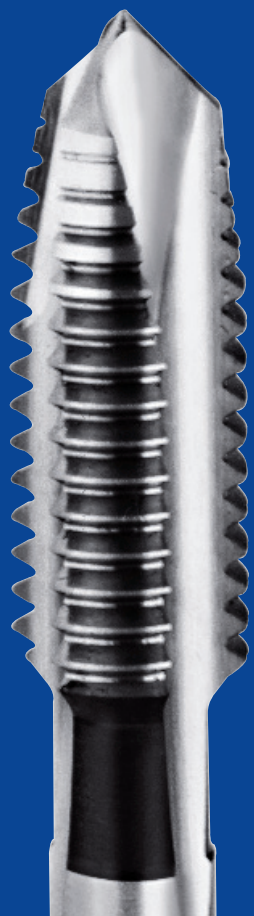
Gewindebohrer

Taps



ILIX PRECISION

Gewindebohrer
Taps

▶ Zeichenerklärung
Key to symbols

SCHNEIDSTOFF / TOOL MATERIAL

- HSS-Co
- HSS-Co PM
- HSS

BESCHICHTUNG / COATING

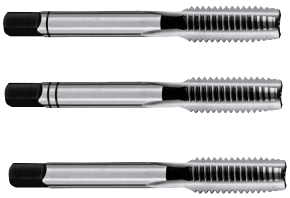
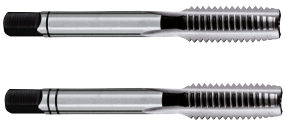
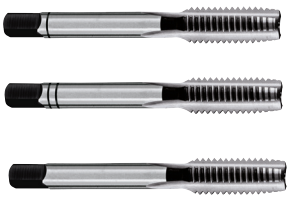
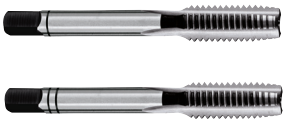
- Unbeschichtet / Blank
- TN — TiN
- TF — TiAlN Futura
- TC — TiCN
- HL — Hard Lube
- XP — XP TOP
- TX — TiNOX

OBERFLÄCHENBEHANDLUNGEN / SURFACE TREATMENT

- VP — Vaporizzato / Vaporized
- Nitrurato / Nitrided

▶ Werkzeug-Auswahlhilfe
Tool selection guide

HAND-GEWINDEBOHRER / HAND TAPS

KAT.-NR. ITEM	SIMBOL SYMBOL	Ø mm	DIN	SACKLOCH / DURCHGANGSLOCH Blind hole/ Through hole	TOLERANZ TOLERANCE	DRALLWINKEL HELIX ANGLE	ANSCHNITT FORM CHAMFER FORM
N							
6615 	**M**	1 ÷ 68	**352**		6H	0°	C
6608 Sätze in Metallkassetten / Sets in metal cases with tap drills 	**M**	3 ÷ 12	**352**		6H	0°	C
6609 Sätze in Metallkassetten / Sets in metal cases with tap drills 	**M**	3 ÷ 12	**352**		6H	0°	C
6618 	**M**	3 ÷ 20	**352**		6H	0°	C
6633 	**MF**	2 ÷ 52	**2181**		6H	0°	C
6775 	**UNC**	1 ÷ 2	**352***		2B	0°	C
6776 	**UNF**	3 ÷ 7/16	**2181***		2B	0°	C
6603 	**BSW/W**	1/16 ÷ 2	**352***		-	0°	C
6627 	**BSP/G**	1/16 ÷ 2	**5157**		-	0°	C

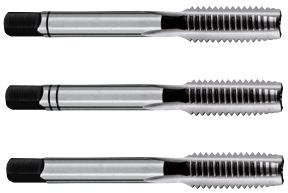
* **Abmessungen ähnlich DIN 352/2181** - Dimension similar to DIN 352/2181

HAND-GEWINDEBOHRER / HAND TAPS

BESCHICHTUNG COATING	KÜHLUNG INTERNAL COOLANT	SCHNEIDRICHTUNG CUTTING DIRECT.	SCHNEIDSTOFF TOOL MATERIAL	P	M	K	N	S	H	Seite Page
-	-		HSS	●	●	●	●	❍	-	504
-	-		HSS	●	●	●	●	❍	-	508
-	-		HSS	●	●	●	●	❍	-	509
-	-		HSS	●	●	●	●	❍	-	504
-	-		HSS	●	●	●	●	❍	-	552
-	-		HSS	●	●	●	●	❍	-	569
-	-		HSS	●	●	●	●	❍	-	581
-	-		HSS	●	●	●	●	❍	-	594
-	-		HSS	●	●	●	●	❍	-	598

HSS-CO

HAND-GEWINDEBOHRER / HAND TAPS

KAT.-NR. ITEM	SIMBOL SYMBOL	Ø mm	DIN	SACKLOCH / DURCHGANGSLOCH Blind hole/ Through hole	TOLERANZ TOLERANCE	DRALLWINKEL HELIX ANGLE	ANSCHNITT FORM CHAMFER FORM
VA							
6614 	**M**	2 ÷ 20	**352**		6HX	0°	C
Ti							
6625 	**M**	2 ÷ 20	**352**		6HX	0°	C

HSS-CO

KURZE MASCHINEN-GEWINDEBOHRER / SHORT MACHINE TAPS

N							
6678 	**M**	2 ÷ 20	**352**		6H	0°	C
6659 	**M**	3 ÷ 20	**352**		6H	15°	C
6639 	**M**	3 ÷ 20	**352**		6H	40°	C
6604 	**M**	3 ÷ 24	**352**		6H-6G	40°	C
6899 	**MF**	6 ÷ 20	**2181**		6H	0°	C
6656 	**MF**	4 ÷ 24	**2181**		6H	15°	C
6858 	**BSP/G**	1/16 ÷ 1-1/2	**5157**		-	0°	C
6905 	**BSP/G**	1/8 ÷ 3/4	**5157**		+0,1	15°	C

HAND-GEWINDEBOHRER / HAND TAPS

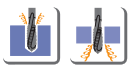
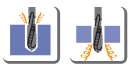
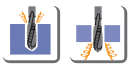
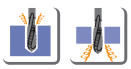
BESCHICHTUNG COATING	KÜHLUNG INTERNAL COOLANT	SCHNEIDRICHTUNG CUTTING DIRECT.	SCHNEIDSTOFF TOOL MATERIAL	P	M	K	N	S	H	Seite Page
-	-		HSS-CO	❍	●	-	●	●	-	505
-	-		HSS-CO	-	●	-	-	●	-	505

HSS-CO
KURZE MASCHINEN-GEWINDEBOHRER / SHORT MACHINE TAPS

-	-		HSS-Co	●	-	●	-	-	-	510
-	-		HSS-Co	●	-	●	-	-	-	510
-	-		HSS-Co	●	-	●	-	-	-	510
-	-		HSS-Co	●	-	●	-	-	-	510
-	-		HSS-Co	●	-	●	-	-	-	554
-	-		HSS-Co	●	-	●	-	-	-	554
-	-		HSS-Co	●	-	●	-	-	-	599
-	-		HSS-Co	●	❍	●	●	-	-	599

HSS-CO

KURZE MASCHINEN-GEWINDEBOHRER / SHORT MACHINE TAPS

KAT.-NR. ITEM	SIMBOL SYMBOL	Ø mm	DIN	SACKLOCH / DURCHGANGSLOCH Blind hole/ Through hole	TOLERANZ TOLERANCE	DRALLWINKEL HELIX ANGLE	ANSCHNITT FORM CHAMFER FORM
RAPID							
6679 	**M**	2 ÷ 20	**352**		6H	0°	B
VA							
6648 	**M**	3 ÷ 16	**352**		6HX	15°	C
6612 	**M**	3 ÷ 16	**352**		6HX	15°	C
6857 	**BSP/G**	1/16 ÷ 1/2	**5157**		-	0°	B
6951 	**BSP/G**	1/16 ÷ 1	**5157**		-	15°	**E**
MS							
6624 	**M**	2 ÷ 12	**352**		6H	0°	C
6724 	**MF**	4 ÷ 12	**2181**		6H	0°	C
6913 	**BSP/G**	1/16 ÷ 1" 1/2	**5157**		-	0°	**E**
AZ							
6621 	**M**	3 ÷ 16	**352**		6H	0°	C
6613 	**M**	3 ÷ 16	**352**		6H	0°	B

HSS-CO

MASCHINEN-GEWINDEBOHRER / MACHINE TAPS

RAPID							
6707 	**M**	2 ÷ 10	**371**		6H-6G 4H-**7G**	0°	B
6711 	**M**	2 ÷ 52	**376**		6H-6G **7G**	0°	B

HSS-CO

KURZE MASCHINEN-GEWINDEBOHRER / SHORT MACHINE TAPS

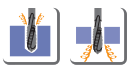
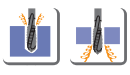
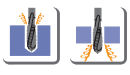
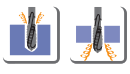
BESCHICHTUNG COATING	KÜHLUNG INTERNAL COOLANT	SCHNEIDRICHTUNG CUTTING DIRECT.	SCHNEIDSTOFF TOOL MATERIAL	P	M	K	N	S	H	Seite Page
-	-		HSS-Co	●	-	●	-	-	-	510
-	-		HSS-Co	❍	●	❍	-	❍	-	511
-	-		HSS-Co	❍	●	❍	-	❍	-	511
-	-		HSS-Co	❍	●	❍	-	❍	-	600
-	-		HSS-Co	❍	●	❍	-	❍	-	599
-	-		HSS-Co	-	-	❍	●	-	-	511
-	-		HSS-Co	-	-	❍	●	-	-	554
-	-		HSS-Co	-	-	❍	●	-	-	599
-	-		HSS-Co	-	❍	-	●	-	-	510
-	-		HSS-Co	-	❍	-	●	-	-	510

HSS-CO

MASCHINEN-GEWINDEBOHRER / MACHINE TAPS

TN TC	-		HSS-Co	●	❍	❍	●	-	-	520
TN TC	-		HSS-Co	●	❍	❍	●	-	-	536

MASCHINEN-GEWINDEBOHRER / MACHINE TAPS

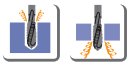
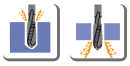
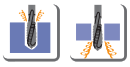
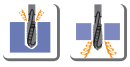
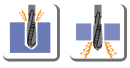
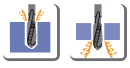
KAT.-NR. ITEM	SIMBOL SYMBOL	Ø mm	DIN	SACKLOCH / DURCHGANGSLOCH Blind hole/ Through hole	TOLERANZ TOLERANCE	DRALLWINKEL HELIX ANGLE	ANSCHNITT FORM CHAMFER FORM
RAPID							
6730 	**MF**	3 ÷ 52	**374**		6H	0°	B
6690 	**UNC**	1 ÷ 3/8	**2184/1**		2B-3B	0°	B
6693 	**UNC**	7/16 ÷ 2	**2184/1**		2B-3B	0°	B
6607 	**UNF**	1 ÷ 3/8	**2184/1**		2B-3B	0°	B
6687 	**UNF**	7/16 ÷ 1 1/2	**2184/1**		2B-3B	0°	B
6697 	**BSW/W**	1/8 ÷ 3/8	**371***		-	0°	B
6636 	**BSW/W**	7/16 ÷ 1x8	**376***		-	0°	B
6704 	**BSP/G**	1/16 ÷ 2X11	**5156**		-	0°	B
6673 	**RP**	1/16 ÷ 2	**5156**		-	0°	B
6710 	**PG**	7 ÷ 48	**40 432**		-	0°	B
RAPID 2							
6640 	**M**	2 ÷ 10	**371**		6H-6G	0°	B
N ■ Gerade genutet / Straight Flutes							
6706 	**M**	1 ÷ 10	**371**		6H	0°	C
6705 	**M**	2 ÷ 52	**376**		6H	0°	C
6726 	**MF**	3 ÷ 52	**374**		6H	0°	C
6823 	**UNC**	3 ÷ 3/8	**2184/1**		2B	0°	C

* **Abmessungen ähnlich DIN 352/2181** - Dimension similar to DIN 352/2181

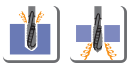
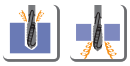
BESCHICHTUNG COATING	KÜHLUNG INTERNAL COOLANT	SCHNEIDRICHTUNG CUTTING DIRECT.	SCHNEIDSTOFF TOOL MATERIAL	P	M	K	N	S	H	Seite Page
TN TC	-		HSS-Co	●	❍	❍	●	-	-	564
TN	-		HSS-Co	●	❍	❍	●	-	-	572
-	-		HSS-Co	●	❍	❍	●	-	-	578
TN	-		HSS-Co	●	❍	❍	●	-	-	584
-	-		HSS-Co	●	❍	❍	●	-	-	592
-	-		HSS-Co	●	❍	❍	●	-	-	595
-	-		HSS-Co	●	❍	❍	●	-	-	596
TN	-		HSS-Co	●	❍	❍	●	-	-	604
-	-		HSS-Co	●	❍	❍	●	-	-	597
-	-		HSS-Co	●	❍	❍	●	-	-	610
-	-		HSS-Co	●	❍	❍	●	-	-	521
TN TC	-		HSS-Co	●	-	❍	●	-	-	512
TN TC	-		HSS-Co	●	-	❍	●	-	-	530
TN TC	-		HSS-Co	●	-	❍	●	-	-	556
-	-		HSS-Co	●	-	❍	●	-	-	570

MASCHINEN-GEWINDEBOHRER / MACHINE TAPS

N ■ Gerade genutet / Straight Flutes

KAT.-NR. ITEM	SIMBOL SYMBOL	Ø mm	DIN	SACKLOCH / DURCHGANGSLOCH Blind hole/ Through hole	TOLERANZ TOLERANCE	DRALLWINKEL HELIX ANGLE	ANSCHNITT FORM CHAMFER FORM
6824 	UNC	7/16 ÷ 1	2184/1		2B	0°	C
6838 	UNF	1 ÷ 3/8	2184/1		2B	0°	C
6839 	UNF	7/16 ÷ 1 1/2	2184/1		2B	0°	C
6699 	BSW/W	1/8 ÷ 3/8	371*		-	0°	C
6610 	NPT	1/16 ÷ 2x1	2181*		-	0°	C
6611 	NPTF	1/16 ÷ 1 1/2	2181*		-	0°	C
6915 	PG	7 ÷ 48	40 432		-	0°	C
6914 	PG	7 ÷ 36	40 432		-	0°	D
6790 	RC	1/8 ÷ 1	5156*		-	0°	C

N SX ■ Linksschneidend / Left hand thread

6712 	M	3 ÷ 10	371		6H	0°	C
6859 	M	3 ÷ 10	371		6H	0°	B
6861 	M	3 ÷ 10	371		6H	40°	C
6715 	M	12 ÷ 24	376		6H	0°	C
6860 	M	12 ÷ 20	376		6H	0°	B
6862 	M	12 ÷ 20	376		6H	40°	C
6863 	MF	8 ÷ 20	374		6H	0°	B

* **Abmessungen ähnlich DIN 352/2181** - Dimension similar to DIN 352/2181

MASCHINEN-GEWINDEBOHRER / MACHINE TAPS

BESCHICHTUNG COATING	KÜHLUNG INTERNAL COOLANT	SCHNEIDRICHTUNG CUTTING DIRECT.	SCHNEIDSTOFF TOOL MATERIAL	P	M	K	N	S	H	Seite Page
-	-		HSS-Co	●	-	❍	●	-	-	576
-	-		HSS-Co	●	-	❍	●	-	-	582
-	-		HSS-Co	●	-	❍	●	-	-	588
-	-		HSS-Co	●	-	❍	●	-	-	595
-	-		HSS-Co	●	-	❍	●	-	-	607
-	-		HSS-Co	●	-	❍	●	-	-	607
-	-		HSS-Co	●	-	❍	●	-	-	610
-	-		HSS-Co	●	-	❍	●	-	-	611
-	-		HSS-Co	●	-	❍	●	-	-	606
-	-		HSS-Co	●	❍	❍	●	-	-	512
-	-		HSS-Co	●	❍	❍	●	-	-	521
-	-		HSS-Co	●	❍	❍	●	-	-	515
-	-		HSS-Co	●	❍	❍	●	-	-	530
-	-		HSS-Co	●	❍	❍	●	-	-	537
-	-		HSS-Co	●	❍	❍	●	-	-	531
-	-		HSS-Co	●	❍	❍	●	-	-	564

MASCHINEN-GEWINDEBOHRER / MACHINE TAPS

KAT.-NR. ITEM	SIMBOL SYMBOL	Ø mm	DIN	SACKLOCH / DURCHGANGSLOCH Blind hole/ Through hole	TOLERANZ TOLERANCE	DRALLWINKEL HELIX ANGLE	ANSCHNITT FORM CHAMFER FORM
N SX ■ Linksschneidend / Left hand thread							
6864 	**MF**	8 ÷ 20	**374**		6H	40°	C
NL ■ 15° Linksdrall, rechtsschneidend / 15° left flute right hand thread							
6727 	**M**	3 ÷ 10	**371**		6H	15°	D
6740 	**M**	12 ÷ 20	**376**		6H	15°	B
6741 	**MF**	8 ÷ 20	**374**		6H	15°	B
N 15°							
6657 	**M**	2 ÷ 10	**371**		6H-6G	15°	C
6902 	**M**	3 ÷ 10	**371**		6H+**0,1**	15°	C
6658 	**M**	8 ÷ 30	**376**		6H	15°	C
6903 	**M**	12 ÷ 20	**376**		6H+**0,1**	15°	C
6664 	**MF**	8 ÷ 30	**374**		6H	15°	C
6904 	**MF**	16 ÷ 24	**374**		6H+**0,1**	15°	**E**
6696 	**UNC**	nr. 3 ÷ 3/8	**2184/1**		2B	15°	C
6728 	**UNC**	7/16 ÷ 1x8	**2184/1**		2B	15°	C
6719 	**UNF**	nr. 5 ÷ 3/8	**2184/1**		2B	15°	C
6729 	**UNF**	7/16 ÷ 1x12	**2184/1**		2B	15°	C
6665 	**BSP/G**	1/16 ÷ 1x11	**5156**		-	15°	C

MASCHINEN-GEWINDEBOHRER / MACHINE TAPS

BESCHICHTUNG COATING	KÜHLUNG INTERNAL COOLANT	SCHNEIDRICHTUNG CUTTING DIRECT.	SCHNEIDSTOFF TOOL MATERIAL	P	M	K	N	S	H	Seite Page
-	-		HSS-Co	●	❍	❍	●	-	-	557
-	-		HSS-Co	●	❍	❍	●	-	-	523
-	-		HSS-Co	●	❍	❍	●	-	-	538
-	-		HSS-Co	●	❍	❍	●	-	-	564
TN TC	-		HSS-Co	●	❍	●	●	-	-	513
-	-		HSS-Co	●	❍	●	●	-	-	513
TN TC	-		HSS-Co	●	❍	●	●	-	-	530
-	-		HSS-Co	●	❍	●	●	-	-	530
TN TC	-		HSS-Co	●	❍	●	●	-	-	556
-	-		HSS-Co	●	❍	●	●	-	-	557
-	-		HSS-Co	●	❍	●	●	-	-	570
-	-		HSS-Co	●	❍	●	●	-	-	576
-	-		HSS-Co	●	❍	●	●	-	-	582
-	-		HSS-Co	●	❍	●	●	-	-	588
-	-		HSS-Co	●	❍	●	●	-	-	601

MASCHINEN-GEWINDEBOHRER / MACHINE TAPS

KAT.-NR. ITEM	SIMBOL SYMBOL	Ø mm	DIN	SACKLOCH / DURCHGANGSLOCH Blind hole/ Through hole	TOLERANZ TOLERANCE	DRALLWINKEL HELIX ANGLE	ANSCHNITT FORM CHAMFER FORM
N 15°							
6675 	**RP**	1/8 ÷ 1	**5156**		-	15°	C
N 40°							
6644 	**M**	2 ÷ 10	**371**		6H-6G 7G	40°	C
6867 	**M**	3 ÷ 10	**371**		6H	40°	E
6638 	**M**	3 ÷ 36	**376**		6H-6G 7G	40°	C
6868 	**M**	12 ÷ 20	**376**		6H	40°	E
6652 	**MF**	3 ÷ 30	**374**		6H	40°	C
6877 	**MF**	6 ÷ 20	**374**		6H	40°	E
6691 	**UNC**	2 ÷ 3/8	**2184/1**		2B-3B	40°	C
6694 	**UNC**	7/16 ÷ 1x8	**2184/1**		2B-3B	40°	C
6680 	**UNF**	5 ÷ 3/8	**2184/1**		2B-3B	40°	C
6688 	**UNF**	7/16 ÷ 1	**2184/1**		2B-3B	40°	C
6836 	**BSW/W**	1/8 ÷ 1 3/8	**371***		-	40°	C
6837 	**BSW/W**	7/16 ÷ 1	**376***		-	40°	C
6703 	**BSP/G**	1/16 ÷ 1	**5156**		-	40°	C

MASCHINEN-GEWINDEBOHRER / MACHINE TAPS

BESCHICHTUNG COATING	KÜHLUNG INTERNAL COOLANT	SCHNEIDRICHTUNG CUTTING DIRECT.	SCHNEIDSTOFF TOOL MATERIAL	P	M	K	N	S	H	Seite Page
-	-		HSS-Co	●	❍	●	●	-	-	597
TN TC	-		HSS-Co	●	❍	●	●	-	-	514
-	-		HSS-Co	●	❍	●	●	-	-	515
TN TC	-		HSS-Co	●	❍	●	●	-	-	531
-	-		HSS-Co	●	❍	●	●	-	-	531
TN TC	-		HSS-Co	●	❍	●	●	-	-	557
-	-		HSS-Co	●	❍	●	●	-	-	557
TN	-		HSS-Co	●	❍	●	●	-	-	570
-	-		HSS-Co	●	❍	●	●	-	-	576
TN	-		HSS-Co	●	❍	●	●	-	-	582
-	-		HSS-Co	●	❍	●	●	-	-	588
-	-		HSS-Co	●	❍	●	●	-	-	595
-	-		HSS-Co	●	❍	●	●	-	-	596
TN	-		HSS-Co	●	❍	●	●	-	-	601

MASCHINEN-GEWINDEBOHRER / MACHINE TAPS

KAT.-NR. ITEM	SIMBOL SYMBOL	Ø mm	DIN	SACKLOCH / DURCHGANGSLOCH Blind hole/ Through hole	TOLERANZ TOLERANCE	DRALLWINKEL HELIX ANGLE	ANSCHNITT FORM CHAMFER FORM
VA							
6646 NEW XP	M	2 ÷ 10	371		6HX-6GX	0°	B
6654 NEW XP	M	2 ÷ 10	371		6HX	15°	C
6661 NEW XP	M	2 ÷ 10	371		6HX-6GX	35°	C
6647 NEW XP	M	12 ÷ 24	376		6HX-6GX	0°	B
6634	M	12 ÷ 24	376		6HX	15°	C
6662 NEW XP	M	12 ÷ 24	376		6HX-6GX	35°	C
6663 NEW XP	MF	8 ÷ 30	374		6HX-6GX	0°	B
6671	MF	8 ÷ 30	374		6HX	15°	C
6655 NEW XP	MF	8 ÷ 30	374		6HX-6GX	35°	C
6739 NEW XP	UNC	nr. 2 ÷ 3/8	2184/1		2BX	0°	B
6735 NEW XP	UNC	nr. 6 ÷ 3/8	2184/1		2BX	35°	C
6749	UNC	1/2 ÷ 1	2184/1		2BX	0°	B
6754	UNC	1/2 ÷ 1	2184/1		2BX	35°	C
6718	UNF	nr. 2 ÷ 3/8	2184/1		2BX	0°	B
6794	UNF	10x32 ÷ 3/8	2184/1		2BX	35°	C
6797	UNF	7/16 ÷ 3/4	2184/1		2BX	0°	B
6796	UNF	7/16 ÷ 3/4	2184/1		2BX	35°	C
6945 NEW	UN-8	1 1/8 ÷ 1 1/2	2184/1		2BX	35°	C

MASCHINEN-GEWINDEBOHRER / MACHINE TAPS

BESCHICHTUNG COATING	KÜHLUNG INTERNAL COOLANT	SCHNEIDRICHTUNG CUTTING DIRECT.	SCHNEIDSTOFF TOOL MATERIAL	P	M	K	N	S	H	Seite Page
TN TX XP	-		HSS-Co	❍	●	❍	●	❍	-	524
XP	-		HSS-Co	❍	●	❍	●	❍	-	516
TN TX XP	-		HSS-Co	❍	●	❍	●	❍	-	517
XP	-		HSS-Co	❍	●	❍	●	❍	-	538
-	-		HSS-Co	❍	●	❍	●	❍	-	532
TX XP	-		HSS-Co	❍	●	❍	●	❍	-	533
TN XP	-		HSS-Co	❍	●	❍	●	❍	-	565
-	-		HSS-Co	❍	●	❍	●	❍	-	560
XP	-		HSS-Co	❍	●	❍	●	❍	-	560
XP	-		HSS-Co	❍	●	❍	●	❍	-	573
XP	-		HSS-Co	❍	●	❍	●	❍	-	571
-	-		HSS-Co	❍	●	❍	●	❍	-	578
-	-		HSS-Co	❍	●	❍	●	❍	-	577
-	-		HSS-Co	❍	●	❍	●	❍	-	585
-	-		HSS-Co	❍	●	❍	●	❍	-	583
-	-		HSS-Co	❍	●	❍	●	❍	-	592
-	-		HSS-Co	❍	●	❍	●	❍	-	589
-	-		HSS-Co	❍	●	❍	●	❍	-	590

MASCHINEN-GEWINDEBOHRER / MACHINE TAPS

KAT.-NR. ITEM	SIMBOL SYMBOL	Ø mm	DIN	SACKLOCH / DURCHGANGSLOCH Blind hole/ Through hole	TOLERANZ TOLERANCE	DRALLWINKEL HELIX ANGLE	ANSCHNITT FORM CHAMFER FORM
VA							
6700 NEW XP	**BSP/G**	1/16 ÷ 1	**5156**		-	0°	B
6716	**BSP/G**	1/16 ÷ 1	**5156**		-	15°	C
6701 NEW XP	**BSP/G**	1/16 ÷ 1	**5156**		-	35°	C
VA i 15° ■ Mit Innenkühlung / With internal coolant							
6620 NEW XP	**M**	6 ÷ 10	**371**		6HX	15°	C
6605 NEW XP	**M**	12 ÷ 20	**376**		6HX	15°	C
6626 NEW XP	**M**	8 ÷ 20	**374**		6HX	15°	C
VR 50°							
6850	**M**	2 ÷ 10	**371**		6HX	50°	C
6851	**M**	12 ÷ 24	**376**		6HX	50°	C
6852	**UNC**	nr. 6 ÷ 3/8	**2181-1**		2BX	50°	C
6853	**UNC**	1/2 ÷ 1	**2181-1**		2BX	50°	C
6854	**UNF**	nr. 10 ÷ 3/8	**2181-1**		2BX	50°	C
6855	**UNF**	7/16 ÷ 3/4	**2181-1**		2BX	50°	C
6856	**BSP/G**	1/16 ÷ 1	**5156**		-	50°	C

MASCHINEN-GEWINDEBOHRER / MACHINE TAPS

BESCHICHTUNG COATING	KÜHLUNG INTERNAL COOLANT	SCHNEIDRICHTUNG CUTTING DIRECT.	SCHNEIDSTOFF TOOL MATERIAL	P	M	K	N	S	H	Seite Page
XP	-		HSS-Co	❍	●	❍	●	❍	-	605
-	-		HSS-Co	❍	●	❍	●	❍	-	602
XP	-		HSS-Co	❍	●	❍	●	❍	-	602
XP	-		HSS-Co	❍	●	❍	●	❍	-	516
XP	-		HSS-Co	❍	●	❍	●	❍	-	532
XP	-		HSS-Co	❍	●	❍	●	❍	-	560
TN	-		HSS-Co	❍	●	-	❍	-	-	517
TN	-		HSS-Co	❍	●	-	❍	-	-	533
-	-		HSS-Co	❍	●	-	❍	-	-	571
-	-		HSS-Co	❍	●	-	❍	-	-	577
-	-		HSS-Co	❍	●	-	❍	-	-	583
-	-		HSS-Co	❍	●	-	❍	-	-	589
-	-		HSS-Co	❍	●	-	❍	-	-	602

MASCHINEN-GEWINDEBOHRER / MACHINE TAPS

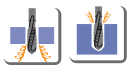
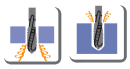
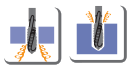
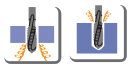
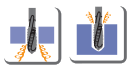
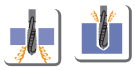
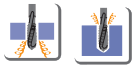
HD

KAT.-NR. ITEM	SIMBOL SYMBOL	Ø mm	DIN	SACKLOCH / DURCHGANGSLOCH Blind hole/ Through hole	TOLERANZ TOLERANCE	DRALLWINKEL HELIX ANGLE	ANSCHNITT FORM CHAMFER FORM
6870 	**M**	2 ÷ 10	**371**		6H	0°	B
6878 	**M**	3 ÷ 10	**371**		6H	15°	C
6666 	**M**	3 ÷ 10	**371**		4H-6H-6G	40°	C
6871 	**M**	12 ÷ 30	**376**		6H	0°	B
6879 	**M**	12 ÷ 30	**376**		6H	15°	C
6667 	**M**	3 ÷ 20	**376**		6H	40°	C
6872 	**MF**	6 ÷ 24	**374**		6H	0°	B
6880 	**MF**	6 ÷ 24	**374**		6H	15°	C
6873 	**UNC**	nr. 2 ÷ 3/8	**2184/1**		2B	0°	B
6865 	**UNC**	nr. 3 ÷ 3/8	**2184/1**		2B	15°	C
6874 	**UNC**	7/16 ÷ 1x8	**2184/1**		2B	0°	B
6866 	**UNC**	7/16 ÷ 1x8	**2184/1**		2B	15°	C
6875 	**UNF**	nr. 2 ÷ 3/8	**2184/1**		2B	0°	B
6848 	**UNF**	nr. 5 ÷ 3/8	**2184/1**		2B	15°	C
6876 	**UNF**	7/16 ÷ 1	**2184/1**		2B	0°	B
6849 	**UNF**	7/16 ÷ 1	**2184/1**		2B	15°	C
6912 	**BSP/G**	1/16 ÷ 2	**5156**		-	0°	C

MASCHINEN-GEWINDEBOHRER / MACHINE TAPS

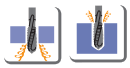
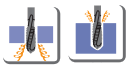
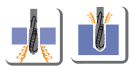
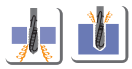
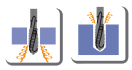
BESCHICHTUNG COATING	KÜHLUNG INTERNAL COOLANT	SCHNEIDRICHTUNG CUTTING DIRECT.	SCHNEIDSTOFF TOOL MATERIAL	P	M	K	N	S	H	Seite Page
TN TF	-		HSS-Co	●	-	●	-	-	-	525
HL	-		HSS-Co	●	-	●	-	-	❍	513
TN TF	-		HSS-Co	●	-	●	-	-	-	519
TN TF	-		HSS-Co	●	-	●	-	-	-	539
HL	-		HSS-Co	●	-	●	-	-	❍	535
TN TF	-		HSS-Co	●	-	●	-	-	-	535
TN	-		HSS-Co	●	-	●	-	-	-	565
HL	-		HSS-Co	●	-	●	-	-	❍	561
-	-		HSS-Co	●	-	●	-	-	-	572
-	-		HSS-Co	●	-	●	-	-	-	571
-	-		HSS-Co	●	-	●	-	-	-	578
-	-		HSS-Co	●	-	●	-	-	-	577
-	-		HSS-Co	●	-	●	-	-	-	585
-	-		HSS-Co	●	-	●	-	-	-	583
-	-		HSS-Co	●	-	●	-	-	-	592
-	-		HSS-Co	●	-	●	-	-	-	589
TN	-		HSS-Co	●	-	●	-	-	-	601

MASCHINEN-GEWINDEBOHRER / MACHINE TAPS

KAT.-NR. ITEM	SIMBOL SYMBOL	Ø mm	DIN	SACKLOCH / DURCHGANGSLOCH Blind hole/ Through hole	TOLERANZ TOLERANCE	DRALLWINKEL HELIX ANGLE	ANSCHNITT FORM CHAMFER FORM
HD							
6917 	**NPT**	1/16 ÷ 1/4	**371**		-	0°	C
6918 	**NPT**	3/8 ÷ 1 1/2	**376**		-	0°	C
6923 	**NPTF**	1/16 ÷ 1/4	**371**		-	0°	C
6924 	**NPTF**	3/8 ÷ 1 1/2	**374**		-	0°	C
HR							
6681 	**M**	3 ÷ 10	**371**		6H	40°	C
6689 	**M**	12 ÷ 20	**376**		6H	40°	C
GG							
6631 	**M**	3 ÷ 10	**371**		6HX	0°	C
6632 	**M**	6 ÷ 30	**376**		6HX	0°	C
6653 	**MF**	8 ÷ 30	**374**		6HX	0°	C
6708 	**BSP/G**	1/16 ÷ 2	**5157**		-	0°	C
6674 	**RP**	1/8 ÷ 2	**5156**		-	0°	C
GG i							
6629 	**M**	5 ÷ 10	**371**		6HX	0°	C
6637 	**M**	12 ÷ 20	**376**		6HX	0°	C

BESCHICHTUNG COATING	KÜHLUNG INTERNAL COOLANT	SCHNEIDRICHTUNG CUTTING DIRECT.	SCHNEIDSTOFF TOOL MATERIAL	P	M	K	N	S	H	Seite Page
TN	-		HSS-Co	●	-	●	-	-	-	608
-	-		HSS-Co	●	-	●	-	-	-	609
-	-		HSS-Co	●	-	●	-	-	-	608
-	-		HSS-Co	●	-	●	-	-	-	609
TF	-		HSS-Co	●	-	❍	-	-	-	519
TF	-		HSS-Co	●	-	❍	-	-	-	535
TF	-		HSS-Co	-	-	●	❍	-	-	518
TF	-		HSS-Co	-	-	●	❍	-	-	534
-	-		HSS-Co	-	-	●	❍	-	-	561
TF	-		HSS-Co	-	-	●	❍	-	-	603
-	-		HSS-Co	-	-	●	❍	-	-	597
TC			HSS-Co	-	-	●	❍	-	-	518
TC			HSS-Co	-	-	●	❍	-	-	534

MASCHINEN-GEWINDEBOHRER / MACHINE TAPS

KAT.-NR. ITEM	SIMBOL SYMBOL	Ø mm	DIN	SACKLOCH / DURCHGANGSLOCH Blind hole/ Through hole	TOLERANZ TOLERANCE	DRALLWINKEL HELIX ANGLE	ANSCHNITT FORM CHAMFER FORM
AZ							
6820 	**M**	2 ÷ 10	**371**		6H	0°	C
6616 	**M**	2 ÷ 10	**371**		6H	0°	B
6821 	**M**	6 ÷ 24	**376**		6H	0°	C
6617 	**M**	12 ÷ 20	**376**		6H	0°	B
6916 	**NPT**	1/16 ÷ 2	**371**		-	0°	C
6919 	**NPT**	1/16 ÷ 1/4	**371**		-	0°	C
6920 	**NPT**	3/8 ÷ 1 1/2	**376**		-	0°	C
6921 	**NPT**	1/16 ÷ 1/4	**371**		-	35°	C
6922 	**NPT**	3/8 ÷ 1 1/2	**376**		-	35°	C
6925 	**NPTF**	1/16 ÷ 1/4	**374**		-	35°	C
6926 	**NPTF**	3/8 ÷ 1 1/2	**374**		-	35°	C
ALU							
6641 	**M**	2 ÷ 10	**371**		6H	0°	B
6643 	**M**	2 ÷ 10	**371**		6H	45°	C
6642 	**M**	12 ÷ 20	**376**		6H	0°	B
6651 	**M**	12 ÷ 20	**376**		6HX	45°	C
6731 	**MF**	8 ÷ 20	**374**		6H	45°	C

MASCHINEN-GEWINDEBOHRER / MACHINE TAPS

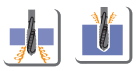
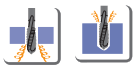
BESCHICHTUNG COATING	KÜHLUNG INTERNAL COOLANT	SCHNEIDRICHTUNG CUTTING DIRECT.	SCHNEIDSTOFF TOOL MATERIAL	P	M	K	N	S	H	Seite Page
-	-		HSS-Co	❍	-	-	●	-	-	513
-	-		HSS-Co	❍	-	-	●	-	-	523
-	-		HSS-Co	❍	-	-	●	-	-	530
-	-		HSS-Co	❍	-	-	●	-	-	538
-	-		HSS-Co	❍	-	-	●	-	-	607
-	-		HSS-Co	❍	-	-	●	-	-	608
-	-		HSS-Co	❍	-	-	●	-	-	609
TN	-		HSS-Co	❍	-	-	●	-	-	608
-	-		HSS-Co	❍	-	-	●	-	-	609
-	-		HSS-Co	❍	-	-	●	-	-	608
-	-		HSS-Co	❍	-	-	●	-	-	609
-	-		HSS-Co	-	-	-	●	-	-	525
-	-		HSS-Co	-	-	-	●	-	-	518
-	-		HSS-Co	-	-	-	●	-	-	539
-	-		HSS-Co	-	-	-	●	-	-	534
-	-		HSS-Co	-	-	-	●	-	-	561

MASCHINEN-GEWINDEBOHRER / MACHINE TAPS

KAT.-NR. ITEM	SIMBOL SYMBOL	Ø mm	DIN	SACKLOCH / DURCHGANGSLOCH Blind hole/ Through hole	TOLERANZ TOLERANCE	DRALLWINKEL HELIX ANGLE	ANSCHNITT FORM CHAMFER FORM
ALU							
6732 	**UNC**	nr. 4 ÷ 3/8	**2184/1**		2B	45°	C
6733 	**UNC**	1/2	**2184/1**		2B	45°	C
6628 	**UNF**	nr. 10 ÷ 3/8	**2184/1**		2B	45°	C
6734 	**UNF**	1/2	**2184/1**		2B	45°	C
BAK							
6670 	**M**	2 ÷ 10	**371**		6HX	0°	E
ULTRA							
6606 	**M**	1 ÷ 10	**371**		6HX-6GX	0°	B
6737 	**UNC**	nr. 1 ÷ 3/8	**2184/1**		2B	0°	B
ULTRA S							
6649 	**M**	2 ÷ 10	**371**		6HX-6GX	0°	B
EGM							
6908 	**M**	3 ÷ 8	**8140/371**		6H	0°	B
6910 	**M**	3 ÷ 8	**8140/371**		6H	40°	C
6909 	**M**	10 ÷ 16	**8140/376**		6H	0°	B
6911 	**M**	10 ÷ 16	**8140/376**		6H	40°	C

BESCHICHTUNG COATING	KÜHLUNG INTERNAL COOLANT	SCHNEIDRICHTUNG CUTTING DIRECT.	SCHNEIDSTOFF TOOL MATERIAL	P	M	K	N	S	H	Seite Page
-	-		HSS-Co	-	-	-	●	-	-	571
-	-		HSS-Co	-	-	-	●	-	-	577
-	-		HSS-Co	-	-	-	●	-	-	583
-	-		HSS-Co	-	-	-	●	-	-	589
-	-		HSS-Co	-	-	-	●	-	-	518
-	-		HSS-Co	❍	-	-	●	-	-	522
-	-		HSS-Co	❍	-	-	●	-	-	572
TN	-		HSS-Co	❍	-	-	●	-	-	522
-	-		HSS-Co	●	❍	❍	●	-	-	613
-	-		HSS-Co	●	❍	❍	●	-	-	612
-	-		HSS-Co	●	❍	❍	●	-	-	615
-	-		HSS-Co	●	❍	❍	●	-	-	614

MASCHINEN-GEWINDEBOHRER / MACHINE TAPS

KAT.-NR. ITEM	SIMBOL SYMBOL	Ø mm	DIN	SACKLOCH / DURCHGANGSLOCH Blind hole/ Through hole	TOLERANZ TOLERANCE	DRALLWINKEL HELIX ANGLE	ANSCHNITT FORM CHAMFER FORM
FORMER							
6722 	**M**	1 ÷ 10	**371**		6HX	-	C
6622 	**M**	2 ÷ 10	**371**		6GX	-	C
6723 	**M**	12 ÷ 16	**376**		6HX	-	C
6623 	**M**	12 ÷ 16	**376**		6GX	-	C
6721 	**MF**	8 ÷ 16	**374**		6HX-6GX	-	C
6738 	**UNC**	nr. 2 ÷ 3/8	**2184/1**		2BX	-	C
6747 	**UNF**	nr. 4 ÷ 3/8	**2184/1**		2BX	-	C
6702 	**BSP/G**	1/16 ÷ 1/2	**5156**		-	-	B
FORMER S ■ **Mit Schmiernuten/** Coolant groove							
6709 	**M**	3 ÷ 10	**371**		6HX	-	C
6808 	**M**	3 ÷ 10	**371**		6GX	-	C
6819 	**M**	6 ÷ 10	**371**		**7GX**	-	C
6725 	**M**	12 ÷ 16	**376**		6HX	-	C
6809 	**M**	12 ÷ 16	**376**		6GX	-	C
6720 	**MF**	8 ÷ 16	**374**		6HX-6GX	-	C
6802 	**UNC**	nr. 5 ÷ 3/8	**2184/1**		2BX	-	C
6811 	**UNC**	7/16 ÷ 1/2	**2184/1**		2BX	-	C

MASCHINEN-GEWINDEBOHRER / MACHINE TAPS

BESCHICHTUNG COATING	KÜHLUNG INTERNAL COOLANT	SCHNEIDRICHTUNG CUTTING DIRECT.	SCHNEIDSTOFF TOOL MATERIAL	P	M	K	N	S	H	Seite Page
TN TF TX	-		HSS-Co	●	❍	-	●	-	-	526
TN TF TX	-		HSS-Co	●	❍	-	●	-	-	526
TN TF TX	-		HSS-Co	●	❍	-	●	-	-	540
TN TF TX	-		HSS-Co	●	❍	-	●	-	-	540
-	-		HSS-Co	●	❍	-	●	-	-	568
-	-		HSS-Co	●	❍	-	●	-	-	575
-	-		HSS-Co	●	❍	-	●	-	-	587
-	-		HSS-Co	●	❍	-	●	-	-	605
TN TF TX	-		HSS-Co	●	❍	-	●	-	-	528
TN TF TX	-		HSS-Co	●	❍	-	●	-	-	528
-	-		HSS-Co	●	❍	-	●	-	-	529
TN TF TX	-		HSS-Co	●	❍	-	●	-	-	542
TN TF TX	-		HSS-Co	●	❍	-	●	-	-	542
-	-		HSS-Co	●	❍	-	●	-	-	568
-	-		HSS-Co	●	❍	-	●	-	-	575
-	-		HSS-Co	●	❍	-	●	-	-	579

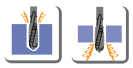
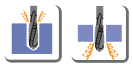
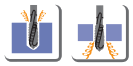
MASCHINEN-GEWINDEBOHRER / MACHINE TAPS

KAT.-NR. ITEM	SIMBOL SYMBOL	Ø mm	DIN	SACKLOCH / DURCHGANGSLOCH Blind hole/ Through hole	TOLERANZ TOLERANCE	DRALLWINKEL HELIX ANGLE	ANSCHNITT FORM CHAMFER FORM
FORMER S ■ **Mit Schmiernuten/** Coolant groove							
6815 	**UNF**	nr. 4 ÷ 3/8	**2184/1**		2BX	-	C
6816 	**UNF**	7/16 ÷ 5/8	**2184/1**		2BX	-	C
6818 	**BSP/G**	1/16 ÷ 1/2	**5156**		-	-	C
Langer Schaft / Long shank							
6672 	**M**	3 ÷ 14	**ILIX NORM**		6H	0°	B
Extra langer Schaft / Extra long shank							
6692 	**M**	3 ÷ 6	**ILIX NORM**		6H	0°	B
6695 	**M**	8 ÷ 20	**ILIX NORM**		6H	0°	B
Muttergewindebohrer / Nut Tap							
6660 	**M**	3 ÷ 30	**357**		6H	0°	A

MASCHINEN-GEWINDEBOHRER / MACHINE TAPS

BESCHICHTUNG COATING	KÜHLUNG INTERNAL COOLANT	SCHNEIDRICHTUNG CUTTING DIRECT.	SCHNEIDSTOFF TOOL MATERIAL	P	M	K	N	S	H	Seite Page
-	-		HSS-Co	●	❍	-	●	-	-	587
-	-		HSS-Co	●	❍	-	●	-	-	593
-	-		HSS-Co	●	❍	-	●	-	-	605
-	-		HSS-Co	●	❍	❍	●	-	-	544
-	-		HSS-Co	●	❍	❍	●	-	-	546
-	-		HSS-Co	●	❍	❍	●	-	-	547
-	-		HSS-Co	●	❍	❍	●	-	-	545

MASCHINEN-GEWINDEBOHRER / MACHINE TAPS

KAT.-NR. ITEM	SIMBOL SYMBOL	Ø mm	DIN	SACKLOCH / DURCHGANGSLOCH Blind hole/ Through hole	TOLERANZ TOLERANCE	DRALLWINKEL HELIX ANGLE	ANSCHNITT FORM CHAMFER FORM
Extra langer Schaft / Extra long shank							
6842	**M**	3 ÷ 6	**ILIX NORM**		6H	0°	B
6840	**M**	3 ÷ 6	**ILIX NORM**		6H	40°	C
6843 	**M**	8 ÷ 20	**ILIX NORM**		6H	0°	B
6841 	**M**	8 ÷ 20	**ILIX NORM**		6H	40°	C
TR ■ Trapez / Trapezoidal							
6938 	**TR**	10 ÷ 36	**ILIX NORM**		7H	0°	-
6939 	**TR**	10 ÷ 36	**ILIX NORM**		7H	0°	-
6937 	**TR**	10 ÷ 30	**ILIX NORM**		7H	0°	C

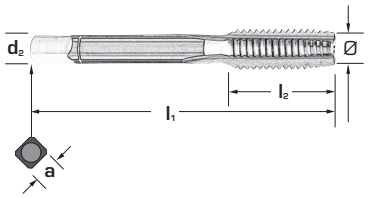
MASCHINEN-GEWINDEBOHRER / MACHINE TAPS

BESCHICHTUNG COATING	KÜHLUNG INTERNAL COOLANT	SCHNEIDRICHTUNG CUTTING DIRECT.	SCHNEIDSTOFF TOOL MATERIAL	P	M	K	N	S	H	Seite Page
-	-		HSS-Co	●	❍	❍	●	-	-	549
-	-		HSS-Co	●	❍	❍	●	-	-	548
-	-		HSS-Co	●	❍	❍	●	-	-	551
-	-		HSS-Co	●	❍	❍	●	-	-	550
-	-		HSS-Co	●	❍	❍	●	-	-	617
-	-		HSS-Co	●	❍	❍	●	-	-	618
-	-		HSS-Co	●	❍	❍	●	-	-	616

DIN 352

Hand-Gewindebohrer, dreiteiliger Satz
für Metrisches ISO-Gewinde nach DIN 13
Hand taps, serial in set of 3 pieces
for ISO metric coarse thread as per DIN 13

M



Typ / Type							N	N	N	N	N	N
Toleranz Tolerance							6 H	6 H	6 H	6 H	6 H	6 H
Anschnitt / Gangzahl Chamfer form / No. of threads							A/5-6	D/3-4	C/2,5-3	A/5-6	D/3-4	C/2,5-3
Schneidrichtung Cutting direction												
Schneidstoff/ Material							HSS	HSS	HSS	HSS	HSS	HSS
Ø mm		**Steigung** Pitch	**Kernloch Ø** Tap-drill Ø	**l_1** mm	**l_2** mm	**d_2** mm h9**	**a** h12	**6615 V**	**6615 M**	**6615 F**	**6618 V**	**6618 M**	**6618 F**
								Einzel single tap		**Satz** set	**Einzel** single tap		**Satz** set
M	1,0	0,25	0,75	32	5,5	2,5	2,1	●		●	-		-
M	1,1	0,25	0,85	32	5,5	2,5	2,1	●		●	-		-
M	1,2	0,25	0,95	32	5,5	2,5	2,1	●		●	-		-
M	1,4	0,30	1,10	32	7,0	2,5	2,1	●		●	-		-
M	1,6	0,35	1,25	32	8,0	2,5	2,1	●		●	-		-
M	1,7*	0,35	1,30	32	8,0	2,5	2,1	●		●	-		-
M	1,8	0,35	1,45	32	8,0	2,5	2,1	●		●	-		-
M	2,0	0,40	1,60	36	8,0	2,8	2,1	●		●	-		-
M	2,2	0,45	1,75	36	9,0	2,8	2,1	●		●	-		-
M	2,3*	0,40	1,90	36	9,0	2,8	2,1	●		●	-		-
M	2,5	0,45	2,05	40	9,0	2,8	2,1	●		●	-		-
M	2,6*	0,45	2,10	40	9,0	2,8	2,1	●		●	-		-
M	3,0	0,50	2,50	40	11,0	3,5	2,7	●		●	●		●
M	3,0*	0,60	2,40	40	11,0	3,5	2,7	●		●	-		-
M	3,5	0,60	2,90	45	13,0	4,0	3,0	●		●	●		●
M	4,0	0,70	3,30	45	13,0	4,5	3,4	●		●	●		●
M	4*	0,75	3,25	45	13,0	4,5	3,4	●		-	-		-
M	4,5	0,75	3,70	50	16,0	6,0	4,9	●		●	-		-
M	5,0	0,80	4,20	50	16,0	6,0	4,9	●		-	●		●
M	5*	0,90	4,10	50	16,0	6,0	4,9	●		●	-		-
M	6,0	1,00	5,00	50	19,0	6,0	4,9	●		●	●		●
M	7,0	1,00	6,00	50	19,0	6,0	4,9	●		●	●		●
M	8,0	1,25	6,80	56	22,0	6,0	4,9	●		●	●		●

N: **Herkömmliche Anwendung**
universal application

* Diese Gewinde sind im Metrischen ISO-Gewinde nicht enthalten / These sizes are not ISO standard.
** Schafttoleranz der Vor- und Mittelschneider h 12 / Shank tolerance of 1st and 2nd tap h 12

● Standardartikel / Items available ex stock

DIN 352

Hand-Gewindebohrer, dreiteiliger Satz
für Metrisches ISO-Gewinde nach DIN 13
Hand taps, serial in set of 3 pieces
for ISO metric coarse thread as per DIN 13

VA	VA	VA	Ti	Ti	Ti	**Typ /** Type
6 HX	6 HX	6 HX	HX	HX	6 HX	**Toleranz** Tolerance
A/5-6	D/3-4	C/2,5-3	A/5-6	D/3-4	C/2,5-3	**Anschnitt / Gangzahl** Chamfer form / No. of threads
						Schneidrichtung Cutting direction
HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	**Schneidstoff/** Material

6614 V	6614 M	6614 F	6625 V	6625 M	6625 F	Ø mm		Steigung Pitch	Kernloch Ø Tap drill Ø
Einzel single tap	Satz set		Einzel single tap	Satz set					
-	-	-	-			M	1,0	0,25	0,75
-	-	-	-			M	1,1	0,25	0,85
-	-	-	-			M	1,2	0,25	0,95
-	-	-	-			M	1,4	0,30	1,10
-	-	-	-			M	1,6	0,35	1,25
-	-	-	-			M	1,7*	0,35	1,30
-	-	-	-			M	1,8	0,35	1,45
●	●	●	●			M	2,0	0,40	1,60
●	●	●	●			M	2,2	0,45	1,75
●	●	●	●			M	2,3*	0,40	1,90
●	●	●	●			M	2,5	0,45	2,05
●	●	■	■			M	2,6*	0,45	2,10
●	●	●	●			M	3,0	0,50	2,50
-	■	●	-			M	3*	0,60	2,40
●	●	●	●			M	3,5	0,60	2,90
●	●	●	●			M	4,0	0,70	3,30
-	-	-	-			M	4*	0,75	3,25
-	-	-	-			M	4,5	0,75	3,70
●	●	●	●			M	5,0	0,80	4,20
■	-	●	●			M	5*	0,90	4,10
●	●	-	●			M	6,0	1,00	5,00
●	●	●	●			M	7,0	1,00	6,00
●	●	●	●			M	8,0	1,25	6,80

VA: **für rostfreien Stahl**
for stainless steel

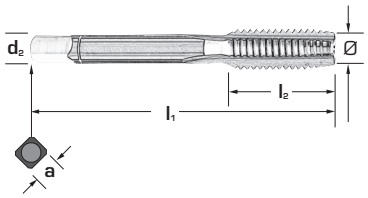
Ti: **für Titanlegierung**
for titanium alloys

● Standardartikel / Items available ex stock - ■ Auslaufender Artikel / discontinued items

DIN 352

Hand-Gewindebohrer, dreiteiliger Satz
für Metrisches ISO-Gewinde nach DIN 133
Hand taps, serial in set of 3 pieces
for ISO metric coarse thread as per DIN 13

M



Typ / Type								N	N	N	N	N	N
Toleranz Tolerance								6 H	6 H	6 H	6 H	6 H	6 H
Anschnitt / Gangzahl Chamfer form / No. of threads								A/5-6	D/3-4	C/2,5-3	A/5-6	D/3-4	C/2,5-3
Schneidrichtung Cutting direction													
Schneidstoff/ Material								HSS	HSS	HSS	HSS	HSS	HSS
Ø mm		**Steigung** Pitch	**Kernloch Ø** Tap drill Ø	**l_1** mm	**l_2** mm	**d_2** mm h9**	**a** h12	**6615 V**	**6615 M**	**6615 F**	**6618 V**	**6618 M**	**6618 F**
								Einzel single tap		**Satz** set	**Einzel** single tap		**Satz** set
M	9	1,25	7,8	63	22	7	5,5	●		●	-		-
M	10	1,50	8,5	70	24	7	6,2	●		●	●		●
M	11	1,50	9,5	70	24	8	5,5	●		●	-		-
M	12	1,75	10,2	75	29	9	7,0	●		●	●		●
M	14	2,00	12,0	80	30	11	9,0	●		●	●		●
M	16	2,00	14,0	80	32	12	9,0	●		●	●		●
M	18	2,50	15,5	95	40	14	11,0	●		●	●		●
M	20	2,50	17,5	95	40	16	12,0	●		●	●		●
M	22	2,50	19,5	100	40	18	14,5	●		●	-		-
M	24	3,00	21,0	110	50	18	14,5	●		●	-		-
M	27	3,00	24,0	110	50	20	16,0	●		●	-		-
M	30	3,50	26,5	125	56	22	18,0	●		●	-		-
M	33	3,50	29,5	125	56	25	20,0	●		●	-		-
M	36	4,00	32,0	150	63	28	22,0	●		●	-		-
M	39	4,00	35,0	150	63	32	24,0	●		●	-		-
M	42	4,50	37,5	150	63	32	24,0	●		●	-		-
M	45	4,50	40,5	160	70	36	29,0	●		●	-		-
M	48	5,00	43,0	180	75	36	29,0	●		●	-		-
M	52	5,00	47,0	180	75	40	32,0	●		●	-		-
M	56	5,50	50,5	200	85	45	35,0	●		●	-		-
M	60	5,50	54,5	200	85	45	35,0	●		●	-		-
M	64	6,00	58,0	220	90	50	39,0	●		●	-		-
M	68	6,00	62,0	220	90	50	29,0	●		●	-		-

N: **Herkömmliche Anwendung**
universal application

** Schafttoleranz der Vor- und Mittelschneider h 12 / Shank tolerance of 1st and 2nd tap h 12

● Standardartikel / Items available ex stock

DIN 352

Hand-Gewindebohrer, dreiteiliger Satz
für Metrisches ISO-Gewinde nach DIN 13
Hand taps, serial in set of 3 pieces
for ISO metric coarse thread as per DIN 13

6614 V	6614 M	6614 F	6625 V	6625 M	6625 F	Ø mm		Steigung Pitch	Kernloch Ø Tap drill Ø
VA	VA	VA	Ti	Ti	Ti				**Typ /** Type
6 HX	6 HX	6 HX	HX	HX	6 HX				**Toleranz** Tolerance
A/5-6	D/3-4	C/2,5-3	A/5-6	D/3-4	C/2,5-3				**Anschnitt / Gangzahl** Chamfer form / No. of threads
									Schneidrichtung Cutting direction
HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co				**Schneidstoff/** Material
Einzel single tap	Satz set		Einzel single tap	Satz set					
-	-		-	-		M	9	1,25	7,8
●	●		●	●		M	10	1,50	8,5
-	-		-	-		M	11	1,50	9,5
●	●		●	●		M	12	1,75	10,2
●	●		●	●		M	14	2,00	12,0
●	●		●	●		M	16	2,00	14,0
●	●		●	●		M	18	2,50	15,5
●	●		●	●		M	20	2,50	17,5
-	-		-	-		M	22	2,50	19,5
-	-		-	-		M	24	3,00	21,0
-	-		-	-		M	27	3,00	24,0
-	-		-	-		M	30	3,50	26,5
-	-		-	-		M	33	3,50	29,5
-	-		-	-		M	36	4,00	32,0
-	-		-	-		M	39	4,00	35,0
-	-		-	-		M	42	4,50	37,5
-	-		-	-		M	45	4,50	40,5
-	-		-	-		M	48	5,00	43,0
-	-		-	-		M	52	5,00	47,0
-	-		-	-		M	56	5,50	50,5
-	-		-	-		M	60	5,50	54,5
-	-		-	-		M	64	6,00	58,0
-	-		-	-		M	68	6,00	62,0

VA: **für rostfreien Stahl** for stainless steel

Ti: **für Titanlegierung** for titanium alloys

● Standardartikel / Items available ex stock

DIN 352

Hand-Gewindebohrer, dreiteilige Sätze, in Metallkassetten für Metrisches ISO-Gewinde nach DIN 13
Hand taps, serial, in set of 3 pieces in metal cases for ISO metric coarse thread as per DIN 13

M

Ø mm		Steigung Pitch		6608
			Typ / Type	-
			Toleranz Tolerance	-
			Anschnitt / Gangzahl Chamfer form / No. of threads	-
			Schneidrichtung Cutting direction	-
			Schneidstoff/ Material	HSS
			Satz in Kassette set in metal case	
M	3	0,50		●
M	4	0,70		●
M	5	0,80		●
M	6	1,00		●
M	8	1,25		●
M	10	1,50		●
M	12	1,75		●

Die Kassette enthält Gewindebohrer nach Kat.-Nr. 6615 / The metal case contains hand taps Cat.-No. 6615

● Standardartikel / Items available ex stock

DIN 352

Hand-Gewindebohrer, dreiteilige Sätze und Kernlochbohrer nach DIN 338, in Metallkassetten für Metrisches ISO-Gewinde nach DIN 13
Hand taps, serial, in set of 3 pieces and drills for Tap drill Ø hole acc. to DIN 338, in metal cases for ISO metric coarse thread as per DIN 13

M

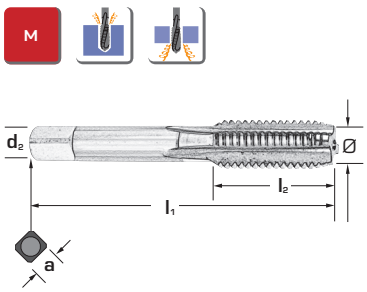
Typ / Type					-
Toleranz Tolerance					-
Anschnitt / Gangzahl Chamfer form / No. of threads					-
Schneidrichtung Cutting direction					-
Schneidstoff/ Material					HSS
Ø mm		**Steigung** Pitch	**Kernloch Ø** Tap drill Ø		**6609**
				Satz in Kassette set in metal case	
M	**3**	0,50	2,5		✔
M	**4**	0,70	3,3		✔
M	**5**	0,80	4,2		✔
M	**6**	1,00	5,0		✔
M	**8**	1,25	6,8		✔
M	**10**	1,50	8,5		✔
M	**12**	1,75	10,2		✔

Die Kassette enthält Gewindebohrer Kat.-Nr. 6615 und Spiralbohrer nach DIN 338
The metal case contains hand taps Cat.-No. 6615 and twist drills Cat.-No. 6151 DIN 338

✔ Auf Anfrage / Upon request

DIN 352

Kurze Maschinen-Gewindebohrer
für Metrisches ISO-Gewinde nach DIN 13
Short machine taps
for ISO metric coarse thread as per DIN 13



Typ / Type	N	N 15°	N 40°	N 40°	N 40°	Rapid	AZ	AZ
Toleranz / Tolerance	6 H	6 H	6 H	6 H	6 G	6 H	6 H	6 H
Anschnitt / Gangzahl / Chamfer form / No. of threads	C/2,5-3	C/2,5-3	C/2,5-3	E/1,5-2	E/1,5-2	B/4-5	B/4-5	C/2,5-3
Schneidrichtung / Cutting direction								
Schneidstoff / Material	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co

Ø mm		Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	l_3 mm	d_2 mm h9	a h12	6678	6659	6639	6604	6604 6G	6679	6613	6621
M	2,0	0,40	1,60	36	8	-	2,8	2,1	●	-	-	-	-	●	-	-
M	2,2	0,45	1,75	36	9	-	2,8	2,1	●	-	-	-	-	●	-	-
M	2,3*	0,40	1,90	36	9	-	2,8	2,1	●	-	-	-	-	●	-	-
M	2,5	0,45	2,05	40	9	-	2,8	2,1	●	-	-	-	-	●	-	-
M	2,6*	0,45	2,10	40	9	-	2,8	2,1	●	-	-	-	-	●	-	-
M	3,0	0,50	2,50	40	11	5	3,5	2,7	●	●	●	●	●	●	●	●
M	3,5	0,60	2,90	45	13	6	4,0	3,0	●	●	●	-	-	●	-	-
M	4,0	0,70	3,30	45	13	7	4,5	3,4	●	●	●	●	●	●	●	●
M	5,0	0,80	4,20	50	16	8	6,0	4,9	●	●	●	●	●	●	●	●
M	6,0	1,00	5,00	50	19	10	6,0	4,9	●	●	●	●	●	●	●	●
M	7,0	1,00	6,00	50	19	10	6,0	4,9	-	●	●	-	-	●	-	-
M	8,0	1,25	6,80	56	22	12	6,0	4,9	●	●	●	●	●	●	●	●
M	10,0	1,50	8,50	70	24	14	7,0	5,5	●	●	●	●	●	●	●	●
M	12,0	1,75	10,20	75	29	16	9,0	7,0	●	●	●	●	●	●	●	●
M	14,0	2,00	12,00	80	30	20	11,0	9,0	●	●	●	-	-	●	-	-
M	16,0	2,00	14,00	80	32	20	12,0	9,0	●	●	●	●	●	●	●	●
M	18,0	2,50	15,50	95	40	25	14,0	11,0	●	●	●	-	-	●	-	-
M	20,0	2,50	17,50	95	40	25	16,0	12,0	●	●	●	●	●	●	-	-
M	24,0	3,00	21,00	110	38	30	18,0	14,5	-	-	-	●	●	-	-	-

N: herkömmliche Anwendunng
universal application

N15/40°: 15°/40° Rechtsrall
15°/40° right hand helix

Rapid: Herkömmliche Anwendung
universal application

AZ: Ausgesetzte Zähne
interrupted threads

* Diese Gewinde sind im Metrischen ISO-Gewinde nicht enthalten / These sizes are not ISO standard.

● Standardartikel / Items available ex stock

DIN 352

Kurze Maschinen-Gewindebohrer
für Metrisches ISO-Gewinde nach DIN 13
Short machine taps
for ISO metric coarse thread as per DIN 13

VA 15°	VA 15°	MS	**Typ /** Type
6 HX	6 HX	6H	**Toleranz** Tolerance
C/2,5-3	E/1,5-2	E/1,5-2	**Anschnitt / Gangzahl** Chamfer form / No. of threads
			Schneidrichtung Cutting direction
HSS-Co	HSS-Co	HSS-Co	**Schneidstoff/** Material
6648	**6612**	**6624**	**Ø mm** / **Steigung** Pitch / **Kernloch Ø** Tap drill Ø
-	-	●	M **2,0** 0,40 1,60
-	-	●	M **2,2** 0,45 1,75
-	-	●	M **2,3*** 0,40 1,90
-	-	●	M **2,5** 0,45 2,05
-	-	●	M **2,6*** 0,45 2,10
●	●	●	M **3,0** 0,50 2,50
●	-	●	M **3,5** 0,60 2,90
●	●	●	M **4,0** 0,70 3,30
●	●	●	M **5,0** 0,80 4,20
●	●	●	M **6,0** 1,00 5,00
-	-	●	M **7,0** 1,00 6,00
●	●	●	M **8,0** 1,25 6,80
●	●	●	M **10,0** 1,50 8,50
●	●	●	M **12,0** 1,75 10,20
●	-	-	M **14,0** 2,00 12,00
●	●	-	M **16,0** 2,00 14,00
-	-	-	M **18,0** 2,50 15,50
-	-	-	M **20,0** 2,50 17,50
-	-	-	M **24,0** 3,00 21,00

VA: für rostfreien Stahl
for stainless steel

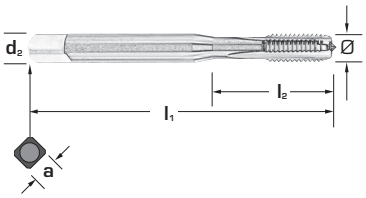
MS: für Messing
for brass

● Standardartikel / Items available ex stock

DIN 371

Maschinen-Gewindebohrer mit verstärktem Schaft
für Metrisches ISO-Gewinde nach DIN 13
Machine taps with reinforced shank
for ISO metric coarse thread as per DIN 13

M | HARD LUBE | TICN | TiN



Typ / Type	N	N	N	N
Toleranz Tolerance	6 H	6 H	6 H	6 H
Anschnitt / Gangzahl Chamfer form / No. of threads	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3
Schneidrichtung Cutting direction				
Schneidstoff/ Material	HSS-Co	HSS-Co	HSS-Co	HSS-Co

Ø mm		Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	l_3 mm	d_2 mm h9	a h12	6706	6706 TN	6706 TC	6712
M	1	0,25	0,75	40	5,5	-	2,5	2,1	●	●	●	-
M	1,1	0,25	0,85	40	5,5	-	2,5	2,1	●	●	●	-
M	1,2	0,25	0,95	40	5,5	-	2,5	2,1	●	●	●	-
M	1,4	0,30	1,10	40	7	-	2,5	2,1	●	●	●	-
M	1,6	0,35	1,25	40	8	-	2,5	2,1	●	●	●	-
M	1,7*	0,35	1,30	40	8	-	2,5	2,1	●	●	●	-
M	1,8	0,35	1,45	40	8	-	2,5	2,1	●	●	●	-
M	2	0,40	1,60	45	8	4	2,8	2,1	●	●	●	-
M	2,2	0,45	1,75	45	9	4	2,8	2,1	●	●	●	-
M	2,3*	0,40	1,90	45	9	4	2,8	2,1	●	●	●	-
M	2,5	0,45	2,05	50	9	4	2,8	2,1	●	●	●	-
M	2,6*	0,45	2,10	50	9	4	2,8	2,1	●	●	●	-
M	3	0,50	2,50	56	11	5	3,5	2,7	●	●	●	●
M	3*	0,60	2,40	56	11	5	3,5	2,7	●	●	●	-
M	3,5	0,60	2,90	56	13	6	4,0	3,0	●	●	●	-
M	4	0,70	3,30	63	13	7	4,5	3,4	●	●	●	●
M	4*	0,75	3,25	63	13	7	4,5	3,4	●	●	●	-
M	5	0,80	4,20	70	16	8	6,0	4,9	●	●	●	●
M	5*	0,90	4,10	70	16	8	6,0	4,9	■	●	●	-
M	6	1,00	5,00	80	19	10	6,0	4,9	●	●	●	●
M	7	1,00	6,00	80	19	10	7,0	5,5	●	●	●	-
M	8	1,25	6,80	90	22	12	8,0	6,2	●	●	●	●
M	9	1,25	7,80	90	22	12	9,0	7,0	●	●	●	-
M	10	1,50	8,50	100	24	14	10,0	8,0	●	●	●	●
Abmessungen mit Überlaufschaft über M 10 siehe Kat.-Nr / above M 10 refer to Cat.-No.									6705	6705TN	6706TC	6715

N: Herkömmliche Anwendung
universal application

* Diese Gewinde sind im Metrischen ISO-Gewinde nicht enthalten / These sizes are not ISO standard.

● Standardartikel / Items available ex stock ■ Auslaufender Artikel / discontinued item

DIN 371

Maschinen-Gewindebohrer mit verstärktem Schaft
für Metrisches ISO-Gewinde nach DIN 13
Machine taps with reinforced shank
for ISO metric coarse thread as per DIN 13

AZ	N 15°	N 15°	N 15°	N 15°	N 15°	HD 15°	HD 15°	**Typ /** Type
6 H	6 H	6 G	6 H	6 H	6 H+0,1	6H	6H	**Toleranz** Tolerance
C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	**Anschnitt / Gangzahl** Chamfer form / No. of threads
								Schneidrichtung Cutting direction
HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	**Schneidstoff/** Material
6820	**6657**	**6657 6G**	**6657 TN**	**6657 TC**	**6902**	**6878**	**6878 HL**	**Ø mm**	**Steigung** Pitch	**Kernloch Ø** Tap drill Ø
-	-	-	-	-	-	-	-	**M 1**	0,25	0,75
-	-	-	-	-	-	-	-	**M 1,1**	0,25	0,85
-	-	-	-	-	-	-	-	**M 1,2**	0,25	0,95
-	-	-	-	-	-	-	-	**M 1,4**	0,30	1,10
-	-	-	-	-	-	-	-	**M 1,6**	0,35	1,25
-	-	-	-	-	-	-	-	**M 1,7***	0,35	1,30
-	-	-	-	-	-	-	-	**M 1,8**	0,35	1,45
●	●	●	●	●	-	-	-	**M 2**	0,40	1,60
-	●	-	●	●	-	-	-	**M 2,2**	0,45	1,75
-	●	-	●	●	-	-	-	**M 2,3***	0,40	1,90
-	●	●	●	●	-	-	-	**M 2,5**	0,45	2,05
-	●	-	●	●	-	-	-	**M 2,6***	0,45	2,10
●	●	●	●	●	●	●	●	**M 3**	0,50	2,50
-	-	-	-	-	-	-	-	**M 3***	0,60	2,40
-	●	●	●	●	-	-	-	**M 3,5**	0,60	2,90
●	●	●	●	●	●	●	●	**M 4**	0,70	3,30
-	-	-	-	-	-	-	-	**M 4***	0,75	3,25
●	●	●	●	●	●	●	●	**M 5**	0,80	4,20
-	-	-	-	-	-	-	-	**M 5***	0,90	4,10
●	●	●	●	●	●	●	●	**M 6**	1,00	5,00
-	●	●	●	●	-	-	-	**M 7**	1,00	6,00
●	●	●	●	●	●	●	●	**M 8**	1,25	6,80
-	-	-	-	-	-	-	-	**M 9**	1,25	7,80
●	●	●	●	●	●	●	●	**M 10**	1,50	8,50
	6658					6879	6679HL			

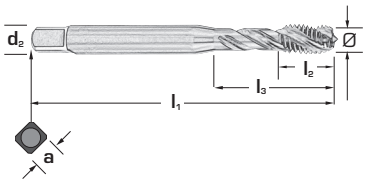
AZ: Ausgesetzte Zähne/ interrupted threads
N15°: 15° Rechtsdrall / 15°right hand helix
HD: für zähe Werkstoffe / for tough materials

● Standardartikel / Items available ex stock

DIN 371

Maschinen-Gewindebohrer mit verstärktem Schaft
für Metrisches ISO-Gewinde nach DIN 13
Machine taps with reinforced shank
for ISO metric coarse thread as per DIN 13

M TICN TiN



Typ / Type									N 40°	N/VAP 40°	N 40°	N 40°
Toleranz Tolerance									6 H	6 H	6 G	6 G*
Anschnitt / Gangzahl Chamfer form / No. of threads									C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3
Schneidrichtung Cutting direction												
Schneidstoff/ Material									HSS-Co	HSS-Co	HSS-Co	HSS-Co
Ø mm		**Steigung** Pitch	**Kernloch Ø** Tap drill Ø	**l_1** mm	**l_2** mm	**l_3** mm	**d_2** mm h9	**a** h12	**6644**	**6644 VP**	**6644 6G**	**6644 TN**
M	1	0,25	0,75	40	-	5,5	2,5	2,1	-	-	-	-
M	1,1	0,25	0,85	40	-	5,5	2,5	2,1	-	-	-	-
M	1,2	0,25	0,95	40	-	5,5	2,5	2,1	-	-	-	-
M	1,4	0,30	1,10	40	-	7,0	2,5	2,1	-	-	-	-
M	1,6	0,35	1,25	40	-	8,0	2,5	2,1	-	-	-	-
M	1,7*	0,35	1,30	40	-	8,0	2,5	2,1	-	-	-	-
M	1,8	0,35	1,45	40	-	8,0	2,5	2,1	-	-	-	-
M	2	0,40	1,60	45	4	8,0	2,8	2,1	●	●	●	●
M	2,2	0,45	1,75	45	4	9,0	2,8	2,1	●	●	-	-
M	2,3*	0,40	1,90	45	4	9,0	2,8	2,1	●	●	-	-
M	2,5	0,45	2,05	50	4	9,0	2,8	2,1	●	●	●	●
M	2,6*	0,45	2,10	50	4	9,0	2,8	2,1	●	●	-	-
M	3	0,50	2,50	56	5	11,0	3,5	2,7	●	●	●	●
M	3*	0,60	2,40	56	5	11,0	3,5	2,7	-	-	-	-
M	3,5	0,60	2,90	56	6	13,0	4,0	3,0	●	●	●	●
M	4	0,70	3,30	63	7	13,0	4,5	3,4	●	●	●	●
M	4*	0,75	3,25	63	7	13,0	4,5	3,4	-	-	-	-
M	5	0,80	4,20	70	8	16,0	6,0	4,9	●	●	●	●
M	5*	0,90	4,10	70	8	16,0	6,0	4,9	-	-	-	-
M	6	1,00	5,00	80	10	19,0	6,0	4,9	●	●	●	●
M	7	1,00	6,00	80	10	19,0	7,0	5,5	●	●	●	●
M	8	1,25	6,80	90	12	22,0	8,0	6,2	●	●	●	●
M	9	1,25	7,80	90	12	22,0	9,0	7,0	●	●	-	-
M	10	1,50	8,50	100	14	24,0	10,0	8,0	●	●	●	●
Abmessungen mit Überlaufschaft über M 10 siehe Kat.-Nr / above M 10 refer to Cat.-No.									6638	6638VP	66386G	6638TN

N 40°: Rechtsrall a 40° / 40° right hand helix **VAP: vaporisiert /** 40° vaporized

* Diese Gewinde sind im Metrischen ISO-Gewinde nicht enthalten / These sizes are not ISO standard. - **6 G*** Bei Bestellung bitte 6G angeben / when ordering please state 6G

● Standardartikel / Items available ex stock

DIN 371

Maschinen-Gewindebohrer mit verstärktem Schaft
für Metrisches ISO-Gewinde nach DIN 13
Machine taps with reinforced shank
for ISO metric coarse thread as per DIN 13

N 40°	N 40°	N 40°	N 40°	N Sx 40°	**Typ /** Type
7 G	6 H	6 H	6 H	6 H	**Toleranz** Tolerance
C/2,5-3	C/2,5-3	C/2,5-3	E/1,5-2	C/2,5-3	**Anschnitt / Gangzahl** Chamfer form / No. of threads
					Schneidrichtung Cutting direction
HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	**Schneidstoff/** Material
6644 7G	**6644 TN**	**6644 TC**	**6867**	**6861**	**Ø mm**	**Steigung** Pitch	**Kernloch Ø** Tap drill Ø
-	-	-	-	-	M 1	0,25	0,75
-	-	-	-	-	M 1,1	0,25	0,85
-	-	-	-	-	M 1,2	0,25	0,95
-	-	-	-	-	M 1,4	0,30	1,10
-	-	-	-	-	M 1,6	0,35	1,25
-	-	-	-	-	M 1,7*	0,35	1,30
-	-	-	-	-	M 1,8	0,35	1,45
●	●	●	-	-	M 2	0,40	1,60
-	-	-	-	-	M 2,2	0,45	1,75
-	-	-	-	-	M 2,3*	0,40	1,90
●	●	●	-	-	M 2,5	0,45	2,05
-	-	-	-	-	M 2,6*	0,45	2,10
●	●	●	●	●	M 3	0,50	2,50
-	-	-	-	-	M 3*	0,60	2,40
-	●	●	-	-	M 3,5	0,60	2,90
●	●	●	●	●	M 4	0,70	3,30
-	-	-	-	-	M 4*	0,75	3,25
●	●	●	●	●	M 5	0,80	4,20
-	-	-	-	-	M 5*	0,90	4,10
●	●	●	●	●	M 6	1,00	5,00
-	●	-	-	-	M 7	1,00	6,00
●	●	●	●	●	M 8	1,25	6,80
-	-	-	-	-	M 9	1,25	7,80
●	●	●	●	●	M 10	1,50	8,50
66387G	6638TN	6638TC	6868	6862			

N 40°: Rechtsrall a 40° / 40° right hand helix

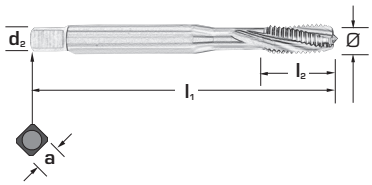
● Standardartikel / Items available ex stock

DIN 371

Maschinen-Gewindebohrer mit verstärktem Schaft
für Metrisches ISO-Gewinde nach DIN 13
Machine taps with reinforced shank
for ISO metric coarse thread as per DIN 13

M | TICN | TiN | TINOX | XP TOP

Axialer Kühlmittelaustritt
Axial internal cooling



Typ / Type									VA 15°	VAP 15°	VA 15°	VA 15°	VA i 15°
Toleranz / Tolerance									6 HX	6 HX	6 HX	6 HX	6 HX
Anschnitt / Gangzahl / Chamfer form / No. of threads									C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3
Schneidrichtung / Cutting direction													
Schneidstoff / Material									HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co
Ø mm		Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	l_3 mm	d_2 mm h9	a h12	6654	6654 VP	6654 XP	6620	6620 XP
M	2	0,40	1,60	45	8	4	2,8	2,1	●	●	●	-	-
M	2,2	0,45	1,75	45	9	4	2,8	2,1	●	●	●	-	-
M	2,3*	0,40	1,90	45	9	4	2,8	2,1	●	●	●	-	-
M	2,5	0,45	2,05	50	9	4	2,8	2,1	●	●	●	-	-
M	2,6*	0,45	2,10	50	9	4	2,8	2,1	●	●	●	-	-
M	3	0,50	2,50	56	11	5	3,5	2,7	●	●	●	-	-
M	3,5	0,60	2,90	56	13	6	4,0	3,0	●	●	●	-	-
M	4	0,70	3,30	63	13	7	4,5	3,4	●	●	●	-	-
M	5	0,80	4,20	70	16	8	6,0	4,9	●	●	●	-	-
M	6	1,00	5,00	80	19	10	6,0	4,9	●	●	●	●	●
M	7	1,00	6,00	80	19	10	7,0	5,5	●	●	●	-	-
M	8	1,25	6,80	90	22	12	8,0	6,2	●	●	●	●	●
M	10	1,50	8,50	100	24	14	10,0	8,0	●	●	●	●	●
Abmessungen mit Überlaufschaft über M 10 siehe Kat.-Nr / above M 10 refer to Cat.-No.									6634	6634VP	6634XP	6605	6605XP

VA: **Für rostfreien Stahl**
for stainless steel

VA i: **Für rostfreien Stahl, con fori di lubruficazione**
for stainless steel, with internal cooling

VAP: vaporisiert / 40° vaporized

* Diese Gewinde sind im Metrischen ISO-Gewinde nicht enthalten / These sizes are not ISO standard.
Kat.Nr.6661 mit Abschrägung ab M 3, ausgenommen M 7 / Cat.-No. 6661 with back tapered from M 3 onwards, except M 7

● Standardartikel / Items available ex stock

DIN 371

Maschinen-Gewindebohrer mit verstärktem Schaft
für Metrisches ISO-Gewinde nach DIN 13
Machine taps with reinforced shank
for ISO metric coarse thread as per DIN 13

VR 35°	VRP 35°	VR 35°	VR 35°	VR 35°	VR 35°	VRP 50°	VR 50°	**Typ /** Type
6 HX	6 HX	6 G	6 HX	6 HX	6 HX	6 HX	6 HX	**Toleranz** Tolerance
C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	**Anschnitt / Gangzahl** Chamfer form / No. of threads
								Schneidrichtung Cutting direction
HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	**Schneidstoff/** Material
6661	**6661 VP**	**6661 6G**	**6661 TN**	**6661 TX**	**6661 XP**	**6850 VP**	**6850 TN**	

			Ø mm	Steigung Pitch	Kernloch Ø Tap drill Ø
●	●	●	M 2	0,40	1,60
●	●	●	M 2,2	0,45	1,75
●	●	-	M 2,3*	0,40	1,90
●	●	●	M 2,5	0,45	2,05
●	●	-	M 2,6*	0,45	2,10
●	●	●	M 3	0,50	2,50
●	●	-	M 3,5	0,60	2,90
●	●	●	M 4	0,70	3,30
●	●	●	M 5	0,80	4,20
●	●	●	M 6	1,00	5,00
●	●	-	M 7	1,00	6,00
●	●	●	M 8	1,25	6,80
●	●	●	M 10	1,50	8,50

6662	6662VP	66626G	6662	6662TX	6662XB	6851VP	6851TN

VR: **für rostfreien Stahl, mit Abschrägung**
for stainless steel, back tapered
VRP: für rostfreien Stahl, mit Abschrägung und vaporisiert
for stainless steel, back tapered and vaporized

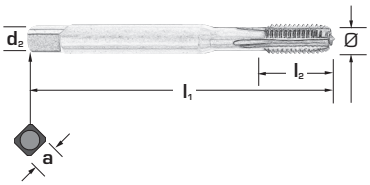
● **Standartartikel /** Items available ex stock

DIN 371

Maschinen-Gewindebohrer mit verstärktem Schaft
für Metrisches ISO-Gewinde nach DIN 13
Machine taps with reinforced shank
for ISO metric coarse thread as per DIN 13

M | TICN | TiN | TiAlN Futura

Axialer Kühlmittelaustritt
Axial internal cooling



Typ / Type									GG	GG	Multi GG i	Multi GG i	Alu 45°	BAK
Toleranz Tolerance									6 HX	6 HX	6 HX	6 HX	6 H	6 HX
Anschnitt / Gangzahl Chamfer form / No. of threads									C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	E/1,5-2
Schneidrichtung Cutting direction														
Schneidstoff/ Material									HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co
Ø mm		**Steigung** Pitch	**Kernloch Ø** Tap drill Ø	**l_1** mm	**l_2** mm	**l_3** mm	**d_2** mm h9	**a** h12	**6631**	**6631 TF**	**6629**	**6629 TC**	**6643**	**6670**
M	2	0,40	1,60	45	8	4	2,8	2,1	-	-	-	-	●	●
M	2,2	0,45	1,75	45	9	4	2,8	2,1	-	-	-	-	●	-
M	2,3*	0,40	1,90	45	9	4	2,8	2,1	-	-	-	-	●	■
M	2,5	0,45	2,05	50	9	4	2,8	2,1	-	-	-	-	●	●
M	2,6*	0,45	2,10	50	9	4	2,8	2,1	-	-	-	-	●	-
M	3	0,50	2,50	56	11	5	3,5	2,7	●	●	-	-	●	●
M	3,5	0,60	2,90	56	13	6	4,0	3,0	●	●	-	-	●	●
M	4	0,70	3,30	63	13	7	4,5	3,4	●	●	-	-	●	●
M	5	0,80	4,20	70	16	8	6,0	4,9	●	●	●	●	●	●
M	6	1,00	5,00	80	19	10	6,0	4,9	●	●	●	●	●	●
M	7	1,00	6,00	80	19	10	7,0	5,5	●	●	-	-	●	■
M	8	1,25	6,80	90	22	12	8,0	6,2	●	●	●	●	●	●
M	10	1,50	8,50	100	24	14	10,0	8,0	●	●	●	●	●	●
Abmessungen mit Überlaufschaft über M 10 siehe Kat.-Nr / above M 10 refer to Cat.-No.									6632	6632TF	6637	6637TC	6651	-

Alu: **für Aluminium** for Aluminium
BAK: **für Bakelit** for bakelite
GG: **für Guss** for cast iron

* Diese Gewinde sind im Metrischen ISO-Gewinde nicht enthalten / These sizes are not ISO standard.

● Standardartikel / Items available ex stock ■ Auslaufender Artikel / discontinued items

DIN 371

Maschinen-Gewindebohrer mit verstärktem Schaft
für Metrisches ISO-Gewinde nach DIN 13
Machine taps with reinforced shank
for ISO metric coarse thread as per DIN 13

HD 40°	HD 40°	HD 40°	HD 40°	HD 40°	HR 40°	HR 40°	**Typ /** Type	
6 H	6 G	4 H	6 H	6 H	6 H	6 H	**Toleranz** Tolerance	
C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	**Anschnitt / Gangzahl** Chamfer form / No. of threads	
							Schneidrichtung Cutting direction	
HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	**Schneidstoff/** Material	
6666	**6666 6G**	**6666 4H**	**6666 TN**	**6666 TF**	**6681**	**6681 TF**	**Ø mm**	**Steigung** Pitch	**Kernloch Ø** Tap drill Ø
-	-	-	-	-	-	-	M 2	0,40	1,60
-	-	-	-	-	-	-	M 2,2	0,45	1,75
-	-	-	-	-	-	-	M 2,3*	0,40	1,90
-	-	-	-	-	-	-	M 2,5	0,45	2,05
-	-	-	-	-	-	-	M 2,6*	0,45	2,10
●	●	●	●	●	●	●	M 3	0,50	2,50
●	●	●	●	●	-	-	M 3,5	0,60	2,90
●	●	●	●	●	●	●	M 4	0,70	3,30
●	●	●	●	●	●	●	M 5	0,80	4,20
●	●	●	●	●	●	●	M 6	1,00	5,00
●	●	●	●	●	-	-	M 7	1,00	6,00
●	●	●	●	●	●	●	M 8	1,25	6,80
●	●	●	●	●	●	●	M 10	1,50	8,50
6667	-	-	6667TN	6667TF	6689	6689TF			

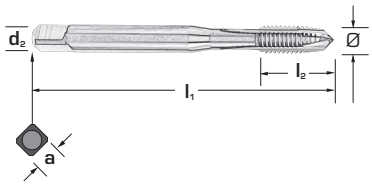
HD: **für zähe Werkstoffe**
for tough materials
HR: **für zähe Werkstoffe, mit Abschrägung**
for tough materials, back tapered

● Standardartikel / Items available ex stock

DIN 371

Maschinen-Gewindebohrer mit verstärktem Schaft
für Metrisches ISO-Gewinde nach DIN 13
Machine taps with reinforced shank
for ISO metric coarse thread as per DIN 13

M TICN TiN



Typ / Type	Rapid	VAP Rapid	Rapid	Rapid	Rapid	Rapid
Toleranz Tolerance	6 H	6 H	6 G	6 G*	4 H	7 G
Anschnitt / Gangzahl Chamfer form / No. of threads	B/4-5	B/4-5	B/4-5	B/4-5	B/4-5	B/4-5
Schneidrichtung Cutting direction						
Schneidstoff/ Material	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co

Ø mm	Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a h12	6707	6707 VP	6707 6G	6707 TN	6707 4H	6707 7G
M 2	0,40	1,60	45	8	2,8	2,1	●	●	●	●	●	●
M 2,2	0,45	1,75	45	9	2,8	2,1	●	●	●	●	●	●
M 2,3*	0,40	1,90	45	9	2,8	2,1	●	●	-	-	-	-
M 2,5	0,45	2,05	50	9	2,8	2,1	●	●	●	●	●	●
M 2,6*	0,45	2,10	50	9	2,8	2,1	●	●	-	-	-	-
M 3	0,50	2,50	56	11	3,5	2,7	●	●	●	●	●	●
M 3*	0,60	2,40	56	11	3,5	2,7	■	-	■	-	-	-
M 3,5	0,60	2,90	56	13	4,0	3,0	●	●	●	●	●	-
M 4	0,70	3,30	63	13	4,5	3,4	●	●	●	●	●	●
M 4*	0,75	3,25	63	13	4,5	3,4	■	-	-	-	-	-
M 5	0,80	4,20	70	16	6,0	4,9	●	●	●	●	●	●
M 6	1,00	5,00	80	19	6,0	4,9	●	●	●	●	●	●
M 7	1,00	6,00	80	19	7,0	5,5	●	●	●	●	●	-
M 8	1,25	6,80	90	22	8,0	6,2	●	●	●	●	●	●
M 9	1,25	7,80	90	22	9,0	7,0	●	●	-	-	-	-
M 10	1,50	8,50	100	24	10,0	8,0	●	●	●	●	●	●
Abmessungen mit Überlaufschaft über M 10 siehe Kat.-Nr / above M 10 refer to Cat.-No.							6711	6711VP	67116G	6711TN	-	67117G

Rapid: **Herkömmliche Anwendung**
universal application
VAP: **vaporisiert**
vaporized

* Diese Gewinde sind im Metrischen ISO-Gewinde nicht enthalten / These sizes are not ISO standard.

● Standardartikel / Items available ex stock ■ Auslaufender Artikel / discontinued items- **6 G*** Bei Bestellung bitte 6G angeben / when ordering please state 6G

DIN 371

Maschinen-Gewindebohrer mit verstärktem Schaft
für Metrisches ISO-Gewinde nach DIN 13
Machine taps with reinforced shank
for ISO metric coarse thread as per DIN 13

Rapid	Rapid	N sx	Rapid 2	Rapid 2	**Typ /** Type
6 H	6 H	6 H	6 H	6 G	**Toleranz** Tolerance
B/4-5	B/4-5	B/4-5	B/4-5	B/4-5	**Anschnitt / Gangzahl** Chamfer form / No. of threads
					Schneidrichtung Cutting direction
HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	**Schneidstoff/** Material
6707 TN	**6707 TC**	**6859**	**6640**	**6640 6G**	**Ø mm**	**Steigung** Pitch	**Kernloch Ø** Tap drill Ø
---	---	---	---	---	---	---	---
●	●	-	●	●	M 2	0,40	1,60
-	-	-	●	●	M 2,2	0,45	1,75
-	-	-	●	-	M 2,3*	0,40	1,90
●	●	-	●	●	M 2,5	0,45	2,05
-	-	-	●	-	M 2,6*	0,45	2,10
●	●	●	●	●	M 3	0,50	2,50
-	-	-	-	-	M 3*	0,60	2,40
●	●	-	●	●	M 3,5	0,60	2,90
●	●	●	●	●	M 4	0,70	3,30
-	-	-	-	-	M 4*	0,75	3,25
●	●	●	●	●	M 5	0,80	4,20
●	●	●	●	●	M 6	1,00	5,00
●	-	-	●	●	M 7	1,00	6,00
●	●	●	●	●	M 8	1,25	6,80
-	-	-	-	-	M 9	1,25	7,80
●	●	●	●	●	M 10	1,50	8,50
6711TN	6711TC	6860	-	-			

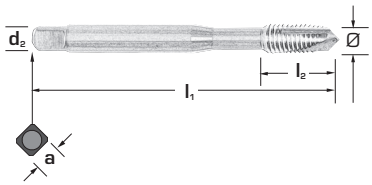
Rapid 2: **Herkömmliche Anwendung (2 Nuten)**
universal application (2 flutes)

● Standardartikel / Items available ex stock

DIN 371

Maschinen-Gewindebohrer mit verstärktem Schaft
für Metrisches ISO-Gewinde nach DIN 13
Machine taps with reinforced shank
for ISO metric coarse thread as per DIN 13

M TiN



Typ / Type	Ultra	Ultra	Ultra-S
Toleranz Tolerance	6 HX	6 GX	6 HX
Anschnitt / Gangzahl Chamfer form / No. of threads	B/4-5	B/4-5	B/4-5
Schneidrichtung Cutting direction			
Schneidstoff/ Material	HSS-Co	HSS-Co	HSS-Co

Ø mm		Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a h12	6606	6606 6G	6649
M	1	0,25	0,75	40	5,5	2,5	2,1	●	-	-
M	1,2	0,25	0,95	40	5,5	2,5	2,1	●	-	-
M	1,4	0,30	1,10	40	7,0	2,5	2,1	●	-	-
M	1,6	0,35	1,25	40	8,0	2,5	2,1	●	-	-
M	1,7*	0,35	1,30	40	8,0	2,5	2,1	●	-	-
M	1,8	0,35	1,45	40	8,0	2,5	2,1	●	-	-
M	2	0,40	1,60	45	8,0	2,8	2,1	●	●	●
M	2,2	0,45	1,75	45	9,0	2,8	2,1	●	●	●
M	2,3*	0,40	1,90	45	9,0	2,8	2,1	●	-	●
M	2,5	0,45	2,05	50	9,0	2,8	2,1	●	●	●
M	2,6*	0,45	2,10	50	9,0	2,8	2,1	●	-	●
M	3	0,50	2,50	56	11,0	3,5	2,7	●	●	●
M	3,5	0,60	2,90	56	13,0	4,0	3,0	●	●	●
M	4	0,70	3,30	63	13,0	4,5	3,4	●	●	●
M	4*	0,75	3,25	63	13,0	4,5	3,4	■	-	-
M	5	0,80	4,20	70	16,0	6,0	4,9	●	●	●
M	6	1,00	5,00	80	19,0	6,0	4,9	●	●	●
M	7	1,00	6,00	80	19,0	7,0	5,5	●	●	●
M	8	1,25	6,80	90	22,0	8,0	6,2	●	●	●
M	9	1,25	7,80	90	22,0	9,0	7,0	●	-	●
M	10	1,50	8,50	100	24,0	10,0	8,0	●	●	●
Abmessungen mit Überlaufschaft über M 10 siehe Kat.-Nr / above M 10 refer to Cat.-No.								-	-	-

Ultra: **für Bleche**
for sheet metals
Ultra-s: **mit Schmiernuten für Bleche**
with coolant grooves for sheet metals

* Diese Gewinde sind im Metrischen ISO-Gewinde nicht enthalten / These sizes are not ISO standard.

● Standardartikel / Items available ex stock ■ Auslaufender Artikel / discontinued items

DIN 371

Maschinen-Gewindebohrer mit verstärktem Schaft
für Metrisches ISO-Gewinde nach DIN 13
Machine taps with reinforced shank
for ISO metric coarse thread as per DIN 13

Ultra-S	Ultra-S	AZ	NL15°	**Typ /** Type
6 GX	6 HX	6 H	6 H	**Toleranz** Tolerance
B/4-5	B/4-5	B/4-5	D/4-5	**Anschnitt / Gangzahl** Chamfer form / No. of threads
				Schneidrichtung Cutting direction
HSS-Co	HSS-Co	HSS-Co	HSS-Co	**Schneidstoff/** Material

6649 6G	6649 TN	6616	6727	Ø mm		Steigung Pitch	Kernloch Ø Tap drill Ø
-	-	-	-	M	1	0,25	0,75
-	-	-	-	M	1,2	0,25	0,95
-	-	-	-	M	1,4	0,30	1,10
-	-	-	-	M	1,6	0,35	1,25
-	-	-	-	M	1,7*	0,35	1,30
-	-	-	-	M	1,8	0,35	1,45
-	●	●	-	M	2	0,40	1,60
●	-	●	-	M	2,2	0,45	1,75
-	-	●	-	M	2,3*	0,40	1,90
●	-	●	-	M	2,5	0,45	2,05
-	-	●	-	M	2,6*	0,45	2,10
●	●	●	●	M	3	0,50	2,50
●	-	●	●	M	3,5	0,60	2,90
●	●	●	●	M	4	0,70	3,30
-	-	-	-	M	4*	0,75	3,25
●	●	●	●	M	5	0,80	4,20
●	●	●	●	M	6	1,00	5,00
■	●	●	-	M	7	1,00	6,00
●	-	●	●	M	8	1,25	6,80
-	-	-	-	M	9	1,25	7,80
●	-	●	●	M	10	1,50	8,50
-	-	6617	6740				

Ultra-s: **mit Schmiernuten für Bleche**
with coolant grooves for sheet metals

AZ: **mit Schmiernuten für Bleche**
interrupted threads

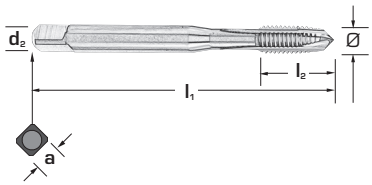
NL15°: **15° Linksdrall**
15° left hand helix

● **Standartartikel /** Items available ex stock

DIN 371

Maschinen-Gewindebohrer mit verstärktem Schaft
für Metrisches ISO-Gewinde nach DIN 13
Machine taps with reinforced shank
for ISO metric coarse thread as per DIN 13

M | TiN | TINOX | XP TOP | TiAlN Futura



Typ / Type	VA	VA	VAP	VA	VA	VA
Toleranz Tolerance	6 HX	6 HX	6 HX	6 HX	6 HX	6 GX
Anschnitt / Gangzahl Chamfer form / No. of threads	B/4-5	B/4-5	B/4-5	B/4-5	B/4-5	B/4-5
Schneidrichtung Cutting direction						
Schneidstoff/ Material	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co

Ø mm	Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a h12	6646	6646 XP	6646 VP	6646 TN	6646 TX	6646 6G
M 1	0,25	0,75	40	5,5	2,5	2,1	-	-	-	-	-	-
M 1,2	0,25	0,95	40	5,5	2,5	2,1	-	-	-	-	-	-
M 1,4	0,30	1,10	40	7,0	2,5	2,1	-	-	-	-	-	-
M 1,6	0,35	1,25	40	8,0	2,5	2,1	-	-	-	-	-	-
M 1,7*	0,35	1,30	40	8,0	2,5	2,1	-	-	-	-	-	-
M 1,8	0,35	1,45	40	8,0	2,5	2,1	-	-	-	-	-	-
M 2	0,40	1,60	45	8,0	2,8	2,1	●	●	●	●	●	●
M 2,2	0,45	1,75	45	9,0	2,8	2,1	●	●	●	●	●	●
M 2,3*	0,40	1,90	45	9,0	2,8	2,1	●	-	●	●	●	-
M 2,5	0,45	2,05	50	9,0	2,8	2,1	●	●	●	●	●	●
M 2,6*	0,45	2,10	50	9,0	2,8	2,1	●	-	●	●	●	-
M 3	0,50	2,50	56	11,0	3,5	2,7	●	●	●	●	●	●
M 3,5	0,60	2,90	56	13,0	4,0	3,0	●	-	●	●	●	-
M 4	0,70	3,30	63	13,0	4,5	3,4	●	●	●	●	●	●
M 4*	0,75	3,25	63	13,0	4,5	3,4	-	-	-	-	-	-
M 5	0,80	4,20	70	16,0	6,0	4,9	●	●	●	●	●	●
M 6	1,00	5,00	80	19,0	6,0	4,9	●	●	●	●	●	●
M 7	1,00	6,00	80	19,0	7,0	5,5	●	-	●	●	●	-
M 8	1,25	6,80	90	22,0	8,0	6,2	●	●	●	●	●	●
M 9	1,25	7,80	90	22,0	9,0	7,0	-	-	-	-	-	-
M 10	1,50	8,50	100	24,0	10,0	8,0	●	●	●	●	●	●
Abmessungen mit Überlaufschaft über M 10 siehe Kat.-Nr / above M 10 refer to Cat.-No.							6647	6647XP	6647VP	-	6647XP	66476G

VA: **Für rostfreien Stahl**
for stainless steel
VAP: **vaporisiert**
vaporized

* Diese Gewinde sind im Metrischen ISO-Gewinde nicht enthalten / These sizes are not ISO standard.

● Standardartikel / Items available ex stock

DIN 371

Maschinen-Gewindebohrer mit verstärktem Schaft
für Metrisches ISO-Gewinde nach DIN 13
Machine taps with reinforced shank
for ISO metric coarse thread as per DIN 13

Alu	HD	HD	HD	**Typ /** Type
6 H	6 H	6 H	6 H	**Toleranz** Tolerance
B/4-5	B/4-5	B/4-5	B/4-5	**Anschnitt / Gangzahl** Chamfer form / No. of threads
				Schneidrichtung Cutting direction
HSS-Co	HSS-Co	HSS-Co	HSS-Co	**Schneidstoff/** Material

6641	6870	6870 TN	6870 TF	Ø mm		Steigung Pitch	Kernloch Ø Tap drill Ø
-	-	-	-	M	1	0,25	0,75
-	-	-	-	M	1,2	0,25	0,95
-	-	-	-	M	1,4	0,30	1,10
-	-	-	-	M	1,6	0,35	1,25
-	-	-	-	M	1,7*	0,35	1,30
-	-	-	-	M	1,8	0,35	1,45
●	●	●	●	M	2	0,40	1,60
●	●	●	●	M	2,2	0,45	1,75
●	-	-	-	M	2,3*	0,40	1,90
●	●	●	●	M	2,5	0,45	2,05
●	-	-	-	M	2,6*	0,45	2,10
●	●	●	●	M	3	0,50	2,50
●	-	-	-	M	3,5	0,60	2,90
●	●	●	●	M	4	0,70	3,30
-	-	-	-	M	4*	0,75	3,25
●	●	●	●	M	5	0,80	4,20
●	●	●	●	M	6	1,00	5,00
●	●	●	●	M	7	1,00	6,00
●	●	●	●	M	8	1,25	6,80
-	-	-	-	M	9	1,25	7,80
●	●	●	●	M	10	1,50	8,50
6642	6871	6871TN	6871TF				

HD: für zähe Werkstoffe
for tough materials
Alu: für Aluminium
for Aluminium

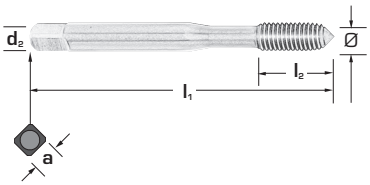
● Standardartikel / Items available ex stock

DIN 371

Innengewinde-Former mit verstärktem Schaft
für Metrisches ISO-Gewinde nach DIN 13
Cold forming taps with reinforced shank
for ISO metric coarse thread as per DIN 13

Ref. **6722 – 6622** mit Schmiernuten / with coolant grooves

M | TiN | TINOX | TiAlN Futura



Typ / Type	Former	Former	Former	Former
Toleranz / Tolerance	6 HX	6 GX	6 HX	6 GX
Anschnitt / Gangzahl / Chamfer form / No. of threads	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3
Schneidrichtung / Cutting direction				
Schneidstoff / Material	HSS-Co	HSS-Co	HSS-Co	HSS-Co

Ø mm	Steigung / Pitch	Kernloch Ø / Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a h12	6722	6622	6722 BL	6622 BL
M 1**	0,25	0,88	40	5,5	2,5	2,1	●	-	●	-
M 1,1**	0,25	0,98	40	5,5	2,5	2,1	●	-	●	-
M 1,2**	0,25	1,08	40	5,5	2,5	2,1	●	-	●	-
M 1,4**	0,30	1,25	40	7,0	2,5	2,1	●	-	●	-
M 1,6	0,35	1,45	40	8,0	2,5	2,1	●	-	●	-
M 1,7*	0,35	1,55	40	8,0	2,5	2,1	●	-	●	-
M 1,8	0,35	1,65	40	8,0	2,5	2,1	●	-	●	-
M 2	0,40	1,80	45	8,0	2,8	2,1	●	●	●	●
M 2,2	0,45	2,00	45	9,0	2,8	2,1	●	-	●	-
M 2,3*	0,40	2,10	45	9,0	2,8	2,1	●	-	●	-
M 2,5	0,45	2,30	50	9,0	2,8	2,1	●	●	●	●
M 2,6*	0,45	2,40	50	9,0	2,8	2,1	●	-	●	-
M 3	0,50	2,75	56	11,0	3,5	2,7	●	●	●	●
M 3,5	0,60	3,20	56	13,0	4,0	3,0	●	●	●	●
M 4	0,70	3,65	63	13,0	4,5	3,4	●	●	●	●
M 5	0,80	4,60	70	16,0	6,0	4,9	●	●	●	●
M 6	1,00	5,50	80	19,0	6,0	4,9	●	●	●	●
M 7	1,00	6,50	80	19,0	7,0	5,5	●	-	●	-
M 8	1,25	7,40	90	22,0	8,0	6,2	●	●	●	●
M 10	1,50	9,30	100	24,0	10,0	8,0	●	●	●	●
Abmessungen mit Überlaufschaft über M 10 siehe Kat.-Nr / above M 10 refer to Cat.-No.							6723	6623	6723	6623

* Diese Gewinde sind im Metrischen ISO-Gewinde nicht enthalten / These sizes are not ISO standard.
** Toleranz 5H / Tolerance 5H

● Standardartikel / Items available ex stock

DIN 371

Innengewinde-Former mit verstärktem Schaft
für Metrisches ISO-Gewinde nach DIN 13
Cold forming taps with reinforced shank
for ISO metric coarse thread as per DIN 13

Ref. **6722 – 6622** mit Schmiernuten / with coolant grooves

Former	Former	Former	Former	Former	Former	**Typ /** Type
6 HX	6 GX	6 HX	6 GX	6 HX	6 GX	**Toleranz** Tolerance
C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	**Anschnitt / Gangzahl** Chamfer form / No. of threads
						Schneidrichtung Cutting direction
HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	**Schneidstoff/** Material

6722 TN	6622 TN	6722 TF	6622 TF	6722 TX	6622 TX	Ø mm	Steigung Pitch	Kernloch Ø Tap drill Ø
●	-	●	-	●	-	M 1**	0,25	0,88
●	-	●	-	●	-	M 1,1**	0,25	0,98
●	-	●	-	●	-	M 1,2**	0,25	1,08
●	-	●	-	●	-	M 1,4**	0,30	1,25
●	-	●	-	●	-	M 1,6	0,35	1,45
●	-	●	-	●	-	M 1,7*	0,35	1,55
●	-	●	-	●	-	M 1,8	0,35	1,65
●	●	●	●	●	●	M 2	0,40	1,80
●	-	●	-	●	-	M 2,2	0,45	2,00
●	-	●	-	●	-	M 2,3*	0,40	2,10
●	●	●	●	●	●	M 2,5	0,45	2,30
●	-	●	-	●	-	M 2,6*	0,45	2,40
●	●	●	●	●	●	M 3	0,50	2,75
●	●	●	●	●	●	M 3,5	0,60	3,20
●	●	●	●	●	●	M 4	0,70	3,65
●	●	●	●	●	●	M 5	0,80	4,60
●	●	●	●	●	●	M 6	1,00	5,50
●	-	●	-	●	-	M 7	1,00	6,50
●	●	●	●	●	●	M 8	1,25	7,40
●	●	●	●	●	●	M 10	1,50	9,30
6723TN	6623TN	6723TF	6623TF	6723TX	6623TX			

* Diese Gewinde sind im Metrischen ISO-Gewinde nicht enthalten / These sizes are not ISO standard.
** Toleranz 5H / Tolerance 5H

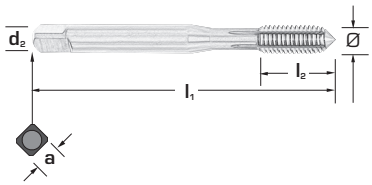
● Standardartikel / Items available ex stock

DIN 371

Innengewinde-Former mit verstärktem Schaft
für Metrisches ISO-Gewinde nach DIN 13
Cold forming taps with reinforced shank
for ISO metric coarse thread as per DIN 13

Ref. **6709 – 6819** mit Schmiernuten / with coolant grooves

M | TiN | TINOX | TiAlN Futura



Typ / Type	Former s	Former s	Former s	Former s
Toleranz Tolerance	6 HX	6 GX	6 HX	6 GX
Anschnitt / Gangzahl Chamfer form / No. of threads	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3
Schneidrichtung Cutting direction				
Schneidstoff/ Material	HSS-Co	HSS-Co	HSS-Co	HSS-Co

Ø mm	Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a h12	6709	6808	6709 BL	6808 BL
M 3,0	0,50	2,75	56	11	3,5	2,7	●	●	●	●
M 3,5	0,60	3,20	56	13	4,0	3,0	●	●	●	●
M 4,0	0,70	3,65	63	13	4,5	3,4	●	●	●	●
M 5,0	0,80	4,60	70	16	6,0	4,9	●	●	●	●
M 6,0	1,00	5,50	80	19	6,0	4,9	●	●	●	●
M 7,0	1,00	6,50	80	19	7,0	5,5	●	-	●	-
M 8,0	1,25	7,40	90	22	8,0	6,2	●	●	●	●
M 10,0	1,50	9,30	100	24	10,0	8,0	●	●	●	●
Abmessungen mit Überlaufschaft über M 10 siehe Kat.-Nr / above M 10 refer to Cat.-No.							6725	6809	6725	6809

Former s: mit Schmiernuten
with coolant grooves

● Standardartikel / Items available ex stock

DIN 371

Innengewinde-Former mit verstärktem Schaft
für Metrisches ISO-Gewinde nach DIN 13
Cold forming taps with reinforced shank
for ISO metric coarse thread as per DIN 13

Ref. **6709 – 6819** mit Schmiernuten / with coolant grooves

Former s	Former s	Former s	Former s	Former s	Former s	Former s	**Typ /** Type
6 HX	6 GX	6 HX	6 GX	6 HX	6 GX	7 GX	**Toleranz** Tolerance
C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	**Anschnitt / Gangzahl** Chamfer form / No. of threads
							Schneidrichtung Cutting direction
HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	**Schneidstoff/** Material
6709 TN	**6808 TN**	**6709 TF**	**6808 TF**	**6709 TX**	**6808 TX**	**6819**	**Ø mm**	**Steigung** Pitch	**Kernloch Ø** Tap drill Ø
●	●	●	●	●	●	-	**M 3,0**	0,50	2,75
●	●	●	●	●	●	-	**M 3,5**	0,60	3,20
●	●	●	●	●	●	-	**M 4,0**	0,70	3,65
●	●	●	●	●	●	-	**M 5,0**	0,80	4,60
●	●	●	●	●	●	●	**M 6,0**	1,00	5,50
●	-	●	-	●	-	-	**M 7,0**	1,00	6,50
●	●	●	●	●	●	●	**M 8,0**	1,25	7,40
●	●	●	●	●	●	●	**M 10,0**	1,50	9,30
6725TN	6809TN	6725TF	6809TF	6725TX	6809TX	-			

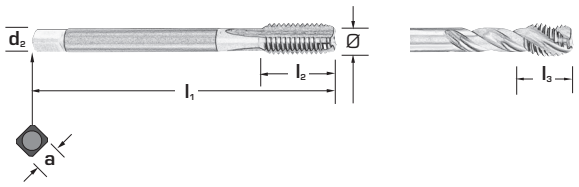
Former s: mit Schmiernuten
with coolant grooves

● Standardartikel / Items available ex stock

DIN 376

Maschinen-Gewindebohrer mit Überlaufschaft
für Metrisches ISO-Gewinde nach DIN 13
Machine taps with reduced shank
for ISO-metric coarse thread as per DIN 13

M TiN TICN



Typ / Type	N	N	N	N	AZ	N 15°	N 15°	N 15°	N 15°
Toleranz / Tolerance	6 H	6 H	6 H	6 H	6 H	6 H	6 H	6 H	6 H+0,1
Anschnitt / Gangzahl / Chamfer form / No. of threads	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3
Schneidrichtung / Cutting direction									
Schneidstoff / Material	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co

Ø mm		Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	l_3 mm	d_2 mm h9	a h12	6705	6705 TN	6705 TC	6715	6821	6658	6658 TN	6658 TC	6903
M	2	0,40	1,60	45	8	-	1,4	-	●	●	●	-	-	-	-	-	-
M	2,2	0,45	1,75	45	9	-	1,6	-	■	-	-	-	-	-	-	-	-
M	2,3*	0,40	1,90	45	9	-	1,6	-	●	●	●	-	-	-	-	-	-
M	2,5	0,45	2,05	50	9	-	1,8	-	●	●	●	-	-	-	-	-	-
M	2,6*	0,45	2,10	50	9	4	1,8	-	●	●	●	-	-	-	-	-	-
M	3	0,50	2,50	56	11	5	2,2	-	●	●	●	-	-	-	-	-	-
M	3,5	0,60	2,90	56	13	6	2,5	2,1	●	●	●	-	-	-	-	-	-
M	4	0,70	3,30	63	13	7	2,8	2,1	●	●	●	-	-	-	-	-	-
M	5	0,80	4,20	70	16	8	3,5	2,7	●	●	●	-	-	-	-	-	-
M	6	1,00	5,00	80	19	10	4,5	3,4	●	●	●	-	●	-	-	-	-
M	7	1,00	6,00	80	19	10	5,5	4,3	●	●	●	-	-	-	-	-	-
M	8	1,25	6,80	90	22	12	6,0	4,9	●	●	●	-	●	●	●	●	-
M	9	1,25	7,80	90	22	19	7,0	5,5	●	●	●	-	-	-	-	-	-
M	10	1,50	8,50	100	24	14	7,0	5,5	●	●	●	-	●	●	●	●	-
M	12	1,75	10,20	110	29	16	9,0	7,0	●	●	●	●	●	●	●	●	●
M	14	2,00	12,00	110	30	20	11,0	9,0	●	●	●	●	-	●	●	●	●
M	16	2,00	14,00	110	32	20	12,0	9,0	●	●	●	●	●	●	●	●	●
M	18	2,50	15,50	125	34	24	14,0	11,0	●	●	●	●	-	●	●	●	-
M	20	2,50	17,50	140	34	25	16,0	12,0	●	●	●	●	●	●	●	●	●
M	22	2,50	19,50	140	34	25	18,0	14,5	●	●	●	●	-	●	●	●	-
M	24	3,00	21,00	160	38	30	18,0	14,5	●	●	●	●	●	●	●	●	-
M	27	3,00	24,00	160	38	30	20,0	16,0	●	●	●	-	-	●	●	●	-
M	30	3,50	26,50	180	45	35	22,0	18,0	●	●	●	-	-	●	●	●	-
M	33	3,50	29,50	180	50	-	25,0	20,0	●	●	●	-	-	-	-	-	-
M	36	4,00	32,00	200	56	-	28,0	22,0	●	●	●	-	-	-	-	-	-
M	39	4,00	35,00	200	60	-	32,0	24,0	●	●	●	-	-	-	-	-	-
M	42	4,50	37,50	200	60	-	32,0	24,0	●	●	●	-	-	-	-	-	-
M	45	4,50	40,50	220	65	-	36,0	29,0	●	●	●	-	-	-	-	-	-
M	48	5,00	43,00	250	70	-	36,0	29,0	●	●	●	-	-	-	-	-	-
M	52	5,00	47,00	250	70	-	40,0	32,0	●	●	●	-	-	-	-	-	-

N: Herkömmliche Anwendung universal application

N 15°: 15° Rechtsdrall 15° right hand helix

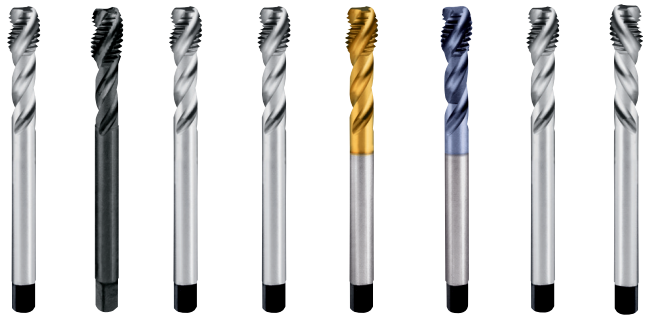
AZ: Ausgesetzte Zähne interrupted threads

* Diese Gewinde sind im Metrischen ISO-Gewinde nicht enthalten / These sizes are not ISO standard.

● Standardartikel / Items available ex stock ■ Auslaufender Artikel / discontinued items

DIN 376

Maschinen-Gewindebohrer mit Überlaufschaft
für Metrisches ISO-Gewinde nach DIN 13
Machine taps with reduced shank
for ISO-metric coarse thread as per DIN 13



N 40°	N VAP 40°	N 40°	N 40°	N 40°	N 40°	N 40°	N Sx 40°	**Typ /** Type
6 H	6 H	6 G	7 G	6 H	6 H	6 H	6 H	**Toleranz** Tolerance
C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	E/1,5-2	C/2,5-3	**Anschnitt / Gangzahl** Chamfer form / No. of threads
								Schneidrichtung Cutting direction
HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	**Schneidstoff/** Material

6638	6638 VP	6638 6G	6638 7G	6638 TN	6638 TC	6868	6862	Ø mm	Steigung Pitch	Kernloch Ø Tap drill Ø
-	-	-	-	-	-	-	-	M 2	0,40	1,60
-	-	-	-	-	-	-	-	M 2,2	0,45	1,75
-	-	-	-	-	-	-	-	M 2,3*	0,40	1,90
-	-	-	-	-	-	-	-	M 2,5	0,45	2,05
-	-	-	-	-	-	-	-	M 2,6*	0,45	2,10
●	●	●	-	-	-	-	-	M 3	0,50	2,50
●	●	●	-	-	-	-	-	M 3,5	0,60	2,90
●	●	●	-	-	-	-	-	M 4	0,70	3,30
●	●	●	-	-	-	-	-	M 5	0,80	4,20
●	●	●	-	-	-	-	-	M 6	1,00	5,00
●	●	-	-	-	-	-	-	M 7	1,00	6,00
●	●	●	●	-	-	-	-	M 8	1,25	6,80
●	●	-	-	-	-	-	-	M 9	1,25	7,80
●	●	●	●	-	-	-	-	M 10	1,50	8,50
●	●	●	●	●	●	●	●	M 12	1,75	10,20
●	●	●	-	●	●	●	●	M 14	2,00	12,00
●	●	●	●	●	●	●	●	M 16	2,00	14,00
●	●	●	-	●	●	●	●	M 18	2,50	15,50
●	●	●	●	●	●	●	●	M 20	2,50	17,50
●	●	●	-	-	-	-	-	M 22	2,50	19,50
●	●	●	●	-	-	-	-	M 24	3,00	21,00
●	●	-	-	-	-	-	-	M 27	3,00	24,00
●	●	●	-	-	-	-	-	M 30	3,50	26,50
●	●	-	-	-	-	-	-	M 33	3,50	29,50
●	●	-	-	-	-	-	-	M 36	4,00	32,00
-	-	-	-	-	-	-	-	M 39	4,00	35,00
-	-	-	-	-	-	-	-	M 42	4,50	37,50
-	-	-	-	-	-	-	-	M 45	4,50	40,50
-	-	-	-	-	-	-	-	M 48	5,00	43,00
-	-	-	-	-	-	-	-	M 52	5,00	47,00

N 40°: **Rechtsrall a 40°**
40° right hand helix

VAP: **vaporisiert**
vaporized

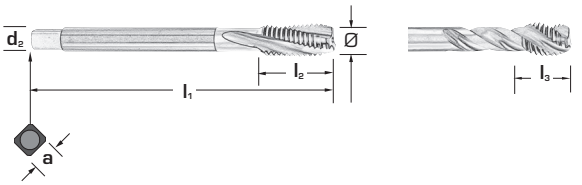
● Standardartikel / Items available ex stock

DIN 376

Maschinen-Gewindebohrer mit Überlaufschaft
für Metrisches ISO-Gewinde nach DIN 13
Machine taps with reduced shank
for ISO-metric coarse thread as per DIN 13

M | TiN | TINOX | XP TOP

Axialer Kühlmittelaustritt
Axial internal cooling



Ø mm		Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	l_3 mm	d_2 mm h9	a h12	Typ / Type: VA 15° 6634	VA i 15° 6605	VA i 15° 6605 XP
									6 HX	6 HX	6 HX
									C/2,5-3	C/2,5-3	C/2,5-3
									HSS-Co	HSS-Co	HSS-Co
M	12	1,75	10,2	110	29	16	9	7,0	●	●	●
M	14	2,00	12,0	110	30	20	11	9,0	●	-	-
M	16	2,00	14,0	110	32	20	12	9,0	●	●	●
M	18	2,50	15,5	125	34	24	14	11,0	●	-	-
M	20	2,50	17,5	140	34	25	16	12,0	●	●	●
M	22	2,50	19,5	140	34	25	18	14,5	●	-	-
M	24	3,00	21,0	160	38	30	18	14,5	●	-	-

VA: **Für rostfreien Stahl**
for stainless steel

VA i: **Für rostfreien Stahl mit Innenkühlung**
for stainless steel, with internal cooling

● Standardartikel / Items available ex stock

DIN 376

Maschinen-Gewindebohrer mit Überlaufschaft
für Metrisches ISO-Gewinde nach DIN 13
Machine taps with reduced shank
for ISO-metric coarse thread as per DIN 13

VR 35°	VRP 35°	VR 35°	VR 35°	VR 35°	VRP 50°	VR 50°	**Typ /** Type
6 HX	6 HX	6 HX	6 HX	6 GX	6 HX	6 HX	**Toleranz** Tolerance
C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	**Anschnitt / Gangzahl** Chamfer form / No. of threads
							Schneidrichtung Cutting direction
HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	**Schneidstoff/** Material
6662	**6662 VP**	**6662 TX**	**6662 XP**	**6662 6G**	**6851 VP**	**6851 TN**	**Ø mm**	**Steigung** Pitch	**Kernloch Ø** Tap drill Ø
●	●	●	●	●	●	●	**M 12**	1,75	10,2
●	●	●	●	●	●	●	**M 14**	2,00	12,0
●	●	●	●	●	●	●	**M 16**	2,00	14,0
●	●	●	●	-	●	●	**M 18**	2,50	15,5
●	●	●	●	-	●	●	**M 20**	2,50	17,5
●	●	●	●	-	-	-	**M 22**	2,50	19,5
●	●	●	●	-	●	●	**M 24**	3,00	21,0

VR: **Für rostfreien Stahl, mit Abschrägung**
for stainless steel, back tapered
VRP: **Für rostfreien Stahl mit Abschrägung und vaporisiert**
for stainless steel, back tapered and vaporized

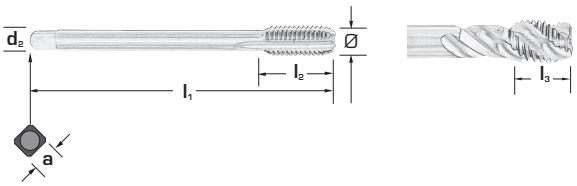
● Standardartikel / Items available ex stock

DIN 376

Maschinen-Gewindebohrer mit Überlaufschaft
für Metrisches ISO-Gewinde nach DIN 13
Machine taps with reduced shank
for ISO-metric coarse thread as per DIN 13

M | TICN | TiN | HARD LUBE | TiAlN Futura

Axialer Kühlmittelaustritt
Axial internal cooling



Typ / Type									GG	GG	Multi GGi	Multi GGi	Alu 45°
Toleranz Tolerance									6 HX	6 HX	6 HX	6 HX	6 HX
Anschnitt / Gangzahl Chamfer form / No. of threads									C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3
Schneidrichtung Cutting direction													
Schneidstoff/ Material									HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co
Ø mm		**Steigung** Pitch	**Kernloch Ø** Tap drill Ø	**l_1** mm	**l_2** mm	**l_3** mm	**d_2** mm h9	**a** h12	**6632**	**6632 TF**	**6637**	**6637 TC**	**6651**
M	3	0,50	2,5	56	11	5	2,2	-	-	-	-	-	-
M	3,5	0,60	2,9	56	13	6	2,5	2,1	-	-	-	-	-
M	4	0,70	3,3	63	13	7	2,8	2,1	-	-	-	-	-
M	5	0,80	4,2	70	16	8	3,5	2,7	-	-	-	-	-
M	6	1,00	5,0	80	19	10	4,5	3,4	●	●	-	-	-
M	7	1,00	6,0	80	19	10	5,5	4,3	●	●	-	-	-
M	8	1,25	6,8	90	22	12	6,0	4,9	●	●	-	-	-
M	10	1,50	8,5	100	24	14	7,0	5,5	●	●	-	-	-
M	12	1,75	10,2	110	29	16	9,0	7,0	●	●	●	●	●
M	14	2,00	12,0	110	30	20	11,0	9,0	●	●	-	-	●
M	16	2,00	14,0	110	32	20	12,0	9,0	●	●	●	●	●
M	18	2,50	15,5	125	34	24	14,0	11,0	●	●	●	●	●
M	20	2,50	17,5	140	34	25	16,0	12,0	●	●	●	●	●
M	22	2,50	19,5	140	34	25	18,0	14,5	●	●	-	-	-
M	24	3,00	21,0	160	38	30	18,0	14,5	●	●	-	-	-
M	27	3,00	24,0	160	38	30	20,0	16,0	●	●	-	-	-
M	30	3,50	26,5	180	45	35	22,0	18,0	●	●	-	-	-

GG: **für Guss**
for cast iron
Alu: **für Aluminium**
for Aluminium

MULTI GG i: **Hochleistungs - Gewindebohrer mit Kühlkanälen für Guß**
High performance taps with internal cooling for cast iron

● Standardartikel / Items available ex stock

DIN 376

Maschinen-Gewindebohrer mit Überlaufschaft
für Metrisches ISO-Gewinde nach DIN 13
Machine taps with reduced shank
for ISO-metric coarse thread as per DIN 13

HD 15°	HD 15°	HD 40°	HD 40°	HD 40°	HR 40°	HR 40°	**Typ /** Type
6 H	6 H	6 H	6 H	6 H	6 H	6 H	**Toleranz** Tolerance
C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	**Anschnitt / Gangzahl** Chamfer form / No. of threads
							Schneidrichtung Cutting direction
HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	**Schneidstoff/** Material
6879	**6879 HL**	**6667**	**6667 TN**	**6667 TF**	**6689**	**6689 TF**	**Ø mm**	**Steigung** Pitch	**Kernloch Ø** Tap drill Ø
-	-	●	●	●	-	-	**M 3**	0,50	2,5
-	-	●	●	●	-	-	**M 3,5**	0,60	2,9
-	-	●	●	●	-	-	**M 4**	0,70	3,3
-	-	●	●	●	-	-	**M 5**	0,80	4,2
-	-	●	●	●	-	-	**M 6**	1,00	5,0
-	-	●	●	●	-	-	**M 7**	1,00	6,0
-	-	●	●	●	-	-	**M 8**	1,25	6,8
-	-	●	●	●	-	-	**M 10**	1,50	8,5
●	●	●	●	●	●	●	**M 12**	1,75	10,2
●	●	●	●	●	●	●	**M 14**	2,00	12,0
●	●	●	●	●	●	●	**M 16**	2,00	14,0
●	●	●	●	●	●	●	**M 18**	2,50	15,5
●	●	●	●	●	●	●	**M 20**	2,50	17,5
●	●	-	-	-	-	-	**M 22**	2,50	19,5
●	●	-	-	-	-	-	**M 24**	3,00	21,0
●	●	-	-	-	-	-	**M 27**	3,00	24,0
●	●	-	-	-	-	-	**M 30**	3,50	26,5

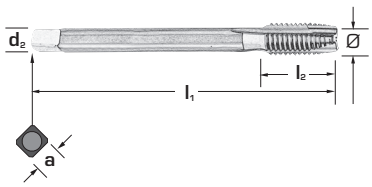
HD: **für zähe Werkstoffe**
for tough materials
HR: **für zähe Werkstoffe Abschrägung**
for tough materials, back tapered

● Standardartikel / Items available ex stock

DIN 376

Maschinen-Gewindebohrer mit Überlaufschaft
für Metrisches IOS-Gewinde nach DIN 13
Machine taps with reduced shank
for ISO metric coarse thread as per DIN 13

M | TiN | TICN



Typ / Type	Rapid	Rapid VAP	Rapid	Rapid	Rapid
Toleranz / Tolerance	6 H	6 H	6 G	6 H	6 H
Anschnitt / Gangzahl / Chamfer form / No. of threads	B/4-5	B/4-5	B/4-5	B/4-5	B/4-5
Schneidrichtung / Cutting direction					
Schneidstoff / Material	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co

Ø mm		Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a h12	6711	6711 VP	6711 6G	6711 TN	6711 TC
M	2	0,40	1,60	45	8	1,4	-	●	●	●	-	-
M	2,2	0,45	1,75	45	9	1,6	-	●	●	-	-	-
M	2,3*	0,40	1,90	45	9	1,6	-	●	●	-	-	-
M	2,5	0,45	2,05	50	9	1,8	-	●	●	●	-	-
M	2,6*	0,45	2,10	50	9	1,8	-	●	●	-	-	-
M	3	0,50	2,50	56	11	2,2	-	●	●	●	-	-
M	3,5	0,60	2,90	56	13	2,5	2,1	●	●	●	-	-
M	4	0,70	3,30	63	13	2,8	2,1	●	●	●	-	-
M	5	0,80	4,20	70	16	3,5	2,7	●	●	●	-	-
M	6	1,00	5,00	80	19	4,5	3,4	●	●	●	-	-
M	7	1,00	6,00	80	19	5,5	4,3	●	●	-	-	-
M	8	1,25	6,80	90	22	6,0	4,9	●	●	●	-	-
M	9	1,25	7,80	90	22	7,0	5,5	●	●	-	-	-
M	10	1,50	8,50	100	24	7,0	5,5	●	●	●	-	-
M	12	1,75	10,20	110	29	9,0	7,0	●	●	●	●	●
M	14	2,00	12,00	110	30	11,0	9,0	●	●	●	●	●
M	16	2,00	14,00	110	32	12,0	9,0	●	●	●	●	●
M	18	2,50	15,50	125	34	14,0	11,0	●	●	●	●	●
M	20	2,50	17,50	140	34	16,0	12,0	●	●	●	●	●
M	22	2,50	19,50	140	34	18,0	14,5	●	●	●	-	-
M	24	3,00	21,00	160	38	18,0	14,5	●	●	●	-	-
M	27	3,00	24,00	160	38	20,0	16,0	●	●	●	-	-
M	30	3,50	26,50	180	45	22,0	18,0	●	●	-	-	-
M	33	3,50	29,50	180	50	25,0	20,0	●	●	●	-	-
M	36	4,00	32,00	200	56	28,0	22,0	●	●	●	-	-
M	39	4,00	35,00	200	60	32,0	24,0	●	●	●	-	-
M	42	4,50	37,50	200	60	32,0	24,0	●	●	●	-	-
M	45	4,50	40,50	220	65	36,0	29,0	●	●	-	-	-
M	48	5,00	43,00	250	70	36,0	29,0	●	●	●	-	-
M	52	5,00	47,00	250	70	40,0	32,0	●	●	-	-	-

Rapid: **Herkömmliche Anwendung** universal application
VAP: **vaporisiert** vaporized

* Diese Gewinde sind im Metrischen ISO-Gewinde nicht enthalten / These sizes are not ISO standard.

● Standardartikel / Items available ex stock

DIN 376

Maschinen-Gewindebohrer mit Überlaufschaft
für Metrisches IOS-Gewinde nach DIN 13
Machine taps with reduced shank
for ISO metric coarse thread as per DIN 13

Rapid	N Sx					
					Typ / Type	
7 G	6 H				**Toleranz** Tolerance	
B/4-5	B/4-5				**Anschnitt / Gangzahl** Chamfer form / No. of threads	
					Schneidrichtung Cutting direction	
HSS-Co	HSS-Co				**Schneidstoff/** Material	
6711 7G	**6860**		**Ø mm**		**Steigung** Pitch	**Kernloch Ø** Tap drill Ø
-	-		**M**	**2**	0,40	1,60
-	-		**M**	**2,2**	0,45	1,75
-	-		**M**	**2,3***	0,40	1,90
-	-		**M**	**2,5**	0,45	2,05
-	-		**M**	**2,6***	0,45	2,10
-	-		**M**	**3**	0,50	2,50
-	-		**M**	**3,5**	0,60	2,90
-	-		**M**	**4**	0,70	3,30
-	-		**M**	**5**	0,80	4,20
-	-		**M**	**6**	1,00	5,00
-	-		**M**	**7**	1,00	6,00
●	-		**M**	**8**	1,25	6,80
-	-		**M**	**9**	1,25	7,80
●	-		**M**	**10**	1,50	8,50
●	●		**M**	**12**	1,75	10,20
-	●		**M**	**14**	2,00	12,00
●	●		**M**	**16**	2,00	14,00
-	●		**M**	**18**	2,50	15,50
●	●		**M**	**20**	2,50	17,50
-	-		**M**	**22**	2,50	19,50
●	-		**M**	**24**	3,00	21,00
-	-		**M**	**27**	3,00	24,00
-	-		**M**	**30**	3,50	26,50
-	-		**M**	**33**	3,50	29,50
-	-		**M**	**36**	4,00	32,00
-	-		**M**	**39**	4,00	35,00
-	-		**M**	**42**	4,50	37,50
-	-		**M**	**45**	4,50	40,50
-	-		**M**	**48**	5,00	43,00
-	-		**M**	**52**	5,00	47,00

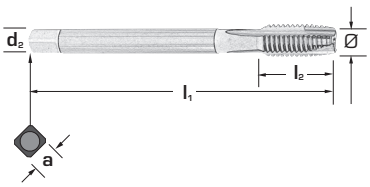
Rapid: **Herkömmliche Anwendung**
universal application

● Standardartikel / Items available ex stock

DIN 376

Maschinen-Gewindebohrer mit Überlaufschaft
für Metrisches IOS-Gewinde nach DIN 13
Machine taps with reduced shank
for ISO metric coarse thread as per DIN 13

M | TiN | TiAlN Futura | XP TOP



Typ / Type	AZ	NL 15°	VA	VAP	VA	VA
Toleranz Tolerance	6 H	6 H	6 HX	6 HX	6 HX	6 GX
Anschnitt / Gangzahl Chamfer form / No. of threads	B/4-5	B/4-5	B/4-5	B/4-5	B/4-5	B/4-5
Schneidrichtung Cutting direction						
Schneidstoff/ Material	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co

Ø mm		Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a h12	6617	6740	6647	6647 VP	6647 XP	6647 6G
M	2	0,40	1,60	45	8	1,4	-	-	-	-	-	-	-
M	2,2	0,45	1,75	45	9	1,6	-	-	-	-	-	-	-
M	2,3*	0,40	1,90	45	9	1,6	-	-	-	-	-	-	-
M	2,5	0,45	2,05	50	9	1,8	-	-	-	-	-	-	-
M	2,6*	0,45	2,10	50	9	1,8	-	-	-	-	-	-	-
M	3	0,50	2,50	56	11	2,2	-	-	-	-	-	-	-
M	3,5	0,60	2,90	56	13	2,5	2,1	-	-	-	-	-	-
M	4	0,70	3,30	63	13	2,8	2,1	-	-	-	-	-	-
M	5	0,80	4,20	70	16	3,5	2,7	-	-	-	-	-	-
M	6	1,00	5,00	80	19	4,5	3,4	-	-	-	-	-	-
M	7	1,00	6,00	80	19	5,5	4,3	-	-	-	-	-	-
M	8	1,25	6,80	90	22	6,0	4,9	-	-	-	-	-	-
M	9	1,25	7,80	90	22	7,0	5,5	-	-	-	-	-	-
M	10	1,50	8,50	100	24	7,0	5,5	-	-	-	-	-	-
M	12	1,75	10,20	110	29	9,0	7,0	●	●	●	●	●	●
M	14	2,00	12,00	110	30	11,0	9,0	●	●	●	●	●	●
M	16	2,00	14,00	110	32	12,0	9,0	●	●	●	●	●	●
M	18	2,50	15,50	125	34	14,0	11,0	●	●	●	●	●	-
M	20	2,50	17,50	140	34	16,0	12,0	●	●	●	●	●	-
M	22	2,50	19,50	140	34	18,0	14,5	-	-	●	●	●	-
M	24	3,00	21,00	160	38	18,0	14,5	-	-	●	●	●	-
M	27	3,00	24,00	160	38	20,0	16,0	-	-	-	-	-	-
M	30	3,50	26,50	180	45	22,0	18,0	-	-	-	-	-	-

AZ: **Ausgesetzte Zähne** interrupted threads
NL15°: **15° Linksdrall** left hand helix
VAP: **vaporisiert** vaporized

* Diese Gewinde sind im Metrischen ISO-Gewinde nicht enthalten / These sizes are not ISO standard.

● Standardartikel / Items available ex stock

DIN 376

Maschinen-Gewindebohrer mit Überlaufschaft
für Metrisches IOS-Gewinde nach DIN 13
Machine taps with reduced shank
for ISO metric coarse thread as per DIN 13

HD	HD	HD	Alu	**Typ /** Type
6 H	6 H	6 H	6 H	**Toleranz** Tolerance
B/4-5	B/4-5	B/4-5	B/4-5	**Anschnitt / Gangzahl** Chamfer form / No. of threads
				Schneidrichtung Cutting direction
HSS-Co	HSS-Co	HSS-Co	HSS-Co	**Schneidstoff/** Material

6871	6871 TN	6871 TF	6642	Ø mm	Steigung Pitch	Kernloch Ø Tap drill Ø
-	-	-	-	M 2	0,40	1,60
-	-	-	-	M 2,2	0,45	1,75
-	-	-	-	M 2,3*	0,40	1,90
-	-	-	-	M 2,5	0,45	2,05
-	-	-	-	M 2,6*	0,45	2,10
-	-	-	-	M 3	0,50	2,50
-	-	-	-	M 3,5	0,60	2,90
-	-	-	-	M 4	0,70	3,30
-	-	-	-	M 5	0,80	4,20
-	-	-	-	M 6	1,00	5,00
-	-	-	-	M 7	1,00	6,00
-	-	-	-	M 8	1,25	6,80
-	-	-	-	M 9	1,25	7,80
-	-	-	-	M 10	1,50	8,50
●	●	●	●	M 12	1,75	10,20
●	●	●	●	M 14	2,00	12,00
●	●	●	●	M 16	2,00	14,00
●	●	●	●	M 18	2,50	15,50
●	●	●	●	M 20	2,50	17,50
-	-	-	-	M 22	2,50	19,50
●	●	●	-	M 24	3,00	21,00
●	●	●	-	M 27	3,00	24,00
●	●	●	-	M 30	3,50	26,50

HD : **für zähe Werkstoffe**
for tough materials
Alu : **für Aluminium**
for Aluminium

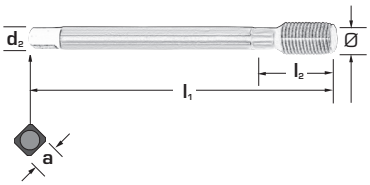
● Standardartikel / Items available ex stock

DIN 376

Maschinen-Gewindeformer mit Überlaufschaft
für Metrisches IOS-Gewinde nach DIN 13
Cold forming taps with reduced shank
for ISO metric coarse thread as per DIN

Ref. **6723 – 6623** ohne Schmiernuten / without coolant grooves

M TiN TINOX TiAlN Futura



Typ / Type								Former	Former	Former	Former
Toleranz / Tolerance								6 HX	6 GX	6 HX	6 GX
Anschnitt / Gangzahl / Chamfer form / No. of threads								C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3
Schneidrichtung / Cutting direction											
Schneidstoff / Material								HSS-Co	HSS-Co	HSS-Co	HSS-Co
Ø mm		Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a h12	6723	6623	6723 BL	6623 BL
M	12	1,75	11,2	110	29	9	7	●	●	●	●
M	14	2,00	13,0	110	30	11	9	●	●	●	●
M	16	2,00	15,0	110	32	12	9	●	●	●	●

Former: **ohne Schmiernuten**
without coolant grooves

● Standardartikel / Items available ex stock

DIN 376

Maschinen-Gewindeformer mit Überlaufschaft
für Metrisches IOS-Gewinde nach DIN 13
Cold forming taps with reduced shank
for ISO metric coarse thread as per DIN

Ref. **6723 – 6623** ohne Schmiernuten / without coolant grooves

Former	Former	Former	Former	Former	Former	**Typ /** Type
6 HX	6 GX	6 HX	6 GX	6 HX	6 GX	**Toleranz** Tolerance
C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	**Anschnitt / Gangzahl** Chamfer form / No. of threads
						Schneidrichtung Cutting direction
HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	**Schneidstoff/** Material
6723 TN	**6623 TN**	**6723 TF**	**6623 TF**	**6723 TX**	**6623 TX**	**Ø mm**	**Steigung** Pitch	**Kernloch Ø** Tap drill Ø
●	●	●	●	●	●	**M 12**	1,75	11,2
●	●	●	●	●	●	**M 14**	2,00	13,0
●	●	●	●	●	●	**M 16**	2,00	15,0

Former: **ohne Schmiernuten**
without coolant grooves

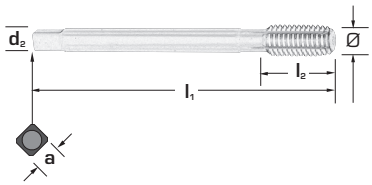
● Standardartikel / Items available ex stock

DIN 376

Maschinen-Gewindeformer mit Überlaufschaft
für Metrisches IOS-Gewinde nach DIN 13
Cold forming taps with reduced shank
for ISO metric coarse thread as per DIN

Ref. **6725 – 6809** mit Schmiernuten / with coolant grooves

M | TiN | TINOX | TiAlN Futura



Typ / Type								Former-S	Former-S	Former-S	Former-S
Toleranz Tolerance								6 HX	6 GX	6 HX	6 GX
Anschnitt / Gangzahl Chamfer form / No. of threads								C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3
Schneidrichtung Cutting direction											
Schneidstoff/ Material								HSS-Co	HSS-Co	HSS-Co	HSS-Co
Ø mm		**Steigung** Pitch	**Kernloch Ø** Tap drill Ø	**l_1** mm	**l_2** mm	**d_2** mm h9	**a** h12	**6725**	**6809**	**6725 BL**	**6809 BL**
M	12	1,75	11,2	110	29	9	7	●	●	●	●
M	14	2,00	13,0	110	30	11	9	●	●	●	●
M	16	2,00	15,0	110	32	12	9	●	●	●	●

Former S: **mit Schmiernuten**
with coolant grooves

● Standardartikel / Items available ex stock

DIN 376

Maschinen-Gewindeformer mit Überlaufschaft
für Metrisches IOS-Gewinde nach DIN 13
Cold forming taps with reduced shank
for ISO metric coarse thread as per DIN

Ref. **6725 – 6809** mit Schmiernuten / with coolant grooves

Former-S	Former-S	Former-S	Former-S	Former-S	Former-S	**Typ /** Type
6 HX	6 GX	6 HX	6 GX	6 HX	6 GX	**Toleranz** Tolerance
C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	**Anschnitt / Gangzahl** Chamfer form / No. of threads
						Schneidrichtung Cutting direction
HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	**Schneidstoff/** Material

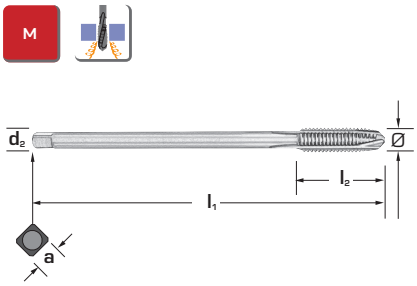
6725 TN	6809 TN	6725 TF	6809 TF	6725 TX	6809 TX	Ø mm		Steigung Pitch	Kernloch Ø Tap drill Ø
●	●	●	●	●	●	M	12	1,75	11,2
●	●	●	●	●	●	M	14	2,00	13,0
●	●	●	●	●	●	M	16	2,00	15,0

Former S: **mit Schmiernuten**
with coolant grooves

● Standardartikel / Items available ex stock

DIN 357

Maschinen-Gewindebohrer mit langem Schaft
für Metrisches ISO-Gewinde nach DIN 13
Machine taps with long shank
for ISO metric coarse thread as per DIN 13



Typ / Type									N
Toleranz Tolerance									6 H
Anschnitt / Gangzahl Chamfer form / No. of threads									B/4-5
Schneidrichtung Cutting direction									
Schneidstoff/ Material									HSS-Co
Ø mm		**Steigung** Pitch	**Kernloch Ø** Tap drill Ø	**l_1** mm	**l_2** mm	**d_2** mm h9	**a** h12		**6672**
M	**3**	0,50	2,5	70	18	2,2	-		●
M	**4**	0,70	3,3	90	22	2,8	2,1		●
M	**5**	0,80	4,2	100	24	3,5	2,7		●
M	**6**	1,00	5,0	110	25	4,5	3,4		●
M	**7**	1,00	6,0	110	25	5,5	4,3		●
M	**8**	1,25	6,8	125	28	6,0	4,9		●
M	**10**	1,50	8,5	140	30	7,0	5,5		●
M	**12**	1,75	10,2	180	35	9,0	7,0		●
M	**14**	2,00	12,0	200	35	11,0	9,0		●

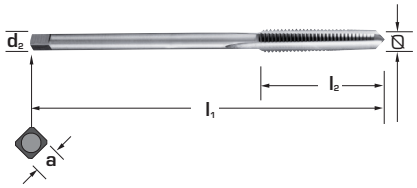
N: **Herkömmliche Anwendung**
universal application

● Standardartikel / Items available ex stock

DIN 357

Maschinen-Muttergewindebohrer mit langem Schaft für Metrisches ISO-Gewinde nach DIN 13

Machine nut taps with extra long lead, straight shank for ISO metric coarse thread as per DIN 13



									N
Typ / Type									
Toleranz Tolerance									6 H
Anschnitt / Gangzahl Chamfer form / No. of threads									A/6-8
Schneidrichtung Cutting direction									
Schneidstoff/ Material									HSS-Co
Ø mm		**Steigung** Pitch	**Kernloch Ø** Tap drill Ø	**l_1** mm	**l_2** mm	**d_2** mm h9	**a** h12		**6660**
M	**3**	0,50	2,5	70	22	2,2	-		●
M	**3,5**	0,60	2,9	80	25	2,5	2,1		●
M	**4**	0,70	3,3	90	25	2,8	2,1		●
M	**5**	0,80	4,2	100	28	3,5	2,7		●
M	**6**	1,00	5,0	110	32	4,5	3,4		●
M	**7**	1,00	6,0	110	36	5,5	4,3		●
M	**8**	1,25	6,8	125	40	6,0	4,9		●
M	**10**	1,50	8,5	140	45	7,0	5,5		●
M	**12**	1,75	10,2	180	50	9,0	7,0		●
M	**14**	2,00	12,0	200	56	11,0	9,0		●
M	**16**	2,00	14,0	200	63	12,0	9,0		●
M	**18**	2,50	15,5	220	63	14,0	11,0		●
M	**20**	2,50	17,5	250	70	16,0	12,0		●
M	**22**	2,50	19,5	280	80	18,0	14,5		●
M	**24**	3,00	21,0	280	80	18,0	14,5		●
M	**27**	3,00	24,0	315	90	20,0	16,0		●
M	**30**	3,50	26,5	315	100	22,0	18,0		●

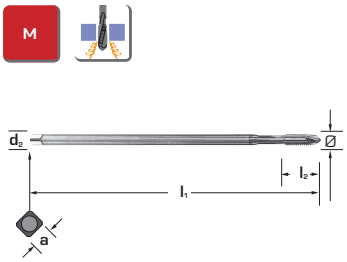
N: Herkömmliche Anwendung
universal application

● Standardartikel / Items available ex stock

ILIX NORM

Maschinen-Gewindebohrer mit extra langem Schaft
für Metrisches ISO-Gewinde nach DIN 13
ca. doppelte Gesamtlänge wie DIN 371

Machine taps with extra long shank
for ISO metric coarse thread as per DIN 13
approx. double length of DIN 371



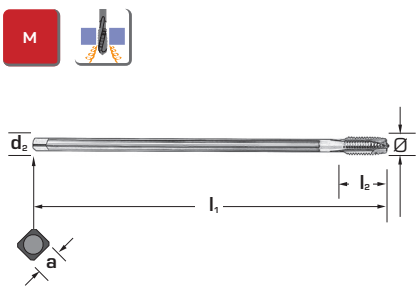
Typ / Type									N
Toleranz Tolerance									6 H
Anschnitt / Gangzahl Chamfer form / No. of threads									B/4-5
Schneidrichtung Cutting direction									
Schneidstoff/ Material									HSS-Co
Ø mm		**Steigung** Pitch	**Kernloch Ø** Tap drill Ø	**l_1 mm**	**l_2 mm**	**$d_2$mm h9**	**a h12**		**6692**
M	**3**	0,5	2,5	100	11	3,5	2,7		●
M	**4**	0,7	3,3	120	13	4,5	3,4		●
M	**5**	0,8	4,2	140	15	6,0	4,9		●
M	**6**	1,0	5,0	160	17	6,0	4,9		●

● Standardartikel / Items available ex stock

ILIX NORM

Maschinen-Gewindebohrer mit extra langem Schaft
für Metrisches ISO-Gewinde nach DIN 13
ca. doppelte Gesamtlänge wie DIN 376

Machine taps with extra long shank
for ISO metric coarse thread as per DIN 13
approx. double length of DIN 3716



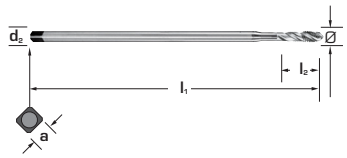
Typ / Type									N
Toleranz Tolerance									6 H
Anschnitt / Gangzahl Chamfer form / No. of threads									B/4-5
Schneidrichtung Cutting direction									
Schneidstoff/ Material									HSS-Co
Ø mm		**Steigung** Pitch	**Kernloch Ø** Tap drill Ø	**l_1** mm	**l_2** mm	**d_2** mm h9	**a** h12		**6695**
M	**8**	1,25	6,8	180	20	6,0	4,9		●
M	**10**	1,50	8,5	200	22	7,0	5,5		●
M	**12**	1,75	10,2	224	24	9,0	7,0		●
M	**14**	2,00	12,0	224	26	11,0	9,0		●
M	**16**	2,00	14,0	224	27	12,0	9,0		●
M	**18**	2,50	15,5	250	30	14,0	11,0		●
M	**20**	2,50	17,5	280	32	16,0	12,0		●

● **Standardartikel** / Items available ex stock

ILIX NORM

Maschinen-Gewindebohrer, extra lang, 40° Rechtsdrall
für Metrisches ISO-Gewinde nach DIN 13
ca. doppelte Gesamtlänge wie DIN 371

Machine taps, extra long, 40° right hand helix
for ISO metric coarse thread as per DIN 13
approx. double length of DIN 371



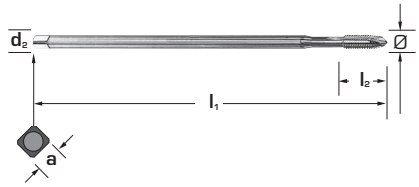
Typ / Type								N 40°
Toleranz Tolerance								6 H
Anschnitt / Gangzahl Chamfer form / No. of threads								C/2,5-3
Schneidrichtung Cutting direction								
Schneidstoff/ Material								HSS-Co
Ø mm		**Steigung** Pitch	**Kernloch Ø** Tap drill Ø	**l_1 mm**	**l_2 mm**	**d_2 mm h9**	**a h12**	**6840**
M	**3**	0,5	2,5	100	11	3,5	2,7	●
M	**4**	0,7	3,3	120	13	4,5	3,4	●
M	**5**	0,8	4,2	140	15	6,0	4,9	●
M	**6**	1,0	5,0	160	17	6,0	4,9	●

● Standardartikel / Items available ex stock

ILIX NORM

Maschinen-Gewindebohrer, extra lang, 40° Rechtsdrall
für Metrisches ISO-Gewinde nach DIN 13
ca. doppelte Gesamtlänge wie DIN 371

Machine taps, extra long
for ISO metric coarse thread as per DIN 13
approx. double total length of DIN 371



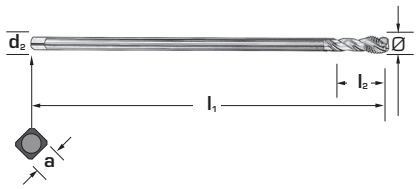
Typ / Type								N
Toleranz Tolerance								6 H
Anschnitt / Gangzahl Chamfer form / No. of threads								B/4-5
Schneidrichtung Cutting direction								
Schneidstoff/ Material								HSS-Co
Ø mm		**Steigung** Pitch	**Kernloch Ø** Tap drill Ø	**l_1 mm**	**l_2 mm**	**$d_2$mm h9**	**a h12**	**6842**
M	**3**	0,5	2,5	100	11	3,5	2,7	●
M	**4**	0,7	3,3	120	13	4,5	3,4	●
M	**5**	0,8	4,2	140	15	6,0	4,9	●
M	**6**	1,0	5,0	160	17	6,0	4,9	●

● Standardartikel / Items available ex stock

ILIX NORM

Maschinen-Gewindebohrer, extra lang, 40°
Rechtsdrall für Metrisches ISO-Gewinde nach DIN 13
ca. doppelte Gesamtlänge wie DIN 376

Machine taps, extra long, 40° right hand helix
for ISO metric coarse thread as per DIN 13
approx. double length of DIN 376



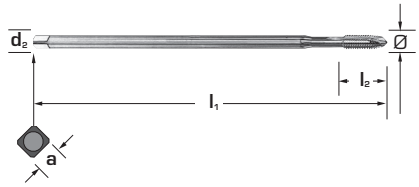
Typ / Type									N 40°
Toleranz Tolerance									6 H
Anschnitt / Gangzahl Chamfer form / No. of threads									C/2,5-3
Schneidrichtung Cutting direction									
Schneidstoff/ Material									HSS-Co
Ø mm		**Steigung** Pitch	**Kernloch Ø** Tap drill Ø	**l_1 mm**	**l_2 mm**	**$d_2$mm h9**	**a h12**		**6841**
M	**8**	1,25	6,8	180	20	6	4,9		●
M	**10**	1,50	8,5	200	22	7	4,9		●
M	**12**	1,75	10,2	224	24	9	7,0		●
M	**14**	2,00	12,0	224	26	11	9,0		●
M	**16**	2,00	14,0	224	27	12	9,0		●
M	**18**	2,50	15,5	250	30	14	11,0		●
M	**20**	2,50	17,5	280	32	16	12,0		●

● Standardartikel / Items available ex stock

ILIX NORM

Maschinen-Gewindebohrer, extra lang, 40° Rechtsdrall
für Metrisches ISO-Gewinde nach DIN 13
ca. doppelte Gesamtlänge wie DIN 376

Machine taps, extra long
for ISO metric coarse thread as per DIN 13
approx. double total length of DIN 376



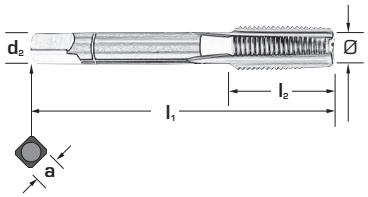
Typ / Type									N
Toleranz Tolerance									6 H
Anschnitt / Gangzahl Chamfer form / No. of threads									B/4-5
Schneidrichtung Cutting direction									
Schneidstoff/ Material									HSS-Co
Ø mm		**Steigung** Pitch	**Kernloch Ø** Tap drill Ø	**l_1** mm	**l_2** mm	**d_2** mm h9	**a** h12		**6843**
M	**8**	1,25	6,8	180	20	6	4,9		●
M	**10**	1,50	8,5	200	22	7	4,9		●
M	**12**	1,75	10,2	224	24	9	7,0		●
M	**14**	2,00	12,0	224	26	11	9,0		●
M	**16**	2,00	14,0	224	27	12	9,0		●
M	**18**	2,50	15,5	250	30	14	11,0		●
M	**20**	2,50	17,5	280	32	16	12,0		●

● Standardartikel / Items available ex stock

DIN 2181

Hand-Gewindebohrer, zweiteiliger Satz
für Metrisches ISO-Feingewinde nach DIN 13
Hand taps, serial, in set of 2 pieces
for ISO metric fine threads as per DIN 13

MF **Satz 6633**



Typ / Type									N	N
Toleranz Tolerance									6 H	6 H
Anschnitt / Gangzahl Chamfer form / No. of threads									A/5-6	C/2,5-3
Schneidrichtung Cutting direction										
Schneidstoff/ Material									HSS	HSS
Ø mm		**Steigung** Pitch	**Kernloch Ø** Tap drill Ø	**l_1 mm**	**l_2 mm**	**d_2 mm h9**	**a h12**		**6633 V**	**6633 F**
MF	2	0,25	1,8	36	8	2,8	2,1		●	●
MF	2,2	0,25	2,0	36	9	2,8	2,1		●	●
MF	2,3	0,25*	2,1	36	9	2,8	2,1		●	●
MF	2,5	0,35	2,2	40	9	2,8	2,1		●	●
MF	2,6	0,35	2,3	40	9	2,8	2,1		●	●
MF	3	0,35	2,7	40	9	3,5	2,7		●	●
MF	3,5	0,35	3,2	45	10	4,0	3,0		●	●
MF	4	0,50	3,5	45	10	4,5	3,4		●	●
MF	5	0,50	4,5	50	12	6,0	4,9		●	●
MF	6	0,50	5,5	50	14	6,0	4,9		●	●
MF	6	0,75	5,2	50	14	6,0	4,9		●	●
MF	7	0,75	6,2	50	14	6,0	4,9		●	●
MF	8	0,50	7,5	50	19	6,0	4,9		●	●
MF	8	0,75	7,2	50	19	6,0	4,9		●	●
MF	8	1,00	7,0	56	22	6,0	4,9		●	●
MF	9	1,00	8,0	63	22	7,0	5,5		●	●
MF	10	0,75	9,2	63	20	7,0	5,5		●	●
MF	10	1,00	9,0	63	20	7,0	5,5		●	●
MF	10	1,25	8,8	70	24	7,0	5,5		●	●
MF	11	1,00	10,0	63	20	8,0	6,2		●	●
MF	12	1,00	11,0	70	22	9,0	7,0		●	●
MF	12	1,25	10,8	70	22	9,0	7,0		●	●
MF	12	1,50	10,5	70	22	9,0	7,0		●	●
MF	14	1,00	13,0	70	22	11,0	9,0		●	●
MF	14	1,25*	12,8	70	22	11,0	9,0		●	●
MF	14	1,50	12,5	70	22	11,0	9,0		●	●
MF	15	1,00	14,0	70	22	12,0	9,0		●	●
MF	15	1,50	13,5	70	22	12,0	9,0		●	●
MF	16	1,00	15,0	70	22	12,0	9,0		●	●
MF	16	1,50	14,5	70	22	12,0	9,0		●	●
MF	18	1,00	17,0	80	22	14,0	11,0		●	●
MF	18	1,50	16,5	80	22	14,0	11,0		●	●

N: Herkömmliche Anwendung
universal application

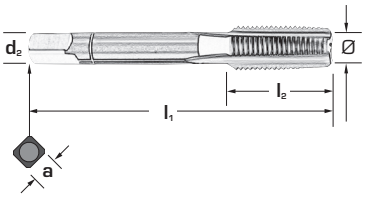
* Diese Gewinde sind im Metrischen ISO-Gewinde nicht enthalten / These sizes are not ISO standard. - Nur im Satz lieferbar. Nur Vorschneider auf Anfrage / Only available as set. Only taper Tap (No. 1) upon request.

● Standardartikel / Items available ex stock

DIN 2181

Hand-Gewindebohrer, zweiteiliger Satz
für Metrisches ISO-Feingewinde nach DIN 13
Hand taps, serial, in set of 2 pieces
for ISO metric fine threads as per DIN 13

MF **Satz 6633**



Typ / Type									**N**	**N**
Toleranz Tolerance									**6 H**	**6 H**
Anschnitt / Gangzahl Chamfer form / No. of threads									**A/5-6**	**A/5-6**
Schneidrichtung Cutting direction										
Schneidstoff/ Material									**HSS**	**HSS**
Ø mm		**Steigung** Pitch	**Kernloch Ø** Tap drill Ø	**l_1 mm**	**l_2 mm**	**d_2 mm h9**	**a h12**		**6633 V**	**6633 F**
MF	18	2,0	16,00	80	22	14	11,0		●	●
MF	20	1,0	19,00	80	22	16	12,0		●	●
MF	20	1,5	18,50	80	22	16	12,0		●	●
MF	20	2,0	18,00	80	22	16	12,0		●	●
MF	22	1,0	21,00	80	22	18	14,5		●	●
MF	22	1,5	20,50	80	22	18	14,5		●	●
MF	22	2,0	20,00	80	22	18	14,5		●	●
MF	24	1,0	23,00	90	22	18	14,5		●	●
MF	24	1,5	22,50	90	22	18	14,5		●	●
MF	24	2,0	22,00	90	22	18	14,5		●	●
MF	26	1,5	24,50	90	22	18	14,5		●	●
MF	27	1,5	25,50	90	22	20	16,0		●	●
MF	27	2,0	25,00	90	22	20	16,0		●	●
MF	28	1,5	26,50	90	22	20	16,0		●	●
MF	30	1,0	29,00	90	22	22	18,0		●	●
MF	30	1,5	28,50	90	22	22	18,0		●	●
MF	30	2,0	28,00	90	22	22	18,0		●	●
MF	32	1,5	30,50	90	22	22	18,0		●	●
MF	33	1,5	31,50	100	25	25	20,0		●	●
MF	34	1,5	32,50	100	25	28	22,0		●	●
MF	35	1,5	33,50	100	25	25	20,0		●	●
MF	36	1,5	34,50	100	25	28	22,0		●	●
MF	36	3,0	33,00	125	40	28	22,0		●	●
MF	38	1,5	36,50	100	25	28	22,0		●	●
MF	40	1,5	38,50	110	25	32	24,0		●	●
MF	42	1,5	40,50	110	25	32	24,0		●	●
MF	45	1,5	43,50	110	25	36	29,0		●	●
MF	48	1,5	46,50	140	40	36	29,0		●	●
MF	48	2,0	46,00	140	40	36	29,0		●	●
MF	48	3,0	45,00	140	40	36	29,0		●	●
MF	50	1,5	48,50	140	40	36	29,0		●	●
MF	52	1,5	50,50	140	40	40	32,0		●	●

N: Herkömmliche Anwendung
universal application

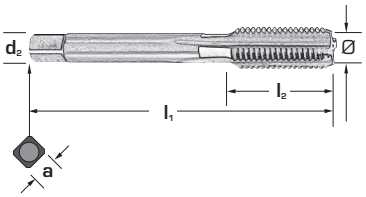
* Diese Gewinde sind im Metrischen ISO-Gewinde nicht enthalten / These sizes are not ISO standard. - Nur im Satz lieferbar. Nur Vorschneider auf Anfrage / Only available as set. Only taper Tap (No. 1) upon request.

● Standardartikel / Items available ex stock

DIN 2181

Kurze Maschinen-Gewindebohrer
für Metrisches ISO-Feingewinde nach DIN 13
Short machine taps
for ISO metric fine thread as per DIN 13

MF



Typ / Type									**N**	**N 15°**	**MS**
Toleranz Tolerance									**6 H**	**6 H**	**6 H**
Anschnitt / Gangzahl Chamfer form / No. of threads									**C/2,5-3**	**C/2,5-3**	**C/2,5-3**
Schneidrichtung Cutting direction											
Schneidstoff/ Material									HSS-Co	HSS-Co	HSS-Co
Ø mm		**Steigung** Pitch	**Kernloch Ø** Tap drill Ø	**l_1** mm	**l_2** mm	**d_2** mm h9	**a** h12		**6899**	**6656**	**6724**
MF	4	0,50	3,5	45	10	4,5	3,4		-	●	●
MF	5	0,50	4,5	50	12	6,0	4,9		-	●	●
MF	6	0,50	5,5	50	14	6,0	4,9		●	●	●
MF	6	0,75	5,2	50	14	6,0	4,9		●	-	●
MF	7	0,75	6,2	50	14	6,0	4,9		-	-	●
MF	8	0,50	7,5	50	19	6,0	4,9		●	●	●
MF	8	0,75	7,2	50	19	6,0	4,9		●	●	●
MF	8	1,00	7,0	56	22	6,0	4,9		●	-	●
MF	9	1,00	8,0	63	22	7,0	5,5		●	-	●
MF	10	0,75	9,2	63	20	7,0	5,5		●	-	●
MF	10	1,00	9,0	63	20	7,0	5,5		●	●	●
MF	10	1,25	8,8	70	24	7,0	5,5		●	-	●
MF	11	1,00	10,0	63	20	8,0	6,2		-	-	●
MF	12	1,00	11,0	70	22	9,0	7,0		●	●	●
MF	12	1,25	10,8	70	22	9,0	7,0		●	-	●
MF	12	1,50	10,5	70	22	9,0	7,0		●	●	●
MF	14	1,00	10,5	70	22	9,0	7,0		●	-	-
MF	14	1,25	10,5	70	22	9,0	7,0		●	-	-
MF	14	1,50	12,5	70	22	11,0	9,0		●	●	-
MF	16	1,00	12,5	70	22	11,0	9,0		●	-	-
MF	16	1,50	14,5	70	22	12,0	9,0		●	●	-
MF	18	1,00	14,5	70	22	12,0	9,0		●	-	-
MF	18	1,50	16,5	80	22	14,0	11,0		●	●	-
MF	18	2,00	16,5	80	22	14,0	11,0		●	-	-
MF	20	1,00	16,5	80	22	14,0	11,0		●	-	-
MF	20	1,50	18,5	80	22	16,0	12,0		●	●	-
MF	20	2,00	18,5	80	22	16,0	12,0		●	-	-
MF	22	1,50	20,5	80	22	18,0	14,5		-	●	-
MF	24	1,50	22,5	90	22	18,0	14,5		-	●	-

N: **Herkömmliche Anwendung** universal application
N 15°: **15° Rechtsdrall** right hand helix
MS: **für Messing** for brass

● Standardartikel / Items available ex stock

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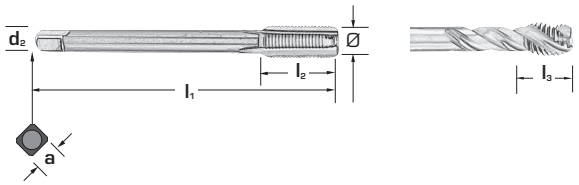
DIN 374

Maschinen-Gewindebohrer mit Überlaufschaft
für Metrisches ISO-Feingewinde nach DIN 13
Machine taps with reduced shank
for ISO metric fine thread as per DIN 13

MF TiN TICN



Typ / Type	N	N	N	N 15°	N 15°
Toleranz / Tolerance	6 H	6 H	6 H	6 H	6 H
Anschnitt / Gangzahl / Chamfer form / No. of threads	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3
Schneidrichtung / Cutting direction					
Schneidstoff / Material	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co

Ø mm		Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	$l_{2\,MAX}$ mm	l_3 mm	d_2 mm h9	a h12	6726	6726 TN	6726 TC	6664	6664 TN
MF	3	0,35	2,65	56	9	5	2,2	-	●	●	●	-	-
MF	3,5	0,35	3,15	56	10	6	2,5	2,1	●	●	●	-	-
MF	4	0,50	3,50	63	10	7	2,8	2,1	●	●	●	-	-
MF	5	0,50	4,50	70	12	8	3,5	2,7	●	●	●	-	-
MF	6	0,50	5,50	80	14	10	4,5	3,4	●	●	●	-	-
MF	6	0,75	5,20	80	14	10	4,5	3,4	●	●	●	-	-
MF	7	0,75	6,20	80	14	10	5,5	4,3	●	●	●	-	-
MF	8	0,50	7,50	80	19	12	6,0	4,9	●	●	●	-	-
MF	8	0,75	7,20	80	19	12	6,0	4,9	●	●	●	●	●
MF	8	1,00	7,00	90	22	12	6,0	4,9	●	●	●	●	●
MF	9	1,00	8,00	90	22	12	7,0	5,5	●	●	●	-	-
MF	10	0,75	9,20	90	20	14	7,0	5,5	●	●	●	-	-
MF	10	1,00	9,00	90	20	14	7,0	5,5	●	●	●	●	●
MF	10	1,25	8,80	100	24	14	7,0	5,5	●	●	●	●	●
MF	11	1,00	10,00	90	20	14	8,0	6,2	●	●	●	-	-
MF	12	1,00	11,00	100	22	16	9,0	7,0	●	●	●	●	●
MF	12	1,25	10,80	100	22	16	9,0	7,0	●	●	●	-	-
MF	12	1,50	10,50	100	22	16	9,0	7,0	●	●	●	●	●
MF	14	1,00	13,00	100	22	20	11,0	9,0	●	●	●	-	-
MF	14	1,25*	12,80	100	22	20	11,0	9,0	●	●	●	-	-
MF	14	1,50	12,50	100	22	20	11,0	9,0	●	●	●	●	●
MF	15	1,00	14,00	100	22	20	12,0	9,0	●	●	●	-	-
MF	15	1,50	13,50	100	22	20	12,0	9,0	●	●	●	-	-
MF	16	1,00	15,00	100	22	20	12,0	9,0	●	●	●	-	-
MF	16	1,50	14,50	100	22	20	12,0	9,0	●	●	●	●	●
MF	18	1,00	17,00	110	25	25	14,0	11,0	●	●	●	-	-
MF	18	1,50	16,50	110	25	25	14,0	11,0	●	●	●	●	●
MF	18	2,00	16,00	125	34	25	14,0	11,0	●	●	●	-	-
MF	20	1,00	19,00	125	25	25	16,0	12,0	●	●	●	-	-
MF	20	1,50	18,50	125	25	25	16,0	12,0	●	●	●	●	●
MF	20	2,00	18,00	140	34	25	16,0	12,0	●	●	●	-	-
MF	22	1,00	21,00	125	25	25	18,0	14,5	●	●	●	-	-

N: Herkömmliche Anwendung universal application
N 15°: 15° Rechtsdrall right hand helix

* Diese Gewinde sind im Metrischen ISO-Gewinde nicht enthalten / These sizes are not ISO standard.

● Standardartikel / Items available ex stock

DIN 374

Maschinen-Gewindebohrer mit Überlaufschaft
für Metrisches ISO-Feingewinde nach DIN 13
Machine taps with reduced shank
for ISO metric fine thread as per DIN 13

N 15°	N 15°	N Sx 40°	N 40°	VAP 40°	N 40°	N 40°	N 40°	**Typ /** Type
6 H	6 H+0,1	6 H	6 H	6 H	6 H	6 H	6 H	**Toleranz** Tolerance
C/2,5-3	E/1-2	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	E/1-2	**Anschnitt / Gangzahl** Chamfer form / No. of threads
								Schneidrichtung Cutting direction
HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	**Schneidstoff/** Material

6664 TC	6904	6864	6652	6652 VP	6652 TN	6652 TC	6877	Ø mm		Steigung Pitch	Kernloch Ø Tap drill Ø
-	-	-	●	●	●	●	-	MF	3	0,35	2,65
-	-	-	●	●	●	●	-	MF	3,5	0,35	3,15
-	-	-	●	●	●	●	-	MF	4	0,50	3,50
-	-	-	●	●	●	●	-	MF	5	0,50	4,50
-	-	-	●	●	●	●	●	MF	6	0,50	5,50
-	-	-	●	●	●	●	●	MF	6	0,75	5,20
-	-	-	-	-	-	-	-	MF	7	0,75	6,20
-	-	-	-	-	-	-	-	MF	8	0,50	7,50
●	-	-	●	●	●	●	●	MF	8	0,75	7,20
●	-	●	●	●	●	●	●	MF	8	1,00	7,00
-	-	-	-	-	-	-	-	MF	9	1,00	8,00
-	-	-	-	-	-	-	-	MF	10	0,75	9,20
●	-	●	●	●	●	●	●	MF	10	1,00	9,00
●	-	-	●	●	●	●	●	MF	10	1,25	8,80
-	-	-	-	-	-	-	-	MF	11	1,00	10,00
●	-	●	●	●	●	●	●	MF	12	1,00	11,00
-	-	-	-	-	-	-	●	MF	12	1,25	10,80
●	-	●	●	●	●	●	●	MF	12	1,50	10,50
-	-	-	-	-	-	-	-	MF	14	1,00	13,00
-	-	-	-	-	-	-	-	MF	14	1,25*	12,80
●	-	●	●	●	●	●	●	MF	14	1,50	12,50
-	-	-	-	-	-	-	-	MF	15	1,00	14,00
-	-	-	-	-	-	-	-	MF	15	1,50	13,50
-	●	-	-	-	-	-	-	MF	16	1,00	15,00
●	-	●	●	●	●	●	●	MF	16	1,50	14,50
-	●	-	-	-	-	-	-	MF	18	1,00	17,00
●	-	●	●	●	●	●	●	MF	18	1,50	16,50
-	-	-	-	-	-	-	-	MF	18	2,00	16,00
-	●	-	-	-	-	-	-	MF	20	1,00	19,00
●	-	●	●	●	●	●	●	MF	20	1,50	18,50
-	-	-	-	-	-	-	-	MF	20	2,00	18,00
-	●	-	-	-	-	-	-	MF	22	1,00	21,00

N 15°: 15° Rechtsdrall
right hand helix

N 40°: Rechtsrall a 40°
right hand helix

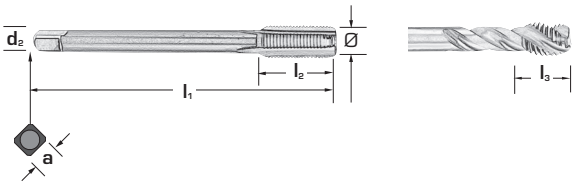
VAP: vaporisiert
vaporized

● Standardartikel / Items available ex stock

DIN 374

Maschinen-Gewindebohrer mit Überlaufschaft
für Metrisches ISO-Feingewinde nach DIN 13
Machine taps with reduced shank
for ISO metric fine thread as per DIN 13

MF TiN TICN



Typ / Type	N	N	N	N 15°	N 15°
Toleranz / Tolerance	6 H	6 H	6 H	6 H	6 H
Anschnitt / Gangzahl / Chamfer form / No. of threads	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3
Schneidrichtung / Cutting direction					
Schneidstoff / Material	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co

Ø mm		Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	$l_{2\,MAX}$ mm	l_3 mm	d_2 mm h9	a h12	6726	6726 TN	6726 TC	6664	6664 TN
MF	22	1,50	20,50	125	25	25	18,0	14,5	●	●	●	●	●
MF	22	2,00	20,00	140	34	25	18,0	14,5	●	●	●	-	-
MF	24	1,00	23,00	140	28	28	18,0	14,5	●	●	●	-	-
MF	24	1,50	22,50	140	28	28	18,0	14,5	●	●	●	●	●
MF	24	2,00	22,00	140	28	28	18,0	14,5	●	●	●	-	-
MF	26	1,50	24,50	140	28	28	18,0	14,5	●	●	●	●	●
MF	27	1,50	25,50	140	28	28	20,0	16,0	●	●	●	●	●
MF	27	2,00	25,00	140	28	28	20,0	16,0	●	●	●	●	●
MF	28	1,50	26,50	140	28	28	20,0	16,0	●	●	●	●	●
MF	30	1,00	29,00	150	28	28	22,0	18,0	●	●	●	-	-
MF	30	1,50	28,50	150	28	28	22,0	18,0	●	●	●	●	●
MF	30	2,00	28,00	150	28	28	22,0	18,0	●	●	●	●	●
MF	32	1,50	30,50	150	28	-	22,0	18,0	●	●	●	-	-
MF	33	1,50	31,50	160	30	-	25,0	20,0	●	●	●	-	-
MF	34	1,50	32,50	170	30	-	28,0	22,0	●	●	●	-	-
MF	35	1,50	33,50	170	30	-	28,0	22,0	●	●	●	-	-
MF	36	1,50	34,50	170	30	-	28,0	22,0	●	●	●	-	-
MF	38	1,50	36,50	170	30	-	28,0	22,0	●	●	●	-	-
MF	40	1,50	38,50	170	30	-	32,0	24,0	●	●	●	-	-
MF	42	1,50	40,50	170	30	-	32,0	24,0	●	●	●	-	-
MF	45	1,50	43,50	180	32	-	36,0	29,0	●	●	●	-	-
MF	48	1,50	46,50	190	32	-	36,0	29,0	●	●	●	-	-
MF	50	1,50	48,50	190	32	-	36,0	29,0	●	●	●	-	-
MF	52	1,50	50,50	190	32	-	40,0	32,0	●	●	●	-	-

N: Herkömmliche Anwendung universal application
N 15°: 15° Rechtsdrall right hand helix

* Diese Gewinde sind im Metrischen ISO-Gewinde nicht enthalten / These sizes are not ISO standard.

● Standardartikel / Items available ex stock

DIN 374

Maschinen-Gewindebohrer mit Überlaufschaft
für Metrisches ISO-Feingewinde nach DIN 13
Machine taps with reduced shank
for ISO metric fine thread as per DIN 13

N 15°	N 15°	N Sx 40°	N 40°	VAP 40°	N 40°	N 40°	N 40°	**Typ /** Type
6 H	6 H+0,1	6 H	6 H	6 H	6 H	6 H	6 H	**Toleranz** Tolerance
C/2,5-3	E/1-2	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	E/1-2	**Anschnitt / Gangzahl** Chamfer form / No. of threads
								Schneidrichtung Cutting direction
HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	**Schneidstoff/** Material

6664 TC	6904	6864	6652	6652 VP	6652 TN	6652 TC	6877	Ø mm		Steigung Pitch	Kernloch Ø Tap drill Ø
●	-	-	●	●	●	●	-	MF	22	1,50	20,50
-	-	-	-	-	-	-	-	MF	22	2,00	20,00
-	●	-	-	-	-	-	-	MF	24	1,00	23,00
●	-	-	●	●	●	●	-	MF	24	1,50	22,50
●	-	-	-	-	-	-	-	MF	24	2,00	22,00
●	-	-	●	●	●	●	-	MF	26	1,50	24,50
●	-	-	●	●	●	●	-	MF	27	1,50	25,50
●	-	-	●	●	●	●	-	MF	27	2,00	25,00
●	-	-	●	●	●	●	-	MF	28	1,50	26,50
●	-	-	-	-	-	-	-	MF	30	1,00	29,00
-	-	-	●	●	●	●	-	MF	30	1,50	28,50
-	-	-	●	●	●	●	-	MF	30	2,00	28,00
-	-	-	-	-	-	-	-	MF	32	1,50	30,50
-	-	-	-	-	-	-	-	MF	33	1,50	31,50
-	-	-	-	-	-	-	-	MF	34	1,50	32,50
-	-	-	-	-	-	-	-	MF	35	1,50	33,50
-	-	-	-	-	-	-	-	MF	36	1,50	34,50
-	-	-	-	-	-	-	-	MF	38	1,50	36,50
-	-	-	-	-	-	-	-	MF	40	1,50	38,50
-	-	-	-	-	-	-	-	MF	42	1,50	40,50
-	-	-	-	-	-	-	-	MF	45	1,50	43,50
-	-	-	-	-	-	-	-	MF	48	1,50	46,50
-	-	-	-	-	-	-	-	MF	50	1,50	48,50
-	-	-	-	-	-	-	-	MF	52	1,50	50,50

N 15°: **15° Rechtsdrall** right hand helix
N 40°: **Rechtsrall a 40°** right hand helix
VAP: **vaporisiert** vaporized

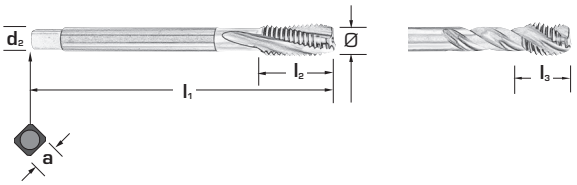
● Standardartikel / Items available ex stock

DIN 374

Maschinen-Gewindebohrer mit Überlaufschaft
für Metrisches ISO-Feingewinde nach DIN 13
Machine taps with reduced shank
for ISO metric fine thread as per DIN 13

MF | HARD LUBE | XP TOP

Axialer Kühlmittelaustritt
Axial internal cooling



Typ / Type	VA 15°	VA i 15°	VA i 15°	VA 35°	VAP 35°	VA 35°	VA 35°
Toleranz / Tolerance	6 HX	6 HX	6 HX	6 HX	6 HX	6 HX	6 GX
Anschnitt / Gangzahl / Chamfer form / No. of threads	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3
Schneidrichtung / Cutting direction							
Schneidstoff / Material	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co

Ø mm		Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	l_3 mm	d_2 mm h9	a h12	6671	6626	6626 XP	6655	6655 VP	6655 XP	6655 6G
MF	3	0,35	2,65	56	9	5	2,2	-	-	-	-	-	-	-	-
MF	3,5	0,35	3,15	56	10	6	2,5	2,1	-	-	-	-	-	-	-
MF	4	0,50	3,50	63	10	7	2,8	2,1	-	-	-	-	-	-	-
MF	5	0,50	4,50	70	12	8	3,5	2,7	-	-	-	-	-	-	-
MF	6	0,50	5,50	80	14	10	4,5	3,4	-	-	-	-	-	-	-
MF	6	0,75	5,20	80	14	10	4,5	3,4	-	-	-	-	-	-	-
MF	7	0,75	6,20	80	14	10	5,5	4,3	-	-	-	-	-	-	-
MF	8	0,50	7,50	80	19	12	6,0	4,9	-	-	-	-	-	-	-
MF	8	0,75	7,20	80	19	12	6,0	4,9	-	-	-	-	-	-	-
MF	8	1,00	7,00	90	22	12	6,0	4,9	●	●	●	●	●	●	●
MF	9	1,00	8,00	90	22	12	7,0	5,5	-	-	-	-	-	-	-
MF	10	0,75	9,20	90	20	14	7,0	5,5	-	-	-	-	-	-	-
MF	10	1,00	9,00	90	20	14	7,0	5,5	●	●	●	●	●	●	●
MF	10	1,25	8,80	100	24	14	7,0	5,5	●	●	●	●	●	●	-
MF	11	1,00	10,00	90	20	14	8,0	6,2	-	-	-	-	-	-	-
MF	12	1,00	11,00	100	22	16	9,0	7,0	●	●	●	●	●	●	●
MF	12	1,25	10,80	100	22	16	9,0	7,0	-	●	●	-	-	-	-
MF	12	1,50	10,50	100	22	16	9,0	7,0	●	●	●	●	●	●	●
MF	14	1,00	13,00	100	22	20	11,0	9,0	-	-	-	-	-	-	-
MF	14	1,25*	12,80	100	22	20	11,0	9,0	-	-	-	-	-	-	-
MF	14	1,50	12,50	100	22	20	11,0	9,0	●	●	●	●	●	●	●
MF	15	1,00	14,00	100	22	20	12,0	9,0	-	-	-	-	-	-	-
MF	15	1,50	13,50	100	22	20	12,0	9,0	-	-	-	-	-	-	-
MF	16	1,00	15,00	100	22	20	12,0	9,0	-	-	-	-	-	-	-
MF	16	1,50	14,50	100	22	20	12,0	9,0	●	●	●	●	●	●	●
MF	18	1,00	17,00	110	25	25	14,0	11,0	-	-	-	-	-	-	-
MF	18	1,50	16,50	110	25	25	14,0	11,0	●	●	●	●	●	●	●

VA: **Für rostfreien Stahl**
for stainless steel

VA i: **Für rostfreien Stahl mit Innenkühlung**
for stainless steel, with internal cooling

VAP: **vaporisiert**
vaporized

* Diese Gewinde sind im Metrischen ISO-Gewinde nicht enthalten / These sizes are not ISO standard.

● Standardartikel / Items available ex stock

DIN 374

Maschinen-Gewindebohrer mit Überlaufschaft
für Metrisches ISO-Feingewinde nach DIN 13
Machine taps with reduced shank
for ISO metric fine thread as per DIN 13

GG	HD 15°	HD 15°	Alu 45°	**Typ /** Type
6 HX	6 H	6 H	6 H	**Toleranz** Tolerance
C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	**Anschnitt / Gangzahl** Chamfer form / No. of threads
				Schneidrichtung Cutting direction
HSS-Co	HSS-Co	HSS-Co	HSS-Co	**Schneidstoff/** Material

6653	6880	6880 HL	6731	Ø mm		Steigung Pitch	Kernloch Ø Tap drill Ø
-	-	-	-	MF	3	0,35	2,65
-	-	-	-	MF	3,5	0,35	3,15
-	-	-	-	MF	4	0,50	3,50
-	-	-	-	MF	5	0,50	4,50
-	-	-	-	MF	6	0,50	5,50
-	●	●	-	MF	6	0,75	5,20
-	-	-	-	MF	7	0,75	6,20
-	-	-	-	MF	8	0,50	7,50
-	●	●	-	MF	8	0,75	7,20
●	●	●	●	MF	8	1,00	7,00
●	-	-	-	MF	9	1,00	8,00
-	-	-	-	MF	10	0,75	9,20
●	●	●	●	MF	10	1,00	9,00
●	-	-	●	MF	10	1,25	8,80
-	-	-	-	MF	11	1,00	10,00
-	●	●	●	MF	12	1,00	11,00
-	-	-	-	MF	12	1,25	10,80
●	●	●	●	MF	12	1,50	10,50
-	-	-	-	MF	14	1,00	13,00
-	-	-	-	MF	14	1,25*	12,80
●	●	●	●	MF	14	1,50	12,50
-	-	-	-	MF	15	1,00	14,00
-	-	-	-	MF	15	1,50	13,50
-	-	-	-	MF	16	1,00	15,00
●	●	●	●	MF	16	1,50	14,50
-	-	-	-	MF	18	1,00	17,00
●	●	●	●	MF	18	1,50	16,50

HD : **für zähe Werkstoffe**
for tough materials

GG: **für Guss**
for cast iron

Alu: **für Aluminium**
for Aluminium

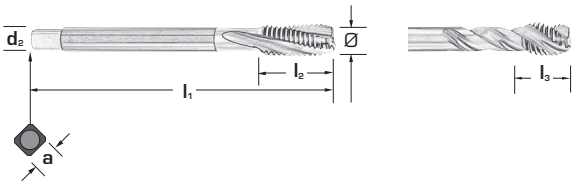
● Standardartikel / Items available ex stock

DIN 374

Maschinen-Gewindebohrer mit Überlaufschaft
für Metrisches ISO-Feingewinde nach DIN 13
Machine taps with reduced shank
for ISO metric fine thread as per DIN 13

MF | HARD LUBE | XP TOP

Axialer Kühlmittelaustritt
Axial internal cooling



Typ / Type									VA 15°	VA i 15°	VA i 15°	VA 35°	VAP 35°	VA 35°	VA 35°
Toleranz Tolerance									6 HX	6 HX	6 HX	6 HX	6 HX	6 HX	6 GX
Anschnitt / Gangzahl Chamfer form / No. of threads									C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3
Schneidrichtung Cutting direction															
Schneidstoff/ Material									HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co
Ø mm		**Steigung** Pitch	**Kernloch Ø** Tap drill Ø	**l_1** mm	**l_2** mm	**l_3** mm	**d_2** mm h9	**a** h12	**6671**	**6626**	**6626 XP**	**6655**	**6655 VP**	**6655 XP**	**6655 6G**
MF	20	1,50	18,50	125	25	25	16,0	12,0	●	●	●	●	●	●	●
MF	20	2,00	18,00	140	34	25	16,0	12,0	-	-	-	-	-	-	-
MF	22	1,00	21,00	125	25	25	18,0	14,5	-	-	-	-	-	-	-
MF	22	1,50	20,50	125	25	25	18,0	14,5	●	-	-	●	●	●	-
MF	22	2,00	20,00	140	34	25	18,0	14,5	-	-	-	-	-	-	-
MF	24	1,00	23,00	140	28	28	18,0	14,5	-	-	-	-	-	-	-
MF	24	1,50	22,50	140	28	28	18,0	14,5	●	-	-	●	●	●	●
MF	24	2,00	22,00	140	28	28	18,0	14,5	-	-	-	-	-	-	-
MF	26	1,50	24,50	140	28	28	18,0	14,5	●	-	-	●	●	●	-
MF	27	1,50	25,50	140	28	28	20,0	16,0	●	-	-	●	●	●	-
MF	27	2,00	25,00	140	28	28	20,0	16,0	●	-	-	●	●	●	-
MF	28	1,50	26,50	140	28	28	20,0	16,0	●	-	-	●	●	●	-
MF	30	1,00	29,00	150	28	28	22,0	18,0	-	-	-	-	-	-	-
MF	30	1,50	28,50	150	28	28	22,0	18,0	●	-	-	●	●	●	-
MF	30	2,00	28,00	150	28	28	22,0	18,0	●	-	-	●	●	●	-

VA: **Für rostfreien Stahl**
for stainless steel

VA i: **Für rostfreien Stahl mit Innenkühlung**
for stainless steel, with internal cooling

VAP: **vaporisiert**
vaporized

* Diese Gewinde sind im Metrischen ISO-Gewinde nicht enthalten / These sizes are not ISO standard.

● Standardartikel / Items available ex stock

DIN 374

Maschinen-Gewindebohrer mit Überlaufschaft
für Metrisches ISO-Feingewinde nach DIN 13
Machine taps with reduced shank
for ISO metric fine thread as per DIN 13

GG	HD 15°	HD 15°	Alu 45°	**Typ /** Type
6 HX	6 H	6 H	6 H	**Toleranz** Tolerance
C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	**Anschnitt / Gangzahl** Chamfer form / No. of threads
				Schneidrichtung Cutting direction
HSS-Co	HSS-Co	HSS-Co	HSS-Co	**Schneidstoff/** Material

6653	6880	6880 HL	6731	Ø mm		Steigung Pitch	Kernloch Ø Tap drill Ø
●	●	●	●	MF	20	1,50	18,50
-	-	-	-	MF	20	2,00	18,00
-	-	-	-	MF	22	1,00	21,00
●	●	●	-	MF	22	1,50	20,50
-	-	-	-	MF	22	2,00	20,00
-	-	-	-	MF	24	1,00	23,00
●	●	●	-	MF	24	1,50	22,50
-	-	-	-	MF	24	2,00	22,00
-	-	-	-	MF	26	1,50	24,50
-	-	-	-	MF	27	1,50	25,50
-	-	-	-	MF	27	2,00	25,00
-	-	-	-	MF	28	1,50	26,50
-	-	-	-	MF	30	1,00	29,00
●	-	-	-	MF	30	1,50	28,50
-	-	-	-	MF	30	2,00	28,00

HD : **für zähe Werkstoffe**
for tough materials
GG: **für Guss**
for cast iron

Alu: **für Aluminium**
for Aluminium

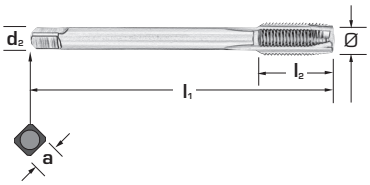
MULTI HD: **Hochleistungs - Gewindebohrer für zähe Werkstoffe**
High performance taps for tough materials

● Standardartikel / Items available ex stock

DIN 374

Maschinen-Gewindebohrer mit Überlaufschaft
für Metrisches ISO-Feingewinde nach DIN 13
Machine taps with reduced shank
for ISO metric fine thread as per DIN 13

MF | TiN | TICN | XP TOP



Typ / Type	Rapid	Rapid VAP	Rapid	Rapid	N Sx	NL 15°
Toleranz Tolerance	6 H	6 H	6 H	6 H	6 H	6 H
Anschnitt / Gangzahl Chamfer form / No. of threads	B/4-5	B/4-5	B/4-5	B/4-5	B/4-5	B/4-5
Schneidrichtung Cutting direction						
Schneidstoff/ Material	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co

Ø mm		Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a h12	6730	6730 VP	6730 TN	6730 TC	6863	6741
MF	3	0,35	2,65	56	9	2,2	-	●	●	●	●	-	-
MF	3,5	0,35	3,15	56	10	2,5	2,1	●	●	●	●	-	-
MF	4	0,50	3,50	63	10	2,8	2,1	●	●	●	●	-	-
MF	5	0,50	4,50	70	12	3,5	2,7	●	●	●	●	-	-
MF	6	0,50	5,50	80	14	4,5	3,4	●	●	●	●	-	-
MF	6	0,75	5,20	80	14	4,5	3,4	●	●	●	●	-	-
MF	7	0,75	6,20	80	14	5,5	4,3	●	●	●	●	-	-
MF	8	0,50	7,50	80	19	6,0	4,9	●	●	●	●	-	-
MF	8	0,75	7,20	80	19	6,0	4,9	●	●	●	●	-	●
MF	8	1,00	7,00	90	22	6,0	4,9	●	●	●	●	●	●
MF	9	1,00	8,00	90	22	7,0	5,5	●	●	●	●	-	-
MF	10	0,75	9,20	90	20	7,0	5,5	●	●	●	●	-	-
MF	10	1,00	9,00	90	20	7,0	5,5	●	●	●	●	●	●
MF	10	1,25	8,80	100	24	7,0	5,5	●	●	●	●	-	-
MF	11	1,00	10,00	90	20	8,0	6,2	●	●	●	●	-	-
MF	12	1,00	11,00	100	22	9,0	7,0	●	●	●	●	●	●
MF	12	1,25	10,80	100	22	9,0	7,0	●	●	●	●	-	-
MF	12	1,50	10,50	100	22	9,0	7,0	●	●	●	●	●	●
MF	14	1,00	13,00	100	22	11,0	9,0	●	●	●	●	-	-
MF	14	1,25*	12,80	100	22	11,0	9,0	●	●	●	●	-	-
MF	14	1,50	12,50	100	22	11,0	9,0	●	●	●	●	●	●
MF	15	1,00	14,00	100	22	12,0	9,0	●	●	●	●	-	-
MF	15	1,50	13,50	100	22	12,0	9,0	●	●	●	●	-	-
MF	16	1,00	15,00	100	22	12,0	9,0	●	●	●	●	-	-
MF	16	1,50	14,50	100	22	12,0	9,0	●	●	●	●	●	●
MF	18	1,00	16,50	110	25	14,0	11,0	●	●	●	●	-	-
MF	18	1,50	16,50	110	25	14,0	11,0	●	●	●	●	●	●
MF	18	2,00	16,00	125	34	14,0	11,0	●	●	●	●	-	-

Rapid: **Herkömmliche Anwendung**
universal application

VAP: **vaporisiert**
vaporized

NL15°: **15° Linksdrall**
left hand helix

N: **Herkömmliche Anwendung**
universal application

* Diese Gewinde sind im Metrischen ISO-Gewinde nicht enthalten / These sizes are not ISO standard.

● Standardartikel / Items available ex stock

DIN 374

Maschinen-Gewindebohrer mit Überlaufschaft
für Metrisches ISO-Feingewinde nach DIN 13
Machine taps with reduced shank
for ISO metric fine thread as per DIN 13

VA	VAP	VA	VA	VA	HD	HD	**Typ /** Type	
6 HX	6 HX	6 GX	6 HX	6 HX	6 H	6 H	**Toleranz** Tolerance	
B/4-5	B/4-5	B/4-5	B/4-5	B/4-5	B/4-5	B/4-5	**Anschnitt / Gangzahl** Chamfer form / No. of threads	
							Schneidrichtung Cutting direction	
HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	**Schneidstoff/** Material	
6663	**6663 VP**	**6663 6G**	**6663 TN**	**6663 XP**	**6872**	**6872 TN**	**Ø mm**	**Steigung** Pitch	**Kernloch Ø** Tap drill Ø
-	-	-	-	-	-	-	MF 3	0,35	2,65
-	-	-	-	-	-	-	MF 3,5	0,35	3,15
-	-	-	-	-	-	-	MF 4	0,50	3,50
-	-	-	-	-	-	-	MF 5	0,50	4,50
-	-	-	-	-	-	-	MF 6	0,50	5,50
-	-	-	-	-	●	●	MF 6	0,75	5,20
-	-	-	-	-	-	-	MF 7	0,75	6,20
-	-	-	-	-	-	-	MF 8	0,50	7,50
-	-	-	-	-	●	●	MF 8	0,75	7,20
●	●	●	●	●	●	●	MF 8	1,00	7,00
-	-	-	-	-	-	-	MF 9	1,00	8,00
-	-	-	-	-	-	-	MF 10	0,75	9,20
●	●	●	●	●	●	●	MF 10	1,00	9,00
●	●	-	●	●	-	-	MF 10	1,25	8,80
-	-	-	-	-	-	-	MF 11	1,00	10,00
●	●	●	●	●	●	●	MF 12	1,00	11,00
-	-	-	-	-	-	-	MF 12	1,25	10,80
●	●	●	●	●	●	●	MF 12	1,50	10,50
-	-	-	-	-	-	-	MF 14	1,00	13,00
-	-	-	-	-	-	-	MF 14	1,25*	12,80
●	●	●	●	●	●	●	MF 14	1,50	12,50
-	-	-	-	-	-	-	MF 15	1,00	14,00
-	-	-	-	-	-	-	MF 15	1,50	13,50
-	-	-	-	-	-	-	MF 16	1,00	15,00
●	●	●	●	●	●	●	MF 16	1,50	14,50
-	-	-	-	-	-	-	MF 18	1,00	16,50
●	●	●	●	●	●	●	MF 18	1,50	16,50
-	-	-	-	-	-	-	MF 18	2,00	16,00

VA: **Für rostfreien Stahl**
for stainless steel

VAP: **vaporisiert**
vaporized

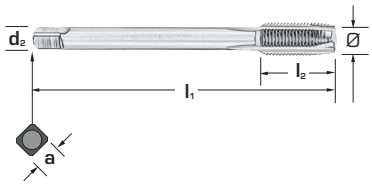
HD : **für zähe Werkstoffe**
for tough materials

● Standardartikel / Items available ex stock

DIN 374

Maschinen-Gewindebohrer mit Überlaufschaft
für Metrisches ISO-Feingewinde nach DIN 13
Machine taps with reduced shank
for ISO metric fine thread as per DIN 13

MF | TiN | TICN | XP TOP



Typ / Type	Rapid	Rapid VAP	Rapid	Rapid	N Sx	NL 15°
Toleranz Tolerance	6 H	6 H	6 H	6 H	6 H	6 H
Anschnitt / Gangzahl Chamfer form / No. of threads	B/4-5	B/4-5	B/4-5	B/4-5	B/4-5	B/4-5
Schneidrichtung Cutting direction						
Schneidstoff/ Material	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co

Ø mm		Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a h12	6730	6730 VP	6730 TN	6730 TC	6863	6741
MF	20	1,00	19,00	125	25	16,0	12,0	●	●	●	●	-	-
MF	20	1,50	18,50	125	25	16,0	12,0	●	●	●	●	●	●
MF	20	2,00	18,00	140	34	16,0	12,0	●	●	●	●	-	-
MF	22	1,00	21,00	125	25	18,0	14,5	●	●	●	●	-	-
MF	22	1,50	20,50	125	25	18,0	14,5	●	●	●	●	-	-
MF	22	2,00	20,00	140	34	18,0	14,5	●	●	●	●	-	-
MF	24	1,00	23,00	140	28	18,0	14,5	●	●	●	●	-	-
MF	24	1,50	22,50	140	28	18,0	14,5	●	●	●	●	-	-
MF	24	2,00	22,00	140	28	18,0	14,5	●	●	●	●	-	-
MF	26	1,50	24,50	140	28	18,0	14,5	●	●	●	●	-	-
MF	27	1,50	25,50	140	28	20,0	16,0	●	●	●	●	-	-
MF	27	2,00	25,00	140	28	20,0	16,0	●	●	●	●	-	-
MF	28	1,50	26,50	140	28	20,0	16,0	●	●	●	●	-	-
MF	30	1,00	29,00	150	28	22,0	18,0	●	●	●	●	-	-
MF	30	1,50	28,50	150	28	22,0	18,0	●	●	●	●	-	-
MF	30	2,00	28,00	150	28	22,0	18,0	●	●	●	●	-	-
MF	32	1,50	30,50	150	28	22,0	18,0	●	●	●	●	-	-
MF	33	1,50	31,50	160	30	25,0	20,0	●	●	●	●	-	-
MF	34	1,50	32,50	170	30	28,0	22,0	●	●	●	●	-	-
MF	35	1,50	33,50	170	30	28,0	22,0	●	●	●	●	-	-
MF	36	1,50	34,50	170	30	28,0	22,0	●	●	●	●	-	-
MF	38	1,50	36,50	170	30	28,0	22,0	●	●	●	●	-	-
MF	40	1,50	38,50	170	30	32,0	24,0	●	●	●	●	-	-
MF	42	1,50	40,50	170	30	32,0	24,0	●	●	●	●	-	-
MF	45	1,50	43,50	180	32	36,0	29,0	●	●	●	●	-	-
MF	48	1,50	46,50	190	32	36,0	29,0	●	●	●	●	-	-
MF	50	1,50	48,50	190	32	36,0	29,0	●	●	●	●	-	-
MF	52	1,50	50,50	190	32	40,0	32,0	●	●	●	●	-	-

Rapid: **Herkömmliche Anwendung**
universal application

VAP: **vaporisiert**
vaporized

NL15°: **15° Linksdrall**
left hand helix

N: **Herkömmliche Anwendung**
universal application

* Diese Gewinde sind im Metrischen ISO-Gewinde nicht enthalten / These sizes are not ISO standard.

● Standardartikel / Items available ex stock

DIN 374

Maschinen-Gewindebohrer mit Überlaufschaft
für Metrisches ISO-Feingewinde nach DIN 13
Machine taps with reduced shank
for ISO metric fine thread as per DIN 13

VA	VAP	VA	VA	VA	HD	HD	**Typ /** Type		
6 HX	6 HX	6 GX	6 HX	6 HX	6 H	6 H	**Toleranz** Tolerance		
B/4-5	B/4-5	B/4-5	B/4-5	B/4-5	B/4-5	B/4-5	**Anschnitt / Gangzahl** Chamfer form / No. of threads		
							Schneidrichtung Cutting direction		
HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	**Schneidstoff/** Material		
6663	**6663 VP**	**6663 6G**	**6663 TN**	**6663 XP**	**6872**	**6872 TN**	**Ø mm**	**Steigung** Pitch	**Kernloch Ø** Tap drill Ø
-	-	-	-	-	-	-	MF 20	1,00	19,00
●	●	●	●	●	●	●	MF 20	1,50	18,50
●	●	-	●	-	-	-	MF 20	2,00	18,00
-	-	-	-	-	-	-	MF 22	1,00	21,00
●	●	-	●	-	●	●	MF 22	1,50	20,50
●	●	-	●	-	-	-	MF 22	2,00	20,00
-	-	-	-	-	-	-	MF 24	1,00	23,00
●	●	●	●	●	●	●	MF 24	1,50	22,50
●	●	-	●	-	-	-	MF 24	2,00	22,00
●	●	-	●	-	-	-	MF 26	1,50	24,50
●	●	-	●	-	-	-	MF 27	1,50	25,50
●	●	-	●	-	-	-	MF 27	2,00	25,00
-	-	-	-	-	-	-	MF 28	1,50	26,50
-	-	-	-	-	-	-	MF 30	1,00	29,00
●	●	-	●	-	-	-	MF 30	1,50	28,50
●	●	-	●	-	-	-	MF 30	2,00	28,00
-	-	-	-	-	-	-	MF 32	1,50	30,50
-	-	-	-	-	-	-	MF 33	1,50	31,50
-	-	-	-	-	-	-	MF 34	1,50	32,50
-	-	-	-	-	-	-	MF 35	1,50	33,50
-	-	-	-	-	-	-	MF 36	1,50	34,50
-	-	-	-	-	-	-	MF 38	1,50	36,50
-	-	-	-	-	-	-	MF 40	1,50	38,50
-	-	-	-	-	-	-	MF 42	1,50	40,50
-	-	-	-	-	-	-	MF 45	1,50	43,50
-	-	-	-	-	-	-	MF 48	1,50	46,50
-	-	-	-	-	-	-	MF 50	1,50	48,50
-	-	-	-	-	-	-	MF 52	1,50	50,50

VA: **Für rostfreien Stahl**
for stainless steel

VAP: **vaporisiert**
vaporized

HD : **für zähe Werkstoffe**
for tough materials

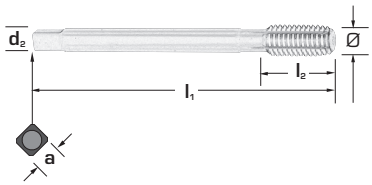
● Standardartikel / Items available ex stock

DIN 374

Maschinen-Gewindeformer mit Überlaufschaft
für Metrisches ISO-Feingewinde nach DIN 13
Cold forming taps with reduced shank
for ISO metric fine thread as per DIN 13

Ref. **6721** ohne Schmiernuten / without coolant grooves
Ref. **6720** mit Schmiernuten / with coolant grooves

M



Typ / Type	Former	Former	Former-S	Former-S
Toleranz Tolerance	6 HX	6 GX	6 HX	6 GX
Anschnitt / Gangzahl Chamfer form / No. of threads	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3
Schneidrichtung Cutting direction				
Schneidstoff/ Material	HSS-Co	HSS-Co	HSS-Co	HSS-Co

Ø mm		Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a h12	6721	6721 6G	6720	6720 6G
M	8	1,00	7,50	90	22	6	4,9	●	●	●	●
M	10	1,00	9,50	90	20	7	5,5	●	●	●	●
M	10	1,25	9,40	100	24	7	5,5	●	●	●	●
M	12	1,00	11,50	100	22	9	7,0	●	●	●	●
M	12	1,50	11,30	100	22	9	7,0	●	●	●	●
M	14	1,50	13,30	100	22	11	9,0	●	●	●	●
M	16	1,00	15,50	100	22	12	9,0	●	●	●	●
M	16	1,50	15,30	100	22	12	9,0	●	●	●	●

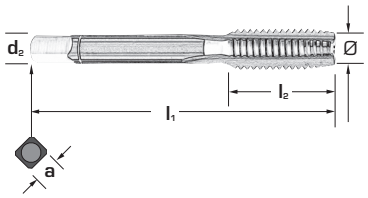
Former S: **mit Schmiernuten** with coolant grooves
Former : **ohne Schmiernuten** without coolant grooves

● Standardartikel / Items available ex stock

ILIX NORM - UNC

Hand-Gewindebohrer, dreiteiliger Satz
für unified-Gewinde (grob) UNC
Baumaße an DIN 352 angelehnt
Hand taps, serial, in set of 3 pieces
for unified coarse thread UNC
dimensions generally as per DIN 352

UNC



Typ / Type							N	N	N
Toleranz Tolerance							2 B	2 B	2 B
Anschnitt / Gangzahl Chamfer form / No. of threads							A/5-6	D/3-4	C/2,5-3
Schneidrichtung Cutting direction									
Schneidstoff/ Material							HSS	HSS	HSS
Ø mm	**Gg/1"** Tpi	**Kernloch Ø** Tap drill Ø	**l_1** mm	**l_2** mm	**d_2** mm h9*	**a** h12	**6775 V**	**6775 M**	**6775 F**
							Einzel single tap		**Satz** set
UNC nr.	1 - 64	1,55	36	8	2,8	2,1	●		●
UNC nr.	2 - 56	1,85	36	9	2,8	2,1	●		●
UNC nr.	3 - 48	2,10	40	9	2,8	2,1	●		●
UNC nr.	4 - 40	2,35	40	11	3,5	2,7	●		●
UNC nr.	5 - 40	2,65	40	11	3,5	2,7	●		●
UNC nr.	6 - 32	2,85	45	13	4,0	3,0	●		●
UNC nr.	8 - 32	3,50	45	13	4,5	3,4	●		●
UNC nr.	10 - 24	3,90	50	16	6,0	4,9	●		●
UNC nr.	12 - 24	4,50	50	17	6,0	4,9	●		●
UNC	1/4 - 20	5,10	50	19	6,0	4,9	●		●
UNC	5/16 - 18	6,60	56	22	6,0	4,9	●		●
UNC	3/8 - 16	8,00	63	22	7,0	5,5	●		●
UNC	7/16 - 14	9,40	70	24	8,0	6,2	●		●
UNC	1/2 - 13	10,80	75	29	9,0	7,0	●		●
UNC	9/16 - 12	12,20	80	30	11,0	9,0	●		●
UNC	5/8 - 11	13,50	80	32	12,0	9,0	●		●
UNC	3/4 - 10	16,50	95	40	14,0	11,0	●		●
UNC	7/8 - 9	19,50	100	40	18,0	14,5	●		●
UNC	1 - 8	22,25	110	50	18,0	14,5	●		●
UNC	1/8 - 7	25,00	125	56	22,0	18,0	●		●
UNC	1/4 - 7	28,00	125	56	22,0	18,0	●		●
UNC	3/8 - 6	30,75	150	63	28,0	22,0	●		●
UNC	1/2 - 6	34,00	150	63	32,0	24,0	●		●
UNC	3/4 - 5	39,50	160	70	36,0	29,0	●		●
UNC nr.	2 - 4 1/2	45,00	180	75	40,0	32,0	●		●

N: Herkömmliche Anwendung
universal application

** Schafttoleranz der Vor- und Mittelschneider h 12 / Shank tolerance of 1st and 2nd tap h 12

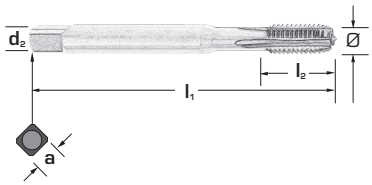
● Standardartikel / Items available ex stock

DIN 2184/1 - UNC

Maschinen-Gewindebohrer mit verstärktem Schaft
für unified-Gewinde (grob) UNC – ASME – B 1.1
Baumaße an DIN 371 angelehnt

Machine taps with reinforced shank
for unified coarse thread UNC - ASME – B 1.1
dimensions generally as per DIN 371

UNC | XP TOP | TiN



Typ / Type	N	N 15°	N 40°	N 40°	N 40°
Toleranz / Tolerance	2 B	2 B	2 B	3 B	2 B
Anschnitt / Gangzahl / Chamfer form / No. of threads	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3
Schneidrichtung / Cutting direction					
Schneidstoff / Material	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co

Ø mm	Gg/1" Tpi	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	l_3 mm	d_2 mm h9	a h12	6823	6696	6691	6691 3B	6691 TN
UNC nr.	2 - 56	1,85	45	9	4	2,8	2,1	-	-	●	●	●
UNC nr.	3 - 48	2,10	50	9	4	2,8	2,1	●	●	●	●	●
UNC nr.	4 - 40	2,35	56	11	5	3,5	2,7	●	●	●	●	●
UNC nr.	5 - 40	2,65	56	11	5	3,5	2,7	●	●	●	●	●
UNC nr.	6 - 32	2,85	56	13	6	4,0	3,0	●	●	●	●	●
UNC nr.	8 - 32	3,50	63	13	7	4,5	3,4	●	●	●	●	●
UNC nr.	10 - 24	3,90	70	16	8	6,0	4,9	●	●	●	●	●
UNC nr.	12 - 24	4,50	80	17	10	6,0	4,9	●	●	●	●	●
UNC	1/4 - 20	5,10	80	17	10	7,0	5,5	●	●	●	●	●
UNC	5/16 - 18	6,60	90	20	12	8,0	6,2	●	●	●	●	●
UNC	3/8 - 16	8,00	90	20	12	10,0	8,0	●	●	●	●	●
Abmessungen mit Überlaufschaft über M 3/8 siehe Kat.-Nr. / above M 3/8 refer to Cat.-No.								6824	6728	66942B	66943B	-

N 15°/40°: 15° Rechtsdrall/40°
15°/40° right hand helix

N: Herkömmliche Anwendung
universal application

● Standardartikel / Items available ex stock

DIN 2184/1 - UNC

Maschinen-Gewindebohrer mit verstärktem Schaft
für unified-Gewinde (grob) UNC – ASME – B 1.1
Baumaße an DIN 371 angelehnt
Machine taps with reinforced shank
for unified coarse thread UNC - ASME – B 1.1
dimensions generally as per DIN 371

VA 35°	VAP 35°	VA 35°	VRP 50°	Alu 45°	HD 15°	**Typ /** Type
2 BX	2 BX	2 BX	2 BX	2 B	2 B	**Toleranz** Tolerance
C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	**Anschnitt / Gangzahl** Chamfer form / No. of threads
						Schneidrichtung Cutting direction
HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	**Schneidstoff/** Material
6735	**6735 VP**	**6735 XP**	**6852 VP**	**6732**	**6865**	**Ø mm**	**Gg/1"** Tpi	**Kernloch Ø** Tap drill Ø
-	-	-	-	-	-	UNC nr.	2 - 56	1,85
-	-	-	-	-	●	UNC nr.	3 - 48	2,10
-	-	-	-	●	●	UNC nr.	4 - 40	2,35
-	-	-	-	●	●	UNC nr.	5 - 40	2,65
●	●	●	●	●	●	UNC nr.	6 - 32	2,85
●	●	●	●	●	●	UNC nr.	8 - 32	3,50
●	●	●	●	●	●	UNC nr.	10 - 24	3,90
●	●	●	●	●	●	UNC nr.	12 - 24	4,50
●	●	●	●	●	●	UNC	1/4 - 20	5,10
●	●	●	●	●	●	UNC	5/16 - 18	6,60
●	●	●	●	●	●	UNC	3/8 - 16	8,00
6754	6754VP	-	6853VP	6733	6866	

VA: **Für rostfreien Stahl**
for stainless steel
VAP: **vaporisiert**
vaporized
VRP: **Für rostfreien Stahl mit Abschrägung und vaporisiert**
for stainless steel, back tapered and vaporized

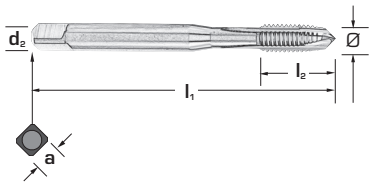
Alu: **für Aluminium**
for Aluminium
HD: **für zähe Werkstoffe**
for tough materials

● Standardartikel / Items available ex stock

DIN 2184/1 - UNC

Maschinen-Gewindebohrer mit verstärktem Schaft
für unified-Gewinde (grob) UNC – ASME – B 1.1
Baumaße an DIN 371 angelehnt
Machine taps with reinforced shank
for unified coarse thread UNC - ASME – B 1.1
dimensions generally as per DIN 371

UNC TiN XP TOP



Typ / Type	HD	Rapid	Rapid	Rapid	Ultra
Toleranz / Tolerance	2 B	2 B	3 B	2 B	2 B
Anschnitt / Gangzahl / Chamfer form / No. of threads	B/4-5	B/4-5	B/4-5	B/4-5	B/4-5
Schneidrichtung / Cutting direction					
Schneidstoff / Material	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co

Ø mm	Gg/1" Tpi	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a h12	6873	6690	6690 3B	6690 TN	6737
UNC nr.	1 - 64	1,55	45	8	2,8	2,1	-	●	-	●	●
UNC nr.	2 - 56	1,85	45	9	2,8	2,1	●	●	-	●	●
UNC nr.	3 - 48	2,10	50	9	2,8	2,1	●	●	-	●	●
UNC nr.	4 - 40	2,35	56	11	3,5	2,7	●	●	●	●	●
UNC nr.	5 - 40	2,65	56	11	3,5	2,7	●	●	-	●	●
UNC nr.	6 - 32	2,85	56	13	4,0	3,0	●	●	●	●	●
UNC nr.	8 - 32	3,50	63	13	4,5	3,4	●	●	●	●	●
UNC nr.	10 - 24	3,90	70	16	6,0	4,9	●	●	●	●	●
UNC nr.	12 - 24	4,50	80	17	6,0	4,9	●	●	-	●	●
UNC	1/4 - 20	5,10	80	17	7,0	5,5	●	●	●	●	●
UNC	5/16 - 18	6,60	90	20	8,0	6,2	●	●	-	●	●
UNC	3/8 - 16	8,00	90	20	10,0	8,0	●	●	●	●	●
Abmessungen mit Überlaufschaft über M 3/8 siehe Kat.-Nr. / above M 3/8 refer to Cat.-No.							6874	66932B	66933B	-	-

HD: **für zähe Werkstoffe** for tough materials
Rapid: **Herkömmliche Anwendung** universal application
Ultra: **für Bleche** for sheet metals

● Standardartikel / Items available ex stock

DIN 2184/1 - UNC

Maschinen-Gewindebohrer mit verstärktem Schaft
für unified-Gewinde (grob) UNC – ASME – B 1.1
Baumaße an DIN 371 angelehnt
Machine taps with reinforced shank
for unified coarse thread UNC - ASME – B 1.1
dimensions generally as per DIN 371

VA	VA VAP	VA	**Typ /** Type
2 BX	2 BX	2 BX	**Toleranz** Tolerance
B/4-5	B/4-5	B/4-5	**Anschnitt / Gangzahl** Chamfer form / No. of threads
			Schneidrichtung Cutting direction
HSS-Co	HSS-Co	HSS-Co	**Schneidstoff/** Material

6739	6739 VP	6739 XP	Ø mm		Gg/1" Tpi	Kernloch Ø Tap drill Ø
-	-	-	UNC	nr.	1 - 64	1,55
●	●	●	UNC	nr.	2 - 56	1,85
●	●	●	UNC	nr.	3 - 48	2,10
●	●	●	UNC	nr.	4 - 40	2,35
●	●	●	UNC	nr.	5 - 40	2,65
●	●	●	UNC	nr.	6 - 32	2,85
●	●	●	UNC	nr.	8 - 32	3,50
●	●	●	UNC	nr.	10 - 24	3,90
●	●	●	UNC	nr.	12 - 24	4,50
●	●	●	UNC		1/4 - 20	5,10
●	●	●	UNC		5/16 - 18	6,60
●	●	●	UNC		3/8 - 16	8,00
6749	6749VP	-				

VA: **Für rostfreien Stahl**
for stainless steel

VAP: **vaporisiert**
vaporized

● Standardartikel / Items available ex stock

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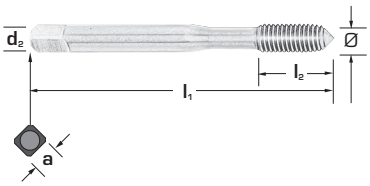
DIN 2184/1 - UNC

Innengewinde-Former mit verstärktem Schaft
für unified-Gewinde (grob) UNC – ASME – B 1.1
Baumaße an DIN 371 angelehnt
Cold forming taps with reinforced shank
for unified coarse thread UNC - ASME – B 1.1
dimensions generally as per DIN 371

Ref. **6738** ohne Schmiernuten / without coolant grooves
Ref. **6802** mit Schmiernuten / with coolant grooves

UNC



Typ / Type	**Former**	**Former S**
Toleranz Tolerance	**2 BX**	**2 BX**
Anschnitt / Gangzahl Chamfer form / No. of threads	**C/2,5-3**	**C/2,5-3**
Schneidrichtung Cutting direction		
Schneidstoff/ Material	HSS-Co	HSS-Co

Ø mm	**Gg/1"** Tpi	**Kernloch Ø** Tap drill Ø	**l_1** mm	**l_2** mm	**d_2** mm h9	**a** h12	**6738**	**6802**
UNC nr.	2 - 56	1,95	45	9	2,8	2,1	●	-
UNC nr.	3 - 48	2,30	50	9	2,8	2,1	●	-
UNC nr.	4 - 40	2,55	56	11	3,5	2,7	●	-
UNC nr.	5 - 40	2,85	56	11	3,5	2,7	●	●
UNC nr.	6 - 32	3,10	63	13	4,0	3,0	●	●
UNC nr.	8 - 32	3,80	70	13	4,5	3,4	●	●
UNC nr.	10 - 24	4,30	70	16	6,0	4,9	●	●
UNC nr.	12 - 24	5,00	80	19	6,0	4,9	●	●
UNC	1/4 - 20	5,75	80	19	7,0	5,5	●	●
UNC	5/16 - 18	7,25	90	22	8,0	6,2	●	●
UNC	3/8 - 16	8,70	90	22	10,0	8,0	●	●
Abmessungen mit Überlaufschaft über M 3/8 siehe Kat.-Nr. / above M 3/8 refer to Cat.-No.							-	6811

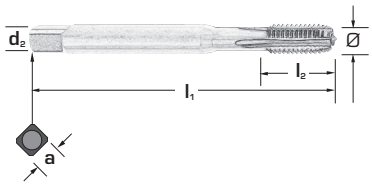
Former S: **mit Schmiernuten** with coolant grooves
Former : **ohne Schmiernuten** without coolant grooves

● Standardartikel / Items available ex stock

DIN 2184/1 - UNC

Maschinen-Gewindebohrer mit Überlaufschaft
für unified-Gewinde (grob) UNC – ASME – B 1.1
Baumaße an DIN 376 angelehnt

Machine taps with reduced shank
for unified coarse thread UNC - ASME – B 1.1
dimensions generally as per DIN 376



Typ / Type	N	N 15°	N 40°	N 40°
Toleranz / Tolerance	2 B	2 B	2 B	3 B
Anschnitt / Gangzahl / Chamfer form / No. of threads	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3
Schneidrichtung / Cutting direction				
Schneidstoff / Material	HSS-Co	HSS-Co	HSS-Co	HSS-Co

Ø mm	Gg/1" Tpi	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	l_3 mm	d_2 mm h9	a h12	6824	6728	6694	6694 3B
UNC	7/16 - 14	9,40	100	14	24	8	6,2	●	●	●	●
UNC	1/2 - 13	10,80	110	16	29	9	7,0	●	●	●	●
UNC	9/16 - 12	12,20	110	20	30	11	9,0	-	-	●	●
UNC	5/8 - 11	13,50	110	20	32	12	9,0	●	●	●	●
UNC	3/4 - 10	16,50	125	25	34	14	11,0	●	●	●	●
UNC	7/8 - 9	19,50	140	25	34	18	14,5	●	●	●	●
UNC	1 - 8	22,25	160	30	38	18	14,5	●	●	●	●

N 15°/40°: **15° Rechtsdrall/40°**
15°/40°right hand helix

N: **Herkömmliche Anwendung**
universal application

● Standardartikel / Items available ex stock

DIN 2184/1 - UNC

Maschinen-Gewindebohrer mit Überlaufschaft
für unified-Gewinde (grob) UNC – ASME – B 1.1
Baumaße an DIN 376 angelehnt
Machine taps with reduced shank
for unified coarse thread UNC - ASME – B 1.1
dimensions generally as per DIN 376

VA 35°	VAP 35°	VRP 50°	HD 15°	Alu 45°	**Typ /** Type
2 BX	2 BX	2 BX	2 B	2 B	**Toleranz** Tolerance
C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	**Anschnitt / Gangzahl** Chamfer form / No. of threads
					Schneidrichtung Cutting direction
HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	**Schneidstoff/** Material
6754	**6754 VP**	**6853 VP**	**6866**	**6733**	**Ø mm**	**Gg/1"** Tpi	**Kernloch Ø** Tap drill Ø
-	-	-	●	-	UNC	7/16 - 14	1,55
●	●	●	●	●	UNC	1/2 - 13	1,85
-	-	-	-	-	UNC	9/16 - 12	2,10
●	●	●	●	-	UNC	5/8 - 11	2,35
●	●	●	●	-	UNC	3/4 - 10	2,65
-	-	-	●	-	UNC	7/8 - 9	2,85
●	●	●	●	-	UNC	1 - 8	3,50

VA: **Für rostfreien Stahl**
for stainless steel
VAP: **vaporisiert**
vaporized
VRP: **Für rostfreien Stahl mit Abschrägung und vaporisiert**
for stainless steel, back tapered and vaporized

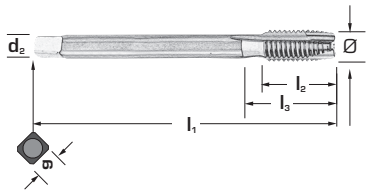
Alu: **für Aluminium**
for Aluminium
HD: **für zähe Werkstoffe**
for tough materials

● Standardartikel / Items available ex stock

DIN 2184/1 - UNC

Maschinen-Gewindebohrer mit Überlaufschaft
für unified-Gewinde (grob) UNC – ASME – B 1.1
Baumaße an DIN 376 angelehnt

Machine taps with reduced shank
for unified coarse thread UNC - ASME – B 1.1
dimensions generally as per DIN 376



Typ / Type	HD	Rapid	Rapid	VA	VA
Toleranz Tolerance	2 B	2 B	3 B	2 BX	2 BX
Anschnitt / Gangzahl Chamfer form / No. of threads	B 4/5	B 4/5	B 4/5	B 4/5	B 4/5
Schneidrichtung Cutting direction					
Schneidstoff/ Material	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co

Ø mm	Gg/1" Tpi	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	l_3 mm	d_2 mm h9	a h12	6874	6693	6693 3B	6749	6749 VP
UNC 7/16	14	9,40	100	14	24	8	6,2	●	●	●	-	-
UNC 1/2	13	10,80	110	16	29	9	7,0	●	●	●	●	●
UNC 9/16	12	12,20	110	20	30	11	9,0	●	●	●	-	-
UNC 5/8	11	13,50	110	20	32	12	9,0	●	●	●	●	●
UNC 3/4	10	16,50	125	25	34	14	11,0	●	●	●	●	●
UNC 7/8	9	19,50	140	25	34	18	14,5	●	●	●	●	●
UNC 1	8	22,25	160	30	38	18	14,5	●	●	●	●	●
UNC 1 1/8	7	25,00	180	-	45	22	18,0	-	●	●	-	-
UNC 1 1/4	7	28,00	180	-	50	22	18,0	-	●	●	-	-
UNC 1 3/8	6	30,75	200	-	56	28	22,0	-	●	●	-	-
UNC 1 1/2	6	34,00	200	-	60	32	24,0	-	●	●	-	-
UNC 1 3/4	5	39,50	220	-	65	36	29,0	-	●	●	-	-
UNC 2	4 1/2	45,00	250	-	70	40	32,0	-	●	●	-	-

Rapid: **Herkömmliche Anwendung**
universal application

HD: **für zähe Werkstoffe**
for tough materials

VA: **Für rostfreien Stahl**
for stainless steel

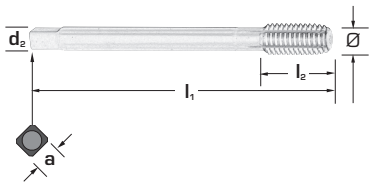
● Standardartikel / Items available ex stock

DIN 2184/1 - UNC

Innengewinde-Former mit Überlaufschaft
für unified-Gewinde (grob) UNC – ASME – B 1.1
Baumaße an DIN 376 angelehnt
Cold forming taps with reduced shank
for unified coarse thread UNC - ASME – B 1.1
dimensions generally as per DIN 376

mit Schmiernuten / with coolant grooves

UNC



	Former S
Typ / Type	
Toleranz Tolerance	2 BX
Anschnitt / Gangzahl Chamfer form / No. of threads	C/2,5-3
Schneidrichtung Cutting direction	
Schneidstoff/ Material	HSS-Co

Ø mm	Gg/1" Tpi	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a h12	6811
UNC 7/16 -	14	10,2	100	22	8	6,2	●
UNC 1/2 -	13	11,7	110	25	9	7,0	●

Former S: **mit Schmiernuten**
with coolant grooves

● Standardartikel / Items available ex stock

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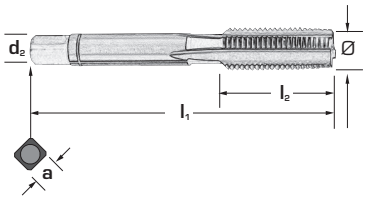
DIN 2184/1 - UNF

Hand-Gewindebohrer, zweiteiliger Satz
für unified-Gewinde (fein) UNF – ASME – B 1.1
Baumaße an DIN 2181 angelehnt

Hand taps, serial, in sets of 2 pieces
for unified fine thread UNF – ASME – B 1.1
dimensions generally as per DIN 2181

UNF



Typ / Type	N	N
Toleranz Tolerance	2 B	2 B
Anschnitt / Gangzahl Chamfer form / No. of threads	A/5-6	C/2,5-3
Schneidrichtung Cutting direction		
Schneidstoff/ Material	HSS	HSS

Ø mm	Gg/1" Tpi	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9*	a h12	6776 V	6776 F
UNF nr. 1 -	72	1,55	45	8	-	2,1	●	●
UNF nr. 2 -	72	1,90	45	9	-	2,1	●	●
UNF nr. 3 -	56	2,15	40	9	2,8	2,1	●	●
UNF nr. 4 -	48	2,40	40	11	3,5	2,7	●	●
UNF nr. 5 -	44	2,70	40	11	3,5	2,7	●	●
UNF nr. 6 -	40	2,95	45	13	4,0	3,0	●	●
UNF nr. 8 -	36	3,50	45	13	4,5	3,4	●	●
UNF nr. 10 -	32	4,10	50	12	6,0	4,9	●	●
UNF nr. 12 -	28	4,70	50	17	6,0	4,9	●	●
UNF 1/4 -	28	5,50	50	14	6,0	4,9	●	●
UNF 5/16 -	24	6,90	56	22	6,0	4,9	●	●
UNF 3/8 -	24	8,50	63	22	7,0	5,5	●	●
UNF 7/16 -	20	9,90	63	20	8,0	6,2	●	●
UNF 1/2 -	20	11,50	70	22	9,0	7,0	●	●
UNF 9/16 -	18	12,90	70	22	11,0	9,0	●	●
UNF 5/8 -	18	14,50	70	22	12,0	9,0	●	●
UNF 3/4 -	16	17,50	80	22	14,0	11,0	●	●
UNF 7/8 -	14	20,40	80	22	18,0	14,5	●	●
UNF 1 -	12	23,25	90	22	18,0	14,5	●	●
UNF 1 1/8 -	12	26,50	90	22	22,0	18,0	●	●
UNF 1 1/4 -	12	29,50	90	22	22,0	18,0	●	●
UNF 1 3/8 -	12	32,75	125	40	28,0	22,0	●	●
UNF 1 1/2 -	12	36,00	125	40	32,0	24,0	●	●

N: Herkömmliche Anwendung
universal application

* Schafttoleranz der Vorschneider h12 / shank tolerance of 1st Tap: h12

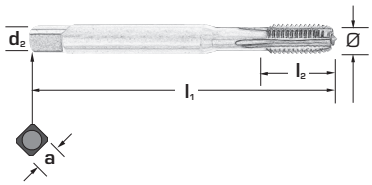
● Standardartikel / Items available ex stock

DIN 2184/1 - UNF

Maschinen-Gewindebohrer mit verstärktem Schaft
für unified-Gewinde (fein) UNF – ASME – B 1.1
Baumaße an DIN 371 angelehnt

Machine taps with reinforced shank
for unified fine thread UNF – ASME – B 1.1
dimensions generally as per DIN 371

UNF | TiCN Top | TiN



Typ / Type	N	N 15°	N 40°	N 40°	N 40°
Toleranz / Tolerance	2 B	2 B	2 B	3 B	2 B
Anschnitt / Gangzahl / Chamfer form / No. of threads	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3
Schneidrichtung / Cutting direction					
Schneidstoff / Material	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co

Ø mm	Gg/1" Tpi	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	l_3 mm	d_2 mm h9	a h12	6838	6719	6680	6680 3B	6680 TN
UNF nr. 1	72	1,55	45	8	-	2,8	2,1	●	-	-	-	-
UNF nr. 2	64	1,90	45	9	-	2,8	2,1	●	-	-	-	-
UNF nr. 3	56	2,15	50	9	-	2,8	2,1	●	-	-	-	-
UNF nr. 4	48	2,40	56	11	-	3,5	2,7	●	-	-	-	-
UNF nr. 5	44	2,70	56	11	5	3,5	-	●	●	●	●	●
UNF nr. 6	40	2,95	56	13	6	4,0	2,1	●	●	●	●	●
UNF nr. 8	36	3,50	63	13	7	4,5	2,1	●	●	●	●	●
UNF nr. 10	32	4,10	70	12	8	6,0	2,7	●	●	●	●	●
UNF nr. 12	28	4,70	80	17	10	6,0	3,0	●	●	●	●	●
UNF 1/4	28	5,50	80	14	10	7,0	3,4	●	●	●	●	●
UNF 5/16	24	6,90	90	22	12	8,0	4,9	●	●	●	●	●
UNF 3/8	24	8,50	90	22	12	10,0	7,0	●	●	●	●	●
Abmessungen mit Überlaufschaft über M 3/8 siehe Kat.-Nr. / above M 3/8 refer to Cat.-No.								6839	6729	66882B	66883B	-

N 15°/40°: 15° Rechtsdrall/40°
15°/40°right hand helix

N: Herkömmliche Anwendung
universal application

● Standardartikel / Items available ex stock

DIN 2184/1 - UNF

Maschinen-Gewindebohrer mit verstärktem Schaft
für unified-Gewinde (fein) UNF – ASME – B 1.1
Baumaße an DIN 371 angelehnt
Machine taps with reinforced shank
for unified fine thread UNF – ASME – B 1.1
dimensions generally as per DIN 371

VA 35°	VAP 35°	VRP 50°	HD 15°	Alu 45°	**Typ /** Type
2 BX	2 BX	2 BX	2 B	2 B	**Toleranz** Tolerance
C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	**Anschnitt / Gangzahl** Chamfer form / No. of threads
					Schneidrichtung Cutting direction
HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	**Schneidstoff/** Material
6794	**6794 VP**	**6854 VP**	**6848**	**6628**	**Ø mm**	**Gg/1"** Tpi	**Kernloch Ø** Tap drill Ø
-	-	-	-	-	**UNF nr. 1**	72	1,55
-	-	-	-	-	**UNF nr. 2**	64	1,90
-	-	-	-	-	**UNF nr. 3**	56	2,15
-	-	-	-	-	**UNF nr. 4**	48	2,40
-	-	-	●	-	**UNF nr. 5**	44	2,70
-	-	-	●	-	**UNF nr. 6**	40	2,95
-	-	-	●	-	**UNF nr. 8**	36	3,50
●	●	●	●	●	**UNF nr. 10**	32	4,10
-	-	-	●	-	**UNF nr. 12**	28	4,70
●	●	●	●	●	**UNF 1/4**	28	5,50
●	●	●	●	●	**UNF 5/16**	24	6,90
●	●	●	●	●	**UNF 3/8**	24	8,50
6796	6796VP	6855VP	6849	6734			

VA: **Für rostfreien Stahl**
for stainless steel
VAP: **vaporisiert**
vaporized
VRP: **Für rostfreien Stahl mit Abschrägung und vaporisiert**
for stainless steel, back tapered and vaporized

Alu: **für Aluminium**
for Aluminium
HD: **für zähe Werkstoffe**
for tough materials

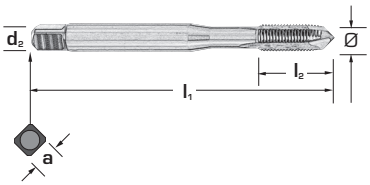
● Standardartikel / Items available ex stock

DIN 2184/1 - UNF

Maschinen-Gewindebohrer mit verstärktem Schaft
für unified-Gewinde (fein) UNF – ASME – B 1.1
Baumaße an DIN 371 angelehnt

Machine taps with reinforced shank
for unified fine thread UNF - ASME – B 1.1
dimensions generally as per DIN 371

UNF TiN



Typ / Type	Rapid	Rapid	Rapid
Toleranz Tolerance	2 B	3 B	2 B
Anschnitt / Gangzahl Chamfer form / No. of threads	B/4-5	B/4-5	B/4-5
Schneidrichtung Cutting direction			
Schneidstoff/ Material	HSS-Co	HSS-Co	HSS-Co

Ø mm	Gg/1" Tpi	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a h12	6607	6607 3B	6607 TN
UNF nr. 1 -	72	1,55	45	8	2,8	2,1	●	●	●
UNF nr. 2 -	64	1,90	45	9	2,8	2,1	●	●	●
UNF nr. 3 -	56	2,15	50	9	2,8	2,1	●	●	●
UNF nr. 4 -	48	2,40	56	11	3,5	2,7	●	●	●
UNF nr. 5 -	44	2,70	56	11	3,5	2,7	●	●	●
UNF nr. 6 -	40	2,95	56	13	4,0	3,0	●	●	●
UNF nr. 8 -	36	3,50	63	13	4,5	3,4	●	●	●
UNF nr. 10 -	32	4,10	70	12	6,0	4,9	●	●	●
UNF nr. 12 -	28	4,70	80	17	6,0	4,9	●	●	●
UNF 1/4 -	28	5,50	80	14	7,0	5,5	●	●	●
UNF 5/16 -	24	6,90	90	22	8,0	6,2	●	●	●
UNF 3/8 -	24	8,50	90	22	10,0	7,0	●	●	●
Abmessungen mit Überlaufschaft über M 3/8 siehe Kat.-Nr. / above M 3/8 refer to Cat.-No.							66872B	66873B	-

Rapid: Herkömmliche Anwendung
universal application

● Standardartikel / Items available ex stock

DIN 2184/1 - UNF

Maschinen-Gewindebohrer mit verstärktem Schaft
für unified-Gewinde (fein) UNF – ASME – B 1.1
Baumaße an DIN 371 angelehnt
Machine taps with reinforced shank
for unified fine thread UNF - ASME – B 1.1
dimensions generally as per DIN 371

VA	VAP	HD	
			Typ / Type
2 BX	2 BX	2 BX	**Toleranz** Tolerance
B/4-5	B/4-5	B/4-5	**Anschnitt / Gangzahl** Chamfer form / No. of threads
			Schneidrichtung Cutting direction
HSS-Co	HSS-Co	HSS-Co	**Schneidstoff/** Material
6718	**6718 VP**	**6875**	**Ø mm** / **Gg/1"** Tpi / **Kernloch Ø** Tap drill Ø
-	-	-	UNF nr. 1 - 72 — 1,55
●	●	●	UNF nr. 2 - 64 — 1,90
●	●	●	UNF nr. 3 - 56 — 2,15
●	●	●	UNF nr. 4 - 48 — 2,40
●	●	●	UNF nr. 5 - 44 — 2,70
●	●	●	UNF nr. 6 - 40 — 2,95
●	●	●	UNF nr. 8 - 36 — 3,50
●	●	●	UNF nr. 10 - 32 — 4,10
●	●	●	UNF nr. 12 - 28 — 4,70
●	●	●	UNF 1/4 - 28 — 5,50
●	●	●	UNF 5/16 - 24 — 6,90
●	●	●	UNF 3/8 - 24 — 8,50
6797	-	6876	

VA: **Für rostfreien Stahl**
for stainless steel

VAP: **vaporisiert**
vaporized

HD: **für zähe Werkstoffe**
for tough materials

● Standardartikel / Items available ex stock

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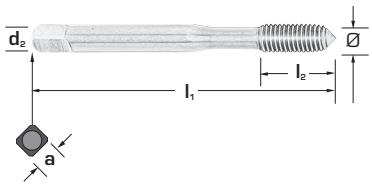
DIN 2184/1 - UNF

Innengewinde-Former mit verstärktem Schaft für unified-Gewinde (fein) UNF – ASME – B 1.1 Baumaße an DIN 371 angelehnt

Cold forming taps with reinforced shank for unified fine thread UNF - ASME – B 1.1 dimensions generally as per DIN 371

Ref. **6747** ohne Schmiernuten / without coolant grooves
Ref. **6815** mit Schmiernuten / with coolant grooves

UNF



Typ / Type	Former	Former S
Toleranz Tolerance	2 BX	2 BX
Anschnitt / Gangzahl Chamfer form / No. of threads	C/2,5-3	C/2,5-3
Schneidrichtung Cutting direction		
Schneidstoff/ Material	HSS-Co	HSS-Co

Ø mm	Gg/1" Tpi	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a h12	6747	6815
UNF nr. 4 -	48	2,60	56	11	3,5	2,7	●	●
UNF nr. 5 -	44	2,90	56	11	3,5	2,7	●	●
UNF nr. 6 -	40	3,20	56	13	4,0	2,1	-	●
UNF nr. 8 -	36	3,80	63	13	4,5	3,4	●	●
UNF nr. 10 -	32	4,45	70	16	6,0	4,9	●	●
UNF nr. 12 -	28	5,05	80	19	6,0	4,9	●	●
UNF 1/4 -	28	5,90	80	19	7,0	5,5	●	●
UNF 5/16 -	24	7,40	90	22	8,0	6,2	●	●
UNF 3/8 -	24	9,00	90	22	10,0	7,0	●	●
Abmessungen mit Überlaufschaft über M 3/8 siehe Kat.-Nr. / above M 3/8 refer to Cat.-No.							-	6816

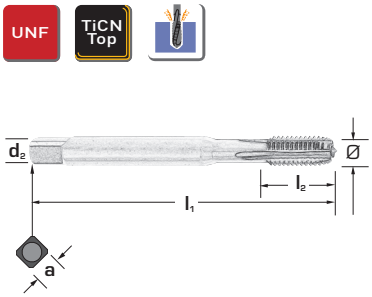
Former S: **mit Schmiernuten** with coolant grooves
Former : **ohne Schmiernuten** without coolant grooves

● Standardartikel / Items available ex stock

DIN 2184/1 - UNF

Maschinen-Gewindebohrer mit Überlaufschaft
für unified-Gewinde (fein) UNF – ASME – B 1.1
Baumaße an DIN 374 angelehnt

Machine taps with reduced shank
for unified fine thread UNF - ASME – B 1.1
dimensions generally as per DIN 374



Typ / Type	N	N 15°	N 40°	N 40°
Toleranz Tolerance	2 B	2 B	2 B	3 B
Anschnitt / Gangzahl Chamfer form / No. of threads	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3
Schneidrichtung Cutting direction				
Schneidstoff/ Material	HSS-Co	HSS-Co	HSS-Co	HSS-Co

Ø mm	Gg/1" Tpi	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	l_3 mm	$d_2$mm h9	a h12	6839	6729	6688	6688 3B
UNF 7/16 -	20	9,90	90	20	14	8	6,2	●	●	●	●
UNF 1/2 -	20	11,50	100	22	16	9	7,0	●	●	●	●
UNF 9/16 -	18	12,90	100	22	20	11	9,0	●	●	●	●
UNF 5/8 -	18	14,50	100	22	20	12	9,0	●	●	●	●
UNF 3/4 -	16	17,50	110	25	25	14	11,0	●	●	●	●
UNF 7/8 -	14	20,40	125	25	25	18	14,5	●	●	●	●
UNF 1 -	12	23,25	140	28	25	18	14,5	●	●	●	●
UNF 1 1/8 -	12	26,50	150	28	26	22	15,0	●	-	-	-
UNF 1 1/4 -	12	29,50	150	28	27	22	15,5	●	-	-	-
UNF 1 3/8 -	12	32,75	170	30	27	28	16,0	●	-	-	-
UNF 1 1/2 -	12	30,60	170	30	28	28	16,5	●	-	-	-

N 15°/40°: **15° Rechtsdrall/40°**
15°/40°right hand helix

N: **Herkömmliche Anwendung**
universal application

● Standardartikel / Items available ex stock

DIN 2184/1 - UNF

Maschinen-Gewindebohrer mit verstärktem Schaft
für unified-Gewinde (fein) UNF – ASME – B 1.1
Baumaße an DIN 371 angelehnt
Machine taps with reinforced shank
for unified fine thread UNF – ASME – B 1.1
dimensions generally as per DIN 371

VA 35°	VRP 50°	HD 15°	ALU 45°	**Typ /** Type
2 B	2 BX	2 B	2 B	**Toleranz** Tolerance
C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	**Anschnitt / Gangzahl** Chamfer form / No. of threads
				Schneidrichtung Cutting direction
HSS-Co	HSS-Co	HSS-Co	HSS-Co	**Schneidstoff/** Material

6796	6855 VP	6849	6734	Ø mm	Gg/1" Tpi	Kernloch Ø Tap drill Ø
●	●	●	-	UNF 7/16 -	20	9,90
●	●	●	●	UNF 1/2 -	20	11,50
●	●	●	-	UNF 9/16 -	18	12,90
●	●	●	-	UNF 5/8 -	18	14,50
●	●	●	-	UNF 3/4 -	16	17,50
-	-	●	-	UNF 7/8 -	14	20,40
-	-	●	-	UNF 1 -	12	23,25
-	-	-	-	UNF 1 1/8 -	12	26,50
-	-	-	-	UNF 1 1/4 -	12	29,50
-	-	-	-	UNF 1 3/8 -	12	32,75
-	-	-	-	UNF 1 1/2 -	12	30,60

VA: **Für rostfreien Stahl**
for stainless steel
VRP: **Für rostfreien Stahl mit Abschrägung und vaporisiert**
for stainless steel, back tapered and vaporized

HD: **für zähe Werkstoffe**
for tough materials
Alu: **für Aluminium**
for Aluminium

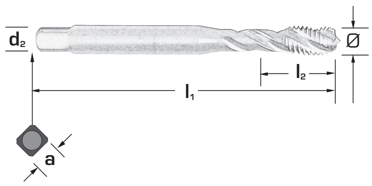
● Standardartikel / Items available ex stock

DIN 376 UN-8

Maschinen-Gewindebohrer mit Überlaufschaft
für unified fein Gewinde UN – 8
Baumaße DIN 376
Machine taps with reduced shank
for unified fine thread UN-8
dimensions generally as per DIN 376

UN-8

NEW



Typ / Type	VA 35°
Toleranz Tolerance	2 BX
Anschnitt / Gangzahl Chamfer form / No. of threads	C/2,5-3
Schneidrichtung Cutting direction	
Schneidstoff / Material	HSS-Co

Ø mm	Gg/1" Tpi	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	$d_2$mm h9	a h12	6945 VP
UN-8 1 1/8 -	8	9,90	180	28	22	18	●
UN-8 1 1/4 -	8	11,50	180	40	22	18	●
UN-8 1 3/8 -	8	12,90	200	32	28	22	●
UN-8 1 1/2 -	8	14,50	200	32	28	22	●

VA: **Für rostfreien Stahl**
for stainless steel

● **Standardartikel /** Items available ex stock

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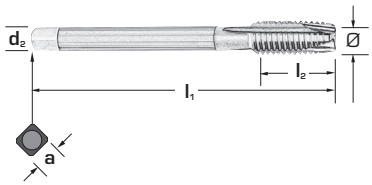
DIN 2184/1 - UNF

Maschinen-Gewindebohrer mit Überlaufschaft
für unified-Gewinde (fein) UNF – ASME – B 1.1
Baumaße an DIN 374 angelehnt
Machine taps with reduced shank
for unified fine thread UNF - ASME – B 1.1
dimensions generally as per DIN 374



Typ / Type	Rapid	Rapid	VA	HD
Toleranz / Tolerance	2 B	3 B	2 BX	2 B
Anschnitt / Gangzahl / Chamfer form / No. of threads	B/4-5	B/4-5	B/4-5	B/4-5
Schneidrichtung / Cutting direction				
Schneidstoff / Material	HSS-Co	HSS-Co	HSS-Co	HSS-Co

Ø mm	Gg/1" Tpi	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a h12	6687	6687 3B	6797	6876
UNF 7/16	- 20	9,90	90	20	8	6,2	●	●	●	●
UNF 1/2	- 20	11,50	100	22	9	7,0	●	●	●	●
UNF 9/16	- 18	12,90	100	22	11	9,0	●	●	-	●
UNF 5/8	- 18	14,50	100	22	12	9,0	●	●	●	●
UNF 3/4	- 16	17,50	110	25	14	11,0	●	●	●	●
UNF 7/8	- 14	20,40	125	25	18	14,5	●	●	-	●
UNF 1	- 12	23,25	140	28	18	14,5	●	●	-	●
UNF 1 1/8	- 12	26,50	150	28	22	18,0	●	●	-	
UNF 1 1/4	- 12	29,50	150	28	22	18,0	●	●	-	
UNF 1 3/8	- 12	32,75	170	30	28	22,0	●	●	-	
UNF 1 1/2	- 12	36,00	170	30	32	24,0	●	●	-	

Rapid: **Herkömmliche Anwendung**
universal application

VA: **Für rostfreien Stahl**
for stainless steel

HD: **für zähe Werkstoffe**
for tough materials

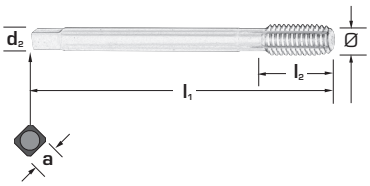
● Standartartikel / Items available ex stock

DIN 2184/1 - UNF

Innengewinde-Former mit Überlaufschaft
für unified-Gewinde (fein) UNF – ASME – B 1.1
Baumaße an DIN 374 angelehnt
Cold forming taps with reduced shank
for unified fine thread UNF - ASME – B 1.1
dimensions generally as per DIN 374

mit Schmiernuten / with coolant grooves

UNF



	Former S
Typ / Type	
Toleranz Tolerance	2 BX
Anschnitt / Gangzahl Chamfer form / No. of threads	C/2,5-3
Schneidrichtung Cutting direction	
Schneidstoff/ Material	HSS-Co

Ø mm	Gg/1" Tpi	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a h12	6816
UNF 7/16 -	20	10,5	90	20	8	6,2	●
UNF 1/2 -	20	12,1	100	22	9	7,0	●
UNF 5/8 -	18	15,2	100	22	12	9,0	●

Former S: **mit Schmiernuten**
with coolant grooves

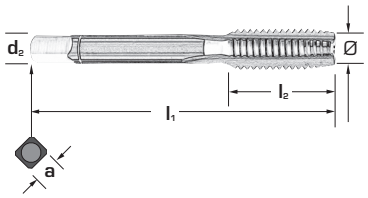
● Standardartikel / Items available ex stock

ILIX NORM - BSW

Hand-Gewindebohrer, dreiteiliger Satz
für Whitworth-Gewinde BSW
Baumaße an DIN 352 angelehnt

Hand taps, serial, in sets of 3 pieces
for British standard Whitworth thread BSW
dimensions generally as per DIN 352

W



Typ / Type							N	N	N
Toleranz Tolerance							-	-	-
Anschnitt / Gangzahl Chamfer form / No. of threads							A/5-6	D/3-4	C/2,5-3
Schneidrichtung Cutting direction									
Schneidstoff/ Material							HSS	HSS	HSS
Ø mm	**Gg/1"** Tpi	**Kernloch Ø** Tap drill Ø	**l_1** mm	**l_2** mm	**d_2** mm h9*	**a** h12	**6603 V**	**6603 M**	**6603 F**
							Einzel single tap		**Satz** set
W 1/16	60	1,20	32	8	2,5	2,1	●		●
W 3/32	48	1,90	40	9	2,8	2,1	●		●
W 1/8	40	2,50	40	11	3,5	2,7	●		●
W 5/32	32	3,20	45	13	4,5	3,4	●		●
W 3/16	24	3,60	50	16	6,0	4,9	●		●
W 7/32	24	4,50	50	17	6,0	4,9	●		●
W 1/4	20	5,10	50	19	6,0	4,9	●		●
W 5/16	18	6,50	56	22	6,0	4,9	●		●
W 3/8	16	7,90	63	22	7,0	5,5	●		●
W 7/16	14	9,30	70	24	8,0	6,2	●		●
W 1/2	12	10,50	75	29	9,0	7,0	●		●
W 9/16	12	12,00	80	30	11,0	9,0	●		●
W 5/8	11	13,50	80	32	12,0	9,0	●		●
W 3/4	10	16,50	95	40	14,0	11,0	●		●
W 7/8	9	19,25	100	40	18,0	14,5	●		●
W 1	8	22,00	110	50	18,0	14,5	●		●
W 1 1/8	7	24,75	125	56	22,0	18,0	●		●
W 1 1/4	7	28,00	125	56	22,0	18,0	●		●
W 1 3/8	6	30,50	150	63	28,0	22,0	●		●
W 1 1/2	6	33,50	150	63	32,0	24,0	●		●
W 1 5/8	5	35,50	150	63	32,0	24,0	●		●
W 1 3/4	5	39,00	160	70	36,0	29,0	●		●
W 2	4,5	44,50	180	75	40,0	32,0	●		●

N: **Herkömmliche Anwendung**
universal application

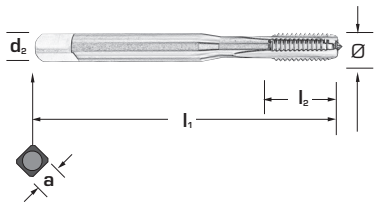
* Schafttoleranz der Vorschneider h 12 / Shank tolerance of 1st tap: h 12

● Standardartikel / Items available ex stock

ILIX NORM - BSW

Maschinen-Gewindebohrer mit verstärktem Schaft
für Whitworth-Gewinde BSW
Baumaße an DIN 371 angelehnt

Machine taps with reinforced shank
for British standard Whitworth thread BSW
dimensions generally as per DIN 371



Typ / Type	N	N 40°	Rapid
Toleranz Tolerance	-	-	-
Anschnitt / Gangzahl Chamfer form / No. of threads	C/2,5-3	C/2,5-3	B/4-5
Schneidrichtung Cutting direction			
Schneidstoff/ Material	HSS-Co	HSS-Co	HSS-Co

Ø mm	Gg/1" Tpi	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a h12	6699	6836	6697
W 1/8	40	2,5	56	11	3,5	2,7	●	●	●
W 5/32	32	3,2	63	13	4,5	3,4	●	●	●
W 3/16	24	3,6	70	16	6,0	4,9	●	●	●
W 1/4	20	5,1	80	17	7,0	5,5	●	●	●
W 5/16	18	6,5	90	20	8,0	6,2	●	●	●
W 3/8	16	7,9	90	20	9,0	7,0	●	●	●

N: **Herkömmliche Anwendung**
universal application

Rapid: **Herkömmliche Anwendung**
universal application

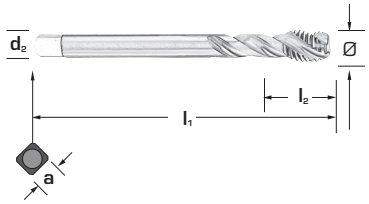
N 40°: **Rechtsrall a 40°**
40° right hand helix

● Standardartikel / Items available ex stock

ILIX NORM - BSW

Maschinen-Gewindebohrer mit Überlaufschaft
für Whitworth-Gewinde BSW
Baumaße an DIN 376 angelehnt

Machine taps with reduced shank
for British standard Whitworth thread BSW
dimensions generally as per DIN 376



Typ / Type	**N 40°**	**Rapid**
Toleranz Tolerance	-	-
Anschnitt / Gangzahl Chamfer form / No. of threads	C/2,5-3	B/4-5
Schneidrichtung Cutting direction		
Schneidstoff/ Material	HSS-Co	HSS-Co

Ø mm	Gg/1" Tpi	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a h12	6837	6636
W 7/16	14	9,30	100	24	8	6,2	●	●
W 1/2	12	10,50	110	29	9	7,0	●	●
W 9/16	12	12,00	110	30	11	9,0	●	●
W 5/8	11	13,50	110	32	12	9,0	●	●
W 3/4	10	16,50	125	34	14	11,0	●	●
W 7/8	9	19,25	140	34	18	14,5	●	●
W 1	8	22,00	160	38	18	14,5	●	●

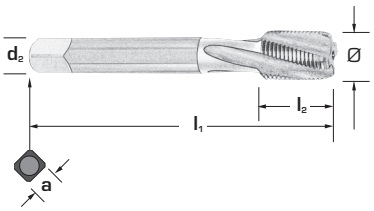
N 40°: Rechtsrall a 40°
40° right hand helix
Rapid: Herkömmliche Anwendung
universal application

● Standardartikel / Items available ex stock

DIN 5156 - (Rp)

Maschinen-Gewindebohrer mit Überlaufschaft
für zylindrisches Whitworth-Rohr-Innengewinde nach DIN 2999
Machine taps with reduced shank
for cylindrical Whitworth-Pipe internal thread
as per DIN 2999

Rp



Typ / Type	N 15°	GG	Rapid
Toleranz Tolerance	-	-	-
Anschnitt / Gangzahl Chamfer form / No. of threads	C/2,5-3	C/2,5-3	B/4-5
Schneidrichtung Cutting direction			
Schneidstoff/ Material	HSS-Co	HSS-Co	HSS-Co

Ø mm	Gg/1" Tpi	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a h12	6675	6674	6673
Rp 1/16	28	6,60	90	22	6	4,9	-	-	●
Rp 1/8	28	8,60	90	20	7	5,5	●	●	●
Rp 1/4	19	11,50	100	22	11	9,0	●	●	●
Rp 3/8	19	15,00	100	22	12	9,0	●	●	●
Rp 1/2	14	18,75	125	25	16	12,0	●	●	●
Rp 3/4	14	24,25	140	28	20	16,0	●	●	●
Rp 1	11	30,25	160	30	25	20,0	●	●	●
Rp 1 1/4	11	39,00	170	30	32	24,0	-	●	●
Rp 1 1/2	11	45,00	190	32	36	29,0	-	●	●
Rp 2	11	56,50	190	32	45	35,0	-	●	●

GG: **für Guss**
for cast iron

N 15°: **15° Rechtsdrall**
15° right hand helix

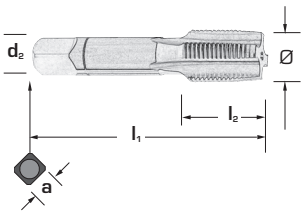
Rapid: **Herkömmliche Anwendung**
universal application

● Standardartikel / Items available ex stock

DIN 5157 - BSP

Hand-Gewindebohrer, zweiteiliger Satz
für Rohrgewinde nach DIN 259 und DIN-ISO 228
Hand taps, serial, in set of 2 pieces for British standard Pipe thread
as per DIN 259 and DIN-ISO 228

G



Typ / Type	N	N
Toleranz Tolerance	-	-
Anschnitt / Gangzahl Chamfer form / No. of threads	A/5-6	C/2,5-3
Schneidrichtung Cutting direction		
Schneidstoff/ Material	HSS	HSS

Ø mm	Gg/1" Tpi	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9*	a h12	6627 V	6627 F
							Einzel single tap	**Satz** set
G 1/16	28	6,80	56	22	6	4,9	●	●
G 1/8	28	8,80	63	20	7	5,5	●	●
G 1/4	19	11,80	70	22	11	9,0	●	●
G 3/8	19	15,25	70	22	12	9,0	●	●
G 1/2	14	19,00	80	22	16	12,0	●	●
G 5/8	14	21,00	80	22	18	14,5	●	●
G 3/4	14	24,50	90	22	20	16,0	●	●
G 7/8	14	28,25	90	22	22	18,0	●	●
G 1	11	30,75	100	25	25	20,0	●	●
G 1 1/8	11	35,50	125	40	28	22,0	●	●
G 1 1/4	11	39,50	125	40	32	24,0	●	●
G 1 3/8	11	42,00	125	40	36	29,0	●	●
G 1 1/2	11	45,00	140	40	36	29,0	●	●
G 1 3/4	11	51,00	140	40	40	32,0	●	●
G 2	11	57,00	160	40	45	35,0	●	●

N: **Herkömmliche Anwendung**
universal application

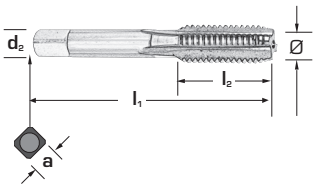
* Schafttoleranz der Vorschneider h 12 / Shank tolerance of 1st tap: h 12

● Standardartikel / Items available ex stock

DIN 5157 - BSP

Kurze Maschinen-Gewindebohrer
mit Überlaufschaft für Rohrgewinde nach DIN 259 und DIN-ISO 228
Short machine taps with reduced shank for British standard Pipe thread
as per DIN 259 and DIN-ISO 228

G



Typ / Type	N	N 15°	MS	VA 15°
Toleranz Tolerance	-	ISO 228 +0,1	-	-
Anschnitt / Gangzahl Chamfer form / No. of threads	C/2,5-3	E/1-2	E/1,5-2	E/1-2
Schneidrichtung Cutting direction				
Schneidstoff/ Material	HSS-Co	HSS-Co	HSS-Co	HSS-Co

Ø mm	Gg/1" Tpi	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a h12	6858	6905	6913	6951
G 1/16	28	6,80	56	22	6	4,9	●	-	●	●
G 1/8	28	8,80	63	20	7	5,5	●	●	●	●
G 1/4	19	11,80	70	22	11	9,0	●	●	●	●
G 3/8	19	15,25	70	22	12	9,0	●	●	●	●
G 1/2	14	19,00	80	22	16	12,0	●	●	●	●
G 5/8	14	21,00	80	22	18	14,5	●	-	●	●
G 3/4	14	24,50	90	22	20	16,0	●	●	●	●
G 7/8	14	28,25	90	22	22	18,0	●	-	●	●
G 1	11	30,75	100	25	25	20,0	●	-	●	●
G 1 1/8	11	35,50	125	40	28	22,0	●	-	●	-
G 1 1/4	11	39,50	125	40	32	24,0	●	-	●	-
G 1 3/8	11	42,00	125	40	36	29,0	●	-	●	-
G 1 1/2	11	45,00	140	40	36	29,0	●	-	●	-

N 15°: **15° Rechtsdrall**
15° right hand helix

N: **Herkömmliche Anwendung**
universal application

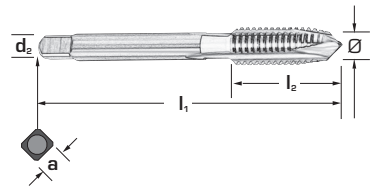
MS: **für Messing**
for brass

VA: **Für rostfreien Stahl**
for stainless steel

● Standardartikel / Items available ex stock

DIN 5157 - BSP

Kurze Maschinen-Gewindebohrer
mit Überlaufschaft für Rohrgewinde nach DIN 259 und DIN-ISO 228
Short machine taps with reduced shank for British standard Pipe thread
as per DIN 259 and DIN-ISO 228



	VA
Typ / Type	
Toleranz Tolerance	-
Anschnitt / Gangzahl Chamfer form / No. of threads	B/4-5
Schneidrichtung Cutting direction	
Schneidstoff/ Material	HSS-Co

Ø mm	Gg/1" Tpi	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a h12	6857
G 1/16	28	6,80	56	22	6	4,9	●
G 1/8	28	8,80	63	20	7	5,5	●
G 1/4	19	11,80	70	22	11	9,0	●
G 3/8	19	15,25	70	22	12	9,0	●
G 1/2	14	19,00	80	22	16	12,0	●
G 5/8	14	21,00	80	22	18	14,5	●
G 3/4	14	24,50	90	22	20	16,0	●
G 7/8	14	28,25	90	22	22	18,0	●
G 1	11	30,75	100	25	25	20,0	●
G 1 1/8	11	35,50	125	40	28	22,0	●
G 1 1/4	11	39,50	125	40	32	24,0	●
G 1 3/8	11	42,00	125	40	36	29,0	●
G 1 1/2	11	45,00	140	40	36	29,0	●

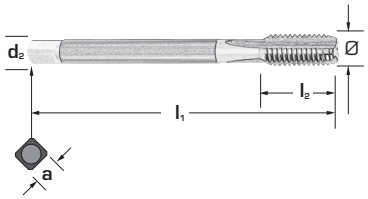
VA: **Für rostfreien Stahl**
for stainless steel

● Standardartikel / Items available ex stock

DIN 5156 - BSP

Maschinen-Gewindebohrer
mit Überlaufschaft für Rohrgewinde nach DIN 259 und DIN-ISO 228
Machine taps with reduced shank for British standard Pipe thread as per DIN 259 and DIN-ISO 228

G TiN



Ø mm	Gg/1" Tpi	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	l_3 mm	d_2 mm h9	a h12	6912	6912 TN	6665	6703	6703 VP	6703 TN
								HD	HD	N 15°	N 40°	N VAP 15°	N 40°
								-	-	-	-	-	-
								C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3
								HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co
G 1/16	28	6,80	90	22	12	6	4,9	●	●	●	●	●	●
G 1/8	28	8,80	90	20	14	7	5,5	●	●	●	●	●	●
G 1/4	19	11,80	100	22	20	11	9,0	●	●	●	●	●	●
G 3/8	19	15,25	100	22	20	12	9,0	●	●	●	●	●	●
G 1/2	14	19,00	125	25	25	16	12,0	●	●	●	●	●	●
G 5/8	14	21,00	125	25	25	18	14,5	●	●	●	●	●	●
G 3/4	14	24,50	140	28	28	20	16,0	●	●	●	●	●	●
G 7/8	14	28,25	150	28	28	22	18,0	●	●	●	●	●	●
G 1	11	30,75	160	30	30	25	20,0	●	●	●	●	●	●
G 1 1/8	11	35,50	170	30	-	28	22,0	●	●	-	-	-	-
G 1 1/4	11	39,50	170	30	-	32	24,0	●	●	-	-	-	-
G 1 3/8	11	42,00	180	32	-	36	29,0	●	●	-	-	-	-
G 1 1/2	11	45,00	190	32	-	36	29,0	●	●	-	-	-	-
G 1 3/4	11	51,00	190	32	-	40	32,0	●	●	-	-	-	-
G 2	11	57,00	220	40	-	45	35,0	●	●	-	-	-	-

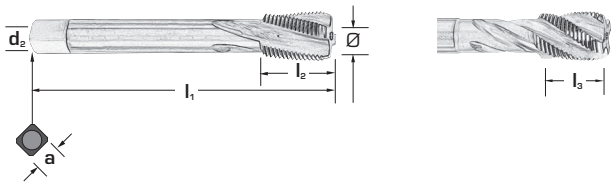
HD : **für zähe Werkstoffe**
for tough materials
N 15°/40°: **15° Rechtsdrall/40°**
15°/40°right hand helix
VAP: **vaporisiert**
vaporized
N: **Herkömmliche Anwendung**
universal application

● Standardartikel / Items available ex stock

DIN 5156 - BSP

Maschinen-Gewindebohrer
mit Überlaufschaft für Rohrgewinde nach DIN 259
und DIN-ISO 228

Machine taps with reduced shank
for British standard Pipe thread
as per DIN 259 and DIN-ISO 228



Typ / Type									VA 15°	VA 35°	VAP 35°	VA 35°	VRP 50°
Toleranz / Tolerance									-	-	-	-	-
Anschnitt / Gangzahl / Chamfer form / No. of threads									C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3
Schneidrichtung / Cutting direction													
Schneidstoff / Material									HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co
Ø mm		Gg/1" Tpi	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	l_3 mm	d_2 mm h9	a h12	6716	6701	6701 VP	6701 XP	6856 VP
G	1/16	28	6,80	90	22	12	6	4,9	●	●	●	●	●
G	1/8	28	8,80	90	20	14	7	5,5	●	●	●	●	●
G	1/4	19	11,80	100	22	20	11	9,0	●	●	●	●	●
G	3/8	19	15,25	100	22	20	12	9,0	●	●	●	●	●
G	1/2	14	19,00	125	25	25	16	12,0	●	●	●	●	●
G	5/8	14	21,00	125	25	25	18	14,5	●	●	●	●	●
G	3/4	14	24,50	140	28	28	20	16,0	●	●	●	●	●
G	7/8	14	28,25	150	28	28	22	18,0	●	●	●	●	●
G	1	11	30,75	160	30	30	25	20,0	●	●	●	●	●
G	1 1/8	11	35,50	170	30	-	28	22,0	-	-	-	-	-
G	1 1/4	11	39,50	170	30	-	32	24,0	-	-	-	-	-
G	1 3/8	11	42,00	180	32	-	36	29,0	-	-	-	-	-
G	1 1/2	11	45,00	190	32	-	36	29,0	-	-	-	-	-
G	1 3/4	11	51,00	190	32	-	40	32,0	-	-	-	-	-
G	2	11	57,00	220	40	-	45	35,0	-	-	-	-	-

VA: **Für rostfreien Stahl**
for stainless steel

VAP: **vaporisiert**
vaporized

VRP: **Für rostfreien Stahl mit Abschrägung und vaporisiert**
for stainless steel, back tapered and vaporized

● Standartartikel / Items available ex stock

DIN 5156 - BSP

Maschinen-Gewindebohrer
mit Überlaufschaft für Rohrgewinde nach DIN 259
und DIN-ISO 228
Machine taps with reduced shank
for British standard Pipe thread
as per DIN 259 and DIN-ISO 228

GG	GG	**Typ /** Type
-	-	**Toleranz** Tolerance
C/2,5-3	C/2,5-3	**Anschnitt / Gangzahl** Chamfer form / No. of threads
		Schneidrichtung Cutting direction
HSS-Co	HSS-Co	**Schneidstoff/** Material

6708	6708 TF	Ø mm		Gg/1" Tpi		Kernloch Ø Tap drill Ø
●	●	G		1/16	28	6,80
●	●	G		1/8	28	8,80
●	●	G		1/4	19	11,80
●	●	G		3/8	19	15,25
●	●	G		1/2	14	19,00
●	●	G		5/8	14	21,00
●	●	G		3/4	14	24,50
●	●	G		7/8	14	28,25
●	●	G		1	11	30,75
●	●	G	1	1/8	11	35,50
●	●	G	1	1/4	11	39,50
●	●	G	1	3/8	11	42,00
●	●	G	1	1/2	11	45,00
●	●	G	1	3/4	11	51,00
●	●	G		2	11	57,00

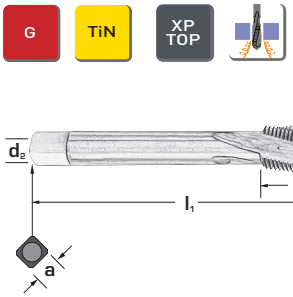
GG: für Guss
for cast iron

● Standardartikel / Items available ex stock

DIN 5156 - BSP

Maschinen-Gewindebohrer
mit Überlaufschaft für Rohrgewinde nach DIN 259
und DIN-ISO 228

Machine taps with reduced shank
for British standard Pipe thread
as per DIN 259 and DIN-ISO 228



Typ / Type	Rapid	VAP Rapid	Rapid
Toleranz Tolerance	-	-	-
Anschnitt / Gangzahl Chamfer form / No. of threads	B/4-5	B/4-5	B/4-5
Schneidrichtung Cutting direction			
Schneidstoff/ Material	HSS-Co	HSS-Co	HSS-Co

Ø mm	Gg/1" Tpi	Kernloch Ø Tap drill Ø	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a h12	6704	6704 VP	6704 TN
G 1/16	28	6,80	7,3	90	22	6	4,9	●	●	●
G 1/8	28	8,80	9,3	90	20	7	5,5	●	●	●
G 1/4	19	11,80	12,5	100	22	11	9,0	●	●	●
G 3/8	19	15,25	16,0	100	22	12	9,0	●	●	●
G 1/2	14	20,10	20,1	125	25	16	12,0	●	●	●
G 5/8	14	21,00	-	125	25	18	14,5	●	●	●
G 3/4	14	24,50	-	140	28	20	16,0	●	●	●
G 7/8	14	28,25	-	150	28	22	18,0	●	●	●
G 1	11	30,75	-	160	30	25	20,0	●	●	●
G 1 1/8	11	35,50	-	170	30	28	22,0	●	●	●
G 1 1/4	11	39,50	-	170	30	32	24,0	●	●	●
G 1 1/2	11	45,00	-	190	32	36	29,0	●	●	●
G 1 3/4	11	51,00	-	190	32	40	32,0	●	●	●
G 2	11	57,00	-	220	40	45	35,0	●	●	●

Rapid: **Herkömmliche Anwendung**
universal application
VAP: **vaporisiert**
vaporized

● Standardartikel / Items available ex stock

DIN 5156 - BSP

Maschinen-Gewindebohrer
mit Überlaufschaft für Rohrgewinde nach DIN 259
und DIN-ISO 228
Machine taps with reduced shank
for British standard Pipe thread
as per DIN 259 and DIN-ISO 228

VA	VAP	VA	Former	Former S	**Typ /** Type
-	-	-	-	-	**Toleranz** Tolerance
B/4-5	B/4-5	B/4-5	B/4-5	C/2,5-3	**Anschnitt / Gangzahl** Chamfer form / No. of threads
					Schneidrichtung Cutting direction
HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	**Schneidstoff/** Material

6700	6700 VP	6700 XP	6702	6818	Ø mm	Gg/1" Tpi	Gg/1" Tpi	Kernloch Ø Tap drill Ø
●	●	●	●	●	G 1/16	28	6,80	7,3
●	●	●	●	●	G 1/8	28	8,80	9,3
●	●	●	●	●	G 1/4	19	11,80	12,5
●	●	●	●	●	G 3/8	19	15,25	16,0
●	●	●	●	●	G 1/2	14	20,10	20,1
●	●	●	-	-	G 5/8	14	21,00	-
●	●	●	-	-	G 3/4	14	24,50	-
●	●	●	-	-	G 7/8	14	28,25	-
●	●	●	-	-	G 1	11	30,75	-
-	-	-	-	-	G 1 1/8	11	35,50	-
-	-	-	-	-	G 1 1/4	11	39,50	-
-	-	-	-	-	G 1 1/2	11	45,00	-
-	-	-	-	-	G 1 3/4	11	51,00	-
-	-	-	-	-	G 2	11	57,00	-

VAP: **vaporisiert**
vaporized

VA: **Für rostfreien Stahl**
for stainless steel

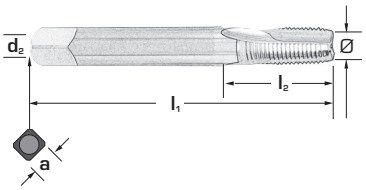
Former S: **mit Schmiernuten**
with coolant grooves

● Standardartikel / Items available ex stock

DIN 5156 - BSPT (Rc)

Maschinen-Gewindebohrer mit Überlaufschaft
für konisches Rohrgewinde BSPT (Rc), Kegel 1 : 16
Machine taps with reduced shank
for British standard Pipe thread BSPT (Rc), taper 1:16

RC



Typ / Type									N 0°
Toleranz Tolerance									-
Anschnitt / Gangzahl Chamfer form / No. of threads									C/2,5-3
Schneidrichtung Cutting direction									
Schneidstoff/ Material									HSS-Co
Ø mm		**Gg/1"** Tpi	**Kernloch Ø** Tap drill Ø	**l_1** mm	**l_2** mm	**d_2** mm h9	**a** h12		**6790**
RC	1/8	28	8,2	90	13	10	8,0		●
RC	1/4	19	11,0	100	20	14	11,0		●
RC	3/8	19	14,0	110	20	14	11,0		●
RC	1/2	14	18,0	140	25	16	12,0		●
RC	3/4	14	23,5	150	26	20	16,0		●
RC	1	11	29,5	170	32	25	20,0		●

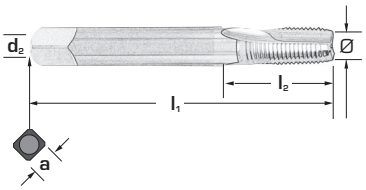
N: **Herkömmliche Anwendung**
universal application

● Standardartikel / Items available ex stock

ILIX NORM - NPT, NPTF

NPT (National Pipe Taper USA, Normalausführung)
NPTF (Dryseal National Pipe Taper USA)
kegeliges Rohrgewinde 1 : 16 – Flankenwinkel 60°
NPT thread (National Pipe Taper USA, standard range)
NPTF thread (Dryseal National Pipe Taper USA)
tapered pipe thread 1 : 16 – included angle 60°
dimensions generally as per DIN 371

NPT NPTF



Typ / Type								N NPT	N NPTF	VA/AZ NPT
Toleranz Tolerance								-	-	-
Anschnitt / Gangzahl Chamfer form / No. of threads								C/2,5-3	C/2,5-3	C/2,5-3
Schneidrichtung Cutting direction										
Schneidstoff/ Material								HSS-Co	HSS-Co	HSS-Co
Nennweite des Rohres in Zoll Size of pipe in inch		**Gg/1"** Tpi	**Kernloch Ø** Tap drill Ø	**l_1** mm	**l_2** mm	**d_2** mm h9	**a** h12	**6610**	**6611**	**6916**
NPT/NPTF	1/16	27	6,30	56	14	7	5,5	●	●	●
NPT/NPTF	1/8	27	8,50	63	15	8	6,2	●	●	●
NPT/NPTF	1/4	18	11,10	70	21	11	9,0	●	●	●
NPT/NPTF	3/8	18	14,50	70	21	12	9,0	●	●	●
NPT/NPTF	1/2	14	17,75	80	27	16	12,0	●	●	●
NPT/NPTF	3/4	14	23,00	100	27	20	16,0	●	●	●
NPT/NPTF	1	11,5	29,00	125	32	25	20,0	●	●	●
NPT/NPTF	1 1/4	11,5	38,00	125	33	32	24,0	●	●	●
NPT/NPTF	1 1/2	11,5	44,00	140	33	36	29,0	●	●	●
NPT/NPTF	2	11,5	56,00	140	44	36	29,0	●	-	●

NPT: **für Gewinde mit Dichtmittel**
for threads with dryseal

NPTF: **für Gewinde ohne Dichtmittel**
for threads without dryseal

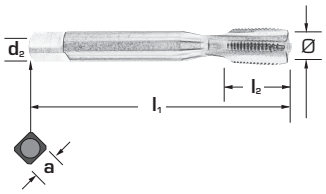
Kegelreibhale für NPT/NPTF Gewinde auf der Seite 699
Taper pin reamer for NPT/NPTF thread on the page 699

● Standardartikel / Items available ex stock

ILIX NORM - NPT, NPTF

NPT (National Pipe Taper USA, Normalausführung)
NPTF (Dryseal National Pipe Taper USA)
kegeliges Rohrgewinde 1 : 16 – Flankenwinkel 60°
NPT thread (National Pipe Taper USA, standard range)
NPTF thread (Dryseal National Pipe Taper USA)
tapered pipe thread 1 : 16 – included angle 60°
dimensions generally as per DIN 371

NPT NPTF TiN



								6917	6917 TN	6923	6919	6921	6921 TN	6925
Typ / Type								HD NPT 0°	HD NPT 0°	HD NPTF 0°	VA/AZ NPT 0°	VA/AZ NPT 35°	VA/AZ NPT 35°	VA NPTF 35°
Toleranz Tolerance								-	-	-	-	-	-	-
Anschnitt / Gangzahl Chamfer form / No. of threads								C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3
Schneidrichtung Cutting direction														
Schneidstoff/ Material								HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co
Nennweite des Rohres in Zoll Size of pipe in inch		**Gg/1"** Tpi	**Kernloch Ø** Tap drill Ø	**l_1** mm	**l_2** mm	**d_2** mm h9	**a** h12							
NPT/NPTF	**1/16**	27	6,3	90	13	8	6,2	●	●	●	●	●	●	●
NPT/NPTF	**1/8**	27	8,5	90	13	10	8,0	●	●	●	●	●	●	●
NPT/NPTF	**1/4**	18	11,1	100	20	14	11,0	●	●	●	●	●	●	●

NPT: **für Gewinde mit Dichtmittel**
for threads with dryseal

NPTF: **für Gewinde ohne Dichtmittel**
for threads without dryseal

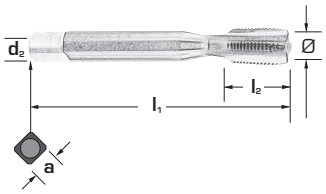
Kegelreibhale für NPT/NPTF Gewinde auf der Seite 699
Taper pin reamer for NPT/NPTF thread on the page 699

● Standardartikel / Items available ex stock

ILIX NORM - NPT, NPTF

NPT (National Pipe Taper USA, Normalausführung)
NPTF (Dryseal National Pipe Taper USA)
kegeliges Rohrgewinde 1 : 16 – Flankenwinkel 60°
NPT thread (National Pipe Taper USA, standard range)
NPTF thread (Dryseal National Pipe Taper USA)
tapered pipe thread 1 : 16 – included angle 60°
dimensions generally as per DIN 371

NPT NPTF



Typ / Type								**HD** NPT 0°	**HD** NPTF 0°	**VA/AZ** NPT 0°	**VA/AZ** NPT 35°	**VA** NPTF 35°
Toleranz Tolerance								-	-	-	-	-
Anschnitt / Gangzahl Chamfer form / No. of threads								C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3
Schneidrichtung Cutting direction												
Schneidstoff/ Material								HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co
Nennweite des Rohres in Zoll Size of pipe in inch		**Gg/1"** Tpi	**Kernloch Ø** Tap drill Ø	**l_1** mm	**l_2** mm	**d_2** mm h9	**a** h12	**6918**	**6924**	**6920**	**6922**	**6926**
NPT/NPTF	3/8	18,0	14,50	110	20	14	11,0	●	●	●	●	●
NPT/NPTF	1/2	14,0	17,75	140	25	16	12,0	●	●	●	●	●
NPT/NPTF	3/4	14,0	23,00	150	26	20	16,0	●	●	●	●	●
NPT/NPTF	1	11,5	29,00	170	32	25	20,0	●	●	●	●	●
NPT/NPTF	1 1/4	11,5	38,00	190	34	32	24,0	●	●	●	●	●
NPT/NPTF	1 1/2	11,5	44,00	200	34	36	29,0	●	●	●	●	●

NPT: **für Gewinde mit Dichtmittel**
for threads with dryseal

NPTF: **für Gewinde ohne Dichtmittel**
for threads without dryseal

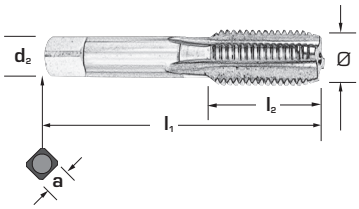
Kegelreibhale für NPT/NPTF Gewinde auf der Seite 699
Taper pin reamer for NPT/NPTF thread on the page 699

● Standardartikel / Items available ex stock

DIN 40432 - (Pg)

Gewindebohrer für Stahlpanzerrohr-Gewinde nach DIN 40430
Flankenwinkel 80° - Einzelschneider für Hand- und Maschinengebrauc
Machine taps for steel conduit pipe thread as per DIN 40430
included angle 80° - on machine and power tools

PG



Typ / Type	N Pg	N Pg
Toleranz Tolerance	-	-
Anschnitt / Gangzahl Chamfer form / No. of threads	C/2,5-3	B/4-5
Schneidrichtung Cutting direction		
Schneidstoff/ Material	HSS-Co	HSS-Co

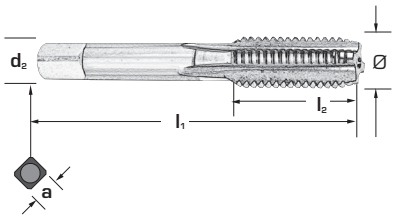
Gewinde-bezeichnung Size	Ø mm	Gg/1" Tpi	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a h12	6915	6710
PG	7,0	12,5	20	11,50	70	22	9	7,0	●	●
PG	9,0	15,2	18	14,00	70	22	12	9,0	●	●
PG	11,0	18,6	18	17,25	80	22	14	11,0	●	●
PG	13,5	20,4	18	19,00	80	22	16	12,0	●	●
PG	16,0	22,5	18	21,25	80	22	18	14,5	●	●
PG	21,0	28,3	16	27,00	90	22	22	18,0	●	●
PG	29,0	37,0	16	35,50	100	25	28	22,0	●	●
PG	36,0	47,0	16	45,50	140	40	36	29,0	●	●
PG	42,0	54,0	16	52,50	140	40	40	32,0	●	●
PG	48,0	59,3	16	58,00	160	40	45	35,0	●	●

● Standardartikel / Items available ex stock

DIN 40433 - (Pg)

Gewindebohrer für Stahlpanzerrohr-Gewinde nach DIN 40430
Flankenwinkel 80° - Einzelschneider für Hand- und Maschinengebrauc
Machine taps for steel conduit pipe thread as per DIN 40430
included angle 80° - on machine and power tools

PG



Typ / Type	N / Pg
Toleranz Tolerance	-
Anschnitt / Gangzahl Chamfer form / No. of threads	D/4-5
Schneidrichtung Cutting direction	
Schneidstoff/ Material	HSS-Co

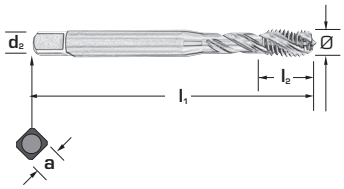
Gewinde-bezeichnung Size		Ø mm	Gg/1" Tpi	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a h12	6914
PG	**7,0**	12,5	20	11,50	100	20	9	7,0	●
PG	**9,0**	15,2	18	14,00	100	20	12	9,0	●
PG	**11,0**	18,6	18	17,25	110	22	14	11,0	●
PG	**13,5**	20,4	18	19,00	125	22	16	12,0	●
PG	**16,0**	22,5	18	21,25	125	25	18	14,5	●
PG	**21,0**	28,3	16	27,00	150	28	22	18,0	●
PG	**29,0**	37,0	16	35,50	170	28	28	22,0	●
PG	**36,0**	47,0	16	45,50	190	32	36	29,0	●

● Standardartikel / Items available ex stock

DIN 8140 - EGM

Maschinen-Gewindebohrer
für Gewindedrahteinsätze
für Metrisches ISO-Gewinde
Machine taps for wire thread inserts
for metric ISO thread

EGM



Typ / Type	N 40°
Toleranz Tolerance	6 H Mod
Anschnitt / Gangzahl Chamfer form / No. of threads	C/2,5-3
Schneidrichtung Cutting direction	
Schneidstoff/ Material	HSS-Co

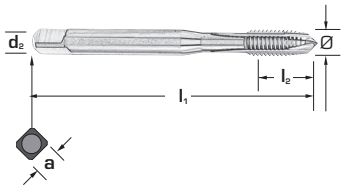
Gewinde-bezeichnung Size		Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a h12	6910
EG M	3	0,50	3,2	63	5	4,5	3,4	●
EG M	4	0,70	4,2	70	7	6,0	4,9	●
EG M	5	0,80	5,2	80	8	6,0	4,9	●
EG M	6	1,00	6,3	90	10	8,0	6,2	●
EG M	8	1,25	8,4	100	12	10,0	8,0	●

● Standardartikel / Items available ex stock

DIN 8140 - EGM

Maschinen-Gewindebohrer
für Gewindedrahteinsätze
für Metrisches ISO-Gewinde
Machine taps for wire thread inserts
for metric ISO thread

EGM



Typ / Type	N
Toleranz Tolerance	6 H Mod
Anschnitt / Gangzahl Chamfer form / No. of threads	B/4-5
Schneidrichtung Cutting direction	
Schneidstoff/ Material	HSS-Co

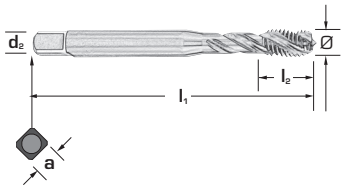
Gewinde-bezeichnung Size		Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a h12	6908
EG M	3	0,50	3,2	63	5	4,5	3,4	●
EG M	4	0,70	4,2	70	7	6,0	4,9	●
EG M	5	0,80	5,2	80	8	6,0	4,9	●
EG M	6	1,00	6,3	90	10	8,0	6,2	●
EG M	8	1,25	8,4	100	12	10,0	8,0	●

● Standardartikel / Items available ex stock

DIN 8140 - EGM

Maschinen-Gewindebohrer
für Gewindedrahteinsätze
für Metrisches ISO-Gewinde DIN 376
Machine taps for wire thread inserts
for metric ISO thread

EGM



Typ / Type	N 40°
Toleranz Tolerance	6 H Mod
Anschnitt / Gangzahl Chamfer form / No. of threads	C/2,5-3
Schneidrichtung Cutting direction	
Schneidstoff/ Material	HSS-Co

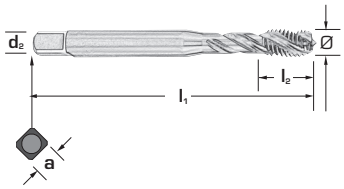
Gewinde-bezeichnung Size	Ø mm	Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a h12	6911
EG M	10	1,50	10,5	110	14	9	7	●
EG M	12	1,75	12,5	110	16	11	9	●
EG M	16	2,00	16,5	125	20	14	11	●

● Standardartikel / Items available ex stock

DIN 8140 - EGM

Maschinen-Gewindebohrer
für Gewindedrahteinsätze
für Metrisches ISO-Gewinde DIN 376
Machine taps for wire thread inserts
for metric ISO thread

EGM



Typ / Type	N 40°
Toleranz Tolerance	6 H Mod
Anschnitt / Gangzahl Chamfer form / No. of threads	B/4-5
Schneidrichtung Cutting direction	
Schneidstoff/ Material	HSS-Co

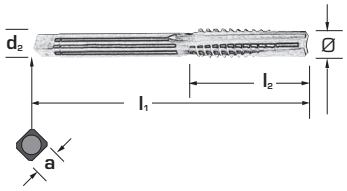
Gewinde-bezeichnung Size	Ø mm	Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a h12	6909
EG M	10	1,50	10,5	110	14	9	7	●
EG M	12	1,75	12,5	110	16	11	9	●
EG M	16	2,00	16,5	125	20	14	11	●

● Standardartikel / Items available ex stock

ILIX NORM - TR

Hand-Gewindebohrer, dreiteiliger Satz
für Metrisches ISO-Trapez-Regelgewinde
Hand taps, serial, in sets of 2/3 pieces
for ISO metric trapezoidal coarse thread

TR



Typ / Type	N	N	N
Toleranz Tolerance	7 H	7 H	7 H
Anschnitt / Gangzahl Chamfer form / No. of threads	A/5-6	D/3-4	C/2,5-3
Schneidrichtung Cutting direction			
Schneidstoff/ Material	HSS-Co	HSS-Co	HSS-Co

Gewinde-bezeichnung Size	Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a h12	6937 V	6937 M	6937 F
							Einzel single tap		Satz set
TR 10*	2	8,20	110	70	7,1	5,6	●		●
TR 12	3	9,25	160	102	8,0	6,3	●		●
TR 14	3	11,25	160	102	9,0	7,1	●		●
TR 16	4	12,25	220	136	11,2	9,0	●		●
TR 18	4	14,25	220	136	12,5	10,0	●		●
TR 20	4	16,25	220	136	14,0	11,2	●		●
TR 22	5	17,25	275	166	16,0	12,5	●		●
TR 24	5	19,25	275	166	16,0	12,5	●		●
TR 26	5	21,25	290	170	18,0	14,0	●		●
TR 28	5	23,25	290	170	18,0	14,0	●		●
TR 30	6	24,25	345	200	22,4	18,0	●		●

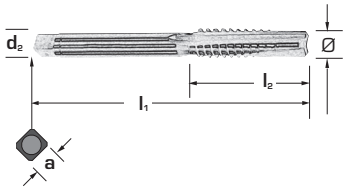
TR: **für Trapezgewinde**
for trapezoidal thread

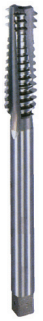
● Standardartikel / Items available ex stock - * 2 pezzi / 2 Pieces

ILIX NORM - TR

Maschinen-Gewindebohrer
für Metrisches ISO-Trapez-Regelgewinde
Machine taps
for ISO metric trapezoidal coarse thread

TR





Typ / Type	N
Toleranz Tolerance	7 H
Anschnitt / Gangzahl Chamfer form / No. of threads	-
Schneidrichtung Cutting direction	
Schneidstoff/ Material	HSS-Co

Gewinde-bezeichnung Size	Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a h12	6938
TR 10	2	8,20	116	76	7,1	5,6	●
TR 12	2	10,20	126	76	8,0	6,3	●
TR 12	3	9,25	175	115	8,0	6,3	●
TR 14	2	12,20	126	76	9,0	7,1	●
TR 14	3	11,25	175	115	9,0	7,1	●
TR 16	4	12,25	235	150	11,2	9,0	●
TR 18	4	14,25	235	150	12,5	10,0	●
TR 20	4	16,25	235	150	14,0	11,2	●
TR 22	5	17,25	290	180	16,0	12,5	●
TR 24	5	19,25	290	180	16,0	12,5	●
TR 26	5	21,25	300	180	18,0	14,0	●
TR 28	5	23,25	300	180	18,0	14,0	●
TR 30	6	24,25	380	235	22,4	18,0	●
TR 32	6	26,25	380	235	22,4	18,0	●
TR 34	6	28,25	390	240	25,0	20,0	●
TR 36	6	30,25	390	240	25,0	20,0	●

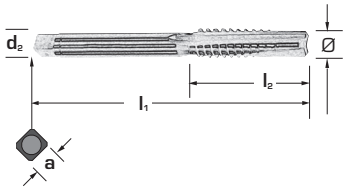
TR: für Trapezgewinde
for trapezoidal thread

● Standardartikel / Items available ex stock

ILIX NORM - TR

Maschinen-Gewindebohrer
für Metrisches ISO-Trapez-Regelgewinde
Machine taps
for ISO metric trapezoidal coarse thread

TR



Typ / Type	N Sx
Toleranz Tolerance	7 H
Anschnitt / Gangzahl Chamfer form / No. of threads	-
Schneidrichtung Cutting direction	
Schneidstoff/ Material	HSS-Co

Gewinde-bezeichnung Size	Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a h12	6939
TR 10	2	8,20	116	76	7,1	5,6	●
TR 12	2	10,20	126	76	8,0	6,3	●
TR 12	3	9,25	175	115	8,0	6,3	●
TR 14	2	12,20	126	76	9,0	7,1	●
TR 14	3	11,25	175	115	9,0	7,1	●
TR 16	4	12,25	235	150	11,2	9,0	●
TR 18	4	14,25	235	150	12,5	10,0	●
TR 20	4	16,25	235	150	14,0	11,2	●
TR 22	5	17,25	290	180	16,0	12,5	●
TR 24	5	19,25	290	180	16,0	12,5	●
TR 26	5	21,25	300	180	18,0	14,0	●
TR 28	5	23,25	300	180	18,0	14,0	●
TR 30	6	24,25	380	235	22,4	18,0	●
TR 32	6	26,25	380	235	22,4	18,0	●
TR 34	6	28,25	390	240	25,0	20,0	●
TR 36	6	30,25	390	240	25,0	20,0	●

TR: für Trapezgewinde
for trapezoidal thread

● Standardartikel / Items available ex stock

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Gewindebohrer
Taps

▶ Technische Daten
Technical Guide

TECHNISCHE DATEN
TECHNICAL DATA


	Typ / Type	**RAPID**		**RAPID 2**
	ILIX Typ-siehe Seite / ILIX type - see page	476		478
	Werkstoff / Material	HSS-Co		HSS-Co
	Anwendung / Application	Durchgangsloch Through Hole		Durchgangsloch Through Hole
	Anschnitt - Drallwinkel / Chamfer - Flute angle	B 0°		B 0°
	Gewindetiefe / Threding deep	2xD		2xD
	Beschichtung / Coating	BL/VP	TN / TC	BL
	Innenliegende Kühlkanäle / Internal Coolant	-		-
M	**4H**	6707/6711		-
	6H/6HX	6707/6711		6640
	6G/6GX	6707/6711		6640
	7G	6707/6711		-
	6H+0,1	-		-
MF	**6H/6HX**	6730		-
	6G/6GX	-		-
	6H+0,1	-		-
UNC	**2B/2BX**	6690/6693		-
	3B/3BX	6690/6693		-
UNF	**2B/2BX**	6607/6687		-
	3B/3BX	6607/6687		-
8-UN	**2B**	-		-
BSP/G	**G**	6704		-
RP (BSPP)	**Rp**	6673		-
RC (BSPT)	**Rc**	-		-
BSW-W	**BSW**	6697/6636		-
NPT	**NPT**	-		-
NPTF	**NPTF**	-		-
		Vc	**Vc**	**Vc**
P	**< 800 N/mm²**	15	18	-
	700-1000 N/mm²	10	13	-
	1000-1300 N/mm²	6	8	-
M	**Austenitisch**	6	10	-
	Austenitisch / ferritisch	-	7	-
K	**GG**	10	13	-
	GGG	5	8	-
N	**Aluminium**	15	20	15
	NE-Metalle	10	15	13
S	**Titan**	-	-	-
	Sonderlegierungen	-	-	-
H	**Gehärteter Stahl 38 / 48 HRC**	-	-	-
	Gehärteter Stahl 48 / 58 HRC	-	-	-
	Gehärteter Stahl 58 / 68 HRC	-	-	-

Die in der Tabelle dargestellten Schnittdaten sind nur gültig für optimale Maschine / Werkstück Bedingungen.
The cutting parameters shown in the table have to be considered valid in optimal machine/workpiece conditions

TECHNISCHE DATEN
TECHNICAL DATA

							
N		**N 15°**		**N 40°**		**MULTI GG i**	
478		482		484		492	
HSS-Co		HSS-Co		HSS-Co		HSS Co	
Sackloch / Blind Hole Durchgangsloch / Through Hole		Sackloch Blind Hole		Sackloch Blind Hole		Sackloch / Blind Hole Durchgangsloch / Through Hole	
C 0°		C 15°		C 40°		C 0°	
2xD		1,5xD		2,5xD		2,5xD	
BL	TN / TC	BL	TN / TC	BL/VP	TN / TC	VP	
-		-		-			
-		-		-		-	
6706/6705		6657/6658		6644/6638/6867/6868		6629/6637	
-		6657/6658		6644/6638		-	
-		-		6644/6638		-	
-		6903		-		-	
6726		6664		6652/6877		-	
-		-		-		-	
-		6904		-		-	
6823/6824		6696		6691/6694		-	
-		6728		6691/6694		-	
6838/6839		6719		6680/6688		-	
-		6729		6680/6688		-	
-		-		-		-	
-		6665		6703		-	
-		6675		-		-	
6790		-		-		-	
6699		-		6836/6837		-	
6610		-		-		-	
-		-		-		-	
Vc	**Vc**	**Vc**	**Vc**	**Vc**	**Vc**	**Vc**	
-	-	15	18	15	18	-	
10	13	10	13	10	13	-	
6	8	6	8	6	8	-	
-	-	-	8	-	8	-	
-	-	-	5	-	5	-	
10	13	10	13	10	13	30	
-	-	5	8	5	8	35	
15	20	15	20	15	20	30	
10	15	10	15	10	15	-	
-	-	-	-	-	-	-	
-	-	-	-	-	-	-	
-	-	-	-	-	-	-	
-	-	-	-	-	-	-	
-	-	-	-	-	-	-	

TECHNISCHE DATEN
TECHNICAL DATA


	Typ / Type	**VA**		**VA**	
	ILIX Typ-siehe Seite / ILIX type - see page	486		486	
	Werkstoff / Material	HSS-Co		HSS-Co	
	Anwendung / Application	Durchgangsloch Through Hole		Sackloch Blind Hole	
	Anschnitt - Drallwinkel / Chamfer - Flute angle	B		C 15°	
	Gewindetiefe / Threding deep	2xD		1,5xD	
	Beschichtung / Coating	BL/VP	TN / XT/XTP	BL/VP	TN / XT/XTP
	Innenliegende Kühlkanäle / Internal Coolant	-		-	
M	**4H**	-		-	
	6H/6HX	6646/6647		6654/6634	
	6G/6GX	6646/6647		-	
	7G	-		-	
	6H+0,1	-		-	
MF	**6H/6HX**	6663		6671	
	6G/6GX	6663		-	
	6H+0,1	-		-	
UNC	**2B/2BX**	6739/6749		-	
	3B/3BX	–		-	
UNF	**2B/2BX**	6718/6797		-	
	3B/3BX	–		-	
8-UN	**2B**	-		-	
BSP/G	**G**	6700		6716	
RP (BSPP)	**Rp**	–		-	
RC (BSPT)	**Rc**	-		-	
BSW-W	**BSW**	-		-	
NPT	**NPT**	-		-	
NPTF	**NPTF**	-		-	
		Vc	**Vc**	**Vc**	**Vc**
P	**< 800 N/mm²**	15	18	13	15
	700-1000 N/mm²	-	-	-	-
	1000-1300 N/mm²	-	-	-	-
M	**Austenitisch**	6	10	10	12
	Austenitisch / ferritisch	5	7	8	10
K	**GG**	-	-	-	-
	GGG	-	-	-	-
N	**Aluminium**	-	-	-	-
	NE-Metalle	10	15	11	13
S	**Titan**	3	5	3	5
	Sonderlegierungen	2	4	2	4
H	**Gehärteter Stahl 38 / 48 HRC**	-	-	-	-
	Gehärteter Stahl 48 / 58 HRC	-	-	-	-
	Gehärteter Stahl 58 / 68 HRC	-	-	-	-

Die in der Tabelle dargestellten Schnittdaten sind nur gültig für optimale Maschine / Werkstück Bedingungen.
The cutting parameters shown in the table have to be considered valid in optimal machine/workpiece conditions

TECHNISCHE DATEN
TECHNICAL DATA


VA		VA i			
486		488			
HSS-Co		HSS-Co			
Sackloch Blind Hole		Sackloch Blind Hole			
C 40°		C 15°			
2xD		2,5xD			
BL / VP	TN / XT/XTP	BL	XTP		
-		-			
-		-			
6661/6662		6620/6605			
6661/6662		–			
-		-			
-		-			
6655		6626			
6655		-			
-		–			
6735/6754		–			
-		–			
6794/6796		–			
-		–			
6945		-			
6701		–			
-		–			
–		–			
–		–			
–		–			
–		–			
Vc	**Vc**	**Vc**	**Vc**		
13	15	15	17		
-	-	12	15		
-	-	-	-		
10	12	15	15		
8	8	8	10		
-	-	-	-		
-	-	-	-		
-	-	-	-		
11	13	13	15		
3	5	4	6		
2	4	3	5		
-	-	-	-		
-	-	-	-		
-	-	-	-		

TECHNISCHE DATEN
TECHNICAL DATA


	Typ / Type	**HD**		**HD**	
	ILIX Typ-siehe Seite / ILIX type - see page	490		490	
	Werkstoff / Material	HSS-Co		HSS-Co	
	Anwendung / Application	Durchgangsloch Through Hole		Sackloch Blind Hole	
	Anschnitt - Drallwinkel / Chamfer - Flute angle	B		C 15°	
	Gewindetiefe / Threding deep	2xD		1,5xD	
	Beschichtung / Coating	BL/VP	TN / TF	BL	HL
	Innenliegende Kühlkanäle / Internal Coolant	-		-	
M	**4H**	-		-	
	6H/6HX	6870/6871		6878/6879	
	6G/6GX	–		-	
	7G	-		-	
	6H+0,1	-		-	
MF	**6H/6HX**	6872		6880	
	6G/6GX	–		-	
	6H+0,1	-		-	
UNC	**2B/2BX**	6873/6874		6865/6866	
	3B/3BX	–		-	
UNF	**2B/2BX**	6875/6876		6848/6849	
	3B/3BX	–		-	
8-UN	**2B**	-		-	
BSP/G	**G**	6912		–	
RP (BSPP)	**Rp**	–		-	
RC (BSPT)	**Rc**	-		-	
BSW-W	**BSW**	-		-	
NPT	**NPT**	6917/6918		6917/6918	
NPTF	**NPTF**	6923/6924		6923/6924	
		Vc	**Vc**	**Vc**	**Vc**
P	**< 800 N/mm²**	15	18	13	15
	700-1000 N/mm²	10	13	10	12
	1000-1300 N/mm²	6	8	6	8
M	**Austenitisch**	-	-	-	-
	Austenitisch / ferritisch	-	-	-	-
K	**GG**	-	-	-	-
	GGG	10	10	10	10
N	**Aluminium**	-	-	-	-
	NE-Metalle	-	-	-	-
S	**Titan**	-	-	-	-
	Sonderlegierungen	-	-	-	-
H	**Gehärteter Stahl 38 / 48 HRC**	-	-	-	3
	Gehärteter Stahl 48 / 58 HRC	-	-	-	-
	Gehärteter Stahl 58 / 68 HRC	-	-	-	-

Die in der Tabelle dargestellten Schnittdaten sind nur gültig für optimale Maschine / Werkstück Bedingungen.
The cutting parameters shown in the table have to be considered valid in optimal machine/workpiece conditions

TECHNISCHE DATEN
TECHNICAL DATA

	HD		HR		VR 50°		GG	
	490		492		488		492	
	HSS-Co		HSS-Co		HSS-Co		HSS-Co	
	Sackloch Blind Hole		Sackloch Blind Hole		Sackloch Blind Hole		Sackloch / Blind Hole Durchgangsloch / Through Hole	
	C 40°		C 40°		C 50°		C 0°	
	2,5xD		2,5xD		3xD		2,5xD	
	BL	TN / TF	BL	TF	VP	TN	VP	TF
	-		-		-		-	
	-				-		-	
	6666/6667		6681/6689		6850/6851		6631/6632	
	–				-		-	
	-		-		-		-	
	-		-		-		-	
	–		–		-		6653	
	–		-		-		-	
	-		–		-		-	
	–		–		6852/6853		-	
	-		–		-		-	
	–		–		6854/6855		-	
	-		–		-		-	
	–		-		-		-	
	–		–		6856		6708	
	-		–		-		6674	
	–		–		-		-	
	–		–		-		-	
	–		–		-		-	
	–		–				-	
	Vc	Vc	Vc	Vc	Vc	Vc	Vc	Vc
	13	15	13	15	13	15	-	-
	10	12	10	12	-	-	-	-
	6	8	8	10	-	-	-	-
	-	-	-	-	10	12	-	-
	-	-	-	-	8	10	-	-
	-	-	-	-	-	-	25	30
	10	10	-	-	-	-	20	25
	-	-	-	-	-	-	-	-
	-	-	-	-	-	-	-	-
	-	-	-	-	-	-	-	-
	-	-	-	-	-	-	-	-
	-	-	-	-	-	-	-	-
	-	-	-	-	-	-	-	-
	-	-	-	-	-	-	-	-

TECHNISCHE DATEN
TECHNICAL DATA


	Typ / Type		**AZ**	
	ILIX Typ-siehe Seite / ILIX type - see page		494	
	Werkstoff / Material		HSS-Co	
	Anwendung / Application		Durchgangsloch Through Hole	Sackloch Blind Hole
	Anschnitt - Drallwinkel / Chamfer - Flute angle		B 0°	C 0°
	Gewindetiefe / Threding deep		2,5xD	2,5xD
	Beschichtung / Coating		BL	BL
	Innenliegende Kühlkanäle / Internal Coolant		-	-
M	**4H**		-	-
	6H/6HX		6616/6617	6820/6821
	6G/6GX		-	-
	7G		-	-
	6H+0,1		-	-
MF	**6H/6HX**		-	-
	6G/6GX		-	-
	6H+0,1		-	-
UNC	**2B/2BX**		-	-
	3B/3BX		-	-
UNF	**2B/2BX**		-	-
	3B/3BX		-	-
8-UN	**2B**		-	-
BSP/G	**G**		-	-
RP (BSPP)	**Rp**		-	-
RC (BSPT)	**Rc**		-	-
BSW-W	**BSW**		-	-
NPT	**NPT**		-	6916/6919/6920
NPTF	**NPTF**		-	-
			Vc	**Vc**	**Vc**
P	**< 800 N/mm²**		15	15	18
	700-1000 N/mm²		-	-	-
	1000-1300 N/mm²		-	-	-
M	**Austenitisch**		6	6	10
	Austenitisch / ferritisch		-	-	-
K	**GG**		-	-	-
	GGG		-	-	-
N	**Aluminium**		15	15	20
	NE-Metalle		10	10	15
S	**Titan**		-	-	-
	Sonderlegierungen		-	-	-
H	**Gehärteter Stahl 38 / 48 HRC**		-	-	-
	Gehärteter Stahl 48 / 58 HRC		-	-	-
	Gehärteter Stahl 58 / 68 HRC		-	-	-

Die in der Tabelle dargestellten Schnittdaten sind nur gültig für optimale Maschine / Werkstück Bedingungen.
The cutting parameters shown in the table have to be considered valid in optimal machine/workpiece conditions

TECHNISCHE DATEN
TECHNICAL DATA




AZ		ALU		BAK
494		494		496
HSS-Co		HSS-Co		HSS-Co
Sackloch Blind Hole		Durchgangsloch Through Hole	Sackloch Blind Hole	Sackloch / Blind Hole Durchgangsloch / Through Hole
C 40°		B 0°	C 40°	E 0°
2,5xD		2,5xD	2,5xD	2,5xD
BL	TN	BL	BL	VP
-		-	-	-
-		-	-	-
-		6641/6642	6643/6651	6770
-		-	-	-
-		-	-	-
-		-	-	-
-		-	6731	-
-		-	-	-
-		-	-	-
-		-	6732/6733	-
-		-	-	-
-		-	6628/6734	-
-		-	-	-
-		-	-	-
-		-	-	-
-		-	-	-
-		-	-	-
-		-	-	-
6921/6922		-	-	-
6925/6926		-	-	-
Vc	Vc	Vc	Vc	Vc
15	18	-	-	-
-	-	-	-	-
-	-	-	-	-
6	10	-	-	-
-	-	-	-	-
-	-	-	-	-
-	-	-	-	-
15	20	25	25	-
10	15	15	15	15
-	-	-	-	-
-	-	-	-	-
-	-	-	-	-
-	-	-	-	-
-	-	-	-	-

TECHNISCHE DATEN
TECHNICAL DATA


	Typ / Type	**FORMER**		**FORMER S**	
	ILIX Typ-siehe Seite / ILIX type - see page	498		498	
	Werkstoff / Material	HSS-Co		HSS-Co	
	Anwendung / Application	Sackloch / Blind Hole Durchgangsloch / Through Hole		Sackloch / Blind Hole Durchgangsloch / Through Hole	
	Anschnitt - Drallwinkel / Chamfer - Flute angle	C		C	
	Gewindetiefe / Threding deep	2xD		2xD	
	Beschichtung / Coating	BL/VP	TN / TC	BL/VP	TN / TC
	Innenliegende Kühlkanäle / Internal Coolant	-		-	
M	**4H**	-		-	
	6H/6HX	6722/6723		6709/6725	
	6G/6GX	6622/6623		6808/6809	
	7G	-		6819	
	6H+0,1	-		-	
MF	**6H/6HX**	6721		6720	
	6G/6GX	-		-	
	6H+0,1	-		-	
UNC	**2B/2BX**	6738		6802/6811	
	3B/3BX	-		-	
UNF	**2B/2BX**	6747		6815/6816	
	3B/3BX	-		-	
8-UN	**2B**	-		-	
BSP/G	**G**	6702		6818	
RP (BSPP)	**Rp**	-		-	
RC (BSPT)	**Rc**	-		-	
BSW-W	**BSW**	-		-	
NPT	**NPT**	-		-	
NPTF	**NPTF**	-		-	
		Vc	**Fz**	**Vc**	**Fz**
P	**< 800 N/mm²**	13	15	15	17
	700-1000 N/mm²	11	13	13	15
	1000-1300 N/mm²	-	-	-	-
M	**Austenitisch**	8	10	10	12
	Austenitisch / ferritisch	-	-	-	-
K	**GG**	-	-	-	-
	GGG	-	-	-	-
N	**Aluminium**	20	25	25	30
	NE-Metalle	18	22	22	25
S	**Titan**	-	-	-	-
	Sonderlegierungen	-	-	-	-
H	**Gehärteter Stahl 38 / 48 HRC**	-	-	-	-
	Gehärteter Stahl 48 / 58 HRC	-	-	-	-
	Gehärteter Stahl 58 / 68 HRC	-	-	-	-

Die in der Tabelle dargestellten Schnittdaten sind nur gültig für optimale Maschine / Werkstück Bedingungen.
The cutting parameters shown in the table have to be considered valid in optimal machine/workpiece conditions