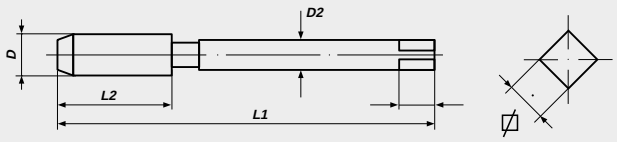
Nominal Diameter D	L 1	L 2	D 2	⊡	Art.-No.	€
DIN 371						
M 3 x 0.5	56	11	3.5	2.7	35126	9,70
M 4 x 0.7	63	13	4.5	3.4	35130	9,70
M 5 x 0.8	70	16	6.0	4.9	35134	10,60
M 6 x 1.0	80	19	6.0	4.9	35138	10,60
M 8 x 1.25	90	22	8.0	6.2	35142	12,40
M 10 x 1.5	100	24	10.0	8.0	35146	17,00
DIN 376						
M 12 x 1.75	110	29	9.0	7.0	35150	22,00
M 14 x 2.0	110	30	11.0	9.0	35154	25,00
M 16 x 2.0	110	32	12.0	9.0	35158	27,00
M 18 x 2.5	125	34	14.0	11.0	35162	36,50
M 20 x 2.5	140	34	16.0	12.0	35166	51,00
SET						
M 3 - 12	M 3-4-5-6-8-10 (DIN 371), M 12 (DIN 376)				47851	94,00

Application:

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

Applicazione:

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



YELLOW RING-Machine Taps
metric ISO-thread DIN 13

Maschi a macchina con collarino giallo
filettatura metrica ISO DIN 13

DIN 371/376 Form C/40° RSP HSS-E

Nominal Diameter D		L 1	L 2	D 2	⌀	Art.-No.	€
M	Tol. ISO2/6H	DIN 371					
M	3 x 0.5	56	6	3.5	2.7	36526	10,70
M	4 x 0.7	63	7	4.5	3.4	36530	10,70
M	5 x 0.8	70	8	6.0	4.9	36534	11,70
M	6 x 1.0	80	10	6.0	4.9	36538	11,70
M	8 x 1.25	90	14	8.0	6.2	36542	13,50
M	10 x 1.5	100	16	10.0	8.0	36546	20,00
		DIN 376					
M	12 x 1.75	110	18	9.0	7.0	36550	26,00
M	14 x 2.0	110	20	11.0	9.0	36554	28,00
M	16 x 2.0	110	22	12.0	9.0	36558	31,00
SET							
M	3 - 12	M 3-4-5-6-8-10 (DIN 371), M 12 (DIN 376)				47860	103,00
UNC	Tol. 2B	DIN 371					
UNC	1/4 x 20	80	13	7,0	5,5	36580	13,80
UNC	5/16 x 18	90	14	8,0	6,2	36581	16,60
UNC	3/8 x 16	100	16	9,0	7,0	36582	18,20
UNC	7/16 x 14	100	17	8,0	6,2	36583	23,00
		DIN 376					
UNC	1/2 x 13	100	20	9,0	7,0	36584	23,00

Application:

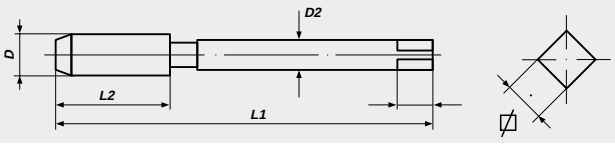
Aluminium-alloys, long chipping

- for blind holes
- with 2 flutes

Applicazione:

Alluminio, truciolo lungo

- per fori ciechi
- A 2 scanalature



ORANGE RING-Machine Taps
metric ISO-thread DIN 13

Maschi a macchina con collarino arancione
filettatura metrica ISO DIN 13

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

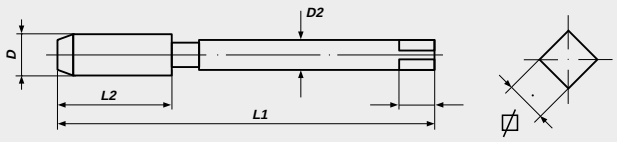
Nominal Diameter D	L 1	L 2	D 2	⊡	Art.-No.	€
DIN 371						
M 3 x 0.5	56	11	3.5	2.7	35726	9,70
M 4 x 0.7	63	13	4.5	3.4	35730	9,70
M 5 x 0.8	70	16	6.0	4.9	35734	10,60
M 6 x 1.0	80	19	6.0	4.9	35738	10,60
M 8 x 1.25	90	22	8.0	6.2	35742	12,40
M 10 x 1.5	100	24	10.0	8.0	35746	17,00
DIN 376						
M 12 x 1.75	110	29	9.0	7.0	35750	22,00
M 14 x 2.0	110	30	11.0	9.0	35754	25,00
M 16 x 2.0	110	32	12.0	9.0	35758	27,00
SET						
M 3 - 12	M 3-4-5-6-8-10 (DIN 371), M 12 (DIN 376)				47850	94,00

Application:

Ms
Brass, short chipping
- for through and blind holes

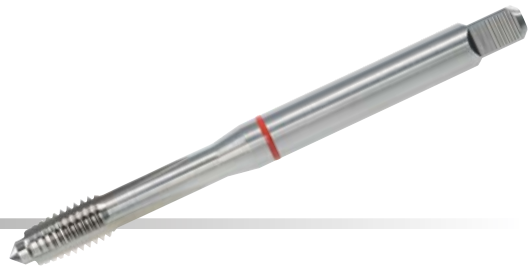
Applicazione:

Ms
Ottone, truciolo corto
- per fori passanti e ciechi



RED RING-Machine Taps
metric ISO-thread DIN 13

Maschi a macchina con collarino rosso
filettatura metrica ISO DIN 13



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

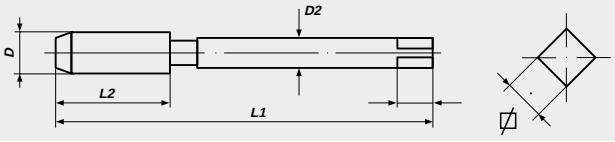
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
DIN 371						
M 4 x 0.7	63	9	4.5	3.4	36130	11,20
M 5 x 0.8	70	11	6.0	4.9	36134	12,40
M 6 x 1.0	80	13	6.0	4.9	36138	12,40
M 8 x 1.25	90	15	8.0	6.2	36142	14,20
M 10 x 1.5	100	16	10.0	8.0	36146	17,80

Application:

short-chipping Material from 1200 N/mm² tensile strength
For through and blind holes.
Due to the very robust execution and the special profile of the flutes this Machine Tap is suitable for extreme applications.
The lead Form A and an additional short lead make working easier.

Applicazione:

Materiali con truciolo corto da 1.200 N/mm² resistenza alla trazione
per fori passanti e ciechi
Dalla versione particolarmente robusto e speciale profilo delle scanalature di questo maschi è adatto per applicazioni estreme.
L'imbocco a Forma A e un aggiuntivo imbocco corto facilitano la lavorazione



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

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

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

77 + 153 - 155

GREEN RING TwinBox

Machine Tap + Twist Drill
metric ISO-thread DIN 13

TwinBox verde

Maschi a macchina + punte
filettatura metrica ISO DIN 13

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

Nominal Diameter D			Art.-No.	€
Form B, Spiral Point / punta en espiral (pasante)				
M 3 x 0.5	DIN 371	2.5 mm	35390	10,90
M 4 x 0.7	DIN 371	3.3 mm	35391	11,00
M 5 x 0.8	DIN 371	4.2 mm	35392	12,20
M 6 x 1.0	DIN 371	5.0 mm	35393	12,50
M 8 x 1.25	DIN 371	6.8 mm	35394	15,50
M 10 x 1.5	DIN 371	8.5 mm	35395	25,00
M 12 x 1.75	DIN 376	10.2 mm	35396	33,00
M 14 x 2.0	DIN 376	12.0 mm	35397	35,00
M 16 x 2.0	DIN 376	14.0 mm	35398	43,00
Form C, Spiral Flute / Helicoidal 39° (ciego)				
M 3 x 0.5	DIN 371	2.5 mm	36390	12,10
M 4 x 0.7	DIN 371	3.3 mm	36391	12,30
M 5 x 0.8	DIN 371	4.2 mm	36392	13,50
M 6 x 1.0	DIN 371	5.0 mm	36393	13,80
M 8 x 1.25	DIN 371	6.8 mm	36394	17,00
M 10 x 1.5	DIN 371	8.5 mm	36395	26,50
M 12 x 1.75	DIN 376	10.2 mm	36396	34,50
M 14 x 2.0	DIN 376	12.0 mm	36397	38,50
M 16 x 2.0	DIN 376	14.0 mm	36398	46,50

Application:

for general use
- non abrasive material up to 1000 N/mm²
- unalloyed and low alloyed steel
- malleable cast iron and zinc alloys

Spiral Point for through holes
Spiral Flute for blind holes

HSS-CO Twist Drills DIN 338
Type N right, 118° - Spiral: 25-30°

Applicazione:

per uso universale
- Materiali buona truciodibilità fino a 1000 N/mm²
- Acciaio non legati e scarsamente legati
- Ghisa malleabile e leghe forgiate

Forma B per fori passanti
39° RSP per fori ciechi

Punte DIN 338 HSS-Co
Tipo N, destra 118° - elica: 25-30°

VÖLKEL
THREADING SOLUTIONS

BLUE RING TwinBox

Machine Tap + Twist Drill
metric ISO-thread DIN 13

TwinBox blu

Maschi a macchina + punte
filettatura metrica ISO DIN 13

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

Nominal Diameter D				Art.-No.	€
Form B, Spiral Point / con imbocco corretto					
M	3 x 0.5	DIN 371	2.5 mm	35490	10,60
M	4 x 0.7	DIN 371	3.3 mm	35491	10,90
M	5 x 0.8	DIN 371	4.2 mm	35492	12,00
M	6 x 1.0	DIN 371	5.0 mm	35493	12,50
M	8 x 1.25	DIN 371	6.8 mm	35494	15,80
M	10 x 1.5	DIN 371	8.5 mm	35495	24,00
M	12 x 1.75	DIN 376	10.2 mm	35496	32,00
M	14 x 2.0	DIN 376	12.0 mm	35497	36,00
M	16 x 2.0	DIN 376	14.0 mm	35498	41,00
Form C, Spiral Flute / spirale destra a 39°,					
M	3 x 0.5	DIN 371	2.5 mm	36490	12,30
M	4 x 0.7	DIN 371	3.3 mm	36491	12,60
M	5 x 0.8	DIN 371	4.2 mm	36492	13,70
M	6 x 1.0	DIN 371	5.0 mm	36493	14,10
M	8 x 1.25	DIN 371	6.8 mm	36494	17,50
M	10 x 1.5	DIN 371	8.5 mm	36495	25,00
M	12 x 1.75	DIN 376	10.2 mm	36496	33,00
M	14 x 2.0	DIN 376	12.0 mm	36497	39,00
M	16 x 2.0	DIN 376	14.0 mm	36498	45,60

Application:

wear resistant steel up to 1200 N/mm²
- high alloy steel
- short chipping material
- short chipping stainless steel
- alloy tool steel

Spiral Point for through holes
Spiral Flute for blind holes

HSS-CO Twist Drills DIN 338
Form C right, 130° - Spiral: 25-30°
with Split Point

Applicazione:

Acciaio resistente all'usura a 1200 N/mm²
- Acciaio alto legato
- Materiali duro con truciolo corto
- Acciaio inossidabile con truciolo corto
- Acciaio utensili legati

Forma B per fori passanti
39° RSP per fori ciechi

Punte DIN 338 HSS-Co
Forma C, destra 130° - elica: 25-30°
con affilatura a croce

WHITE RING TwinBox
Machine Tap + Twist Drill
metric ISO-thread DIN 13

TwinBox bianco
Maschi a macchina + punte
filettatura metrica ISO DIN 13

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

Nominal Diameter D				Art.-No.	€
Form B, Spiral Point / con imbocco corretto					
M	3 x 0.5	DIN 371	2.5 mm	35290	11,40
M	4 x 0.7	DIN 371	3.3 mm	35291	11,80
M	5 x 0.8	DIN 371	4.2 mm	35292	13,00
M	6 x 1.0	DIN 371	5.0 mm	35293	13,50
M	8 x 1.25	DIN 371	6.8 mm	35294	16,50
M	10 x 1.5	DIN 371	8.5 mm	35295	24,00
M	12 x 1.75	DIN 376	10.2 mm	35296	31,50
M	14 x 2.0	DIN 376	12.0 mm	35297	37,00
M	16 x 2.0	DIN 376	14.0 mm	35298	44,00
Form C, Spiral Flute / spirale destra a 39°					
M	3 x 0.5	DIN 371	2.5 mm	36290	13,30
M	4 x 0.7	DIN 371	3.3 mm	36291	13,60
M	5 x 0.8	DIN 371	4.2 mm	36292	14,80
M	6 x 1.0	DIN 371	5.0 mm	36293	15,30
M	8 x 1.25	DIN 371	6.8 mm	36294	18,50
M	10 x 1.5	DIN 371	8.5 mm	36295	25,50
M	12 x 1.75	DIN 376	10.2 mm	36296	34,00
M	14 x 2.0	DIN 376	12.0 mm	36297	40,50
M	16 x 2.0	DIN 376	14.0 mm	36298	48,60

Application:

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

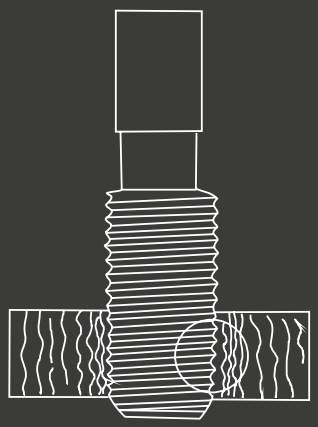
HSS-CO Twist Drills DIN 338
Form C right, 130° - Spiral: 25-30°
with Split Point

Applicazione:

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

Punte DIN 338 HSS-Co
Forma C, destra 130° - elica: 25-30°
con affilatura a croce

FLUTELESS MACHINE TAPS
MASCHI A RULLARE

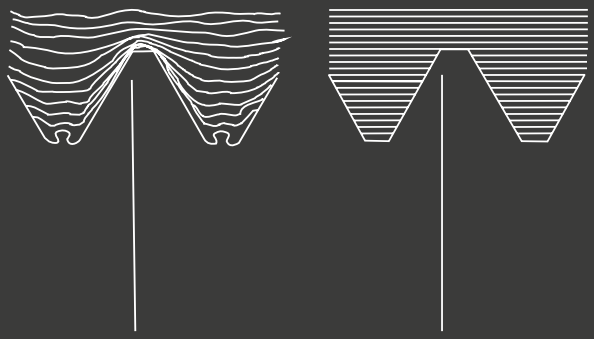


Application:

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

Applicazione:

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



Fibre structure
of thread forming
Andamento delle fibre
per filettatura rullata

Fibre structure
of thread cutting
Andamento delle fibre
per filettatura tagliata

Benefit:

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

Vantaggio:

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

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

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

FLUTELESS MACHINE TAPS
MASCHI A RULLARE

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

Application:

bright:
- for nonferrous metal of good ductility

VAP (Steam Tempered):
- for steel up to approx. 700 N/mm²

TIN (Titanium Nitride Coating):
- for steel up to approx. 900 N/mm²
  and to increase endurance and cutting speed

Applicazione:

Lucido:
- per materiali non ferrosi con buona deformabilità

VAP (vaporizzato):
- per acciaio a ca. 700 N/mm²

TIN (revestimento di nitrurato di titanio):
- per acciaio a ca. 900 N/mm²
  per l'aumento della vita utensile e della velocità di taglio

RECOMMENDED APPLICATION OF FLUTELESS MACHINE TAPS
PER MASCHI A RULLARE

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

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

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

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

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

RECOMMENDED CORE HOLE DIAMETER
DIAMETRO DEL FORO RACCOMANDATO

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

Fluteless Machine Taps (Forming Taps)
metric ISO-thread DIN 13

Maschi a rullare
filettatura metrica ISO DIN 13

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

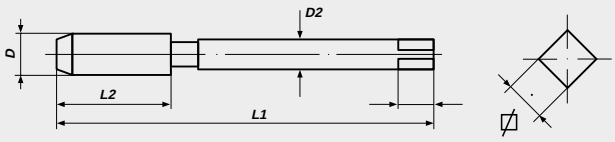
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
without Oil Groove/senza canali di espulsione						
DIN 371						
M 1 x 0.25	40	5	2.5	2.1	35500	24,00
M 1.1 x 0.25	40	5	2.5	2.1	35501	24,00
M 1.2 x 0.25	40	5	2.5	2.1	35502	24,00
M 1.4 x 0.3	40	7	2.5	2.1	35503	21,00
M 1.6 x 0.35	40	8	2.5	2.1	35504	21,00
M 1.7 x 0.35	40	8	2.5	2.1	35505	21,00
M 1.8 x 0.35	40	8	2.5	2.1	35506	21,00
M 2 x 0.4	45	8	2.8	2.1	35507	18,00
M 2.5 x 0.45	50	9	2.8	2.1	35508	18,00
M 3 x 0.5	56	11	3.5	2.7	35510	9,70
M 4 x 0.7	63	13	4.5	3.4	35512	11,00
M 5 x 0.8	70	16	6.0	4.9	35513	12,00
M 6 x 1.0	80	19	6.0	4.9	35514	12,00
M 8 x 1.25	90	22	8.0	6.2	35515	14,50
M 10 x 1.5	100	24	10.0	8.0	35516	16,90
DIN 376						
M 12 x 1.75	110	29	9.0	7.0	35517	21,80
M 14 x 2.0	110	30	11.0	9.0	35518	37,50
M 16 x 2.0	110	32	12.0	9.0	35519	44,50
with Oil Groove/con canali di espulsione						
DIN 371						
M 3 x 0.5	56	11	3.5	2.7	35610	10,60
M 4 x 0.7	63	13	4.5	3.4	35612	12,00
M 5 x 0.8	70	16	6.0	4.9	35613	13,20
M 6 x 1.0	80	19	6.0	4.9	35614	13,20
M 8 x 1.25	90	22	8.0	6.2	35615	15,90
M 10 x 1.5	100	24	10.0	8.0	35616	18,60
DIN 376						
M 12 x 1.75	110	29	9.0	7.0	35617	23,80
M 14 x 2.0	110	30	11.0	9.0	35618	40,00
M 16 x 2.0	110	32	12.0	9.0	35619	48,00

Application:

bright:
- for nonferrous metal of good ductility

Applicazione:

Lucido:
- per materiali non ferrosi con buona deformabilità



Fluteless Machine Taps
metric ISO-thread DIN 13

Maschi a rullare
filettatura metrica ISO DIN 13

DIN 371/376 — 2.1/2 Thread Start — HSSE-VAP — Tol. ISO2X/6HX

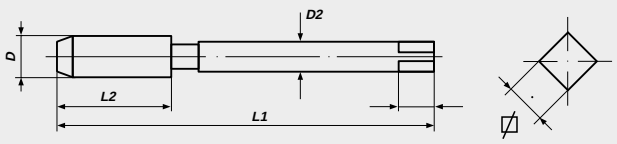
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
without Oil Groove/senza canali di espulsione						
DIN 371						
M 3 x 0.5	56	11	3.5	2.7	35550	10,70
M 4 x 0.7	63	13	4.5	3.4	35552	12,10
M 5 x 0.8	70	16	6.0	4.9	35553	13,20
M 6 x 1.0	80	19	6.0	4.9	35554	13,20
M 8 x 1.25	90	22	8.0	6.2	35555	16,00
M 10 x 1.5	100	24	10.0	8.0	35556	18,60
DIN 376						
M 12 x 1.75	110	29	9.0	7.0	35557	24,00
M 14 x 2.0	110	30	11.0	9.0	35558	41,30
M 16 x 2.0	110	32	12.0	9.0	35559	49,00
with Oil Groove/con canali di espulsione						
DIN 371						
M 3 x 0.5	56	11	3.5	2.7	35650	11,70
M 4 x 0.7	63	13	4.5	3.4	35652	13,20
M 5 x 0.8	70	16	6.0	4.9	35653	14,50
M 6 x 1.0	80	19	6.0	4.9	35654	14,50
M 8 x 1.25	90	22	8.0	6.2	35655	17,50
M 10 x 1.5	100	24	10.0	8.0	35656	20,50
DIN 376						
M 12 x 1.75	110	29	9.0	7.0	35657	26,20
M 14 x 2.0	110	30	11.0	9.0	35658	44,00
M 16 x 2.0	110	32	12.0	9.0	35659	52,80

Application:

VAP (Steam Tempered):
- for steel up to approx. 700 N/mm²

Applicazione:

VAP (vaporizzato):
- per acciaio a ca. 700 N/mm²



Fluteless Machine Taps
metric ISO-thread DIN 13

Maschi a rullare
filettatura metrica ISO DIN 13

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

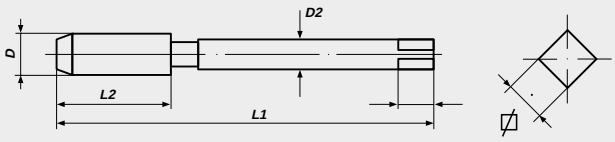
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
without Oil Groove/senza canali di espulsione						
DIN 371						
M 1 x 0.25	40	5	2.5	2.1	35520	27,10
M 1.1 x 0.25	40	5	2.5	2.1	35521	27,10
M 1.2 x 0.25	40	5	2.5	2.1	35522	27,10
M 1.4 x 0.3	40	7	2.5	2.1	35523	24,10
M 1.6 x 0.35	40	8	2.5	2.1	35524	24,10
M 1.7 x 0.35	40	8	2.5	2.1	35525	24,10
M 1.8 x 0.35	40	8	2.5	2.1	35526	24,10
M 2 x 0.4	45	8	2.8	2.1	35527	21,10
M 2.5 x 0.45	50	9	2.8	2.1	35528	21,10
M 3 x 0.5	56	11	3.5	2.7	35530	12,80
M 4 x 0.7	63	13	4.5	3.4	35532	14,10
M 5 x 0.8	70	16	6.0	4.9	35533	15,10
M 6 x 1.0	80	19	6.0	4.9	35534	15,70
M 8 x 1.25	90	22	8.0	6.2	35535	19,20
M 10 x 1.5	100	24	10.0	8.0	35536	23,40
DIN 376						
M 12 x 1.75	110	29	9.0	7.0	35537	31,70
M 14 x 2.0	110	30	11.0	9.0	35538	48,50
M 16 x 2.0	110	32	12.0	9.0	35539	56,50
with Oil Groove/con canali di espulsione						
DIN 371						
M 3 x 0.5	56	11	3.5	2.7	35630	13,70
M 4 x 0.7	63	13	4.5	3.4	35632	15,10
M 5 x 0.8	70	16	6.0	4.9	35633	16,30
M 6 x 1.0	80	19	6.0	4.9	35634	16,90
M 8 x 1.25	90	22	8.0	6.2	35635	20,60
M 10 x 1.5	100	24	10.0	8.0	35636	25,10
DIN 376						
M 12 x 1.75	110	29	9.0	7.0	35637	33,70
M 14 x 2.0	110	30	11.0	9.0	35638	51,00
M 16 x 2.0	110	32	12.0	9.0	35639	60,00

Application:

TIN (Titanium Nitride Coating):
- for steel up to approx. 900 N/mm²
  and to increase endurance and cutting speed

Applicazione:

TIN (revestimento di nitrurato di titanio):
- per acciaio a ca. 900 N/mm²
  per l'aumento della vita utensile e della velocità di taglio



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

metric ISO-thread DIN 13

Maschi a rullare, *tolleranza maggiorata*

metrica ISO DIN 13

DIN 371/376 2.1/2 Thread Start HSS-E Tol. ISO3X/6GX

Nominal Diameter D	L 1	L 2	D 2	⌀	Art.-No.	€
without Oil Groove/senza canali di espulsione						
DIN 371						
M 3 x 0.5	56	11	3.5	2.7	35510-6G	10,40
M 4 x 0.7	63	13	4.5	3.4	35512-6G	11,70
M 5 x 0.8	70	16	6.0	4.9	35513-6G	12,60
M 6 x 1.0	80	19	6.0	4.9	35514-6G	12,60
M 8 x 1.25	90	22	8.0	6.2	35515-6G	15,30
M 10 x 1.5	100	24	10.0	8.0	35516-6G	17,80
DIN 376						
M 12 x 1.75	110	29	9.0	7.0	35517-6G	22,80
with Oil Groove/con canali di espulsione						
DIN 371						
M 3 x 0.5	56	11	3.5	2.7	35610-6G	11,40
M 4 x 0.7	63	13	4.5	3.4	35612-6G	12,70
M 5 x 0.8	70	16	6.0	4.9	35613-6G	13,80
M 6 x 1.0	80	19	6.0	4.9	35614-6G	13,80
M 8 x 1.25	90	22	8.0	6.2	35615-6G	16,80
M 10 x 1.5	100	24	10.0	8.0	35616-6G	19,50
DIN 376						
M 12 x 1.75	110	29	9.0	7.0	35617-6G	25,00

Application:

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

Applicazione:

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

MACHINE NUT TAPS
MASCHI A MACCHINA PER DADI

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

Machine Nut Taps
metric ISO-thread DIN 13

Maschi a macchina per dadi
filettatura metrica ISO DIN 13

DIN 357 HSS-E Tol. ISO2/6H

M

Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
M 3 x 0.5	70	22	2.2	—	37126	13,70
M 4 x 0.7	90	25	2.8	2.1	37130	13,70
M 5 x 0.8	100	28	3.5	2.7	37134	14,70
M 6 x 1.0	110	32	4.5	3.4	37138	14,70
M 8 x 1.25	125	40	6.0	4.9	37142	16,80
M 10 x 1.5	140	45	7.0	5.5	37146	22,00
M 12 x 1.75	180	50	9.0	7.0	37150	31,00
M 14 x 2.0	200	56	11.0	9.0	37154	38,80
M 16 x 2.0	200	63	12.0	9.0	37158	47,30
M 18 x 2.5	220	63	14.0	11.0	37162	53,50
M 20 x 2.5	250	70	16.0	12.0	37166	58,80
M 22 x 2.5	280	80	18.0	14.5	37170	70,40
M 24 x 3.0	280	80	18.0	14.5	37174	79,00

Application:

- long reduced shank to allow nuts to run over
- for thread depth up to 1 x D
- ideal for tapping difficult to reach holes
- for through holes

for general use

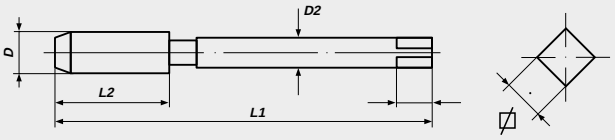
- non abrasive material up to 800 N/mm²
- unalloyed and low alloyed steel

Applicazione:

- Gambo prolungato per la lavorazione di più dadi contemporaneamente
- profondità di maschiatura a 1 x D
- per la filettatura in luoghi di difficile accesso
- per fori passanti

per uso universale

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



Machine Nut Taps
piloted, trapezoidal thread DIN 103

Maschi a macchina per dadi
con nocciolo di guida, filettatura trapeziodale metrica ISO 103

HSS-G Tol. 7H

Tr

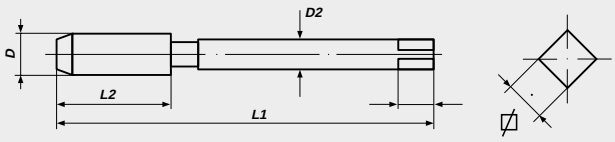
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
Tr 10 x 2	110	63	7	5.5	79108	208,00
Tr 10 x 3	125	75	7	5.5	79112	208,00
Tr 12 x 3	165	111	8	6.2	79116	180,00
Tr 14 x 3	140	85	10	8.0	79120	192,00
Tr 14 x 4	170	112	10	8.0	79124	192,00
Tr 16 x 4	180	116	11	9.0	79128	210,00
Tr 18 x 4	190	120	12	9.0	79132	215,00
Tr 20 x 4	200	124	14	11.0	79136	223,00
Tr 22 x 4	210	130	16	12.0	79139	290,00
Tr 22 x 5	235	155	16	12.0	79140	290,00
Tr 24 x 5	245	160	18	14.5	79144	332,00
Tr 26 x 5	255	165	20	16.0	79148	350,00
Tr 28 x 5	265	170	22	18.0	79152	390,00
Tr 30 x 6	290	185	22	18.0	79156	455,00
Tr 32 x 6	300	191	25	20.0	79160	560,00
Tr 36 x 6	310	200	28	22.0	79164	570,00
LEFT HAND THREAD/FILETTO SINISTRO						
Tr 10 x 2	110	63	7	5.5	79108-L	292,00
Tr 10 x 3	125	75	7	5.5	79112-L	292,00
Tr 12 x 3	165	111	8	6.2	79116-L	252,00
Tr 14 x 3	140	85	10	8.0	79120-L	270,00
Tr 14 x 4	170	112	10	8.0	79124-L	270,00
Tr 16 x 4	180	116	11	9.0	79128-L	292,00
Tr 18 x 4	190	120	12	9.0	79132-L	292,00
Tr 20 x 4	200	124	14	11.0	79136-L	313,00
Tr 22 x 5	235	155	16	12.0	79140-L	405,00
Tr 24 x 5	245	160	18	14.5	79144-L	465,00
Tr 26 x 5	255	165	20	16.0	79148-L	486,00
Tr 28 x 5	265	170	22	18.0	79152-L	541,00
Tr 30 x 6	290	185	22	18.0	79156-L	635,00
Tr 32 x 6	300	191	25	20.0	79160-L	770,00
Tr 36 x 6	310	200	28	22.0	79164-L	790,00

Application:

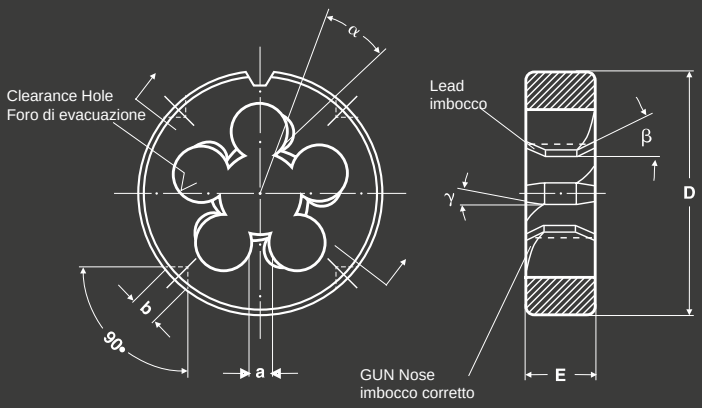
for general use
- non abrasive material up to 700 N/mm²
- unalloyed and low alloyed steel
- for thread depth up to 1 x D
- for through holes

Applicazione:

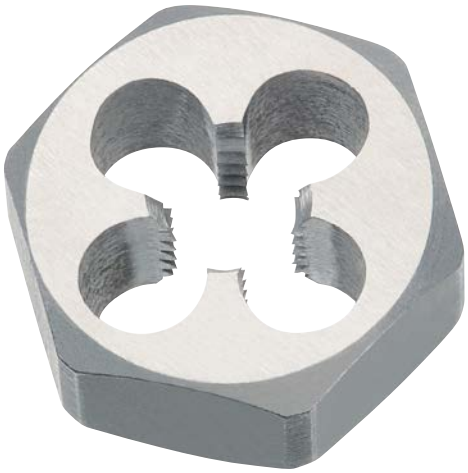
per uso universale
- Materiali buona truciodibilità fino a R 800 N/mm²
- Acciaio non legati e scarsamente legati
- profondità di maschiatura a 1 x D
- per fori passanti



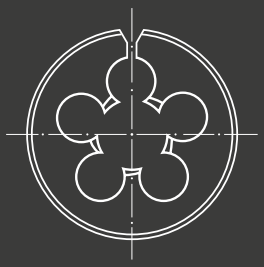
ROUND DIES
HEXAGON DIE NUTS
FILIERE
FILIERE ESAGONALI



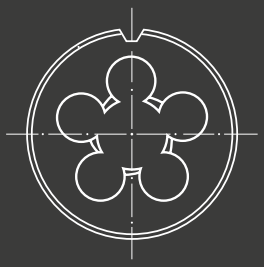
D	Outside diameter	Diametro esterno
E	Width of die	Spessore
a	Width of land	Ampiezza del dente
b	Hole for holding screws	Diametro fissaggio vite
α	Rake angle	Angolo di taglio
β	Lead angle	Angolo dell'imbocco
γ	Angle of gun nose	Angolo dell'imbocco corretto



Form A split / Forma A aperta



Form B solid / Forma B chiuso



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

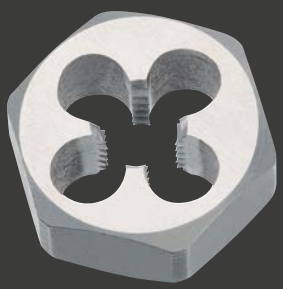
Se non diversamente specificato,
forniamo tutte le filiere in forma B (chiuso)

Round Dies VS
HSS Round Dies for general use by hand, for non abrasive material
Filiere tonde VS
Filiere tonde HSS per uso universale a mano, per la lavorazione di materiali con buona truciolabilità.

Round Dies VE
HSS-E Round Dies with gun nose, for general use by hand, for stainless steel and abrasive material
Filiere tonde VE
Filiere tonde HSS-E con imbocco corretto per uso universale a mano, per la lavorazione di acciai inossidabili e materiali di difficile lavorazione.

Round Dies VX
Lapped and steam tempered high performance HSS-E Round Dies with gun nose, for thread cutting by hand and machine, for alloyed, tough-hard material, stainless steel, aluminium and spheroidal graphite cast iron (GGG)
Filiere tonde VX
Filiere tonde per alte prestazioni in HSS-E con imbocco corretto, lappate e vaporizzate, per uso a mano e a macchina, per la lavorazione di materiali teneri legati, acciai inossidabili, alluminio e ghisa sferoidale (GGG).

Round Dies MS
Lapped HSS Round Dies with gun nose, optimized for machining brass, short-chipping material and short-chipping bronze
Filiere tonde MS
Filiere tonde HSS lappate con imbocco corretto per la lavorazione ottimale di materiali in ottone, materiali in bronzo a truciolo corto e in bronzo a truciolo corto.



Hexagon Die Nuts VS
HSS Hexagon Die Nuts, for general use by hand, for non abrasive material, for cleaning and repairing damaged threads and for general use in awkward places
Filiere esagonali VS
Filiere esagonali HSS per uso universale a mano, per la lavorazione di materiali con buona truciolabilità, per la riparazione di filetti danneggiati e in luoghi di difficile accesso.

	VS HSS	VS HSS	VE HSSE	VX HSSE-VAP	MS HSS	Collants and lubrications Refrigerazione e lubrificante
Thread cutting by hand Per uso a mano	●	●	●	●	●	
Machine use Per uso a macchina	○		○	●	○	
Steel, unallyoed; tensile strength < 800N/mm² Acciai non legati; resistenza alla trazione < 800N/mm²	●	●	●	●		Thread cutting oil also with lubricity-increasing additives, emulsion Emulsione, Olio da taglio con additivi che aumentano la lubrificazione
Machining steels, case hardening steels, tempered steels; tensile strength < 800 N/mm² Acciai automatici, acciai da cementazione, acciai bonificati; resistenza alla trazione < 800 N/mm²	○	○	●	●		
Steel, unallyoed; tensile strength < 1000N/mm² Acciai non legati; resistenza alla trazione < 1000N/mm²			●	●		
Steel, alloyed and unallyoed; tensile strength < 1200 N/mm² Acciai legati e non legati; resistenza alla trazione < 1200 N/mm²			○	●		Thread cutting oil, thread cutting oil highly activated with special additives, emulsion Olio da taglio per maschiatura, Olio da taglio con additivi, Emulsione
Rust- and acid-resistant steels; VA-steels < 850 N/mm² Acciai inossidabili, Acciai V4A; resistenza alla trazione < 850 N/mm2			○	●		
Rust- and acid-resistant steels with high chromium-nickel content, V4A steels Acciai inossidabili con alto contenuto in Cromo-Nickel, Acciai V4A				●		
Brass, short-chipping Ottone, truciolo corto					●	Thread cutting oil for non-ferrous metals, emulsion Olio da taglio per maschiatura per metalli non ferrosi, Emulsione
Brass, long-chipping Ottone, truciolo lungo	○	○	●			
Bronze, short-chipping Bronzo, truciolo corto					●	
Copper alloys Leghe di rame			○	●		
Aluminium, short-chipping Alluminio, truciolo corto				●		
Aluminium, long-chipping Alluminio, truciolo lungo	○	○	●			
Titanium alloys; tensile strength < 1200 N/mm² Leghe di titanio; resistenza alla trazione < 1200 N/mm²				○		Special thread cutting oil Olio da taglio speciale per maschiatura
Thermosetting plastics Duroplaste					●	Oil mist, compressed air, mold release oil Olio nebulizzato, Aria compressa, Olio di distacco dallo stampo

● = appropiate / idoneitá ottimale ○ = conditionally suitable / idoneitá limitata

ROUND DIES
HEXAGON DIE NUTS
FILIERE
FILIERE ESAGONALI

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

VÖLKEL THREADING SOLUTIONS

Round Dies VS
metric ISO-thread DIN 13

Filiere tonde VS
filettatura metrica ISO DIN 13

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

Nominal Diameter mm	Ø o / d	Art.-No.	€
M 1 x 0.25	16 x 5	27402	11,50
M 1.1 x 0.25	16 x 5	27404	11,50
M 1.2 x 0.25	16 x 5	27406	11,50
M 1.4 x 0.3	16 x 5	27408	11,50
M 1.6 x 0.35	16 x 5	27410	11,50
M 1.7 x 0.35	16 x 5	27412	11,50
M 1.8 x 0.35	16 x 5	27414	10,00
M 2 x 0.4	16 x 5	27416	10,00
M 2.2 x 0.45	16 x 5	27418	10,00
M 2.3 x 0.4	16 x 5	27420	10,00
M 2.5 x 0.45	16 x 5	27422	10,00
M 2.6 x 0.45	16 x 5	27424	10,00
M 3 x 0.5	20 x 5	27426	4,80
M 3.5 x 0.6	20 x 5	27428	7,40
M 4 x 0.7	20 x 5	27430	4,80
M 4.5 x 0.75	20 x 7	27432	7,40
M 5 x 0.8	20 x 7	27434	5,10
M 5.5 x 0.9	20 x 7	27436	7,40
M 6 x 1.0	20 x 7	27438	5,10
M 7 x 1.0	25 x 9	27440	8,00
M 8 x 1.25	25 x 9	27442	5,40
M 9 x 1.25	25 x 9	27444	9,10
M 10 x 1.5	30 x 11	27446	8,00
M 11 x 1.5	30 x 11	27448	11,00
M 12 x 1.75	38 x 14	27450	13,00
M 14 x 2.0	38 x 14	27454	13,00
M 15 x 2.0	38 x 14	27456	20,00
M 16 x 2.0	45 x 18	27458	20,00
M 18 x 2.5	45 x 18	27462	20,00
M 19 x 2.5	45 x 18	27464	29,00
M 20 x 2.5	45 x 18	27466	20,00
M 22 x 2.5	55 x 22	27470	39,00
M 24 x 3.0	55 x 22	27474	39,00
M 27 x 3.0	65 x 25	27476	52,50
M 30 x 3.5	65 x 25	27478	52,50
M 33 x 3.5	65 x 25	27480	56,00
M 36 x 4.0	65 x 25	27482	56,00
M 39 x 4.0	75 x 30	27484	91,00
M 42 x 4.5	75 x 30	27486	91,00
M 45 x 4.5	90 x 36	27488	156,00
M 48 x 5.0	90 x 36	27490	156,00
M 52 x 5.0	90 x 36	27492	156,00
M 56 x 5.5	105 x 36	27494	313,00
M 60 x 5.5	105 x 36	27496	313,00
M 64 x 6.0	120 x 36	27498	415,00
M 68 x 6.0	120 x 36	27499	415,00

►►►

Application:
for general use
- non abrasive material up to 800 N/mm²
- unalloyed and low alloyed steel

Applicazione:
per uso universale
- Materiali con buona truciodibilità fino a R 800 N/mm²
- Acciaio non legati e scarsamente legati

Round Dies VS
metric ISO-thread DIN 13

Filiere tonde VS
filettatura metrica ISO DIN 13

HSS Tol. 6g

M

Nominal Diameter mm	Ø o / d		Art.-No.	€
M 72 x 6.0	120 x 36		28280	310,00
M 76 x 6.0	120 x 36		28281	310,00
M 80 x 6.0	120 x 36		28282	310,00
M 84 x 6.0	130 x 36		28283	395,00
M 88 x 6.0	140 x 36		28284	608,00
M 90 x 6.0	140 x 36		28285	608,00
M 92 x 6.0	140 x 36		28286	608,00
M 96 x 6.0	140 x 36		28287	608,00
M 100 x 6.0	150 x 36		28288	705,00
M 3 x 0.5	25 x 9		27826	5,50
M 4 x 0.7	25 x 9		27830	5,50
M 5 x 0.8	25 x 9		27834	5,50
M 6 x 1.0	25 x 9		27838	5,50
M 8 x 1.25	25 x 9		27842	5,50
M 10 x 1.5	25 x 9		27846	5,50
M 12 x 1.75	25 x 9		27850	5,50
M 3 x 0.5	25.4	Form A	27926	6,50
M 4 x 0.7	25.4	Form A	27930	6,50
M 5 x 0.8	25.4	Form A	27934	6,50
M 6 x 1.0	25.4	Form A	27938	6,50
M 8 x 1.25	25.4	Form A	27942	6,50
M 10 x 1.5	25.4	Form A	27946	6,50
M 12 x 1.75	25.4	Form A	27950	6,50
M 14 x 2.0	38.1	Form A	27954	14,90
M 16 x 2.0	38.1	Form A	27958	14,90
M 18 x 2.5	38.1	Form A	27962	14,90
M 20 x 2.5	38.1	Form A	27966	14,90

Application:
for general use
- non abrasive material up to 800 N/mm²
- unalloyed and low alloyed steel

Applicazione:
per uso universale
- Materiali con buona truciodibilità fino a R 800 N/mm²
- Acciaio non legati e scarsamente legati

Round Dies VS
metric ISO-thread DIN 13

Filiere tonde VS
filettatura metrica ISO DIN 13

DIN 223 (DIN EN 22568) HSS Tol. 6e M

Nominal Diameter mm	Ø o / d	Art.-No.	€
M 3 x 0.5	20 x 5	27503	8,00
M 4 x 0.7	20 x 5	27505	8,00
M 5 x 0.8	20 x 7	27507	8,30
M 6 x 1.0	20 x 7	27509	8,30
M 8 x 1.25	25 x 9	27511	8,90
M 10 x 1.5	30 x 11	27513	11,50
M 12 x 1.75	38 x 14	27515	17,80
M 14 x 2.0	38 x 14	27516	23,00
M 16 x 2.0	45 x 18	27517	34,60
M 18 x 2.5	45 x 18	27518	34,60
M 20 x 2.5	45 x 18	27519	34,60

Application:
for general use
- non abrasive material up to 800 N/mm²
- unalloyed and low alloyed steel

Applicazione:
per uso universale
- Materiali con buona truciodibilità fino a R 800 N/mm²
- Acciaio non legati e scarsamente legati

Round Dies VS
metric-fine ISO-thread DIN 13

Filiere tonde VS
filettatura metrica fine ISO DIN 13

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

Nominal Diameter mm	Ø o / d	Art.-No.	€
M 2.5 x 0.35	16 x 5	26404	12,10
M 2.6 x 0.35	16 x 5	26405	12,10
M 3 x 0.35	20 x 5	26408	11,00
M 3.5 x 0.35	20 x 5	26409	11,00
M 4 x 0.35	20 x 5	26410	11,00
M 4 x 0.5	20 x 5	26412	11,00
M 4.5 x 0.5	20 x 5	26413	11,00
M 5 x 0.5	20 x 5	26414	11,00
M 5 x 0.75	20 x 7	26416	11,00
M 5.5 x 0.5	20 x 5	26415	11,00
M 6 x 0.5	20 x 5	26417	11,00
M 6 x 0.75	20 x 7	26418	9,50
M 7 x 0.5	25 x 9	26419	12,00
M 7 x 0.75	25 x 9	26420	12,00
M 8 x 0.5	25 x 9	26422	12,00
M 8 x 0.75	25 x 9	26424	10,00
M 8 x 1.0	25 x 9	26426	10,00
M 9 x 0.5	25 x 9	26427	15,00
M 9 x 0.75	25 x 9	26428	15,00
M 9 x 1.0	25 x 9	26430	15,00
M 10 x 0.5	30 x 11	26431	15,00
M 10 x 0.75	30 x 11	26432	15,00
M 10 x 1.0	30 x 11	26436	11,50
M 10 x 1.25	30 x 11	26438	11,50
M 11 x 1.0	30 x 11	26440	17,30
M 11 x 1.25	30 x 11	26442	17,30
M 12 x 0.5	38 x 10	26445	17,30
M 12 x 0.75	38 x 10	26443	17,30
M 12 x 1.0	38 x 10	26444	14,70
M 12 x 1.25	38 x 10	26446	14,70
M 12 x 1.5	38 x 10	26448	14,20
M 13 x 0.5	38 x 10	26447	24,10
M 13 x 0.75	38 x 10	26449	24,10
M 13 x 1.0	38 x 10	26450	19,30
M 13 x 1.5	38 x 10	26451	19,30
M 14 x 0.5	38 x 10	26455	24,10
M 14 x 0.75	38 x 10	26452	19,30
M 14 x 1.0	38 x 10	26453	19,30
M 14 x 1.25	38 x 10	26454	16,20
M 14 x 1.5	38 x 10	26456	30,50
M 15 x 0.75	38 x 10	26457	26,30
M 15 x 1.0	38 x 10	26458	26,30
M 15 x 1.5	38 x 10	26460	33,60
M 16 x 0.5	45 x 14	26461	33,60
M 16 x 0.75	45 x 14	26463	16,20

►►►

Application:
for general use
- non abrasive material up to 800 N/mm²
- unalloyed and low alloyed steel

Applicazione:
per uso universale
- Materiali con buona truciodibilità fino a R 800 N/mm²
- Acciaio non legati e scarsamente legati

Round Dies VS
metric-fine ISO-thread DIN 13

Filiere tonde VS
filettatura metrica fine ISO DIN 13

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

Nominal Diameter mm	Ø o / d	Art.-No.	€
M 16 x 1.0	45 x 14	26462	26,30
M 16 x 1.25	45 x 14	26464	26,30
M 16 x 1.5	45 x 14	26466	20,70
M 17 x 1.0	45 x 14	26468	35,70
M 17 x 1.5	45 x 14	26469	35,70
M 18 x 0.5	45 x 14	26467	35,70
M 18 x 0.75	45 x 14	26473	35,70
M 18 x 1.0	45 x 14	26470	24,10
M 18 x 1.25	45 x 14	26471	24,10
M 18 x 1.5	45 x 14	26472	20,70
M 18 x 2.0	45 x 14	26474	24,70
M 19 x 1.0	45 x 14	26475	35,70
M 19 x 1.5	45 x 14	26476	24,10
M 20 x 0.5	45 x 14	26477	35,70
M 20 x 0.75	45 x 14	26479	35,70
M 20 x 1.0	45 x 14	26478	24,70
M 20 x 1.25	45 x 14	26480	24,70
M 20 x 1.5	45 x 14	26484	20,70
M 20 x 2.0	45 x 14	26486	24,70
M 21 x 1.0	45 x 14	26487	37,30
M 21 x 1.5	45 x 14	26488	37,30
M 22 x 0.5	55 x 16	26489	51,50
M 22 x 0.75	55 x 16	26491	51,50
M 22 x 1.0	55 x 16	26490	39,90
M 22 x 1.25	55 x 16	26492	39,90
M 22 x 1.5	55 x 16	26494	36,00
M 22 x 2.0	55 x 16	26496	39,90
M 23 x 1.0	55 x 16	26497	52,30
M 23 x 1.5	55 x 16	26498	39,90
M 24 x 0.5	55 x 16	26601	51,50
M 24 x 0.75	55 x 16	26603	51,50
M 24 x 1.0	55 x 16	26600	39,90
M 24 x 1.25	55 x 16	26602	39,90
M 24 x 1.5	55 x 16	26604	36,00
M 24 x 2.0	55 x 16	26606	39,90
M 25 x 1.0	55 x 16	26607	51,50
M 25 x 1.5	55 x 16	26608	51,50
M 26 x 1.0	55 x 16	26610	51,50
M 26 x 1.5	55 x 16	26612	51,50
M 26 x 2.0	55 x 16	26614	51,50
M 27 x 1.0	65 x 18	26616	58,80
M 27 x 1.5	65 x 18	26617	58,80
M 27 x 2.0	65 x 18	26618	58,80
M 28 x 1.0	65 x 18	26620	58,80
M 28 x 1.5	65 x 18	26622	58,80
M 28 x 2.0	65 x 18	26624	58,80
M 29 x 1.5	65 x 18	26626	58,80
M 30 x 1.0	65 x 18	26628	58,80
M 30 x 1.5	65 x 18	26630	58,80
M 30 x 2.0	65 x 18	26632	58,80

Round Dies VS
metric-fine ISO-thread DIN 13

Filiere tonde VS
filettatura metrica fine ISO DIN 13

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

Nominal Diameter mm	Ø o / d	Art.-No.	€
M 30 x 2.5	65 x 18	26633	58,80
M 30 x 3.0	65 x 25	26634	58,80
M 32 x 1.0	65 x 18	26639	83,00
M 32 x 1.5	65 x 18	26636	58,80
M 32 x 2.0	65 x 18	26635	58,80
M 32 x 3.0	65 x 25	26637	58,80
M 33 x 1.5	65 x 18	26638	58,80
M 33 x 2.0	65 x 18	26640	58,80
M 33 x 3.0	65 x 25	26642	58,80
M 34 x 1.0	65 x 18	26643	83,00
M 34 x 1.5	65 x 18	26644	58,80
M 34 x 2.0	65 x 18	26646	58,80
M 35 x 1.0	65 x 18	26647	83,00
M 35 x 1.5	65 x 18	26648	58,80
M 35 x 2.0	65 x 18	26649	83,00
M 36 x 1.0	65 x 18	26651	83,00
M 36 x 1.5	65 x 18	26650	58,80
M 36 x 2.0	65 x 18	26652	58,80
M 36 x 3.0	65 x 25	26654	58,80
M 37 x 1.5	65 x 18	26653	125,00
M 38 x 1.0	75 x 20	26655	125,00
M 38 x 1.5	75 x 20	26656	95,00
M 38 x 2.0	75 x 20	26657	95,00
M 38 x 3.0	75 x 30	26659	125,00
M 39 x 1.5	75 x 20	26658	95,00
M 39 x 2.0	75 x 20	26660	95,00
M 39 x 3.0	75 x 30	26662	95,00
M 40 x 1.0	75 x 20	26663	125,00
M 40 x 1.5	75 x 20	26664	95,00
M 40 x 2.0	75 x 20	26666	95,00
M 40 x 3.0	75 x 30	26668	95,00
M 42 x 1.0	75 x 20	26669	125,00
M 42 x 1.5	75 x 20	26670	95,00
M 42 x 2.0	75 x 20	26672	95,00
M 42 x 3.0	75 x 30	26674	95,00
M 44 x 1.5	90 x 22	26671	204,00
M 44 x 2.0	90 x 22	26673	204,00
M 45 x 1.0	90 x 22	26675	204,00
M 45 x 1.5	90 x 22	26676	158,00
M 45 x 2.0	90 x 22	26678	158,00
M 45 x 3.0	90 x 36	26680	158,00
M 46 x 1.5	90 x 22	26681	204,00
M 48 x 1.0	90 x 22	26683	204,00
M 48 x 1.5	90 x 22	26682	158,00
M 48 x 2.0	90 x 22	26684	158,00
M 48 x 3.0	90 x 36	26686	158,00
M 50 x 1.5	90 x 22	26688	158,00
M 50 x 2.0	90 x 22	26690	158,00
M 50 x 3.0	90 x 36	26692	158,00
M 52 x 1.5	90 x 22	26694	158,00

VÖLKEL THREADING SOLUTIONS

Round Dies VS
metric-fine ISO-thread DIN 13

Filiere tonde VS
filettatura metrica fine ISO DIN 13

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

Mf

Nominal Diameter mm	Ø o / d	Art.-No.	€
M 52 x 2.0	90 x 22	26696	158,00
M 52 x 3.0	90 x 36	26698	158,00
M 54 x 1.0	105 x 22	28267	280,00
M 54 x 1.5	105 x 22	28150	280,00
M 54 x 2.0	105 x 22	28151	280,00
M 54 x 3.0	105 x 36	28152	280,00
M 54 x 4.0	105 x 36	28153	280,00
M 55 x 1.5	105 x 22	28154	280,00
M 55 x 2.0	105 x 22	28155	280,00
M 55 x 3.0	105 x 36	28156	280,00
M 55 x 4.0	105 x 36	28157	280,00
M 56 x 1.0	105 x 22	28268	280,00
M 56 x 1.5	105 x 22	28158	280,00
M 56 x 2.0	105 x 22	28159	280,00
M 56 x 3.0	105 x 36	28160	280,00
M 56 x 4.0	105 x 36	28161	280,00
M 58 x 1.0	105 x 22	28269	280,00
M 58 x 1.5	105 x 22	28162	280,00
M 58 x 2.0	105 x 22	28163	280,00
M 58 x 3.0	105 x 36	28164	280,00
M 58 x 4.0	105 x 36	28165	280,00
M 60 x 1.5	105 x 22	28166	280,00
M 60 x 2.0	105 x 22	28167	280,00
M 60 x 3.0	105 x 36	28168	280,00
M 60 x 4.0	105 x 36	28169	280,00
M 62 x 1.5	105 x 22	28170	280,00
M 62 x 2.0	105 x 22	28171	280,00
M 62 x 3.0	105 x 36	28172	280,00
M 62 x 4.0	105 x 36	28173	280,00
M 63 x 1.5	105 x 22	28174	280,00
M 64 x 1.5	120 x 22	28175	318,00
M 64 x 2.0	120 x 22	28176	318,00
M 64 x 3.0	120 x 36	28177	318,00
M 64 x 4.0	120 x 36	28178	318,00
M 65 x 1.5	120 x 22	28179	318,00
M 65 x 2.0	120 x 22	28180	318,00
M 65 x 3.0	120 x 36	28181	318,00
M 65 x 4.0	120 x 36	28182	318,00
M 68 x 1.5	120 x 22	28183	318,00
M 68 x 2.0	120 x 22	28184	318,00
M 68 x 3.0	120 x 36	28185	318,00
M 68 x 4.0	120 x 36	28186	318,00
M 70 x 1.5	120 x 22	28187	318,00
M 70 x 2.0	120 x 22	28188	318,00
M 70 x 3.0	120 x 36	28189	318,00
M 70 x 4.0	120 x 36	28190	318,00
M 72 x 1.5	120 x 22	28191	318,00
M 72 x 2.0	120 x 22	28192	318,00
M 72 x 3.0	120 x 36	28193	318,00
M 72 x 4.0	120 x 36	28194	318,00

Round Dies VS
metric-fine ISO-thread DIN 13

Filiere tonde VS
filettatura metrica fine ISO DIN 13

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

Mf

Nominal Diameter mm	Ø o / d	Art.-No.	€
M 74 x 1.5	120 x 22	28195	318,00
M 74 x 2.0	120 x 22	28196	318,00
M 74 x 3.0	120 x 36	28197	318,00
M 74 x 4.0	120 x 36	28198	318,00
M 75 x 1.5	120 x 22	28199	318,00
M 75 x 2.0	120 x 22	28200	318,00
M 75 x 3.0	120 x 36	28201	318,00
M 75 x 4.0	120 x 36	28202	318,00
M 76 x 1.5	120 x 22	28203	318,00
M 76 x 2.0	120 x 22	28204	318,00
M 76 x 3.0	120 x 36	28205	318,00
M 76 x 4.0	120 x 36	28206	318,00
M 78 x 1.5	120 x 22	28207	318,00
M 78 x 2.0	120 x 22	28208	318,00
M 78 x 3.0	120 x 36	28209	318,00
M 78 x 4.0	120 x 36	28210	318,00
M 80 x 1.5	120 x 22	28211	318,00
M 80 x 2.0	120 x 22	28212	318,00
M 80 x 3.0	120 x 36	28213	318,00
M 80 x 4.0	120 x 36	28214	318,00
M 82 x 1.5	130 x 25	28215	402,00
M 82 x 2.0	130 x 25	28216	402,00
M 82 x 3.0	130 x 36	28217	402,00
M 82 x 4.0	130 x 36	28218	402,00
M 84 x 1.5	130 x 25	28219	402,00
M 84 x 2.0	130 x 25	28220	402,00
M 84 x 3.0	130 x 36	28221	402,00
M 84 x 4.0	130 x 36	28222	402,00
M 85 x 1.5	130 x 25	28223	402,00
M 85 x 2.0	130 x 25	28224	402,00
M 85 x 3.0	130 x 36	28225	402,00
M 85 x 4.0	130 x 36	28226	402,00
M 86 x 1.5	140 x 22	28227	501,00
M 86 x 2.0	140 x 22	28228	501,00
M 86 x 3.0	140 x 22	28229	501,00
M 86 x 4.0	140 x 22	28230	501,00
M 88 x 1.5	140 x 22	28231	501,00
M 88 x 2.0	140 x 22	28232	501,00
M 88 x 3.0	140 x 22	28233	501,00
M 88 x 4.0	140 x 22	28234	501,00
M 90 x 1.5	140 x 22	28235	501,00
M 90 x 2.0	140 x 22	28236	501,00
M 90 x 3.0	140 x 22	28237	501,00
M 90 x 4.0	140 x 22	28238	501,00
M 92 x 1.5	140 x 22	28239	501,00
M 92 x 2.0	140 x 22	28240	501,00
M 92 x 3.0	140 x 22	28241	501,00
M 92 x 4.0	140 x 22	28242	501,00
M 95 x 1.5	140 x 22	28243	501,00
M 95 x 2.0	140 x 22	28244	501,00

Round Dies VS
metric-fine ISO-thread DIN 13

Filiere tonde VS
filettatura metrica fine ISO DIN 13

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

Mf

Nominal Diameter mm	Ø o / d	Art.-No.	€
M 95 x 3.0	140 x 22	28245	501,00
M 95 x 4.0	140 x 22	28246	501,00
M 96 x 1.5	140 x 22	28247	501,00
M 96 x 2.0	140 x 22	28248	501,00
M 96 x 3.0	140 x 22	28249	501,00
M 96 x 4.0	140 x 22	28250	501,00
M 98 x 1.5	150 x 25	28251	603,00
M 98 x 2.0	150 x 25	28252	603,00
M 98 x 3.0	150 x 25	28253	603,00
M 98 x 4.0	150 x 25	28254	603,00
M 100 x 1.5	150 x 25	28255	603,00
M 100 x 2.0	150 x 25	28256	603,00
M 100 x 3.0	150 x 25	28257	603,00
M 100 x 4.0	150 x 25	28258	603,00
M 105 x 1.5	150 x 25	28259	603,00
M 105 x 2.0	150 x 25	28260	603,00
M 105 x 3.0	150 x 25	28261	603,00
M 105 x 4.0	150 x 25	28262	603,00
M 110 x 1.5	160 x 25	28263	659,00
M 110 x 2.0	160 x 25	28264	659,00
M 110 x 3.0	160 x 25	28265	659,00
M 110 x 4.0	160 x 25	28266	659,00

Round Dies VS
Whitworth-thread BS 84

Filiere tonde VS
filettatura Whitworth BS 84

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

BSW / BSF

Nominal Diameter	Ø o / d	Art.-No.	€
BSW			
BSW 1/16 x 60	16 x 5	22402	10,50
BSW 3/32 x 48	16 x 5	22404	10,50
BSW 1/8 x 40	20 x 5	22406	10,50
BSW 5/32 x 32	20 x 5	22408	10,50
BSW 3/16 x 24	20 x 7	22410	10,50
BSW 7/32 x 24	20 x 7	22412	10,50
BSW 1/4 x 20	20 x 7	22414	10,50
BSW 5/16 x 18	25 x 9	22416	12,00
BSW 3/8 x 16	30 x 11	22418	13,30
BSW 7/16 x 14	30 x 11	22420	15,40
BSW 1/2 x 12	38 x 14	22422	17,30
BSW 9/16 x 12	38 x 14	22424	21,40
BSW 5/8 x 11	45 x 18	22426	23,40
BSW 3/4 x 10	45 x 18	22430	23,40
BSW 7/8 x 9	55 x 22	22434	40,00
BSW 1" x 8	55 x 22	22438	40,00
BSW 1.1/8 x 7	65 x 25	22442	60,50
BSW 1.1/4 x 7	65 x 25	22446	60,50
BSW 1.3/8 x 6	65 x 25	22450	60,50
BSW 1.1/2 x 6	65 x 25	22452	60,50
BSW 1.1/2 x 6	75 x 30	22454	108,00
BSW 1.5/8 x 5	75 x 30	22458	108,00
BSW 1.3/4 x 5	90 x 36	22462	165,00
BSW 1.7/8 x 4.1/2	90 x 36	22466	165,00
BSW 2" x 4.1/2	90 x 36	22470	165,00
BSW 2.1/4 x 4	105 x 36	22472	425,00
BSW 2.1/2 x 4	105 x 36	22474	425,00
BSW 2.3/4 x 3.1/2	120 x 36	22476	521,00
BSW 3" x 3.1/2	120 x 36	22478	521,00
BSF			
BSF 3/16 x 32	20 x 7	22810	10,50
BSF 1/4 x 26	20 x 7	22814	10,50
BSF 5/16 x 22	25 x 9	22816	12,00
BSF 3/8 x 20	30 x 11	22818	13,30
BSF 7/16 x 18	30 x 11	22820	15,40
BSF 1/2 x 16	38 x 10	22822	19,80
BSF 9/16 x 16	38 x 10	22824	22,00
BSF 5/8 x 14	45 x 14	22826	30,00
BSF 3/4 x 12	45 x 14	22830	30,00
BSF 7/8 x 11	55 x 16	22834	41,00
BSF 1" x 10	55 x 22	22838	41,00

Application:
for general use
- non abrasive material up to 800 N/mm²
- unalloyed and low alloyed steel

Applicazione:
per uso universale
- Materiali con buona truciodibilità fino a R 800 N/mm²
- Acciaio non legati e scarsamente legati

Round Split Dies VS
BA-thread BS 93

Filiere tonde VS
filettatura BA, BS 93

BS1127 **HSS** **Tol. med.** **BA**

Nominal Diameter	Ø o / d		Art.-No.	€
BA 0	20.6 x 6.35	Form A	89000	10,40
BA 1	20.6 x 6.35	Form A	89001	10,40
BA 2	20.6 x 6.35	Form A	89002	10,40
BA 3	20.6 x 6.35	Form A	89003	10,40
BA 4	20.6 x 6.35	Form A	89004	10,40
BA 5	20.6 x 6.35	Form A	89005	10,40
BA 6	20.6 x 6.35	Form A	89006	10,40

Application:
for general use
- non abrasive material up to 800 N/mm²
- unalloyed and low alloyed steel

Applicazione:
per uso universale
- Materiali con buona truciodibilità fino a R 800 N/mm²
- Acciaio non legati e scarsamente legati

Round Dies VS
Unified Coarse thread

Filiere tonde VS
filettatura unificata, serie grossa ANSI B1.1

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

Nominal Diameter	Ø o / d	Art.-No.	€
UNC Nr. 1 x 64	16 x 5	23401	12,00
UNC Nr. 2 x 56	16 x 5	23402	12,00
UNC Nr. 3 x 48	16 x 5	23403	12,00
UNC Nr. 4 x 40	20 x 5	23404	11,00
UNC Nr. 5 x 40	20 x 5	23405	11,00
UNC Nr. 6 x 32	20 x 7	23406	11,00
UNC Nr. 8 x 32	20 x 7	23408	11,00
UNC Nr.10 x 24	20 x 7	23410	11,00
UNC Nr.12 x 24	20 x 7	23412	11,00
UNC 1/4 x 20	20 x 7	23414	10,50
UNC 5/16 x 18	25 x 9	23416	12,00
UNC 3/8 x 16	30 x 11	23418	13,30
UNC 7/16 x 14	30 x 11	23420	15,40
UNC 1/2 x 13	38 x 14	23422	17,30
UNC 9/16 x 12	38 x 14	23424	21,40
UNC 5/8 x 11	45 x 18	23426	23,40
UNC 3/4 x 10	45 x 18	23430	23,40
UNC 7/8 x 9	55 x 22	23434	40,00
UNC 1" x 8	55 x 22	23438	40,00
UNC 1.1/8 x 7	65 x 25	23442	60,50
UNC 1.1/4 x 7	65 x 25	23446	60,50
UNC 1.3/8 x 6	65 x 25	23450	60,50
UNC 1.1/2 x 6	65 x 25	23452	60,50
UNC 1.1/2 x 6	75 x 30	23454	108,00
UNC 1.5/8 x 5	75 x 30	23458	108,00
UNC 1.3/4 x 5	90 x 36	23462	165,00
UNC 1.7/8 x 4.1/2	90 x 36	23466	165,00
UNC 2" x 4.1/2	90 x 36	23470	165,00

Application:
for general use
- non abrasive material up to 800 N/mm²
- unalloyed and low alloyed steel

Applicazione:
per uso universale
- Materiali con buona truciodibilità fino a R 800 N/mm²
- Acciaio non legati e scarsamente legati

VÖLKEL THREADING SOLUTIONS

Round Dies VS
Unified Fine thread

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

DIN 223 (DIN EN 22568) HSS Tol. 2A UNF

Nominal Diameter	Ø o / d	Art.-No.	€
UNF Nr. 0 x 80	16 x 5	24400	12,00
UNF Nr. 1 x 72	16 x 5	24401	12,00
UNF Nr. 2 x 64	16 x 5	24402	12,00
UNF Nr. 3 x 56	16 x 5	24403	12,00
UNF Nr. 4 x 48	20 x 5	24404	11,00
UNF Nr. 5 x 44	20 x 5	24405	11,00
UNF Nr. 6 x 40	20 x 5	24406	11,00
UNF Nr. 8 x 36	20 x 7	24408	11,00
UNF Nr. 10 x 32	20 x 7	24410	11,00
UNF Nr. 12 x 28	20 x 7	24412	11,00
UNF 1/4 x 28	20 x 7	24414	10,50
UNF 5/16 x 24	25 x 9	24416	12,00
UNF 3/8 x 24	30 x 11	24418	13,30
UNF 7/16 x 20	30 x 11	24420	15,40
UNF 1/2 x 20	38 x 10	24422	17,30
UNF 9/16 x 18	38 x 10	24424	21,40
UNF 5/8 x 18	45 x 14	24426	23,40
UNF 3/4 x 16	45 x 14	24430	23,40
UNF 7/8 x 14	55 x 16	24434	40,00
UNF 1" x 12	55 x 16	24438	40,00
UNF 1" x 14	55 x 16	24440	40,00
UNF 1.1/8 x 12	65 x 18	24442	60,50
UNF 1.1/4 x 12	65 x 18	24446	60,50
UNF 1.3/8 x 12	65 x 18	24450	60,50
UNF 1.1/2 x 12	65 x 18	24452	60,50
UNF 1.1/2 x 12	75 x 20	24454	108,00

Application:
for general use
- non abrasive material up to 800 N/mm²
- unalloyed and low alloyed steel

Applicazione:
per uso universale
- Materiali con buona truciodibilità fino a R 800 N/mm²
- Acciaio non legati e scarsamente legati

Round Dies VS
Unified Extra Fine thread ANSI B 1.1

Filiere tonde VS
filettatura unificata, serie extra-fina ANSI B1.1

DIN 223 (DIN EN 22568) HSS Tol. 2A UNEF

Nominal Diameter	Ø o / d	Art.-No.	€
UNEF Nr. 12 x 32	20 x 7	24612	13,00
UNEF 1/4 x 32	20 x 7	24614	13,00
UNEF 5/16 x 32	25 x 9	24615	16,50
UNEF 3/8 x 32	30 x 11	24616	18,90
UNEF 7/16 x 28	30 x 11	24620	18,90
UNEF 1/2 x 28	38 x 10	24621	28,90
UNEF 9/16 x 24	38 x 10	24625	28,90
UNEF 5/8 x 24	45 x 14	24626	46,20
UNEF 11/16 x 24	45 x 14	24627	46,20
UNEF 3/4 x 20	45 x 14	24633	46,20
UNEF 13/16 x 20	55 x 16	24634	54,50
UNEF 7/8 x 20	55 x 16	24635	54,50
UNEF 15/16 x 20	55 x 16	24636	54,50
UNEF 1" x 20	55 x 16	24637	54,50
UNEF 1.1/16 x 18	65 x 18	24645	87,00
UNEF 1.1/8 x 18	65 x 18	24646	87,00
UNEF 1.3/16 x 18	65 x 18	24647	87,00
UNEF 1.1/4 x 18	65 x 18	24648	87,00
UNEF 1.5/16 x 18	65 x 18	24649	87,00
UNEF 1.3/8 x 18	65 x 18	24650	87,00
UNEF 1.7/16 x 18	75 x 20	24651	110,00
UNEF 1.1/2 x 18	75 x 20	24652	110,00

Application:
for general use
- non abrasive material up to 800 N/mm²
- unalloyed and low alloyed steel

Applicazione:
per uso universale
- Materiali con buona truciodibilità fino a R 800 N/mm²
- Acciaio non legati e scarsamente legati

VÖLKEL THREADING SOLUTIONS

Round Dies VS
Pipe-thread DIN ISO 228

Filiere tonde VS
filettatura per tubi gas DIN ISO 228

DIN 5158 (DIN EN 24231) HSS Tol. A G (BSP)

Nominal Diameter	Ø o / d	Art.-No.	€
G 1/8 x 28	30 x 11	25412	15,50
G 1/4 x 19	38 x 10	25414	15,80
G 3/8 x 19	45 x 14	25416	21,00
G 1/2 x 14	45 x 14	25418	21,00
G 5/8 x 14	55 x 16	25420	38,00
G 3/4 x 14	55 x 16	25422	38,00
G 7/8 x 14	65 x 18	25424	51,00
G 1" x 11	65 x 18	25426	51,00
G 1.1/8 x 11	75 x 20	25430	86,00
G 1.1/4 x 11	75 x 20	25434	86,00
G 1.3/8 x 11	90 x 22	25438	150,00
G 1.1/2 x 11	90 x 22	25442	150,00
G 1.5/8 x 11	90 x 22	25446	150,00
G 1.3/4 x 11	105 x 22	25450	257,00
G 2" x 11	90 x 22	25452	150,00
G 2" x 11	105 x 22	25454	257,00
G 2.1/4 x 11	120 x 22	25458	350,00
G 2.1/2 x 11	120 x 22	25462	468,00
G 2.3/4 x 11	120 x 22	25466	468,00
G 3" x 11	130 x 25	25470	518,00
G 3.1/2 x 11	150 x 25	25474	840,00
G 4" x 11	160 x 25	25478	1.040,00

Application:
for general use
- non abrasive material up to 800 N/mm²
- unalloyed and low alloyed steel

Applicazione:
per uso universale
- Materiali con buona truciodibilità fino a R 800 N/mm²
- Acciaio non legati e scarsamente legati

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

Filiere tonde VS
filettatura conica per tubi, cono 1:16

HSS

R (BSPT)

Nominal Diameter		Ø o / d		Art.-No.	€
PT	1/8 x 28	38 x 11	Form A	97006	16,80
PT	1/4 x 19	38 x 16	Form A	97014	16,80
PT	3/8 x 19	50 x 18	Form A	97020	34,00
PT	1/2 x 14	50 x 22	Form A	97022	34,00
PT	3/4 x 14	50 x 24	Form A	97030	34,00
PT	1" x 11	63 x 28	Form A	97040	57,00
PT	1.1/4 x 11	75 x 32	Form A	97048	77,00

Application:
for general use
- non abrasive material up to 800 N/mm²
- unalloyed and low alloyed steel

Applicazione:
per uso universale
- Materiali con buona truciodibilità fino a R 800 N/mm²
- Acciaio non legati e scarsamente legati

Round Dies VS
armoured tube thread DIN 40 430

Filiere tonde VS
filettatura per tubi corazzati DIN 40 430

DIN 40434 HSS

PG

Nominal Diameter	Ø o / d	Art.-No.	€
PG 7 x 20	38 x 10	25807	39,00
PG 9 x 18	45 x 14	25809	47,50
PG 11 x 18	45 x 14	25811	47,50
PG 13.5 x 18	45 x 14	25813	47,50
PG 16 x 18	55 x 16	25816	56,00
PG 21 x 16	65 x 18	25821	86,00
PG 29 x 16	65 x 18	25829	86,00
PG 36 x 16	90 x 22	25836	170,00
PG 42 x 16	105 x 22	25842	216,00
PG 48 x 16	105 x 22	25848	216,00

Application:
for general use
- non abrasive material up to 800 N/mm²
- unalloyed and low alloyed steel

Applicazione:
per uso universale
- Materiali con buona truciodibilità fino a R 800 N/mm²
- Acciaio non legati e scarsamente legati

Round Dies VS
american tapered pipe thread, taper 1:16

Filiere tonde VS
filettatura americana conica per tubi, cono 1:16

HSS

NPT / NPTF

Nominal Diameter	Ø o / d		Art.-No.	€
NPT				
NPT 1/16 x 27	25 x 9		23610	31,50
NPT 1/8 x 27	30 x 11		23612	33,50
NPT 1/4 x 18	38 x 14		23614	41,00
NPT 3/8 x 18	45 x 14		23616	52,00
NPT 1/2 x 14	45 x 18		23618	52,00
NPT 5/8 x 14	55 x 22		23620	83,00
NPT 3/4 x 14	55 x 22		23622	83,00
NPT 7/8 x 14	65 x 25		23624	123,00
NPT 1" x 11.5	65 x 25		23626	123,00
NPT 1.1/4 x 11.5	75 x 26		23634	145,00
NPT 1.1/2 x 11.5	90 x 27		23642	237,00
NPT 2" x 11.5	105 x 28		23654	313,00
NPTF				
NPTF 1/8 x 27	50 x 11	Form A	98072	35,00
NPTF 1/4 x 18	50 x 14	Form A	98074	35,00
NPTF 3/8 x 18	50 x 14	Form A	98076	35,00
NPTF 1/2 x 14	50 x 18	Form A	98078	35,00
NPTF 3/4 x 14	50 x 22	Form A	98080	35,00
NPTF 1" x 11.5	50 x 25	Form A	98082	35,00

Application:
for general use
- non abrasive material up to 800 N/mm²
- unalloyed and low alloyed steel

Applicazione:
per uso universale
- Materiali con buona truciodibilità fino a R 800 N/mm²
- Acciaio non legati e scarsamente legati

VÖLKEL THREADING SOLUTIONS

Round Dies VS
Cycle thread DIN 79012 and BS 811

Filiere tonde VS
filettatura per biciclette DIN 79012 e BS 811

DIN 223 (DIN EN 22568) HSS Tol. med. FG / BSC

Nominal Diameter	Ø o / d	Art.-No.	€
FG (DIN 79012)			
FG 2 x 56	16 x 5	79301	35,00
FG 2.3 x 56	16 x 5	79302	35,00
FG 2.6 x 56	16 x 5	79303	35,00
FG 6.35 x 26	20 x 7	79304	36,00
FG 7.9 x 26	25 x 9	79305	51,00
FG 9.5 x 26	30 x 11	79306	71,00
FG 14.3 x 20	38 x 10	79307	109,00
FG 14.3 x 20 - LH	38 x 10	79308	131,00
FG 25.4 x 24	55 x 16	79309	297,00
BSC (BS 811)			
BSC 1/4 x 26	20 x 7	79320	36,00
BSC 5/16 x 26	25 x 9	79321	51,00
BSC 3/8 x 26	30 x 11	79322	71,00
BSC 9/16 x 20	38 x 10	79323	109,00
BSC 9/16 x 20 - LH	38 x 10	79324	131,00
BSC 1" x 24	55 x 16	79325	297,00

Application:
for general use
- non abrasive material up to 800 N/mm²
- unalloyed and low alloyed steel

Applicazione:
per uso universale
- Materiali con buona truciodibilità fino a R 800 N/mm²
- Acciaio non legati e scarsamente legati

Round Dies VS
Valve thread DIN 7756

Filiere tonde VS
filettatura per valvole DIN 7756

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

Nominal Diameter	Ø o / d	Art.-No.	€
VG 5 x 36	20 x 7	79330	36,00
VG 5.2 x 24	20 x 7	79331	36,00
VG 6 x 32	20 x 7	79332	36,00
VG 8 x 32	25 x 9	79333	51,00
VG 10 x 28	30 x 11	79334	71,00
VG 12 x 26	30 x 11	79335	71,00

Application:
for general use
- non abrasive material up to 800 N/mm²
- unalloyed and low alloyed steel

Applicazione:
per uso universale
- Materiali con buona truciodibilità fino a R 800 N/mm²
- Acciaio non legati e scarsamente legati

VÖLKEL THREADING SOLUTIONS

Round Dies VE
gun nosed
metric ISO-thread DIN 13

Filiere tonde VE
con imbocco corretto
filettatura metrica ISO DIN 13

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

Nominal Diameter mm	Ø o / d	Art.-No.	€
M 3 x 0.5	20 x 5	57426	8,10
M 4 x 0.7	20 x 5	57430	8,10
M 5 x 0.8	20 x 7	57434	8,40
M 6 x 1.0	20 x 7	57438	8,40
M 8 x 1.25	25 x 9	57442	11,90
M 10 x 1.5	30 x 11	57446	16,90
M 12 x 1.75	38 x 14	57450	26,70
M 14 x 2.0	38 x 14	57454	26,70
M 16 x 2.0	45 x 18	57458	40,30
M 18 x 2.5	45 x 18	57462	40,30
M 20 x 2.5	45 x 18	57466	40,30
M 22 x 2.5	55 x 22	57470	71,60
M 24 x 3.0	55 x 22	57474	71,60
M 27 x 3.0	65 x 25	57476	106,00
M 30 x 3.5	65 x 25	57478	106,00

Benefit:
- high cutting ability
- reduction of torque
- uninterrupted swarf flow in direction of feed
- prevents jaming of swarf

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

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

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

Round Dies VE
gun nosed
metric-fine ISO-thread DIN 13

Filiere tonde VE
con imbocco corretto
filettatura metrica fine ISO DIN 13

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

Nominal Diameter mm	Ø o / d	Art.-No.	€
M 6 x 0.75	20 x 7	56418	12,00
M 8 x 0.75	25 x 9	56424	15,80
M 8 x 1.0	25 x 9	56426	15,80
M 10 x 1.0	30 x 11	56436	17,90
M 10 x 1.25	30 x 11	56438	17,90
M 12 x 1.0	38 x 10	56444	31,00
M 12 x 1.25	38 x 10	56446	31,00
M 12 x 1.5	38 x 10	56448	31,00
M 14 x 1.25	38 x 10	56454	31,00
M 14 x 1.5	38 x 10	56456	31,00
M 16 x 1.5	45 x 14	56466	49,00
M 18 x 1.5	45 x 14	56472	49,00
M 18 x 2.0	45 x 14	56474	49,00
M 20 x 1.5	45 x 14	56484	49,00
M 20 x 2.0	45 x 14	56486	49,00
M 22 x 1.5	55 x 16	56494	86,00
M 24 x 1.5	55 x 16	56604	86,00

Benefit:
- high cutting ability
- reduction of torque
- uninterrupted swarf flow in direction of feed
- prevents jaming of swarf

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

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

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

Round Dies VE
gun nosed
Pipe-thread DIN ISO 228

Filiere tonde VE
con imbocco corretto
filettatura per tubi gas DIN ISO 228

DIN 5158 (DIN EN 24231) HSS-E Tol. A G (BSP)

Nominal Diameter	Ø o / d	Art.-No.	€
G 1/8 x 28	30 x 11	55412	24,50
G 1/4 x 19	38 x 10	55414	24,50
G 3/8 x 19	45 x 14	55416	36,50
G 1/2 x 14	45 x 14	55418	36,50
G 3/4 x 14	55 x 16	55422	67,00
G 1" x 11	65 x 18	55426	96,00

Benefit:
- high cutting ability
- reduction of torque
- uninterrupted swarf flow in direction of feed
- prevents jaming of swarf

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

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

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

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

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

DIN 223 (DIN EN 22568) HSSE-VAP Tol. 6g

M

Nominal Diameter	Ø o / d	Art.-No.	€
M 3 x 0.5	20 x 5	57826	19,00
M 4 x 0.7	20 x 5	57830	19,00
M 5 x 0.8	20 x 7	57834	19,00
M 6 x 1.0	20 x 7	57838	19,00
M 8 x 1.25	25 x 9	57842	22,60
M 10 x 1.5	30 x 11	57846	28,00
M 12 x 1.75	38 x 14	57850	34,50
M 14 x 2.0	38 x 14	57854	34,50
M 16 x 2.0	45 x 18	57858	52,00
M 18 x 2.5	45 x 18	57862	52,00
M 20 x 2.5	45 x 18	57866	52,00
M 22 x 2.5	55 x 22	57870	85,00
M 24 x 3.0	55 x 22	57874	85,00
M 27 x 3.0	65 x 25	57876	134,00
M 30 x 3.5	65 x 25	57878	134,00

Application:
- alloyed, tough-hard material up to 1.200 N/mm²
- stainless steel
- aluminium cast
- spheroidal graphite cast iron (GGG)
- as well as for general use

for thread cutting by hand and machine

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

Steam tempered and hence optimal adhesion of the cutting oil

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

per uso a mano e macchina

Vantaggi:
- elevata durata
- taglio più facile
- libero scarico del truciolo dal davanti
- nessun intasamento dello scarico dei trucioli

Vaporizzato che garantisce una ottimale aderenza del lubrificante

VÖLKEL THREADING SOLUTIONS

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

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

DIN 223 (DIN EN 22568) HSSE-VAP Tol. 6g

Mf

Nominal Diameter		Ø o / d	Art.-No.	€
Mf	4 x 0.5	20 x 5	56806	22,70
Mf	5 x 0.5	20 x 5	56808	22,70
Mf	6 x 0.5	20 x 5	56811	22,70
Mf	6 x 0.75	20 x 7	56812	22,70
Mf	7 x 0.75	25 x 9	56814	28,00
Mf	8 x 0.5	25 x 9	56815	28,00
Mf	8 x 0.75	25 x 9	56816	28,00
Mf	8 x 1.0	25 x 9	56817	28,00
Mf	9 x 0.5	25 x 9	56818	34,50
Mf	9 x 0.75	25 x 9	56819	34,50
Mf	9 x 1.0	25 x 9	56820	34,50
Mf	10 x 0.5	30 x 11	56821	34,50
Mf	10 x 0.75	30 x 11	56822	34,50
Mf	10 x 1.0	30 x 11	56823	34,50
Mf	10 x 1.25	30 x 11	56824	34,50
Mf	11 x 1.0	30 x 11	56825	42,00
Mf	11 x 1.25	30 x 11	56826	42,00
Mf	12 x 0.5	38 x 10	56827	42,00
Mf	12 x 0.75	38 x 10	56828	42,00
Mf	12 x 1.0	38 x 10	56829	42,00
Mf	12 x 1.25	38 x 10	56830	42,00
Mf	12 x 1.5	38 x 10	56831	42,00
Mf	14 x 0.5	38 x 10	56836	42,50
Mf	14 x 0.75	38 x 10	56837	42,50
Mf	14 x 1.0	38 x 10	56838	42,50
Mf	14 x 1.25	38 x 10	56839	42,50
Mf	14 x 1.5	38 x 10	56840	42,50
Mf	15 x 0.75	38 x 10	56841	62,00
Mf	15 x 1.0	38 x 10	56842	62,00
Mf	15 x 1.5	38 x 10	56843	62,00
Mf	16 x 0.5	45 x 14	56844	62,00
Mf	16 x 0.75	45 x 14	56845	62,00
Mf	16 x 1.0	45 x 14	56846	62,00
Mf	16 x 1.25	45 x 14	56847	62,00
Mf	16 x 1.5	45 x 14	56848	62,00
Mf	17 x 1.0	45 x 14	56849	62,50
Mf	17 x 1.5	45 x 14	56850	62,50
Mf	18 x 0.5	45 x 14	56851	62,50
Mf	18 x 0.75	45 x 14	56852	62,50
Mf	18 x 1.0	45 x 14	56853	62,50
Mf	18 x 1.25	45 x 14	56854	62,50
Mf	18 x 1.5	45 x 14	56855	62,50
Mf	18 x 2.0	45 x 14	56856	62,50
Mf	20 x 0.5	45 x 14	56859	64,00
Mf	20 x 0.75	45 x 14	56860	64,00
Mf	20 x 1.0	45 x 14	56861	64,00
Mf	20 x 1.25	45 x 14	56862	64,00
Mf	20 x 1.5	45 x 14	56863	64,00
Mf	20 x 2.0	45 x 14	56864	64,00
Mf	22 x 0.5	55 x 16	56867	95,00

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

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

DIN 223 (DIN EN 22568) HSSE-VAP Tol. 6g

Mf

Nominal Diameter	Ø o / d	Art.-No.	€
Mf 22 x 0.75	55 x 16	56868	95,00
Mf 22 x 1.0	55 x 16	56869	95,00
Mf 22 x 1.25	55 x 16	56870	95,00
Mf 22 x 1.5	55 x 16	56871	95,00
Mf 22 x 2.0	55 x 16	56872	95,00
Mf 24 x 0.5	55 x 16	56875	105,00
Mf 24 x 0.75	55 x 16	56876	105,00
Mf 24 x 1.0	55 x 16	56877	105,00
Mf 24 x 1.25	55 x 16	56878	105,00
Mf 24 x 1.5	55 x 16	56879	105,00
Mf 24 x 2.0	55 x 16	56880	105,00

Application:
- alloyed, tough-hard material up to 1.200 N/mm²
- stainless steel
- aluminium cast
- spheroidal graphite cast iron (GGG)
- as well as for general use

for thread cutting by hand and machine

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

Steam tempered and hence optimal adhesion of the cutting oil

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

per uso a mano e macchina

Vantaggi:
- elevata durata
- taglio più facile
- libero scarico del truciolo dal davanti
- nessun intasamento dello scarico dei trucioli

Vaporizzato che garantisce una ottimale aderenza del lubrificante

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

Filiere tonde VX
con imbocco corretto, lappate e vaporizzate
filettarura per tubi gas DIN ISO 228

DIN 5158 (DIN EN 24231) HSSE-VAP

G (BSP)

Nominal Diameter	Ø o / d	Art.-No.	€
G 1/8 x 28	30 x 11	55612	24,50
G 1/4 x 19	38 x 10	55614	32,00
G 3/8 x 19	45 x 14	55616	51,00
G 1/2 x 14	45 x 14	55618	51,00
G 3/4 x 14	55 x 16	55622	91,00
G 1" x 11	65 x 18	55626	136,00

Application:
- alloyed, tough-hard material up to 1.200 N/mm²
- stainless steel
- aluminium cast
- spheroidal graphite cast iron (GGG)
- as well as for general use

for thread cutting by hand and machine

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

Steam tempered and hence optimal adhesion of the cutting oil

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

per uso a mano e macchina

Vantaggi:
- elevata durata
- taglio più facile
- libero scarico del truciolo dal davanti
- nessun intasamento dello scarico dei trucioli

Vaporizzato che garantisce una ottimale aderenza del lubrificante

Round Dies MS
gun nosed, lapped
metric ISO-thread DIN 13

Filiere tonde MS
con imbocco corretto, lappate
filettatura metrica ISO DIN 13

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

Nominal Diameter	Ø o / d	Art.-No.	€
M 3 x 0.5	20 x 5	57226	14,00
M 4 x 0.7	20 x 5	57230	14,00
M 5 x 0.8	20 x 7	57234	14,00
M 6 x 1.0	20 x 7	57238	14,00
M 8 x 1.25	25 x 9	57242	15,00
M 10 x 1.5	30 x 11	57246	16,50
M 12 x 1.75	38 x 14	57250	23,00
M 14 x 2.0	38 x 14	57254	25,00
M 16 x 2.0	45 x 18	57258	37,00
M 18 x 2.5	45 x 18	57262	37,00
M 20 x 2.5	45 x 18	57266	37,00
M 22 x 2.5	55 x 22	57270	58,00
M 24 x 3.0	55 x 22	57274	58,00
M 27 x 3.0	65 x 25	57276	77,00
M 30 x 3.5	65 x 25	57278	77,00

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

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

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

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

VÖLKEL THREADING SOLUTIONS

Round Dies MS
gun nosed, lapped
metric-fine ISO-thread DIN 13

Filiere tonde MS
con imbocco corretto, lappate
filettatura metrica fine ISO DIN 13

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

Nominal Diameter	Ø o / d	Art.-No.	€
Mf 4 x 0.5	20 x 5	56206	17,50
Mf 5 x 0.5	20 x 5	56208	17,50
Mf 6 x 0.5	20 x 5	56211	17,50
Mf 6 x 0.75	20 x 7	56212	17,50
Mf 7 x 0.75	25 x 9	56214	21,60
Mf 8 x 0.5	25 x 9	56215	21,60
Mf 8 x 0.75	25 x 9	56216	21,60
Mf 8 x 1.0	25 x 9	56217	21,60
Mf 9 x 0.5	25 x 9	56218	21,60
Mf 9 x 0.75	25 x 9	56219	21,60
Mf 9 x 1.0	25 x 9	56220	21,60
Mf 10 x 0.5	30 x 11	56221	23,00
Mf 10 x 0.75	30 x 11	56222	23,00
Mf 10 x 1.0	30 x 11	56223	23,00
Mf 10 x 1.25	30 x 11	56224	23,00
Mf 11 x 1.0	30 x 11	56225	23,00
Mf 11 x 1.25	30 x 11	56226	23,00
Mf 12 x 0.5	38 x 10	56227	30,60
Mf 12 x 0.75	38 x 10	56228	30,60
Mf 12 x 1.0	38 x 10	56229	30,60
Mf 12 x 1.25	38 x 10	56230	30,60
Mf 12 x 1.5	38 x 10	56231	30,60
Mf 14 x 0.5	38 x 10	56236	30,60
Mf 14 x 0.75	38 x 10	56237	30,60
Mf 14 x 1.0	38 x 10	56238	30,60
Mf 14 x 1.25	38 x 10	56239	30,60
Mf 14 x 1.5	38 x 10	56240	30,60
Mf 15 x 0.75	38 x 10	56241	30,60
Mf 15 x 1.0	38 x 10	56242	30,60
Mf 15 x 1.5	38 x 10	56243	30,60
Mf 16 x 0.5	45 x 14	56244	45,50
Mf 16 x 0.75	45 x 14	56245	45,50
Mf 16 x 1.0	45 x 14	56246	45,50
Mf 16 x 1.25	45 x 14	56247	45,50
Mf 16 x 1.5	45 x 14	56248	45,50
Mf 17 x 1.0	45 x 14	56249	45,50
Mf 17 x 1.5	45 x 14	56250	45,50
Mf 18 x 0.5	45 x 14	56251	45,50
Mf 18 x 0.75	45 x 14	56252	45,50
Mf 18 x 1.0	45 x 14	56253	45,50
Mf 18 x 1.25	45 x 14	56254	45,50
Mf 18 x 1.5	45 x 14	56255	45,50
Mf 18 x 2.0	45 x 14	56256	45,50
Mf 20 x 0.5	45 x 14	56259	45,50
Mf 20 x 0.75	45 x 14	56260	45,50
Mf 20 x 1.0	45 x 14	56261	45,50
Mf 20 x 1.25	45 x 14	56262	45,50
Mf 20 x 1.5	45 x 14	56263	45,50
Mf 20 x 2.0	45 x 14	56264	45,50
Mf 22 x 0.5	55 x 16	56267	71,00

Round Dies MS
gun nosed, lapped
metric-fine ISO-thread DIN 13

Filiere tonde MS
con imbocco corretto, lappate
filettatura metrica fine ISO DIN 13

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

Nominal Diameter	Ø o / d	Art.-No.	€
Mf 22 x 0.75	55 x 16	56268	71,00
Mf 22 x 1.0	55 x 16	56269	71,00
Mf 22 x 1.25	55 x 16	56270	71,00
Mf 22 x 1.5	55 x 16	56271	71,00
Mf 22 x 2.0	55 x 16	56272	71,00
Mf 24 x 0.5	55 x 16	56275	71,00
Mf 24 x 0.75	55 x 16	56276	71,00
Mf 24 x 1.0	55 x 16	56277	71,00
Mf 24 x 1.25	55 x 16	56278	71,00
Mf 24 x 1.5	55 x 16	56279	71,00
Mf 24 x 2.0	55 x 16	56280	71,00

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

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

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

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

VÖLKEL
THREADING SOLUTIONS

Round Dies MS
gun nosed, lapped
Pipe-thread DIN ISO 228

Filiere tonde MS
con imbocco corretto, lappate
filettarura per tubi gas DIN ISO 228

DIN 5158 (DIN EN 24231) HSS

G (BSP)

Nominal Diameter	Ø o / d	Art.-No.	€
G 1/8 x 28	30 x 11	55212	16,00
G 1/4 x 19	38 x 10	55214	22,00
G 3/8 x 19	45 x 14	55216	32,00
G 1/2 x 14	45 x 14	55218	32,00
G 3/4 x 14	55 x 16	55222	47,00
G 1" x 11	65 x 18	55226	62,00

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

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

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

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

Round Dies VS

Left Hand

metric ISO-thread DIN 13

Filiere tonde VS

filetto sinistro

filettatura metrica ISO DIN 13

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

M

Nominal Diameter mm	Ø o / d	Art.-No.	€
M 2 x 0.4	16 x 5	27216	18,00
M 3 x 0.5	20 x 5	27226	8,30
M 4 x 0.7	20 x 5	27230	8,30
M 5 x 0.8	20 x 7	27234	8,90
M 6 x 1.0	20 x 7	27238	8,90
M 8 x 1.25	25 x 9	27242	10,30
M 10 x 1.5	30 x 11	27246	13,50
M 12 x 1.75	38 x 14	27250	19,20
M 14 x 2.0	38 x 14	27254	22,00
M 16 x 2.0	45 x 18	27258	30,50
M 18 x 2.5	45 x 18	27262	30,50
M 20 x 2.5	45 x 18	27266	30,50
M 22 x 2.5	55 x 22	27270	46,00
M 24 x 3.0	55 x 22	27274	46,00
M 27 x 3.0	65 x 25	27276	83,00
M 30 x 3.5	65 x 25	27278	83,00
M 33 x 3.5	65 x 25	27280	83,00
M 36 x 4.0	65 x 25	27282	83,00
M 39 x 4.0	75 x 30	27284	140,00
M 42 x 4.5	75 x 30	27286	140,00
M 45 x 4.5	90 x 36	27288	220,00
M 48 x 5.0	90 x 36	27290	220,00
M 52 x 5.0	90 x 36	27292	220,00

Application:

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

Applicazione:

per uso universale
- Materiali con buona truciodibilità fino a R 800 N/mm²
- Acciaio non legati e scarsamente legati

VÖLKEL THREADING SOLUTIONS

Round Dies VS

Left Hand

metric ISO-thread DIN 13

Filiere tonde VS

filetto sinistro

filettatura metrica ISO DIN 13

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

Mf

Nominal Diameter mm	Ø o / d	Art.-No.	€
M 2.5 x 0.35	16 x 5	26801	14,00
M 3 x 0.35	20 x 5	26802	14,00
M 3.5 x 0.35	20 x 5	26803	14,00
M 4 x 0.35	20 x 5	26804	14,00
M 4 x 0.5	20 x 5	26805	14,00
M 4.5 x 0.5	20 x 5	26806	14,00
M 5 x 0.5	20 x 5	26807	14,00
M 5 x 0.75	20 x 7	26808	14,00
M 5.5 x 0.5	20 x 5	26809	14,00
M 6 x 0.5	20 x 5	26810	14,00
M 6 x 0.75	20 x 7	26207	14,00
M 7 x 0.5	25 x 9	26811	16,80
M 7 x 0.75	25 x 9	26812	16,80
M 8 x 0.5	25 x 9	26813	16,80
M 8 x 0.75	25 x 9	26210	16,80
M 8 x 1.0	25 x 9	26211	16,80
M 9 x 0.5	25 x 9	26814	16,80
M 9 x 0.75	25 x 9	26815	16,80
M 9 x 1.0	25 x 9	26816	16,80
M 10 x 0.5	30 x 11	26817	21,00
M 10 x 0.75	30 x 11	26818	21,00
M 10 x 1.0	30 x 11	26215	21,00
M 10 x 1.25	30 x 11	26216	21,00
M 11 x 1.0	30 x 11	26819	21,00
M 11 x 1.25	30 x 11	26820	21,00
M 12 x 0.5	38 x 10	26821	27,30
M 12 x 0.75	38 x 10	26822	27,30
M 12 x 1.0	38 x 10	26220	27,30
M 12 x 1.25	38 x 10	26221	27,30
M 12 x 1.5	38 x 10	26222	27,30
M 13 x 0.5	38 x 10	26823	27,30
M 13 x 0.75	38 x 10	26824	27,30
M 13 x 1.0	38 x 10	26825	27,30
M 13 x 1.5	38 x 10	26826	27,30
M 14 x 0.5	38 x 10	26827	27,30
M 14 x 0.75	38 x 10	26828	27,30
M 14 x 1.0	38 x 10	26829	27,30
M 14 x 1.25	38 x 10	26227	27,30
M 14 x 1.5	38 x 10	26228	27,30
M 15 x 0.75	38 x 10	26830	27,30
M 15 x 1.0	38 x 10	26831	27,30
M 15 x 1.5	38 x 10	26832	27,30
M 16 x 0.75	45 x 14	26833	41,00
M 16 x 1.0	45 x 14	26231	41,00
M 16 x 1.25	45 x 14	26834	41,00
M 16 x 1.5	45 x 14	26233	41,00

►►►

Application:
for general use
- non abrasive material up to 800 N/mm²
- unalloyed and low alloyed steel

Applicazione:
per uso universale
- Materiali con buona truciodibilità fino a R 800 N/mm²
- Acciaio non legati e scarsamente legati

Round Dies VS
Left Hand
metric ISO-thread DIN 13

Filiere tonde VS
filetto sinistro
filettatura metrica ISO DIN 13

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

Nominal Diameter	Ø o / d	Art.-No.	€
M 17 x 1.0	45 x 14	26835	41,00
M 17 x 1.5	45 x 14	26836	41,00
M 18 x 0.75	45 x 14	26837	41,00
M 18 x 1.0	45 x 14	26838	41,00
M 18 x 1.25	45 x 14	26839	41,00
M 18 x 1.5	45 x 14	26236	41,00
M 18 x 2.0	45 x 14	26840	41,00
M 19 x 1.0	45 x 14	26841	41,00
M 19 x 1.5	45 x 14	26842	41,00
M 20 x 0.5	45 x 14	26843	41,00
M 20 x 0.75	45 x 14	26844	41,00
M 20 x 1.0	45 x 14	26845	41,00
M 20 x 1.25	45 x 14	26846	41,00
M 20 x 1.5	45 x 14	26240	41,00
M 20 x 2.0	45 x 14	26847	41,00
M 21 x 1.0	45 x 14	26848	41,00
M 21 x 1.5	45 x 14	26849	41,00
M 22 x 1.0	55 x 16	26850	66,00
M 22 x 1.25	55 x 16	26851	66,00
M 22 x 1.5	55 x 16	26245	65,00
M 22 x 2.0	55 x 16	26852	66,00
M 24 x 1.25	55 x 16	26853	66,00
M 24 x 1.5	55 x 16	26250	65,00
M 24 x 2.0	55 x 16	26251	65,00
M 25 x 1.0	55 x 16	26854	66,00
M 25 x 1.5	55 x 16	26855	66,00
M 26 x 1.0	55 x 16	26856	66,00
M 26 x 1.5	55 x 16	26857	66,00
M 26 x 2.0	55 x 16	26858	66,00
M 27 x 1.0	65 x 18	26859	103,00
M 27 x 1.5	65 x 18	26860	103,00
M 27 x 2.0	65 x 18	26861	103,00
M 28 x 1.0	65 x 18	26862	103,00
M 28 x 1.5	65 x 18	26863	103,00
M 28 x 2.0	65 x 18	26864	103,00
M 29 x 1.5	65 x 18	26865	103,00
M 30 x 1.0	65 x 18	26866	103,00
M 30 x 1.5	65 x 18	26867	103,00
M 30 x 2.0	65 x 18	26264	103,00
M 30 x 2.5	65 x 18	26265	103,00
M 30 x 3.0	65 x 25	26266	103,00
M 32 x 1.0	65 x 18	26267	103,00
M 32 x 1.5	65 x 18	26268	103,00
M 32 x 2.0	65 x 18	26269	103,00
M 32 x 3.0	65 x 25	26270	103,00
M 33 x 1.5	65 x 18	26271	103,00

►►►

Application:
for general use
- non abrasive material up to 800 N/mm²
- unalloyed and low alloyed steel

Applicazione:
per uso universale
- Materiali con buona truciodibilità fino a R 800 N/mm²
- Acciaio non legati e scarsamente legati

VÖLKEL THREADING SOLUTIONS

Round Dies VS

Left Hand

metric ISO-thread DIN 13

Filiere tonde VS

filetto sinistro

filettatura metrica ISO DIN 13

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

Mf

Nominal Diameter	Ø o / d	Art.-No.	€
M 33 x 2.0	65 x 18	26272	103,00
M 33 x 3.0	65 x 25	26273	103,00
M 34 x 1.0	65 x 18	26274	103,00
M 34 x 1.5	65 x 18	26275	103,00
M 34 x 2.0	65 x 18	26276	103,00
M 35 x 1.0	65 x 18	26277	103,00
M 35 x 1.5	65 x 18	26278	103,00
M 35 x 2.0	65 x 18	26279	103,00
M 36 x 1.0	65 x 18	26280	103,00
M 36 x 1.5	65 x 18	26281	103,00
M 36 x 2.0	65 x 18	26282	103,00
M 36 x 3.0	65 x 25	26283	103,00
M 37 x 1.5	65 x 18	26284	103,00
M 38 x 1.0	75 x 20	26285	157,00
M 38 x 1.5	75 x 20	26286	157,00
M 38 x 2.0	75 x 20	26287	157,00
M 38 x 3.0	75 x 30	26288	157,00
M 39 x 1.5	75 x 20	26289	157,00
M 39 x 2.0	75 x 20	26290	157,00
M 39 x 3.0	75 x 30	26291	157,00
M 40 x 1.0	75 x 20	26292	157,00
M 40 x 1.5	75 x 20	26293	157,00
M 40 x 2.0	75 x 20	26294	157,00
M 40 x 3.0	75 x 30	26295	157,00
M 42 x 1.0	75 x 20	26296	157,00
M 42 x 1.5	75 x 20	26297	157,00
M 42 x 2.0	75 x 20	26298	157,00
M 42 x 3.0	75 x 30	26299	157,00
M 44 x 1.5	90 x 22	26868	281,00
M 45 x 1.5	90 x 22	26869	281,00
M 45 x 2.0	90 x 22	26870	281,00
M 45 x 3.0	90 x 36	26871	281,00
M 46 x 1.5	90 x 22	26872	281,00
M 48 x 1.5	90 x 22	26873	281,00
M 48 x 2.0	90 x 22	26874	281,00
M 48 x 3.0	90 x 36	26875	281,00
M 50 x 1.5	90 x 22	26876	281,00
M 50 x 2.0	90 x 22	26877	281,00
M 50 x 3.0	90 x 36	26878	281,00
M 52 x 1.5	90 x 22	26879	281,00
M 52 x 2.0	90 x 22	26880	281,00
M 52 x 3.0	90 x 36	26881	281,00

Application:
for general use
- non abrasive material up to 800 N/mm²
- unalloyed and low alloyed steel

Applicazione:
per uso universale
- Materiali con buona truciodibilità fino a R 800 N/mm²
- Acciaio non legati e scarsamente legati

Round Dies VS

Left Hand

Whitworth-thread BS 84

Filiere tonde VS

filetto sinistro

filettatura Whitworth BS 84

DIN 223 (DIN EN 22568) HSS Tol. med BSW

Nominal Diameter	Ø o / d	Art.-No.	€
BSW 1/8 x 40	20 x 5	22206	16,20
BSW 5/32 x 32	20 x 5	22208	16,20
BSW 3/16 x 24	20 x 7	22210	16,20
BSW 1/4 x 20	20 x 7	22214	16,20
BSW 5/16 x 18	25 x 9	22216	18,90
BSW 3/8 x 16	30 x 11	22218	23,00
BSW 7/16 x 14	30 x 11	22220	23,00
BSW 1/2 x 12	38 x 14	22222	36,00
BSW 9/16 x 12	38 x 14	22224	36,00
BSW 5/8 x 11	45 x 18	22226	46,00
BSW 3/4 x 10	45 x 18	22230	46,00
BSW 7/8 x 9	55 x 22	22234	67,00
BSW 1" x 8	55 x 22	22238	67,00

Application:
for general use
- non abrasive material up to 800 N/mm²
- unalloyed and low alloyed steel

Applicazione:
per uso universale
- Materiali con buona truciodibilità fino a R 800 N/mm²
- Acciaio non legati e scarsamente legati

VÖLKEL THREADING SOLUTIONS

Round Dies VS

Left Hand

Unified thread ANSI B 1.1

Filiere tonde VS

filetto sinistro

filettatura unificata ANSI B1.1

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

Nominal Diameter mm	Width across flats mm	Art.-No.	€
UNC			
UNC Nr. 6 x 32	20 x 7	23206	20,00
UNC Nr. 8 x 32	20 x 7	23208	20,00
UNC Nr.10 x 24	20 x 7	23210	20,00
UNC 1/4 x 20	20 x 7	23214	16,20
UNC 5/16 x 18	25 x 9	23216	18,90
UNC 3/8 x 16	30 x 11	23218	23,00
UNC 7/16 x 14	38 x 14	23220	23,00
UNC 1/2 x 13	38 x 14	23222	36,00
UNC 9/16 x 12	38 x 14	23224	36,00
UNC 5/8 x 11	45 x 18	23226	46,00
UNC 3/4 x 10	45 x 18	23230	46,00
UNC 7/8 x 9	55 x 22	23234	67,00
UNC 1" x 8	55 x 22	23238	67,00
UNF			
UNF Nr. 10 x 32	20 x 7	24210	20,00
UNF 1/4 x 28	20 x 7	24214	16,20
UNF 5/16 x 24	25 x 9	24216	18,90
UNF 3/8 x 24	30 x 11	24218	23,00
UNF 7/16 x 20	30 x 11	24220	23,00
UNF 1/2 x 20	38 x 10	24222	36,00
UNF 9/16 x 18	38 x 10	24224	36,00
UNF 5/8 x 18	45 x 14	24226	46,00
UNF 3/4 x 16	45 x 14	24230	46,00
UNF 7/8 x 14	55 x 16	24234	67,00
UNF 1" x 12	55 x 16	24238	67,00

Application:

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

Applicazione:

per uso universale
- Materiali con buona truciodibilità fino a R 800 N/mm²
- Acciaio non legati e scarsamente legati

Round Dies VS
Left Hand
Pipe-thread DIN ISO 228

Filiere tonde VS
filetto sinistro
filettatura per tubi gas DIN ISO 228

DIN 5158 (DIN EN 24231) HSS Tol. A G (BSP)

Nominal Diameter	Width across flats mm	Art.-No.	€
G 1/8 x 28	30 x 11	25212	28,00
G 1/4 x 19	38 x 10	25214	32,00
G 3/8 x 19	45 x 14	25216	47,00
G 1/2 x 14	45 x 14	25218	47,00
G 5/8 x 14	55 x 16	25220	63,50
G 3/4 x 14	55 x 16	25222	79,00
G 7/8 x 14	65 x 18	25224	87,00
G 1" x 11	65 x 18	25226	87,00
G 1.1/8 x 11	75 x 20	25230	110,00
G 1.1/4 x 11	75 x 20	25234	110,00
G 1.3/8 x 11	90 x 22	25238	182,00
G 1.1/2 x 11	90 x 22	25242	182,00
G 1.5/8 x 11	90 x 22	25246	182,00
G 1.3/4 x 11	105 x 22	25250	312,00
G 2" x 11	105 x 22	25254	312,00

Application:

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

Applicazione:

per uso universale
- Materiali con buona truciodibilità fino a R 800 N/mm²
- Acciaio non legati e scarsamente legati

Hexagon Die Nuts VS
metric ISO-thread DIN 13

Filiere esagonali VS
filettatura metrica ISO DIN 13

DIN 382 HSS Tol. 6g

M

Nominal Diameter mm	Width across flats mm	Art.-No.	€
M 3 x 0.5	19 x 5	27126	10,00
M 3.5 x 0.6	19 x 5	27128	10,00
M 4 x 0.7	19 x 5	27130	10,00
M 5 x 0.8	19 x 7	27134	10,00
M 6 x 1.0	19 x 7	27138	10,00
M 7 x 1.0	22 x 9	27140	11,00
M 8 x 1.25	22 x 9	27142	11,00
M 9 x 1.25	22 x 9	27144	11,00
M 10 x 1.5	27 x 11	27146	13,00
M 11 x 1.5	27 x 11	27148	13,00
M 12 x 1.75	36 x 14	27150	18,00
M 14 x 2.0	36 x 14	27154	18,00
M 16 x 2.0	41 x 18	27158	25,50
M 18 x 2.5	41 x 18	27162	25,50
M 20 x 2.5	41 x 18	27166	25,50
M 22 x 2.5	50 x 22	27170	43,00
M 24 x 3.0	50 x 22	27174	52,00
M 27 x 3.0	60 x 25	27176	79,00
M 30 x 3.5	60 x 25	27178	79,00
M 33 x 3.5	60 x 25	27180	79,00
M 36 x 4.0	60 x 25	27182	79,00
M 39 x 4.0	70 x 30	27184	131,00
M 42 x 4.5	70 x 30	27186	131,00
M 45 x 4.5	85 x 36	27188	181,00
M 48 x 5.0	85 x 36	27190	181,00
M 52 x 5.0	85 x 36	27192	181,00
M 56 x 5.5	100 x 36	27194	320,00
M 60 x 5.5	100 x 36	27196	320,00
M 64 x 6.0	100 x 36	27198	320,00
M 68 x 6.0	115 x 36	27199	415,00

Application:

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

Applicazione:

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

Hexagon Die Nuts VS
metric-fine ISO-thread DIN 13

Filiere esagonali VS
filettatura metrica fine ISO DIN 13

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

Nominal Diameter mm	Width across flats mm	Art.-No.	€
M 3 x 0.35	19 x 5	26108	19,50
M 4 x 0.35	19 x 5	26110	19,50
M 4 x 0.5	19 x 5	26112	19,50
M 5 x 0.5	19 x 5	26114	19,50
M 5 x 0.75	19 x 7	26116	19,50
M 6 x 0.5	19 x 5	26117	19,50
M 6 x 0.75	19 x 7	26118	19,50
M 7 x 0.75	22 x 9	26120	21,00
M 8 x 0.5	22 x 9	26122	21,00
M 8 x 0.75	22 x 9	26124	21,00
M 8 x 1.0	22 x 9	26126	21,00
M 9 x 0.75	22 x 9	26128	21,00
M 9 x 1.0	22 x 9	26130	21,00
M 10 x 0.75	27 x 11	26132	21,00
M 10 x 1.0	27 x 11	26136	21,00
M 10 x 1.25	27 x 11	26138	21,00
M 11 x 1.0	27 x 11	26140	29,40
M 11 x 1.25	27 x 11	26142	29,40
M 12 x 0.75	36 x 10	26143	29,40
M 12 x 1.0	36 x 10	26144	29,40
M 12 x 1.25	36 x 10	26146	29,40
M 12 x 1.5	36 x 10	26148	29,40
M 13 x 1.0	36 x 10	26150	33,50
M 13 x 1.5	36 x 10	26151	33,50
M 14 x 0.75	36 x 10	26152	33,50
M 14 x 1.0	36 x 10	26153	33,50
M 14 x 1.25	36 x 10	26154	33,50
M 14 x 1.5	36 x 10	26156	33,50
M 15 x 1.0	36 x 10	26158	39,00
M 15 x 1.5	36 x 10	26160	39,00
M 16 x 1.0	41 x 14	26162	41,00
M 16 x 1.25	41 x 14	26164	41,00
M 16 x 1.5	41 x 14	26166	41,00
M 18 x 1.0	41 x 14	26170	43,00
M 18 x 1.25	41 x 14	26171	43,00
M 18 x 1.5	41 x 14	26172	43,00
M 18 x 2.0	41 x 14	26174	43,00
M 20 x 1.0	41 x 14	26178	43,00
M 20 x 1.25	41 x 14	26180	43,00
M 20 x 1.5	41 x 14	26184	43,00
M 20 x 2.0	41 x 14	26186	43,00
M 21 x 1.5	41 x 14	26188	63,00
M 22 x 1.0	50 x 16	26190	63,00
M 22 x 1.25	50 x 16	26192	63,00
M 22 x 1.5	50 x 16	26194	63,00
M 22 x 2.0	50 x 16	26196	63,00
M 23 x 1.5	50 x 16	26198	63,00
M 24 x 1.0	50 x 16	26700	63,00
M 24 x 1.25	50 x 16	26702	63,00
M 24 x 1.5	50 x 16	26704	63,00

Hexagon Die Nuts VS
metric-fine ISO-thread DIN 13

Filiere esagonali VS
filettatura metrica fine ISO DIN 13

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

Nominal Diameter mm	Width across flats mm	Art.-No.	€
M 24 x 2.0	50 x 16	26706	63,00
M 25 x 1.0	50 x 16	26707	91,00
M 25 x 1.5	50 x 16	26708	91,00
M 26 x 1.0	50 x 16	26710	91,00
M 26 x 1.5	50 x 16	26712	91,00
M 26 x 2.0	50 x 16	26714	91,00
M 27 x 1.0	60 x 18	26717	95,00
M 27 x 1.5	60 x 18	26716	95,00
M 27 x 2.0	60 x 18	26718	95,00
M 28 x 1.0	60 x 18	26720	95,00
M 28 x 1.5	60 x 18	26722	95,00
M 28 x 2.0	60 x 18	26724	95,00
M 29 x 1.5	60 x 18	26726	95,00
M 30 x 1.0	60 x 18	26728	95,00
M 30 x 1.5	60 x 18	26730	95,00
M 30 x 2.0	60 x 18	26732	95,00
M 30 x 3.0	60 x 25	26734	95,00
M 32 x 1.5	60 x 18	26736	95,00
M 32 x 2.0	60 x 18	26735	95,00
M 32 x 3.0	60 x 25	26737	95,00
M 33 x 1.5	60 x 18	26738	95,00
M 33 x 2.0	60 x 18	26740	95,00
M 33 x 3.0	60 x 25	26742	95,00
M 34 x 1.5	60 x 18	26744	95,00
M 34 x 2.0	60 x 18	26746	95,00
M 35 x 1.5	60 x 18	26748	95,00
M 36 x 1.5	60 x 18	26750	95,00
M 36 x 2.0	60 x 18	26752	95,00
M 36 x 3.0	60 x 25	26754	95,00
M 38 x 1.5	70 x 20	26756	158,00
M 39 x 1.5	70 x 20	26758	158,00
M 39 x 2.0	70 x 20	26760	158,00
M 39 x 3.0	70 x 30	26762	158,00
M 40 x 1.5	70 x 20	26764	158,00
M 40 x 2.0	70 x 20	26766	158,00
M 40 x 3.0	70 x 30	26768	158,00
M 42 x 1.5	70 x 20	26770	158,00
M 42 x 2.0	70 x 20	26772	158,00
M 42 x 3.0	70 x 30	26774	158,00
M 45 x 1.5	85 x 22	26776	233,00
M 45 x 2.0	85 x 22	26778	233,00
M 45 x 3.0	85 x 36	26780	233,00
M 48 x 1.5	85 x 22	26782	233,00
M 48 x 2.0	85 x 22	26784	233,00
M 48 x 3.0	85 x 36	26786	233,00
M 50 x 1.5	85 x 22	26788	233,00
M 50 x 2.0	85 x 22	26790	233,00
M 50 x 3.0	85 x 36	26792	233,00
M 52 x 1.5	85 x 22	26794	233,00
M 52 x 2.0	85 x 22	26796	233,00
M 52 x 3.0	85 x 36	26798	233,00

Hexagon Die Nuts VS
Whitworth-thread BS 84

Filiere esagonali VS
filettatura Whitworth BS 84

DIN 382 **HSS** **Tol. med.** **BSW / BSF**

Nominal Diameter mm	Width across flats mm	Art.-No.	€
BSW			
BSW 1/8 x 40	19 x 5	22106	13,00
BSW 3/16 x 24	19 x 7	22110	13,00
BSW 1/4 x 20	19 x 7	22114	13,00
BSW 5/16 x 18	22 x 9	22116	13,50
BSW 3/8 x 16	27 x 11	22118	16,30
BSW 7/16 x 14	27 x 11	22120	16,30
BSW 1/2 x 12	36 x 14	22122	20,00
BSW 9/16 x 12	36 x 14	22124	20,00
BSW 5/8 x 11	41 x 18	22126	27,30
BSW 3/4 x 10	41 x 18	22130	27,30
BSW 7/8 x 9	50 x 22	22134	56,70
BSW 1" x 8	50 x 22	22138	56,70
BSW 1.1/8 x 7	60 x 25	22142	86,00
BSW 1.1/4 x 7	60 x 25	22146	86,00
BSW 1.3/8 x 6	60 x 25	22150	86,00
BSW 1.1/2 x 6	70 x 30	22154	103,00
BSW 2" x 4.1/2	85 x 36	22170	135,00
BSW 2.1/4 x 4	100 x 36	22172	475,00
BSW 2.1/2 x 4	115 x 36	22174	475,00
BSW 2.3/4 x 3.1/2	115 x 36	22176	588,00
BSW 3" x 3.1/2	115 x 36	22178	588,00
BSF			
BSF 3/16 x 32	19 x 7	22510	14,70
BSF 1/4 x 26	19 x 7	22514	14,70
BSF 5/16 x 22	22 x 9	22516	16,30
BSF 3/8 x 20	27 x 11	22518	20,00
BSF 7/16 x 18	27 x 11	22520	20,00
BSF 1/2 x 16	36 x 10	22522	31,50
BSF 9/16 x 16	36 x 10	22524	31,50
BSF 5/8 x 14	41 x 14	22526	48,30
BSF 3/4 x 12	41 x 14	22530	48,30
BSF 7/8 x 11	50 x 16	22534	57,00
BSF 1" x 10	50 x 16	22538	57,00

Application:

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

Applicazione:

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

VÖLKEL THREADING SOLUTIONS

Hexagon Die Nuts VS
Whitworth-thread BS 84

Filiere esagonali VS
filettatura unificata ANSI B1.1

DIN 382 **HSS** **Tol. 2A** **UNC / UNF**

Nominal Diameter	Width across flats mm	Art.-No.	€
UNC			
UNC 1/4 x 20	19 x 7	23114	13,00
UNC 5/16 x 18	22 x 9	23116	13,50
UNC 3/8 x 16	27 x 11	23118	16,30
UNC 7/16 x 14	27 x 11	23120	16,30
UNC 1/2 x 13	36 x 14	23122	20,00
UNC 9/16 x 12	36 x 14	23124	20,00
UNC 5/8 x 11	41 x 18	23126	27,30
UNC 3/4 x 10	41 x 18	23130	27,30
UNC 7/8 x 9	50 x 22	23134	56,70
UNC 1" x 8	50 x 22	23138	56,70
UNC 1.1/8 x 7	60 x 25	23142	86,00
UNC 1.1/4 x 7	60 x 25	23146	86,00
UNC 1.3/8 x 6	60 x 25	23150	86,00
UNC 1.1/2 x 6	70 x 30	23154	103,00
UNF			
UNF 1/4 x 28	19 x 7	24114	13,00
UNF 5/16 x 24	22 x 9	24116	13,50
UNF 3/8 x 24	27 x 11	24118	16,30
UNF 7/16 x 20	27 x 11	24120	16,30
UNF 1/2 x 20	36 x 10	24122	20,00
UNF 9/16 x 18	36 x 10	24124	20,00
UNF 5/8 x 18	41 x 14	24126	27,30
UNF 3/4 x 16	41 x 14	24130	27,30
UNF 7/8 x 14	50 x 16	24134	56,70
UNF 1" x 12	50 x 16	24138	56,70
UNF 1.1/8 x 12	60 x 18	24142	86,00
UNF 1.1/4 x 12	60 x 18	24146	86,00
UNF 1.3/8 x 12	60 x 18	24150	86,00
UNF 1.1/2 x 12	70 x 20	24154	103,00

Application:

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

Applicazione:

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

Hexagon Die Nuts VS
Unified thread ANSI B 1.1

Filiere esagonali VS
filettatura unificata ANSI B1.1

DIN 382 HSS Tol. 2A 8-UN

Nominal Diameter	Width across flats mm	Art.-No.	€
UN 1.1/8 x 8	60 x 25	24171	86,00
UN 1.1/4 x 8	60 x 25	24172	86,00
UN 1.3/8 x 8	60 x 25	24173	86,00
UN 1.1/2 x 8	70 x 30	24174	157,00
UN 1.5/8 x 8	70 x 30	24175	157,00
UN 1.3/4 x 8	85 x 36	24176	157,00
UN 1.7/8 x 8	85 x 22	24177	157,00
UN 2" x 8	85 x 22	24178	157,00
UN 2.1/8 x 8	85 x 22	24179	267,00
UN 2.1/4 x 8	100 x 22	24180	267,00
UN 2.1/2 x 8	115 x 22	24181	400,00

Application:

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

Applicazione:

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

Hexagon Die Nuts VS
Pipe-thread DIN ISO 228

Filiere esagonali VS
filettatura per tubi gas DIN ISO 228

DIN 382 HSS Tol. A G (BSP)

Nominal Diameter	Width across flats mm	Art.-No.	€
G 1/8 x 28	27 x 11	25512	18,00
G 1/4 x 19	36 x 10	25514	21,50
G 3/8 x 19	41 x 14	25516	32,00
G 1/2 x 14	41 x 14	25518	32,00
G 5/8 x 14	50 x 16	25520	53,50
G 3/4 x 14	50 x 16	25522	53,50
G 7/8 x 14	60 x 18	25524	72,50
G 1" x 11	60 x 18	25526	72,50
G 1.1/8 x 11	70 x 20	25530	107,00
G 1.1/4 x 11	70 x 20	25534	107,00
G 1.3/8 x 11	85 x 22	25538	178,00
G 1.1/2 x 11	85 x 22	25542	178,00
G 1.5/8 x 11	85 x 22	25546	178,00
G 1.3/4 x 11	100 x 22	25550	267,00
G 2" x 11	100 x 22	25554	267,00

Application:

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

Applicazione:

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

Hexagon Die Nuts VS
tapered pipe thread, taper 1:16, con. 55°

Filiere esagonali VS
rfilettatura conica per tubi, cono 1:16

DIN 382 **HSS**

R (BSPT)

Nominal Diameter	Width across flats mm	Art.-No.	€
R 1/8 x 28	27 x 11	23562	39,00
R 1/4 x 19	36 x 14	23564	48,00
R 3/8 x 19	41 x 15	23566	60,00
R 1/2 x 14	50 x 19	23568	60,00
R 3/4 x 14	60 x 20	23572	95,00
R 1" x 11	60 x 25	23576	140,00
R 1.1/4 x 11	85 x 26	23578	167,00
R 1.1/2 x 11	85 x 26	23580	270,00
R 2" x 11	100 x 31	23584	365,00

Application:

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

Applicazione:

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

Hexagon Die Nuts VS
american tapered pipe thread, taper 1:16

Filiere esagonali VS
filettatura americana conica per tubi, cono 1:16

DIN 382 HSS NPT

Nominal Diameter	Width across flats mm	Art.-No.	€
NPT 1/16 x 27	22 x 9	23510	36,00
NPT 1/8 x 27	27 x 11	23512	39,00
NPT 1/4 x 18	36 x 14	23514	48,00
NPT 3/8 x 18	41 x 14	23516	60,00
NPT 1/2 x 14	50 x 16	23518	60,00
NPT 3/4 x 14	60 x 18	23522	95,00
NPT 1" x 11.5	60 x 25	23526	140,00
NPT 1.1/4 x 11.5	70 x 25	23528	167,00
NPT 1.1/2 x 11.5	85 x 28	23530	270,00
NPT 2" x 11.5	100 x 28	23534	365,00

Application:

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

Applicazione:

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

Hexagon Die Nuts VS

Left Hand

metric ISO-thread DIN 13

Filiere esagonali VS

filetto sinistro

filettatura metrica ISO DIN 13

DIN 382 HSS Tol. 6g

M

Nominal Diameter	Width across flats mm	Art.-No.	€
M 3 x 0.5	19 x 5	28426	12,00
M 4 x 0.7	19 x 5	28430	12,00
M 5 x 0.8	19 x 7	28434	13,00
M 6 x 1.0	19 x 7	28438	13,00
M 8 x 1.25	22 x 9	28442	14,50
M 10 x 1.5	27 x 11	28446	20,50
M 12 x 1.75	36 x 14	28450	31,50
M 14 x 2.0	36 x 14	28454	31,50
M 16 x 2.0	41 x 18	28458	49,00
M 18 x 2.5	41 x 18	28462	49,00
M 20 x 2.5	41 x 18	28466	49,00
M 22 x 2.5	50 x 22	28470	66,50
M 24 x 3.0	50 x 22	28474	66,50
M 27 x 3.0	60 x 25	28476	102,00
M 30 x 3.5	60 x 25	28478	102,00
M 33 x 3.5	60 x 25	28480	102,00
M 36 x 4.0	60 x 25	28482	102,00
M 39 x 4.0	70 x 30	28484	170,00
M 42 x 4.5	70 x 30	28486	170,00
M 45 x 4.5	85 x 36	28488	241,00
M 48 x 5.0	85 x 36	28490	241,00
M 52 x 5.0	85 x 36	28492	241,00

Application:

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

Applicazione:

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

Hexagon Die Nuts VS

Left Hand

Pipe-thread DIN ISO 228

Filiere esagonali VS

filetto sinistro

filettatura per tubi gas DIN ISO 228

DIN 382 **HSS** **Tol. A** **G (BSP)**

Nominal Diameter	Width across flats mm	Art.-No.	€
G 1/8 x 28	27 x 11	25612	31,00
G 1/4 x 19	36 x 10	25614	35,00
G 3/8 x 19	41 x 14	25616	52,50
G 1/2 x 14	41 x 14	25618	52,50
G 5/8 x 14	50 x 16	25620	70,00
G 3/4 x 14	50 x 16	25622	70,00
G 1" x 11	60 x 18	25626	90,00
G 1.1/8 x 11	70 x 20	25630	140,00
G 1.1/4 x 11	70 x 20	25634	140,00
G 1.3/8 x 11	85 x 22	25638	231,00
G 1.1/2 x 11	85 x 22	25642	231,00
G 1.3/4 x 11	100 x 22	25650	347,00
G 2" x 11	100 x 22	25654	347,00

Application:

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

Applicazione:

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

SETS
ASSORTIMENTO

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HexTap Sets
in wooden boxes

Assortimento HexTap
in cassetta di legna

	Art.-No	€
M		
M 3-4-5-6-8-10-12-14-16-18-20	48601	160,00
M 3-4-5-6-8-10-12-14-16-18-20-22-24	48602	240,00
M 3-4-5-6-8-10-12-14-16-18-20-22-24-27-30	48603	360,00
Mf		
M 4x0.5 - 5x0.5 - 6x0.75 - 8x0.75 - 8x1 - 10x1 M 12x1 - 12x1.5 - 14x1.25 - 14x1.5 - 16x1.5 M 18x1.5 - M 20x1.5	48605	210,00
M 4x0.5 - 5x0.5 - 6x0.75 - 8x0.75 - 8x1 - 10x1 M 12x1 - 12x1.5 - 14x1.25 - 14x1.5 - 16x1.5 M 18x1.5 - M 20x1.5 - 22x1.5 - 24x1. 5	48606	305,00
G (BSP)		
G 1/8 - 1/4 - 3/8 - 1/2 - 3/4 - 1"	48608	195,00
G 1/8 - 1/4 - 3/8 - 1/2 - 3/4 - 1" - 1.1/4 - 1.1/2	48609	450,00

HexTap Sets
in wooden boxes

Assortimento HexTap
in cassetta di legna

	Art.-No	€
M		
M 3-4-5-6-8-10-12-14-16-18-20	48621	292,00
M 3-4-5-6-8-10-12-14-16-18-20-22-24	48622	425,00
M 3-4-5-6-8-10-12-14-16-18-20-22-24-27-30	48623	665,00
Mf		
M 4x0.5 - 5x0.5 - 6x0.75 - 8x0.75 - 8x1 - 10x1 M 12x1 - 12x1.5 - 14x1.25 - 14x1.5 - 16x1.5 M 18x1.5 - M 20x1.5	48625	410,00
M 4x0.5 - 5x0.5 - 6x0.75 - 8x0.75 - 8x1 - 10x1 M 12x1 - 12x1.5 - 14x1.25 - 14x1.5 - 16x1.5 M 18x1.5 - M 20x1.5 - 22x1.5 - 24x1.5	48626	560,00
G (BSP)		
G 1/8 - 1/4 - 3/8 - 1/2 - 3/4 - 1"	48628	365,00
G 1/8 - 1/4 - 3/8 - 1/2 - 3/4 - 1" - 1.1/4 - 1.1/2	48629	840,00

HexTap Sets
in wooden boxes

Assortimento HexTap
in cassetta di legna

	Art.-No	€
M		
M 3-4-5-6-8-10-12-14-16-18-20	48641	328,00
M 3-4-5-6-8-10-12-14-16-18-20-22-24	48642	480,00
M 3-4-5-6-8-10-12-14-16-18-20-22-24-27-30	48643	730,00
Mf		
M 4x0.5 - 5x0.5 - 6x0.75 - 8x0.75 - 8x1 - 10x1 M 12x1 - 12x1.5 - 14x1.25 - 14x1.5 - 16x1.5 M 18x1.5 - M 20x1.5	48645	440,00
M 4x0.5 - 5x0.5 - 6x0.75 - 8x0.75 - 8x1 - 10x1 M 12x1 - 12x1.5 - 14x1.25 - 14x1.5 - 16x1.5 M 18x1.5 - M 20x1.5 - 22x1.5 - 24x1.5	48646	625,00
G (BSP)		
G 1/8 - 1/4 - 3/8 - 1/2 - 3/4 - 1"	48648	400,00
G 1/8 - 1/4 - 3/8 - 1/2 - 3/4 - 1" - 1.1/4 - 1.1/2	48649	903,00

Tap & Die Sets
in metal cases
DIN standards

Utensili per filettare in assortimento
in cassetta metallica
versione DIN

						Art.-No	€
M							
M 1-1.2-1.4-1.7-2.0-2.3-2.6 M 3-3.5-4-5-6-8-10	No. 0 No. 1	16 x 5 25 x 9	20 x 5 30 x 11	20 x 7	No. 1	48002	360,00
M 3-4-5-6-7-8-9-10-11-12	No. 1 + 2	20 x 5 30 x 11	20 x 7 38 x 14	25 x 9	No. 1	48003	350,00
M 5-6-7-8-9-10-11-12	No. 1 + 2	20 x 7 30 x 11	25 x 9 38 x 14		No. 1	48004	320,00
M 5-6-7-8-9-10-11-12-14-16 M 18-20	No. 1 + 3	20 x 7 38 x 14	25 x 9 45 x 18	30 x 11		48005	540,00
M 3-4-5-6-8-10-12-14-16-18-20 M 22-24	No. 1 + 4	20 x 5 30 x 11 55 x 22	20 x 7 38 x 14	25 x 9 45 x 18		48006	690,00
M 5-6-8-10-12-14-16-18-20-22 M 24-27-30	No. 1 No. 3 + 5	20 x 7 38 x 14 65 x 25	25 x 9 45 x 18	30 x 11 55 x 22		48007	1.208,00
Mf							
Mf 3 x 0.35-4 x 0.5-5 x 0.5 Mf 6 x 0.75-8 x 0.75-8 x 1.0 Mf 10 x 1.0-12 x 1.5	No. 1 + 2	20 x 5 38 x 10	25 x 9	30 x 11	No. 1	48010	260,00
Mf 6 x 0.75-8 x 0.75-8 x 1.0-10 x 1.0 Mf 12 x 1.0-12 x 1.5-14 x 1.25-14 x 1.5 Mf 16 x 1.5-18 x 1.5-20 x 1.5	No. 1 + 3	20 x 7 38 x 10	25 x 9 45 x14	30 x 11		48011	465,00
Mf 6 x 0.75-8 x 0.75-8 x 1.0-10 x 1.0 Mf 12 x 1.0-12 x 1.5-14 x 1.25-14 x 1.5 Mf 16 x 1.5-18 x 1.5-20 x 1.5-22 x 1.5 Mf 24 x 1.5	No. 1 + 4	20 x 7 38 x 10	25 x 9 45 x 14	30 x 11 55 x 16		48012	680,00

VÖLKEL
THREADING SOLUTIONS

Tap & Die Sets
in metal cases
DIN standards

Utensili per filettare in assortimento
in cassetta metallica
versione DIN

						Art.-No	€
G (BSP)							
G 1/8-1/4-3/8-1/2-3/4-1"	No. 1 + 3 + 5	30 x 11 55 x 16	38 x 10 65 x 18	45 x 14		48020	570,00
G 1/8-1/4-3/8-1/2-5/8-3/4-7/8-1"	No. 1 + 3 + 5	30 x 11 55 x 16	38 x 10 65 x 18	45 x 14		48021	760,00
G 1/4-3/8-1/2-3/4-1"-1.1/4-1.1/2	No. 2 + 4 + 7	38 x 10 65 x 18	45 x 14 75 x 20	55 x 16 90 x 22		48022	1.600,00
BSW							
BSW 1/8-3/16-1/4-5/16-3/8-7/16-1/2	No. 1 + 2	20 x 5 30 x 11	20 x 7 38 x 14	25 x 9	No. 1	48030	290,00
BSW 1/4-5/16-3/8-7/16-1/2	No. 1 + 2	20 x 7 38 x 14	25 x 9	30 x 11	No. 1	48031	248,00
BSW 1/4-5/16-3/8-7/16-1/2-5/8-3/4	No. 1 + 3	20 x 7 38 x 14	25 x 9 45 x 18	30 x 11		48032	436,00
BSW 1/4-5/16-3/8-7/16-1/2-5/8 BSW 3/4-7/8-1"	No. 1 + 4	20 x 7 38 x 14	25 x 9 45 x 18	30 x 11 55 x 22		48034	652,00
BSW 1/4-5/16-3/8-7/16-1/2-5/8-3/4 BSW 7/8-1"-1.1/8-1.1/4-1.3/8-1.1/2"	No. 1 No. 3 + 5	20 x 7 38 x 14 65 x 25	25 x 9 45 x 18	30 x 11 55 x 22		48035	1.650,00
BSF							
BSF 1/4-5/16-3/8-7/16-1/2	No. 1 + 2	20 x 7 38 x 10	25 x 9	30 x 11	No. 1	48041	240,00
BSF 1/4-5/16-3/8-7/16-1/2-5/8-3/4	No. 1 + 3	20 x 7 38 x 10	25 x 9 45 x 14	30 x 11		48042	410,00
BSF 1/4-5/16-3/8-7/16-1/2-5/8 BSF 3/4-7/8-1"	No. 1 + 4	20 x 7 38 x 10	25 x 9 45 x 14	30 x 11 55 x 16		48044	630,00
BSW / BSF							
BSW/BSF 1/4-5/16-3/8-7/16-1/2 BSW/BSF 5/8-3/4	No. 1 + 3	20 x 7 38 x 14	25 x 9 45 x 18	30 x 11		48046	698,00

Tap & Die Sets
in metal cases
DIN standards

Utensili per filettare in assortimento
in cassetta metallica
versione DIN

						Art.-No	€
NPT							
NPT 1/8-1/4-3/8-1/2-3/4-1"	No. 1 + 3 + 5	30 x 11 55 x 22	38 x 14 65 x 25	45 x 18		48025	740,00
NPT 1/8-1/4-3/8-1/2-3/4-1" NPT 1.1/4-1.1/2-2"	No. 2 + 4 + 7	30 x 11 55 x 22 90 x 36	38 x 14 65 x 25 105 x 36	45 x 18 75 x 30		48027	2.750,00
UNC							
UNC 1/4-5/16-3/8-7/16-1/2	No. 1 + 2	20 x 7 38 x 14	25 x 9	30 x 11	No. 1	48050	248,00
UNC 1/4-5/16-3/8-7/16-1/2-5/8-3/4	No. 1 + 3	20 x 7 38 x 14	25 x 9 45 x 18	30 x 11		48051	436,00
UNC 1/4-5/16-3/8-7/16-1/2-5/8 UNC 3/4-7/8-1"	No. 1 + 4	20 x 7 38 x 14	25 x 9 45 x 18	30 x 11 55 x 22		48053	652,00
UNC 1/4-5/16-3/8-7/16-1/2-5/8-3/4 UNC 7/8-1"-1.1/8-1.1/4-1.3/8-1.1/2"	No. 1 No. 3 + 5	20 x 7 38 x 14 65 x 25	25 x 9 45 x 18	30 x 11 55 x 22		48054	1.650,00
UNF							
UNF 1/4-5/16-3/8-7/16-1/2	No. 1 + 2	20 x 7 38 x 10	25 x 9	30 x 11	No. 1	48060	230,00
UNF 1/4-5/16-3/8-7/16-1/2-5/8-3/4	No. 1 + 3	20 x 7 38 x 10	25 x 9 45 x 14	30 x 11		48061	385,00
UNF 1/4-5/16-3/8-7/16-1/2-5/8 UNF 3/4-7/8-1"	No. 1 + 4	20 x 7 38 x 10	25 x 9 45 x 14	30 x 11 55 x 16		48063	580,00
UNC / UNF							
UNC/UNF 1/4-5/16-3/8-7/16-1/2 UNC/UNF 5/8-3/4	No. 1 + 3	20 x 7 38 x 14	25 x 9 45 x 18	30 x 11		48066	698,00

Tap & Die Sets
in metal cases
DIN standards

Utensili per filettare in assortimento
in cassetta metallica
versione DIN

Hand Taps DIN 352
in sets of 3 pieces
Round Dies DIN 223

Maschi a mano DIN 352
Serie 3 pezzi
Filiere tonde DIN 223

								Art.-No	€
P.V.1 drilbox	M 3-4-5-6-8 M 10-12	2.5/3.3/4.2/5.0 6.8/8.5/10.2 mm	No. 1 No. 2	20 x 5 30 x 11	20 x 7 38 x 14	25 x 9	No. 1	49101	225,00
drilbox	M 3-4-5-6-8 M 10-12		No. 1 No. 2	20 x 5 30 x 11	20 x 7 38 x 14	25 x 9		49107	215,00
HSSE drilbox	M 3-4-5-6-8 M 10-12	2.5/3.3/4.2/5.0 6.8/8.5/10.2 mm	No. 1 No. 2	20 x 5 30 x 11	20 x 7 38 x 14	25 x 9	No. 1	49151	300,00
LH drilbox	M 3-4-5-6-8 M 10-12	2.5/3.3/4.2/5.0 6.8/8.5/10.2 mm	No. 1 No. 2	20 x 5 30 x 11	20 x 7 38 x 14	25 x 9	No. 1	49171	263,00
	M 3-4-5-6-8 M 10-12	2.5/3.3/4.2/5.0 6.8/8.5/10.2 mm	No. 1 No. 2	20 x 5 30 x 11	20 x 7 38 x 14	25 x 9		49111	156,00

Tap & Die Sets
in metal cases
DIN standards

Utensili per filettare in assortimento
in cassetta metallica
versione DIN

F.Z. 1
Hand Taps DIN 352, HSSE-VAP
Rougher piloted
Round Dies DIN 223, HSSE
+ 7 Guides for Round Dies

Maschi a mano DIN 352, HSSE-VAP
Sgrossatore con guida
Filiere DIN 223, HSSE
+ 7 guida per filiera

S.F. 1
Hand Taps DIN 352, HSS-G
Round Dies DIN 223, HSS
+ 7 Guides for Round Dies

Maschi a mano DIN 352, HSS-G
Filiere DIN 223, HSS
+ 7 guida per filiera

								Art.-No	€
F.Z.1	M 3-4-5-6-8	2.5/3.3/4.2/5.0	No. 1	20 x 5	20 x 7	25 x 9	No. 1	49150	320,00
drilbox	M 10-12	6.8/8.5/10.2 mm	No. 2	30 x 11	38 x 14				
S.F.1	M 3-4-5-6-8	2.5/3.3/4.2/5.0	No. 1	20 x 5	20 x 7	25 x 9	No. 1	49106	235,00
drilbox	M 10-12	6.8/8.5/10.2 mm	No. 2	30 x 11	38 x 14				

Tap & Die Sets
in metal cases
DIN standards

Utensili per filettare in assortimento
in cassetta metallica
versione DIN

Hand Taps DIN 352
in sets of 3 pieces
Round Dies DIN 223

Maschi a mano DIN 352
Serie 3 pezzi
Filiere tonde DIN 223

							Art.-No	€
P.V.2	M 3-4-5-6-8-10-12-14 M 16-18-20	No. 1 No. 3	20 x 5 30 x 11	20 x 7 38 x 14	25 x 9 45 x 18	No. 1 No. 2	49201	345,00
HSSE drilbox	M 3-4-5-6-8-10-12-14 M 16-18-20	No. 1 No. 3	20 x 5 30 x 11	20 x 7 38 x 14	25 x 9 45 x 18		49251	620,00
LH drilbox	M 3-4-5-6-8-10-12-14 M 16-18-20	No. 1 No. 3	20 x 5 30 x 11	20 x 7 38 x 14	25 x 9 45 x 18		49271	550,00
P.V.3	M 5-6-8-10-12-14 M 16-18-20	No. 1 No. 3	20 x 7 38 x 14	25 x 9 45 x 18	30 x 11	No. 1 No. 2	49301	330,00
P.V.5 drilbox	M 3-4-5-6-8-10-12-14 M 16-18-20	No. 1 No. 3	20 x 5 30 x 11	20 x 7 38 x 14	25 x 9 45 x 18		49205	440,00

Tap & Die Sets
in metal cases

Utensili per filettare in assortimento
in cassetta metallica

Hand Taps DIN 352
in sets of 3 pieces

Maschi a mano DIN 352
Serie 3 pezzi

					Art.-No	€
P.V.22	M 3-4-5-6-8 M 10-12	2.5/3.3/4.2/5.0 6.8/8.5/10.2 mm	No. 1.1/2		49510	95,00
P.V.23	M 3-4-5-6-8 M 10-12	2.5/3.3/4.2/5.0 6.8/8.5/10.2 mm	No. 1.1/2	No. 1	49511	102,00

Hand Taps DIN 352
in sets of 3 pieces
Round Dies 25 x 9 mm ø

Maschi a mano DIN 352
Serie 3 pezzi
Filiere tonde 25 x 9 ø

					Art.-No	€
P.V.12	M 3-4-5-6-8-10-12	No. 1.1/2	25 x 9	No. 1	49501	108,00
P.V.15 drilbox	M 3-4-5-6-8-10-12	No. 1.1/2	25 x 9	No. 1	49505	143,00

Die Sets
in metal cases
DIN standards

Utensili per filettare in assortimento
in cassetta metallica
versione DIN

				Art.-No	€
P.V.97		M 3-4-5-6-8-10-12		49521	69,00
P.V.98	*HSSE*	M 3-4-5-6-8-10-12		49522	90,00
P.V.99			M 3-4-5-6-8-10-12	49520	80,00
			UNC 1/4-5/16-3/8-7/16-1/2	49530	109,00
			UNF 1/4-5/16-3/8-7/16-1/2	49540	109,00
P.V.92	o/d 25x9	M 3-4-5-6-8-10-12		49525	47,00

Round Dies DIN 223
+ 7 Guides

Filiere tonde DIN 223
+ 7 guida per filiera

					Art.-No	€
P.V.14	M 3-4-5-6-8-10-12	20 x 5 30 x 11	20 x 7 38 x 14	25 x 9	49599	79,00
LH	M 3-4-5-6-8-10-12	20 x 5 30 x 11	20 x 7 38 x 14	25 x 9	49598	106,00

Tap Sets
in plastic boxes
DIN standards

Utensili per filettare in assortimento
in cassetta di plastica
versione DIN

Hand Taps DIN 352
in sets of 3 pieces

Maschi a mano DIN 352
Serie 3 pezzi

				Art.-No	€
P.K.20	M 3-4-5-6-8-10-12	No. 1.1/2		47001	75,00
P.K.21	M 3-4-5-6-8-10-12	No. 1.1/2	No. 1	47005	84,00
HSSE	M 3-4-5-6-8-10-12	No. 1.1/2	No. 1	47055	130,00
LH	M 3-4-5-6-8-10-12	No. 1.1/2	No. 1	47075	115,00
UNC No.5-No.8-No.10-1/4-5/16-3/8-1/2		No. 1.1/2		47033	105,00

Short Machine Taps DIN 352,
Spiral Point

Maschi a macchina corti DIN 352/B
con imbocco corretto

					Art.-No	€
P.K.25	M 3-4-5-6-8 M 10-12	2.5/3.3/4.2/5.0 6.8/8.5/10.2 mm	No. 1.1/2	No. 1	47605	60,00
P.K.26	M 3-4-5-6-8 M 10-12	2.5/3.3/4.2/5.0 6.8/8.5/10.2 mm	No. 1.1/2		47601	53,00

Tap & Die Sets
in plastic box
ISO standards

Utensili per filettare in assortimento
in cassetta di plastica

Machine Taps ISO 529
Spiral Point (Form B)

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

			Art.-No	€
P.K.85	M 3-4-5-6-8-10	2.5/3.3/4.2/5.0/6.8/8.5	80501	68,00

Machine Taps ISO 529

Maschi a macchina ISO 529

		Art.-No	€
Form B	M 3-4-5-6-8-10-12	80500	39,00
Form B-AZ	M 3-4-5-6-8-10-12	80900	56,00
Form C/35°RSP	M 3-4-5-6-8-10-12	80700	45,00

Machine Tap Sets
in plastic boxes

Maschi a macchina
in cassetta di plastica

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

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

			Art.-No	€
P.K.40	M 3-4-5-6-8-10-12		47901	126,00
P.K.41	M 3-4-5-6-8-10-12	***TIN***	47921	210,00

Combined Taps ***HSSE***

Maschi combinati con punte ***HSSE***

		Art.-No	€
P.K.370	M 3-4-5-6-8-10-12	47837	133,00
P.K.700	BSW 1/8-5/32-3/16-1/4-5/16-3/8-1/2	47870	133,00

Machine Tap Sets
in plastic boxes

Maschi a macchina
in cassetta di plastica

Machine Taps ***HSSE***
Spiral Point

Maschi a macchina ***HSSE***
con imbocco corretto

				Art.-No	€
P.K.28	M 3-4-5-6-8-10-12			47815	58,00
P.K.29	M 3-4-5-6-8-10-12	***TIN***		47825	99,00
●	M 3-4-5-6-8-10-12			47853	87,00
●	M 3-4-5-6-8-10-12			47854	87,00
●	M 3-4-5-6-8-10-12	***TiCN***		47859	122,00
○	M 3-4-5-6-8-10-12			47852	94,00
P.K.35	M 3-4-5-6-8-10-12		2.5/3.3/4.2/5.0/6.8/8.5/10.2 mm	47835	68,00
P.K.36	M 3-4-5-6-8-10-12	***TIN***	2.5/3.3/4.2/5.0/6.8/8.5/10.2 mm	47836	112,00
	M 3-4-5-6-8-10-12	***VAP***	2.5/3.3/4.2/5.0/6.8/8.5/10.2 mm	47858	84,00
●	M 3-4-5-6-8-10-12		2.5/3.3/4.2/5.0/6.8/8.5/10.2 mm	47856	105,00
●	M 3-4-5-6-8-10-12		2.5/3.3/4.2/5.0/6.8/8.5/10.2 mm	47857	113,00
○	M 3-4-5-6-8-10-12		2.5/3.3/4.2/5.0/6.8/8.5/10.2 mm	47855	113,00

Machine Tap Sets
in plastic boxes

Maschi a macchina
in cassetta di plastica

Machine Taps ***HSSE***
Spiral Flute

Maschi a macchina ***HSSE***
con spirale destra a 35°

				Art.-No	€
P.K.30	M 3-4-5-6-8-10-12			47817	68,00
P.K.31	M 3-4-5-6-8-10-12	***TIN***		47827	108,00
●	M 3-4-5-6-8-10-12			47863	103,00
●	M 3-4-5-6-8-10-12			47864	103,00
●	M 3-4-5-6-8-10-12	***TiCN***		47869	139,00
○	M 3-4-5-6-8-10-12			47862	113,00
P.K.47	M 3-4-5-6-8-10-12		2.5/3.3/4.2/5.0/6.8/8.5/10.2 mm	47847	78,00
P.K.48	M 3-4-5-6-8-10-12	***TIN***	2.5/3.3/4.2/5.0/6.8/8.5/10.2 mm	47848	116,00
	M 3-4-5-6-8-10-12	***VAP***	2.5/3.3/4.2/5.0/6.8/8.5/10.2 mm	47868	102,00
●	M 3-4-5-6-8-10-12		2.5/3.3/4.2/5.0/6.8/8.5/10.2 mm	47866	125,00
●	M 3-4-5-6-8-10-12		2.5/3.3/4.2/5.0/6.8/8.5/10.2 mm	47867	135,00
○	M 3-4-5-6-8-10-12		2.5/3.3/4.2/5.0/6.8/8.5/10.2 mm	47865	135,00

Electrical Conduit Set
in plastic box

Assortimento per tubatura elettrica
in cassetta di plastica

			Art.-No	€
M 20x1.5 - M 25x1.5	M 20x1.5 - M 25x1.5	42 mm	18012	49,50
M 20x1.5			18002	7,20
M 25x1.5			18003	7,20

Tap Sets
in wooden boxes
DIN standards

Utensili per filettare in assortimento
in cassetta di legna
versione DIN

Hand Taps DIN 352
in sets of 3 pieces

Maschi a mano DIN 352
Serie 3 pezzi

		Art.-No	€
M 1-1.2-1.4-1.7 M 2.0-2.3-2.6	No. 0	48001	185,00

Combined-Bit-Set
in pastic box

Assortimento di maschi a macchina combinati
in cassetta di plastica

HSS-G

				Art.-No	€
M	3-4-5-6-8-10		1/4"	67200	46,00
M	3-4-5-6-8-10	***TIN***	1/4"	67209	87,00
UNC	No.8 - No.10 - No.12 - 1/4 - 5/16 - 3/8"		1/4"	67272	62,00
UNF	No.8 - No.10 - No.12 - 1/4 - 5/16 - 3/8"		1/4"	67274	62,00

Threading-Bit-Set
with Twist-Drill-Bits in plastic box

Assortimento di maschi e punte
con attacco esagonale 1/4” in cassetta di plastica

Form D M 3-10 HSS-G Tol. ISO2/6H

			Art.-No	€
M 3-4-5-6-8-10	2.5/3.3/4.2/5.0/6.8/8.5 mm	1/4"	67020	46,00

Threading-Bit-Set
in plastic box

Assortimento di maschi con attacco esagonale 1/4”
in cassetta di plastica

Form D **M 3-10** **HSS-G** **Tol. ISO2/6H**

	Art.-No	€
M 3-4-5-6-8-10	67010	28,00

Drill Bit-Set
in plastic box

Assortimento di punte con attacco esagonale 1/4”
in cassetta di plastica

1,0 - 10,0 mm **HSS-G**

	Art.-No	€
1.0 / 1.5 / 2.0 / 2.5 / 3.0 / 3.5 4.0 / 4.5 / 5.0 / 5.5 / 6.0 / 6.5 7.0 / 7.5 / 8.0 / 8.5 / 9.0 / 9.5 / 10.0	67100	60,00

Countersink-Bit-Set
in plastic box

Assortimento di frese per svasare
con attacco esagonale 1/4”, in cassetta di plastica

6,3 - 20,5 mm **HSS**

	Art.-No	€
6.3/8.3/10.4/12.4/16.5/20,5	67300	56,00

Q.C. 1

Combined Bits

Assortimento di maschi a macchina combinati

M 3 - M 10 HSS-G

		Art.-No	€
M 3-4-5-6-8-10	non-magnetic 1/4"	67421	57,00

Q.C. 2

Threading-Bits

Maschi con attacco esagonale 1/4”

M 3 - M 10 HSS-G

			Art.-No	€
M 3-4-5-6-8-10	non-magnetic 1/4"	non-magnetic 1/4"	67422	53,00

Q.C. 3

Countersink Bits

Frese per svasare
con attacco esagonale 1/4”

6,3 - 20,5 mm HSS

			Art.-No	€
6.3/8.3/10.4/12.4/16.5/20.5	non-magnetic 1/4"	non-magnetic 1/4"	67423	80,00

Q.C. 4

Drill Bits

Punte
con attacco esagonale 1/4”

3,0 - 10,0 mm HSS-G

				Art.-No	€
3.0/4.0/5.0/6.0/8.0/10.0	6 Bits: 2xPH1, 3xPH2, 1xPH3	6 Torx Bits: T10, T15, T20, T25, T30, T40	non-magnetic 1/4"	67424	40,00

Q.C. 5

WOOD Drill Bits

Punte per legna
con attacco esagonale 1/4”

3,0 - 10,0 mm HSS-G

				Art.-No	€
3.0/4.0/5.0/6.0/8.0/10.0	6 Bits: 2xPZ1, 3xPZ2, 1xPZ3	6 Torx Bits: T10, T15, T20, T25, T30, T40	magnetic 1/4"	67425	40,00

Drill Bit-Set
in plastic box

Punte con attacco esagonale 1/4”
in cassetta di plastica

3,0 - 10,0 mm HSS-G

		Art.-No	€
3.0 / 4.0 / 5.0 / 6.0 / 8.0 / 10.0	for wood / per legna 3.0 / 4.0 / 5.0 / 6.0 / 8.0 / 10,0	67101	45,00

SD 2600
Art.-No. 48926

€ 1.900,00

SD 6000
Art.-No. 48960

€ 570,00

SD 670
Art.-No. 48967

€ 780,00

SD 3000

SD 672

Art.-No	Contents		€
48980	20 Sets	67200	920,00
48981	10 Sets	67200	880,00
	10 Sets	67020	
48982	10 Sets	67200	995,00
	10 Sets	67100	
48983	10 Sets	67200	1.020,00
	10 Sets	67300	

TECHNICAL INFORMATION
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SURFACE FINISHES
ACABADOS SUPEFICIALES

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

Ogni maschi VÖLKEL e filiere VÖLKEL può essere offerto con qualsiasi rivestimento o trat-tamenti termici breve

SURFACE FINISHES
ACABADOS SUPEFICIALES

Steam Tempered:

An iron oxide film is created on the tool surface by heat treatment.
This improves the adhesion of the coolant and as a result helps to prevent cold welding of the chip to the tool surface.

Vaporizzazione:

Attraverso un trattamento termico sull'utensile finito si deposita uno strato di ossido di ferro sulla superficie dell'utensile.
Questo strato migliora l'aderenza del refrigerante e del lubrificante, riducendo così il rischio di rottura del film lubrificante evitando la formazione di saldature a freddo di scorie.

Nitriding:

The surface hardness is increased by enriching the surface of the tap with nitrogen. This results in high abrasion resistance and improved anti-friction properties.

Nitrurazione:

L'arricchimento della superficie del maschio con azoto permette di aumentare la durezza della superficie dell'utensile. Si ottiene altresì un miglioramento della resistenza all'abrasione e delle proprietà antifrizione.

TiN (Titanium Nitride Coating):

Following PVD processing, the tap undergoes titanium nitride vapour-deposition within the vacuum chamber at approx. 500°C. Excellent anti-friction properties and high resistance to wear and abrasion result from the reduced surface roughness and remarkable hardness.
TIN coated taps can be employed using cinsiderably faster cutting speeds.

TiN (Rivestimento al Nitruro di Titanio):

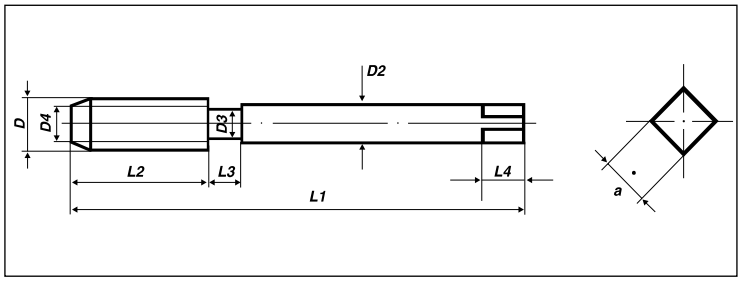
Attraverso il procedimento di metallizzazione a vuoto a 500°C ca. (PVD) viene depositato sull'utensile uno strato vaporizzato di nitrito di Titanio. La riduzione della rugosità della superficie e la durezza estrema permettono di ottenere eccellenti proprietà antifrizione e una forte resistenza all'usura e all'abrasione.
I maschi rivestiti al TiN possono essere utilizzati con velocità di taglio nettamente più elevate.

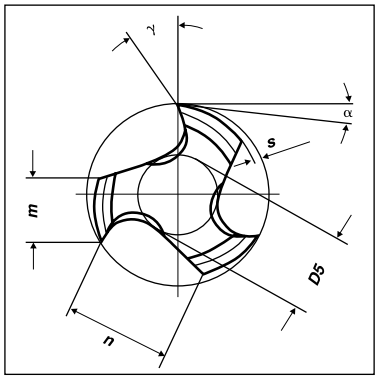
TiCN (Titanium CarboNitride Coating):

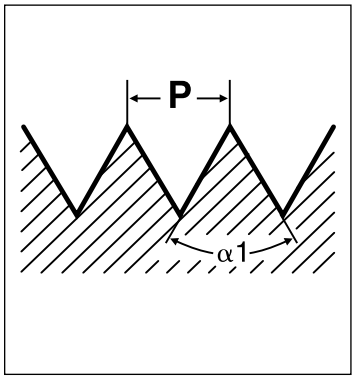
The TiCN-coating is particularly suitable for wear-resistant and abrasive material. The TiCN-coating has an hardness of 3.000 HV and thus is harder as the TiN-coating (2.600 HV). As a result the TiCN-coating has an excellent wear-resistance. Also the hardness and the toughness is higher, the heat resistance is reduced. Therefore intensive and optimum cooling is essential.

TiCN (Rivestimento con carbonitruro di titanio):

Il rivestimento TiCN è particolarmente indicato per acciai ad elevata resistenza all'abrasione e materiali altamente abrasivi. Il rivestimento TiCN ha una durezza pari a 3.000 HV quindi risulta essere più duro rispetto al rivestimento TiN (2.600 HV); ciò comporta un miglioramento della resistenza all'usura dell'utensile. Una maggiore tenacità all'abrasione è contrapposta a una minore resistenza alle elevate temperature. Perciò è fondamentale una ottima refrigerazione dell'utensile rivestito.



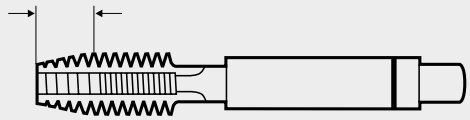




D	Nominal diameter	Diametro nominale
D2	Shank diameter	Diametro del gambo
D3	Neck diameter	Diametro dell'imbocco
D4	Point diameter	Diametro del collarino
D5	Web diameter	Diametro del nucleo
L1	Overall length	Lunghezza totale
L2	Thread length	Lunghezza filetto
L3	Neck length	Lunghezza utile
L4	Square length	Lunghezza quadro
P	Pitch	Passo
a	Square size	Quadro
m	Land width	Larghezza settore
n	Flute width	Larghezza scanalatura
s	Thread relief	Spoglia sul filetto
α	Relief angle	Angolo di spoglia sul filetto
γ	Rake angle	Angolo di taglio
α_1	Thread angle	Angolo del profilo

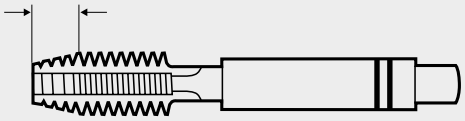
Leads of Hand Taps, Sets of 3 pcs.
Lunghezza di Imbocco – Maschi a mano, serie 3 pezzi

6-8 threads/spire



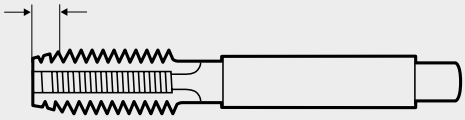
Nr. 1
Rougher, 6-8 Threads Lead
Sgrossatore, Imbocco a 6-8 spire

4-5 threads/spire



Nr. 2
Intermediate, 4-5 Threads Lead
Intermedio, Imbocco a 4-5 spire

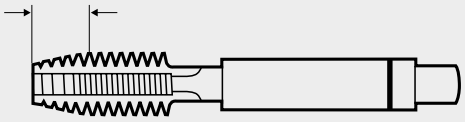
2-3 threads/spire



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

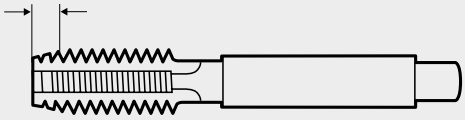
Leads of Hand Taps, Sets of 2 pcs.
Orden de los machos, juegos de 2 piezas

5-6 threads/spire

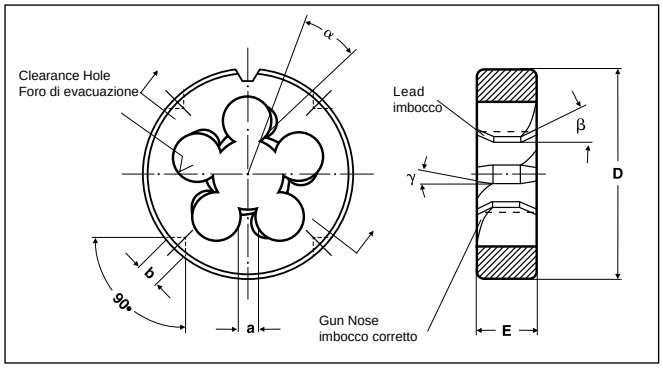


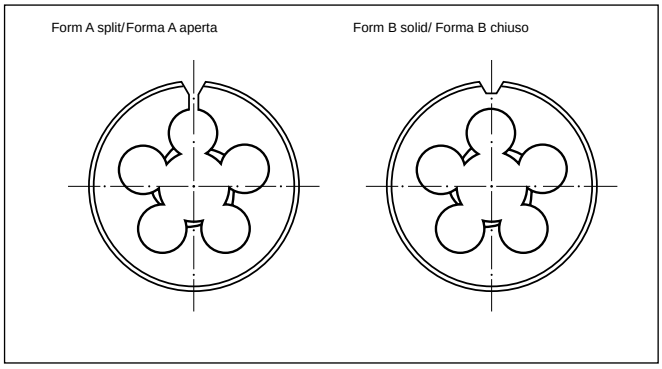
Nr. 1
Rougher, 5-6 Threads Lead
Sgrossatore, Imbocco a 6-8 spire

2-3 threads/spire



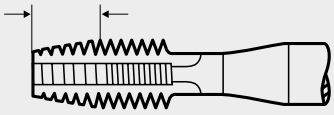
Nr. 2
Finisher, 2-3 Threads Lead
Finitore, Imbocco a 2-3 spire





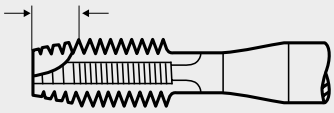
D	Outside diameter	Diametro esterno
E	Width of die	Spessore
a	Width of land	Ampiezza del dente
b	Hole for holding screws	Diametro fissaggio vite
α	Rake angle	Angolo di taglio
β	Lead angle	Angolo dell'imbocco
γ	Angle of gun nose	Angolo dell'imbocco corretto

6-8 threads/spire



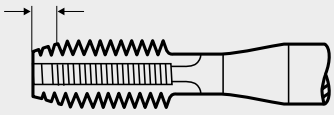
Form A
6-8 Threads Lead, for short through holes
Imbocco a 6-8 spire, per fori passanti corti

4-5 threads/spire



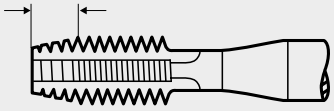
Form B
4-5 Threads Lead with Spiral Point for through holes
Imbocco a 4-5 spire con imbocco corretto, per tutti i fori passanti

2-3 threads/spire



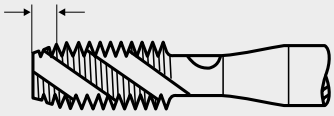
Form C
2-3 Threads Lead, for blind holes
Imbocco a 2-3 spire, per fori ciechi

4-5 threads/spire



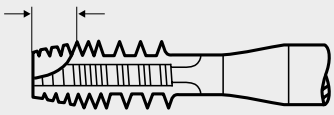
Form D
4-5 Threads Lead, for through and blind holes
Imbocco a 4-5 spire, per fori passante e ciechi

2-3 threads/spire



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

4-5 threads/spire



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

Tolerance of the tap **Classe di tolleranza del maschio** Designation according Definizione a tenore di		Tolerance of the nut thread Utilizzabile nel campo di tolleranza per la filettatura del dado	Explanation commento
DIN 802 DIN	DIN EN 22857 ISO 2857		
4H	ISO 1	4H, 5H	undersize / Fine
6H	ISO 2	4G, 5G, 6H	standard / Normale
6G	ISO 3	6G, 7H, 8H	oversize (M12x1,5 7G = ISO2/6H + 0,03 mm) tolleranza maggiorata (p.es. a M 12x1,5-6G = ca. + 0,03 mm, riferito a ISO 2/6H)
7G	./.	7G, 8G, (6E)	oversize (M12x1,5 7G = ISO2/6H + 0,06 mm) tolleranza maggiorata (p.es. a M 12x1,5-7G = ca. + 0,06 mm riferito a ISO 2/6H)
4HX	ISO 1X	4H, 5H	manufacturer tolerance for special materials (X = small oversize, 4HX ≈ ISO2/6H) Classe di tolleranza speciale per materiale speciale (X = minor tolleranza maggiorata 4 HX corrisponde ≈ ISO 2/6H)
6HX	ISO 2X	6H	manufacturer tolerance for special materials (X = small oversize, 6HX ≈ ISO3/6G) Classe di tolleranza speciale per materiale speciale (X = minor tolleranza maggiorata 6HX corrisponde ≈ ISO 3/6G)
6GX	ISO 3X	6G	manufacturer tolerance for special materials (X = small oversize, 6GX ≈ 7G) Classe di tolleranza speciale per materiale speciale (X = minor tolleranza maggiorata 6GX corrisponde ≈ 7G)
6H + 0,1	ISO 2 + 0,1	4G, 5G, 6H	+ 0,1 mm oversize for galvanic coatings and surface finishing with thickness of Layer up to 25 µm tolleranza maggiorata 0,1 mm, per strato di protezione galvanica e superficie raffinato con spessore fino 25 µm
6H + 0,2	ISO 2 + 0,2	4G, 5G, 6H	+ 0,2 mm oversize for galvanic coatings and surface finishing with thickness of Layer up to 50 µm tolleranza maggiorata 0,2 mm, per strato di protezione galvanica e superficie raffinato con spessore fino 25 µm

The required oversize of the tap with galvanic coatings depends on the thread angle.
The oversize O can be calculated with the following approach formula: O = S x F
S = thickness of the layer / F = factor depending on the thread angle a (F = 2 / sin a / 2)
tolleranza maggiorata necessaria da strato di protezione galvanica e dipendente dall'angolo del profilo
tolleranza maggiorata O può essere calcolata con la seguente formula: O = S x F
S = spessore dell rivestimento galvanico / F = fattore dipendente di angolo del profilo a (F = 2 / sin / 2)

Thread angle /Angolo del profilo	30°	47°/30'	55°	60°	80°	90°
F=	7,727	4,966	4,331	4,000	3,111	2,828

Conversion table - pitch per inch into mm
Tabella di conversione - Paso pollice in mm

P (Gg/1")	mm
100	0,254 000
96	0,264 583
80	0,317 500
72	0,352 778
64	0,396 875
60	0,423 333
56	0,453 571
48	0,529 167
44	0,577 273
40	0,635 000
36	0,705 555
32	0,793 750
28	0,907 143
27	0,940 741
26	0,976 923
25	1,016 000

P (Gg/1")	mm
24	1,058 333
22	1,154 545
20	1,270 000
19	1,336 842
18	1,411 111
16	1,587 500
14	1,814 286
13	1,953 846
12	2,116 667
11.1/2	2,208 696
11	2,309 091
10	2,540 000
9	2,822 222
8	3,175 000
7	3,628 571
6	4,233 333

P (Gg/1")	mm
5	5,080 000
4.1/2	5,644 444
4	6,350 000
3.1/2	7.257 143
3.1/4	7,815 385
3	8,466 667
2.7/8	8,834 783
2.3/4	9,236 364
2.5/8	9,676 190
2.1/2	10,160 000
2.1/4	11,288 889
2	12,700 000

CONVERSION TABLE OF TENSILE STRENGTH AND HARDNESS*

TABELLA CONVERSIONE RESISTENZA E DUREZZA*

		Rockwell			Vickers	Brinell
N/mm²	HRC	HRA	HRB	HRF	HV (≥98N)	HB 30
255	-	-	-	-	80	76
285	-	-	48	83	90	86
320	-	-	56	87	100	95
350	-	-	62	91	110	105
385	-	-	67	94	120	114
415	-	-	71	96	130	124
450	-	-	75	99	140	133
480	-	-	79	101	150	143
510	-	-	82	104	160	152
545	-	-	85	106	170	162
575	-	-	87	107	180	171
610	-	-	90	109	190	181
640	-	-	92	110	200	190
675	-	-	94	111	210	199
705	-	-	95	112	220	209
740	-	-	97	113	230	219
770	20	61	98	114	240	228
800	22	62	100	115	250	238
835	24	62	101	-	260	247
865	26	63	102	-	270	257
900	27	64	104	-	280	266
930	29	65	105	-	290	276
965	30	65	-	-	300	285
1030	32	66	-	-	320	304
1095	34	68	-	-	340	323
1155	37	69	-	-	360	342
1220	39	70	-	-	380	361
1290	41	71	-	-	400	380
1350	43	72	-	-	420	399
1420	45	73	-	-	440	418
1485	46	74	-	-	460	437
1555	48	75	-	-	480	456
1595	48	75	-	-	490	466
1665	50	76	-	-	510	485
1740	51	76	-	-	530	504
1810	52	77	-	-	550	523
1880	54	78	-	-	570	542
1955	55	78	-	-	590	561
2030	56	79	-	-	610	580
2105	57	80	-	-	630	599
2180	58	80	-	-	650	618
-	59	81	-	-	670	636
-	60	81	-	-	690	-
-	61	82	-	-	720	-
-	63	83	-	-	760	-
-	64	83	-	-	800	-
-	65	84	-	-	840	-
-	66	85	-	-	880	-

*no liability assumed *senza garanzia

CONVERSION TABLE OF CUTTING SPEED M/MIN. TO R/MIN.

TRADUZIONE DELLA VELOCITÀ DI M/MIN IN U/MIN

m/min.		4	6	8	9	10	12	15	18	21	25	27	30	36
Size		Revolutions per Minute (rpm)												
mm	inch	giri al minuto U/min												
1,6	1/16	800	1194	1592	1791	1988	2386	2983	3579	4176	4971	5369	5965	7158
1,8		708	1065	1415	1598	1768	2121	2652	3182	3712	4419	4743	5303	6364
2		637	955	1274	1433	1591	1909	2386	2863	3341	3977	4295	4773	5727
2,2	3/32	579	869	1158	1303	1446	1736	2169	2603	3037	3616	3905	4339	5207
2,5		510	764	1019	1147	1274	1527	1909	2291	2673	3182	3436	3818	4582
3	1/8	425	637	849	955	1061	1273	1591	1909	2227	2651	2864	3182	3818
3,5		364	546	728	819	909	1091	1364	1636	1909	2273	2455	2727	3273
4	5/32	318	478	637	718	796	955	1193	1432	1671	1989	2148	2387	2864
4,5		283	425	566	637	707	849	1061	1273	1485	1768	1909	2122	2546
5	3/16	255	382	510	573	637	764	955	1146	1337	1591	1719	1909	2292
6	1/4	212	319	425	477	530	636	795	954	1113	1326	1432	1592	1909
7	9/32	182	273	364	409	455	546	682	818	955	1136	1227	1364	1636
8	5/16	159	239	319	358	398	477	597	716	835	994	1074	1193	1432
9		142	212	283	318	354	425	531	637	742	885	955	1061	1293
10	3/8	127	191	255	286	318	382	477	573	668	795	859	955	1146
11		116	174	232	260	289	347	434	521	608	723	781	868	1041
12	1/2	106	159	212	238	265	318	398	477	557	663	716	796	955
13		98	147	196	220	245	294	367	441	514	612	661	734	881
14	9/16	91	136	182	205	277	273	341	409	477	568	614	682	818
16	5/8	80	119	159	179	199	239	298	358	418	497	537	597	716
18		71	106	141	159	177	212	265	318	371	442	477	530	636
20	3/4	64	96	127	143	159	191	239	286	334	398	430	477	573
22	7/8	58	87	116	130	145	174	217	260	304	362	391	434	521
24	1"	53	80	106	119	133	159	199	239	275	331	353	398	477
27		47	71	94	106	118	141	177	212	245	295	318	354	424
30	1-1/8	43	64	85	95	106	127	159	191	223	265	286	318	382
33	1-1/4	39	58	77	87	96	116	145	174	203	241	260	289	347
36		35	53	71	80	88	106	133	159	186	221	239	265	318
39	1-1/2	33	49	65	73	82	98	122	147	171	204	220	245	294
42		30	46	61	68	76	91	114	136	159	189	205	227	273
45	1-3/4	28	42	57	64	71	85	106	127	149	177	191	212	255
48		27	40	53	60	66	80	99	119	139	166	179	199	239
52		24	37	49	55	61	73	92	110	129	153	165	184	220
56	2"	23	34	46	51	57	68	85	102	119	142	153	170	205

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

Material/Materiali	Lubricant lubrificante	Cutting Speed velocità di taglio m/min.
Steel, unalloyed and low alloyed, short-chipping Acciaio non legati e e baso legati, truciolo corto	S/E	10-20
non abrasive Material, short-chipping Materiali buona truciodibilità, truciolo corto	S/E	6-15
Steel, heat resistant, long-chipping Acciaio resistenti al calore, truciolo lungo	S	4- 8
Steel, heat resistant, short-chipping Acciaio resistenti al calore, truciolo corto	S	4- 8
Steel, cementation and heat treatable, short-chipping Acciaio da cementazione, Acciaio bonificato, truciolo corto	S	4- 8
Steel, Tool Steel up to 1200 N/mm² Acciaio, Acciaio utensili a 1.200 N/mm²	S	2- 5
Steel, Tool Steel over 1200 N/mm² Acciaio, Acciaio utensili da 1.200 N/mm²	S	2- 5
Steel stainless, short-chipping Acciaio inossidabile, truciolo corto	S	5-10
Steel stainless, long-chipping Acciaio inossidabile, truciolo lungo	S	5-10
Iron, Cast Ghisa grigia	P/T	6-20
Iron, spheroidal graphite Ghisa sferoidale	P/T	6-20
Iron, Malleable Cast Ghisa malleabile	E	6-12
Brass, short-chipping Ottone, truciolo corto	E	20-30
Brass, long-chipping Ottone, truciolo lungo	S/E	10-15
Bronze, short-chipping Bronzo, truciolo corto	S/E	6-15
Bronze, long-chipping Bronzo, truciolo lungo	S/E	6-15
Copper Rame	S/E	10-15
Aluminium-alloys, short-chipping Alluminio, truciolo corto	S/E	15-30
Aluminium-alloys, long-chipping Alluminio, truciolo lungo	E	10-20
Zinc Alloys Leghe forgiate	S/E	10-15
Magnesium Alloys Leghe di magnesio	E/T	10-20
Titanium, short-chipping Titanio, truciolo corto	S	3- 4
Titanium, long-chipping Titanio, truciolo lungo	S	3- 4
Plastics, thermoplastics Materiali plastici, materiali termoplastici	E/T	5-15
Plastics, thermosetting Materiali plastici, materiali termodurenti	T	5-15

S = cutting oil/olii da taglio E = oil emulsion/emulsione P = kerosene/petrolio T = dry/secco

CONVERSION TABLE INCH-MM
TABELLA DI CONVERSIONE POLLICE – MM

Nominal-Ø Inch	BSW Pitch Inch	BSF Pitch Inch	UNC Pitch Inch	UNF Pitch Inch	UNEF Pitch Inch	Thread-Ø mm
No. 0	-	-	-	80	-	1,520
No. 1	-	-	64	72	-	1,850
No. 2	-	-	56	64	-	2,180
No. 3	-	-	48	56	-	2,520
No. 4	-	-	40	48	-	2,850
No. 5	-	-	40	44	-	3,180
No. 6	-	-	32	40	-	3,510
No. 8	-	-	32	36	-	4,170
No. 10	-	-	24	32	-	4,830
No. 12	-	-	24	28	32	5,490
1/16"	60	-	-	-	-	1,587
3/32"	48	-	-	-	-	2,381
1/8"	40	-	-	-	-	3,175
5/32"	32	-	-	-	-	3,969
3/16	24	32	-	-	-	4,762
7,32"	24	28	-	-	-	5,556
1/4"	20	26	20	28	32	6,350
5/16"	18	22	18	24	32	7,938
3/8"	16	20	16	24	32	9,525
7/16"	14	18	14	20	28	11,113
1/2"	12	16	13	20	28	12,700
9/16"	12	16	12	18	24	14,288
5/8"	11	14	11	18	24	15,876
11/16"	-	14	-	-	24	17,463
3/4"	10	12	10	16	20	19,051
13/16"	-	12	-	-	20	20,638
7/8"	9	11	9	14	20	22,226
15/16"	-	11	-	-	20	23,813
1"	8	10	8	12	20	25,401
1 1/16"	-	-	-	-	18	26,988
1 1/8"	7	9	7	12	18	28,576
1 3/16"	-	-	-	-	18	30,163
1 1/4"	7	9	7	12	18	31,751
1 5/16"	.	.	.	.	18	33,338
1 3/8"	6	8	6	12	18	34,926
1 7/16"	-	-	-	-	18	36,512
1 1/2"	6	8	6	12	18	38,101
1 5/8"	5	8	5	-	18	41,277
1 3/4"	5	7	5	-	18	44,452
1 7/8"	4,5	-	4,5	-	18	47,627
2"	4,5	7	4,5	-	18	50,802
2 1/4"	4	-	4,5	-	-	57,152
2 1/2"	4	-	4	-	-	63,502
2 3/4"	3,5	-	4	-	-	69,853
3"	3,5	-	4	-	-	76,203

Nominal-Ø Inch	BSP (G) Pitch Inch	Thread-Ø mm
G 1/8"	28	9,728
G 1/4"	19	13,157
G 3/8"	19	16,662
G 1/2"	14	20,955
G 5/8"	14	22,911
G 3/4	14	26,441
G 7/8"	14	30,201
G 1"	11	33,249
G 1 1/8	11	37,897
G 1 1/4"	11	41,910
G 1 3/8"	11	44,323
G 1 1/2"	11	47,803
G 1 3/4"	11	53,746
G 2"	11	59,614
G 2 1/4"	11	65,710
G 2 1/2"	11	75,184
G 2 3/4"	11	81,534
G 3"	11	87,884
G 3 1/4"	11	93,980
G 3 1/2	11	100,330
G 3 3/4"	11	106,680
G 4"	11	113,030

armoured tube thread PG

Nominal-Ø	Pitch Inch	Thread-Ø mm
PG 7	20	12,500
PG 9	18	15,200
PG 11	18	18,600
PG 13,5	18	20,400
PG 16	18	22,500
PH 21	16	28,300
PG 29	16	37,000
PG 36	16	47,000
PG 42	16	54,000
PG 48	16	59,500

RECOMMENDED OUTSIDE DIAMETER

DIAMETRI DEI PERNI DA FILLETTARE RACCOMANDATO

M		Ø mm
M 1	0,25	0,97
M 1,1	0,25	1,07
M 1,2	0,25	1,17
M 1,4	0,3	1,36
M 1,6	0,35	1,54
M (1,7)	0,35	1,64
M 1,8	0,35	1,74
M 2	0,4	1,93
M 2,2	0,45	2,13
M (2,3)	0,4	2,23
M 2,5	0,45	2,43
M (2,6)	0,45	2,53
M 3	0,5	2,92
M 3	0,6	2,91
M 3,5	0,6	3,41
M 3,5	0,75	3,41
M 4	0,7	3,91
M 4	0,75	3,91
M 4,5	0,75	4,41
M 5	0,8	4,90
M 5	0,9	4,89
M 6	1	5,88
M 7	1	6,88
M 8	1,25	7,87
M 9	1,25	8,87
M 10	1,5	9,85
M 11	1,5	10,85
M 12	1,75	11,83
M 14	2	13,82
M 16	2	15,82
M 18	2,5	17,79
M 20	2,5	19,79
M 22	2,5	21,79
M 24	3	23,77
M 27	3	26,77
M 30	3,5	29,73
M 33	3,5	32,73
M 36	4	35,70
M 39	4	38,70
M 42	4,5	41,69
M 45	4,5	44,69
M 48	5	47,66
M 52	5	51,66

Mf		Ø mm
M 3	x 0,35	2,94
M 3,5	x 0,35	3,44
M 4	x 0,35	3,94
M 4	x 0,5	3,93
M 5	x 0,5	4,93
M 6	x 0,5	5,93
M 6	x 0,75	5,90
M 7	x 0,75	6,90
M 8	x 0,5	7,93
M 8	x 0,75	7,90
M 8	x 1	7,83
M 9	x 1	8,88
M 10	x 0,5	9,93
M 10	x 0,75	9,90
M 10	x 1	9,88
M 10	x 1,25	9,86
M 11	x 1	10,88
M 12	x 0,75	11,90
M 12	x 1	11,88
M 12	x 1,25	11,86
M 12	x 1,5	11,85
M 13	x 1	12,88
M 13	x 1,5	12,85

Mf		Ø mm
M 13	x 1,75	12,83
M 14	x 1	13,88
M 14	x 1,25	13,86
M 14	x 1,5	13,85
M 15	x 1	14,88
M 15	x 1,5	14,85
M 15	x 2	14,82
M 16	x 1	15,88
M 16	x 1,5	15,85
M 18	x 1	17,88
M 18	x 1,5	17,85
M 18	x 2	17,82
M 20	x 1	19,88
M 20	x 1,5	19,85
M 20	x 2	19,82
M 22	x 1	21,88
M 22	x 1,5	21,85
M 22	x 2	21,82
M 24	x 1	23,88
M 24	x 1,5	23,85
M 24	x 2	23,82
M 25	x 1	24,88
M 25	x 1,5	24,85
M 26	x 1	25,88
M 26	x 1,5	25,85
M 27	x 1	26,88
M 27	x 1,5	26,85
M 27	x 2	26,82
M 28	x 1,5	27,85
M 28	x 2	27,82
M 30	x 1	29,88
M 30	x 1,5	29,85
M 30	x 2	29,82
M 32	x 1,5	31,85
M 33	x 1,5	32,85
M 33	x 2	32,82
M 34	x 1,5	33,85
M 35	x 1,5	34,85
M 36	x 1,5	35,85
M 36	x 2	35,82
M 36	x 3	35,76
M 38	x 1,5	37,85
M 39	x 1,5	38,85
M 39	x 2	38,82
M 39	x 3	38,76
M 40	x 1,5	39,85
M 40	x 2	39,82
M 40	x 3	39,76
M 42	x 1,5	41,85
M 42	x 2	41,82
M 42	x 3	41,76
M 45	x 1,5	44,85
M 45	x 2	44,82
M 45	x 3	44,76
M 48	x 1,5	47,85
M 48	x 2	47,82
M 48	x 3	47,46
M 50	x 1,5	49,85
M 50	x 2	49,82
M 50	x 3	49,76
M 52	x 1,5	51,85
M 52	x 2	51,82
M 52	x 3	51,76

BSW	Ø mm
W 1/4	6,16
W 5/16	7,76
W 3/8	9,30
W 7/16	10,89
W 1/2	12,43
W 9/16	13,92
W 5/8	15,62
W 3/4	18,76
W 7/8	21,89
W 1"	25,08
W 1.1/8	28,21

BSF	Ø mm
BSF 3/16	4,67
BSF 1/4	6,25
BSF 5/16	7,82
BSF 3/8	9,39
BSF 7/16	10,97
BSF 1/2	12,54
BSF 9/16	14,12
BSF 5/8	15,71
BSF 3/4	18,85
BSF 7/8	22,02
BSF 1"	25,17

UNC	Ø mm
No. 1-64	1,79
No. 2-56	2,12
No. 3-48	2,44
No. 4-40	2,76
No. 5-40	3,09
No. 6-32	3,41
No. 8-32	4,07
No. 10-24	4,71
No. 12-24	5,37
1/4-20	6,22
5/16-18	7,80
3/8-16	9,37
7/16-14	10,95
1/2-13	12,52
9/16-12	14,10
5/8-11	15,68
3/4-10	18,84
7/8- 9	22
1"- 8	25,16
1.1/8- 7	28,31
1.1/4- 7	31,49
1.3/8- 6	34,63
1.1/2- 6	37,81
1.3/4- 5	44,12
2"- 4,5	50,45
2.1/4- 4,5	56,80
2.1/2- 4	63,10
2.3/4- 4	69,45
3"- 4	75,80

UNF	Ø mm
No. 0-80	1,47
No. 1-72	1,79
No. 2-64	2,12
No. 3-56	2,44
No. 4-48	2,77
No. 5-44	3,10
No. 6-40	3,42
No. 8-36	4,08
No. 10-32	4,73
No. 12-28	5,38
1/4-28	6,24
5/16-24	7,82
3/8-24	9,41
7/16-20	10,98
1/2-20	12,56
9/16-18	14,14
5/8-18	15,73
3/4-16	18,89
7/8-14	22,05
1"-12	25,21
1.1/8-12	28,38
1.1/4-12	31,56
1.3/8-12	34,73
1.1/2-12	37,91

BSP G	Ø mm
G 1/8	9,62
G 1/4	13,03
G 3/8	16,53
G 1/2	20,81
G 5/8	22,77
G 3/4	26,30
G 7/8	30,06
G 1"	33,07
G 1.1/8	37,71
G 1.1/4	41,73
G 1.3/8	44,14
G 1.1/2	47,62
G 1.3/4	53,56
G 2"	59,43

PG	Ø mm
PG 7	12,40
PG 9	15,10
PG 11	18,50
PG 13,5	20,30
PG 16	22,40
PG 21	28,15
PG 29	36,85
PG 36	46,85
PG 42	53,85
PG 48	59,15

NPT	Ø mm
1/16	8,17
1/8	10,55
1/4	14,10
3/8	17,52
1/2	21,85
3/4	27,16
1"	34,16
1.1/4	42,74
1.1/2	48,87
2"	60,95

FG		Ø mm
FG 2	x 56	2,03
FG 2,3	x 56	2,23
FG 2,6	x 56	2,53
FG 6,35	x 26	6,23
FG 7,9	x 26	7,81
FG 9,5	x 26	9,40
FG 14,3	x 20	14,14
FG 14,3	x 20-LH	14,14
FG 25,4	x 24	25,26

BSC	Ø mm
BSC 1/4 x 26	6,23
BSC 5/16 x 26	7,81
BSC 3/8 x 26	9,40
BSC 9/16 x 20	14,14
BSC 9/16 x 20LH	14,14
BSC 1" x 24	25,26

Vg		Ø mm
Vg 5	x 36	5,05
Vg 5,2	x 24	5,12
Vg 6	x 32	5,87
Vg 8	x 32	7,57
Vg 10	x 28	10,16
Vg 12	x 26	12,04

RECOMMENDED TAPPING DRILL SIZES
PREFORI PER MASCHI RACCOMANDATO

M		Ø mm
M 1	0,25	0,75
M 1,1	0,25	0,85
M 1,2	0,25	0,95
M 1,4	0,3	1,1
M 1,6	0,35	1,25
M (1,7)	0,35	1,3
M 1,8	0,35	1,45
M 2	0,4	1,6
M 2,2	0,45	1,75
M (2,3)	0,4	1,9
M 2,5	0,45	2,05
M (2,6)	0,45	2,1
M 3	0,5	2,5
M 3,5	0,6	2,9
M 4	0,7	3,3
M 4,5	0,75	3,7
M 5	0,8	4,2
M 6	1	5
M 7	1	6
M 8	1,25	6,8
M 9	1,25	7,8
M 10	1,5	8,5
M 11	1,5	9,5
M 12	1,75	10,2
M 14	2	12
M 16	2	14
M 18	2,5	15,5
M 20	2,5	17,5
M 22	2,5	19,5
M 24	3	21
M 27	3	24
M 30	3,5	26,5
M 33	3,5	29,5
M 36	4	32
M 39	4	35
M 42	4,5	37,5
M 45	4,5	40,5
M 48	5	43
M 52	5	47
M 3	0,6	2,4
M 3,5	0,75	2,75
M 4	0,75	3,25
M 5	0,9	4,1

Mf	Ø mm
M 2,5 x 0,35	2,15
M 2,6 x 0,35	2,25
M 3 x 0.35	2,65
M 3,5 x 0,35	3,15
M 4 x 0,35	3,65
M 4 x 0,5	3,5
M 4,5 x 0,5	4
M 5 x 0,5	4,5
M 5 x 0,75	4,25
M 5,5 x 0,5	5
M 6 x 0,5	5,5
M 6 x 0,75	5,2
M 7 x 0,5	6,5
M 7 x 0,75	6,2
M 8 x 0,5	7,5
M 8 x 0,75	7,2
M 8 x 1,0	7
M 9 x 0,5	8,5
M 9 x 0,75	8,2
M 9 x 1,0	8
M 10 x 0,5	9,5
M 10 x 0,75	9,2
M 10 x 1,0	9

Mf	Ø mm
M 10 x 1,25	8,8
M 11 x 1,0	10
M 11 x 1,25	9,8
M 12 x 0,75	11,2
M 12 x 1,0	11
M 12 x 0,5	11,5
M 12 x 1,25	10,8
M 13 x 0,5	12,5
M 12 x 1,5	10,5
M 13 x 0,75	12,25
M 13 x 1,0	12
M 13 x 1,5	11,5
M 14 x 0,75	13,25
M 14 x 1,0	13
M 14 x 1,25	12,8
M 14 x 0,5	13,5
M 14 x 1,5	12,5
M 15 x 0,75	14,25
M 15 x 1,0	14
M 15 x 1,5	13,5
M 16 x 0,5	15,5
M 16 x 1,0	15
M 16 x 0,75	15,25
M 16 x 1,25	14,75
M 16 x 1,5	14,5
M 18 x 0,5	17,5
M 17 x 1,0	16
M 18 x 1,0	17
M 18 x 1,25	16,75
M 18 x 1,5	16,5
M 18 x 0,75	17,25
M 18 x 2,0	16
M 19 x 1,0	18
M 19 x 1,5	17,5
M 20 x 0,5	19,5
M 20 x 1,0	19
M 20 x 0,75	19,25
M 20 x 1,25	18,75
M 20 x 1,5	18,5
M 20 x 2,0	18
M 21 x 1,0	20
M 21 x 1,5	19,5
M 22 x 0,5	21,5
M 22 x 1,0	21
M 22 x 0,75	21,25
M 22 x 1,25	20,75
M 22 x 1,5	20,5
M 22 x 2,0	20
M 23 x 1,0	22
M 23 x 1,5	21,5
M 24 x 1,0	23
M 24 x 0,5	23,5
M 24 x 1,25	22,75
M 24 x 0,75	23,25
M 24 x 1,5	22,5
M 24 x 2,0	22
M 25 x 1,0	24
M 25 x 1,5	23,5
M 26 x 1,0	25
M 26 x 1,5	24,5
M 26 x 2,0	24
M 27 x 1,0	26
M 27 x 1,5	25,5
M 27 x 2,0	25
M 28 x 1,0	27
M 28 x 1,5	26,5
M 28 x 2,0	26
M 29 x 1,5	27,5

Mf	Ø mm
M 30 x 1,0	29
M 30 x 1,5	28,5
M 30 x 2,0	28
M 30 x 2,5	27,5
M 30 x 3,0	27
M 32 x 2	30
M 32 x 1,5	29,5
M 32 x 3,0	29
M 33 x 1,5	31,5
M 32 x 1	31
M 33 x 2,0	31
M 33 x 3,0	30
M 34 x 1	33
M 34 x 1,5	32,5
M 34 x 2,0	32
M 35 x 1	34
M 35 x 1,5	33,5
M 35 x 2	33
M 36 x 1,5	34,5
M 36 x 1	35
M 36 x 2,0	34
M 37 x 1,5	35,5
M 36 x 3,0	33
M 38 x 1	37
M 38 x 1,5	36,5
M 38 x 2,0	36
M 39 x 1,5	37,5
M 38 x 3	35
M 39 x 2,0	37
M 39 x 3,0	36
M 40 x 1	39
M 40 x 1,5	38,5
M 40 x 2,0	38
M 40 x 3,0	37
M 42 x 1	41
M 42 x 1,5	40,5
M 44 x 1,5	42,5
M 42 x 2,0	40
M 44 x 2	42
M 42 x 3,0	39
M 45 x 1	44
M 45 x 1,5	43,5
M 45 x 2,0	43
M 45 x 3,0	42
M 46 x 1,5	44,5
M 48 x 1,5	46,5
M 48 x 1	47
M 48 x 2,0	46
M 48 x 3,0	45
M 50 x 1,5	48,5
M 50 x 2,0	48
M 50 x 3,0	47
M 52 x 1,5	50,5
M 52 x 2,0	50
M 52 x 3,0	49
M 54 x 1,0	53
M 54 x 1,5	52,5
M 54 x 2,0	52
M 54 x 3,0	51
M 54 x 4,0	50
M 55 x 1,5	53,5
M 55 x 2,0	53
M 55 x 3,0	52
M 55 x 4,0	51
M 56 x 1,0	55
M 56 x 1,5	54,5
M 56 x 2,0	54
M 56 x 3,0	53

Mf	Ø mm
M 56 x 4,0	52
M 58 x 1,0	57
M 58 x 1,5	56,5
M 58 x 2,0	56
M 58 x 3,0	55
M 58 x 4,0	54
M 60 x 1,5	58,5
M 60 x 2,0	58
M 60 x 3,0	57
M 60 x 4,0	56
M 62 x 1,5	60,5
M 62 x 2,0	60
M 62 x 3,0	59
M 62 x 4,0	58
M 63 x 1,5	61,5
M 64 x 1,5	62,5
M 64 x 2,0	62
M 64 x 3,0	61
M 64 x 4,0	60
M 65 x 1,5	63,5
M 65 x 2,0	63
M 65 x 3,0	62
M 65 x 4,0	61
M 68 x 1,5	66,5
M 68 x 2,0	66
M 68 x 3,0	65
M 68 x 4,0	64
M 70 x 1,5	68,5
M 70 x 2,0	68
M 70 x 3,0	67
M 70 x 4,0	66
M 72 x 1,5	70,5
M 72 x 2,0	70
M 72 x 3,0	69
M 72 x 4,0	68
M 74 x 1,5	72,5
M 74 x 2,0	72
M 74 x 3,0	71
M 74 x 4,0	70
M 75 x 1,5	73,5
M 75 x 2,0	73
M 75 x 3,0	72
M 75 x 4,0	71
M 76 x 1,5	74,5
M 76 x 2,0	74
M 76 x 3,0	73
M 76 x 4,0	72
M 78 x 1,5	76,5
M 78 x 2,0	76
M 78 x 3,0	75
M 78 x 4,0	74
M 80 x 1,5	78,5
M 80 x 2,0	78
M 80 x 3,0	77
M 80 x 4,0	76
M 82 x 1,5	80,5
M 82 x 2,0	80
M 82 x 3,0	79
M 82 x 4,0	78
M 84 x 1,5	82,5
M 84 x 2,0	82
M 84 x 3,0	81
M 84 x 4,0	80
M 85 x 1,5	83,5
M 85 x 2,0	83
M 85 x 3,0	82
M 85 x 4,0	81
M 86 x 1,5	84,5

Mf	Ø mm
M 86 x 2,0	84
M 86 x 3,0	83
M 86 x 4,0	82
M 88 x 1,5	86,5
M 88 x 2,0	86
M 88 x 3,0	85
M 88 x 4,0	84
M 90 x 1,5	88,5
M 90 x 2,0	88
M 90 x 3,0	87
M 90 x 4,0	86
M 92 x 1,5	90,5
M 92 x 2,0	90
M 92 x 3,0	89
M 92 x 4,0	88
M 95 x 1,5	93,5
M 95 x 2,0	93
M 95 x 3,0	92
M 95 x 4,0	91
M 96 x 1,5	94,5
M 96 x 2,0	94
M 96 x 3,0	93
M 96 x 4,0	92
M 98 x 1,5	96,5
M 98 x 2,0	96
M 98 x 3,0	95
M 98 x 4,0	94
M 100 x 1,5	98,5
M 100 x 2,0	98
M 100 x 3,0	97
M 100 x 4,0	96
M 105 x 1,5	103,5
M 105 x 2,0	103
M 105 x 3,0	102
M 105 x 4,0	101
M 110 x 1,5	108,5
M 110 x 2,0	108
M 110 x 3,0	107
M 110 x 4,0	106

BSW	Ø mm
W 3/32	1,8
W 1/8	2,6
W 5/32	3,1
W 3/16	3,6
W 7/32	4,4
W 1/4	5,1
W 5/16	6,5
W 3/8	7,9
W 7/16	9,3
W 1/2	10,5
W 9/16	12
W 5/8	13,5
W 3/4	16,5
W 7/8	19,25
W 1"	22
W 1.1/8	24,75
W 1.1/4	27,75
W 1.3/8	30,2
W 1.1/2	33,5
W 1.3/4	38,5
W 2"	44,5

RECOMMENDED TAPPING DRILL SIZES
PREFORI PER MASCHI RACCOMANDATO

BSF	Ø mm
BSF 1/4	5,2
BSF 5/16	6,6
BSF 3/8	8,1
BSF 7/16	9,5
BSF 1/2	11
BSF 5/8	14
BSF 3/4	16,5
BSF 7/8	19,5
BSF 1"	22,5

BSP G	Ø mm
G 1/8	8,8
G 1/4	11,8
G 3/8	15,25
G 1/2	19
G 5/8	21
G 3/4	24,5
G 7/8	28,25
G 1"	30,75
G 1.1/8	35,3
G 1.1/4	39,5
G 1.3/8	41,7
G 1.1/2	45,25
G 1.3/4	51,1
G 2"	57
G 2.1/4	63,1
G 2.1/2	72,6
G 2.3/4	78,9
G 3"	85,3

BA	Ø mm
BA 0	5,1
BA 1	4,5
BA 2	4
BA 3	3,4
BA 4	3
BA 5	2,65
BA 6	2,3

UNC	Ø mm
No. 1-64	1,5
No. 2-56	1,8
No. 3-48	2,1
No. 4-40	2,3
No. 5-40	2,6
No. 6-32	2,85
No. 8-32	3,5
No. 10-24	3,9
No. 12-24	4,5
1/4-20	5,2
5/16-18	6,6
5/16-18	6,6
3/8-16	8
7/16-14	9,4
1/2-13	10,8
9/16-12	12,2
5/8-11	13,5
3/4-10	16,5
7/8- 9	19,5
1"- 8	22,25
1.1/8- 7	25
1.1/4- 7	28,25
1.3/8- 6	30,75
1.1/2- 6	34
1.3/4- 5	39,5
2"- 4,5	45
2.1/4- 4,5	51,5
2.1/2- 4	57,25

UNC	Ø mm
2"- 4,5	45
2.1/4- 4,5	51,5
2.1/2- 4	57,25
2.3/4- 4	63,5
3"- 4	70
3.1/4- 4	76,2
3.1/2- 4	82,6

UNF	Ø mm
No. 0-80	1,3
No. 1-72	1,6
No. 2-64	1,9
No. 3-56	2,1
No. 4-48	2,4
No. 5-44	2,7
No. 6-40	3
No. 8-36	3,5
No. 10-32	4,1
No. 12-28	4,7
1/4-28	5,5
5/16-24	6,9
3/8-24	8,5
7/16-20	9,9
1/2-20	11,5
9/16-18	12,9
5/8-18	14,5
3/4-16	17,5
7/8-14	20,25
1"-12	23,25
1.1/8-12	26,5
1.1/4-12	29,5
1.3/8-12	32,5
1.1/2-12	36

12-UN	Ø mm
UN 1.5/8-12	39,2
UN 1.3/4-12	42,4
UN 1.7/8-12	45,6
UN 2"-12	48,75
UN 2.1/8-12	51,9
UN 2.1/4-12	55,1
UN 2.1/2-12	61,5
UN 2.3/4-12	67,8
UN 3"-12	74,2
UN 3.1/4-12	80,5
UN 3.1/2-12	86,9
UN 3.3/4-12	93,2
UN 4"-12	99,6

8-UN	Ø mm
UN 1.1/16-8	23,9
UN 1.1/8-8	25,5
UN 1.3/16-8	27,1
UN 1.1/4-8	28,75
UN 1.5/16-8	30,3
UN 1.3/8-8	31,75
UN 1.1/2-8	35
UN 1.5/8-8	38
UN 1.3/4-8	41,5
UN 1.7/8-8	44,5
UN 2"-8	47,75
UN 2.1/8-8	50,9
UN 2.1/4-8	54
UN 2.1/2-8	60,4
UN 2.3/4-8	66,7
UN 3"-8	73,1
UN 3.1/4-8	79,4
UN 3.1/2-8	85,8
UN 3.3/4-8	92,1
UN 4"-8	98,5

UN	Ø mm
UN 5/16-28	7
UN 3/8-20	8,3
UN 3/8-28	8,6
UN 7/16-32	10,3
UN 1/2-32	11,9
UN 9/16-20	10,9
UN 9/16-28	11,3
UN 9/16-32	11,4
UN 5/8-20	14,6
UN 5/8-28	15
UN 11/16-20	16,2
UN 11/16-16	15,9
UN 1"-32	24,6

UNEF	Ø mm
No. 12-32	4,75
1/4-32	5,6
5/16-32	7,2
3/8-32	8,8
7/16-28	10,25
1/2-28	11,8
9/16-24	13,3
5/8-24	14,9
11/16-24	16,5
3/4-20	17,75
13/16-20	19,5
7/8-20	21
15/16-20	22,5
1"-20	24,25
1.1/16-18	25,7
1.1/8-18	27,25
1.3/16-18	28,75
1.1/4-18	30,5
1.5/16-18	32
1.3/8-18	33,5
1.7/16-18	35,2
1.1/2-18	36,8
1.9/16-18	38,4
1.5/8-18	40
1.11/16-18	41,5
1.3/4-18	43
2"-18	49,4

UNS	Ø mm
UNS 1/4-24	5,4
UNS 1/4-36	5,7
UNS 1/4-40	5,75
UNS 3/8-27	8,35
UNS 7/16-24	10,1
UNS 1/2-24	11,75
UNS 5/8-27	14,7
UNS 3/4-24	18
UNS 7/8-18	21
UNS 1"-14	23,75

PG	Ø mm
PG 7	11,4
PG 9	14
PG 11	17,25
PG 13,5	19
PG 16	21,25
PG 21	26,75
PG 29	35,5
PG 36	45,5
PG 42	52,5
PG 48	58

NPT	Ø mm
1/16-27	6,3
1/8-27	8,5
1/4-18	11,2
3/8-18	14,5
1/2-14	18
3/4-14	23
1"-11,5	29
1.1/4-11,5	38
1.1/2-11,5	44
2"-11,5	56
2.1/2- 8	67
3- 8	83

W DIN 477	Ø mm
W 19,8	15,1
W 28,8	23,5
W 31,3	26,0

FG	Ø mm
FG 2 x 56	1,7
FG 2,3 x 56	1,9
FG 2,6 x 56	2,2
FG 6,35 x 26	5,5
FG 7,9 x 26	7
FG 9,5 x 26	8,6
FG 14,3 x 20	13,1
FG 14,3 x 20-LH	13,1
FG 25,4 x 24	24,5

BSC	Ø mm
BSC 1/4 x 26	5,5
BSC 5/16 x 26	7
BSC 3/8 x 26	8,6
BSC 9/16 x 20	13,1
BSC 9/16 x 20 LH	13,1
BSC 1" x 24	24,5

Vg	Ø mm
Vg 5 x 36	4,7
Vg 5,2 x 24	4,3
Vg 6 x 32	5,4
Vg 8 x 32	6,9
Vg 10 x 28	9,4
Vg 12 x 26	11,2

Rd	Ø mm
Rd 8 x 1/10	6
Rd 9 x 1/10	7
Rd 10 x 1/10	8
Rd 11 x 1/10	9
Rd 12 x 1/10	10
Rd 14 x 1/8	11,5
Rd 16 x 1/8	13,5
Rd 18 x 1/8	15,5
Rd 20 x 1/8	17,5
Rd 22 x 1/8	19,5
Rd 24 x 1/8	21,5
Rd 26 x 1/8	23,5
Rd 28 x 1/8	25,5
Rd 30 x 1/8	27,5
Rd 32 x 1/8	29,5
Rd 34 x 1/8	31,5
Rd 36 x 1/8	33,5
Rd 38 x 1/8	35,5
Rd 40 x 1/6	36,6
Rd 42 x 1/6	38,6
Rd 44 x 1/6	40,6

Tr	Ø mm
Tr 10 x 2	8,2
Tr 10 x 3	7,5
Tr 12 x 3	9,25
Tr 14 x 3	11,25
Tr 14 x 4	10,5
Tr 16 x 4	12,25
Tr 18 x 4	14,25
Tr 20 x 4	16,25
Tr 22 x 4	18,25
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