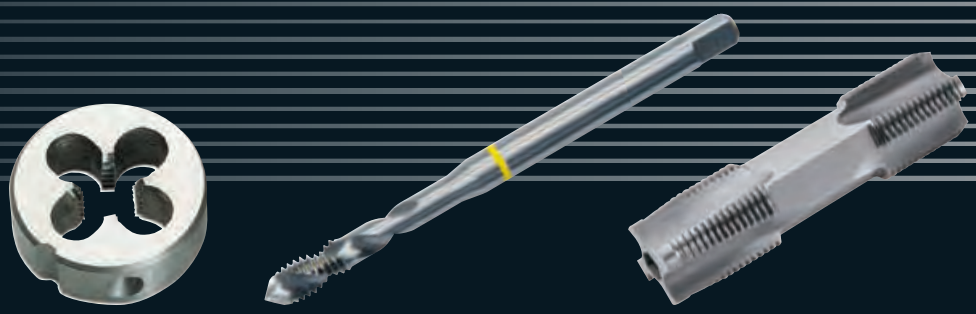
VÖLKEL

THREADING SOLUTIONS



VD 2016

VÖLKEL
THREADING SOLUTIONS

VÖLKEL GmbH
Morsbachtalstraße 18
D-42855 Remscheid

Postfach 15 01 28
D-42828 Remscheid

Telefon +49 2191 490112
Telefax +49 2191 490125

E-Mail: info@voelkel.com
Internet: www.voelkel.com

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

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

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

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

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

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

because available

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

- more than 7.000 articles available on a daily basis
- article in catalogue with an availability of more than 99 %
- dispatch of small orders on the same day
- special dimensions from 1 to 110 mm

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

- oltre 7000 prodotti subito disponibili
- disponibilità di magazzino di oltre il 99% di tutti gli articoli a catalogo
- spedizione in giornata
- misure piene e mezze da 1 mm a 110 mm

because reliable

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

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

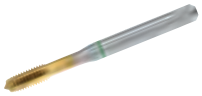
…poiché manteniamo le promesse e potete contare su una qualità e un servizio sempre costante

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

because you

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

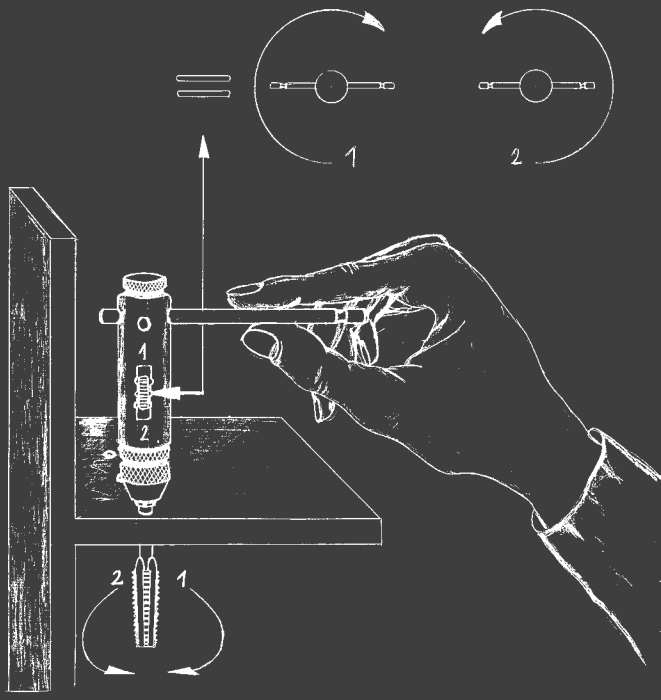
…poiché per noi siete il punto centrale e vi offriamo quindi una collaborazione completa ed efficiente.

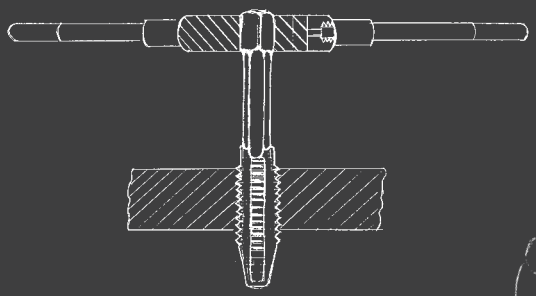
Die Stocks - Tap Wrenches **Porta-utensili**	**9 - 13**	
Hand Taps **Maschi a mano**	**14 - 43**	
Short Machine Taps **Maschi macchina corti**	**44 - 59**	
HexTap, Bits and Combined Taps **HexTap, utensili con attacco esagonale e maschi combinati con punte**	**60 - 73**	
Machine Taps **Maschi a macchina**	**74 - 128**	
Machine Taps with coloured ring **Maschi a macchina con collarini colorati**	**129 - 149**	
Fluteless (Forming) Taps **Maschi a rulare**	**150 - 156**	
Machine Nut Taps **Maschi a macchina per dadi**	**157 - 159**	
Round Dies and Hexagon Die Nuts **Filiere e filiere esagonali**	**161 - 202**	
Tap & Die Sets **Assortimento**	**203 - 228**	
Technical Information **Informazioni tecniche**	**229 - 242**	

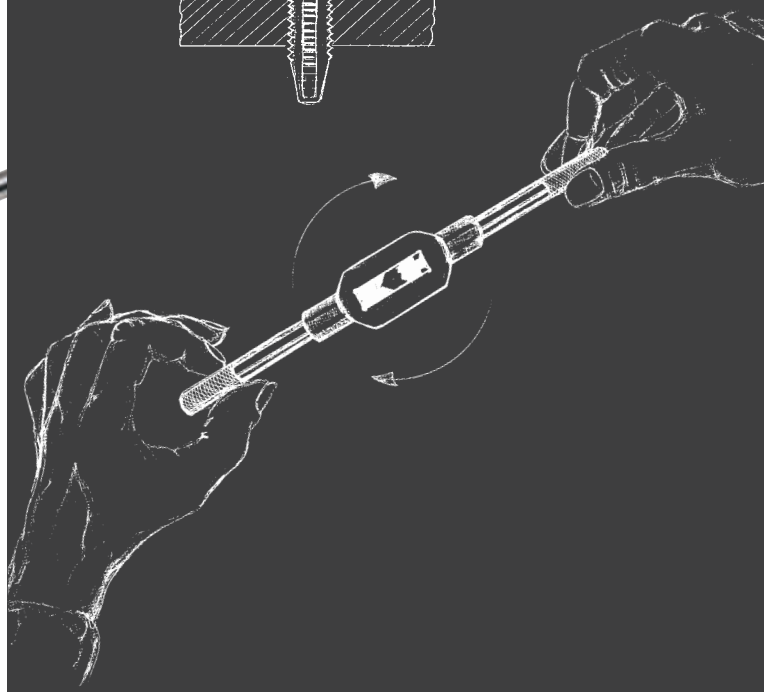
INDEX	M	MF	BSW	BSF	BA	W DIN 477	UNC	UNF	UNEF	UN UNS	UN-8	UN-12
Hand Taps Maschi a mano	16 35	20 37	26	27	28		29	30	31			
Hand Taps - LH Maschi a mano - LH	39	40	41				42	42				
Short Machine Taps Maschi macchina corti	46	49	50			50	51	51				
Combined Taps Maschi combinati con punte	69 73		73				70	70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

INDEX	G BSP	Rc BSPT	Rp BSPP	PG	Tr	NPT	NPTF	NPS	Rd	FG	BSC	Vg
Hand Taps Maschi a mano	32 38			33	34							
Hand Taps - LH Maschi a mano - LH	43											
Short Machine Taps Maschi macchina corti	52	53	54	55		56	58	59				
Combined Taps Maschi combinati con punte												
HexTap HexTap	68											
Machine Taps Maschi a macchina	110	113				114			115	116	117	118
Machine Taps - LH Maschi a macchina - LH	128											
Machine Taps with oversize Maschi a macchina - tolleranza maggiorata												
Machine Taps with coloured ring Maschi a macchina con collarini colorati	139 141											
Fluteless Taps Maschi a rulare												
Fluteless Taps with oversize - 6G Maschi a rulare – 6G												
Machine Nut Taps Maschi a macchina per dadi					159							
Round Dies Filiere	176 184	177		178		179	179			180	180	181
Round Dies - LH Filiere - LH	191											
Hexagon Die Nuts Filiere esagonali	198	199				200						
Hexagon Die Nuts - LH Filiere esagonali - LH	202											
Tap & Die Sets Assortimento	204 208					209						
INDEX	G BSP	Rc BSPT	Rp BSPP	PG	Tr	NPT	NPTF	NPS	Rd	FG	BSC	Vg

DIE STOCKS - TAP WRENCHES
PORTA-UTENSILI







DIE STOCKS - TAP WRENCHES
PORTA-UTENSILI

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

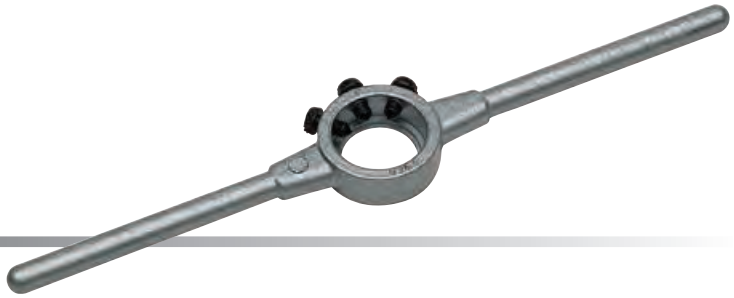
Tap Holder with Ratchet
for right- and left-hand-turn
all steel quality

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

No.	for Taps		Square mm	Length mm	Weight kg		Art.-No.	€
1	M 3-10	1/8-3/8	2.4-5.5	85	0,165	10	10001	8,00
2	M 5-12	7/32-1/2	4.5-8.0	100	0,310	10	10002	9,50
10	M 3-10	1/8-3/8	2.4-5.5	250	0,250	10	10010	13,00
20	M 5-12	7/32-1/2	4.5-8.0	300	0,440	10	10020	16,00
Jaws and Spring for No. 1 und 10						10	10091	1,35
Jaws and Spring for No. 2 und 20						10	10092	2,20

Die Stocks
Inch - with 3 screws

Portafiliere misura
pollice con 3 vite



Ø	mm	inch/pollice	Length mm	Weight kg		Art.-No.	€
13/16"	20.6 x 6.35	13/16 x 1/4	200	0,060	5	15520	3,00
1"	25.4 x 9.5	1" x 3/8	224	0,100	5	15525	3,10
1.5/16"	33.4 x 11.1	1.5/16 x 7/16	270	0,180	5	15533	4,60
1.1/2"	38.1 x 12.7	1.1/2 x 1/2	315	0,320	5	15538	8,70
2"	50.8 x 15.9	2" x 5/8	560	0,900	1	15550	13,80
2.1/4"	57.1 x 17.5	2.1/4 x 11/16	560	0,900	1	15557	13,80
2.1/2"	63.5 x 19.0	2.1/2 x 3/4	630	1,400	1	15563	21,50
3"	76.2 x 22.2	3" x 7/8	900	2,200	1	15576	48,50
3.1/2"	88.9 x 25.4	3.1/2" x 1"	900	3,300	1	15588	60,00
4"	101.6 x 25.4	4" x 1"	1000	3,600	1	15599	191,00

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

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

Ø x mm	for round Dies DIN 223 (DIN EN 22568)			Length mm	Weight kg		Art.-No.	€
16 x 5	M	1-2.6	BSW 1/16-3/32	160	0,050	5	15001	2,70
20 x 5	M	3-4	BSW 1/8-5/32	200	0,065	5	15002	2,80
20 x 7	M	4.5-6	BSW 3/16-1/4	200	0,065	5	15003	2,80
25 x 9	M	7-9	BSW 5/16	224	0,105	5	15004	3,20
30 x 11	M	10-11	BSW 3/8-7/16	280	0,190	5	15005	5,20
38 x 10	Mf	12-15	G 1/4	315	0,340	5	15006	8,10
38 x 14	M	12-14	BSW 1/2-9/16	315	0,340	5	15007	8,10
45 x 14	Mf	16-20	G 3/8-1/2	450	0,650	1	15008	9,90
45 x 18	M	16-20	BSW 5/8-13/16	450	0,650	1	15009	9,90
55 x 16	Mf	22-26	G 5/8-3/4	560	0,900	1	15010	12,70
55 x 22	M	22-24	BSW 7/8-1"	560	0,900	1	15011	12,70
65 x 18	Mf	27-36	G 7/8-1"	630	1,400	1	15012	21,40
65 x 25	M	27-36	BSW 1.1/8-1.3/8	630	1,400	1	15013	21,40

Die Stocks
DIN 225 (DIN EN 22568), STEEL

Portafiliere
DIN 225 (DIN EN 22568), esecuzione acciaio

Ø x mm	for round Dies DIN 223 (DIN EN 22568)		Length mm	Weight kg		Art.-No.	€
45 x 18	M 16-20	BSW 5/8-13/16	450	0,650	1	15209	16,20
55 x 22	M 22-24	BSW 7/8-1"	560	0,900	1	15211	23,10
65 x 25	M 27-36	BSW 1.1/8-1.3/8	630	1,400	1	15213	28,90
75 x 20	Mf 38-42	G 1.1/8-1.1/4	800	2,250	1	15214	48,50
75 x 30	M 38-42	BSW 1.1/2-1.5/8	800	2,100	1	15215	48,50
90 x 22	Mf 45-52	G 1.3/8-1.5/8	900	3,200	1	15216	60,00
90 x 36	M 45-52	BSW 1.3/4-2"	900	3,000	1	15217	60,00
105 x 22	Mf 54-63	G 1.3/4-2"	975	3,500	1	15218	91,50
105 x 36	M 54-63	BSW 2.1/4"-2.1/2"	975	3,500	1	15219	91,50
120 x 22	Mf 64-71	G 2.1/4-2.3/4	956	3,170	1	15220	237,00
120 x 36	M 64-71	BSW 2.3/4"	956	3,910	1	15221	237,00
130 x 25		G 3"	966	3,505	1	15222	329,00
130 x 36			966	4,025	1	15223	329,00
140 x 22			976	3,620	1	15224	413,00
150 x 25		G 3.1/2"	986	3,950	1	15226	470,00
160 x 25		G 4"	996	4,115	1	15228	645,00

Adjustable Tap Wrenches
DIN 1814 Zinc die cast

Giramaschi regolabili
DIN 1814, lega leggera

No.	for Taps			Square mm	Length mm	Weight kg		Art.-No.	€
0	M 1-8	1/16-1/4		2.0-5.0	130	0,050	5	13000	3,40
1	M 1-10	1/16-3/8	G 1/8	2.0-6.3	176	0,095	5	13010	3,70
1.1/2	M 1-12	1/16-1/2	G 1/8	2.1-8.0	176	0,120	5	13015	3,70
2	M 4-12	5/32-1/2	G 1/8	3.0-9.0	280	0,285	5	13020	6,00
3	M 5-20	7/32-3/4	G 1/8-1/2	4.9-12	380	0,660	1	13030	11,30
4	M 11-27	7/16-1"	G 1/4-3/4	5.5-16	505	1,500	1	13040	20,80
5 L	M 13-32	1/2 -1.1/4	G 1/4-1"	7-20	700	1,800	1	13050	32,00

Adjustable Tap Wrenches
DIN 1814, STEEL

Giramaschi regolabili
DIN 1814, esecuzione acciaio

No.	for Taps			Square mm	Length mm	Weight kg		Art.-No.	€
0	M 1-8	1/16-1/4		2.0-5.0	130	0,050	5	14000	5,00
1	M 1-10	1/16-3/8		2.0-6.3	176	0,100	5	14010	5,70
1.1/2	M 1-12	1/16-1/2	G 1/8	2.1-8.0	176	0,120	5	14015	5,70
2	M 4-12	5/32-1/2	G 1/8	3.0-9.0	280	0,285	5	14020	10,10
3	M 5-20	7/32-3/4	G 1/8-1/2	4.9-12	380	0,660	1	14030	16,00
4	M 11-27	7/16-1"	G 1/4-3/4	5.5-16	500	1,500	1	14040	30,00
5	M 13-32	1/2-1.1/4	G 1/4-1"	7-20	700	1,800	1	14050	47,00
6	M 18-42	3/4-1.1/2	G 1/2-1.1/4	11-24	1000	2,600	1	14060	55,00
7	M 27-52	1.1/8-2"	G 3/4-1.3/4	16-32	1250	4,500	1	14070	90,00
8	M 27-64	1.1/8"-3"	G 3/4-3"	16-40	1250	4,500	1	14080	230,00

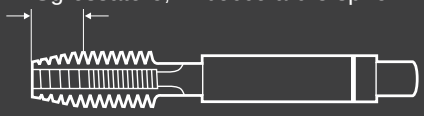
Tap Extensions
DIN 377, Squares according to DIN 10

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

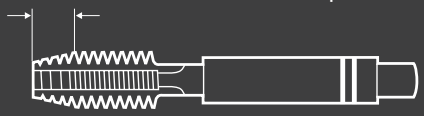
Square mm	L1	for DIN 352	Art.-No.	€
2.1	60	M 1-2.6	14521	2,80
2.4	70		14524	2,80
2.7	80	M 3	14527	2,80
3.0	90	M 3.5	14530	2,80
3.4	95	M 4	14534	2,80
3.8	100		14538	3,40
4.3	105		14543	4,00
4.9	110	M 4.5-8	14549	3,20
5.5	115	M 9-10	14555	3,60
6.2	120	M 11	14562	3,90
7.0	125	M 12	14570	4,80
8.0	125		14580	6,00
9.0	130	M 14-16	14590	6,60
10.0	140		14610	8,70
11.0	150	M 18	14611	10,50
12.0	155	M 20	14612	13,70
13.0	165		14613	15,50
14.5	175	M 22-24	14614	19,00
16.0	180	M 27	14616	20,00
18.0	200	M 30	14618	23,50
20.0	220	M 33	14620	30,00
22.0	220	M 36	14622	42,00
24.0	235	M 39-42	14624	54,00
26.0	250		14626	70,00
29.0	265	M 45-48	14629	82,00
32.0	285	M 52	14632	115,00

HAND TAPS
MASCHI A MANO

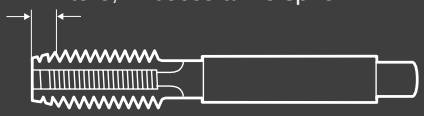
Nr. 1
Rougher, 6-8 Threads Lead
Sgrossatore, Imbocco a 6-8 spire



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

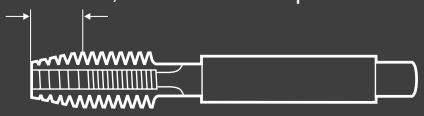


Nr. 3
Finisher, 2-3 Threads Lead
Finitore, Imbocco a 2-3 spire

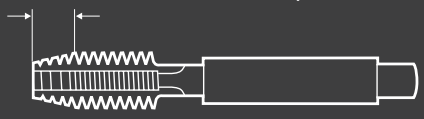


NON-SERIAL FORM
VERSIONE CONICA

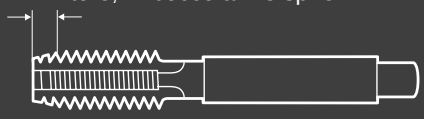
Nr. 1 - Form A
Finisher, 6-8 Threads Lead
Finitore, Imbocco a 6-8 spire



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



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



HAND TAPS
MASCHI A MANO

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

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

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

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

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

VÖLKEL
THREADING SOLUTIONS

Hand Taps
metric ISO-thread DIN 13

Maschi a mano
filettatura metrica ISO DIN 13

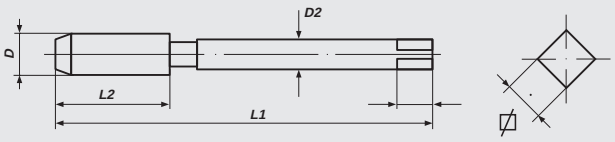
DIN 352 HSS-G Tol. ISO2/6H

M

Nominal Diameter D		L 1	L 2	D 2	⌀	Art.-No.	€	€
M	1 x 0.25	32	5.5	2.5	2.1	27302	10,20	30,60
M	1.1 x 0.25	32	5.5	2.5	2.1	27304	10,20	30,60
M	1.2 x 0.25	32	5.5	2.5	2.1	27306	10,20	30,60
M	1.4 x 0.3	32	7.0	2.5	2.1	27308	10,20	30,60
M	1.6 x 0.35	32	8.0	2.5	2.1	27310	10,20	30,60
M	1.7 x 0.35	32	8.0	2.5	2.1	27312	10,20	30,60
M	1.8 x 0.35	32	8.0	2.5	2.1	27314	10,20	30,60
M	2 x 0.4	36	8.0	2.8	2.1	27316	4,20	12,60
M	2.2 x 0.45	36	9.0	2.8	2.1	27318	4,20	12,60
M	2.3 x 0.4	36	9.0	2.8	2.1	27320	4,20	12,60
M	2.5 x 0.45	40	9.0	2.8	2.1	27322	4,20	12,60
M	2.6 x 0.45	40	9.0	2.8	2.1	27324	4,20	12,60
M	3 x 0.5	40	11.0	3.5	2.7	27326	2,30	6,90
M	3.5 x 0.6	45	13.0	4.0	3.0	27328	3,40	10,20
M	4 x 0.7	45	13.0	4.5	3.4	27330	2,30	6,90
M	4.5 x 0.75	50	16.0	6.0	4.9	27332	3,40	10,20
M	5 x 0.8	50	16.0	6.0	4.9	27334	2,50	7,50
M	5.5 x 0.9	50	18.0	6.0	4.9	27336	4,10	12,30
M	6 x 1.0	50	19.0	6.0	4.9	27338	2,50	7,50
M	7 x 1.0	50	19.0	6.0	4.9	27340	4,10	12,30
M	8 x 1.25	56	22.0	6.0	4.9	27342	2,95	8,85
M	9 x 1.25	63	22.0	7.0	5.5	27344	5,20	15,60
M	10 x 1.5	70	24.0	7.0	5.5	27346	4,05	12,15
M	11 x 1.5	70	24.0	8.0	6.2	27348	6,60	19,80
M	12 x 1.75	75	29.0	9.0	7.0	27350	5,30	15,90
M	14 x 2.0	80	30.0	11.0	9.0	27354	6,00	18,00
M	15 x 2.0	80	32.0	12.0	9.0	27356	7,10	21,30
M	16 x 2.0	80	32.0	12.0	9.0	27358	7,50	22,50
M	18 x 2.5	95	40.0	14.0	11.0	27362	9,60	28,80
M	20 x 2.5	95	40.0	16.0	12.0	27366	11,00	33,00
M	22 x 2.5	100	40.0	18.0	14.5	27370	14,00	42,00
M	24 x 3.0	110	50.0	18.0	14.5	27374	16,00	48,00
M	27 x 3.0	110	50.0	20.0	16.0	27376	26,50	79,50
M	30 x 3.5	125	56.0	22.0	18.0	27378	34,00	102,00
M	33 x 3.5	125	56.0	25.0	20.0	27380	46,00	138,00
M	36 x 4.0	150	63.0	28.0	22.0	27382	55,00	165,00
M	39 x 4.0	150	63.0	32.0	24.0	27384	72,00	216,00
M	42 x 4.5	150	63.0	32.0	24.0	27386	81,00	243,00
M	45 x 4.5	160	70.0	36.0	29.0	27388	98,00	294,00
M	48 x 5.0	180	75.0	36.0	29.0	27390	139,00	417,00
M	52 x 5.0	180	75.0	40.0	32.0	27392	139,00	417,00
M	56 x 5.5	200	85.0	45.0	35.0	27394	172,00	516,00
M	60 x 5.5	200	85.0	45.0	35.0	27396	216,00	648,00
M	64 x 6.0	220	90.0	50.0	39.0	27398	250,00	750,00
M	68 x 6.0	220	90.0	50.0	39.0	27399	295,00	885,00

How to order / esempio come ordinare:

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



Hand Taps
metric ISO-thread DIN 13

Maschi a mano
filettatura metrica ISO DIN 13

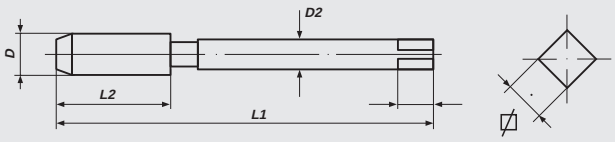
DIN 352 HSS-G Tol. ISO2/6H

M

Nominal Diameter D		L 1	L 2	D 2	⧄	Art.-No.	€	€
M	72 x 6.0	240	80.0	50.0	39.0	28130	575,00	1.725,00
M	76 x 6.0	240	80.0	50.0	39.0	28131	710,00	2.130,00
M	80 x 6.0	260	85.0	50.0	39.0	28132	780,00	2.340,00
M	84 x 6.0	260	85.0	50.0	39.0	28133	880,00	2.640,00
M	88 x 6.0	260	85.0	50.0	39.0	28134	1.190,00	3.570,00
M	90 x 6.0	260	85.0	50.0	39.0	28135	1.275,00	3.825,00
M	92 x 6.0	280	90.0	56.0	44.0	28136	1.365,00	4.095,00
M	96 x 6.0	280	90.0	56.0	44.0	28137	1.540,00	4.620,00
M	100 x 6.0	280	90.0	56.0	44.0	28138	1.735,00	5.205,00

How to order / esempio come ordinare:

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



VÖLKEL
THREADING SOLUTIONS

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

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

DIN 352 HSS-G Tol. ISO2/6H

M

Nominal Diameter D		L 1	L 2	D 2	⊠	Art.-No.	€	€
M	2 x 0.4	36	8	2.8	2.1	27616	4,20	12,60
M	2.5 x 0.45	40	9	2.8	2.1	27622	4,20	12,60
M	3 x 0.5	40	11	3.5	2.7	27626	2,30	6,90
M	4 x 0.7	45	13	4.5	3.4	27630	2,30	6,90
M	5 x 0.8	50	16	6.0	4.9	27634	2,50	7,50
M	6 x 1.0	50	19	6.0	4.9	27638	2,50	7,50
M	8 x 1.25	56	22	6.0	4.9	27642	2,95	8,85
M	9 x 1.25	63	22	7.0	5.5	27644	5,20	15,60
M	10 x 1.5	70	24	7.0	5.5	27646	4,05	12,15
M	11 x 1.5	70	24	8.0	6.2	27648	6,60	19,80
M	12 x 1.75	75	29	9.0	7.0	27650	5,30	15,90
M	13 x 1.75	75	29	9.0	7.0	27652	7,50	22,50
M	14 x 2.0	80	30	11.0	9.0	27654	6,00	18,00
M	16 x 2.0	80	32	12.0	9.0	27658	7,50	22,50
M	18 x 2.5	95	40	14.0	11.0	27662	9,60	28,80
M	19 x 2.5	95	40	14.0	11.0	27664	14,00	42,00
M	20 x 2.5	95	40	16.0	12.0	27666	11,00	33,00
M	22 x 2.5	100	40	18.0	14.5	27670	14,00	42,00
M	24 x 3.0	110	50	18.0	14.5	27674	16,00	48,00
M	27 x 3.0	110	50	20.0	16.0	27676	26,50	79,50
M	30 x 3.5	125	56	22.0	18.0	27678	34,00	102,00
M	33 x 3.5	125	56	25.0	20.0	27680	46,00	138,00
M	36 x 4.0	150	63	28.0	22.0	27682	55,00	165,00
M	39 x 4.0	150	63	32.0	24.0	27684	72,00	216,00
M	42 x 4.5	150	63	32.0	24.0	27686	81,00	243,00
M	3 x 0.6	40	11	3.5	2.7	27627	4,40	13,20
M	4 x 0.75	45	13	4.5	3.4	27631	4,40	13,20
M	5 x 0.9	50	16	6.0	4.9	27635	4,40	13,20

Application:

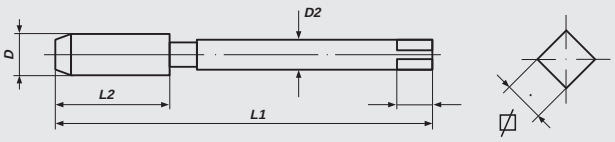
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

Applicazione:

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

How to order / esempio come ordinare:

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



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

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

ISO 529 HSS-G Tol. ISO2/6H

M

Nominal Diameter D		L 1	L 2	D 2	⧄	Art.-No.	€	€
M	3 x 0.5	48	11	3.15	2.5	80426	2,65	7,95
M	4 x 0.7	53	13	4.0	3.15	80430	2,65	7,95
M	5 x 0.8	58	16	5.0	4.0	80434	2,75	8,25
M	6 x 1.0	66	19	6.3	5.0	80438	2,90	8,70
M	8 x 1.25	72	22	8.0	6.3	80442	3,85	11,55
M	10 x 1.5	80	24	10.0	8.0	80446	5,30	15,90
M	12 x 1.75	89	29	9.0	7.1	80450	6,60	19,80
M	14 x 2.0	95	30	11.2	9.0	80454	7,30	21,90
M	16 x 2.0	102	32	12.5	10.0	80458	9,50	28,50
M	18 x 2.5	110	37	14.0	11.2	80462	13,20	39,60
M	20 x 2.5	112	37	14.0	11.2	80466	14,80	44,40
M	22 x 2.5	118	38	16.0	12.5	80470	17,00	51,00
M	24 x 3.0	130	45	18.0	14.0	80474	19,50	58,50

Application:

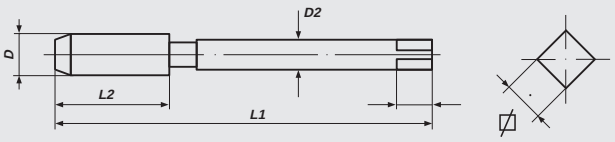
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

Applicazione:

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

How to order / esempio come ordinare:

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



VÖLKEL
THREADING SOLUTIONS

Hand Taps
metric-fine ISO-thread DIN 13

Maschi a mano
filettatura metrica fine ISO DIN 13

DIN 2181 HSS-G Tol. ISO2/6H

Mf

Nominal Diameter D	L 1	L 2	D 2	⌀	Art.-No.	€	€
M 2.5 x 0.35	40	9	2.8	2.1	26304	6,40	12,80
M 2.6 x 0.35	40	9	2.8	2.1	26305	6,40	12,80
M 3 x 0.35	40	9	3.5	2.7	26308	6,40	12,80
M 3.5 x 0.35	45	10	4.0	3.0	26309	6,40	12,80
M 4 x 0.35	45	10	4.5	3.4	26310	6,40	12,80
M 4 x 0.5	45	10	4.5	3.4	26312	6,40	12,80
M 4.5 x 0.5	50	12	6.0	4.9	26313	6,40	12,80
M 5 x 0.5	50	12	6.0	4.9	26314	6,40	12,80
M 5 x 0.75	50	12	6.0	4.9	26316	6,40	12,80
M 5.5 x 0.5	50	12	6.0	4.9	26315	6,40	12,80
M 6 x 0.5	50	14	6.0	4.9	26317	6,40	12,80
M 6 x 0.75	50	14	6.0	4.9	26318	5,70	11,40
M 7 x 0.5	50	14	6.0	4.9	26319	5,70	11,40
M 7 x 0.75	50	14	6.0	4.9	26320	5,70	11,40
M 8 x 0.5	50	19	6.0	4.9	26322	5,70	11,40
M 8 x 0.75	50	19	6.0	4.9	26324	5,70	11,40
M 8 x 1.0	56	22	6.0	4.9	26326	5,70	11,40
M 9 x 0.5	56	19	7.0	5.5	26327	6,40	12,80
M 9 x 0.75	56	19	7.0	5.5	26328	6,40	12,80
M 9 x 1.0	63	20	7.0	5.5	26330	6,40	12,80
M 10 x 0.5	63	20	7.0	5.5	26331	6,40	12,80
M 10 x 0.75	63	20	7.0	5.5	26332	6,40	12,80
M 10 x 1.0	63	20	7.0	5.5	26336	5,70	11,40
M 10 x 1.25	70	24	7.0	5.5	26338	6,40	12,80
M 11 x 0.75	63	20	8.0	6.2	26339	8,30	16,60
M 11 x 1.0	63	20	8.0	6.2	26340	8,30	16,60
M 11 x 1.25	63	22	8.0	6.2	26342	8,30	16,60
M 12 x 0.5	70	22	9.0	7.0	26345	8,30	16,60
M 12 x 0.75	70	22	9.0	7.0	26343	8,30	16,60
M 12 x 1.0	70	22	9.0	7.0	26344	8,30	16,60
M 12 x 1.25	70	22	9.0	7.0	26346	8,30	16,60
M 12 x 1.5	70	22	9.0	7.0	26348	7,50	15,00
M 13 x 0.5	70	22	11.0	9.0	26347	12,70	25,40
M 13 x 0.75	70	22	11.0	9.0	26349	12,70	25,40
M 13 x 1.0	70	22	11.0	9.0	26350	12,70	25,40
M 13 x 1.5	70	22	11.0	9.0	26351	12,70	25,40
M 14 x 0.5	70	22	11.0	9.0	26355	12,70	25,40

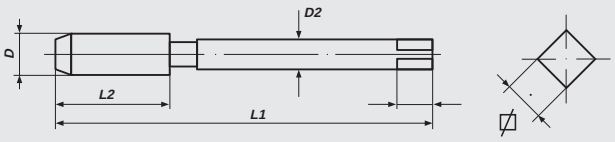
Application:

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

Applicazione:

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

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



VÖLKEL THREADING SOLUTIONS

Hand Taps
metric-fine ISO-thread DIN 13

Maschi a mano
filettatura metrica fine ISO DIN 13

DIN 2181 HSS-G Tol. ISO2/6H

Mf

Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€	€
M 14 x 0.75	70	22	11.0	9.0	26352	12,70	25,40
M 14 x 1.0	70	22	11.0	9.0	26353	12,70	25,40
M 14 x 1.25	70	22	11.0	9.0	26354	9,50	19,00
M 14 x 1.5	70	22	11.0	9.0	26356	8,20	16,40
M 15 x 0.75	70	22	12.0	9.0	26357	14,00	28,00
M 15 x 1.0	70	22	12.0	9.0	26358	14,00	28,00
M 15 x 1.5	70	22	12.0	9.0	26360	14,00	28,00
M 16 x 0.5	70	22	12.0	9.0	26361	14,00	28,00
M 16 x 0.75	70	22	12.0	9.0	26363	14,00	28,00
M 16 x 1.0	70	22	12.0	9.0	26362	14,00	28,00
M 16 x 1.25	70	22	12.0	9.0	26364	14,00	28,00
M 16 x 1.5	70	22	12.0	9.0	26366	10,00	20,00
M 17 x 1.0	70	22	12.0	9.0	26368	15,30	30,60
M 17 x 1.5	70	22	12.0	9.0	26369	15,30	30,60
M 18 x 0.5	80	22	14.0	11.0	26367	15,30	30,60
M 18 x 0.75	80	22	14.0	11.0	26373	15,30	30,60
M 18 x 1.0	80	22	14.0	11.0	26370	15,30	30,60
M 18 x 1.25	80	22	14.0	11.0	26371	15,30	30,60
M 18 x 1.5	80	22	14.0	11.0	26372	11,50	23,00
M 18 x 2.0	80	22	14.0	11.0	26374	15,30	30,60
M 19 x 1.0	80	22	14.0	11.0	26375	19,20	38,40
M 19 x 1.5	80	22	14.0	11.0	26376	19,20	38,40
M 20 x 0.5	80	22	16.0	12.0	26377	19,20	38,40
M 20 x 0.75	80	22	16.0	12.0	26379	19,20	38,40
M 20 x 1.0	80	22	16.0	12.0	26378	19,20	38,40
M 20 x 1.25	80	22	16.0	12.0	26380	19,20	38,40
M 20 x 1.5	80	22	16.0	12.0	26384	14,00	28,00
M 20 x 2.0	80	22	16.0	12.0	26386	19,20	38,40
M 21 x 1.0	80	22	16.0	12.0	26387	19,90	39,80
M 21 x 1.5	80	22	16.0	12.0	26388	19,90	39,80
M 22 x 0.5	80	22	18.0	14.5	26389	19,90	39,80
M 22 x 0.75	80	22	18.0	14.5	26391	19,90	39,80
M 22 x 1.0	80	22	18.0	14.5	26390	19,90	39,80
M 22 x 1.25	80	22	18.0	14.5	26392	19,90	39,80
M 22 x 1.5	80	22	18.0	14.5	26394	19,90	39,80
M 22 x 2.0	80	22	18.0	14.5	26396	19,90	39,80
M 23 x 1.0	80	22	18.0	14.5	26397	26,70	53,40
M 23 x 1.5	80	22	18.0	14.5	26398	26,70	53,40
M 24 x 0.5	90	22	18.0	14.5	26501	26,70	53,40
M 24 x 0.75	90	22	18.0	14.5	26503	26,70	53,40
M 24 x 1.0	90	22	18.0	14.5	26500	26,70	53,40
M 24 x 1.25	90	22	18.0	14.5	26502	26,70	53,40
M 24 x 1.5	90	22	18.0	14.5	26504	20,00	40,00
M 24 x 2.0	90	22	18.0	14.5	26506	26,70	53,40
M 25 x 1.0	90	22	18.0	14.5	26507	39,00	78,00
M 25 x 1.5	90	22	18.0	14.5	26508	39,00	78,00
M 26 x 1.0	90	22	18.0	14.5	26510	39,00	78,00
M 26 x 1.5	90	22	18.0	14.5	26512	39,00	78,00
M 26 x 2.0	90	22	18.0	14.5	26514	39,00	78,00
M 27 x 1.0	90	22	20.0	16.0	26516	39,00	78,00

VÖLKEL THREADING SOLUTIONS

Hand Taps
metric-fine ISO-thread DIN 13

Maschi a mano
filettatura metrica fine ISO DIN 13

DIN 2181 HSS-G Tol. ISO2/6H

Mf

Nominal Diameter D	L 1	L 2	D 2	⌀	Art.-No.	€	€
M 27 x 1.5	90	22	20.0	16.0	26517	39,00	78,00
M 27 x 2.0	90	22	20.0	16.0	26518	46,00	92,00
M 28 x 1.0	90	22	20.0	16.0	26520	46,00	92,00
M 28 x 1.5	90	22	20.0	16.0	26522	46,00	92,00
M 28 x 2.0	90	22	20.0	16.0	26524	46,00	92,00
M 29 x 1.5	90	22	22.0	18.0	26526	46,00	92,00
M 30 x 1.0	90	22	22.0	18.0	26528	54,00	108,00
M 30 x 1.5	90	22	22.0	18.0	26530	54,00	108,00
M 30 x 2.0	90	22	22.0	18.0	26532	54,00	108,00
M 30 x 2.5	125	56	22.0	18.0	26533	54,00	108,00
M 30 x 3.0	125	56	22.0	18.0	26534	54,00	108,00
M 32 x 1.0	90	22	22.0	18.0	26539	54,00	108,00
M 32 x 1.5	90	22	22.0	18.0	26536	54,00	108,00
M 32 x 2.0	90	22	22.0	18.0	26535	54,00	108,00
M 32 x 3.0	125	56	22.0	18.0	26537	54,00	108,00
M 33 x 1.5	100	25	25.0	20.0	26538	54,00	108,00
M 33 x 2.0	100	25	25.0	20.0	26540	66,00	132,00
M 33 x 3.0	125	56	25.0	20.0	26542	66,00	132,00
M 34 x 1.0	100	25	28.0	22.0	26543	66,00	132,00
M 34 x 1.5	100	25	28.0	22.0	26544	66,00	132,00
M 34 x 2.0	125	40	28.0	22.0	26546	66,00	132,00
M 35 x 1.0	100	25	28.0	22.0	26547	66,00	132,00
M 35 x 1.5	100	25	28.0	22.0	26548	66,00	132,00
M 35 x 2.0	125	40	28.0	22.0	26549	66,00	132,00
M 36 x 1.0	100	25	28.0	22.0	26551	69,00	138,00
M 36 x 1.5	100	25	28.0	22.0	26550	69,00	138,00
M 36 x 2.0	125	40	28.0	22.0	26552	69,00	138,00
M 36 x 3.0	125	40	28.0	22.0	26554	69,00	138,00
M 37 x 1.5	100	25	28.0	22.0	26553	86,00	172,00
M 38 x 1.0	100	25	28.0	22.0	26555	86,00	172,00
M 38 x 1.5	100	25	28.0	22.0	26556	86,00	172,00
M 38 x 2.0	125	40	28.0	22.0	26557	86,00	172,00
M 38 x 3.0	125	40	28.0	22.0	26559	86,00	172,00
M 39 x 1.5	110	25	32.0	24.0	26558	86,00	172,00
M 39 x 2.0	125	40	32.0	24.0	26560	86,00	172,00
M 39 x 3.0	125	40	32.0	24.0	26562	86,00	172,00
M 40 x 1.0	110	25	32.0	24.0	26563	86,00	172,00
M 40 x 1.5	110	25	32.0	24.0	26564	86,00	172,00
M 40 x 2.0	125	40	32.0	24.0	26566	86,00	172,00
M 40 x 3.0	125	40	32.0	24.0	26568	86,00	172,00
M 42 x 1.0	110	25	32.0	24.0	26569	86,00	172,00
M 42 x 1.5	110	25	32.0	24.0	26570	86,00	172,00
M 42 x 2.0	125	40	32.0	24.0	26572	90,00	180,00
M 42 x 3.0	125	40	32.0	24.0	26574	90,00	180,00
M 44 x 1.5	110	25	36.0	29.0	26571	101,50	203,00
M 44 x 2.0	125	40	36.0	29.0	26573	101,50	203,00
M 45 x 1.0	110	25	36.0	29.0	26575	101,50	203,00
M 45 x 1.5	110	25	36.0	29.0	26576	101,50	203,00
M 45 x 2.0	125	40	36.0	29.0	26578	101,50	203,00
M 45 x 3.0	125	40	36.0	29.0	26580	101,50	203,00

Hand Taps
metric-fine ISO-thread DIN 13

Maschi a mano
filettatura metrica fine ISO DIN 13

DIN 2181 HSS-G Tol. ISO2/6H

Mf

Nominal Diameter D	L 1	L 2	D 2	⌀	Art.-No.	€	€
M 46 x 1.5	140	40	36	29.0	26581	101,50	203,00
M 48 x 1.0	140	40	36	29.0	26583	121,00	242,00
M 48 x 1.5	140	40	36	29.0	26582	121,00	242,00
M 48 x 2.0	140	40	36	29.0	26584	121,00	242,00
M 48 x 3.0	140	40	36	29.0	26586	121,00	242,00
M 50 x 1.5	140	40	36	29.0	26588	133,00	266,00
M 50 x 2.0	140	40	36	29.0	26590	133,00	266,00
M 50 x 3.0	140	40	36	29.0	26592	133,00	266,00
M 52 x 1.5	140	40	40	32.0	26594	160,00	320,00
M 52 x 2.0	140	40	40	32.0	26596	160,00	320,00
M 52 x 3.0	140	40	40	32.0	26598	160,00	320,00
M 54 x 1.0	140	32	40	32.0	28118	173,00	346,00
M 54 x 1.5	140	32	40	32.0	28001	173,00	346,00
M 54 x 2.0	140	36	40	32.0	28002	173,00	346,00
M 54 x 3.0	140	40	40	32.0	28003	173,00	346,00
M 54 x 4.0	180	50	40	32.0	28004	173,00	346,00
M 55 x 1.5	140	32	40	32.0	28005	197,00	394,00
M 55 x 2.0	140	36	40	32.0	28006	197,00	394,00
M 55 x 3.0	140	40	40	32.0	28007	197,00	394,00
M 55 x 4.0	180	50	40	32.0	28008	197,00	394,00
M 56 x 1.0	140	32	40	32.0	28119	220,00	440,00
M 56 x 1.5	140	32	40	32.0	28009	220,00	440,00
M 56 x 2.0	140	36	40	32.0	28010	220,00	440,00
M 56 x 3.0	140	40	40	32.0	28011	220,00	440,00
M 56 x 4.0	180	50	40	32.0	28012	220,00	440,00
M 58 x 1.0	160	32	45	35.0	28120	236,00	472,00
M 58 x 1.5	160	32	45	35.0	28013	225,00	450,00
M 58 x 2.0	160	36	45	35.0	28014	225,00	450,00
M 58 x 3.0	160	40	45	35.0	28015	225,00	450,00
M 58 x 4.0	200	55	45	35.0	28016	225,00	450,00
M 60 x 1.5	160	34	45	35.0	28017	236,00	472,00
M 60 x 2.0	160	36	45	35.0	28018	236,00	472,00
M 60 x 3.0	160	40	45	35.0	28019	236,00	472,00
M 60 x 4.0	200	55	45	35.0	28020	236,00	472,00
M 62 x 1.5	160	34	50	39.0	28021	270,00	540,00
M 62 x 2.0	160	36	50	39.0	28022	270,00	540,00
M 62 x 3.0	180	45	50	39.0	28023	270,00	540,00
M 62 x 4.0	220	55	50	39.0	28024	270,00	540,00
M 63 x 1.5	160	32	50	39.0	28025	279,00	558,00
M 64 x 1.5	160	34	50	39.0	28026	279,00	558,00
M 64 x 2.0	160	36	50	39.0	28027	279,00	558,00
M 64 x 3.0	180	45	50	39.0	28028	279,00	558,00
M 64 x 4.0	220	60	50	39.0	28029	279,00	558,00
M 65 x 1.5	160	34	50	39.0	28030	295,00	590,00
M 65 x 2.0	160	36	50	39.0	28031	295,00	590,00
M 65 x 3.0	180	45	50	39.0	28032	295,00	590,00
M 65 x 4.0	220	60	50	39.0	28033	295,00	590,00
M 68 x 1.5	160	36	50	39.0	28034	304,50	609,00
M 68 x 2.0	160	40	50	39.0	28035	304,50	609,00
M 68 x 3.0	180	50	50	39.0	28036	304,50	609,00

VÖLKEL THREADING SOLUTIONS

Hand Taps
metric-fine ISO-thread DIN 13

Maschi a mano
filettatura metrica fine ISO DIN 13

DIN 2181 HSS-G Tol. ISO2/6H

Mf

Nominal Diameter D	L 1	L 2	D 2	⌀	Art.-No.	€	€
M 68 x 4.0	220	60	50	39.0	28037	304,50	609,00
M 70 x 1.5	160	36	50	39.0	28038	533,00	1.066,00
M 70 x 2.0	160	40	50	39.0	28039	533,00	1.066,00
M 70 x 3.0	200	50	50	39.0	28040	603,00	1.206,00
M 70 x 4.0	240	60	50	39.0	28041	603,00	1.206,00
M 72 x 1.5	160	36	50	39.0	28042	533,00	1.066,00
M 72 x 2.0	160	40	50	39.0	28043	533,00	1.066,00
M 72 x 3.0	200	50	50	39.0	28044	603,00	1.206,00
M 72 x 4.0	240	60	50	39.0	28045	603,00	1.206,00
M 74 x 1.5	160	36	50	39.0	28046	588,00	1.176,00
M 74 x 2.0	160	40	50	39.0	28047	588,00	1.176,00
M 74 x 3.0	200	50	50	39.0	28048	693,00	1.386,00
M 74 x 4.0	240	60	50	39.0	28049	693,00	1.386,00
M 75 x 1.5	160	36	50	39.0	28050	594,00	1.188,00
M 75 x 2.0	160	40	50	39.0	28051	594,00	1.188,00
M 75 x 3.0	200	50	50	39.0	28052	700,00	1.400,00
M 75 x 4.0	240	60	50	39.0	28053	700,00	1.400,00
M 76 x 1.5	160	36	50	39.0	28054	603,00	1.206,00
M 76 x 2.0	160	40	50	39.0	28055	603,00	1.206,00
M 76 x 3.0	220	50	50	39.0	28056	745,00	1.490,00
M 76 x 4.0	260	60	50	39.0	28057	745,00	1.490,00
M 78 x 1.5	160	36	50	39.0	28058	603,00	1.206,00
M 78 x 2.0	160	40	50	39.0	28059	603,00	1.206,00
M 78 x 3.0	220	55	50	39.0	28060	745,00	1.490,00
M 78 x 4.0	260	65	50	39.0	28061	745,00	1.490,00
M 80 x 1.5	160	36	50	39.0	28062	656,00	1.312,00
M 80 x 2.0	160	40	50	39.0	28063	656,00	1.312,00
M 80 x 3.0	220	55	50	39.0	28064	819,00	1.638,00
M 80 x 4.0	260	65	50	39.0	28065	819,00	1.638,00
M 82 x 1.5	160	36	50	39.0	28066	656,00	1.312,00
M 82 x 2.0	160	40	50	39.0	28067	656,00	1.312,00
M 82 x 3.0	220	55	50	39.0	28068	819,00	1.638,00
M 82 x 4.0	260	65	50	39.0	28069	819,00	1.638,00
M 84 x 1.5	160	36	50	39.0	28070	766,00	1.532,00
M 84 x 2.0	160	40	50	39.0	28071	766,00	1.532,00
M 84 x 3.0	220	55	50	39.0	28072	924,00	1.848,00
M 84 x 4.0	260	65	50	39.0	28073	924,00	1.848,00
M 85 x 1.5	160	36	50	39.0	28074	992,00	1.984,00
M 85 x 2.0	160	40	50	39.0	28075	992,00	1.984,00
M 85 x 3.0	220	55	50	39.0	28076	1.213,00	2.426,00
M 85 x 4.0	260	65	50	39.0	28077	1.213,00	2.426,00
M 86 x 1.5	160	36	50	39.0	28078	992,00	1.984,00
M 86 x 2.0	160	40	50	39.0	28079	992,00	1.984,00
M 86 x 3.0	220	55	50	39.0	28080	1.213,00	2.426,00
M 86 x 4.0	260	65	50	39.0	28081	1.213,00	2.426,00
M 88 x 1.5	160	38	50	39.0	28082	1.087,00	2.174,00
M 88 x 2.0	160	40	50	39.0	28083	1.087,00	2.174,00
M 88 x 3.0	220	55	50	39.0	28084	1.249,00	2.498,00
M 88 x 4.0	260	65	50	39.0	28085	1.249,00	2.498,00
M 90 x 1.5	160	38	50	39.0	28086	1.107,00	2.214,00

Hand Taps
metric-fine ISO-thread DIN 13

Maschi a mano
filettatura metrica fine ISO DIN 13

DIN 2181 HSS-G Tol. ISO2/6H

Mf

Nominal Diameter D	L 1	L 2	D 2	⌀	Art.-No.	€	€
M 90 x 2.0	160	40	50	39.0	28087	1.107,00	2.214,00
M 90 x 3.0	220	55	50	39.0	28088	1.338,00	2.676,00
M 90 x 4.0	260	65	50	39.0	28089	1.338,00	2.676,00
M 92 x 1.5	180	40	56	44.0	28090	1.134,00	2.268,00
M 92 x 2.0	180	45	56	44.0	28091	1.134,00	2.268,00
M 92 x 3.0	240	60	56	44.0	28092	1.433,00	2.866,00
M 92 x 4.0	280	70	56	44.0	28093	1.433,00	2.866,00
M 95 x 1.5	180	40	56	44.0	28094	1.223,00	2.446,00
M 95 x 2.0	180	45	56	44.0	28095	1.223,00	2.446,00
M 95 x 3.0	240	60	56	44.0	28096	1.617,00	3.234,00
M 95 x 4.0	280	70	56	44.0	28097	1.567,00	3.134,00
M 96 x 1.5	180	40	56	44.0	28098	1.223,00	2.446,00
M 96 x 2.0	180	45	56	44.0	28099	1.223,00	2.446,00
M 96 x 3.0	240	60	56	44.0	28100	1.617,00	3.234,00
M 96 x 4.0	280	70	56	44.0	28101	1.617,00	3.234,00
M 98 x 1.5	180	40	56	44.0	28102	1.318,00	2.636,00
M 98 x 2.0	180	45	56	44.0	28103	1.318,00	2.636,00
M 98 x 3.0	240	60	56	44.0	28104	1.733,00	3.466,00
M 98 x 4.0	280	70	56	44.0	28105	1.733,00	3.466,00
M 100 x 1.5	180	45	56	44.0	28106	1.501,00	3.002,00
M 100 x 2.0	180	50	56	44.0	28107	1.501,00	3.002,00
M 100 x 3.0	240	65	56	44.0	28108	1.822,00	3.644,00
M 100 x 4.0	280	75	56	44.0	28109	1.822,00	3.644,00
M 105 x 1.5	180	45	56	44.0	28110	1.617,00	3.234,00
M 105 x 2.0	180	50	56	44.0	28111	1.617,00	3.234,00
M 105 x 3.0	240	65	56	44.0	28112	1.964,00	3.928,00
M 105 x 4.0	280	75	56	44.0	28113	1.964,00	3.928,00
M 110 x 1.5	180	45	56	44.0	28114	1.800,00	3.600,00
M 110 x 2.0	180	50	56	44.0	28115	1.800,00	3.600,00
M 110 x 3.0	240	65	56	44.0	28116	2.215,00	4.430,00
M 110 x 4.0	280	75	56	44.0	28117	2.215,00	4.430,00

VÖLKEL
THREADING SOLUTIONS

Hand Taps
Whitworth-thread BS 84

Maschi a mano
filettatura Whitworth BS 84

≈ DIN 352 HSS-G

BSW

Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€	€
BSW 1/16 x 60	36	10	2.5	2.1	22302	5,70	17,10
BSW 3/32 x 48	36	10	2.8	2.1	22304	4,60	13,80
BSW 1/8 x 40	40	12	3.5	2.7	22306	4,10	12,30
BSW 5/32 x 32	45	14	4.5	3.4	22308	4,10	12,30
BSW 3/16 x 24	50	18	6.0	4.9	22310	4,00	12,00
BSW 7/32 x 24	50	18	6.0	4.9	22312	4,00	12,00
BSW 1/4 x 20	50	19	6.0	4.9	22314	4,00	12,00
BSW 5/16 x 18	56	22	6.0	4.9	22316	4,50	13,50
BSW 3/8 x 16	70	24	7.0	5.5	22318	5,00	15,00
BSW 7/16 x 14	70	24	8.0	6.2	22320	6,30	18,90
BSW 1/2 x 12	75	29	9.0	7.0	22322	7,60	22,80
BSW 9/16 x 12	80	30	11.0	9.0	22324	10,00	30,00
BSW 5/8 x 11	80	32	12.0	9.0	22326	11,20	33,60
BSW 3/4 x 10	95	40	14.0	11.0	22330	15,00	45,00
BSW 7/8 x 9	100	40	18.0	14.5	22334	20,00	60,00
BSW 1" x 8	110	50	18.0	14.5	22338	23,00	69,00
BSW 1.1/8 x 7	132	56	22.0	18.0	22342	35,50	106,50
BSW 1.1/4 x 7	132	56	22.0	18.0	22346	40,00	120,00
BSW 1.3/8 x 6	150	63	28.0	22.0	22350	52,00	156,00
BSW 1.1/2 x 6	150	63	32.0	24.0	22354	60,00	180,00
BSW 1.5/8 x 5	160	70	32.0	24.0	22358	120,00	360,00
BSW 1.3/4 x 5	160	70	36.0	29.0	22362	120,00	360,00
BSW 1.7/8 x 4.1/2	190	80	36.0	29.0	22366	156,00	468,00
BSW 2" x 4.1/2	190	80	40.0	32.0	22370	156,00	468,00
BSW 2.1/4 x 4	220	80	45.0	35.0	22372	340,00	1.020,00
BSW 2.1/2 x 4	220	80	50.0	39.0	22374	435,00	1.305,00
BSW 2.3/4 x 3.1/2	240	80	50.0	39.0	22376	1.120,00	3.360,00
BSW 3" x 3.1/2	260	80	50.0	39.0	22378	1.440,00	4.320,00

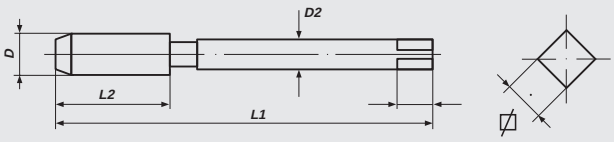
Application:

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

Applicazione:

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

How to order / esempio come ordinare:
BSW 1/8 = 22306
BSW 1/8, No. 1 = 22306-1
BSW 1/8, No. 2 = 22306-2
BSW 1/8, No. 3 = 22306-3



Hand Taps
British-Standard-Fine-thread BS 84

Maschi a mano
filettatura Whitworth fine BS 84

≈ DIN 2181 HSS-G

BSF

Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€	€
BSF 3/16 x 32	50	14	6.0	4.9	22710	4,00	8,00
BSF 1/4 x 26	50	18	6.0	4.9	22714	4,00	8,00
BSF 5/16 x 22	56	22	6.0	4.9	22716	4,50	9,00
BSF 3/8 x 20	63	22	7.0	5.5	22718	5,00	10,00
BSF 7/16 x 18	63	22	8.0	6.2	22720	6,30	12,60
BSF 1/2 x 16	75	24	9.0	7.0	22722	7,60	15,20
BSF 9/16 x 16	80	28	11.0	9.0	22724	10,00	20,00
BSF 5/8 x 14	80	28	12.0	9.0	22726	11,20	22,40
BSF 3/4 x 12	95	32	14.0	11.0	22730	15,00	30,00
BSF 7/8 x 11	100	36	18.0	14.5	22734	20,00	40,00
BSF 1" x 10	110	40	18.0	14.5	22738	23,00	46,00

Application:

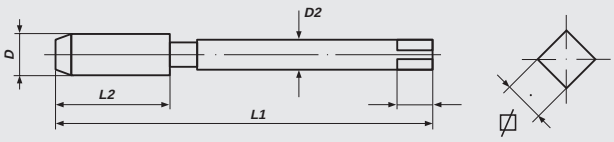
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

Applicazione:

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

How to order / esempio come ordinare:

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



VÖLKEL
THREADING SOLUTIONS

Hand Taps, *non-serial form*

BA-thread BS 93

Maschi a mano, *versione conica*

filettatura BA, BS 93

ISO 529 HSS-G

BA

Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€	€
BA 0	66	19	6.3	5.0	89400	5,70	17,10
BA 1	62	17	5.6	4.5	89401	5,70	17,10
BA 2	58	16	5.0	4.0	89402	5,70	17,10
BA 3	53	13	4.5	3.55	89403	5,70	17,10
BA 4	50	13	3.55	2.8	89404	5,70	17,10
BA 5	48	11	3.15	2.5	89405	5,70	17,10
BA 6	45	9.5	2.8	2.24	89406	5,70	17,10

Application:

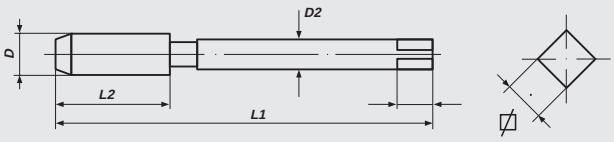
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

Applicazione:

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

How to order / esempio come ordinare:

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



Hand Taps
Unified Coarse thread ANSI B 1.1

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

≈ DIN 352 HSS-G Tol. 2B

UNC

Nominal Diameter D	L 1	L 2	D 2	⊡	Art.-No.	€	€
UNC Nr. 1 x 64	32	10	2.5	2.1	23301	12,50	37,50
UNC Nr. 2 x 56	36	11	2.8	2.1	23302	12,50	37,50
UNC Nr. 3 x 48	36	11	2.8	2.1	23303	12,50	37,50
UNC Nr. 4 x 40	40	12	3.5	2.7	23304	7,60	22,80
UNC Nr. 5 x 40	40	12	3.5	2.7	23305	7,60	22,80
UNC Nr. 6 x 32	45	14	4.0	3.0	23306	7,60	22,80
UNC Nr. 8 x 32	45	14	4.5	3.4	23308	7,60	22,80
UNC Nr. 10 x 24	50	16	6.0	4.9	23310	7,60	22,80
UNC Nr. 12 x 24	50	18	6.0	4.9	23312	7,60	22,80
UNC 1/4 x 20	50	19	6.0	4.9	23314	4,00	12,00
UNC 5/16 x 18	56	22	6.0	4.9	23316	4,50	13,50
UNC 3/8 x 16	70	24	7.0	5.5	23318	5,00	15,00
UNC 7/16 x 14	70	24	8.0	6.2	23320	6,30	18,90
UNC 1/2 x 13	75	29	9.0	7.0	23322	7,60	22,80
UNC 9/16 x 12	80	30	11.0	9.0	23324	10,00	30,00
UNC 5/8 x 11	80	32	12.0	9.0	23326	11,20	33,60
UNC 3/4 x 10	95	40	14.0	11.0	23330	15,00	45,00
UNC 7/8 x 9	100	40	18.0	14.5	23334	20,00	60,00
UNC 1" x 8	110	50	18.0	14.5	23338	23,00	69,00
UNC 1.1/8 x 7	132	56	22.0	18.0	23342	35,50	106,50
UNC 1.1/4 x 7	132	56	22.0	18.0	23346	40,00	120,00
UNC 1.3/8 x 6	150	63	28.0	22.0	23350	52,00	156,00
UNC 1.1/2 x 6	150	63	32.0	24.0	23354	60,00	180,00
UNC 1.5/8 x 5	160	70	32.0	24.0	23358	120,00	360,00
UNC 1.3/4 x 5	160	70	36.0	29.0	23362	120,00	360,00
UNC 1.7/8 x 4.1/2	190	80	36.0	29.0	23366	156,00	468,00
UNC 2" x 4.1/2	190	80	40.0	32.0	23370	156,00	468,00
UNC 2.1/4 x 4.1/2	220	80	45.0	35.0	23372	325,00	975,00
UNC 2.1/2 x 4	220	80	50.0	39.0	23374	418,00	1.254,00
UNC 2.3/4 x 4	240	80	50.0	39.0	23376	1.067,00	3.201,00
UNC 3" x 4	260	80	50.0	39.0	23378	1.375,00	4.125,00

Application:

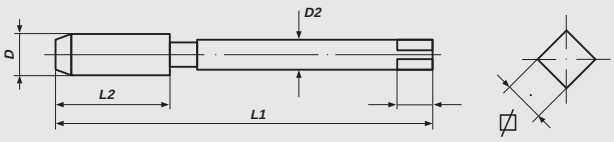
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

Applicazione:

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

How to order / esempio come ordinare:

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



VÖLKEL
THREADING SOLUTIONS

Hand Taps
Unified Fine thread ANSI B 1.1

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

≈ DIN 2181 HSS-G Tol. 2B

UNF

Nominal Diameter D	L 1	L 2	D 2	⊠	Art.-No.	€	€
UNF Nr. 0 x 80	28	8	2.5	2.1	24300	12,50	25,00
UNF Nr. 1 x 72	32	9	2.8	2.1	24301	12,50	25,00
UNF Nr. 2 x 64	32	10	2.8	2.1	24302	12,50	25,00
UNF Nr. 3 x 56	32	10	2.8	2.1	24303	12,50	25,00
UNF Nr. 4 x 48	36	11	3.5	2.7	24304	7,60	15,20
UNF Nr. 5 x 44	36	11	3.5	2.7	24305	7,60	15,20
UNF Nr. 6 x 40	40	12	4.5	3.4	24306	7,60	15,20
UNF Nr. 8 x 36	40	12	4.5	3.4	24308	7,60	15,20
UNF Nr. 10 x 32	45	14	6.0	4.9	24310	7,60	15,20
UNF Nr. 12 x 28	50	14	6.0	4.9	24312	7,60	15,20
UNF 1/4 x 28	50	18	6.0	4.9	24314	4,00	8,00
UNF 5/16 x 24	56	22	6.0	4.9	24316	4,50	9,00
UNF 3/8 x 24	63	22	7.0	5.5	24318	5,00	10,00
UNF 7/16 x 20	63	22	8.0	6.2	24320	6,30	12,60
UNF 1/2 x 20	75	24	9.0	7.0	24322	7,60	15,20
UNF 9/16 x 18	80	28	11.0	9.0	24324	10,00	20,00
UNF 5/8 x 18	80	28	12.0	9.0	24326	11,20	22,40
UNF 3/4 x 16	95	32	14.0	11.0	24330	15,00	30,00
UNF 7/8 x 14	100	36	18.0	14.5	24334	20,00	40,00
UNF 1" x 12	110	40	18.0	14.5	24338	23,00	46,00
UNF 1" x 14	110	40	18.0	14.5	24340	25,00	50,00
UNF 1.1/8 x 12	110	50	22.0	18.0	24342	35,50	71,00
UNF 1.1/4 x 12	132	56	22.0	18.0	24346	40,00	80,00
UNF 1.3/8 x 12	132	56	28.0	22.0	24350	52,00	104,00
UNF 1.1/2 x 12	150	63	32.0	24.0	24354	60,00	120,00

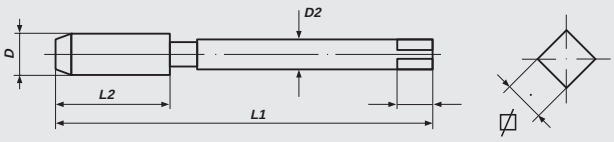
Application:

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

Applicazione:

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

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



Hand Taps, *non-serial form*

Unified Extra Fine thread ANSI B 1.1

Maschi a mano, *versione conica*

filettatura unificata, serie extra-fina ANSI B1.1

ISO 529 HSS-G Tol. 2B

UNEF

Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€	€
UNEF 1/4 x 32	66	19	6.3	5.0	83821	4,80	14,40
UNEF 5/16 x 32	72	22	8.0	6.3	83822	5,40	16,20
UNEF 3/8 x 32	80	24	10.0	8.0	83823	6,10	18,30
UNEF 7/16 x 28	85	25	8.0	6.3	83824	7,60	22,80
UNEF 1/2 x 28	89	29	9.0	7.1	83825	9,00	27,00
UNEF 9/16 x 24	95	30	11.2	9.0	83826	12,00	36,00
UNEF 5/8 x 24	102	32	12.5	10.0	83827	13,50	40,50
UNEF 3/4 x 20	112	37	14.0	11.2	83829	18,00	54,00
UNEF 7/8 x 20	118	38	16.0	12.5	83831	24,30	72,90
UNEF 1" x 20	130	45	16.0	14.0	83833	27,80	83,40

Application:

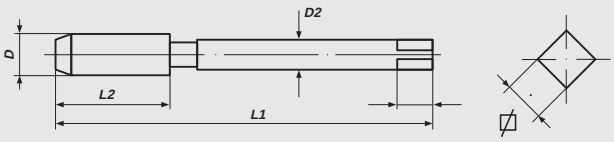
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

Applicazione:

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

How to order / esempio come ordinare:

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



VÖLKEL
THREADING SOLUTIONS

Hand Taps
Pipe-thread DIN ISO 228

Maschi a mano
filettatura per tubi gas DIN ISO 228

DIN 5157 HSS-G

G (BSP)

Nominal Diameter D		L 1	L 2	D 2	⧄	Art.-No.	€	€
G	1/8 x 28	63	20	7	5.5	25312	5,20	10,40
G	1/4 x 19	70	22	11	9.0	25314	5,70	11,40
G	3/8 x 19	70	22	12	9.0	25316	8,60	17,20
G	1/2 x 14	80	22	16	12.0	25318	11,80	23,60
G	5/8 x 14	80	22	18	14.5	25320	17,20	34,40
G	3/4 x 14	90	22	20	16.0	25322	17,20	34,40
G	7/8 x 14	90	22	22	18.0	25324	29,00	58,00
G	1" x 11	100	25	25	20.0	25326	29,00	58,00
G	1.1/8 x 11	125	40	28	22.0	25330	50,50	101,00
G	1.1/4 x 11	125	40	32	24.0	25334	50,50	101,00
G	1.3/8 x 11	140	40	36	29.0	25338	69,00	138,00
G	1.1/2 x 11	140	40	36	29.0	25342	69,00	138,00
G	1.5/8 x 11	140	40	40	32.0	25346	168,00	336,00
G	1.3/4 x 11	140	40	40	32.0	25350	138,00	276,00
G	2" x 11	160	40	45	35.0	25354	138,00	276,00
G	2.1/4 x 11	160	40	50	39.0	25358	310,00	620,00
G	2.1/2 x 11	160	40	50	39.0	25362	399,00	798,00
G	2.3/4 x 11	160	40	50	39.0	25366	730,00	1.460,00
G	3" x 11	160	40	50	39.0	25370	850,00	1.700,00
G	3.1/2 x 11	180	45	56	44.0	25374	1.340,00	2.680,00
G	4" x 11	180	45	56	44.0	25378	1.670,00	3.340,00

Application:

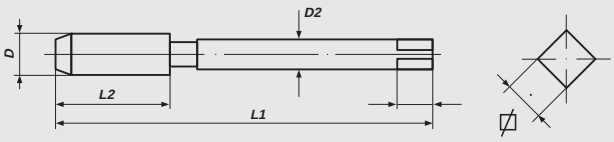
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

Applicazione:

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

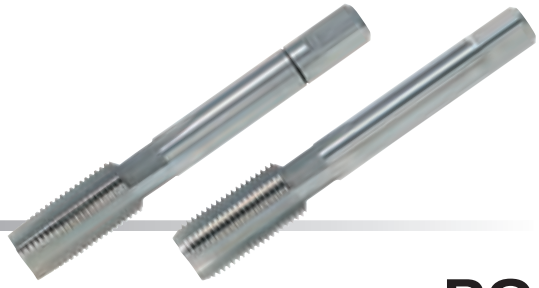
How to order / esempio come ordinare:

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



Hand Taps
armoured tube thread DIN 40 430

Maschi a mano
filettatura per tubi corazzati DIN 40 430



DIN 40432 HSS-G

PG

Nominal Diameter D		L 1	L 2	D 2	⧄	Art.-No.	€	€
PG	7 x 20	70	22	9.0	7.0	25707	10,00	20,00
PG	9 x 18	70	22	12.0	9.0	25709	13,00	26,00
PG	11 x 18	80	22	14.0	11.0	25711	22,00	44,00
PG	13.5 x 18	80	22	16.0	12.0	25713	26,00	52,00
PG	16 x 18	80	22	18.0	14.5	25716	31,50	63,00
PG	21 x 16	90	22	22.0	18.0	25721	43,00	86,00
PG	29 x 16	100	25	28.0	22.0	25729	71,00	142,00
PG	36 x 16	140	40	36.0	29.0	25736	113,00	226,00
PG	42 x 16	140	40	40.0	32.0	25742	177,00	354,00
PG	48 x 16	160	40	45.0	35.0	25748	210,00	420,00

Application:

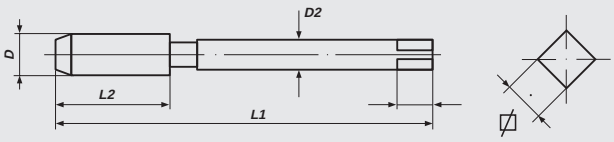
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

Applicazione:

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

How to order / esempio come ordinare:

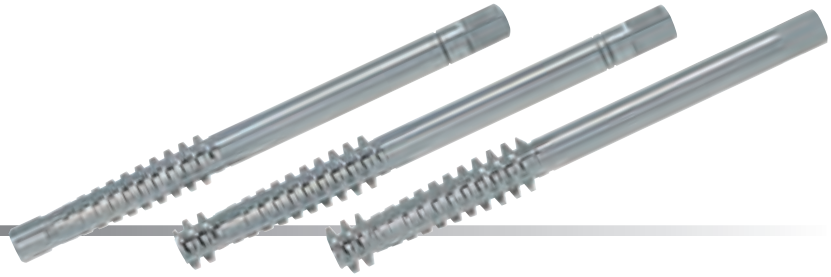
PG 7	=	25707
PG 7, No. 1	=	25707-1
PG 7, No. 2	=	25707-2



VÖLKEL
THREADING SOLUTIONS

Hand Taps
trapezoidal thread DIN 103

Maschi a mano
filettatura trapeziodale metrica ISO 103



HSS-G Tol. 7H

Tr

Nominal Diameter D	L 1	L 2	D 2	⌀	Art.-No.	€	€
Tr 10 x 2	90	34	7	5.5	25108	93,00	279,00
Tr 10 x 3	100	40	7	5.5	25112	93,00	279,00
Tr 12 x 3	110	40	8	6.2	25116	97,00	291,00
Tr 14 x 3	130	45	10	8.0	25120	127,00	381,00
Tr 14 x 4	130	55	10	8.0	25124	127,00	381,00
Tr 16 x 4	140	55	11	9.0	25128	114,00	342,00
Tr 18 x 4	150	55	12	9.0	25132	174,00	522,00
Tr 20 x 4	160	55	14	11.0	25136	185,00	555,00
Tr 22 x 5	175	65	16	12.0	25140	235,00	705,00
Tr 24 x 5	190	65	18	14.5	25144	258,00	774,00
Tr 26 x 5	210	70	20	16.0	25148	286,00	858,00
Tr 28 x 5	220	70	22	18.0	25152	312,00	936,00
Tr 30 x 6	240	80	22	18.0	25156	332,00	996,00
Tr 32 x 6	255	80	25	20.0	25160	405,00	1.215,00

Application:

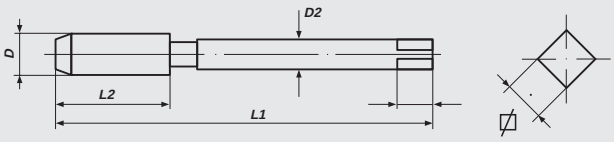
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

Applicazione:

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

How to order / esempio come ordinare:

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



Hand Taps
metric ISO-thread DIN 13

Maschi a mano
filettatura metrica ISO DIN 13

DIN 352 HSS-E Tol. ISO2/6H

M

Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€	€
M 3 x 0.5	40	11	3.5	2.7	57326	4,10	12,30
M 4 x 0.7	45	13	4.5	3.4	57330	4,20	12,60
M 5 x 0.8	50	16	6.0	4.9	57334	4,40	13,20
M 6 x 1.0	50	19	6.0	4.9	57338	4,40	13,20
M 8 x 1.25	56	22	6.0	4.9	57342	5,00	15,00
M 10 x 1.5	70	24	7.0	5.5	57346	6,70	20,10
M 12 x 1.75	75	29	9.0	7.0	57350	8,80	26,40
M 14 x 2.0	80	30	11.0	9.0	57354	11,00	33,00
M 16 x 2.0	80	32	12.0	9.0	57358	13,20	39,60
M 18 x 2.5	95	40	14.0	11.0	57362	16,80	50,40
M 20 x 2.5	95	40	16.0	12.0	57366	19,40	58,20
M 22 x 2.5	100	40	18.0	14.5	57370	25,20	75,60
M 24 x 3.0	110	50	18.0	14.5	57374	29,40	88,20
M 27 x 3.0	110	50	20.0	16.0	57376	47,50	142,50
M 30 x 3.5	125	56	22.0	18.0	57378	65,00	195,00

Application:

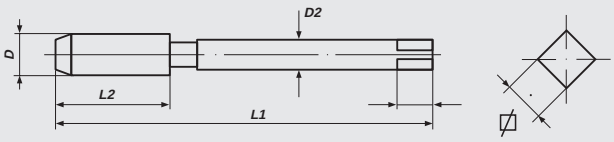
- high cutting ability
- abrasive material
- steels up to 1200 N/mm²
- and general use

Applicazione:

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

How to order / esempio come ordinare:

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



VÖLKEL
THREADING SOLUTIONS

Hand Taps
metric ISO-thread DIN 13
Rougher piloted

Maschi a mano
filettatura metrica ISO DIN 13
Sgrossatore con guida

DIN 352 HSS-E Tol. ISO2/6H

M

Nominal Diameter D	L 1	L 2	D 2	⌀	Art.-No.	€	€
M 3 x 0.5	40	11	3.5	2.7	57726	8,00	24,00
M 4 x 0.7	45	13	4.5	3.4	57730	8,00	24,00
M 5 x 0.8	50	16	6.0	4.9	57734	8,70	26,10
M 6 x 1.0	50	19	6.0	4.9	57738	8,70	26,10
M 8 x 1.25	56	22	6.0	4.9	57742	9,40	28,20
M 10 x 1.5	70	24	7.0	5.5	57746	12,70	38,10
M 12 x 1.75	75	29	9.0	7.0	57750	17,30	51,90

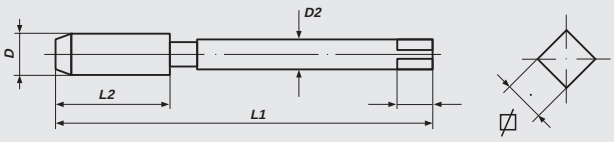
Application:
wear resistant steel up to 1400 N/mm²
- high alloy steel
- heat resistant steel
- stainless steel
- alloy tool steel
- cast iron

Surface treatment: steam tempered

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

Superficie: vaporizzato

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



Hand Taps
metric-fine ISO-thread DIN 13

Maschi a mano
filettatura metrica ISO DIN 13

DIN 2181 HSS-E Tol. ISO2/6H

Mf

Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€	€
M 6 x 0.75	50	14	6.0	4.9	56318	7,60	15,20
M 8 x 0.75	50	19	6.0	4.9	56324	7,60	15,20
M 8 x 1.0	56	22	6.0	4.9	56326	7,60	15,20
M 10 x 1.0	63	20	7.0	5.5	56336	8,30	16,60
M 10 x 1.25	70	24	7.0	5.5	56338	9,60	19,20
M 12 x 1.0	70	22	9.0	7.0	56344	11,50	23,00
M 12 x 1.25	70	22	9.0	7.0	56346	11,50	23,00
M 12 x 1.5	70	22	9.0	7.0	56348	11,50	23,00
M 14 x 1.25	70	22	11.0	9.0	56354	13,30	26,60
M 14 x 1.5	70	22	11.0	9.0	56356	12,10	24,20
M 16 x 1.5	70	22	12.0	9.0	56366	15,30	30,60
M 18 x 1.5	80	22	14.0	11.0	56372	16,00	32,00
M 18 x 2.0	80	22	14.0	11.0	56374	21,30	42,60
M 20 x 1.5	80	22	16.0	12.0	56384	20,00	40,00
M 20 x 2.0	80	22	16.0	12.0	56386	26,80	53,60
M 22 x 1.5	80	22	18.0	14.5	56394	24,90	49,80
M 22 x 2.0	80	22	18.0	14.5	56396	26,80	53,60
M 24 x 1.5	90	22	18.0	14.5	56504	27,80	55,60

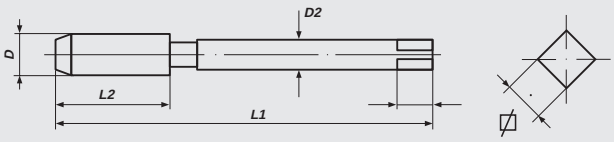
Application:

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

Applicazione:

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

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



VÖLKEL
THREADING SOLUTIONS

Hand Taps
Pipe-thread DIN ISO 228

Maschi a mano
filettatura per tubi gas DIN ISO 228

DIN 5157 HSS-E

G (BSP)

Nominal Diameter D		L 1	L 2	D 2	⧄	Art.-No.	€	€
G	1/8 x 28	63	20	7.0	5.5	55312	7,60	15,20
G	1/4 x 19	70	22	11.0	9.0	55314	9,00	18,00
G	3/8 x 19	70	22	12.0	9.0	55316	13,50	27,00
G	1/2 x 14	80	22	16.0	12.0	55318	18,60	37,20
G	3/4 x 14	90	22	20.0	16.0	55322	25,40	50,80
G	1" x 11	100	25	25.0	20.0	55326	41,50	83,00

Application:

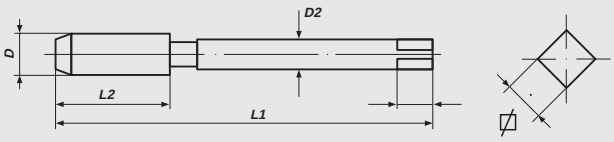
- high cutting ability
- abrasive material
- steels up to 1200 N/mm²
- and general use

Applicazione:

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

How to order / esempio come ordinare:

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



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

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

DIN 352 HSS-G Tol. ISO2/6H

M

Nominal Diameter D		L 1	L 2	D 2	⌀	Art.-No.	€	€
M	3 x 0.5	40	11	3.5	2.7	27026	3,70	11,10
M	4 x 0.7	45	13	4.5	3.4	27030	3,70	11,10
M	5 x 0.8	50	16	6.0	4.9	27034	4,30	12,90
M	6 x 1.0	50	19	6.0	4.9	27038	4,50	13,50
M	8 x 1.25	56	22	6.0	4.9	27042	4,80	14,40
M	10 x 1.5	70	24	7.0	5.5	27046	6,20	18,60
M	12 x 1.75	75	29	9.0	7.0	27050	8,50	25,50
M	14 x 2.0	80	30	11.0	9.0	27054	10,10	30,30
M	16 x 2.0	80	32	12.0	9.0	27058	12,20	36,60
M	18 x 2.5	95	40	14.0	11.0	27062	16,10	48,30
M	20 x 2.5	95	40	16.0	12.0	27066	18,00	54,00
M	22 x 2.5	100	40	18.0	14.5	27070	22,00	66,00
M	24 x 3.0	110	50	18.0	14.5	27074	27,30	81,90
M	27 x 3.0	110	50	20.0	16.0	27076	44,00	132,00
M	30 x 3.5	125	56	22.0	18.0	27078	55,00	165,00
M	33 x 3.5	125	56	25.0	20.0	27080	74,00	222,00
M	36 x 4.0	150	63	28.0	22.0	27082	89,00	267,00
M	39 x 4.0	150	63	32.0	24.0	27084	114,00	342,00
M	42 x 4.5	150	63	32.0	24.0	27086	130,00	390,00
M	45 x 4.5	160	70	36.0	29.0	27088	157,00	471,00
M	48 x 5.0	180	75	36.0	29.0	27090	222,00	666,00
M	52 x 5.0	180	75	40.0	32.0	27092	222,00	666,00

Application:

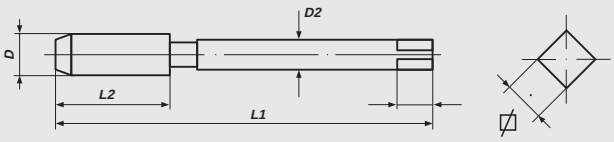
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

Applicazione:

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

How to order / esempio come ordinare:

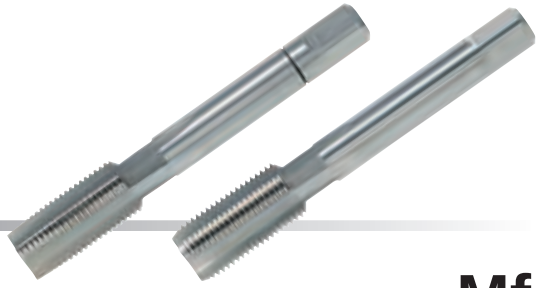
M3	=	27026
M3, No. 1	=	27026-1
M3, No. 2	=	27026-2
M3, No. 3	=	27026-3



VÖLKEL
THREADING SOLUTIONS

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

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



DIN 2181 HSS-G Tol. ISO2/6H

Mf

Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€	€
M 6 x 0.75	50	14	6.0	4.9	26007	8,50	17,00
M 8 x 0.75	50	19	6.0	4.9	26010	8,50	17,00
M 8 x 1.0	56	22	6.0	4.9	26011	8,50	17,00
M 10 x 1.0	63	20	7.0	5.5	26015	8,50	17,00
M 10 x 1.25	70	24	7.0	5.5	26016	9,50	19,00
M 12 x 1.0	70	22	9.0	7.0	26020	12,50	25,00
M 12 x 1.25	70	22	9.0	7.0	26021	12,50	25,00
M 12 x 1.5	70	22	9.0	7.0	26022	11,50	23,00
M 14 x 1.25	70	22	11.0	9.0	26027	14,00	28,00
M 14 x 1.5	70	22	11.0	9.0	26028	12,50	25,00
M 16 x 1.0	70	22	12.0	9.0	26031	21,00	42,00
M 16 x 1.5	70	22	12.0	9.0	26033	15,00	30,00
M 18 x 1.5	80	22	14.0	11.0	26036	17,00	34,00
M 20 x 1.5	80	22	16.0	12.0	26040	21,00	42,00
M 22 x 1.5	80	22	18.0	14.5	26045	27,50	55,00
M 24 x 1.5	90	22	18.0	14.5	26050	30,50	61,00
M 24 x 2.0	90	22	18.0	14.5	26051	39,90	79,80
M 30 x 1.5	90	22	22.0	18.0	26063	81,00	162,00
M 30 x 2.0	90	22	22.0	18.0	26064	81,00	162,00

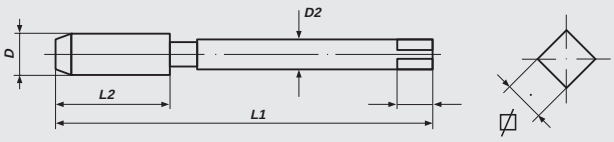
Application:

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

Applicazione:

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

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



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

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

≈ DIN 352 HSS-G

BSW

Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€	€
BSW 1/8 x 40	40	12	3.5	2.7	22006	6,60	19,80
BSW 5/32 x 32	45	14	4.5	3.4	22008	6,60	19,80
BSW 3/16 x 24	50	18	6.0	4.9	22010	6,60	19,80
BSW 1/4 x 20	50	19	6.0	4.9	22014	6,60	19,80
BSW 5/16 x 18	56	22	6.0	4.9	22016	6,90	20,70
BSW 3/8 x 16	70	24	7.0	5.5	22018	8,00	24,00
BSW 7/16 x 14	70	24	8.0	6.2	22020	9,80	29,40
BSW 1/2 x 12	75	29	9.0	7.0	22022	11,70	35,10
BSW 9/16 x 12	80	30	11.0	9.0	22024	15,30	45,90
BSW 5/8 x 11	80	32	12.0	9.0	22026	17,30	51,90
BSW 3/4 x 10	95	40	14.0	11.0	22030	23,10	69,30
BSW 7/8 x 9	100	40	18.0	14.5	22034	28,80	86,40
BSW 1" x 8	110	50	18.0	14.5	22038	34,60	103,80

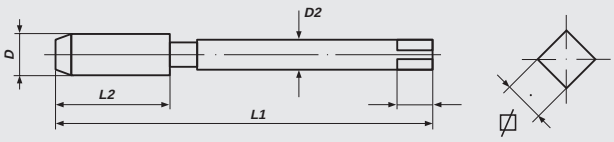
Application:

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

Applicazione:

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

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



VÖLKEL
THREADING SOLUTIONS

Hand Taps, *Left Hand*
Unified thread ANSI B 1.1

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

≈ DIN 352 HSS-G Tol. 2B

UNC / UNF

Nominal Diameter D		L 1	L 2	D 2	⊡	Art.-No.	€	€
UNC 3-pcs								
UNC	Nr. 6 x 32	45	14	4.0	3.0	23006	10,40	31,20
UNC	Nr. 8 x 32	45	14	4.5	3.4	23008	10,40	31,20
UNC	Nr. 10 x 24	50	16	6.0	4.9	23010	10,40	31,20
UNC	Nr. 12 x 24	50	18	6.0	4.9	23012	10,40	31,20
UNC	1/4 x 20	50	19	6.0	4.9	23014	6,60	19,80
UNC	5/16 x 18	56	22	6.0	4.9	23016	6,90	20,70
UNC	3/8 x 16	70	24	7.0	5.5	23018	8,00	24,00
UNC	7/16 x 14	70	24	8.0	6.2	23020	9,80	29,40
UNC	1/2 x 13	75	29	9.0	7.0	23022	11,70	35,10
UNC	9/16 x 12	80	30	11.0	9.0	23024	15,30	45,90
UNC	5/8 x 11	80	32	12.0	9.0	23026	17,30	51,90
UNC	3/4 x 10	95	40	14.0	11.0	23030	23,10	69,30
UNC	7/8 x 9	100	40	18.0	14.5	23034	28,80	86,40
UNC	1" x 8	110	50	18.0	14.5	23038	34,60	103,80
UNF 2-pcs								
UNF	Nr. 10 x 32	45	14	6.0	4.9	24010	10,40	20,80
UNF	1/4 x 28	50	18	6.0	4.9	24014	6,60	13,20
UNF	5/16 x 24	56	22	6.0	4.9	24016	6,90	13,80
UNF	3/8 x 24	63	22	7.0	5.5	24018	8,00	16,00
UNF	7/16 x 20	63	22	8.0	6.2	24020	9,80	19,60
UNF	1/2 x 20	75	24	9.0	7.0	24022	11,70	23,40
UNF	9/16 x 18	80	28	11.0	9.0	24024	15,30	30,60
UNF	5/8 x 18	80	28	12.0	9.0	24026	17,30	34,60
UNF	3/4 x 16	95	32	14.0	11.0	24030	23,10	46,20
UNF	7/8 x 14	100	36	18.0	14.5	24034	28,80	57,60
UNF	1" x 12	110	40	18.0	14.5	24038	34,60	69,20

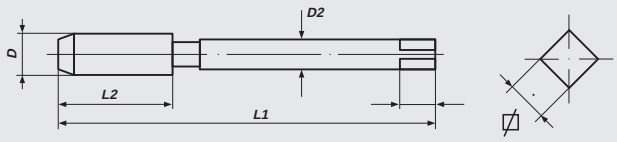
Application:

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

Applicazione:

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

How to order/esempio come ordinare:
UNC 1/4 = 23014
UNC 1/4, No. 1 = 23014-1
UNC 1/4, No. 2 = 23014-2
UNC 1/4, No. 3 = 23014-3



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

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

DIN 5157 HSS-G

G (BSP)

Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€	€
G 1/8 x 28	63	20	7.0	5.5	25012	8,00	16,00
G 1/4 x 19	70	22	11.0	9.0	25014	9,00	18,00
G 3/8 x 19	70	22	12.0	9.0	25016	13,00	26,00
G 1/2 x 14	80	22	16.0	12.0	25018	17,00	34,00
G 5/8 x 14	80	22	18.0	14.5	25020	26,00	52,00
G 3/4 x 14	90	22	20.0	16.0	25022	26,00	52,00
G 1" x 11	100	25	25.0	20.0	25026	44,00	88,00
G 1.1/8 x 11	125	40	28.0	22.0	25030	76,00	152,00
G 1.1/4 x 11	125	40	32.0	24.0	25034	76,00	152,00
G 1.3/8 x 11	140	40	36.0	29.0	25038	100,50	201,00
G 1.1/2 x 11	140	40	36.0	29.0	25042	100,50	201,00
G 1.3/4 x 11	140	40	40.0	32.0	25050	207,00	414,00
G 2" x 11	160	40	45.0	35.0	25054	207,00	414,00

Application:

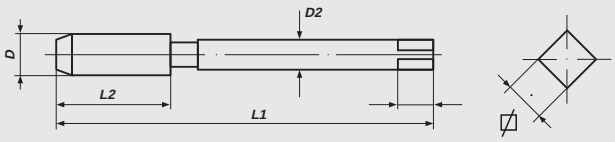
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

Applicazione:

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

How to order / esempio come ordinare:

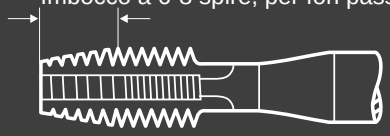
G 1/4	=	25014
G 1/4, No. 1	=	25014-1
G 1/4, No. 2	=	25014-2



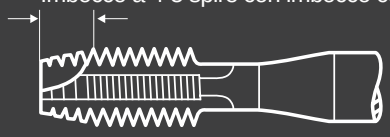
SHORT MACHINE TAPS
MASCHI A MACCHINA CORTI

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

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

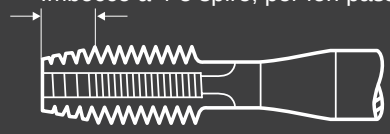


Form B
4-5 Threads Lead with Spiral Point for through holes
Imbocco a 4-5 spire con imbocco corretto, per tutti i fori passanti



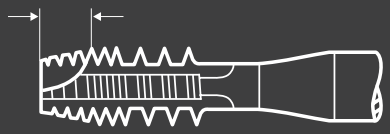
Form C
2-3 Threads Lead, for blind holes
Imbocco a 2-3 spire, per fori ciechi

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



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

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



SHORT MACHINE TAPS
MASCHI A MACCHINA CORTI

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

VÖLKEL
THREADING SOLUTIONS

Short Machine Taps
metric ISO-thread DIN 13

Maschi a macchina corti
filettatura metrica ISO DIN 13

DIN 352 HSS-E Tol. ISO2/6H

M

Nominal Diameter D		L 1	L 2	D 2	⧄	Art.-No.	€
Spiral Point / Forma B con imbocco corretto							
M	3 x 0.5	40	11	3.5	2.7	61526	3,60
M	4 x 0.7	45	13	4.5	3.4	61530	3,60
M	5 x 0.8	48	16	6.0	4.9	61534	3,70
M	6 x 1.0	50	19	6.0	4.9	61538	4,00
M	8 x 1.25	56	22	6.0	4.9	61542	4,70
M	10 x 1.5	70	24	7.0	5.5	61546	5,70
M	12 x 1.75	75	29	9.0	7.0	61550	8,20
M	14 x 2.0	80	30	11.0	9.0	61554	9,70
M	16 x 2.0	80	32	12.0	9.0	61558	13,50
M	18 x 2.5	95	40	14.0	11.0	61562	16,50
M	20 x 2.5	95	40	16.0	12.0	61566	18,30
M	22 x 2.5	100	40	18.0	14.5	61570	26,00
M	24 x 3.0	110	50	18.0	14.5	61574	29,00
35° Spiral Flute / Forma C, spirale destra a 35°							
M	3 x 0.5	40	11	3.5	2.7	61726	4,50
M	4 x 0.7	45	13	4.5	3.4	61730	4,50
M	5 x 0.8	48	16	6.0	4.9	61734	4,80
M	6 x 1.0	50	19	6.0	4.9	61738	5,00
M	8 x 1.25	56	22	6.0	4.9	61742	5,70
M	10 x 1.5	70	24	7.0	5.5	61746	6,80
M	12 x 1.75	75	29	9.0	7.0	61750	8,80
with interrupted threads / Forma B, con denti alternati							
M	3 x 0.5	40	11	3.5	2.7	61926	5,60
M	4 x 0.7	45	13	4.5	3.4	61930	5,60
M	5 x 0.8	48	16	6.0	4.9	61934	5,80
M	6 x 1.0	50	19	6.0	4.9	61938	5,80
M	8 x 1.25	56	22	6.0	4.9	61942	6,20
M	10 x 1.5	70	24	7.0	5.5	61946	7,70
M	12 x 1.75	75	29	9.0	7.0	61950	9,60

Application

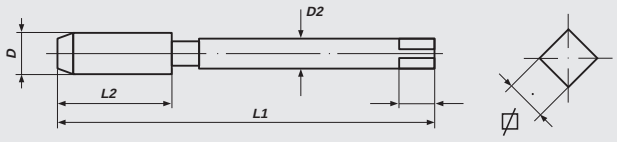
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for thread cutting by hand and machine

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

Applicazione:

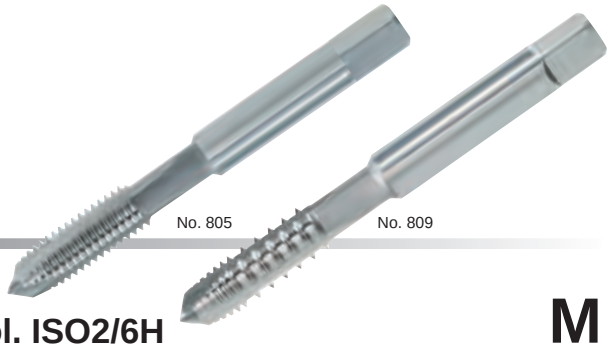
per uso universale
- Materiali con buona truciodibilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per uso manuale e con macchina

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



Machine Taps
metric ISO-thread DIN 13

Maschi a macchina corti
filettatura metrica ISO DIN 13



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

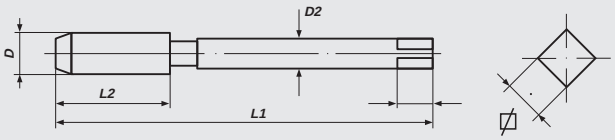
Nominal Diameter D		L 1	L 2	D 2	⧄	Art.-No.	€
M	2 x 0.4	41.0	8.0	2.50	2.00	80516	6,20
M	2.5 x 0.45	44.5	9.5	2.80	2.24	80522	6,20
M	2.6 x 0.45	44.5	9.5	2.90	2.24	80524	6,20
M	3 x 0.5	48.0	11.0	3.15	2.50	80526	3,65
M	3.5 x 0.6	50.0	13.0	3.55	2.80	80528	3,85
M	4 x 0.7	53.0	13.0	4.00	3.15	80530	3,65
M	5 x 0.8	58.0	16.0	5.00	4.00	80534	3,95
M	6 x 1.0	66.0	19.0	6.30	5.00	80538	4,10
M	8 x 1.25	72.0	22.0	8.00	6.30	80542	5,20
M	10 x 1.5	80.0	24.0	10.00	8.00	80546	6,40
M	12 x 1.75	89.0	29.0	9.00	7.10	80550	9,00
M	14 x 2.0	95.0	30.0	11.20	9.00	80554	10,30
M	16 x 2.0	102.0	32.0	12.50	10.00	80558	12,70
M	18 x 2.5	110.0	37.0	14.00	11.20	80562	18,20
M	20 x 2.5	112.0	37.0	14.00	11.20	80566	20,50
M	22 x 2.5	118.0	38.0	16.00	12.50	80570	24,20
M	24 x 3.0	130.0	45.0	18.00	14.00	80574	27,50
M	27 x 3.0	135.0	45.0	20.00	16.00	80576	38,50
M	30 x 3.5	138.0	48.0	20.00	16.00	80578	51,00
with interrupted threads / con denti alternati							
M	3 x 0.5	48.0	11.0	3.15	2.50	80926	5,50
M	4 x 0.7	53.0	13.0	4.00	3.15	80930	5,50
M	5 x 0.8	58.0	16.0	5.00	4.00	80934	5,75
M	6 x 1.0	66.0	19.0	6.30	5.00	80938	5,75
M	7 x 1.0	66.0	19.0	7.10	5.60	80940	6,95
M	8 x 1.25	72.0	22.0	8.00	6.30	80942	6,05
M	10 x 1.5	80.0	24.0	10.0	8.00	80946	7,60
M	12 x 1.75	89.0	29.0	9.00	7.10	80950	9,70
M	14 x 2.0	95.0	30.0	11.20	9.00	80954	13,10
M	16 x 2.0	102.0	32.0	12.50	10.00	80958	14,70
M	18 x 2.5	110.0	37.0	14.00	11.20	80962	22,00
M	20 x 2.5	112.0	37.0	14.00	11.20	80966	25,30
M	22 x 2.5	118.0	38.0	16.00	12.50	80970	28,60
M	24 x 3.0	130.0	45.0	18.00	14.00	80974	32,00

Application:

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

Applicazione:

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



VÖLKEL
THREADING SOLUTIONS

Machine Taps
metric ISO-thread DIN 13

Maschi a macchina corti
filettatura metrica ISO DIN 13

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

M

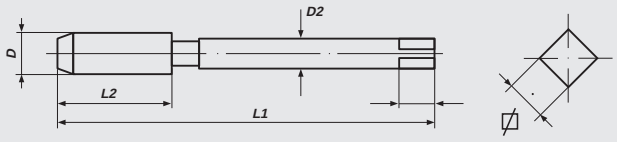
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
M 2.5 x 0.45	44.5	9.5	2.80	2.24	80722	7,90
M 2.6 x 0.45	44.5	9.5	2.90	2.24	80724	7,90
M 3 x 0.5	48.0	11.0	3.15	2.50	80726	4,75
M 4 x 0.7	53.0	13.0	4.00	3.15	80730	4,75
M 5 x 0.8	58.0	16.0	5.00	4.00	80734	4,75
M 6 x 1.0	66.0	19.0	6.30	5.00	80738	4,85
M 8 x 1.25	72.0	22.0	8.00	6.30	80742	5,75
M 10 x 1.5	80.0	24.0	10.00	8.00	80746	7,40
M 12 x 1.75	89.0	29.0	9.00	7.10	80750	9,60
M 14 x 2.0	95.0	30.0	11.20	9.00	80754	13,10
M 16 x 2.0	102.0	32.0	12.50	10.00	80758	14,70
M 18 x 2.5	110.0	37.0	14.00	11.20	80762	22,00
M 20 x 2.5	112.0	37.0	14.00	11.20	80766	25,30
M 22 x 2.5	118.0	38.0	16.00	12.50	80770	28,60
M 24 x 3.0	130.0	45.0	18.00	14.00	80774	32,00
M 27 x 3.0	135.0	45.0	20.00	16.00	80776	46,50
M 30 x 3.5	138.0	48.0	20.00	16.00	80778	60,50

Application:

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

Applicazione:

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



Short Machine Taps
metric-fine ISO-thread DIN 13

Maschi a macchina corti
filettatura metrica fine ISO DIN 13

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

Mf

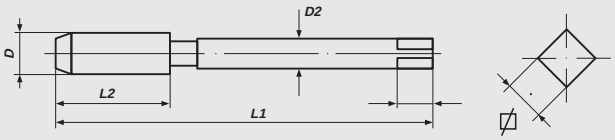
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
M 6 x 0.75	50	14	6.0	4.9	66318	5,70
M 8 x 0.75	50	19	6.0	4.9	66324	5,70
M 8 x 1.0	56	22	6.0	4.9	66326	5,70
M 9 x 0.75	56	19	7.0	5.5	66328	6,40
M 9 x 1.0	63	20	7.0	5.5	66330	6,40
M 10 x 0.75	63	20	7.0	5.5	66332	6,40
M 10 x 1.0	63	20	7.0	5.5	66336	5,70
M 10 x 1.25	70	24	7.0	5.5	66338	6,40
M 12 x 1.0	70	22	9.0	7.0	66344	8,30
M 12 x 1.25	70	22	9.0	7.0	66346	8,30
M 12 x 1.5	70	22	9.0	7.0	66348	7,50
M 13 x 1.0	70	22	11.0	9.0	66350	12,70
M 13 x 1.5	70	22	11.0	9.0	66351	12,70
M 14 x 1.0	70	22	11.0	9.0	66353	12,70
M 14 x 1.25	70	22	11.0	9.0	66354	9,50
M 14 x 1.5	70	22	11.0	9.0	66356	8,20
M 15 x 1.5	70	22	12.0	9.0	66360	14,00
M 16 x 1.5	70	22	12.0	9.0	66366	10,00
M 18 x 1.0	80	22	14.0	11.0	66370	15,30
M 18 x 1.5	80	22	14.0	11.0	66372	11,50
M 20 x 1.5	80	22	16.0	12.0	66384	14,00
M 20 x 2.0	80	22	16.0	12.0	66386	19,20
M 22 x 1.5	80	22	18.0	14.5	66394	19,90
M 22 x 2.0	80	22	18.0	14.5	66396	19,90
M 24 x 1.5	90	22	18.0	14.5	66504	20,00
M 24 x 2.0	90	22	18.0	14.5	66506	26,70
M 25 x 1.5	90	22	18.0	14.5	66508	39,00
M 26 x 1.5	90	22	18.0	14.5	66512	39,00
M 27 x 1.5	90	22	20.0	16.0	66517	39,00
M 28 x 1.5	90	22	20.0	16.0	66522	46,00
M 30 x 1.5	90	22	22.0	18.0	66530	54,00
M 30 x 2.0	90	22	22.0	18.0	66532	54,00
M 32 x 1.5	90	22	22.0	18.0	66536	54,00

Application:

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

Applicazione:

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



Short Machine Taps
Whitworth-thread BS 84

Maschi a macchina corti
filettatura Whitworth BS 84

≈ **DIN 352** **Form D** **HSS-G** **BSW**

Nominal Diameter S	L 1	L 2	D 2	⧄	Art.-No.	€
BSW 1/8 x 40	40	12	3.5	2.7	62306	4,10
BSW 3/16 x 24	50	18	6.0	4.9	62310	4,00
BSW 1/4 x 20	50	19	6.0	4.9	62314	4,00
BSW 5/16 x 18	56	22	6.0	4.9	62316	4,50
BSW 3/8 x 16	70	24	7.0	5.5	62318	5,00
BSW 7/16 x 14	70	24	8.0	6.2	62320	6,30
BSW 1/2 x 12	75	29	9.0	7.0	62322	7,60
BSW 9/16 x 12	80	30	11.0	9.0	62324	10,00
BSW 5/8 x 11	80	32	12.0	9.0	62326	11,20
BSW 3/4 x 10	95	40	14.0	11.0	62330	15,00
BSW 7/8 x 9	100	40	18.0	14.5	62334	20,00
BSW 1" x 8	110	50	18.0	14.5	62338	23,00

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

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

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

Nominal Diameter S	L 1	L 2	D 2	⧄	Art.-No.	€
W 19,8 x 14	90	32	16	12	62397	136,00
W 28,8 x 14	100	40	20	16	62398	152,00
W 31,3 x 14	110	40	22	18	62399	175,00

Short Machine Taps
Unified Coarse and Fine thread ANSI B 1.1

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

≈ DIN 352 Form D HSS-G Tol. 2B

UNC / UNF

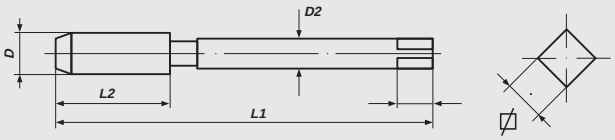
Nominal Diameter S	L 1	L 2	D 2	⧄	Art.-No.	€
UNC						
UNC 1/4 x 20	50	19	6.0	4.9	63314	4,00
UNC 5/16 x 18	56	22	6.0	4.9	63316	4,50
UNC 3/8 x 16	70	24	7.0	5.5	63318	5,00
UNC 7/16 x 14	70	24	8.0	6.2	63320	6,30
UNC 1/2 x 13	75	29	9.0	7.0	63322	7,60
UNC 9/16 x 12	80	30	11.0	9.0	63324	10,00
UNC 5/8 x 11	80	32	12.0	9.0	63326	11,20
UNC 3/4 x 10	95	40	14.0	11.0	63330	15,00
UNC 7/8 x 9	100	40	18.0	14.5	63334	20,00
UNC 1" x 8	110	50	18.0	14.5	63338	23,00
UNF						
UNF 1/4 x 28	50	18	6.0	4.9	64314	4,00
UNF 5/16 x 24	56	22	6.0	4.9	64316	4,50
UNF 3/8 x 24	63	22	7.0	5.5	64318	5,00
UNF 7/16 x 20	63	22	8.0	6.2	64320	6,30
UNF 1/2 x 20	75	24	9.0	7.0	64322	7,60
UNF 9/16 x 18	80	28	11.0	9.0	64324	10,00
UNF 5/8 x 18	80	28	12.0	9.0	64326	11,20
UNF 3/4 x 16	95	32	14.0	11.0	64330	15,00
UNF 7/8 x 14	100	36	18.0	14.5	64334	20,00
UNF 1" x 12	110	40	18.0	14.5	64338	23,00

Application:

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

Applicazione:

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



VÖLKEL
THREADING SOLUTIONS

Short Machine Taps
Pipe-thread DIN ISO 228

Maschi a macchina corti
filettatura per tubi gas DIN ISO 228

DIN 5157 Form D HSS-G

G (BSP)

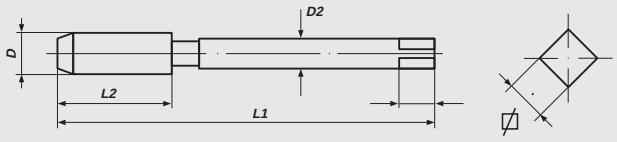
Nominal Diameter S		L 1	L 2	D 2	⧄	Art.-No.	€
G	1/8 x 28	63	20	7	5.5	65312	5,20
G	1/4 x 19	70	22	11	9.0	65314	5,70
G	3/8 x 19	70	22	12	9.0	65316	8,60
G	1/2 x 14	80	22	16	12.0	65318	11,80
G	3/4 x 14	90	22	20	16.0	65322	17,20
G	1" x 11	100	25	25	20.0	65326	29,00
G	1.1/4 x 11	125	40	32	24.0	65334	50,50
G	1.1/2 x 11	140	40	36	29.0	65342	69,00
G	1.3/4 x 11	140	40	40	32.0	65350	138,00
G	2" x 11	160	40	45	35.0	65354	138,00
G	2.1/4 x 11	160	40	50	39.0	65358	310,00
G	2.1/2 x 11	160	40	50	39.0	65362	399,00
G	2.3/4 x 11	160	40	50	39.0	65366	730,00
G	3" x 11	160	40	50	39.0	65370	850,00
G	3.1/2 x 11	180	45	56	44.0	65374	1.340,00
G	4" x 11	180	45	56	44.0	65378	1.670,00

Application:

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

Applicazione:

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



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

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

HSS-G

Rc (BSPT)

Nominal Diameter S	L 1	L 2	D 2	⊡	Art.-No.	€
Form C						
PT 1/8 x 28	65	19.0	7.0	5.5	63712	7,50
PT 1/4 x 19	70	25.0	11.0	9.0	63714	8,70
PT 3/8 x 19	75	26.0	12.0	9.0	63716	13,80
PT 1/2 x 14	80	31.0	16.0	12.0	63718	17,30
PT 3/4 x 14	100	33.0	20.0	16.0	63722	25,40
PT 1" x 11	110	38.0	25.0	20.0	63726	38,30
Form B, Spiral Point / con imbocco corretto						
PT 1/16 x 28	55	17.5	8.0	6.0	97502	7,20
PT 1/8 x 28	55	19.0	8.0	6.0	97506	7,40
PT 1/4 x 19	62	28.0	11.0	9.0	97514	8,60
PT 3/8 x 19	65	28.0	14.0	11.0	97518	15,40
PT 1/2 x 14	80	35.0	18.0	14.0	97522	22,00
PT 3/4 x 14	85	35.0	23.0	17.0	97530	33,00
PT 1" x 11	95	45.0	26.0	21.0	97538	48,50
PT 1.1/4 x 11	105	45.0	32.0	26.0	97546	73,00
PT 1.1/2 x 11	110	45.0	38.0	29.0	97554	105,00
PT 2" x 11	120	50.0	46.0	35.0	97570	175,00
Form C, 35° Spiral Flute / spirale destra a 35°,						
PT 1/16 x 28	55	17.5	8.0	6.0	97702	7,50
PT 1/8 x 28	55	19.0	8.0	6.0	97706	7,80
PT 1/4 x 19	62	28.0	11.0	9.0	97714	9,00
PT 3/8 x 19	65	28.0	14.0	11.0	97718	16,00
PT 1/2 x 14	80	35.0	18.0	14.0	97722	23,00
PT 3/4 x 14	85	35.0	23.0	17.0	97730	34,50
PT 1" x 11	95	45.0	26.0	21.0	97738	51,00
PT 1.1/4 x 11	105	45.0	32.0	26.0	97746	76,50
PT 1.1/2 x 11	110	45.0	38.0	29.0	97754	110,00
PT 2" x 11	120	50.0	46.0	35.0	97770	184,00

Application:

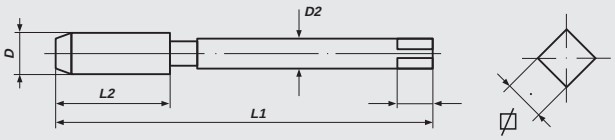
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for thread cutting by hand and machine

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

Applicazione:

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

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



VÖLKEL
THREADING SOLUTIONS

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

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

HSS-G

Rp (BSPP)

Nominal Diameter S	L 1	L 2	D 2	⧄	Art.-No.	€
Form C						
PS 1/16 x 28	55	19	6.5	5.0	95402	6,30
PS 1/8 x 28	55	19	8.0	6.0	95406	6,30
PS 1/4 x 19	62	28	11.0	9.0	95414	7,60
PS 3/8 x 19	65	28	14.0	11.0	95418	12,00
PS 1/2 x 14	80	35	18.0	14.0	95422	19,20
PS 3/4 x 14	85	35	23.0	17.0	95430	33,20
PS 1" x 11	95	45	26.0	21.0	95438	40,80
PS 1.1/4 x 11	105	45	32.0	26.0	95446	61,70
PS 1.1/2 x 11	110	45	38.0	29.0	95454	85,70
PS 2" x 11	120	50	46.0	35.0	95470	120,00
Form C, 35° Spiral Flute / spirale destra a 35°						
PS 1/16 x 28	55	19	6.5	5.0	95702	6,90
PS 1/8 x 28	55	19	8.0	6.0	95706	6,90
PS 1/4 x 19	62	28	11.0	9.0	95714	8,00
PS 3/8 x 19	65	28	14.0	11.0	95718	13,00
PS 1/2 x 14	80	35	18.0	14.0	95722	21,00
PS 3/4 x 14	85	35	23.0	17.0	95730	30,00
PS 1" x 11	95	45	26.0	21.0	95738	45,00
PS 1.1/4 x 11	105	45	32.0	26.0	95746	67,50
PS 1.1/2 x 11	110	45	38.0	29.0	95754	94,00
PS 2" x 11	120	50	46.0	35.0	95770	130,00

Application:

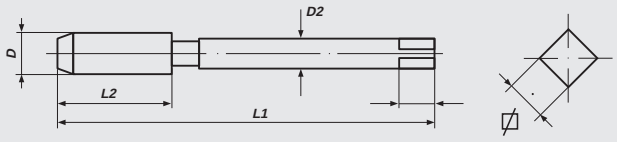
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for thread cutting by hand and machine

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

Applicazione:

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

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



Short Machine Taps
armoured tube thread DIN 40 430

Maschi a macchina corti
filettatura per tubi corazzati DIN 40 430

DIN 40432 Form D HSS-G

PG

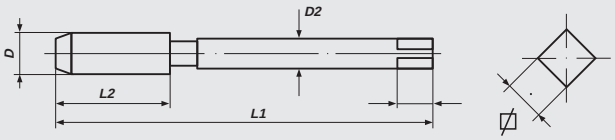
Nominal Diameter S	L 1	L 2	D 2	⊡	Art.-No.	€
PG 7 x 20	70	22	9.0	7.0	65707	10,00
PG 9 x 18	70	22	12.0	9.0	65709	13,00
PG 11 x 18	80	22	14.0	11.0	65711	22,00
PG 13.5 x 18	80	22	16.0	12.0	65713	26,00
PG 16 x 18	80	22	18.0	14.5	65716	31,50
PG 21 x 16	90	22	22.0	18.0	65721	43,00
PG 29 x 16	100	25	28.0	22.0	65729	71,00
PG 36 x 16	140	40	36.0	29.0	65736	113,00
PG 42 x 16	140	40	40.0	32.0	65742	177,00
PG 48 x 16	160	40	45.0	35.0	65748	210,00

Application:

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

Applicazione:

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



VÖLKEL
THREADING SOLUTIONS

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

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

HSS-G

NPT

Nominal Diameter S	L 1	L 2	D 2	⧄	Art.-No.	€
Form C						
NPT 1/16 x 27	65	19	7	5.5	63510	15,00
NPT 1/8 x 27	65	19	7	5.5	63512	12,50
NPT 1/4 x 18	70	25	11	9.0	63514	14,00
NPT 3/8 x 18	75	26	12	9.0	63516	19,00
NPT 1/2 x 14	80	31	16	12.0	63518	24,00
NPT 3/4 x 14	100	33	20	16.0	63522	32,00
NPT 1" x 11.5	110	38	25	20.0	63526	50,00
NPT 1.1/4 x 11.5	125	41	32	24.0	63534	76,00
NPT 1.1/2 x 11.5	140	42	36	29.0	63542	143,00
NPT 2" x 11.5	160	44	36	29.0	63554	176,00
Form B, Spiral Point / con imbocco corretto						
NPT 1/16 x 27	55	17.5	8.0	6.0	98502	18,30
NPT 1/8 x 27	55	19.0	8.0	6.0	98506	14,60
NPT 1/4 x 18	62	28.0	11.0	9.0	98514	16,50
NPT 3/8 x 18	65	28.0	14.0	11.0	98518	22,00
NPT 1/2 x 14	80	35.0	18.0	14.0	98522	27,50
NPT 3/4 x 14	85	35.0	23.0	17.0	98530	36,70
NPT 1" x 11.5	95	45.0	26.0	21.0	98538	58,80
NPT 1.1/4 x 11.5	105	45.0	32.0	26.0	98546	88,00
NPT 1.1/2 x 11.5	110	45.0	38.0	29.0	98554	146,00
NPT 2" x 11.5	120	50.0	46.0	35.0	98570	183,00
Form C, 35° Spiral Flute / spirale destra a 35°						
NPT 1/16 x 27	55	17.5	8.0	6.0	98702	19,20
NPT 1/8 x 27	55	19.0	8.0	6.0	98706	15,30
NPT 1/4 x 18	62	28.0	11.0	9.0	98714	17,30
NPT 3/8 x 18	65	28.0	14.0	11.0	98718	23,10
NPT 1/2 x 14	80	35.0	18.0	14.0	98722	28,90
NPT 3/4 x 14	85	35.0	23.0	17.0	98730	38,50
NPT 1" x 11.5	95	45.0	26.0	21.0	98738	61,70
NPT 1.1/4 x 11.5	105	45.0	32.0	26.0	98746	92,40
NPT 1.1/2 x 11.5	110	45.0	38.0	29.0	98754	153,00
NPT 2" x 11.5	120	50.0	46.0	35.0	98770	192,00

Application:

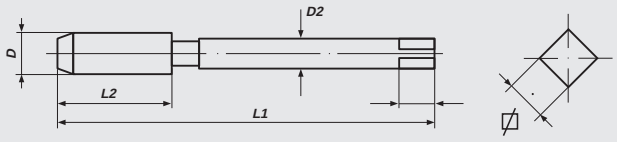
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for thread cutting by hand and machine

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

Applicazione:

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

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



Short Machine Taps, *Left Hand*

american tapered pipe thread, taper 1:16

Maschi a macchina corti, *filetto sinistro*

filettatura americana conica per tubi, cono 1:16

Form C HSS-G

NPT

Nominal Diameter S	L 1	L 2	D 2	⧄	Art.-No.	€
NPT 1/8 x 27	65	19	7	5.5	63002	19,00
NPT 1/4 x 18	70	25	11	9.0	63003	20,50
NPT 3/8 x 18	75	26	12	9.0	63004	29,00
NPT 1/2 x 14	80	31	16	12.0	63005	36,00
NPT 3/4 x 14	100	33	20	16.0	63007	47,00
NPT 1" x 11.5	110	38	25	20.0	63009	76,00
NPT 1.1/4 x 11.5	125	41	32	24.0	63011	114,00
NPT 1.1/2 x 11.5	140	42	36	29.0	63013	215,00

Application:

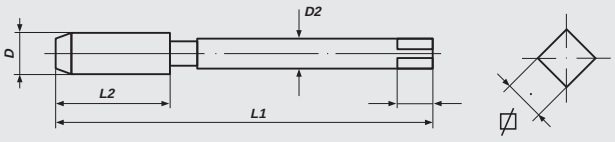
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for thread cutting by hand and machine

Form C: for through and blind holes

Applicazione:

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

Forma C: per fori passanti e ciechi



VÖLKEL
THREADING SOLUTIONS

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

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

HSS-E

NPTF

Nominal Diameter S	L 1	L 2	D 2	⧄	Art.-No.	€
Form B, Spiral Point / con imbocco corretto						
NPTF 1/16 x 27	55	19	6.5	5.0	98571	18,30
NPTF 1/8 x 27	55	19	8.0	6.0	98572	14,60
NPTF 1/4 x 18	62	28	11.0	9.0	98574	16,50
NPTF 3/8 x 18	65	28	14.0	11.0	98576	22,00
NPTF 1/2 x 14	80	35	18.0	14.0	98578	27,50
NPTF 3/4 x 14	85	35	23.0	17.0	98580	36,70
NPTF 1" x 11.5	95	45	26.0	21.0	98582	59,00
NPTF 1.1/4 x 11.5	105	45	32.0	26.0	98584	88,00
NPTF 1.1/2 x 11.5	110	45	38.0	29.0	98586	146,00
NPTF 2" x 11.5	120	50	46.0	35.0	98588	183,00
Form C, 35° Spiral Flute / spirale destra a 35°						
NPTF 1/8 x 27	55	19	8.0	6.0	98772	15,30
NPTF 1/4 x 18	62	28	11.0	9.0	98774	17,30
NPTF 3/8 x 18	65	28	14.0	11.0	98776	23,10
NPTF 1/2 x 14	80	35	18.0	14.0	98778	28,90
NPTF 3/4 x 14	85	35	23.0	17.0	98780	28,50
NPTF 1" x 11.5	95	45	26.0	21.0	98782	61,70

Application:

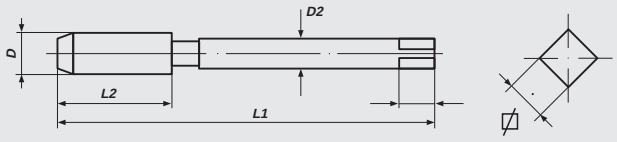
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for thread cutting by hand and machine

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

Applicazione:

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

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



Short Machine Taps
american tapered pipe thread

Maschi a macchina corti
filettatura americana cilindrica per tubi

HSS-E

NPS

Nominal Diameter S	L 1	L 2	D 2	⧄	Art.-No.	€
Form C						
NPS 1/16 x 27	54	17.5	8.0	6.0	99402	15,40
NPS 1/8 x 27	55	19.0	8.0	6.0	99406	13,20
NPS 1/4 x 18	62	28.0	11.0	9.0	99414	14,90
NPS 3/8 x 18	65	28.0	14.0	11.0	99418	18,70
NPS 1/2 x 14	80	35.0	18.0	14.0	99422	23,10
NPS 3/4 x 14	85	35.0	23.0	17.0	99430	30,50
NPS 1" x 11.5	95	45.0	26.0	21.0	99438	48,60
NPS 1.1/4 x 11.5	105	45.0	32.0	26.0	99446	73,00
NPS 1.1/2 x 11.5	110	45.0	38.0	29.0	99454	155,00
NPS 2" x 11.5	120	50.0	46.0	35.0	99470	250,00
Form C, 35° Spiral Flute / spirale destra a 35°						
NPS 1/16 x 27	54	17.5	8.0	6.0	99702	17,20
NPS 1/8 x 27	55	19.0	8.0	6.0	99706	15,00
NPS 1/4 x 18	62	28.0	11.0	9.0	99714	16,50
NPS 3/8 x 18	65	28.0	14.0	11.0	99718	21,00
NPS 1/2 x 14	80	35.0	18.0	14.0	99722	27,50
NPS 3/4 x 14	85	35.0	23.0	17.0	99730	34,50
NPS 1" x 11.5	95	45.0	26.0	21.0	99738	59,00
NPS 1.1/4 x 11.5	105	45.0	32.0	26.0	99746	89,00
NPS 1.1/2 x 11.5	110	45.0	38.0	29.0	99754	177,00
NPS 2" x 11.5	120	50.0	46.0	35.0	99770	275,00

Application:

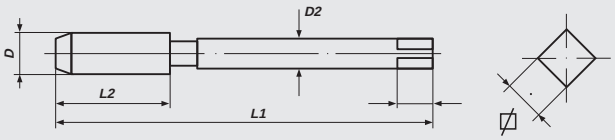
for general
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for thread cutting by hand and machine

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

Applicazione:

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

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



HEX TAP DS

Benefit:

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

Vantaggi

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

BIT EDITION
EDIZIONE BIT

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

HexTap S

Technical Information:

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

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

HexTap S

Informazioni tecniche:

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

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

HexTap DS

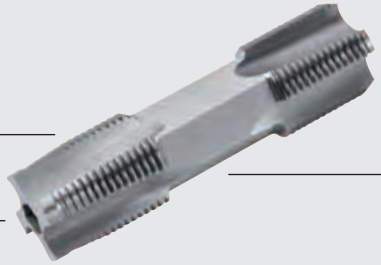
Application:

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

HexTap DS

Applicazione:

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



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

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

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

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

HSS-G Tol. ISO2/6H M

Size	Typ	L 1	L 2	SW1	Art.-No.	€
M 3	S	33.0	11	1/4"	67026	3,30
M 3.5	S	33.5	10	1/4"	67028	4,40
M 4	S	35.0	12	1/4"	67030	3,30
M 4.5	S	35.0	12	1/4"	67032	4,40
M 5	S	36.0	15	1/4"	67034	4,10
M 5.5	S	35.0	15	1/4"	67036	5,00
M 6	S	39.0	18	1/4"	67038	4,10
M 7	S	37.5	16	1/4"	67040	5,00
M 8	S	40.0	19	1/4"	67042	5,90
M 9	S	40.5	18	1/4"	67044	8,30
M 10	S	41.0	21	1/4"	67046	6,90

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

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

HSS-G Tol. ISO2/6H M

Size	Typ	L 1	L 2	SW1	SW2	Art.-No.	€
M 11	DS	70	22	8	4	67048	14,50
M 12	DS	70	22	8	4	67050	14,50
M 14	DS	70	22	10	4	67051	16,50
M 16	DS	70	22	10	4	67052	19,00
M 18	DS	80	24	13	5	67053	21,00
M 20	DS	80	24	13	6	67054	23,00
M 22	DS	80	24	15	6	67055	29,00
M 24	DS	90	27	15	8	67056	34,00
M 27	DS	90	27	19	8	67057	53,00
M 30	DS	90	27	19	10	67058	66,40
M 33	DS	100	29	24	10	67059	88,00
M 36	DS	100	29	24	10	67060	106,00
M 39	DS	110	32	27	12	67061	137,00
M 42	DS	110	27	27	12	67062	155,00
M 45	DS	110	27	32	17	67063	188,00
M 48	DS	140	42	32	17	67064	266,00
M 52	DS	140	42	36	19	67065	266,00

HexTap S

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

HexTap S

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

HSS-G Tol. ISO2/6H

Mf

Size	Typ	L 1	L 2	SW1	Art.-No.	€
M 3 x 0.35	S	33.0	11	1/4"	67700	4,40
M 3.5 x 0.35	S	33.5	10	1/4"	67701	4,40
M 4 x 0.35	S	35.0	12	1/4"	67702	4,40
M 4 x 0.5	S	35.0	12	1/4"	67703	4,40
M 4.5 x 0.5	S	35.0	12	1/4"	67704	5,00
M 5 x 0.5	S	36.0	15	1/4"	67705	5,00
M 5 x 0.75	S	36.0	15	1/4"	67706	5,00
M 5.5 x 0.5	S	35.0	15	1/4"	67707	5,00
M 6 x 0.5	S	39.0	18	1/4"	67708	5,00
M 6 x 0.75	S	39.0	18	1/4"	67709	5,00
M 7 x 0.5	S	37.5	16	1/4"	67710	6,60
M 7 x 0.75	S	37.5	16	1/4"	67711	6,60
M 8 x 0.5	S	40.0	19	1/4"	67712	6,60
M 8 x 0.75	S	40.0	19	1/4"	67713	6,60
M 8 x 1.0	S	40.0	19	1/4"	67714	6,60
M 9 x 0.5	S	40.5	18	1/4"	67715	8,30
M 9 x 0.75	S	40.5	18	1/4"	67716	8,30
M 9 x 1.0	S	40.5	18	1/4"	67717	8,30
M 10 x 0.5	S	41.0	21	1/4"	67718	8,30
M 10 x 0.75	S	41.0	21	1/4"	67719	8,30
M 10 x 1.0	S	41.0	21	1/4"	67720	8,30
M 10 x 1.25	S	41.0	21	1/4"	67721	8,30

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

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

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

Size		Typ	L 1	L 4	SW1	SW2	Art.-No.	€
M	11 x 0,75	DS	70	22	8	4	67722	15,80
M	11 x 1.0	DS	70	22	8	4	67723	15,80
M	11 x 1.25	DS	70	22	8	4	67724	15,80
M	12 x 0.5	DS	70	22	8	4	67725	15,80
M	12 x 0.75	DS	70	22	8	4	67726	15,80
M	12 x 1	DS	70	22	8	4	67727	15,80
M	12 x 1.25	DS	70	22	8	4	67728	15,80
M	12 x 1.5	DS	70	22	8	4	67729	14,60
M	13 x 0.5	DS	70	22	10	4	67730	24,20
M	13 x 0.75	DS	70	22	10	4	67731	24,20
M	13 x 1.0	DS	70	22	10	4	67732	24,20
M	13 x 1.5	DS	70	22	8	4	67733	24,20
M	14 x 0.5	DS	70	22	10	4	67734	24,20
M	14 x 0.75	DS	70	22	10	4	67735	24,20
M	14 x 1.0	DS	70	22	10	4	67736	24,20
M	14 x 1.25	DS	70	22	10	4	67737	18,40
M	14 x 1.5	DS	70	22	10	4	67738	15,80
M	15 x 0.75	DS	70	22	12	4	67739	27,00
M	15 x 1.0	DS	70	22	12	4	67740	27,00
M	15 x 1.5	DS	70	22	10	4	67741	27,00
M	16 x 0.5	DS	70	22	12	4	67742	27,00
M	16 x 0.75	DS	70	22	12	4	67743	27,00
M	16 x 1	DS	70	22	12	4	67744	27,00
M	16 x 1.25	DS	70	22	12	4	67745	27,00
M	16 x 1.5	DS	70	22	12	4	67746	19,40
M	17 x 1.0	DS	80	24	13	5	67747	29,20
M	17 x 1.5	DS	80	24	13	5	67748	29,20
M	18 x 0.5	DS	80	24	13	5	67749	29,20
M	18 x 0.75	DS	80	24	13	5	67750	29,20
M	18 x 1.0	DS	80	24	13	5	67751	29,20
M	18 x 1,25	DS	80	24	13	5	67752	29,20
M	18 x 1.5	DS	80	24	13	5	67753	22,00
M	18 x 2.0	DS	80	24	13	5	67754	29,20
M	19 x 1.0	DS	80	24	15	6	67755	36,60
M	19 x 1.5	DS	80	24	15	6	67756	36,60
M	20 x 0.5	DS	80	24	15	6	67757	36,60
M	20 x 0.75	DS	80	24	15	6	67758	36,60
M	20 x 1.0	DS	80	24	15	6	67759	36,60
M	20 x 1.25	DS	80	24	15	6	67760	36,60
M	20 x 1.5	DS	80	24	15	6	67761	27,00
M	20 x 2.0	DS	80	24	15	6	67762	36,60
M	21 x 1.0	DS	80	24	15	6	67763	38,00
M	21 x 1.5	DS	80	24	15	6	67764	38,00
M	22 x 0.5	DS	80	24	17	6	67765	38,00
M	22 x 0.75	DS	80	24	17	6	67766	38,00
M	22 x 1.0	DS	80	24	17	6	67767	38,00
M	22 x 1.25	DS	80	24	17	6	67768	38,00
M	22 x 1.5	DS	80	24	17	6	67769	38,00
M	22 x 2.0	DS	80	24	17	6	67770	38,00

VÖLKEL
THREADING SOLUTIONS

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

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

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

Size		Typ	L 1	L 4	SW1	SW2	Art.-No.	€
M	23 x 1.0	DS	80	24	17	6	67771	51,00
M	23 x 1.5	DS	80	24	17	6	67772	51,00
M	24 x 0.5	DS	80	24	19	8	67773	51,00
M	24 x 0,75	DS	80	24	19	8	67774	51,00
M	24 x 1.0	DS	80	24	19	8	67775	51,00
M	24 x 1,25	DS	80	24	19	8	67776	51,00
M	24 x 1.5	DS	90	27	19	8	67777	38,60
M	24 x 2.0	DS	90	27	17	8	67778	51,00
M	25 x 1.0	DS	90	27	19	8	67779	75,00
M	25 x 1.5	DS	90	27	19	8	67780	75,00
M	26 x 1.0	DS	90	27	19	8	67781	75,00
M	26 x 1.5	DS	90	27	19	8	67782	75,00
M	26 x 2.0	DS	90	27	19	8	67783	75,00
M	27 x 1.0	DS	90	27	19	8	67784	75,00
M	27 x 1.5	DS	90	27	19	8	67785	75,00
M	27 x 2.0	DS	90	27	19	8	67786	88,00
M	28 x 1.0	DS	90	27	19	8	67787	88,00
M	28 x 1.5	DS	90	27	19	8	67788	88,00
M	28 x 2.0	DS	90	27	19	8	67789	88,00
M	29 x 1.5	DS	90	27	19	8	67790	88,00
M	30 x 1.0	DS	90	27	24	10	67791	104,00
M	30 x 1.5	DS	90	27	24	10	67792	104,00
M	30 x 2.0	DS	90	27	24	10	67793	104,00
M	30 x 2.5	DS	90	27	22	10	67794	104,00
M	30 x 3.0	DS	90	27	22	10	67795	104,00
M	32 x 1.0	DS	90	27	24	10	67796	104,00
M	32 x 1.5	DS	90	27	24	10	67797	104,00
M	32 x 2.0	DS	90	27	24	10	67798	104,00
M	32 x 3.0	DS	90	27	24	10	67799	104,00
M	33 x 1.5	DS	100	29	24	10	67800	104,00
M	33 x 2.0	DS	100	29	24	10	67801	126,00
M	33 x 3.0	DS	100	29	24	10	67802	126,00
M	34 x 1.0	DS	100	29	27	10	67803	126,00
M	34 x 1.5	DS	100	29	27	10	67804	126,00
M	34 x 2.0	DS	100	29	27	10	67805	126,00
M	35 x 1.0	DS	100	29	27	10	67806	126,00
M	35 x 1.5	DS	100	29	27	10	67807	126,00
M	35 x 2.0	DS	100	29	27	10	67808	126,00
M	36 x 1.0	DS	100	29	27	10	67809	133,00
M	36 x 1.5	DS	100	29	27	10	67810	133,00
M	36 x 2.0	DS	100	29	27	10	67811	133,00
M	36 x 3.0	DS	100	29	27	10	67812	133,00
M	37 x 1.5	DS	100	29	27	10	67813	164,00
M	38 x 1.0	DS	110	32	27	12	67814	164,00
M	38 x 1.5	DS	110	32	27	12	67815	164,00
M	38 x 2.0	DS	110	32	27	12	67816	164,00
M	38 x 3.0	DS	110	32	27	12	67817	164,00
M	39 x 1.5	DS	110	32	32	12	67818	164,00
M	39 x 2.0	DS	110	32	27	12	67819	164,00

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

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

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

Size		Typ	L 1	L 4	SW1	SW2	Art.-No.	€
M	39 x 3.0	DS	110	32	27	12	67820	164,00
M	40 x 1.0	DS	110	32	32	12	67821	164,00
M	40 x 1.5	DS	110	32	32	12	67822	164,00
M	40 x 2.0	DS	110	32	32	12	67823	164,00
M	40 x 3.0	DS	110	32	27	12	67824	164,00
M	42 x 1.0	DS	110	32	32	12	67825	164,00
M	42 x 1.5	DS	110	27	32	12	67828	172,00
M	42 x 2.0	DS	110	27	32	12	67826	172,00
M	42 x 3.0	DS	110	27	32	12	67827	164,00
M	44 x 1.5	DS	110	27	36	12	67829	194,00
M	44 x 2.0	DS	110	27	36	12	67830	194,00
M	45 x 1.0	DS	110	27	36	17	67831	194,00
M	45 x 1.5	DS	110	27	36	17	67832	194,00
M	45 x 2.0	DS	110	27	36	17	67833	194,00
M	45 x 3.0	DS	110	27	36	17	67834	194,00
M	46 x 1.5	DS	110	27	36	17	67835	194,00
M	48 x 1.0	DS	140	45	36	17	67836	232,00
M	48 x 1.5	DS	140	45	36	17	67837	232,00
M	48 x 2.0	DS	140	45	36	17	67838	232,00
M	48 x 3.0	DS	140	45	36	17	67839	232,00
M	50 x 1.5	DS	140	42	41	17	67840	254,00
M	50 x 2.0	DS	140	42	41	17	67841	254,00
M	50 x 3.0	DS	140	42	36	17	67842	254,00
M	52 x 1.5	DS	140	42	41	19	67843	304,00
M	52 x 2.0	DS	140	42	41	19	67844	304,00
M	52 x 3.0	DS	140	42	41	19	67845	304,00
M	63 x 1.5	DS	160	47	50	19	67846	498,00

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

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

HSS-G

G (BSP)

Size	Typ	L 1	L 2	SW1	Art.-No.	€
G 1/8	S	40,5	17	1/4"	67870	7,00

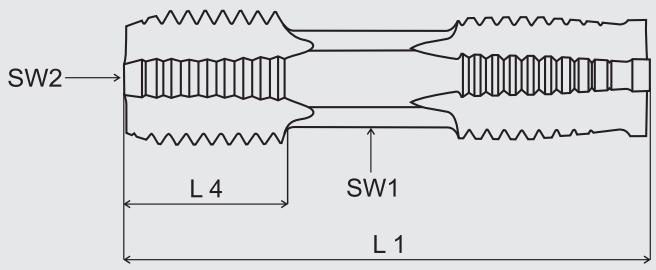
HexTap DS
Double Ended Tap, Multi-Drive
Pipe-thread DIN ISO 228

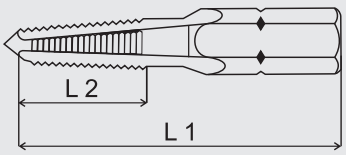
HexTap DS
maschi doppio, Multi-Drive
filettatura per tubi gas DIN ISO 228

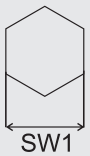
HSS-G

G (BSP)

Size	Typ	L 1	L 4	SW1	SW2	Art.-No.	€
G 1/4	DS	70	22	8	4	67871	12,60
G 3/8	DS	70	22	12	4	67872	17,20
G 1/2	DS	80	24	15	6	67873	23,10
G 3/4	DS	90	27	19	8	67874	34,70
G 1"	DS	100	29	24	10	67875	58,80
G 1.1/4	DS	110	27	32	12	67876	102,00
G 1.1/2	DS	140	42	36	17	67877	135,00
G 2"	DS	160	47	41	19	67878	270,00

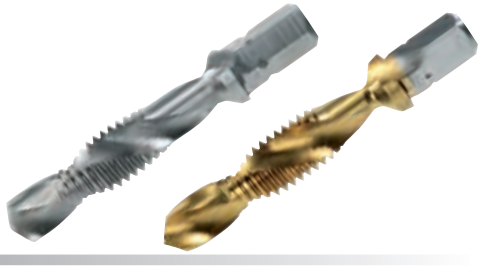






Combined Bits
for Drilling, Tapping and Deburring in one operation
with 1/4" Hexagon Drive (Bit)

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



HSS-G Tol. ISO2/6H

M

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

Technical Information:

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

Informazioni tecniche:

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

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

VÖLKEL
THREADING SOLUTIONS

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

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

HSS-G

UNC / UNF

Nominal Diameter D	D 1	L 1	⬡	Art.-No.	€
UNC					
UNC Nr. 4 x 40	2.3	36	1/4"	67280	8,20
UNC Nr. 5 x 40	2.6	36	1/4"	67281	8,20
UNC Nr. 6 x 32	2.85	39	1/4"	67282	8,20
UNC Nr. 8 x 32	3.5	39	1/4"	67283	8,20
UNC Nr. 10 x 24	3.9	41	1/4"	67284	8,20
UNC Nr. 12 x 24	4.5	41	1/4"	67285	8,20
UNC 1/4 x 20	5.2	44	1/4"	67286	8,20
UNC 5/16 x 18	6.6	50	1/4"	67287	11,50
UNC 3/8 x 16	8.0	59	1/4"	67288	13,90
UNF					
UNF Nr. 4 x 48	2.4	36	1/4"	67290	8,20
UNF Nr. 5 x 44	2.7	36	1/4"	67291	8,20
UNF Nr. 6 x 40	3.0	39	1/4"	67292	8,20
UNF Nr. 8 x 36	3.5	39	1/4"	67293	8,20
UNF Nr. 10 x 32	4.1	41	1/4"	67294	8,20
UNF Nr. 12 x 28	4.7	41	1/4"	67295	8,20
UNF 1/4 x 28	5.5	44	1/4"	67296	8,20
UNF 5/16 x 24	6.9	50	1/4"	67297	11,50
UNF 3/8 x 24	8.5	59	1/4"	67298	13,90

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

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

HSS-G

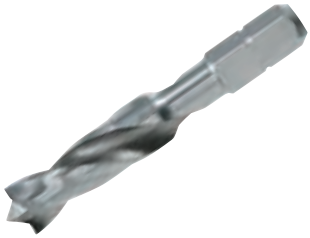
Tol. ISO2/6H

M

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

Wood Drill Bits
with 1/4" Hexagon Drive

Punte per legna
con attacco esagonale 1/4”



HSS-G

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

Drill Bits
with 1/4" Hexagon Drive

Punte elicoidale
con attacco esagonale 1/4”

HSS-G

M

Nominal Diameter D		L 1	S 2	⬡	Art.-No.	€
1.0 mm		32	7	1/4"	67110	3,10
1.5 mm		32	10	1/4"	67115	3,10
2.0 mm		34	12	1/4"	67120	3,10
2.5 mm	(M3)	36	14	1/4"	67125	3,10
3.0 mm		38	16	1/4"	67130	3,10
3.3 mm	(M4)	40	18	1/4"	67133	3,10
3.5 mm		40	18	1/4"	67135	3,10
4.0 mm		44	20	1/4"	67140	3,10
4.2 mm	(M5)	45	20	1/4"	67142	3,10
4.5 mm		46	24	1/4"	67145	3,10
5.0 mm	(M6)	50	26	1/4"	67150	3,10
5.5 mm		50	26	1/4"	67155	3,20
6.0 mm		50	26	1/4"	67160	3,20
6.5 mm		50	30	1/4"	67165	3,20
6.8 mm	(M8)	50	30	1/4"	67168	3,20
7.0 mm		50	30	1/4"	67170	3,20
7.5 mm		51	32	1/4"	67175	3,75
8.0 mm		51	32	1/4"	67180	3,75
8.5 mm	(M10)	53	33	1/4"	67185	4,30
9.0 mm		53	33	1/4"	67190	4,30
9.5 mm		54	38	1/4"	67195	4,85
10.0 mm		54	38	1/4"	67198	4,85
10.2 mm	(M12)	54	38	1/4"	67199	4,85

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

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

HSS

Nominal Diameter D	L 1	⬡	Art.-No.	€
6.3 mm	31	1/4"	67306	8,10
8.3 mm	31	1/4"	67308	8,10
10.4 mm	34	1/4"	67310	8,70
12.4 mm	35	1/4"	67312	9,20
16.5 mm	40	1/4"	67316	10,50
20.5 mm	41	1/4"	67320	11,50

Combined Machine Tap
metric ISO-thread DIN 13

Maschi combinati con punte
filettatura metrica ISO DIN 13

HSS-E Tol. ISO2/6H

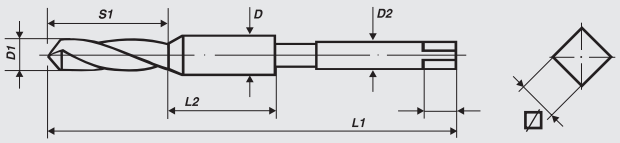
Nominal Diameter D	L 1	S 1	L 2	D 1	D 2	⧄	Art.-No.	€
M								
M 3 x 0.5	56	16	11	2.5	3.0	2.4	37026	15,40
M 4 x 0.7	63	18	14	3.3	4.0	3.0	37030	15,40
M 5 x 0.8	71	20	18	4.2	5.0	3.8	37034	15,40
M 6 x 1.0	80	22	22	5.0	6.0	4.9	37038	17,10
M 8 x 1.25	95	26	25	6.8	8.0	6.2	37042	19,60
M 10 x 1.5	106	30	31	8.5	10.0	8.0	37046	21,50
M 12 x 1.75	115	32	35	10.2	12.0	9.0	37050	25,30
SET								
M 3 - 12		M 3-4-5-6-8-10-12					47837	126,50
BSW								
BSW 1/8 x 40	56	16	11	2.6	3.0	2.4	70006	16,50
BSW 5/32 x 32	63	18	14	3.2	4.0	3.0	70008	16,50
BSW 3/16 x 24	71	20	18	3.7	5.0	3.8	70010	16,50
BSW 1/4 x 20	80	22	22	5.1	6.0	4.9	70014	18,70
BSW 5/16 x 18	95	26	25	6.5	8.0	6.2	70016	20,90
BSW 3/8 x 16	106	30	31	7.9	10.0	8.0	70018	23,00
BSW 1/2 x 12	115	32	35	10.5	12.0	9.0	70022	27,00
SET								
BSW 1/8 - 1/2		BSW 1/8-5/32-3/16-1/4-5/16-3/8-1/2					47870	127,00

Application:

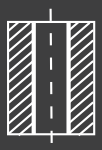
The Combined Tap enables the user to produce the tapping drill hole and the through thread in one operation without any tool changing.
The tool incorporates a twist drill before the thread-tapping part. It is possible with this tool to produce through threads up to a maximum threaded depth of 2 x D.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

Applicazioni:

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

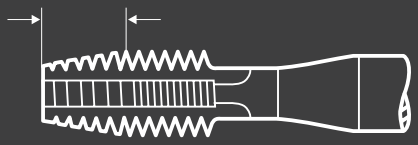


MACHINE TAPS HSS-E
MASCHI A MACCHINA HSS-E

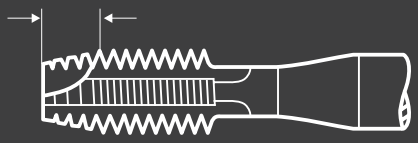


Through hole
per fori passanti

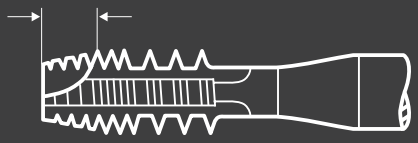
Form A
6-8 Threads Lead
Imbocco a 6-8 spire



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

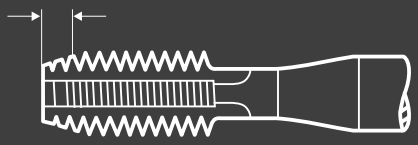


Form B-AZ
4-5 Threads Lead, Spiral Point with interrupted threads
Imbocco a 4-5 spire con imbocco corretto e denti alternati per fori passanti

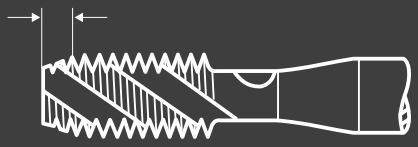


Blind hole
per fori ciechi

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



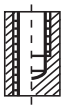
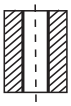
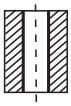
Form C/RSP
2-3 Threads Lead, 35° Spiral Flute
Imbocco a 2-3 spire spirale destra a 35°



MACHINE TAPS HSS-E
MASCHI A MACCHINA HSS-E

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

RECOMMENDED APPLICATION OF MACHINE TAPS
APPLICAZIONE RACCOMANDATA PER MASCHI A MACCHINA

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

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

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

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

Nominal Diameter D				Art.-No.	€
Form B, Spiral Point / con imbocco corretto					
M	3 x 0.5	DIN 371	2.5 mm	37590	6,10
M	4 x 0.7	DIN 371	3.3 mm	37591	6,20
M	5 x 0.8	DIN 371	4.2 mm	37592	6,80
M	6 x 1.0	DIN 371	5.0 mm	37593	6,90
M	8 x 1.25	DIN 371	6.8 mm	37594	8,80
M	10 x 1.5	DIN 371	8.5 mm	37595	11,30
M	12 x 1.75	DIN 376	10.2 mm	38596	14,30
M	14 x 2.0	DIN 376	12.0 mm	38597	18,80
M	16 x 2.0	DIN 376	14.0 mm	38598	25,40
Form C, Spiral Flute / spirale destra a 35°					
M	3 x 0.5	DIN 371	2.5 mm	37790	7,20
M	4 x 0.7	DIN 371	3.3 mm	37791	7,30
M	5 x 0.8	DIN 371	4.2 mm	37792	8,00
M	6 x 1.0	DIN 371	5.0 mm	37793	8,10
M	8 x 1.25	DIN 371	6.8 mm	37794	10,20
M	10 x 1.5	DIN 371	8.5 mm	37795	13,10
M	12 x 1.75	DIN 376	10.2 mm	38796	16,40
M	14 x 2.0	DIN 376	12.0 mm	38797	21,70
M	16 x 2.0	DIN 376	14.0 mm	38798	28,60

Application:

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

Spiral Point for through holes
Spiral Flute for blind holes

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

Applicazione:

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

Forma B per fori passanti
35° per fori ciechi

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

Machine Taps
metric ISO-thread DIN 13

Maschi a macchina
filettatura metrica ISO DIN 13

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

M

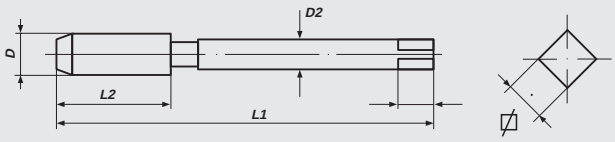
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
DIN 371						
M 2 x 0.4	45	8	2.8	2.1	37316	6,60
M 2.3 x 0.4	45	9	2.8	2.1	37318	6,60
M 2.5 x 0.45	50	9	2.8	2.1	37322	6,60
M 2.6 x 0.45	50	9	2.8	2.1	37324	6,60
M 3 x 0.5	56	11	3.5	2.7	37326	5,40
M 4 x 0.7	63	13	4.5	3.4	37330	5,40
M 5 x 0.8	70	16	6.0	4.9	37334	5,70
M 6 x 1.0	80	19	6.0	4.9	37338	5,70
M 8 x 1.25	90	22	8.0	6.2	37342	6,90
M 10 x 1.5	100	24	10.0	8.0	37346	8,50
DIN 376						
M 2 x 0.4	45	8	1.4	—	38316	6,30
M 3 x 0.5	56	11	2.2	—	38326	5,90
M 4 x 0.7	63	13	2.8	2.1	38330	5,90
M 5 x 0.8	70	16	3.5	2.7	38334	6,20
M 6 x 1.0	80	19	4.5	3.4	38338	6,20
M 8 x 1.25	90	22	6.0	4.9	38342	7,40
M 10 x 1.5	100	24	7.0	5.5	38346	9,00
M 12 x 1.75	110	29	9.0	7.0	38350	10,40
M 14 x 2.0	110	30	11.0	9.0	38354	13,30
M 16 x 2.0	110	32	12.0	9.0	38358	15,00
M 18 x 2.5	125	34	14.0	11.0	38362	21,40
M 20 x 2.5	140	34	16.0	12.0	38366	29,00
M 22 x 2.5	140	34	18.0	14.5	38370	33,00
M 24 x 3.0	160	38	18.0	14.5	38374	35,40
M 27 x 3.0	160	38	20.0	16.0	38376	56,60
M 30 x 3.5	180	45	22.0	18.0	38378	59,00
SET						
M 3 - 12	M 3-4-5-6-8-10 (DIN 371), M 12 (DIN 376)				47813	50,50

Application:

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

Applicazione:

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



Machine Taps
metric ISO-thread DIN 13

Maschi a macchina
filettatura metrica ISO DIN 13

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

M

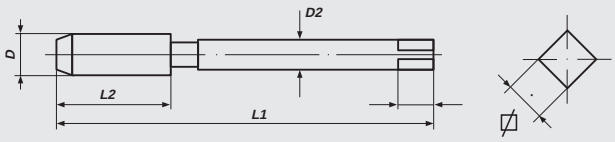
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
DIN 371						
M 2 x 0.4	45	8	2.8	2.1	37416	6,60
M 2.3 x 0.4	45	9	2.8	2.1	37418	6,60
M 2.5 x 0.45	50	9	2.8	2.1	37422	6,60
M 2.6 x 0.45	50	9	2.8	2.1	37424	6,60
M 3 x 0.5	56	11	3.5	2.7	37426	5,40
M 3.5 x 0.6	56	13	4.0	3.0	37428	6,10
M 4 x 0.7	63	13	4.5	3.4	37430	5,40
M 5 x 0.8	70	16	6.0	4.9	37434	5,70
M 6 x 1.0	80	19	6.0	4.9	37438	5,70
M 7 x 1.0	80	19	7.0	5.5	37440	7,90
M 8 x 1.25	90	22	8.0	6.2	37442	6,90
M 10 x 1.5	100	24	10.0	8.0	37446	8,50
DIN 376						
M 3 x 0.5	56	11	2.2	—	38426	5,90
M 4 x 0.7	63	13	2.8	2.1	38430	5,90
M 5 x 0.8	70	16	3.5	2.7	38434	6,20
M 6 x 1.0	80	19	4.5	3.4	38438	6,20
M 8 x 1.25	90	22	6.0	4.9	38442	7,40
M 10 x 1.5	100	24	7.0	5.5	38446	9,00
M 11 x 1.5	100	24	8.0	6.2	38448	10,40
M 12 x 1.75	110	29	9.0	7.0	38450	10,40
M 14 x 2.0	110	30	11.0	9.0	38454	13,30
M 16 x 2.0	110	32	12.0	9.0	38458	15,00
M 18 x 2.5	125	34	14.0	11.0	38462	21,40
M 20 x 2.5	140	34	16.0	12.0	38466	29,00
M 22 x 2.5	140	34	18.0	14.5	38470	33,00
M 24 x 3.0	160	38	18.0	14.5	38474	35,40
M 27 x 3.0	160	38	20.0	16.0	38476	56,60
M 30 x 3.5	180	45	22.0	18.0	38478	59,00
M 33 x 3.5	180	50	25.0	20.0	38480	84,00
M 36 x 4.0	200	56	28.0	22.0	38482	138,00
M 39 x 4.0	200	60	32.0	24.0	38484	176,00
M 42 x 4.5	200	60	32.0	24.0	38486	204,00
M 45 x 4.5	220	65	36.0	29.0	38488	231,00
M 48 x 5.0	250	70	36.0	29.0	38490	254,00
M 52 x 5.0	250	70	40.0	32.0	38492	309,00
SET						
M 3 - 12	M 3-4-5-6-8-10 (DIN 371), M 12 (DIN 376)				47814	50,50

Application:

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

Applicazione:

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



VÖLKEL
THREADING SOLUTIONS

Machine Taps
metric ISO-thread DIN 13

Maschi a macchina
filettatura metrica ISO DIN 13

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

M

Nominal Diameter D	L 1	L 2	D 2	⌀	Art.-No.	€
M 1 x 0.25	40	5	2.5	2.1	37502	20,00
M 1.1 x 0.25	40	5	2.5	2.1	37504	20,00
M 1.2 x 0.25	40	5	2.5	2.1	37506	20,00
M 1.4 x 0.3	40	7	2.5	2.1	37508	17,50
M 1.6 x 0.35	40	8	2.5	2.1	37510	17,50
M 1.7 x 0.35	40	8	2.5	2.1	37512	17,50
M 1.8 x 0.35	40	8	2.5	2.1	37514	17,50
M 2 x 0.4	45	8	2.8	2.1	37516	7,10
M 2.5 x 0.45	50	9	2.8	2.1	37522	7,10
M 3 x 0.5	56	11	3.5	2.7	37526	5,60
M 3.5 x 0.6	56	13	4.0	3.0	37528	6,20
M 4 x 0.7	63	13	4.5	3.4	37530	5,60
M 5 x 0.8	70	16	6.0	4.9	37534	6,00
M 6 x 1.0	80	19	6.0	4.9	37538	6,00
M 7 x 1.0	80	19	7.0	5.5	37540	8,50
M 8 x 1.25	90	22	8.0	6.2	37542	7,30
M 10 x 1.5	100	24	10.0	8.0	37546	9,00
TIN						
M 3 x 0.5	56	11	3.5	2.7	31526	8,70
M 4 x 0.7	63	13	4.5	3.4	31530	8,70
M 5 x 0.8	70	16	6.0	4.9	31534	9,10
M 6 x 1.0	80	19	6.0	4.9	31538	9,70
M 8 x 1.25	90	22	8.0	6.2	31542	12,00
M 10 x 1.5	100	24	10.0	8.0	31546	15,50
VAP						
M 3 x 0.5	56	11	3.5	2.7	31570	6,20
M 4 x 0.7	63	13	4.5	3.4	31571	6,20
M 5 x 0.8	70	16	6.0	4.9	31572	6,60
M 6 x 1.0	80	19	6.0	4.9	31573	6,60
M 8 x 1.25	90	22	8.0	6.2	31574	8,00
M 10 x 1.5	100	24	10.0	8.0	31575	9,90

Application:

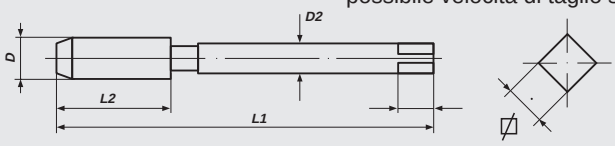
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through holes

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

Applicazione:

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

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



Machine Taps
metric ISO-thread DIN 13

Maschi a macchina
filettatura metrica ISO DIN 13

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

M

Nominal Diameter D	L 1	L 2	D 2	⌀	Art.-No.	€
M 3 x 0.5	56	11	2.2	—	38526	6,10
M 4 x 0.7	63	13	2.8	2.1	38530	6,10
M 5 x 0.8	70	16	3.5	2.7	38534	6,50
M 6 x 1.0	80	19	4.5	3.4	38538	6,50
M 8 x 1.25	90	22	6.0	4.9	38542	7,80
M 9 x 1.25	90	22	7.0	5.5	38544	9,00
M 10 x 1.5	100	24	7.0	5.5	38546	9,40
M 12 x 1.75	110	29	9.0	7.0	38550	10,90
M 14 x 2.0	110	30	11.0	9.0	38554	14,00
M 16 x 2.0	110	32	12.0	9.0	38558	15,70
M 18 x 2.5	125	34	14.0	11.0	38562	22,40
M 20 x 2.5	140	34	16.0	12.0	38566	30,30
M 22 x 2.5	140	34	18.0	14.5	38570	34,80
M 24 x 3.0	160	38	18.0	14.5	38574	37,00
M 27 x 3.0	160	38	20.0	16.0	38576	61,00
M 30 x 3.5	180	45	22.0	18.0	38578	63,00
M 33 x 3.5	180	50	25.0	20.0	38580	88,00
M 36 x 4.0	200	56	28.0	22.0	38582	144,00
M 39 x 4.0	200	60	32.0	24.0	38584	185,00
M 42 x 4.5	200	60	32.0	24.0	38586	215,00
M 45 x 4.5	220	65	36.0	29.0	38588	243,00
M 48 x 5.0	250	70	36.0	29.0	38590	267,00
M 52 x 5.0	250	70	40.0	32.0	38592	325,00
TIN						
M 12 x 1.75	110	29	9.0	7.0	31550	20,80
M 14 x 2.0	110	30	11.0	9.0	31554	25,00
M 16 x 2.0	110	32	12.0	9.0	31558	27,70
M 18 x 2.5	125	34	14.0	11.0	31562	38,30
M 20 x 2.5	140	34	16.0	12.0	31566	46,20
VAP						
M 12 x 1.75	110	29	9.0	7.0	31576	12,00
M 14 x 2.0	110	30	11.0	9.0	31577	15,40
M 16 x 2.0	110	32	12.0	9.0	31578	17,30
M 18 x 2.5	125	34	14.0	11.0	31579	24,60
M 20 x 2.5	140	34	16.0	12.0	31580	33,30

Application:

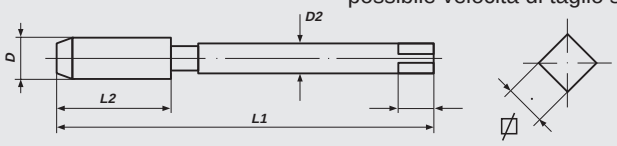
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through holes

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

Applicazione:

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

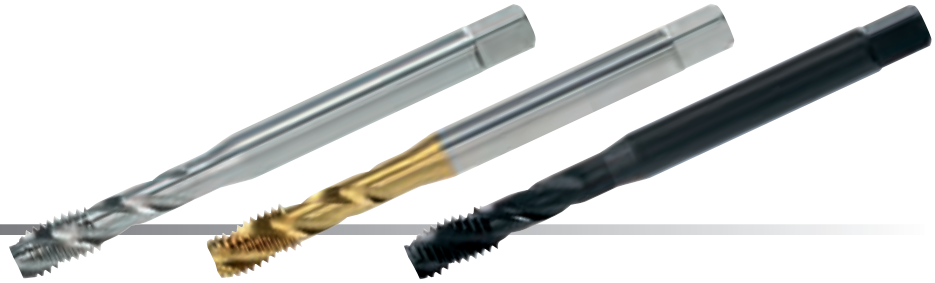
rivestimento TIN
- migliore resistenza all‘ abrasione e alla rottura
- eccellente uniformità
- possibile velocità di taglio superiore



VÖLKEL
THREADING SOLUTIONS

Machine Taps
metric ISO-thread DIN 13

Maschi a macchina
filettatura metrica ISO DIN 13



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

M

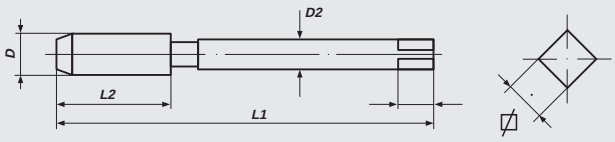
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
M 1 x 0.25	40	4	2.5	2.1	37702	22,00
M 1.1 x 0.25	40	4	2.5	2.1	37704	22,00
M 1.2 x 0.25	40	4	2.5	2.1	37706	22,00
M 1.4 x 0.3	40	5	2.5	2.1	37708	20,00
M 1.6 x 0.35	40	6	2.5	2.1	37710	20,00
M 1.7 x 0.35	40	6	2.5	2.1	37712	20,00
M 1.8 x 0.35	40	6	2.5	2.1	37714	20,00
M 2 x 0.4	45	6	2.8	2.1	37716	7,50
M 2.5 x 0.45	50	6	2.8	2.1	37722	7,50
M 3 x 0.5	56	6	3.5	2.7	37726	6,70
M 3.5 x 0.6	56	6	4.0	3.0	37728	7,50
M 4 x 0.7	63	7	4.5	3.4	37730	6,70
M 5 x 0.8	70	8	6.0	4.9	37734	7,30
M 6 x 1.0	80	10	6.0	4.9	37738	7,30
M 7 x 1.0	80	12	7.0	5.5	37740	10,10
M 8 x 1.25	90	14	8.0	6.2	37742	8,80
M 10 x 1.5	100	16	10.0	8.0	37746	10,80
TIN						
M 3 x 0.5	56	6	3.5	2.7	31726	9,80
M 4 x 0.7	63	7	4.5	3.4	31730	9,80
M 5 x 0.8	70	8	6.0	4.9	31734	10,40
M 6 x 1.0	80	10	6.0	4.9	31738	11,00
M 8 x 1.25	90	14	8.0	6.2	31742	13,50
M 10 x 1.5	100	16	10.0	8.0	31746	17,30
VAP						
M 3 x 0.5	56	6	3.5	2.7	31770	7,40
M 4 x 0.7	63	7	4.5	3.4	31771	7,40
M 5 x 0.8	70	8	6.0	4.9	31772	8,00
M 6 x 1.0	80	10	6.0	4.9	31773	8,00
M 8 x 1.25	90	14	8.0	6.2	31774	9,70
M 10 x 1.5	100	16	10.0	8.0	31775	11,90

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

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

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

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



Machine Taps
metric ISO-thread DIN 13

Maschi a macchina
filettatura metrica ISO DIN 13

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

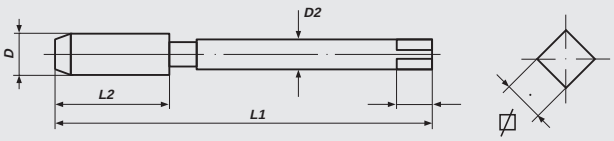
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
M 3 x 0.5	56	6	2.2	—	38726	7,40
M 4 x 0.7	63	7	2.8	2.1	38730	7,40
M 5 x 0.8	70	8	3.5	2.7	38734	7,80
M 6 x 1.0	80	10	4.5	3.4	38738	7,80
M 8 x 1.25	90	14	6.0	4.9	38742	9,30
M 10 x 1.5	100	16	7.0	5.5	38746	11,30
M 12 x 1.75	110	18	9.0	7.0	38750	13,00
M 14 x 2.0	110	20	11.0	9.0	38754	16,80
M 16 x 2.0	110	22	12.0	9.0	38758	18,90
M 18 x 2.5	125	25	14.0	11.0	38762	27,00
M 20 x 2.5	140	25	16.0	12.0	38766	36,00
M 22 x 2.5	140	27	18.0	14.5	38770	42,00
M 24 x 3.0	160	30	18.0	14.5	38774	45,00
M 27 x 3.0	160	30	20.0	16.0	38776	73,50
M 30 x 3.5	180	35	22.0	18.0	38778	76,50
M 33 x 3.5	180	35	25.0	20.0	38780	106,00
M 36 x 4.0	200	40	28.0	22.0	38782	174,00
M 39 x 4.0	200	40	32.0	24.0	38784	222,00
M 42 x 4.5	200	45	32.0	24.0	38786	257,00
M 45 x 4.5	220	45	36.0	29.0	38788	291,00
M 48 x 5.0	250	50	36.0	29.0	38790	320,00
M 52 x 5.0	250	50	40.0	32.0	38792	388,00
TIN						
M 12 x 1.75	110	18	9.0	7.0	31750	22,90
M 14 x 2.0	110	20	11.0	9.0	31754	27,80
M 16 x 2.0	110	22	12.0	9.0	31758	30,90
M 18 x 2.5	125	25	14.0	11.0	31762	42,90
M 20 x 2.5	140	25	16.0	12.0	31766	51,90
VAP						
M 12 x 1.75	110	18	9.0	7.0	31776	14,30
M 14 x 2.0	110	20	11.0	9.0	31777	18,50
M 16 x 2.0	110	22	12.0	9.0	31778	20,80
M 18 x 2.5	125	25	14.0	11.0	31779	29,70
M 20 x 2.5	140	25	16.0	12.0	31780	39,60

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

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

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

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



Machine Taps
metric ISO-thread DIN 13

Maschi a macchina
filettatura metrica ISO DIN 13

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

M

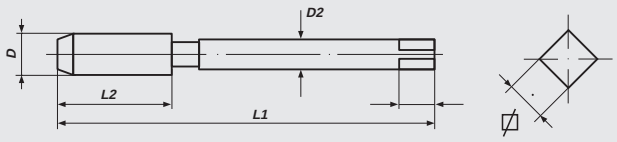
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
DIN 371						
M 3 x 0.5	56	11	3.5	2.7	37626	7,50
M 3.5 x 0.6	56	13	4.0	3.0	37628	8,30
M 4 x 0.7	63	13	4.5	3.4	37630	7,50
M 5 x 0.8	70	16	6.0	4.9	37634	8,00
M 6 x 1.0	80	19	6.0	4.9	37638	8,00
M 7 x 1.0	80	19	7.0	5.5	37640	11,30
M 8 x 1.25	90	22	8.0	6.2	37642	9,90
M 10 x 1.5	100	24	10.0	8.0	37646	12,00
DIN 376						
M 3 x 0.5	56	11	2.2	—	38626	8,40
M 4 x 0.7	63	13	2.8	2.1	38630	8,40
M 5 x 0.8	70	16	3.5	2.7	38634	8,70
M 6 x 1.0	80	19	4.5	3.4	38638	8,70
M 8 x 1.25	90	22	6.0	4.9	38642	10,50
M 10 x 1.5	100	24	7.0	5.5	38646	12,60
M 12 x 1.75	110	29	9.0	7.0	38650	14,60
M 14 x 2.0	110	30	11.0	9.0	38654	18,90
M 16 x 2.0	110	32	12.0	11.0	38658	21,00
M 18 x 2.5	125	34	14.0	11.0	38662	30,40
M 20 x 2.5	140	34	16.0	12.0	38666	40,90
M 22 x 2.5	140	34	18.0	14.5	38670	46,70
M 24 x 3.0	160	38	18.0	14.5	38674	49,80
SET						
M 3 - 12	M 3-4-5-6-8-10 (DIN 371), M 12 (DIN 376)				47816	68,00

Application:

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

Applicazione:

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



Machine Taps
metric ISO-thread DIN 13

Maschi a macchina
filettatura metrica ISO DIN 13

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

M

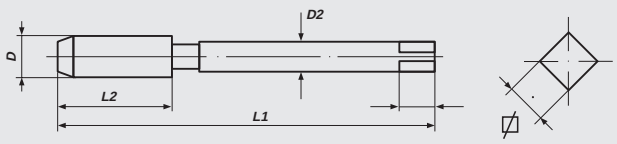
Nominal Diameter D	L 1	L 2	D 2	⌀	Art.-No.	€
DIN 371						
M 3 x 0.5	56	11	3.5	2.7	37926	7,60
M 4 x 0.7	63	13	4.5	3.4	37930	7,60
M 5 x 0.8	70	16	6.0	4.9	37934	8,20
M 6 x 1.0	80	19	6.0	4.9	37938	8,20
M 8 x 1.25	90	22	8.0	6.2	37942	10,10
M 10 x 1.5	100	24	10.0	8.0	37946	12,00
DIN 376						
M 3 x 0.5	56	11	2.2	—	38926	8,30
M 4 x 0.7	63	13	2.8	2.1	38930	8,30
M 5 x 0.8	70	16	3.5	2.7	38934	8,70
M 6 x 1.0	80	19	4.5	3.4	38938	8,70
M 8 x 1.25	90	22	6.0	4.9	38942	10,50
M 10 x 1.5	100	24	7.0	5.5	38946	12,60
M 12 x 1.75	110	29	9.0	7.0	38950	14,60
M 14 x 2.0	110	30	11.0	9.0	38954	18,90
M 16 x 2.0	110	32	12.0	9.0	38958	21,00
M 18 x 2.5	125	34	14.0	11.0	38962	30,00
M 20 x 2.5	140	34	16.0	12.0	38966	40,60
M 22 x 2.5	140	34	18.0	14.5	38970	46,70
M 24 x 3.0	160	38	18.0	14.5	38974	49,80
SET						
M 3 - 12	M 3-4-5-6-8-10 (DIN 371), M 12 (DIN 376)				47819	71,40

Application:

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

Applicazione:

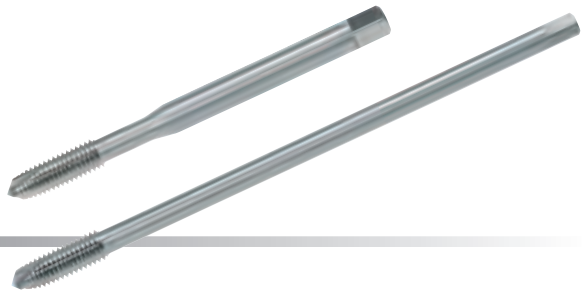
per uso universale
- Materiali con buona truciodibilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per fori passanti



VÖLKEL
THREADING SOLUTIONS

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

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



≈ DIN 371 Form B HSS-E Tol. ISO2/6H

M

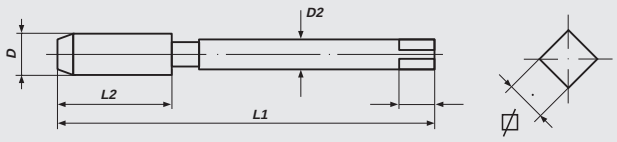
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
100 mm						
M 3 x 0.5	100	11	3.5	2.7	32010	8,00
M 4 x 0.7	100	13	4.5	3.4	32011	8,00
M 5 x 0.8	100	16	6.0	4.9	32012	8,50
M 6 x 1.0	100	19	6.0	4.9	32013	8,50
M 8 x 1.25	100	22	8.0	6.2	32014	10,20
M 10 x 1.5	100	24	10.0	8.0	32015	10,70
M 12 x 1.75	100	29	12.0	9.0	32016	12,00
120 mm						
M 4 x 0.7	120	13	4.5	3.4	32021	8,50
M 5 x 0.8	120	16	6.0	4.9	32022	9,20
M 6 x 1.0	120	19	6.0	4.9	32023	9,20
M 8 x 1.25	120	22	8.0	6.2	32024	10,70
M 10 x 1.5	120	24	10.0	8.0	32025	12,20
M 12 x 1.75	120	29	12.0	9.0	32026	14,20
150 mm						
M 4 x 0.7	150	13	4.5	3.4	32031	8,90
M 5 x 0.8	150	16	6.0	4.9	32032	9,90
M 6 x 1.0	150	19	6.0	4.9	32033	9,90
M 8 x 1.25	150	22	8.0	6.2	32034	12,10
M 10 x 1.5	150	24	10.0	8.0	32035	14,70
M 12 x 1.75	150	29	12.0	9.0	32036	17,30
150 mm with reduced shank / con gambo passante						
M 4 x 0.7	150	13	2.8	2.1	32071	8,90
M 5 x 0.8	150	16	3.5	2.7	32072	9,90
M 6 x 1.0	150	19	4.5	3.4	32073	9,90
M 8 x 1.25	150	22	6.0	4.9	32074	12,10
M 10 x 1.5	150	24	7.0	5.5	32075	14,70
M 12 x 1.75	150	29	9.0	7.0	32076	17,30

Application:

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

Applicazione:

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



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

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

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

M

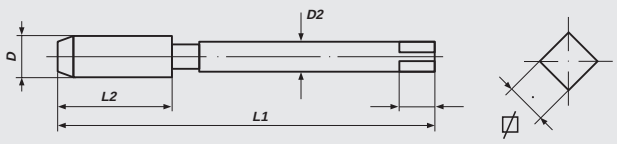
Nominal Diameter D	L 1	L 2	D 2	⌀	Art.-No.	€
100 mm						
M 3 x 0.5	100	6	3.5	2.7	32040	9,60
M 4 x 0.7	100	7	4.5	3.4	32041	9,60
M 5 x 0.8	100	8	6.0	4.9	32042	10,30
M 6 x 1.0	100	10	6.0	4.9	32043	10,30
M 8 x 1.25	100	14	8.0	6.2	32044	12,00
M 10 x 1.5	100	16	10.0	8.0	32045	13,00
M 12 x 1.75	100	18	12.0	9.0	32046	13,10
120 mm						
M 4 x 0.7	120	7	4.5	3.4	32051	10,00
M 5 x 0.8	120	8	6.0	4.9	32052	11,00
M 6 x 1.0	120	10	6.0	4.9	32053	11,00
M 8 x 1.25	120	14	8.0	6.2	32054	12,60
M 10 x 1.5	120	16	10.0	8.0	32055	14,40
M 12 x 1.75	120	18	12.0	9.0	32056	15,30
150 mm						
M 4 x 0.7	150	7	4.5	3.4	32061	10,30
M 5 x 0.8	150	8	6.0	4.9	32062	11,80
M 6 x 1.0	150	10	6.0	4.9	32063	11,80
M 8 x 1.25	150	14	8.0	6.2	32064	14,00
M 10 x 1.5	150	16	10.0	8.0	32065	16,90
M 12 x 1.75	150	18	12.0	9.0	32066	18,30
150 mm with reduced shank / con gambo passante						
M 4 x 0.7	150	7	2.8	2.1	32081	10,30
M 5 x 0.8	150	8	3.5	2.7	32082	11,80
M 6 x 1.0	150	10	4.5	3.4	32083	11,80
M 8 x 1.25	150	14	6.0	4.9	32084	14,00
M 10 x 1.5	150	16	7.0	5.5	32085	16,90
M 12 x 1.75	150	18	9.0	7.0	32086	18,30

Application:

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

Applicazione:

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



VÖLKEL
THREADING SOLUTIONS

Machine Taps, *with oversize*

metric ISO-thread DIN 13

Maschi a macchina, *tolleranza maggiorata*

filettatura metrica ISO DIN 13

DIN 371/376 Form B HSS-E

M

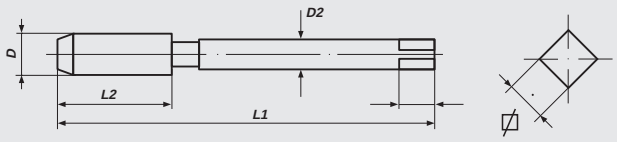
Nominal Diameter D		L 1	L 2	D 2	⧄	Art.-No.	€
6G		DIN 371					
M	2.5 x 0.45	50	9	2.8	2.1	32522	7,50
M	3 x 0.5	56	11	3.5	2.7	32526	7,50
M	4 x 0.7	63	13	4.5	3.4	32530	7,50
M	5 x 0.8	70	16	6.0	4.9	32534	7,80
M	6 x 1.0	80	19	6.0	4.9	32538	7,80
M	8 x 1.25	90	22	8.0	6.2	32542	9,60
M	10 x 1.5	100	24	10.0	8.0	32546	11,00
		DIN 376					
M	12 x 1.75	110	29	9.0	7.0	32550	13,20
M	14 x 2.0	110	30	11.0	9.0	32554	18,90
M	16 x 2.0	110	32	12.0	9.0	32558	22,00
M	18 x 2.5	125	34	14.0	11.0	32562	29,90
M	20 x 2.5	140	34	16.0	12.0	32566	42,00
7G		DIN 371					
M	3 x 0.5	56	11	3.5	2.7	32503	7,60
M	4 x 0.7	63	13	4.5	3.4	32504	7,60
M	5 x 0.8	70	16	6.0	4.9	32505	8,00
M	6 x 1.0	80	19	6.0	4.9	32506	8,00
M	8 x 1.25	90	22	8.0	6.2	32508	10,20
M	10 x 1.5	100	24	10.0	8.0	32510	12,10
		DIN 376					
M	12 x 1.75	110	29	9.0	7.0	32512	14,00
+ 0,1 mm		DIN 371					
M	3 x 0.5	56	11	3.5	2.7	32583	7,60
M	4 x 0.7	63	13	4.5	3.4	32584	7,60
M	5 x 0.8	70	16	6.0	4.9	32585	8,00
M	6 x 1.0	80	19	6.0	4.9	32586	8,00
M	8 x 1.25	90	22	8.0	6.2	32588	10,10
M	10 x 1.5	100	24	10.0	8.0	32590	12,10
		DIN 376					
M	12 x 1.75	110	29	9.0	7.0	32592	14,00

Application:

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

Applicazione:

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



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

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

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

M

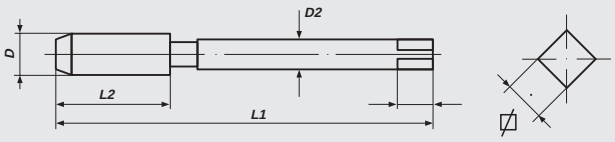
Nominal Diameter D		L 1	L 2	D 2	☐	Art.-No.	€
4H		DIN 371					
M	3 x 0.5	56	11	3.5	2.7	32612	7,60
M	4 x 0.7	63	13	4.5	3.4	32614	7,60
M	5 x 0.8	70	16	6.0	4.9	32616	8,00
M	6 x 1.0	80	19	6.0	4.9	32618	8,00
M	8 x 1.25	90	22	8.0	6.2	32620	10,10
M	10 x 1.5	100	24	10.0	8.0	32622	12,10
		DIN 376					
M	12 x 1.75	110	29	9.0	7.0	32624	14,00
M	14 x 2.0	110	30	11.0	9.0	32625	20,00
M	16 x 2.0	110	32	12.0	9.0	32626	23,00

Application:

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

Applicazione:

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



VÖLKEL
THREADING SOLUTIONS

Machine Taps, *with oversize*

metric ISO-thread DIN 13

Maschi a macchina, *tolleranza maggiorata*

filettatura metrica ISO DIN 13

DIN 371/376 Form C/35°RSP HSS-E

M

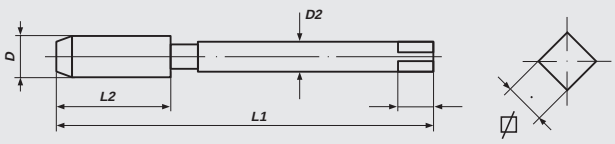
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
6G	DIN 371					
M 3 x 0.5	56	6	3.5	2.7	32726	9,00
M 4 x 0.7	63	7	4.5	3.4	32730	9,00
M 5 x 0.8	70	8	6.0	4.9	32734	9,40
M 6 x 1.0	80	10	6.0	4.9	32738	9,40
M 8 x 1.25	90	14	8.0	6.2	32742	11,50
M 10 x 1.5	100	16	10.0	8.0	32746	13,30
	DIN 376					
M 12 x 1.75	110	18	9.0	7.0	32750	14,40
M 14 x 2.0	110	20	11.0	9.0	32754	20,70
M 16 x 2.0	110	22	12.0	9.0	32758	21,80
M 18 x 2.5	125	25	14.0	11.0	32762	32,50
M 20 x 2.5	140	25	16.0	12.0	32766	45,70
7G	DIN 371					
M 3 x 0.5	56	6	3.5	2.7	32703	9,20
M 4 x 0.7	63	7	4.5	3.4	32704	9,20
M 5 x 0.8	70	8	6.0	4.9	32705	9,90
M 6 x 1.0	80	10	6.0	4.9	32706	9,90
M 8 x 1.25	90	14	8.0	6.2	32708	12,70
M 10 x 1.5	100	16	10.0	8.0	32710	15,00
	DIN 376					
M 12 x 1.75	110	18	9.0	7.0	32712	16,10
+ 0,1 mm	DIN 371					
M 3 x 0.5	56	6	3.5	2.7	32783	9,20
M 4 x 0.7	63	7	4.5	3.4	32784	9,20
M 5 x 0.8	70	8	6.0	4.9	32785	9,90
M 6 x 1.0	80	10	6.0	4.9	32786	9,90
M 8 x 1.25	90	14	8.0	6.2	32788	12,70
M 10 x 1.5	100	16	10.0	8.0	32790	15,00
	DIN 376					
M 12 x 1.75	110	18	9.0	7.0	32792	16,20

Application:

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

Applicazione:

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



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

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

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

M

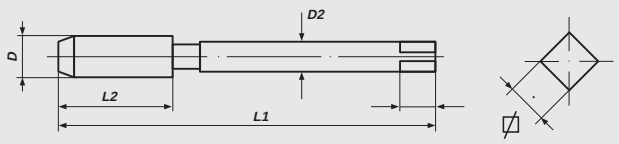
Nominal Diameter D	L 1	L 2	D 2	⌀	Art.-No.	€
4H	DIN 371					
M 3 x 0.5	56	6	3.5	2.7	32652	9,20
M 4 x 0.7	63	7	4.5	3.4	32654	9,20
M 5 x 0.8	70	8	6.0	4.9	32656	9,90
M 6 x 1.0	80	10	6.0	4.9	32658	9,90
M 8 x 1.25	90	14	8.0	6.2	32660	12,70
M 10 x 1.5	100	16	10.0	8.0	32662	15,00
	DIN 376					
M 12 x 1.75	110	18	9.0	7.0	32664	16,20
M 14 x 2.0	110	20	11.0	9.0	32665	23,00
M 16 x 2.0	110	22	12.0	9.0	32666	24,00

Application:

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

Applicazione:

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



VÖLKEL THREADING SOLUTIONS

Machine Taps
metric-fine ISO-thread DIN 13

Maschi a macchina
filettatura metrica fine ISO DIN 13

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

Mf

Nominal Diameter D	L 1	L 2	D 2	⌀	Art.-No.	€
M 4 x 0.35	63	10	2.8	2.1	39402	10,40
M 5 x 0.5	70	12	3.5	2.7	39404	10,40
M 6 x 0.75	80	14	4.5	3.4	39407	10,40
M 8 x 0.75	80	19	6.0	4.9	39410	10,40
M 8 x 1.0	90	22	6.0	4.9	39411	10,40
M 10 x 1.0	90	20	7.0	5.5	39415	12,50
M 10 x 1.25	100	24	7.0	5.5	39416	12,50
M 12 x 1.0	100	22	9.0	7.0	39420	16,20
M 12 x 1.25	100	22	9.0	7.0	39421	16,70
M 12 x 1.5	100	22	9.0	7.0	39422	16,20
M 14 x 1.0	100	22	11.0	9.0	39426	20,10
M 14 x 1.25	100	22	11.0	9.0	39427	20,10
M 14 x 1.5	100	22	11.0	9.0	39428	20,10
M 16 x 1.0	100	22	12.0	9.0	39431	23,80
M 16 x 1.5	100	22	12.0	9.0	39433	23,80
M 18 x 1.0	110	25	14.0	11.0	39434	28,20
M 18 x 1.5	110	25	14.0	11.0	39436	28,20
M 18 x 2.0	125	34	14.0	11.0	39437	28,20
M 20 x 1.0	125	25	16.0	12.0	39438	30,70
M 20 x 1.25	125	25	16.0	12.0	39439	30,70
M 20 x 1.5	125	25	16.0	12.0	39440	30,70
M 20 x 2.0	140	34	16.0	12.0	39441	30,70
M 22 x 1.0	125	25	18.0	14.5	39443	38,80
M 22 x 1.5	125	25	18.0	14.5	39445	38,80
M 22 x 2.0	140	34	18.0	14.5	39446	38,80
M 24 x 1.0	140	28	18.0	14.5	39448	45,40
M 24 x 1.5	140	28	18.0	14.5	39450	45,40
M 24 x 2.0	140	28	18.0	14.5	39451	45,40
M 25 x 1.0	140	28	18.0	14.5	39452	45,40
M 26 x 1.5	140	28	18.0	14.5	39454	45,40
M 27 x 1.5	140	28	20.0	16.0	39456	56,70
M 27 x 2.0	140	28	20.0	16.0	39457	56,70
M 28 x 1.5	140	28	20.0	16.0	39459	56,70
M 30 x 1.5	150	28	22.0	18.0	39463	65,00
M 30 x 2.0	150	28	22.0	18.0	39464	65,00
M 32 x 1.5	150	28	22.0	18.0	39466	83,50
M 32 x 2.0	150	28	22.0	18.0	39467	83,50
M 33 x 2.0	160	30	25.0	20.0	39468	83,50
M 35 x 1.5	170	30	28.0	22.0	39472	83,50
M 36 x 1.5	170	30	28.0	22.0	39473	104,50
M 36 x 2.0	170	30	28.0	22.0	39474	104,50
M 38 x 1.5	170	30	28.0	22.0	39476	111,00
M 40 x 1.5	170	30	32.0	24.0	39480	121,00
M 42 x 1.5	170	30	32.0	24.0	39483	134,00
M 45 x 1.5	180	32	36.0	29.0	39486	158,00
M 48 x 1.5	190	32	36.0	29.0	39489	191,00
M 50 x 1.5	190	32	36.0	29.0	39494	220,00
M 52 x 1.5	190	32	40.0	32.0	39497	243,00

Machine Taps
metric-fine ISO-thread DIN 13

Maschi a macchina
filettatura metrica fine ISO DIN 13

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

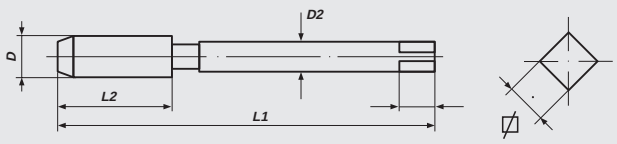
Nominal Diameter D		L 1	L 2	D 2	⌀	Art.-No.	€
M	3 x 0.35	56	9	2.2	-	39501	11,50
M	4 x 0.35	63	10	2.8	2.1	39502	11,50
M	4 x 0.5	63	10	2.8	2.1	39503	11,50
M	5 x 0.5	70	12	3.5	2.7	39504	11,50
M	5 x 0.75	70	12	3.5	2.7	39505	11,50
M	6 x 0.5	80	14	4.5	3.4	39506	11,50
M	6 x 0.75	80	14	4.5	3.4	39507	11,50
M	7 x 0.75	80	14	5.5	4.3	39508	11,50
M	8 x 0.5	80	19	6.0	4.9	39509	11,50
M	8 x 0.75	80	19	6.0	4.9	39510	11,50
M	8 x 1.0	90	22	6.0	4.9	39511	11,50
M	9 x 0.75	80	19	7.0	5.5	39512	11,50
M	9 x 1.0	90	22	7.0	5.5	39513	11,50
M	10 x 0.75	90	20	7.0	5.5	39514	13,40
M	10 x 1.0	90	20	7.0	5.5	39515	13,40
M	10 x 1.25	100	24	7.0	5.5	39516	13,40
M	11 x 1.0	90	20	8.0	6.2	39517	18,40
M	11 x 1.25	90	22	8.0	6.2	39518	18,40
M	12 x 0.75	100	22	9.0	7.0	39519	18,40
M	12 x 1.0	100	22	9.0	7.0	39520	18,40
M	12 x 1.25	100	22	9.0	7.0	39521	18,40
M	12 x 1.5	100	22	9.0	7.0	39522	18,40
M	13 x 1.0	100	22	11.0	9.0	39523	23,70
M	13 x 1.5	100	22	11.0	9.0	39524	23,70
M	14 x 0.75	100	22	11.0	9.0	39525	23,70
M	14 x 1.0	100	22	11.0	9.0	39526	23,70
M	14 x 1.25	100	22	11.0	9.0	39527	23,70
M	14 x 1.5	100	22	11.0	9.0	39528	23,70
M	15 x 1.0	100	22	12.0	9.0	39529	26,00
M	15 x 1.5	100	22	12.0	9.0	39530	26,00
M	16 x 1.0	100	22	12.0	9.0	39531	26,50
M	16 x 1.25	100	22	12.0	9.0	39532	26,50
M	16 x 1.5	100	22	12.0	9.0	39533	26,50
M	18 x 1.0	110	25	14.0	11.0	39534	32,30
M	18 x 1.25	110	25	14.0	11.0	39535	32,30
M	18 x 1.5	110	25	14.0	11.0	39536	32,30
M	18 x 2.0	125	34	14.0	11.0	39537	32,30

Application:

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

Applicazione:

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



VÖLKEL
THREADING SOLUTIONS

Machine Taps
metric-fine ISO-thread DIN 13

Maschi a macchina
filettatura metrica fine ISO DIN 13

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

Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
M 20 x 1.0	125	25	16.0	12.0	39538	35,80
M 20 x 1.25	125	25	16.0	12.0	39539	35,80
M 20 x 1.5	125	25	16.0	12.0	39540	35,80
M 20 x 2.0	140	34	16.0	12.0	39541	35,80
M 21 x 1.5	125	25	16.0	12.0	39542	35,80
M 22 x 1.0	125	25	18.0	14.5	39543	43,80
M 22 x 1.25	125	25	18.0	14.5	39544	43,80
M 22 x 1.5	125	25	18.0	14.5	39545	43,80
M 22 x 2.0	140	34	18.0	14.5	39546	43,80
M 23 x 1.5	125	25	18.0	14.5	39547	50,80
M 24 x 1.0	140	28	18.0	14.5	39548	50,80
M 24 x 1.25	140	28	18.0	14.5	39549	50,80
M 24 x 1.5	140	28	18.0	14.5	39550	50,80
M 24 x 2.0	140	28	18.0	14.5	39551	50,80
M 25 x 1.0	140	28	18.0	14.5	39552	54,20
M 25 x 1.5	140	28	18.0	14.5	39553	54,20
M 26 x 1.0	140	28	18.0	14.5	3955X	54,20
M 26 x 1.5	140	28	18.0	14.5	39554	54,20
M 26 x 2.0	140	28	18.0	14.5	39555	54,20
M 27 x 1.0	140	28	20.0	16.0	39500	64,60
M 27 x 1.5	140	28	20.0	16.0	39556	64,60
M 27 x 2.0	140	28	20.0	16.0	39557	64,60
M 28 x 1.0	140	28	20.0	16.0	39558	64,60
M 28 x 1.5	140	28	20.0	16.0	39559	64,60
M 28 x 2.0	140	28	20.0	16.0	39560	64,60
M 29 x 1.5	150	28	22.0	18.0	39561	72,70
M 30 x 1.0	150	28	22.0	18.0	39562	72,70
M 30 x 1.5	150	28	22.0	18.0	39563	72,70
M 30 x 2.0	150	28	22.0	18.0	39564	72,70
M 30 x 2.5	180	45	22.0	18.0	3956X	72,70
M 30 x 3.0	180	45	22.0	18.0	39565	72,70
M 32 x 1.5	150	28	22.0	18.0	39566	88,90
M 32 x 2.0	150	28	22.0	18.0	39567	88,90
M 32 x 3.0	180	50	22.0	18.0	39592	88,90
M 33 x 1.5	160	30	25.0	20.0	39593	88,90
M 33 x 2.0	160	30	25.0	20.0	39568	88,90
M 33 x 3.0	180	50	25.0	20.0	39569	88,90

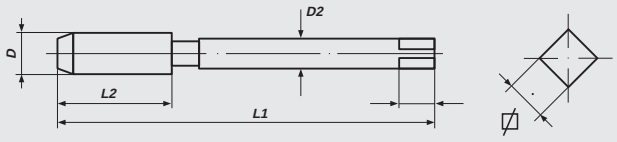
►►►

Application:

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

Applicazione:

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



Machine Taps
metric-fine ISO-thread DIN 13

Maschi a macchina
filettatura metrica fine ISO DIN 13

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

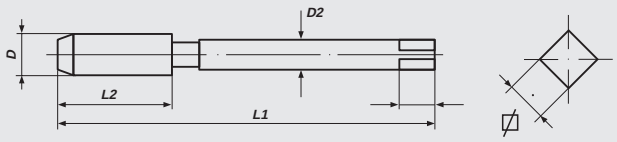
Nominal Diameter D	L 1	L 2	D 2	⌀	Art.-No.	€
M 34 x 1.5	170	30	28.0	22.0	39570	88,90
M 34 x 2.0	170	30	28.0	22.0	39571	88,90
M 35 x 1.5	170	30	28.0	22.0	39572	88,90
M 36 x 1.5	170	30	28.0	22.0	39573	111,00
M 36 x 2.0	170	30	28.0	22.0	39574	111,00
M 36 x 3.0	200	56	28.0	22.0	39575	111,00
M 38 x 1.5	170	30	28.0	22.0	39576	118,00
M 39 x 1.5	170	30	32.0	24.0	39577	118,00
M 39 x 2.0	170	30	32.0	24.0	39578	118,00
M 39 x 3.0	200	60	32.0	24.0	39579	118,00
M 40 x 1.5	170	30	32.0	24.0	39580	131,00
M 40 x 2.0	170	30	32.0	24.0	39581	131,00
M 40 x 3.0	200	60	32.0	24.0	39582	131,00
M 42 x 1.5	170	30	32.0	24.0	39583	147,00
M 42 x 2.0	170	30	32.0	24.0	39584	147,00
M 42 x 3.0	200	60	32.0	24.0	39585	147,00
M 45 x 1.5	180	32	36.0	29.0	39586	173,00
M 45 x 2.0	180	32	36.0	29.0	39587	173,00
M 45 x 3.0	200	50	36.0	29.0	39588	173,00
M 48 x 1.5	190	32	36.0	29.0	39589	207,00
M 48 x 2.0	190	32	36.0	29.0	39590	207,00
M 48 x 3.0	225	50	36.0	29.0	39591	207,00
M 50 x 1.5	190	32	36.0	29.0	39594	242,00
M 50 x 2.0	190	32	36.0	29.0	39595	242,00
M 50 x 3.0	225	50	36.0	29.0	39596	242,00
M 52 x 1.5	190	32	40.0	32.0	39597	265,00
M 52 x 2.0	190	32	40.0	32.0	39598	265,00
M 52 x 3.0	225	50	40.0	32.0	39599	265,00
M 63 x 1.5	275	50	50.0	39.0	3959X	415,00

Application:

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

Applicazione:

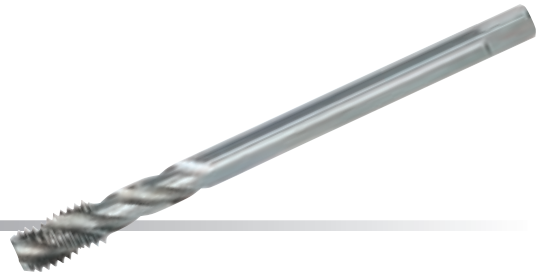
per uso universale
- Materiali con buona truciodibilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per fori passanti



VÖLKEL
THREADING SOLUTIONS

Machine Taps
metric ISO-thread DIN 13

Maschi a macchina
filettatura metrica fine ISO DIN 13



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

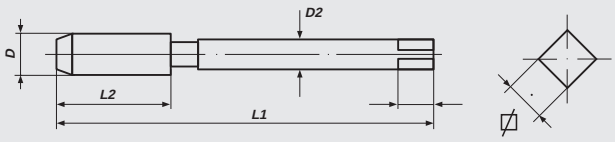
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
M 3 x 0.35	56	5	2.2	-	39701	13,10
M 4 x 0.35	63	5	2.8	2.1	39702	13,10
M 4 x 0.5	63	5	2.8	2.1	39703	13,10
M 5 x 0.5	70	5	3.5	2.7	39704	13,10
M 5 x 0.75	70	8	3.5	2.7	39705	13,10
M 6 x 0.5	80	5	4.5	3.4	39706	13,10
M 6 x 0.75	80	8	4.5	3.4	39707	13,10
M 7 x 0.75	80	8	5.5	4.3	39708	13,10
M 8 x 0.5	80	8	6.0	4.9	39709	13,10
M 8 x 0.75	80	8	6.0	4.9	39710	13,10
M 8 x 1.0	90	10	6.0	4.9	39711	13,10
M 9 x 0.75	80	10	7.0	5.5	39712	13,10
M 9 x 1.0	90	10	7.0	5.5	39713	13,10
M 10 x 0.75	90	10	7.0	5.5	39714	15,50
M 10 x 1.0	90	10	7.0	5.5	39715	15,50
M 10 x 1.25	100	16	7.0	5.5	39716	15,50
M 11 x 1.0	90	11	8.0	6.2	39717	20,00
M 11 x 1.25	90	14	8.0	6.2	39718	20,00
M 12 x 0.75	100	10	9.0	7.0	39719	20,00
M 12 x 1.0	100	11	9.0	7.0	39720	20,00
M 12 x 1.25	100	15	9.0	7.0	39721	20,00
M 12 x 1.5	100	15	9.0	7.0	39722	20,00
M 13 x 1.0	100	11	11.0	9.0	39723	24,40
M 13 x 1.5	100	15	11.0	9.0	39724	24,40
M 14 x 0.75	100	10	11.0	9.0	39725	24,40
M 14 x 1.0	100	11	11.0	9.0	39726	24,40
M 14 x 1.25	100	15	11.0	9.0	39727	24,40
M 14 x 1.5	100	15	11.0	9.0	39728	24,40
M 15 x 1.0	100	12	12.0	9.0	39729	28,30
M 15 x 1.5	100	15	12.0	9.0	39730	28,30
M 16 x 1.0	100	12	12.0	9.0	39731	28,30
M 16 x 1.25	100	15	12.0	9.0	39732	28,30
M 16 x 1.5	100	15	12.0	9.0	39733	28,30
M 18 x 1.0	110	13	14.0	11.0	39734	35,40
M 18 x 1.25	110	15	14.0	11.0	39735	35,40
M 18 x 1.5	110	17	14.0	11.0	39736	35,40
M 18 x 2.0	125	20	14.0	11.0	39737	35,40

Application:

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

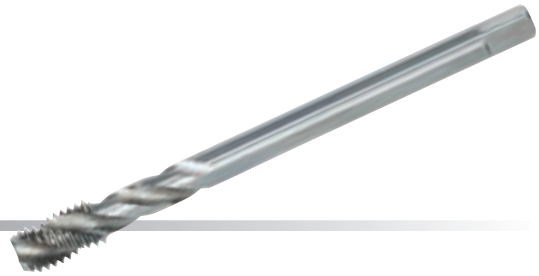
Applicazione:

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



Machine Taps
metric ISO-thread DIN 13

Maschi a macchina
filettatura metrica fine ISO DIN 13



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

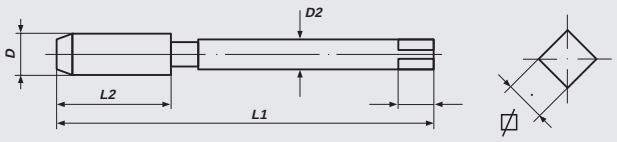
Nominal Diameter D	L 1	L 2	D 2	⌀	Art.-No.	€
M 20 x 1.0	125	14	16.0	12.0	39738	39,30
M 20 x 1.25	125	17	16.0	12.0	39739	39,30
M 20 x 1.5	125	17	16.0	12.0	39740	39,30
M 20 x 2.0	140	20	16.0	12.0	39741	39,30
M 21 x 1.5	125	17	16.0	12.0	39742	39,30
M 22 x 1.0	125	14	18.0	14.5	39743	48,00
M 22 x 1.25	125	17	18.0	14.5	39744	48,00
M 22 x 1.5	125	17	18.0	14.5	39745	48,00
M 22 x 2.0	140	20	18.0	14.5	39746	48,00
M 23 x 1.5	125	17	18.0	14.5	39747	57,70
M 24 x 1.0	140	15	18.0	14.5	39748	57,70
M 24 x 1.25	140	17	18.0	14.5	39749	57,70
M 24 x 1.5	140	20	18.0	14.5	39750	57,70
M 24 x 2.0	140	20	18.0	14.5	39751	57,70
M 25 x 1.0	140	15	18.0	14.5	39752	57,70
M 25 x 1.5	140	20	18.0	14.5	39753	57,70
M 26 x 1.0	140	15	18.0	14.5	3975X	57,70
M 26 x 1.5	140	20	18.0	14.5	39754	57,70
M 26 x 2.0	140	20	18.0	14.5	39755	57,70
M 27 x 1.0	140	15	20.0	16.0	39700	69,00
M 27 x 1.5	140	20	20.0	16.0	39756	69,30
M 27 x 2.0	140	20	20.0	16.0	39757	69,30
M 28 x 1.0	140	15	20.0	16.0	39758	69,30
M 28 x 1.5	140	20	20.0	16.0	39759	69,30
M 28 x 2.0	140	20	20.0	16.0	39760	69,30
M 29 x 1.5	150	22	22.0	18.0	39761	78,70
M 30 x 1.0	150	17	22.0	18.0	39762	78,70
M 30 x 1.5	150	22	22.0	18.0	39763	78,70
M 30 x 2.0	150	22	22.0	18.0	39764	78,70
M 30 x 2.5	180	27	22.0	18.0	3976X	78,70
M 30 x 3.0	180	30	22.0	18.0	39765	78,70
M 32 x 1.5	150	22	22.0	18.0	39766	98,70
M 32 x 2.0	150	22	22.0	18.0	39767	98,70
M 32 x 3.0	180	30	22.0	18.0	39792	98,70
M 33 x 1.5	160	24	25.0	20.0	39793	98,70
M 33 x 2.0	160	24	25.0	20.0	39768	98,70
M 33 x 3.0	180	30	25.0	20.0	39769	98,70

Application:

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

Applicazione:

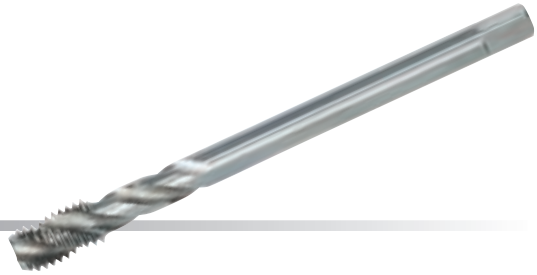
per uso universale
- Materiali con buona truciodibilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per fori ciechi



VÖLKEL
THREADING SOLUTIONS

Machine Taps
metric ISO-thread DIN 13

Maschi a macchina
filettatura metrica fine ISO DIN 13



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

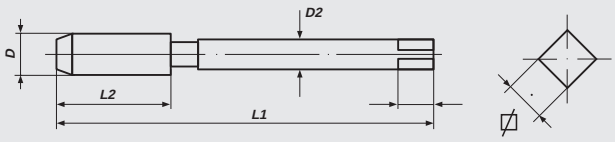
Nominal Diameter D		L 1	L 2	D 2	⧄	Art.-No.	€
M	34 x 1.5	170	24	28.0	22.0	39770	98,70
M	34 x 2.0	170	24	28.0	22.0	39771	98,70
M	35 x 1.5	170	24	28.0	22.0	39772	98,70
M	36 x 1.5	170	24	28.0	22.0	39773	123,90
M	36 x 2.0	170	24	28.0	22.0	39774	123,90
M	36 x 3.0	200	30	28.0	22.0	39775	123,90
M	38 x 1.5	170	24	28.0	22.0	39776	131,20
M	39 x 1.5	170	25	32.0	24.0	39777	131,20
M	39 x 2.0	170	25	32.0	24.0	39778	131,20
M	39 x 3.0	200	30	32.0	24.0	39779	131,20
M	40 x 1.5	170	25	32.0	24.0	39780	145,00
M	40 x 2.0	170	25	32.0	24.0	39781	145,00
M	40 x 3.0	200	30	32.0	24.0	39782	145,00
M	42 x 1.5	170	25	32.0	24.0	39783	163,00
M	42 x 2.0	170	25	32.0	24.0	39784	163,00
M	42 x 3.0	200	30	32.0	24.0	39785	163,00
M	45 x 1.5	180	27	36.0	29.0	39786	190,00
M	45 x 2.0	180	27	36.0	29.0	39787	190,00
M	45 x 3.0	200	30	36.0	29.0	39788	190,00
M	48 x 1.5	190	27	36.0	29.0	39789	226,00
M	48 x 2.0	190	27	36.0	29.0	39790	226,00
M	48 x 3.0	225	33	36.0	29.0	39791	226,00
M	50 x 1.5	190	27	36.0	29.0	39794	262,50
M	50 x 2.0	190	27	36.0	29.0	39795	262,50
M	50 x 3.0	225	33	36.0	29.0	39796	262,50
M	52 x 1.5	190	27	40.0	32.0	39797	288,00
M	52 x 2.0	190	27	40.0	32.0	39798	288,00
M	52 x 3.0	225	33	40.0	32.0	39799	288,00
M	63 x 1.5	275	40	50.0	39.0	3979X	441,00

Application:

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

Applicazione:

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



Machine Taps
Withworth-thread BS 84

Maschi a macchina
filettatura Whitworth BS 84

≈ DIN 371/376 Form B HSS-E

BSW

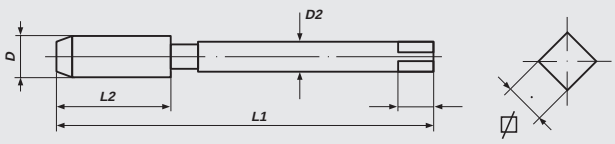
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
≈ DIN 371						
BSW 1/8 x 40	56	11	3.5	2.7	70506	8,20
BSW 5/32 x 32	63	13	4.5	3.4	70508	8,20
BSW 3/16 x 24	70	15	6.0	4.9	70510	8,20
BSW 1/4 x 20	80	17	7.0	5.5	70514	8,20
BSW 5/16 x 18	90	20	8.0	6.2	70516	10,40
BSW 3/8 x 16	100	22	9.0	7.0	70518	11,60
BSW 7/16 x 14	100	22	11.0	9.0	70520	13,80
BSW 1/2 x 12	110	25	12.0	9.0	70522	13,80
≈ DIN 376						
BSW 1/4 x 20	80	17	4.5	3.4	71514	8,20
BSW 5/16 x 18	90	20	6.0	4.9	71516	10,40
BSW 3/8 x 16	100	22	7.0	5.5	71518	11,60
BSW 7/16 x 14	100	22	8.0	6.2	71520	13,80
BSW 1/2 x 12	110	25	9.0	7.0	71522	13,80
BSW 9/16 x 12	110	26	11.0	9.0	71524	21,00
BSW 5/8 x 11	110	27	12.0	9.0	71526	21,00
BSW 3/4 x 10	125	30	14.0	11.0	71530	40,50
BSW 7/8 x 9	140	32	18.0	14.5	71534	49,50
BSW 1" x 8	160	36	20.0	16.0	71538	56,00
BSW 1.1/4 x 7	180	40	22.0	18.0	71546	77,00
BSW 1.3/8 x 6	200	50	28.0	22.0	71550	161,00
BSW 1.1/2 x 6	200	50	32.0	24.0	71554	161,00

Application:

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

Applicazione:

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



Machine Taps
Withworth-thread BS 84

Maschi a macchina
filettatura Whitworth BS 84

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

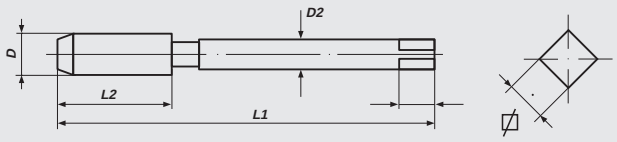
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
≈ DIN 371						
BSW 1/8 x 40	56	7	3.5	2.7	70706	10,20
BSW 5/32 x 32	63	7	4.5	3.4	70708	10,20
BSW 3/16 x 24	70	10	6.0	4.9	70710	10,20
BSW 1/4 x 20	80	13	7.0	5.5	70714	10,20
BSW 5/16 x 18	90	14	8.0	6.2	70716	12,70
BSW 3/8 x 16	100	16	9.0	7.0	70718	14,00
BSW 7/16 x 14	100	17	11.0	9.0	70720	17,20
BSW 1/2 x 12	110	20	12.0	9.0	70722	17,20
≈ DIN 376						
BSW 1/4 x 20	80	13	4.5	3.4	71714	10,20
BSW 5/16 x 18	90	14	6.0	4.9	71716	12,70
BSW 3/8 x 16	100	16	7.0	5.5	71718	14,00
BSW 7/16 x 14	100	17	8.0	6.2	71720	17,20
BSW 1/2 x 12	110	20	9.0	7.0	71722	17,20
BSW 9/16 x 12	110	20	11.0	9.0	71724	25,40
BSW 5/8 x 11	110	22	12.0	9.0	71726	25,40
BSW 3/4 x 10	125	25	14.0	11.0	71730	50,60
BSW 7/8 x 9	140	27	18.0	14.5	71734	61,40
BSW 1" x 8	160	30	20.0	16.0	71738	69,00
BSW 1.1/4 x 7	180	35	22.0	18.0	71746	88,00
BSW 1.3/8 x 6	200	40	28.0	22.0	71750	193,00
BSW 1.1/2 x 6	200	40	32.0	24.0	71754	193,00

Application:

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

Applicazione:

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



Machine Taps
Unified Coarse thread ANSI B 1.1

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

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

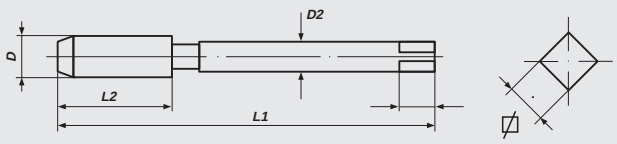
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
≈ DIN 371						
UNC No. 4 x 40	50	10	3.5	2.7	74504	8,20
UNC No. 5 x 40	56	11	3.5	2.7	74505	8,20
UNC No. 6 x 32	56	12	4.0	3.0	74506	8,20
UNC No. 8 x 32	63	13	4.5	3.4	74508	8,20
UNC No. 10 x 24	70	15	6.0	4.9	74510	8,20
UNC No. 12 x 24	70	16	6.0	4.9	74512	8,20
UNC 1/4 x 20	80	17	7.0	5.5	74514	8,20
UNC 5/16 x 18	90	20	8.0	6.2	74516	10,40
UNC 3/8 x 16	100	22	9.0	7.0	74518	11,60
≈ DIN 376						
UNC No. 4 x 40	50	10	1.8	-	75504	8,20
UNC No. 5 x 40	56	11	2.2	1.8	75505	8,20
UNC No. 6 x 32	56	12	2.5	2.1	75506	8,20
UNC No. 8 x 32	63	13	2.8	2.1	75508	8,20
UNC No. 10 x 24	70	15	3.5	2.7	75510	8,20
UNC No. 12 x 24	70	16	3.5	2.7	75512	8,20
UNC 1/4 x 20	80	17	4.5	3.4	75514	8,20
UNC 5/16 x 18	90	20	6.0	4.9	75516	10,40
UNC 3/8 x 16	100	22	7.0	5.5	75518	11,60
UNC 7/16 x 14	100	22	8.0	6.2	75520	13,80
UNC 1/2 x 13	110	25	9.0	7.0	75522	13,80
UNC 9/16 x 12	110	26	11.0	9.0	75524	21,00
UNC 5/8 x 11	110	27	12.0	9.0	75526	21,00
UNC 3/4 x 10	125	30	14.0	11.0	75530	40,50
UNC 7/8 x 9	140	32	18.0	14.5	75534	49,50
UNC 1" x 8	160	36	20.0	16.0	75538	56,00
UNC 1.1/4 x 7	180	40	22.0	18.0	75546	77,00
UNC 1.1/2 x 6	200	50	32.0	24.0	75554	161,00
UNC 1.3/4 x 5	220	65	36.0	29.0	75562	278,00
UNC 2" x 4.1/2	250	70	40.0	32.0	75570	404,00

Application:

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

Applicazione:

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



Machine Taps
Unified Coarse thread ANSI B 1.1

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

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

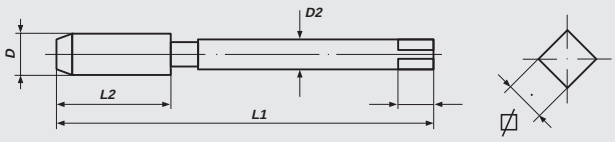
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
≈ DIN 371						
UNC No. 4 x 40	50	6	3.5	2.7	74704	10,20
UNC No. 5 x 40	56	7	3.5	2.7	74705	10,20
UNC No. 6 x 32	56	7	4.0	3.0	74706	10,20
UNC No. 8 x 32	63	8	4.5	3.4	74708	10,20
UNC No. 10 x 24	70	10	6.0	4.9	74710	10,20
UNC No. 12 x 24	70	10	6.0	4.9	74712	10,20
UNC 1/4 x 20	80	13	7.0	5.5	74714	10,20
UNC 5/16 x 18	90	14	8.0	6.2	74716	12,70
UNC 3/8 x 16	100	16	9.0	7.0	74718	14,00
≈ DIN 376						
UNC No. 4 x 40	50	6	1.8	-	75704	10,20
UNC No. 5 x 40	56	7	2.2	1.8	75705	10,20
UNC No. 6 x 32	56	7	2.5	2.1	75706	10,20
UNC No. 8 x 32	63	8	2.8	2.1	75708	10,20
UNC No. 10 x 24	70	10	3.5	2.7	75710	10,20
UNC No. 12 x 24	70	10	3.5	2.7	75712	10,20
UNC 1/4 x 20	80	13	4.5	3.4	75714	10,20
UNC 5/16 x 18	90	14	6.0	4.9	75716	12,70
UNC 3/8 x 16	100	16	7.0	5.5	75718	14,00
UNC 7/16 x 14	100	17	8.0	6.2	75720	17,20
UNC 1/2 x 13	110	20	9.0	7.0	75722	17,20
UNC 9/16 x 12	110	20	11.0	9.0	75724	25,40
UNC 5/8 x 11	110	22	12.0	9.0	75726	25,40
UNC 3/4 x 10	125	25	14.0	11.0	75730	50,60
UNC 7/8 x 9	140	27	18.0	14.5	75734	61,40
UNC 1" x 8	160	30	20.0	16.0	75738	69,00
UNC 1.1/4 x 7	180	35	22.0	18.0	75746	88,00
UNC 1.1/2 x 6	200	40	32.0	24.0	75754	193,00
UNC 1.3/4 x 5	220	45	36.0	29.0	75762	302,00
UNC 2" x 4.1/2	250	50	40.0	32.0	75770	430,00

Application:

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

Applicazione:

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



Machine Taps
Unified Fine thread ANSI B 1.1

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

≈ DIN 371/376 Form B HSS-E Tol. 2B

UNF

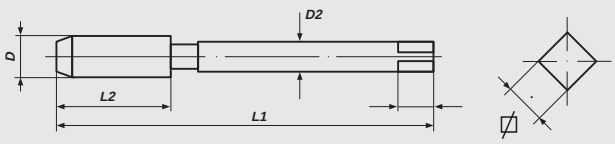
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
≈ DIN 371						
UNF No. 4 x 48	50	10	3.5	2.7	76504	8,20
UNF No. 5 x 44	56	11	3.5	2.7	76505	8,20
UNF No. 6 x 40	56	12	4.0	3.0	76506	8,20
UNF No. 8 x 36	63	13	4.5	3.4	76508	8,20
UNF No. 10 x 32	70	15	6.0	4.9	76510	8,20
UNF No. 12 x 28	70	16	6.0	4.9	76512	8,20
UNF 1/4 x 28	80	17	7.0	5.5	76514	8,20
UNF 5/16 x 24	90	17	8.0	6.2	76516	10,40
UNF 3/8 x 24	100	18	9.0	7.0	76518	11,20
≈ DIN 376						
UNF 7/16 x 20	100	22	8.0	6.2	77520	13,80
UNF 1/2 x 20	100	22	9.0	7.0	77522	13,80
UNF 9/16 x 18	100	22	11.0	9.0	77524	21,00
UNF 5/8 x 18	100	22	12.0	9.0	77526	21,00
UNF 3/4 x 16	110	25	14.0	11.0	77530	40,50
UNF 7/8 x 14	140	26	18.0	14.5	77534	49,50
UNF 1" x 14	150	28	20.0	16.0	77540	56,00
UNF 1" x 12	150	28	20.0	16.0	77538	56,00
UNF 1.1/4 x 12	150	30	22.0	18.0	77546	77,00
UNF 1.1/2 x 12	170	33	32.0	24.0	77554	161,00

Application:

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

Applicazione:

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



VÖLKEL
THREADING SOLUTIONS

Machine Taps
Unified Fine thread ANSI B 1.1

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

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

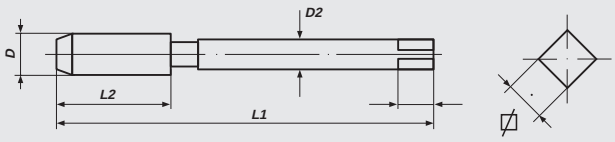
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
≈ DIN 371						
UNF No. 4 x 48	50	6	3.5	2.7	76704	10,20
UNF No. 5 x 44	56	7	3.5	2.7	76705	10,20
UNF No. 6 x 40	56	7	4.0	3.0	76706	10,20
UNF No. 8 x 36	63	8	4.5	3.4	76708	10,20
UNF No. 10 x 32	70	10	6.0	4.9	76710	10,20
UNF No. 12 x 28	70	10	6.0	4.9	76712	10,20
UNF 1/4 x 28	80	10	7.0	5.5	76714	10,20
UNF 5/16 x 24	90	10	8.0	6.2	76716	12,70
UNF 3/8 x 24	100	10	9.0	7.0	76718	14,00
≈ DIN 376						
UNF 7/16 x 20	100	13	8.0	6.2	77720	17,20
UNF 1/2 x 20	100	13	9.0	7.0	77722	17,20
UNF 9/16 x 18	100	15	11.0	9.0	77724	25,40
UNF 5/8 x 18	100	15	12.0	9.0	77726	25,40
UNF 3/4 x 16	110	17	14.0	11.0	77730	50,60
UNF 7/8 x 14	140	17	18.0	14.5	77734	61,40
UNF 1" x 14	150	20	20.0	16.0	77740	69,00
UNF 1" x 12	150	20	20.0	16.0	77738	69,00
UNF 1.1/4 x 12	150	22	22.0	18.0	77746	88,00
UNF 1.1/2 x 12	170	25	32.0	24.0	77754	193,00

Application:

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

Applicazione:

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



Machine Taps
Unified thread ANSI B 1.1

Maschi a macchina
filettatura unificata ANSI B1.1

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

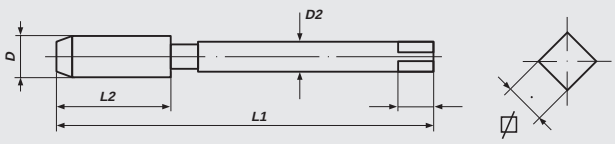
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
8-UN						
UN 1.1/16 x 8	138	48	20.0	16.0	83101	58,00
UN 1.1/8 x 8	138	48	20.0	16.0	83102	58,00
UN 1.3/16 x 8	151	51	22.4	18.0	83103	68,00
UN 1.1/4 x 8	151	51	22.4	18.0	83104	68,00
UN 1.5/16 x 8	162	57	25.0	20.0	83105	85,00
UN 1.3/8 x 8	162	57	25.0	20.0	83106	85,00
UN 1.1/2 x 8	170	60	28.0	22.4	83107	110,00
UN 1.5/8 x 8	170	60	28.0	22.4	83108	130,00
UN 1.3/4 x 8	187	67	31.5	25.0	83109	150,00
UN 1.7/8 x 8	187	67	31.5	25.0	83110	230,00
UN 2" x 8	200	70	35.5	28.0	83111	230,00
UN 2.1/8 x 8	200	70	35.5	28.0	83112	456,00
UN 2.1/4 x 8	221	76	40.0	31.5	83113	456,00
UN 2.1/2 x 8	224	79	40.0	31.5	83115	665,00
UN 2.3/4 x 8	234	79	45.0	35.5	83116	730,00
UN 3" x 8	258	83	50.0	40.0	83117	820,00
UN 3.1/4 x 8	261	86	50.0	40.0	83118	820,00
UN 3.1/2 x 8	261	86	50.0	40.0	83119	960,00
UN 3.3/4 x 8	279	89	56.0	45.0	83120	1.190,00
UN 4" x 8	279	89	56.0	45.0	83121	1.190,00
12-UN						
UN 1.5/8 x 12	170	60	28.0	22.4	83301	130,00
UN 1.3/4 x 12	187	67	31.5	25.0	83302	150,00
UN 1.7/8 x 12	187	67	31.5	25.0	83303	230,00
UN 2" x 12	200	70	35.5	28.0	83304	230,00
UN 2.1/8 x 12	200	70	35.5	28.0	83305	456,00
UN 2.1/4 x 12	221	76	40.0	31.5	83306	456,00
UN 2.1/2 x 12	224	79	40.0	31.5	83308	665,00
UN 2.3/4 x 12	234	79	45.0	35.5	83309	730,00
UN 3" x 12	258	83	50.0	40.0	83310	820,00
UN 3.1/4 x 12	261	86	50.0	40.0	83311	820,00
UN 3.1/2 x 12	261	86	50.0	40.0	83312	960,00
UN 3.3/4 x 12	279	89	56.0	45.0	83313	1.190,00
UN 4" x 12	279	89	56.0	45.0	83314	1.190,00

Application:

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

Applicazione:

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



VÖLKEL
THREADING SOLUTIONS

Machine Taps
Unified thread ANSI B 1.1

Maschi a macchina
filettatura unificata ANSI B1.1

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

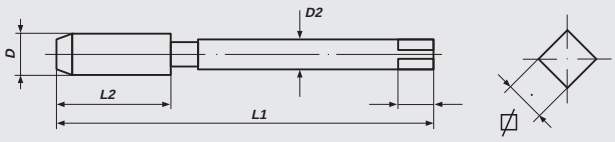
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
8-UN						
UN 1.1/16 x 8	138	48	20.0	16.0	83151	73,00
UN 1.1/8 x 8	138	48	20.0	16.0	83152	73,00
UN 1.3/16 x 8	151	51	22.4	18.0	83153	85,00
UN 1.1/4 x 8	151	51	22.4	18.0	83154	85,00
UN 1.5/16 x 8	162	57	25.0	20.0	83155	106,50
UN 1.3/8 x 8	162	57	25.0	20.0	83156	106,50
UN 1.1/2 x 8	170	60	28.0	22.4	83157	138,00
UN 1.5/8 x 8	170	60	28.0	22.4	83158	162,00
UN 1.3/4 x 8	187	67	31.5	25.0	83159	187,00
UN 1.7/8 x 8	187	67	31.5	25.0	83160	289,00
UN 2" x 8	200	70	35.5	28.0	83161	289,00
UN 2.1/8 x 8	200	70	35.5	28.0	83162	573,00
UN 2.1/4 x 8	221	76	40.0	31.5	83163	573,00
UN 2.1/2 x 8	224	79	40.0	31.5	83165	830,00
UN 2.3/4 x 8	234	79	45.0	35.5	83166	920,00
UN 3" x 8	258	83	50.0	40.0	83167	1.020,00
UN 3.1/4 x 8	261	86	50.0	40.0	83168	1.020,00
UN 3.1/2 x 8	261	86	50.0	40.0	83169	1.200,00
UN 3.3/4 x 8	279	89	56.0	45.0	83170	1.500,00
UN 4" x 8	279	89	56.0	45.0	83171	1.500,00
12-UN						
UN 1.5/8 x 12	170	60	28.0	22.4	83351	162,00
UN 1.3/4 x 12	187	67	31.5	25.0	83352	187,00
UN 1.7/8 x 12	187	67	31.5	25.0	83353	289,00
UN 2" x 12	200	70	35.5	28.0	83354	289,00
UN 2.1/8 x 12	200	70	35.5	28.0	83355	573,00
UN 2.1/4 x 12	221	76	40.0	31.5	83356	573,00
UN 2.1/2 x 12	224	79	40.0	31.5	83358	830,00
UN 2.3/4 x 12	234	79	45.0	35.5	83359	920,00
UN 3" x 12	258	83	50.0	40.0	83360	1.020,00
UN 3.1/4 x 12	261	86	50.0	40.0	83361	1.020,00
UN 3.1/2 x 12	261	86	50.0	40.0	83362	1.200,00
UN 3.3/4 x 12	279	89	56.0	45.0	83363	1.500,00
UN 4" x 12	279	89	56.0	45.0	83364	1.500,00

Application:

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

Applicazione:

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



Machine Taps
Unified Extra Fine thread ANSI B 1.1

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

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

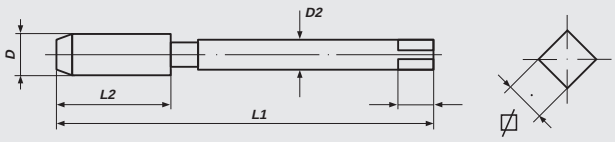
Nominal Diameter D		L 1	L 2	D 2	⧄	Art.-No.	€
UNEF	Nr.12 x 32	62	17	5.6	4.5	83320	8,40
UNEF	1/4 x 32	66	19	6.3	5.0	83321	7,50
UNEF	5/16 x 32	72	22	8.0	6.3	83322	9,40
UNEF	3/8 x 32	80	24	10.0	8.0	83323	10,70
UNEF	7/16 x 28	85	25	8.0	6.3	83324	12,60
UNEF	1/2 x 28	89	29	9.0	7.1	83325	12,60
UNEF	9/16 x 24	95	30	11.2	9.0	83326	19,00
UNEF	5/8 x 24	102	32	12.5	10.0	83327	19,40
UNEF	11/16 x 24	112	37	14.0	11.2	83328	36,00
UNEF	3/4 x 20	112	37	14.0	11.2	83329	36,00
UNEF	13/16 x 20	118	38	16.0	12.5	83330	44,00
UNEF	7/8 x 20	118	38	16.0	12.5	83331	44,00
UNEF	15/16 x 20	130	45	18.0	14.0	83332	50,40
UNEF	1" x 20	130	45	18.0	14.0	83333	50,40
UNEF	1.1/16 x 18	138	48	20.0	16.0	83334	58,00
UNEF	1.1/8 x 18	138	48	20.0	16.0	83335	58,00
UNEF	1.3/16 x 18	151	51	22.4	18.0	83336	68,00
UNEF	1.1/4 x 18	151	51	22.4	18.0	83337	68,00
UNEF	1.5/16 x 18	162	57	25.0	20.0	83338	85,00
UNEF	1.3/8 x 18	162	57	25.0	20.0	83339	85,00
UNEF	1.7/16 x 18	170	60	28.0	22.4	83340	110,00
UNEF	1.1/2 x 18	170	60	28.0	22.4	83341	110,00
UNEF	1.9/16 x 18	170	60	28.0	22.4	83342	130,00
UNEF	1.5/8 x 18	170	60	28.0	22.4	83343	130,00
UNEF	1.11/16 x 18	187	67	31.5	25.0	83344	150,00
UNEF	1.3/4 x 18	187	67	31.5	25.0	83345	150,00
UNEF	2" x 18	200	70	35.5	28.0	83346	230,00

Application:

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

Applicazione:

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



VÖLKEL
THREADING SOLUTIONS

Maschine Taps
Unified Extra Fine thread ANSI B 1.1

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

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

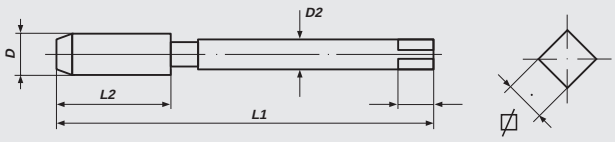
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
UNEF Nr. 12 x 32	62	17	5.6	4.5	83370	10,40
UNEF 1/4 x 32	66	19	6.3	5.0	83371	9,30
UNEF 5/16 x 32	72	22	8.0	6.3	83372	11,80
UNEF 3/8 x 32	80	24	10.0	8.0	83373	13,30
UNEF 7/16 x 28	85	25	8.0	6.3	83374	15,70
UNEF 1/2 x 28	89	29	9.0	7.1	83375	15,70
UNEF 9/16 x 24	95	30	11.2	9.0	83376	23,50
UNEF 5/8 x 24	102	32	12.5	10.0	83377	23,50
UNEF 11/16 x 24	112	37	14.0	11.2	83378	45,00
UNEF 3/4 x 20	112	37	14.0	11.2	83379	45,00
UNEF 13/16 x 20	118	38	16.0	12.5	83380	55,00
UNEF 7/8 x 20	118	38	16.0	12.5	83381	55,00
UNEF 15/16 x 20	130	45	18.0	14.0	83382	63,00
UNEF 1" x 20	130	45	18.0	14.0	83383	63,00

Application:

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

Applicazione:

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



Machine Taps
Unified thread ANSI B 1.1

Maschi a macchina
filettatura unificata ANSI B1.1

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

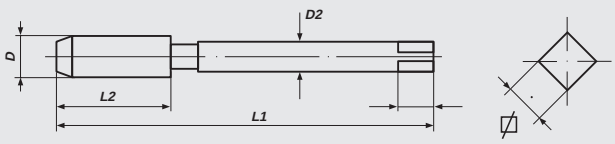
Nominal Diameter D		L 1	L 2	D 2	⌀	Art.-No.	€
UNS							
UNS	1/4 x 24	66	19	6.3	5.0	83201	7,50
UNS	1/4 x 36	66	19	6.3	5.0	83202	7,50
UNS	1/4 x 40	66	19	6.3	5.0	83203	7,50
UNS	3/8 x 27	80	24	10.0	8.0	83204	10,70
UNS	7/16 x 24	85	25	8.0	6.3	83205	12,60
UNS	1/2 x 24	89	29	9.0	7.1	83206	12,60
UNS	5/8 x 27	102	32	12.5	10.0	83207	19,40
UNS	3/4 x 24	112	37	14.0	11.2	83208	36,00
UNS	7/8 x 18	118	38	16.0	12.5	83209	44,00
UNS	1" x 14	130	45	18.0	14.0	83210	50,40
UN							
UN	5/16 x 28	72	22	8.0	6.3	83221	9,50
UN	3/8 x 20	80	24	10.0	8.0	83222	10,70
UN	3/8 x 28	80	24	10.0	8.0	83223	10,70
UN	7/16 x 32	85	25	8.0	6.3	83224	12,60
UN	1/2 x 32	89	29	9.0	7.1	83225	12,60
UN	9/16 x 20	95	30	11.2	9.0	83226	19,00
UN	9/16 x 28	95	30	11.2	9.0	83227	19,00
UN	9/16 x 32	95	30	11.2	9.0	83228	19,00
UN	5/8 x 20	102	32	12.5	10.0	83229	19,40
UN	5/8 x 28	102	32	12.5	10.0	83230	19,40
UN	11/16 x 20	112	37	14.0	11.2	83231	36,00
UN	11/16 x 16	112	37	14.0	11.2	83232	36,00
UN	1" x 32	130	45	18.0	14.0	83233	50,00

Application:

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

Applicazione:

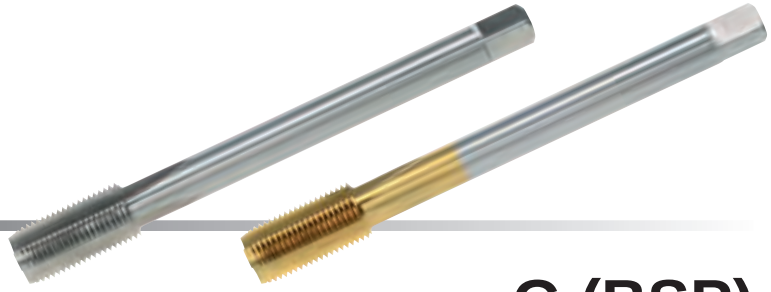
per uso universale
- Materiali con buona truciodibilità fino a R 900 N/mm²
- Acciaio non legati e scarsamente legati
- per fori passanti



VÖLKEL
THREADING SOLUTIONS

Machine Taps
Pipe-thread DIN ISO 228

Maschi a macchina
filettatura per tubi gas DIN ISO 228



DIN 5156 Form C HSS-E

G (BSP)

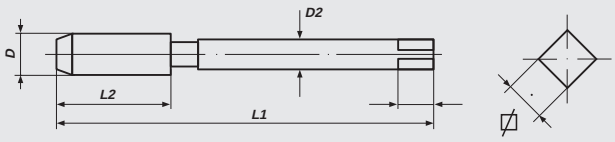
Nominal Diameter D		L 1	L 2	D 2	⧄	Art.-No.	€
G	1/8 x 28	90	20	7.0	5.5	78412	12,70
G	1/4 x 19	100	22	11.0	9.0	78414	16,00
G	3/8 x 19	100	22	12.0	9.0	78416	20,00
G	1/2 x 14	125	25	16.0	12.0	78418	28,00
G	5/8 x 14	125	25	18.0	14.5	78420	32,00
G	3/4 x 14	140	28	20.0	16.0	78422	41,50
G	7/8 x 14	150	28	22.0	18.0	78424	48,80
G	1" x 11	160	30	25.0	20.0	78426	60,00
G	1.1/8 x 11	170	30	28.0	22.0	78430	83,50
G	1.1/4 x 11	170	30	32.0	24.0	78434	113,00
G	1.3/8 x 11	180	32	36.0	29.0	78438	133,00
G	1.1/2 x 11	190	32	36.0	29.0	78442	157,50
G	1.3/4 x 11	190	32	40.0	32.0	78450	207,00
G	2" x 11	220	40	45.0	35.0	78454	216,00
TIN							
G	1/8 x 28	90	20	7.0	5.5	78413	19,20
G	1/4 x 19	100	22	11.0	9.0	78415	27,00
G	3/8 x 19	100	22	12.0	9.0	78417	35,90
G	1/2 x 14	125	25	16.0	12.0	78419	60,00
G	3/4 x 14	140	28	20.0	16.0	78423	84,70
G	1" x 11	160	30	25.0	20.0	78427	126,00

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

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

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

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



Machine Taps
Pipe-thread DIN ISO 228

Maschi a macchina
filettatura per tubi gas DIN ISO 228

DIN 5156 Form C HSS-E

G (BSP)

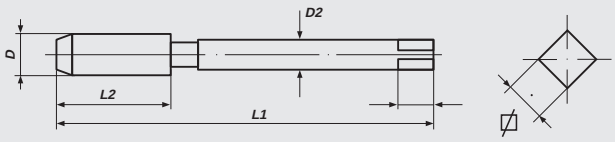
Nominal Diameter D		L 1	L 2	D 2	⌀	Art.-No.	€
G	1/8 x 28	90	20	7.0	5.5	78512	13,30
G	1/4 x 19	100	22	11.0	9.0	78514	16,80
G	3/8 x 19	100	22	12.0	9.0	78516	20,00
G	1/2 x 14	125	25	16.0	12.0	78518	29,40
G	5/8 x 14	125	25	18.0	14.5	78520	33,60
G	3/4 x 14	140	28	20.0	16.0	78522	43,80
G	7/8 x 14	150	28	22.0	18.0	78524	54,50
G	1" x 11	160	30	25.0	20.0	78526	67,70
G	1.1/8 x 11	170	30	28.0	22.0	78530	99,50
G	1.1/4 x 11	170	30	32.0	24.0	78534	120,00
G	1.3/8 x 11	180	32	36.0	29.0	78538	156,00
G	1.1/2 x 11	190	32	36.0	29.0	78542	169,00
G	1.3/4 x 11	190	32	40.0	32.0	78550	246,00
G	2" x 11	220	40	45.0	35.0	78554	252,00
TIN							
G	1/8 x 28	90	20	7.0	5.5	78513	19,80
G	1/4 x 19	100	22	11.0	9.0	78515	27,80
G	3/8 x 19	100	22	12.0	9.0	78517	35,90
G	1/2 x 14	125	25	16.0	12.0	78519	61,40
G	3/4 x 14	140	28	20.0	16.0	78523	87,00
G	1" x 11	160	30	25.0	20.0	78527	133,70

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

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

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

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



VÖLKEL THREADING SOLUTIONS

Machine Taps
Pipe-thread DIN ISO 228

Maschi a macchina
filettatura per tubi gas DIN ISO 228

DIN 5156 Form C/35° RSP HSS-E G (BSP)

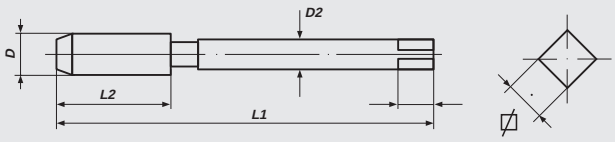
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
G 1/8 x 28	90	20	7.0	5.5	78712	15,00
G 1/4 x 19	100	22	11.0	9.0	78714	19,30
G 3/8 x 19	100	22	12.0	9.0	78716	24,00
G 1/2 x 14	125	25	16.0	12.0	78718	33,60
G 5/8 x 14	125	25	18.0	14.5	78720	38,90
G 3/4 x 14	140	28	20.0	16.0	78722	50,40
G 7/8 x 14	150	28	22.0	18.0	78724	59,30
G 1" x 11	160	30	25.0	20.0	78726	73,50
G 1.1/8 x 11	170	30	28.0	22.0	78730	107,00
G 1.1/4 x 11	170	30	32.0	24.0	78734	136,50
G 1.3/8 x 11	180	32	36.0	29.0	78738	165,00
G 1.1/2 x 11	190	32	36.0	29.0	78742	191,00
G 1.3/4 x 11	190	32	40.0	32.0	78750	251,00
G 2" x 11	220	40	45.0	35.0	78754	258,00
TIN						
G 1/8 x 28	90	20	7.0	5.5	78713	21,50
G 1/4 x 19	100	22	11.0	9.0	78715	30,30
G 3/8 x 19	100	22	12.0	9.0	78717	39,90
G 1/2 x 14	125	25	16.0	12.0	78719	65,60
G 3/4 x 14	140	28	20.0	16.0	78723	93,60
G 1" x 11	160	30	25.0	20.0	78727	139,50

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

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

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

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



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

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

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

Rc (BSPT)

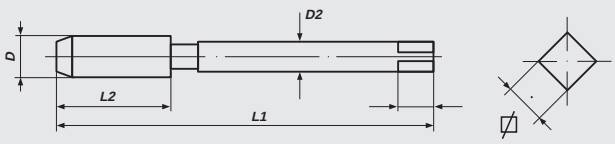
Nominal Diameter D	L 1	L 2	D 2	⊠	Art.-No.	€
Rc 1/8 x 28	90	20	7.0	5.5	73404	16,00
Rc 1/4 x 19	100	22	11.0	9.0	73406	20,00
Rc 3/8 x 19	100	22	12.0	9.0	73408	25,00
Rc 1/2 x 14	125	28	16.0	12.0	73410	35,00
Rc 3/4 x 14	140	28	20.0	16.0	73412	53,00
Rc 1" x 11	160	38	25.0	20.0	73414	76,00

Application:

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

Applicazione:

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



VÖLKEL
THREADING SOLUTIONS

Machine Taps
american tapered pipe thread, taper 1:16

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

Form C HSS-E

NPT

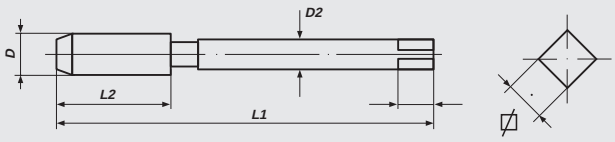
Nominal Diameter D	L 1	L 2	D 2	⊠	Art.-No.	€
NPT 1/16 x 27	90	20	6.0	4.9	73432	21,20
NPT 1/8 x 27	90	20	7.0	5.5	73434	16,00
NPT 1/4 x 18	100	22	11.0	9.0	73436	20,00
NPT 3/8 x 18	100	22	12.0	9.0	73438	25,00
NPT 1/2 x 14	125	28	16.0	12.0	73440	35,00
NPT 3/4 x 14	140	28	20.0	16.0	73442	53,00
NPT 1" x 11.5	160	38	25.0	20.0	73444	76,00

Application:

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

Applicazione:

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



Machine Taps
Knuckle thread DIN 405

Maschi a macchina
filettatura rotunda DIN 405

DIN 374 Form C HSS-E Tol. 7H

Rd

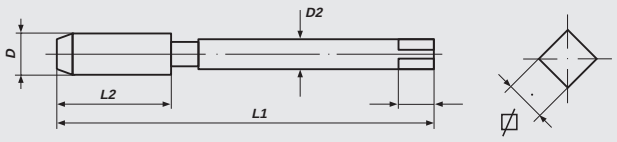
Nominal Diameter D	L 1	L 2	D 2	⌀	Art.-No.	€
Rd 8 x 1/10	90	26	6.0	4.9	79440	70,00
Rd 9 x 1/10	90	26	7.0	5.5	79441	70,00
Rd 10 x 1/10	100	28	7.0	5.5	79442	70,00
Rd 11 x 1/10	100	28	8.0	6.2	79443	85,00
Rd 12 x 1/10	110	28	9.0	7.0	79444	95,00
Rd 14 x 1/8	110	32	11.0	9.0	79445	120,00
Rd 16 x 1/8	110	32	12.0	9.0	79446	125,00
Rd 18 x 1/8	125	32	14.0	11.0	79447	150,00
Rd 20 x 1/8	140	32	16.0	12.0	79448	150,00
Rd 22 x 1/8	140	32	18.0	14.5	79449	195,00
Rd 24 x 1/8	160	34	18.0	14.5	79450	235,00
Rd 26 x 1/8	160	36	20.0	16.0	79451	275,00
Rd 28 x 1/8	160	36	20.0	16.0	79452	295,00
Rd 30 x 1/8	180	36	22.0	18.0	79453	310,00
Rd 32 x 1/8	180	36	25.0	20.0	79454	415,00
Rd 34 x 1/8	200	36	28.0	22.0	79455	470,00
Rd 36 x 1/8	200	36	28.0	22.0	79456	475,00
Rd 38 x 1/8	200	38	28.0	22.0	79457	550,00
Rd 40 x 1/6	200	50	32.0	24.0	79458	650,00
Rd 42 x 1/6	200	50	32.0	24.0	79459	750,00
Rd 44 x 1/6	200	50	36.0	29.0	79460	900,00

Application:

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

Applicazione:

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



VÖLKEL
THREADING SOLUTIONS

Machine Taps
Cycle thread DIN 79012

Maschi a macchina
filettatura per biciclette DIN 79012

DIN 374 Form C HSS-E Tol. medium FG

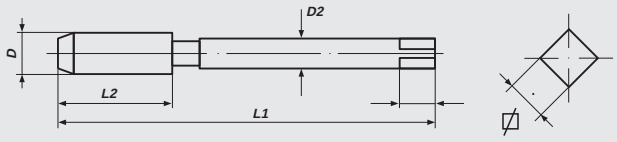
Nennmaß D	L 1	L 2	D 2	⧄	Art.-No.	€
FG 2 x 56	45	8	2.8	2.1	79401	80,00
FG 2.3 x 56	45	8	2.8	2.1	79402	80,00
FG 2.6 x 56	56	8	3.5	2.7	79403	80,00
FG 6.35 x 26	80	14	7.0	5.5	79404	70,00
FG 7.9 x 26	90	16	8.0	6.2	79405	75,00
FG 9.5 x 26	90	16	7.0	5.5	79406	75,00
FG 14.3 x 20	100	22	11.0	9.0	79407	80,00
FG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

Application:

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

Applicazione:

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



Machine Taps
Cycle thread BS 811

Maschi a macchina
filettatura inglese per biciclette BS 811

DIN 374 Form C HSS-E Tol. medium BSC

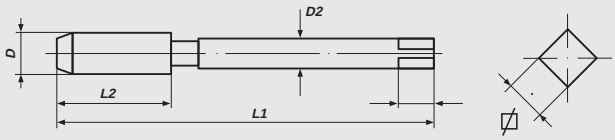
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
BSC 1/4 x 26	80	14	7.0	5.5	79420	70,00
BSC 5/16 x 26	90	16	8.0	6.2	79421	75,00
BSC 3/8 x 26	90	16	7.0	5.5	79422	80,00
BSC 9/16 x 20	100	22	11.0	9.0	79423	80,00
BSC 9/16 x 20 - LH	100	22	11.0	9.0	79424	90,00
BSC 1" x 24	140	24	18.0	14.5	79425	130,00

Application:

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

Applicazione:

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



Machine Taps
Valve thread DIN 7756

Maschi a macchina
filettatura per valvole DIN 7756

DIN 374 Form C HSS-E Tol. medium Vg

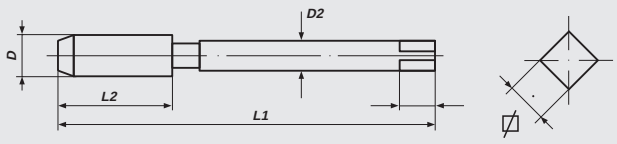
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
Vg 5 x 36	70	12	6.0	4.9	79430	65,00
Vg 5.2 x 24	80	17	6.0	4.9	79431	65,00
Vg 6 x 32	80	14	7.0	5.5	79432	72,50
Vg 8 x 32	80	16	8.0	6.2	79433	74,00
Vg 10 x 28	90	18	8.0	6.2	79434	80,00
Vg 12 x 26	100	22	9.0	7.0	79435	90,00

Application:

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

Applicazione:

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



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

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

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

M

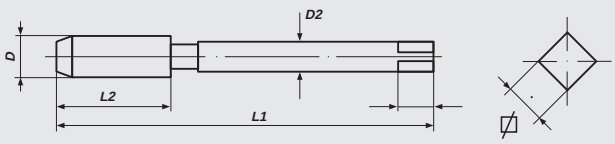
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
DIN 371						
M 3 x 0.5	56	11	3.5	2.7	33426	9,20
M 4 x 0.7	63	13	4.5	3.4	33430	9,20
M 5 x 0.8	70	16	6.0	4.9	33434	9,60
M 6 x 1.0	80	19	6.0	4.9	33438	9,60
M 8 x 1.25	90	22	8.0	6.2	33442	11,50
M 10 x 1.5	100	24	10.0	8.0	33446	13,10
DIN 376						
M 12 x 1.75	110	29	9.0	7.0	34450	15,60
M 14 x 2.0	110	30	11.0	9.0	34454	23,10
M 16 x 2.0	110	32	12.0	9.0	34458	26,20
M 18 x 2.5	125	34	14.0	11.0	34462	35,70
M 20 x 2.5	140	34	16.0	12.0	34466	50,40
M 22 x 2.5	140	34	18.0	14.5	34470	52,50
M 24 x 3.0	160	38	18.0	14.5	34474	54,60

Application:

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

Applicazione:

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



VÖLKEL
THREADING SOLUTIONS

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

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

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

M

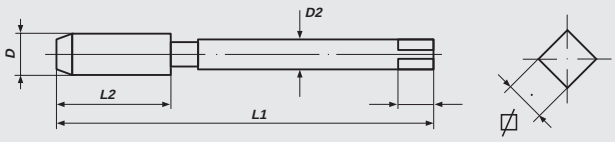
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
DIN 371						
M 3 x 0.5	56	11	3.5	2.7	33526	10,50
M 4 x 0.7	63	13	4.5	3.4	33530	10,50
M 5 x 0.8	70	16	6.0	4.9	33534	10,90
M 6 x 1.0	80	19	6.0	4.9	33538	10,90
M 7 x 1.0	80	19	7.0	5.5	33540	14,20
M 8 x 1.25	90	22	8.0	6.2	33542	13,30
M 10 x 1.5	100	24	10.0	8.0	33546	15,00
DIN 376						
M 3 x 0.5	56	11	2.2	—	34526	10,50
M 4 x 0.7	63	13	2.8	2.1	34530	10,50
M 5 x 0.8	70	16	3.5	2.7	34534	10,90
M 6 x 1.0	80	19	4.5	3.4	34538	10,90
M 8 x 1.25	90	22	6.0	4.9	34542	13,30
M 10 x 1.5	100	24	7.0	5.5	34546	15,00
M 12 x 1.75	110	29	9.0	7.0	34550	18,90
M 14 x 2.0	110	30	11.0	9.0	34554	24,00
M 16 x 2.0	110	32	12.0	9.0	34558	27,80
M 18 x 2.5	125	34	14.0	11.0	34562	37,80
M 20 x 2.5	140	34	16.0	12.0	34566	53,50
M 22 x 2.5	140	34	18.0	14.5	34570	58,80
M 24 x 3.0	160	38	18.0	14.5	34574	63,00
M 27 x 3.0	160	38	20.0	16.0	34576	104,00
M 30 x 3.5	180	45	22.0	18.0	34578	109,00
M 33 x 3.5	180	50	25.0	20.0	34580	148,00
M 36 x 4.0	200	56	28.0	22.0	34582	248,00
M 39 x 4.0	200	60	32.0	24.0	34584	312,00
M 42 x 4.5	200	60	32.0	24.0	34586	371,00
M 45 x 4.5	220	65	36.0	29.0	34588	409,00
M 48 x 5.0	250	70	36.0	29.0	34590	451,00
M 52 x 5.0	250	70	40.0	32.0	34592	535,00

Application:

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

Applicazione:

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



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

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

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

M

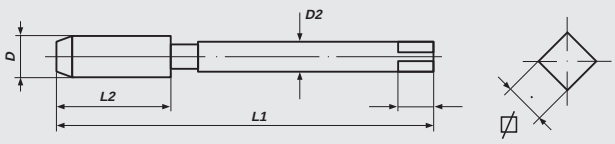
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
DIN 371						
M 3 x 0.5	56	6	3.5	2.7	33726	12,30
M 4 x 0.7	63	7	4.5	3.4	33730	12,30
M 5 x 0.8	70	8	6.0	4.9	33734	13,10
M 6 x 1.0	80	10	6.0	4.9	33738	13,10
M 8 x 1.25	90	14	8.0	6.2	33742	15,70
M 10 x 1.5	100	16	10.0	8.0	33746	17,90
DIN 376						
M 3 x 0.5	56	6	2.2	—	34726	12,30
M 4 x 0.7	63	7	2.8	2.1	34730	12,30
M 5 x 0.8	70	8	3.5	2.7	34734	13,10
M 6 x 1.0	80	10	4.5	3.4	34738	13,10
M 8 x 1.25	90	14	6.0	4.9	34742	15,70
M 10 x 1.5	100	16	7.0	5.5	34746	17,90
M 12 x 1.75	110	18	9.0	7.0	34750	20,40
M 14 x 2.0	110	20	11.0	9.0	34754	26,00
M 16 x 2.0	110	22	12.0	9.0	34758	30,00
M 18 x 2.5	125	25	14.0	11.0	34762	40,00
M 20 x 2.5	140	25	16.0	12.0	34766	57,00
M 22 x 2.5	140	27	18.0	14.5	34770	64,00
M 24 x 3.0	160	30	18.0	14.5	34774	66,00
M 27 x 3.0	160	30	20.0	16.0	34776	113,00
M 30 x 3.5	180	35	22.0	18.0	34778	117,00
M 33 x 3.5	180	35	25.0	20.0	34780	162,00
M 36 x 4.0	200	40	28.0	22.0	34782	274,00
M 39 x 4.0	200	40	32.0	24.0	34784	336,00
M 42 x 4.5	200	45	32.0	24.0	34786	393,00
M 45 x 4.5	220	45	36.0	29.0	34788	446,00
M 48 x 5.0	250	50	36.0	29.0	34790	487,00
M 52 x 5.0	250	50	40.0	32.0	34792	567,00

Application:

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

Applicazione:

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



VÖLKEL
THREADING SOLUTIONS

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

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

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

Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
M 3 x 0.35	56	9	2.2	-	34801	25,00
M 4 x 0.35	63	10	2.8	2.1	34802	25,00
M 4 x 0.5	63	10	2.8	2.1	34803	25,00
M 5 x 0.5	70	12	3.5	2.7	34804	25,00
M 5 x 0.75	70	12	3.5	2.7	34805	25,00
M 6 x 0.5	80	14	4.5	3.4	34806	25,00
M 6 x 0.75	80	14	4.5	3.4	34807	25,00
M 7 x 0.75	80	14	5.5	4.3	34808	25,00
M 8 x 0.5	80	19	6.0	4.9	34809	25,00
M 8 x 0.75	80	19	6.0	4.9	34810	25,00
M 8 x 1.0	90	22	6.0	4.9	34811	25,00
M 9 x 0.75	80	19	7.0	5.5	34812	25,00
M 9 x 1.0	90	22	7.0	5.5	34813	25,00
M 10 x 0.75	90	20	7.0	5.5	34814	27,80
M 10 x 1.0	90	20	7.0	5.5	34815	27,80
M 10 x 1.25	100	24	7.0	5.5	34816	27,80
M 11 x 1.0	90	20	8.0	6.2	34817	38,80
M 11 x 1.25	90	22	8.0	6.2	34818	38,80
M 12 x 0.75	100	22	9.0	7.0	34819	38,80
M 12 x 1.0	100	22	9.0	7.0	34820	38,80
M 12 x 1.25	100	22	9.0	7.0	34821	38,80
M 12 x 1.5	100	22	9.0	7.0	34822	38,80
M 13 x 1.0	100	22	11.0	9.0	34823	47,20
M 13 x 1.5	100	22	11.0	9.0	34824	47,20
M 14 x 0.75	100	22	11.0	9.0	34825	47,20
M 14 x 1.0	100	22	11.0	9.0	34826	47,20
M 14 x 1.25	100	22	11.0	9.0	34827	47,20
M 14 x 1.5	100	22	11.0	9.0	34828	47,20
M 15 x 1.0	100	22	12.0	9.0	34829	54,80
M 15 x 1.5	100	22	12.0	9.0	34830	54,80
M 16 x 1.0	100	22	12.0	9.0	34831	54,80
M 16 x 1.25	100	22	12.0	9.0	34832	54,80
M 16 x 1.5	100	22	12.0	9.0	34833	54,80
M 18 x 1.0	110	25	14.0	11.0	34834	65,60
M 18 x 1.25	110	25	14.0	11.0	34835	65,60
M 18 x 1.5	110	25	14.0	11.0	34836	65,60
M 18 x 2.0	125	34	14.0	11.0	34837	65,60

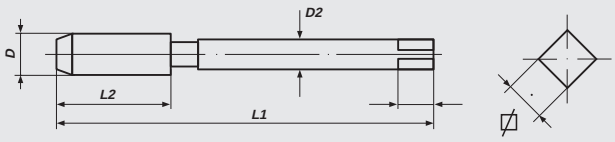
►►►

Application:

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

Applicazione:

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



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

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

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

Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
M 20 x 1.0	125	25	16.0	12.0	34838	71,90
M 20 x 1.25	125	25	16.0	12.0	34839	71,90
M 20 x 1.5	125	25	16.0	12.0	34840	71,90
M 20 x 2.0	140	34	16.0	12.0	34841	71,90
M 21 x 1.5	125	25	16.0	12.0	34842	71,90
M 22 x 1.0	125	25	18.0	14.5	34843	90,30
M 22 x 1.25	125	25	18.0	14.5	34844	90,30
M 22 x 1.5	125	25	18.0	14.5	34845	90,30
M 22 x 2.0	140	34	18.0	14.5	34846	90,30
M 23 x 1.5	125	25	18.0	14.5	34847	105,50
M 24 x 1.0	140	28	18.0	14.5	34848	105,50
M 24 x 1.25	140	28	18.0	14.5	34849	105,50
M 24 x 1.5	140	28	18.0	14.5	34850	105,50
M 24 x 2.0	140	28	18.0	14.5	34851	105,50
M 25 x 1.0	140	28	18.0	14.5	34852	105,50
M 25 x 1.5	140	28	18.0	14.5	34853	105,50
M 26 x 1.0	140	28	18.0	14.5	3485X	105,50
M 26 x 1.5	140	28	18.0	14.5	34854	105,50
M 26 x 2.0	140	28	18.0	14.5	34855	105,50
M 27 x 1.0	140	28	20.0	16.0	34800	132,00
M 27 x 1.5	140	28	20.0	16.0	34856	132,00
M 27 x 2.0	140	28	20.0	16.0	34857	132,00
M 28 x 1.0	140	28	20.0	16.0	34858	132,00
M 28 x 1.5	140	28	20.0	16.0	34859	132,00
M 28 x 2.0	140	28	20.0	16.0	34860	132,00
M 29 x 1.5	150	28	22.0	18.0	34861	151,00
M 30 x 1.0	150	28	22.0	18.0	34862	151,00
M 30 x 1.5	150	28	22.0	18.0	34863	151,00
M 30 x 2.0	150	28	22.0	18.0	34864	151,00
M 30 x 2.5	180	45	22.0	18.0	3486X	151,00
M 30 x 3.0	180	45	22.0	18.0	34865	151,00
M 32 x 1.5	150	28	22.0	18.0	34866	186,00
M 32 x 2.0	150	28	22.0	18.0	34867	186,00
M 32 x 3.0	180	50	22.0	18.0	34892	186,00
M 33 x 1.5	160	30	25.0	20.0	34893	186,00
M 33 x 2.0	160	30	25.0	20.0	34868	186,00
M 33 x 3.0	180	50	25.0	20.0	34869	186,00

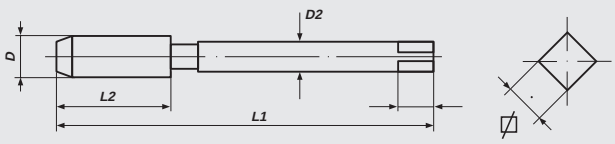
►►►

Application:

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

Applicazione:

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



VÖLKEL
THREADING SOLUTIONS

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

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

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

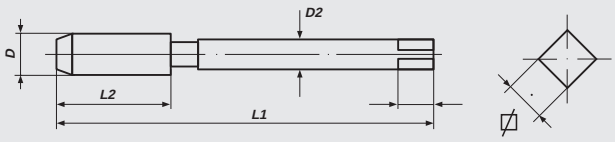
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
M 34 x 1.5	170	30	28.0	22.0	34870	186,00
M 34 x 2.0	170	30	28.0	22.0	34871	186,00
M 35 x 1.5	170	30	28.0	22.0	34872	186,00
M 36 x 1.5	170	30	28.0	22.0	34873	234,00
M 36 x 2.0	170	30	28.0	22.0	34874	234,00
M 36 x 3.0	200	56	28.0	22.0	34875	234,00
M 38 x 1.5	170	30	28.0	22.0	34876	247,00
M 39 x 1.5	170	30	32.0	24.0	34877	247,00
M 39 x 2.0	170	30	32.0	24.0	34878	247,00
M 39 x 3.0	200	60	32.0	24.0	34879	247,00
M 40 x 1.5	170	30	32.0	24.0	34880	269,00
M 40 x 2.0	170	30	32.0	24.0	34881	269,00
M 40 x 3.0	200	60	32.0	24.0	34882	269,00
M 42 x 1.5	170	30	32.0	24.0	34883	301,00
M 42 x 2.0	170	30	32.0	24.0	34884	301,00
M 42 x 3.0	200	60	32.0	24.0	34885	301,00
M 45 x 1.5	180	32	36.0	29.0	34886	357,00
M 45 x 2.0	180	32	36.0	29.0	34887	357,00
M 45 x 3.0	200	50	36.0	29.0	34888	357,00
M 48 x 1.5	190	32	36.0	29.0	34889	430,00
M 48 x 2.0	190	32	36.0	29.0	34890	430,00
M 48 x 3.0	225	50	36.0	29.0	34891	430,00
M 50 x 1.5	190	32	36.0	29.0	34894	498,00
M 50 x 2.0	190	32	36.0	29.0	34895	498,00
M 50 x 3.0	225	50	36.0	29.0	34896	498,00
M 52 x 1.5	190	32	40.0	32.0	34897	551,00
M 52 x 2.0	190	32	40.0	32.0	34898	551,00
M 52 x 3.0	225	50	40.0	32.0	34899	551,00

Application:

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

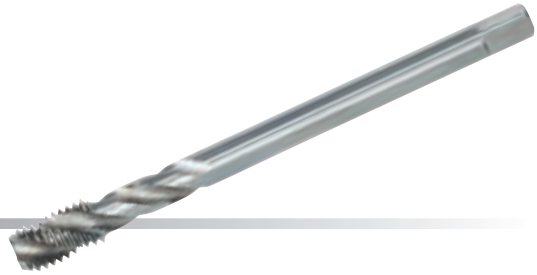
Applicazione:

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



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

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



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

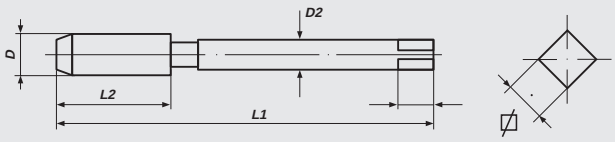
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
M 3 x 0.35	56	5	2.2	-	34901	27,80
M 4 x 0.35	63	5	2.8	2.1	34902	27,80
M 4 x 0.5	63	5	2.8	2.1	34903	27,80
M 5 x 0.5	70	5	3.5	2.7	34904	27,80
M 5 x 0.75	70	8	3.5	2.7	34905	27,80
M 6 x 0.5	80	5	4.5	3.4	34906	27,80
M 6 x 0.75	80	8	4.5	3.4	34907	27,80
M 7 x 0.75	80	8	5.5	4.3	34908	27,80
M 8 x 0.5	80	8	6.0	4.9	34909	27,80
M 8 x 0.75	80	8	6.0	4.9	34910	27,80
M 8 x 1.0	90	10	6.0	4.9	34911	27,80
M 9 x 0.75	80	10	7.0	5.5	34912	27,80
M 9 x 1.0	90	10	7.0	5.5	34913	27,80
M 10 x 0.75	90	10	7.0	5.5	34914	33,60
M 10 x 1.0	90	10	7.0	5.5	34915	33,60
M 10 x 1.25	100	16	7.0	5.5	34916	33,60
M 11 x 1.0	90	11	8.0	6.2	34917	43,00
M 11 x 1.25	90	14	8.0	6.2	34918	43,00
M 12 x 0.75	100	10	9.0	7.0	34919	43,00
M 12 x 1.0	100	11	9.0	7.0	34920	43,00
M 12 x 1.25	100	15	9.0	7.0	34921	43,00
M 12 x 1.5	100	15	9.0	7.0	34922	43,00
M 13 x 1.0	100	11	11.0	9.0	34923	52,50
M 13 x 1.5	100	15	11.0	9.0	34924	52,50
M 14 x 0.75	100	10	11.0	9.0	34925	52,50
M 14 x 1.0	100	11	11.0	9.0	34926	52,50
M 14 x 1.25	100	15	11.0	9.0	34927	52,50
M 14 x 1.5	100	15	11.0	9.0	34928	52,50
M 15 x 1.0	100	12	12.0	9.0	34929	60,30
M 15 x 1.5	100	15	12.0	9.0	34930	60,30
M 16 x 1.0	100	12	12.0	9.0	34931	60,30
M 16 x 1.25	100	15	12.0	9.0	34932	60,30
M 16 x 1.5	100	15	12.0	9.0	34933	60,30
M 18 x 1.0	110	13	14.0	11.0	34934	74,50
M 18 x 1.25	110	15	14.0	11.0	34935	74,50
M 18 x 1.5	110	17	14.0	11.0	34936	74,50
M 18 x 2.0	125	20	14.0	11.0	34937	74,50

Application:

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

Applicazione:

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



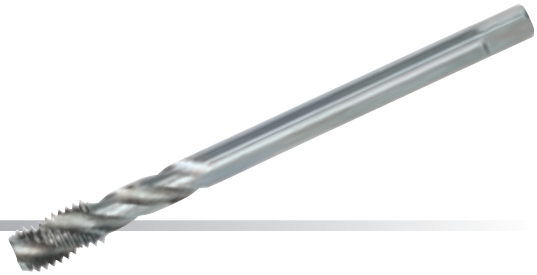
VÖLKEL
THREADING SOLUTIONS

Machine Taps, *Left Hand*

metric-fine ISO-thread DIN 13

Maschi a macchina, *filetto sinistro*

filettatura metrica fine ISO DIN 13



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

Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
M 20 x 1.0	125	14	16.0	12.0	34938	83,40
M 20 x 1.25	125	17	16.0	12.0	34939	83,40
M 20 x 1.5	125	17	16.0	12.0	34940	83,40
M 20 x 2.0	140	20	16.0	12.0	34941	83,40
M 21 x 1.5	125	17	16.0	12.0	34942	83,40
M 22 x 1.0	125	14	18.0	14.5	34943	100,00
M 22 x 1.25	125	17	18.0	14.5	34944	100,00
M 22 x 1.5	125	17	18.0	14.5	34945	100,00
M 22 x 2.0	140	20	18.0	14.5	34946	100,00
M 23 x 1.5	125	17	18.0	14.5	34947	120,00
M 24 x 1.0	140	15	18.0	14.5	34948	120,00
M 24 x 1.25	140	17	18.0	14.5	34949	120,00
M 24 x 1.5	140	20	18.0	14.5	34950	120,00
M 24 x 2.0	140	20	18.0	14.5	34951	120,00
M 25 x 1.0	140	15	18.0	14.5	34952	120,00
M 25 x 1.5	140	20	18.0	14.5	34953	120,00
M 26 x 1.0	140	15	18.0	14.5	3495X	120,00
M 26 x 1.5	140	20	18.0	14.5	34954	120,00
M 26 x 2.0	140	20	18.0	14.5	34955	120,00
M 27 x 1.0	140	15	20.0	16.0	34900	145,00
M 27 x 1.5	140	20	20.0	16.0	34956	145,00
M 27 x 2.0	140	20	20.0	16.0	34957	145,00
M 28 x 1.0	140	15	20.0	16.0	34958	145,00
M 28 x 1.5	140	20	20.0	16.0	34959	145,00
M 28 x 2.0	140	20	20.0	16.0	34960	145,00
M 29 x 1.5	150	22	22.0	18.0	34961	165,00
M 30 x 1.0	150	17	22.0	18.0	34962	165,00
M 30 x 1.5	150	22	22.0	18.0	34963	165,00
M 30 x 2.0	150	22	22.0	18.0	34964	165,00
M 30 x 2.5	180	27	22.0	18.0	3496X	165,00
M 30 x 3.0	180	30	22.0	18.0	34965	165,00
M 32 x 1.5	150	22	22.0	18.0	34966	206,00
M 32 x 2.0	150	22	22.0	18.0	34967	206,00
M 32 x 3.0	180	30	22.0	18.0	34992	206,00
M 33 x 1.5	160	24	25.0	20.0	34993	206,00
M 33 x 2.0	160	24	25.0	20.0	34968	206,00
M 33 x 3.0	180	30	25.0	20.0	34969	206,00

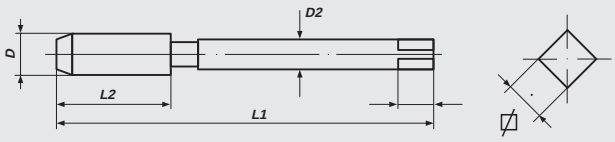
►►►

Application:

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

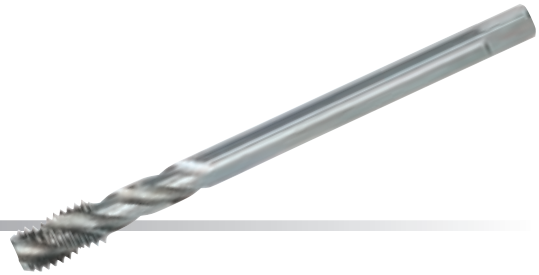
Applicazione:

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



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

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



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

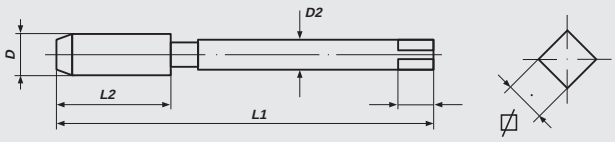
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
M 34 x 1.5	170	24	28.0	22.0	34970	206,00
M 34 x 2.0	170	24	28.0	22.0	34971	206,00
M 35 x 1.5	170	24	28.0	22.0	34972	206,00
M 36 x 1.5	170	24	28.0	22.0	34973	260,00
M 36 x 2.0	170	24	28.0	22.0	34974	260,00
M 36 x 3.0	200	30	28.0	22.0	34975	260,00
M 38 x 1.5	170	24	28.0	22.0	34976	273,00
M 39 x 1.5	170	25	32.0	24.0	34977	273,00
M 39 x 2.0	170	25	32.0	24.0	34978	273,00
M 39 x 3.0	200	30	32.0	24.0	34979	273,00
M 40 x 1.5	170	25	32.0	24.0	34980	297,00
M 40 x 2.0	170	25	32.0	24.0	34981	297,00
M 40 x 3.0	200	30	32.0	24.0	34982	297,00
M 42 x 1.5	170	25	32.0	24.0	34983	336,00
M 42 x 2.0	170	25	32.0	24.0	34984	336,00
M 42 x 3.0	200	30	32.0	24.0	34985	336,00
M 45 x 1.5	180	27	36.0	29.0	34986	394,00
M 45 x 2.0	180	27	36.0	29.0	34987	394,00
M 45 x 3.0	200	30	36.0	29.0	34988	394,00
M 48 x 1.5	190	27	36.0	29.0	34989	470,00
M 48 x 2.0	190	27	36.0	29.0	34990	470,00
M 48 x 3.0	225	33	36.0	29.0	34991	470,00
M 50 x 1.5	190	27	36.0	29.0	34994	548,00
M 50 x 2.0	190	27	36.0	29.0	34995	548,00
M 50 x 3.0	225	33	36.0	29.0	34996	548,00
M 52 x 1.5	190	27	40.0	32.0	34997	601,00
M 52 x 2.0	190	27	40.0	32.0	34998	601,00
M 52 x 3.0	225	33	40.0	32.0	34999	601,00

Application:

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

Applicazione:

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



VÖLKEL
THREADING SOLUTIONS

Machine Taps, *Left Hand*

Pipe-thread DIN ISO 228

Maschi a macchina, *filetto sinistro*

filettatura per tubi gas DIN ISO 228

DIN 5156 Form C HSS-E

G (BSP)

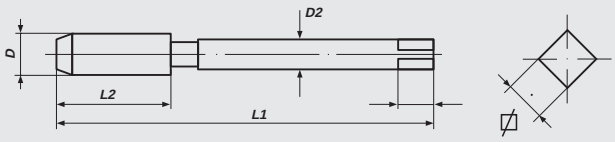
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
G 1/8 x 28	90	20	7.0	5.5	78202	19,00
G 1/4 x 19	100	22	11.0	9.0	78203	23,50
G 3/8 x 19	100	22	12.0	9.0	78204	29,50
G 1/2 x 14	125	25	16.0	12.0	78205	41,50
G 5/8 x 14	125	25	18.0	14.5	78206	48,00
G 3/4 x 14	140	28	20.0	16.0	78207	61,00
G 1" x 11	160	30	25.0	20.0	78209	90,00

Application:

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

Applicazione:

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



MACHINE TAPS WITH COLOURED RING
MASCHI A MACCHINA CON COLLARINI COLORATI

		Form B/A/C	39°RSP	TwinBox
	for general use per uso universale	132	133	147
PM	for general use per uso universale	134	135	
	for wear resistant steel Acciaio resistente all'abrasione	136	137	148
	for stainless steel Acciaio inossidabile	138	140	149
	for cast iron Ghisa grigia	142		
	Material from 1200 N/mm2 tensile strength Materiali con resistenza alla trazione da 1.200 N/mm²	145		
	for aluminium alloys Alluminio	143		
	for brass Ottone	144		

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

Material **Materiali**	Lubricant lubrificante	Cutting Speed velocita di taglio m/min.
Steel, unalloyed and low alloyed, short-chipping Acciaio non legati e scarsamente legati, truciolo corto	S/E	10-20
non abrasive Material, short-chipping Materiali buona truciodibilità, truciolo corto	S/E	6-15
Steel, heat resistant, long-chipping Acciaio resistenti al calore, truciolo lungo	S	4- 8
Steel, heat resistant, short-chipping Acciaio resistenti al calore, truciolo corto	S	4- 8
Steel, cementation and heat treatable, short-chipping Acciaio da cementazione, Acciao bonificato, truciolo corto	S	4- 8
Steel, Tool Steel up to 1200 N/mm² Acciao, Acciaio utensili a 1.200 N/mm²	S	2- 5
Steel, Tool Steel over 1200 N/mm² Acciao, Acciaio utensili da 1.200 N/mm²	S	2- 5
Steel stainless, short-chipping Acciaio inossidabile, truciolo corto	S	5-10
Steel stainless, long-chipping Acciaio inossidabile, truciolo lungo	S	5-10
Iron, Cast Ghisa grigia	P/T	6-20
Iron, spheroidal graphite Ghisa sferoidale	P/T	6-20
Iron, Malleable Cast Ghisa temprata	E	6-12
Brass, short-chipping Ottone, truciolo corto	E	20-30
Brass, long-chipping Ottone, truciolo lungo	S/E	10-15
Bronze, short-chipping Bronzo, truciolo corto	S/E	6-15
Bronze, long-chipping Bronzo, truciolo lungo	S/E	6-15
Copper Rame	S/E	10-15
Aluminium-alloys, short-chipping Alluminio, truciolo corto	S/E	15-30
Aluminium-alloys, long-chipping Alluminio, truciolo lungo	E	10-20
Zinc Alloys Leghe forgiate	S/E	10-15
Magnesium Alloys Leghe di magnesio	E/T	10-20
Titanium, short-chipping Titanio, truciolo corto	S	3- 4
Titanium, long-chipping Titanio, truciolo lungo	S	3- 4
Plastics, thermoplastics Materiali plastici, materiali termoplastici	E/T	5-15
Plastics, thermosetting Materiali plastici, materiali termodurenti	T	5-15

S = cutting oil / olii da taglio E = oil emulsion / emulsione P = kerosene / petrolio T = dry / secco

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

Material	Green Ring collarino verde	Blue Ring collarino blu	White Ring collarino bianco	Black Ring collarino nero	Red Ring collarino rosso	Yellow Ring collarino giallo	Orange Ring collarino arancione
Steel, unalloyed and low alloyed, short-chipping Acciaio non legati e scarsamente legati, truciolo corto	● PM						
non abrasive Material, short-chipping Materiali buona truciodibilità, truciolo corto	● PM						
Steel, heat resistant, long-chipping Acciaio resistenti al calore, truciolo lungo	PM		○				
Steel, heat resistant, short-chipping Acciaio resistenti al calore, truciolo corto	PM	●					
Steel, cementation and heat treatable, short-chipping Acciaio da cementazione, Acciao bonificato, truciolo corto	PM	●					
Steel, Tool Steel up to 1200 N/mm² Acciao, Acciaio utensili a 1.200 N/mm²		●					
Steel, Tool Steel over 1200 N/mm² Acciao, Acciaio utensili da 1.200 N/mm²					●		
Steel stainless, short-chipping Acciaio inossidabile, truciolo corto	PM	●					
Steel stainless, long-chipping Acciaio inossidabile, truciolo lungo	PM		○				
Iron, Cast Ghisa grigia				●			
Iron, spheroidal graphite Ghisa sferoidale		●					
Iron, Malleable Cast Ghisa temprata	● PM						
Brass, short-chipping Ottone, truciolo corto		●		●			●
Brass, long-chipping Ottone, truciolo lungo	● PM						
Bronze, short-chipping Bronzo, truciolo corto		●		●			
Bronze, long-chipping Bronzo, truciolo lungo	● PM						
Copper Rame	● PM						
Aluminium-alloys, short-chipping Alluminio, truciolo corto		●					
Aluminium-alloys, long-chipping Alluminio, truciolo lungo	● PM					●	
Zinc Alloys Leghe forgiate	● PM						
Magnesium Alloys Leghe di magnesio	● PM	●					
Titanium, short-chipping Titanio, truciolo corto		●					
Titanium, long-chipping Titanio, truciolo lungo			○				
Plastics, thermoplastics Materiali plastici, materiali termoplastici	● PM						
Plastics, thermosetting Materiali plastici, materiali termodurenti				●	●		

GREEN RING-Machine Taps
metric ISO-thread DIN 13

Maschi a macchina con collarino verde
filettatura metrica ISO DIN 13

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

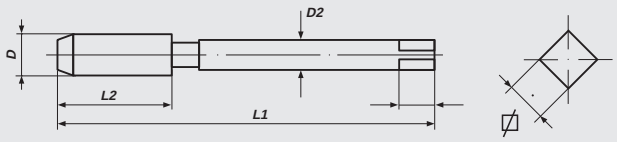
Nominal Diameter D	L 1	L 2	D 2	⌀	Art.-No.	€
DIN 371						
M 3 x 0.5	56	11	3.5	2.7	35326	8,70
M 4 x 0.7	63	13	4.5	3.4	35330	8,70
M 5 x 0.8	70	16	6.0	4.9	35334	9,50
M 6 x 1.0	80	19	6.0	4.9	35338	9,50
M 8 x 1.25	90	22	8.0	6.2	35342	11,00
M 10 x 1.5	100	24	10.0	8.0	35346	15,20
DIN 376						
M 12 x 1.75	110	29	9.0	7.0	35350	19,50
M 14 x 2.0	110	30	11.0	9.0	35354	22,00
M 16 x 2.0	110	32	12.0	9.0	35358	24,00
M 18 x 2.5	125	34	14.0	11.0	35362	32,50
M 20 x 2.5	140	34	16.0	12.0	35366	45,00
SET						
M 3 - 12	M 3-4-5-6-8-10 (DIN 371), M 12 (DIN 376)				47853	82,00

Application:

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

Applicazione:

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



GREEN RING-Machine Taps
metric ISO-thread DIN 13

Maschi a macchina con collarino verde
filettatura metrica ISO DIN 13

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

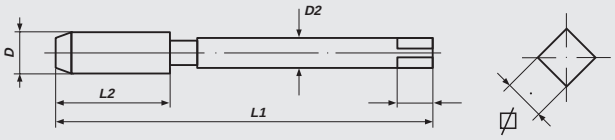
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
DIN 371						
M 3 x 0.5	56	6	3.5	2.7	36326	10,40
M 4 x 0.7	63	7	4.5	3.4	36330	10,40
M 5 x 0.8	70	8	6.0	4.9	36334	11,40
M 6 x 1.0	80	10	6.0	4.9	36338	11,40
M 8 x 1.25	90	14	8.0	6.2	36342	13,20
M 10 x 1.5	100	16	10.0	8.0	36346	18,20
DIN 376						
M 12 x 1.75	110	18	9.0	7.0	36350	23,40
M 14 x 2.0	110	20	11.0	9.0	36354	26,40
M 16 x 2.0	110	22	12.0	9.0	36358	28,80
M 18 x 2.5	125	25	14.0	11.0	36362	39,00
M 20 x 2.5	140	25	16.0	12.0	36366	54,00
SET						
M 3 - 12	M 3-4-5-6-8-10 (DIN 371), M 12 (DIN 376)				47863	98,00

Application:

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

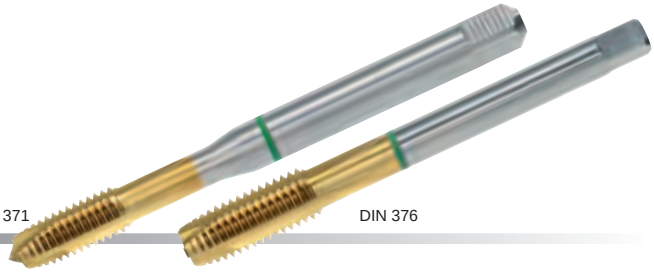
Applicazione

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



GREEN RING-Machine Taps
metric ISO-thread DIN 13

Maschi a macchina con collarino verde
filettatura metrica ISO DIN 13



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

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

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

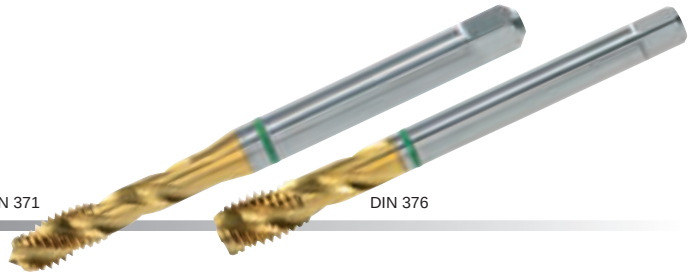
Advantages HSSE-PM-TIN
- increased wear resistance and toughness
- TiN-coating improves anti-friction properties, thereby improved wear-resistance and reduced tendency of build-up edge

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

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

GREEN RING-Machine Taps
metric ISO-thread DIN 13

Maschi a macchina con collarino verde
filettatura metrica ISO DIN 13



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

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

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

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

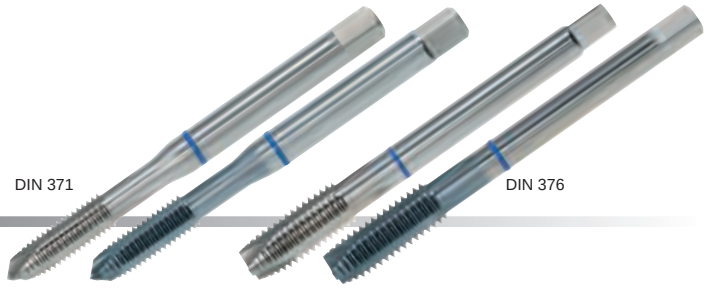
Applicazione
per uso universale
- Materiali con buona truciodibilità fino a R 1.000 N/mm²
- Acciaio inossidabili e legati
- Acciaio non legati e scarsamente legati
- Leghe di rame e alluminio
- per fori ciechi

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

VÖLKEL THREADING SOLUTIONS

BLUE RING-Machine Taps
metric ISO-thread DIN 13

Maschi a macchina con collarino blu
filettatura metrica ISO DIN 13



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

Nominal Diameter D	L 1	L 2	D 2	⌀	Art.-No.	€
DIN 371						
M 3 x 0.5	56	11	3.5	2.7	35426	8,70
M 4 x 0.7	63	13	4.5	3.4	35430	8,70
M 5 x 0.8	70	16	6.0	4.9	35434	9,50
M 6 x 1.0	80	19	6.0	4.9	35438	9,50
M 8 x 1.25	90	22	8.0	6.2	35442	11,00
M 10 x 1.5	100	24	10.0	8.0	35446	15,20
DIN 376						
M 12 x 1.75	110	29	9.0	7.0	35450	19,50
M 14 x 2.0	110	30	11.0	9.0	35454	22,00
M 16 x 2.0	110	32	12.0	9.0	35458	24,00
M 18 x 2.5	125	34	14.0	11.0	35462	32,50
M 20 x 2.5	140	34	16.0	12.0	35466	45,00
SET						
M 3 - 12	M 3-4-5-6-8-10 (DIN 371), M 12 (DIN 376)				47854	82,00

TiCN

DIN 371						
M 3 x 0.5	56	11	3.5	2.7	35427	11,80
M 4 x 0.7	63	13	4.5	3.4	35431	11,80
M 5 x 0.8	70	16	6.0	4.9	35435	12,60
M 6 x 1.0	80	19	6.0	4.9	35439	13,20
M 8 x 1.25	90	22	8.0	6.2	35443	15,70
M 10 x 1.5	100	24	10.0	8.0	35447	21,70
DIN 376						
M 12 x 1.75	110	29	9.0	7.0	35451	29,40
M 14 x 2.0	110	30	11.0	9.0	35455	33,00
M 16 x 2.0	110	32	12.0	9.0	35459	36,00
M 18 x 2.5	125	34	14.0	11.0	35463	48,40
M 20 x 2.5	140	34	16.0	12.0	35467	60,90

Application:

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

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

Applicazione

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

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

BLUE RING-Machine Taps
metric ISO-thread DIN 13

Maschi a macchina con collarino blu
filettatura metrica ISO DIN 13

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

Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
DIN 371						
M 3 x 0.5	56	6	3.5	2.7	36426	10,40
M 4 x 0.7	63	7	4.5	3.4	36430	10,40
M 5 x 0.8	70	8	6.0	4.9	36434	11,40
M 6 x 1.0	80	10	6.0	4.9	36438	11,40
M 8 x 1.25	90	14	8.0	6.2	36442	13,20
M 10 x 1.5	100	16	10.0	8.0	36446	18,20
DIN 376						
M 12 x 1.75	110	18	9.0	7.0	36450	23,40
M 14 x 2.0	110	20	11.0	9.0	36454	26,40
M 16 x 2.0	110	22	12.0	9.0	36458	28,80
M 18 x 2.5	125	25	14.0	11.0	36462	39,00
M 20 x 2.5	140	25	16.0	12.0	36466	54,00
SET						
M 3 - 12	M 3-4-5-6-8-10 (DIN 371). M 12 (DIN 376)				47864	98,00

TiCN

DIN 371						
M 3 x 0.5	56	6	3.5	2.7	36427	13,50
M 4 x 0.7	63	7	4.5	3.4	36431	13,50
M 5 x 0.8	70	8	6.0	4.9	36435	14,50
M 6 x 1.0	80	10	6.0	4.9	36439	15,10
M 8 x 1.25	90	14	8.0	6.2	36443	17,90
M 10 x 1.5	100	16	10.0	8.0	36447	24,70
DIN 376						
M 12 x 1.75	110	18	9.0	7.0	36451	33,30
M 14 x 2.0	110	20	11.0	9.0	36455	37,40
M 16 x 2.0	110	22	12.0	9.0	36459	40,80
M 18 x 2.5	125	25	14.0	11.0	36463	54,90
M 20 x 2.5	140	25	16.0	12.0	36467	69,90

Application:

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

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

Applicazione

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

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

WHITE RING-Machine Taps
metric ISO-thread DIN 13

Maschi a macchina con collarino bianco
filettatura metrica ISO DIN 13

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

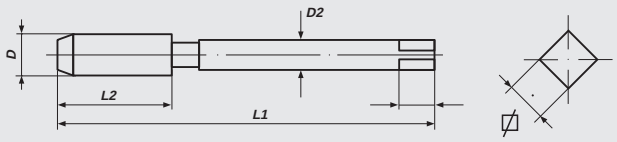
Nominal Diameter D	L 1	L 2	D 2	⊠	Art.-No.	€
DIN 371						
M 3 x 0.5	56	11	3.5	2.7	35226	9,50
M 4 x 0.7	63	13	4.5	3.4	35230	9,50
M 5 x 0.8	70	16	6.0	4.9	35234	10,40
M 6 x 1.0	80	19	6.0	4.9	35238	10,40
M 8 x 1.25	90	22	8.0	6.2	35242	12,10
M 10 x 1.5	100	24	10.0	8.0	35246	16,70
DIN 376						
M 12 x 1.75	110	29	9.0	7.0	35250	21,40
M 14 x 2.0	110	30	11.0	9.0	35254	24,20
M 16 x 2.0	110	32	12.0	9.0	35258	26,40
M 18 x 2.5	125	34	14.0	11.0	35262	35,70
M 20 x 2.5	140	34	16.0	12.0	35266	49,50
SET						
M 3 - 12	M 3-4-5-6-8-10 (DIN 371), M 12 (DIN 376)				47852	90,00

Application:

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

Applicazione:

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



WHITE RING-Machine Taps

Maschi a macchina con collarino bianco

Form B HSS-E

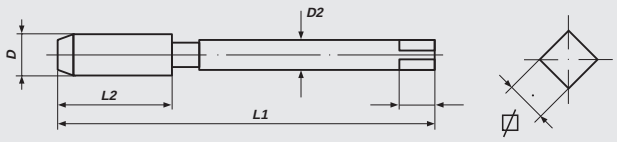
Nominal Diameter D		L 1	L 2	D 2	⧄	Art.-No.	€
MF		DIN 374					
M	5 x 0.5	70	12	3.5	2.7	35903	16,50
M	6 x 0.75	80	14	4.5	3.4	35904	16,50
M	8 x 0.75	80	19	6.0	4.9	35906	16,50
M	8 x 1.0	90	22	6.0	4.9	35907	16,50
M	10 x 1.0	90	20	7.0	5.5	35909	19,30
M	10 x 1.25	100	24	7.0	5.5	35910	19,30
M	12 x 1.25	100	22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

Application:

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

Applicazione:

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



WHITE RING-Machine Taps
metric ISO-thread DIN 13

Maschi a macchina con collarino bianco
filettatura metrica ISO DIN 13

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

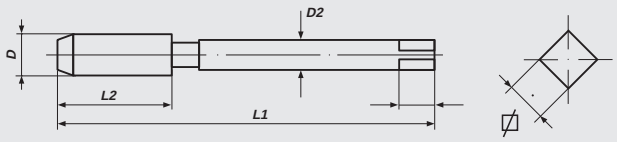
Nominal Diameter D	L 1	L 2	D 2	⌀	Art.-No.	€
DIN 371						
M 3 x 0.5	56	6	3.5	2.7	36226	11,40
M 4 x 0.7	63	7	4.5	3.4	36230	11,40
M 5 x 0.8	70	8	6.0	4.9	36234	12,50
M 6 x 1.0	80	10	6.0	4.9	36238	12,50
M 8 x 1.25	90	14	8.0	6.2	36242	14,50
M 10 x 1.5	100	16	10.0	8.0	36246	20,00
DIN 376						
M 12 x 1.75	110	18	9.0	7.0	36250	25,70
M 14 x 2.0	110	20	11.0	9.0	36254	29,00
M 16 x 2.0	110	22	12.0	9.0	36258	31,70
M 18 x 2.5	125	25	14.0	11.0	36262	42,90
M 20 x 2.5	140	25	16.0	12.0	36266	59,40
SET						
M 3 - 12	M 3-4-5-6-8-10 (DIN 371), M 12 (DIN 376)				47862	108,00

Application:

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

Applicazione:

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



WHITE RING-Machine Taps

Maschi a macchina con collarino bianco

Form C/39° RSP HSS-E

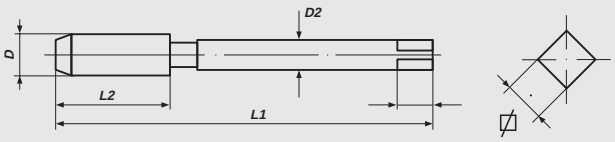
Nominal Diameter D		L 1	L 2	D 2	⧄	Art.-No.	€
MF		DIN 374					
M	5 x 0.5	70	5	3.5	2.7	36903	18,70
M	6 x 0.75	80	8	4.5	3.4	36904	18,70
M	8 x 0.75	80	8	6.0	4.9	36906	18,70
M	8 x 1.0	90	10	6.0	4.9	36907	18,70
M	10 x 1.0	90	10	7.0	5.5	36909	22,50
M	10 x 1.25	100	16	7.0	5.5	36910	22,20
M	12 x 1.25	100	15	9.0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

Application:

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

Applicazione:

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



BLACK RING-Machine Taps
metric ISO-thread DIN 13

Maschi a macchina con collarino nero
filettatura metrica ISO DIN 13

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

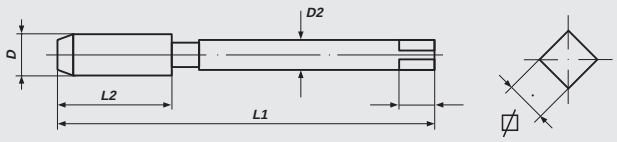
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
DIN 371						
M 3 x 0.5	56	11	3.5	2.7	35126	9,50
M 4 x 0.7	63	13	4.5	3.4	35130	9,50
M 5 x 0.8	70	16	6.0	4.9	35134	10,40
M 6 x 1.0	80	19	6.0	4.9	35138	10,40
M 8 x 1.25	90	22	8.0	6.2	35142	12,10
M 10 x 1.5	100	24	10.0	8.0	35146	16,70
DIN 376						
M 12 x 1.75	110	29	9.0	7.0	35150	21,40
M 14 x 2.0	110	30	11.0	9.0	35154	24,20
M 16 x 2.0	110	32	12.0	9.0	35158	26,40
M 18 x 2.5	125	34	14.0	11.0	35162	35,70
M 20 x 2.5	140	34	16.0	12.0	35166	49,50
SET						
M 3 - 12	M 3-4-5-6-8-10 (DIN 371), M 12 (DIN 376)				47851	90,00

Application:

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

Applicazione:

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

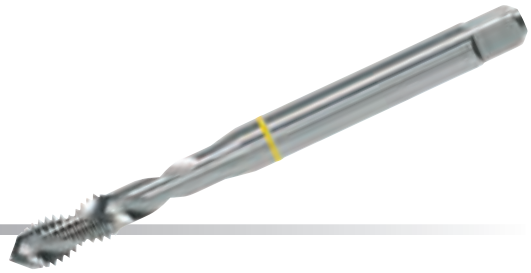


YELLOW RING-Machine Taps

metric ISO-thread DIN 13

Maschi a macchina con collarino giallo

filettatura metrica ISO DIN 13



DIN 371/376 Form C/40° RSP HSS-E Tol. ISO2/6H

Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
DIN 371						
M 3 x 0.5	56	6	3.5	2.7	36526	10,40
M 4 x 0.7	63	7	4.5	3.4	36530	10,40
M 5 x 0.8	70	8	6.0	4.9	36534	11,40
M 6 x 1.0	80	10	6.0	4.9	36538	11,40
M 8 x 1.25	90	14	8.0	6.2	36542	13,20
M 10 x 1.5	100	16	10.0	8.0	36546	18,20
DIN 376						
M 12 x 1.75	110	18	9.0	7.0	36550	23,40
M 14 x 2.0	110	20	11.0	9.0	36554	26,40
M 16 x 2.0	110	22	12.0	9.0	36558	28,80
SET						
M 3 - 12	M 3-4-5-6-8-10 (DIN 371), M 12 (DIN 376)				47860	98,00

Application:

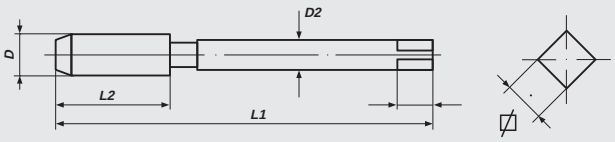
Aluminium-alloys, long chipping

- for blind holes
- with 2 flutes

Applicazione:

Alluminio, truciolo lungo

- per fori ciechi
- A 2 scanalature



ORANGE RING-Machine Taps
metric ISO-thread DIN 13

Maschi a macchina con collarino arancione
filettatura metrica ISO DIN 13

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

Nominal Diameter D	L 1	L 2	D 2	⌀	Art.-No.	€
DIN 371						
M 3 x 0.5	56	11	3.5	2.7	35726	9,50
M 4 x 0.7	63	13	4.5	3.4	35730	9,50
M 5 x 0.8	70	16	6.0	4.9	35734	10,40
M 6 x 1.0	80	19	6.0	4.9	35738	10,40
M 8 x 1.25	90	22	8.0	6.2	35742	12,10
M 10 x 1.5	100	24	10.0	8.0	35746	16,70
DIN 376						
M 12 x 1.75	110	29	9.0	7.0	35750	21,40
M 14 x 2.0	110	30	11.0	9.0	35754	24,20
M 16 x 2.0	110	32	12.0	9.0	35758	26,40
SET						
M 3 - 12	M 3-4-5-6-8-10 (DIN 371), M 12 (DIN 376)				47850	90,00

Application:

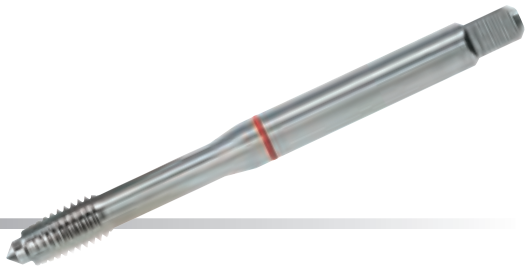
Ms
Brass, short chipping
- for through and blind holes

Applicazione:

Ms
Ottone, truciolo corto
- per fori passanti e ciechi

RED RING-Machine Taps
metric ISO-thread DIN 13

Maschi a macchina con collarino rosso
filettatura metrica ISO DIN 13



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

Nominal Diameter D	L 1	L 2	D 2	⌀	Art.-No.	€
DIN 371						
M 4 x 0.7	63	9	4.5	3.4	36130	11,00
M 5 x 0.8	70	11	6.0	4.9	36134	12,20
M 6 x 1.0	80	13	6.0	4.9	36138	12,20
M 8 x 1.25	90	15	8.0	6.2	36142	14,00
M 10 x 1.5	100	16	10.0	8.0	36146	17,00

Application:

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

Applicazione:

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

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

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

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

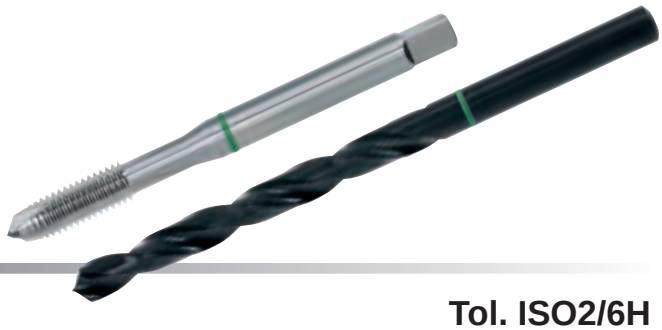
77 + 147 - 149

GREEN RING TwinBox

Machine Tap + Twist Drill
metric ISO-thread DIN 13

TwinBox verde

Maschi a macchina + punte
filettatura metrica ISO DIN 13



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

Nominal Diameter D			Art.-No.	€
Form B, Spiral Point / punta en espiral (pasante)				
M 3 x 0.5	DIN 371	2.5 mm	35390	10,40
M 4 x 0.7	DIN 371	3.3 mm	35391	10,60
M 5 x 0.8	DIN 371	4.2 mm	35392	11,60
M 6 x 1.0	DIN 371	5.0 mm	35393	11,90
M 8 x 1.25	DIN 371	6.8 mm	35394	14,70
M 10 x 1.5	DIN 371	8.5 mm	35395	20,20
M 12 x 1.75	DIN 376	10.2 mm	35396	27,20
M 14 x 2.0	DIN 376	12.0 mm	35397	32,50
M 16 x 2.0	DIN 376	14.0 mm	35398	39,80
Form C, Spiral Flute / Helicoidal 35° (ciego)				
M 3 x 0.5	DIN 371	2.5 mm	36390	12,10
M 4 x 0.7	DIN 371	3.3 mm	36391	12,30
M 5 x 0.8	DIN 371	4.2 mm	36392	13,50
M 6 x 1.0	DIN 371	5.0 mm	36393	13,80
M 8 x 1.25	DIN 371	6.8 mm	36394	16,80
M 10 x 1.5	DIN 371	8.5 mm	36395	23,20
M 12 x 1.75	DIN 376	10.2 mm	36396	31,10
M 14 x 2.0	DIN 376	12.0 mm	36397	36,80
M 16 x 2.0	DIN 376	14.0 mm	36398	44,50

Application:

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

Spiral Point for through holes
Spiral Flute for blind holes

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

Applicazione:

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

Forma B per fori passanti
35° RSP per fori ciechi

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

VÖLKEL
THREADING SOLUTIONS

BLUE RING TwinBox

Machine Tap + Twist Drill
metric ISO-thread DIN 13

TwinBox blu

Maschi a macchina + punte
filettatura metrica ISO DIN 13

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

Nominal Diameter D				Art.-No.	€
Form B, Spiral Point / con imbocco corretto					
M	3 x 0.5	DIN 371	2.5 mm	35490	10,60
M	4 x 0.7	DIN 371	3.3 mm	35491	10,90
M	5 x 0.8	DIN 371	4.2 mm	35492	11,80
M	6 x 1.0	DIN 371	5.0 mm	35493	12,20
M	8 x 1.25	DIN 371	6.8 mm	35494	15,00
M	10 x 1.5	DIN 371	8.5 mm	35495	21,60
M	12 x 1.75	DIN 376	10.2 mm	35496	27,60
M	14 x 2.0	DIN 376	12.0 mm	35497	32,00
M	16 x 2.0	DIN 376	14.0 mm	35498	40,80
Form C, Spiral Flute / spirale destra a 35°,					
M	3 x 0.5	DIN 371	2.5 mm	36490	12,30
M	4 x 0.7	DIN 371	3.3 mm	36491	12,60
M	5 x 0.8	DIN 371	4.2 mm	36492	13,70
M	6 x 1.0	DIN 371	5.0 mm	36493	14,10
M	8 x 1.25	DIN 371	6.8 mm	36494	17,20
M	10 x 1.5	DIN 371	8.5 mm	36495	23,50
M	12 x 1.75	DIN 376	10.2 mm	36496	31,70
M	14 x 2.0	DIN 376	12.0 mm	36497	37,60
M	16 x 2.0	DIN 376	14.0 mm	36498	45,60

Application:

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

Spiral Point for through holes
Spiral Flute for blind holes

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

Applicazione:

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

Forma B per fori passanti
35° RSP per fori ciechi

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

WHITE RING TwinBox

Machine Tap + Twist Drill
metric ISO-thread DIN 13

TwinBox bianco

Maschi a macchina + punte
filettatura metrica ISO DIN 13

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

Nominal Diameter D				Art.-No.	€
Form B, Spiral Point / con imbocco corretto					
M	3 x 0.5	DIN 371	2.5 mm	35290	11,40
M	4 x 0.7	DIN 371	3.3 mm	35291	11,80
M	5 x 0.8	DIN 371	4.2 mm	35292	12,70
M	6 x 1.0	DIN 371	5.0 mm	35293	13,10
M	8 x 1.25	DIN 371	6.8 mm	35294	16,10
M	10 x 1.5	DIN 371	8.5 mm	35295	21,90
M	12 x 1.75	DIN 376	10.2 mm	35296	29,60
M	14 x 2.0	DIN 376	12.0 mm	35297	35,40
M	16 x 2.0	DIN 376	14.0 mm	35298	43,20
Form C, Spiral Flute / spirale destra a 35°					
M	3 x 0.5	DIN 371	2.5 mm	36290	13,30
M	4 x 0.7	DIN 371	3.3 mm	36291	13,60
M	5 x 0.8	DIN 371	4.2 mm	36292	14,80
M	6 x 1.0	DIN 371	5.0 mm	36293	15,30
M	8 x 1.25	DIN 371	6.8 mm	36294	18,50
M	10 x 1.5	DIN 371	8.5 mm	36295	25,30
M	12 x 1.75	DIN 376	10.2 mm	36296	33,80
M	14 x 2.0	DIN 376	12.0 mm	36297	40,20
M	16 x 2.0	DIN 376	14.0 mm	36298	48,60

Application:

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

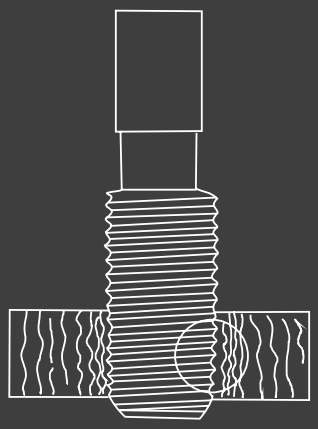
HSS-CO Twist Drills DIN 338
Form C right, 130° - Spiral: 25-30°
with Split Point

Applicazione:

Acciaio inossidabile truciolo lungo a 1000 N/mm²
- Acciaio resistente al calore truciolo lungo
- Materiali difficile da tagliare
Forma B per fori passanti
35° RSP per fori ciechi
Superficie: vaporizzato

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

FLUTELESS MACHINE TAPS
MASCHI A RULLARE

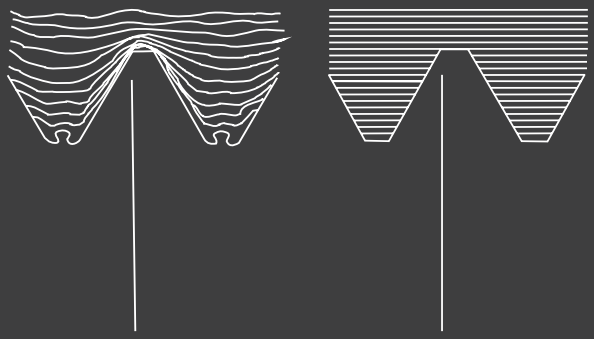


Application:

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

Applicazione:

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



Fibre structure
of thread forming
Andamento delle fibre
per filettatura rullata

Fibre structure
of thread cutting
Andamento delle fibre
per filettatura tagliata

Benefit:

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

Vantaggio:

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

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

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

FLUTELESS MACHINE TAPS
MASCHI A RULLARE

	blank lucido	VAP	TIN
6H ISO2	153	154	155
6G ISO3	156		

Application:

bright:
- for nonferrous metal of good ductility

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

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

Applicazione:

Lucido:
- per materiali non ferrosi con buona deformabilità

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

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

RECOMMENDED APPLICATION OF FLUTELESS MACHINE TAPS
PER MASCHI A RULLARE

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

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

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

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

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

RECOMMENDED CORE HOLE DIAMETER
DIAMETRO DEL FORO RACCOMANDATO

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

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

Maschi a rullare
filettatura metrica ISO DIN 13

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

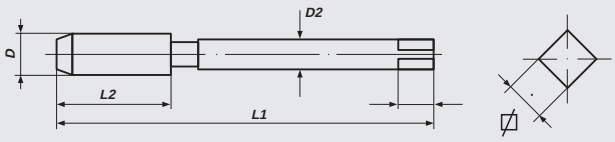
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
without Oil Groove/senza canali di espulsione						
DIN 371						
M 1 x 0.25	40	5	2.5	2.1	35500	24,00
M 1.1 x 0.25	40	5	2.5	2.1	35501	24,00
M 1.2 x 0.25	40	5	2.5	2.1	35502	24,00
M 1.4 x 0.3	40	7	2.5	2.1	35503	21,00
M 1.6 x 0.35	40	8	2.5	2.1	35504	21,00
M 1.7 x 0.35	40	8	2.5	2.1	35505	21,00
M 1.8 x 0.35	40	8	2.5	2.1	35506	21,00
M 2 x 0.4	45	8	2.8	2.1	35507	18,00
M 2.5 x 0.45	50	9	2.8	2.1	35508	18,00
M 3 x 0.5	56	11	3.5	2.7	35510	9,50
M 4 x 0.7	63	13	4.5	3.4	35512	10,60
M 5 x 0.8	70	16	6.0	4.9	35513	11,50
M 6 x 1.0	80	19	6.0	4.9	35514	11,50
M 8 x 1.25	90	22	8.0	6.2	35515	13,80
M 10 x 1.5	100	24	10.0	8.0	35516	16,10
DIN 376						
M 12 x 1.75	110	29	9.0	7.0	35517	20,70
M 14 x 2.0	110	30	11.0	9.0	35518	33,00
M 16 x 2.0	110	32	12.0	9.0	35519	39,00
with Oil Groove/con canali di espulsione						
DIN 371						
M 3 x 0.5	56	11	3.5	2.7	35610	10,40
M 4 x 0.7	63	13	4.5	3.4	35612	11,60
M 5 x 0.8	70	16	6.0	4.9	35613	12,60
M 6 x 1.0	80	19	6.0	4.9	35614	12,60
M 8 x 1.25	90	22	8.0	6.2	35615	15,10
M 10 x 1.5	100	24	10.0	8.0	35616	17,70
DIN 376						
M 12 x 1.75	110	29	9.0	7.0	35617	22,70
M 14 x 2.0	110	30	11.0	9.0	35618	36,30
M 16 x 2.0	110	32	12.0	9.0	35619	42,90

Application:

bright:
- for nonferrous metal of good ductility

Applicazione:

Lucido:
- per materiali non ferrosi con buona deformabilità



Fluteless Machine Taps
metric ISO-thread DIN 13

Maschi a rullare
filettatura metrica ISO DIN 13

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

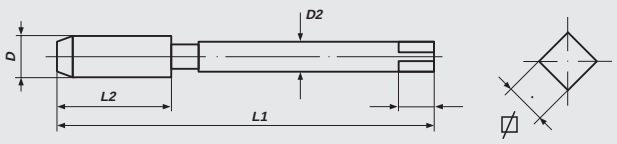
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
without Oil Groove/senza canali di espulsione						
DIN 371						
M 3 x 0.5	56	11	3.5	2.7	35550	10,50
M 4 x 0.7	63	13	4.5	3.4	35552	11,70
M 5 x 0.8	70	16	6.0	4.9	35553	12,70
M 6 x 1.0	80	19	6.0	4.9	35554	12,70
M 8 x 1.25	90	22	8.0	6.2	35555	15,20
M 10 x 1.5	100	24	10.0	8.0	35556	17,70
DIN 376						
M 12 x 1.75	110	29	9.0	7.0	35557	22,80
M 14 x 2.0	110	30	11.0	9.0	35558	36,30
M 16 x 2.0	110	32	12.0	9.0	35559	42,90
with Oil Groove/con canali di espulsione						
DIN 371						
M 3 x 0.5	56	11	3.5	2.7	35650	11,50
M 4 x 0.7	63	13	4.5	3.4	35652	12,80
M 5 x 0.8	70	16	6.0	4.9	35653	13,90
M 6 x 1.0	80	19	6.0	4.9	35654	13,90
M 8 x 1.25	90	22	8.0	6.2	35655	16,60
M 10 x 1.5	100	24	10.0	8.0	35656	19,47
DIN 376						
M 12 x 1.75	110	29	9.0	7.0	35657	25,00
M 14 x 2.0	110	30	11.0	9.0	35658	40,00
M 16 x 2.0	110	32	12.0	9.0	35659	47,20

Application:

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

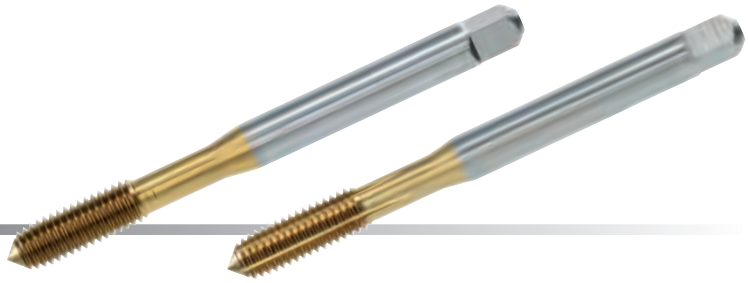
Applicazione:

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



Fluteless Machine Taps
metric ISO-thread DIN 13

Maschi a rullare
filettatura metrica ISO DIN 13



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

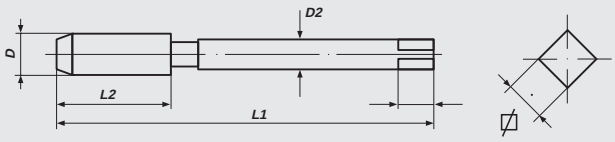
Nominal Diameter D	L 1	L 2	D 2	⌀	Art.-No.	€
without Oil Groove/senza canali di espulsione						
DIN 371						
M 1 x 0.25	40	5	2.5	2.1	35520	27,10
M 1.1 x 0.25	40	5	2.5	2.1	35521	27,10
M 1.2 x 0.25	40	5	2.5	2.1	35522	27,10
M 1.4 x 0.3	40	7	2.5	2.1	35523	24,10
M 1.6 x 0.35	40	8	2.5	2.1	35524	24,10
M 1.7 x 0.35	40	8	2.5	2.1	35525	24,10
M 1.8 x 0.35	40	8	2.5	2.1	35526	24,10
M 2 x 0.4	45	8	2.8	2.1	35527	21,10
M 2.5 x 0.45	50	9	2.8	2.1	35528	21,10
M 3 x 0.5	56	11	3.5	2.7	35530	12,60
M 4 x 0.7	63	13	4.5	3.4	35532	13,70
M 5 x 0.8	70	16	6.0	4.9	35533	14,60
M 6 x 1.0	80	19	6.0	4.9	35534	15,20
M 8 x 1.25	90	22	8.0	6.2	35535	18,50
M 10 x 1.5	100	24	10.0	8.0	35536	22,60
DIN 376						
M 12 x 1.75	110	29	9.0	7.0	35537	30,60
M 14 x 2.0	110	30	11.0	9.0	35538	44,00
M 16 x 2.0	110	32	12.0	9.0	35539	51,00
with Oil Groove/con canali di espulsione						
DIN 371						
M 3 x 0.5	56	11	3.5	2.7	35630	13,50
M 4 x 0.7	63	13	4.5	3.4	35632	14,70
M 5 x 0.8	70	16	6.0	4.9	35633	15,70
M 6 x 1.0	80	19	6.0	4.9	35634	16,30
M 8 x 1.25	90	22	8.0	6.2	35635	19,80
M 10 x 1.5	100	24	10.0	8.0	35636	24,20
DIN 376						
M 12 x 1.75	110	29	9.0	7.0	35637	32,60
M 14 x 2.0	110	30	11.0	9.0	35638	47,30
M 16 x 2.0	110	32	12.0	9.0	35639	54,90

Application:

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

Applicazione:

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



VÖLKEL THREADING SOLUTIONS

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

metric ISO-thread DIN 13

Maschi a rullare, *tolleranza maggiorata*

metrica ISO DIN 13

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

Nominal Diameter D	L 1	L 2	D 2	☐	Art.-No.	€
without Oil Groove/senza canali di espulsione						
DIN 371						
M 3 x 0.5	56	11	3.5	2.7	35510-6G	10,00
M 4 x 0.7	63	13	4.5	3.4	35512-6G	11,10
M 5 x 0.8	70	16	6.0	4.9	35513-6G	12,00
M 6 x 1.0	80	19	6.0	4.9	35514-6G	12,00
M 8 x 1.25	90	22	8.0	6.2	35515-6G	14,50
M 10 x 1.5	100	24	10.0	8.0	35516-6G	16,90
DIN 376						
M 12 x 1.75	110	29	9.0	7.0	35517-6G	21,70
with Oil Groove/con canali di espulsione						
DIN 371						
M 3 x 0.5	56	11	3.5	2.7	35610-6G	10,90
M 4 x 0.7	63	13	4.5	3.4	35612-6G	12,10
M 5 x 0.8	70	16	6.0	4.9	35613-6G	13,20
M 6 x 1.0	80	19	6.0	4.9	35614-6G	13,20
M 8 x 1.25	90	22	8.0	6.2	35615-6G	15,80
M 10 x 1.5	100	24	10.0	8.0	35616-6G	18,60
DIN 376						
M 12 x 1.75	110	29	9.0	7.0	35617-6G	23,80

Application:

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

Applicazione:

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

MACHINE NUT TAPS
MASCHI A MACCHINA PER DADI

	M	Tr
Machine Nut Taps Maschi a macchina per dadi	158	159

Machine Nut Taps
metric ISO-thread DIN 13

Maschi a macchina per dadi
filettatura metrica ISO DIN 13

DIN 357 HSS-E Tol. ISO2/6H

M

Nominal Diameter D	L 1	L 2	D 2	⊠	Art.-No.	€
M 3 x 0.5	70	22	2.2	—	37126	13,00
M 4 x 0.7	90	25	2.8	2.1	37130	13,00
M 5 x 0.8	100	28	3.5	2.7	37134	14,00
M 6 x 1.0	110	32	4.5	3.4	37138	14,00
M 8 x 1.25	125	40	6.0	4.9	37142	16,00
M 10 x 1.5	140	45	7.0	5.5	37146	21,00
M 12 x 1.75	180	50	9.0	7.0	37150	29,50
M 14 x 2.0	200	56	11.0	9.0	37154	37,00
M 16 x 2.0	200	63	12.0	9.0	37158	45,00
M 18 x 2.5	220	63	14.0	11.0	37162	51,00
M 20 x 2.5	250	70	16.0	12.0	37166	56,00
M 22 x 2.5	280	80	18.0	14.5	37170	67,00
M 24 x 3.0	280	80	18.0	14.5	37174	75,00

Application:

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

for general use

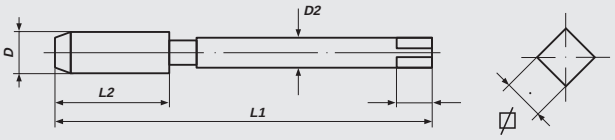
- non abrasive material up to 800 N/mm²
- unalloyed and low alloyed steel

Applicazione:

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

per uso universale

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



Machine Nut Taps
piloted, trapezoidal thread DIN 103

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

HSS-G Tol. 7H

Tr

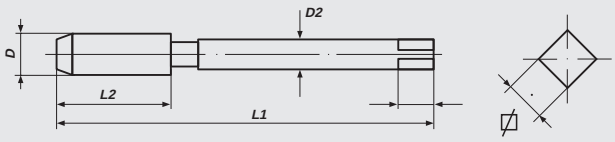
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.	€
Tr 10 x 2	110	63	7	5.5	79108	198,00
Tr 10 x 3	125	75	7	5.5	79112	198,00
Tr 12 x 3	165	111	8	6.2	79116	171,00
Tr 14 x 3	140	85	10	8.0	79120	182,00
Tr 14 x 4	170	112	10	8.0	79124	182,00
Tr 16 x 4	180	116	11	9.0	79128	199,00
Tr 18 x 4	190	120	12	9.0	79132	204,00
Tr 20 x 4	200	124	14	11.0	79136	212,00
Tr 22 x 4	210	130	16	12.0	79139	275,00
Tr 22 x 5	235	155	16	12.0	79140	275,00
Tr 24 x 5	245	160	18	14.5	79144	316,00
Tr 26 x 5	255	165	20	16.0	79148	330,00
Tr 28 x 5	265	170	22	18.0	79152	368,00
Tr 30 x 6	290	185	22	18.0	79156	432,00
Tr 32 x 6	300	191	25	20.0	79160	528,00
Tr 36 x 6	310	200	28	22.0	79164	540,00
LEFT HAND THREAD/FILETTO SINISTRO						
Tr 10 x 2	110	63	7	5.5	79108-L	278,00
Tr 10 x 3	125	75	7	5.5	79112-L	278,00
Tr 12 x 3	165	111	8	6.2	79116-L	240,00
Tr 14 x 3	140	85	10	8.0	79120-L	255,00
Tr 14 x 4	170	112	10	8.0	79124-L	255,00
Tr 16 x 4	180	116	11	9.0	79128-L	278,00
Tr 18 x 4	190	120	12	9.0	79132-L	287,00
Tr 20 x 4	200	124	14	11.0	79136-L	298,00
Tr 22 x 5	235	155	16	12.0	79140-L	385,00
Tr 24 x 5	245	160	18	14.5	79144-L	442,00
Tr 26 x 5	255	165	20	16.0	79148-L	462,00
Tr 28 x 5	265	170	22	18.0	79152-L	515,00
Tr 30 x 6	290	185	22	18.0	79156-L	605,00
Tr 32 x 6	300	191	25	20.0	79160-L	740,00
Tr 36 x 6	310	200	28	22.0	79164-L	755,00

Application:

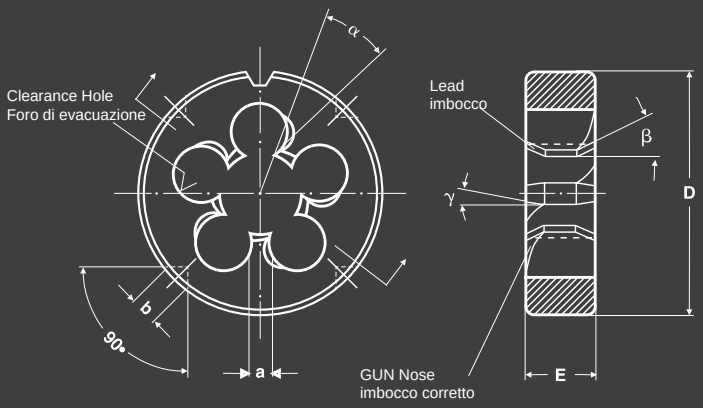
for general use
- non abrasive material up to 700 N/mm²
- unalloyed and low alloyed steel
- for thread depth up to 1 x D
- for through holes

Applicazione:

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

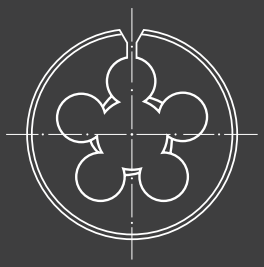


ROUND DIES
HEXAGON DIE NUTS
FILIERE
FILIERE ESAGONALI

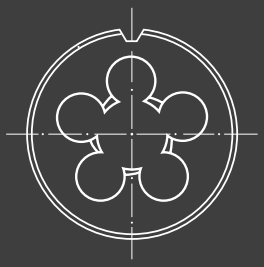


D	Outside diameter	Diametro esterno
E	Width of die	Spessore
a	Width of land	Ampiezza del dente
b	Hole for holding screws	Diametro fissaggio vite
α	Rake angle	Angolo di taglio
β	Lead angle	Angolo dell'imbocco
γ	Angle of gun nose	Angolo dell'imbocco corretto

Form A split / Forma A aperta



Form B solid / Forma B chiuso



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

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

ROUND DIES
HEXAGON DIE NUTS
FILIERE
FILIERE ESAGONALI

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

VÖLKEL THREADING SOLUTIONS

Round Dies
metric ISO-thread DIN 13

Filiere tonde
filettatura metrica ISO DIN 13

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

Nominal Diameter mm	Ø o / d	Art.-No.	€
M 1 x 0.25	16 x 5	27402	11,50
M 1.1 x 0.25	16 x 5	27404	11,50
M 1.2 x 0.25	16 x 5	27406	11,50
M 1.4 x 0.3	16 x 5	27408	11,50
M 1.6 x 0.35	16 x 5	27410	11,50
M 1.7 x 0.35	16 x 5	27412	11,50
M 1.8 x 0.35	16 x 5	27414	10,00
M 2 x 0.4	16 x 5	27416	10,00
M 2.2 x 0.45	16 x 5	27418	10,00
M 2.3 x 0.4	16 x 5	27420	10,00
M 2.5 x 0.45	16 x 5	27422	10,00
M 2.6 x 0.45	16 x 5	27424	10,00
M 3 x 0.5	20 x 5	27426	4,80
M 3.5 x 0.6	20 x 5	27428	7,40
M 4 x 0.7	20 x 5	27430	4,80
M 4.5 x 0.75	20 x 7	27432	7,40
M 5 x 0.8	20 x 7	27434	5,10
M 5.5 x 0.9	20 x 7	27436	7,40
M 6 x 1.0	20 x 7	27438	5,10
M 7 x 1.0	25 x 9	27440	8,00
M 8 x 1.25	25 x 9	27442	5,40
M 9 x 1.25	25 x 9	27444	9,10
M 10 x 1.5	30 x 11	27446	6,95
M 11 x 1.5	30 x 11	27448	10,50
M 12 x 1.75	38 x 14	27450	11,10
M 14 x 2.0	38 x 14	27454	11,50
M 15 x 2.0	38 x 14	27456	16,00
M 16 x 2.0	45 x 18	27458	17,80
M 18 x 2.5	45 x 18	27462	17,80
M 19 x 2.5	45 x 18	27464	17,80
M 20 x 2.5	45 x 18	27466	17,80
M 22 x 2.5	55 x 22	27470	32,20
M 24 x 3.0	55 x 22	27474	32,20
M 27 x 3.0	65 x 25	27476	45,20
M 30 x 3.5	65 x 25	27478	45,20
M 33 x 3.5	65 x 25	27480	45,20
M 36 x 4.0	65 x 25	27482	45,20
M 39 x 4.0	75 x 30	27484	73,00
M 42 x 4.5	75 x 30	27486	73,00
M 45 x 4.5	90 x 36	27488	125,00
M 48 x 5.0	90 x 36	27490	125,00
M 52 x 5.0	90 x 36	27492	125,00
M 56 x 5.5	105 x 36	27494	298,00
M 60 x 5.5	105 x 36	27496	298,00
M 64 x 6.0	120 x 36	27498	395,00
M 68 x 6.0	120 x 36	27499	395,00

►►►

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

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

Round Dies
metric ISO-thread DIN 13

Filiere tonde
filettatura metrica ISO DIN 13

HSS Tol. 6g

M

Nominal Diameter mm	Ø o / d		Art.-No.	€
M 72 x 6.0	120 x 36		28280	288,00
M 76 x 6.0	120 x 36		28281	288,00
M 80 x 6.0	120 x 36		28282	288,00
M 84 x 6.0	130 x 36		28283	365,00
M 88 x 6.0	140 x 36		28284	570,00
M 90 x 6.0	140 x 36		28285	570,00
M 92 x 6.0	140 x 36		28286	570,00
M 96 x 6.0	140 x 36		28287	570,00
M 100 x 6.0	150 x 36		28288	660,00
M 3 x 0.5	25 x 9		27826	5,40
M 4 x 0.7	25 x 9		27830	5,40
M 5 x 0.8	25 x 9		27834	5,40
M 6 x 1.0	25 x 9		27838	5,40
M 8 x 1.25	25 x 9		27842	5,40
M 10 x 1.5	25 x 9		27846	5,40
M 12 x 1.75	25 x 9		27850	5,40
M 3 x 0.5	25.4	Form A	27926	6,40
M 4 x 0.7	25.4	Form A	27930	6,40
M 5 x 0.8	25.4	Form A	27934	6,40
M 6 x 1.0	25.4	Form A	27938	6,40
M 8 x 1.25	25.4	Form A	27942	6,40
M 10 x 1.5	25.4	Form A	27946	6,40
M 12 x 1.75	25.4	Form A	27950	6,40
M 14 x 2.0	38.1	Form A	27954	14,20
M 16 x 2.0	38.1	Form A	27958	14,20
M 18 x 2.5	38.1	Form A	27962	14,20
M 20 x 2.5	38.1	Form A	27966	14,20

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

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

VÖLKEL
THREADING SOLUTIONS

Round Dies
metric ISO-thread DIN 13

Filiere tonde
filettatura metrica ISO DIN 13

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

Nominal Diameter mm	Ø o / d	Art.-No.	€
M 3 x 0.5	20 x 5	27503	7,60
M 4 x 0.7	20 x 5	27505	7,60
M 5 x 0.8	20 x 7	27507	7,90
M 6 x 1.0	20 x 7	27509	7,90
M 8 x 1.25	25 x 9	27511	8,50
M 10 x 1.5	30 x 11	27513	11,00
M 12 x 1.75	38 x 14	27515	17,00
M 14 x 2.0	38 x 14	27516	22,00
M 16 x 2.0	45 x 18	27517	33,00
M 18 x 2.5	45 x 18	27518	33,00
M 20 x 2.5	45 x 18	27519	33,00

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

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

Round Dies
metric-fine ISO-thread DIN 13

Filiere tonde
filettatura metrica fine ISO DIN 13

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

Mf

Nominal Diameter mm	Ø o / d	Art.-No.	€
M 2.5 x 0.35	16 x 5	26404	11,50
M 2.6 x 0.35	16 x 5	26405	11,50
M 3 x 0.35	20 x 5	26408	10,80
M 3.5 x 0.35	20 x 5	26409	10,80
M 4 x 0.35	20 x 5	26410	10,80
M 4 x 0.5	20 x 5	26412	10,80
M 4.5 x 0.5	20 x 5	26413	10,80
M 5 x 0.5	20 x 5	26414	10,80
M 5 x 0.75	20 x 7	26416	10,80
M 5.5 x 0.5	20 x 5	26415	10,80
M 6 x 0.5	20 x 5	26417	10,80
M 6 x 0.75	20 x 7	26418	9,00
M 7 x 0.5	25 x 9	26419	11,50
M 7 x 0.75	25 x 9	26420	11,50
M 8 x 0.5	25 x 9	26422	11,50
M 8 x 0.75	25 x 9	26424	9,50
M 8 x 1.0	25 x 9	26426	9,50
M 9 x 0.5	25 x 9	26427	14,60
M 9 x 0.75	25 x 9	26428	14,60
M 9 x 1.0	25 x 9	26430	14,60
M 10 x 0.5	30 x 11	26431	14,60
M 10 x 0.75	30 x 11	26432	14,60
M 10 x 1.0	30 x 11	26436	11,00
M 10 x 1.25	30 x 11	26438	11,00
M 11 x 1.0	30 x 11	26440	16,50
M 11 x 1.25	30 x 11	26442	16,50
M 12 x 0.5	38 x 10	26445	16,50
M 12 x 0.75	38 x 10	26443	16,50
M 12 x 1.0	38 x 10	26444	14,00
M 12 x 1.25	38 x 10	26446	14,00
M 12 x 1.5	38 x 10	26448	13,50
M 13 x 0.5	38 x 10	26447	23,00
M 13 x 0.75	38 x 10	26449	23,00
M 13 x 1.0	38 x 10	26450	18,40
M 13 x 1.5	38 x 10	26451	18,40
M 14 x 0.5	38 x 10	26455	23,00
M 14 x 0.75	38 x 10	26452	18,40
M 14 x 1.0	38 x 10	26453	18,40
M 14 x 1.25	38 x 10	26454	15,50
M 14 x 1.5	38 x 10	26456	15,50
M 15 x 0.75	38 x 10	26457	29,00
M 15 x 1.0	38 x 10	26458	25,00
M 15 x 1.5	38 x 10	26460	25,00
M 16 x 0.5	45 x 14	26461	32,00
M 16 x 0.75	45 x 14	26463	32,00

►►►

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

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

VÖLKEL THREADING SOLUTIONS

Round Dies
metric-fine ISO-thread DIN 13

Filiere tonde
filettatura metrica fine ISO DIN 13

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

Nominal Diameter mm	Ø o / d	Art.-No.	€
M 16 x 1.0	45 x 14	26462	25,00
M 16 x 1.25	45 x 14	26464	25,00
M 16 x 1.5	45 x 14	26466	19,00
M 17 x 1.0	45 x 14	26468	34,00
M 17 x 1.5	45 x 14	26469	34,00
M 18 x 0.5	45 x 14	26467	34,00
M 18 x 0.75	45 x 14	26473	34,00
M 18 x 1.0	45 x 14	26470	23,00
M 18 x 1.25	45 x 14	26471	23,00
M 18 x 1.5	45 x 14	26472	19,00
M 18 x 2.0	45 x 14	26474	23,50
M 19 x 1.0	45 x 14	26475	34,00
M 19 x 1.5	45 x 14	26476	23,00
M 20 x 0.5	45 x 14	26477	34,00
M 20 x 0.75	45 x 14	26479	34,00
M 20 x 1.0	45 x 14	26478	23,50
M 20 x 1.25	45 x 14	26480	23,50
M 20 x 1.5	45 x 14	26484	19,00
M 20 x 2.0	45 x 14	26486	23,50
M 21 x 1.0	45 x 14	26487	35,50
M 21 x 1.5	45 x 14	26488	35,50
M 22 x 0.5	55 x 16	26489	49,00
M 22 x 0.75	55 x 16	26491	49,00
M 22 x 1.0	55 x 16	26490	38,00
M 22 x 1.25	55 x 16	26492	38,00
M 22 x 1.5	55 x 16	26494	33,50
M 22 x 2.0	55 x 16	26496	38,00
M 23 x 1.0	55 x 16	26497	49,80
M 23 x 1.5	55 x 16	26498	38,00
M 24 x 0.5	55 x 16	26601	49,00
M 24 x 0.75	55 x 16	26603	49,00
M 24 x 1.0	55 x 16	26600	38,00
M 24 x 1.25	55 x 16	26602	38,00
M 24 x 1.5	55 x 16	26604	33,50
M 24 x 2.0	55 x 16	26606	38,00
M 25 x 1.0	55 x 16	26607	49,00
M 25 x 1.5	55 x 16	26608	49,00
M 26 x 1.0	55 x 16	26610	49,00
M 26 x 1.5	55 x 16	26612	49,00
M 26 x 2.0	55 x 16	26614	49,00
M 27 x 1.0	65 x 18	26616	56,00
M 27 x 1.5	65 x 18	26617	56,00
M 27 x 2.0	65 x 18	26618	56,00
M 28 x 1.0	65 x 18	26620	56,00
M 28 x 1.5	65 x 18	26622	56,00
M 28 x 2.0	65 x 18	26624	56,00
M 29 x 1.5	65 x 18	26626	56,00
M 30 x 1.0	65 x 18	26628	56,00
M 30 x 1.5	65 x 18	26630	56,00
M 30 x 2.0	65 x 18	26632	56,00

Round Dies
metric-fine ISO-thread DIN 13

Filiere tonde
filettatura metrica fine ISO DIN 13

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

Nominal Diameter mm	Ø o / d	Art.-No.	€
M 30 x 2.5	65 x 18	26633	56,00
M 30 x 3.0	65 x 25	26634	56,00
M 32 x 1.0	65 x 18	26639	79,00
M 32 x 1.5	65 x 18	26636	56,00
M 32 x 2.0	65 x 18	26635	56,00
M 32 x 3.0	65 x 25	26637	56,00
M 33 x 1.5	65 x 18	26638	56,00
M 33 x 2.0	65 x 18	26640	56,00
M 33 x 3.0	65 x 25	26642	56,00
M 34 x 1.0	65 x 18	26643	79,00
M 34 x 1.5	65 x 18	26644	56,00
M 34 x 2.0	65 x 18	26646	56,00
M 35 x 1.0	65 x 18	26647	79,00
M 35 x 1.5	65 x 18	26648	56,00
M 35 x 2.0	65 x 18	26649	79,00
M 36 x 1.0	65 x 18	26651	79,00
M 36 x 1.5	65 x 18	26650	56,00
M 36 x 2.0	65 x 18	26652	56,00
M 36 x 3.0	65 x 25	26654	56,00
M 37 x 1.5	65 x 18	26653	119,00
M 38 x 1.0	75 x 20	26655	119,00
M 38 x 1.5	75 x 20	26656	90,00
M 38 x 2.0	75 x 20	26657	90,00
M 38 x 3.0	75 x 30	26659	119,00
M 39 x 1.5	75 x 20	26658	90,00
M 39 x 2.0	75 x 20	26660	90,00
M 39 x 3.0	75 x 30	26662	90,00
M 40 x 1.0	75 x 20	26663	119,00
M 40 x 1.5	75 x 20	26664	90,00
M 40 x 2.0	75 x 20	26666	90,00
M 40 x 3.0	75 x 30	26668	90,00
M 42 x 1.0	75 x 20	26669	119,00
M 42 x 1.5	75 x 20	26670	90,00
M 42 x 2.0	75 x 20	26672	90,00
M 42 x 3.0	75 x 30	26674	90,00
M 44 x 1.5	90 x 22	26671	194,00
M 44 x 2.0	90 x 22	26673	194,00
M 45 x 1.0	90 x 22	26675	194,00
M 45 x 1.5	90 x 22	26676	144,00
M 45 x 2.0	90 x 22	26678	144,00
M 45 x 3.0	90 x 36	26680	144,00
M 46 x 1.5	90 x 22	26681	194,00
M 48 x 1.0	90 x 22	26683	194,00
M 48 x 1.5	90 x 22	26682	144,00
M 48 x 2.0	90 x 22	26684	144,00
M 48 x 3.0	90 x 36	26686	144,00
M 50 x 1.5	90 x 22	26688	144,00
M 50 x 2.0	90 x 22	26690	144,00
M 50 x 3.0	90 x 36	26692	144,00
M 52 x 1.5	90 x 22	26694	144,00

VÖLKEL THREADING SOLUTIONS

Round Dies
metric-fine ISO-thread DIN 13

Filiere tonde
filettatura metrica fine ISO DIN 13

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

Mf

Nominal Diameter mm	Ø o / d	Art.-No.	€
M 52 x 2.0	90 x 22	26696	144,00
M 52 x 3.0	90 x 36	26698	144,00
M 54 x 1.0	105 x 22	28267	266,00
M 54 x 1.5	105 x 22	28150	266,00
M 54 x 2.0	105 x 22	28151	266,00
M 54 x 3.0	105 x 36	28152	266,00
M 54 x 4.0	105 x 36	28153	266,00
M 55 x 1.5	105 x 22	28154	266,00
M 55 x 2.0	105 x 22	28155	266,00
M 55 x 3.0	105 x 36	28156	266,00
M 55 x 4.0	105 x 36	28157	266,00
M 56 x 1.0	105 x 22	28268	266,00
M 56 x 1.5	105 x 22	28158	266,00
M 56 x 2.0	105 x 22	28159	266,00
M 56 x 3.0	105 x 36	28160	266,00
M 56 x 4.0	105 x 36	28161	266,00
M 58 x 1.0	105 x 22	28269	266,00
M 58 x 1.5	105 x 22	28162	266,00
M 58 x 2.0	105 x 22	28163	266,00
M 58 x 3.0	105 x 36	28164	266,00
M 58 x 4.0	105 x 36	28165	266,00
M 60 x 1.5	105 x 22	28166	266,00
M 60 x 2.0	105 x 22	28167	266,00
M 60 x 3.0	105 x 36	28168	266,00
M 60 x 4.0	105 x 36	28169	266,00
M 62 x 1.5	105 x 22	28170	266,00
M 62 x 2.0	105 x 22	28171	266,00
M 62 x 3.0	105 x 36	28172	266,00
M 62 x 4.0	105 x 36	28173	266,00
M 63 x 1.5	105 x 22	28174	266,00
M 64 x 1.5	120 x 22	28175	302,00
M 64 x 2.0	120 x 22	28176	302,00
M 64 x 3.0	120 x 36	28177	302,00
M 64 x 4.0	120 x 36	28178	302,00
M 65 x 1.5	120 x 22	28179	302,00
M 65 x 2.0	120 x 22	28180	302,00
M 65 x 3.0	120 x 36	28181	302,00
M 65 x 4.0	120 x 36	28182	302,00
M 68 x 1.5	120 x 22	28183	302,00
M 68 x 2.0	120 x 22	28184	302,00
M 68 x 3.0	120 x 36	28185	302,00
M 68 x 4.0	120 x 36	28186	302,00
M 70 x 1.5	120 x 22	28187	302,00
M 70 x 2.0	120 x 22	28188	302,00
M 70 x 3.0	120 x 36	28189	302,00
M 70 x 4.0	120 x 36	28190	302,00
M 72 x 1.5	120 x 22	28191	302,00
M 72 x 2.0	120 x 22	28192	302,00
M 72 x 3.0	120 x 36	28193	302,00
M 72 x 4.0	120 x 36	28194	302,00

Round Dies
metric-fine ISO-thread DIN 13

Filiere tonde
filettatura metrica fine ISO DIN 13

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

Mf

Nominal Diameter mm	Ø o / d	Art.-No.	€
M 74 x 1.5	120 x 22	28195	302,00
M 74 x 2.0	120 x 22	28196	302,00
M 74 x 3.0	120 x 36	28197	302,00
M 74 x 4.0	120 x 36	28198	302,00
M 75 x 1.5	120 x 22	28199	302,00
M 75 x 2.0	120 x 22	28200	302,00
M 75 x 3.0	120 x 36	28201	302,00
M 75 x 4.0	120 x 36	28202	302,00
M 76 x 1.5	120 x 22	28203	302,00
M 76 x 2.0	120 x 22	28204	302,00
M 76 x 3.0	120 x 36	28205	302,00
M 76 x 4.0	120 x 36	28206	302,00
M 78 x 1.5	120 x 22	28207	302,00
M 78 x 2.0	120 x 22	28208	302,00
M 78 x 3.0	120 x 36	28209	302,00
M 78 x 4.0	120 x 36	28210	302,00
M 80 x 1.5	120 x 22	28211	302,00
M 80 x 2.0	120 x 22	28212	302,00
M 80 x 3.0	120 x 36	28213	302,00
M 80 x 4.0	120 x 36	28214	302,00
M 82 x 1.5	130 x 25	28215	383,00
M 82 x 2.0	130 x 25	28216	383,00
M 82 x 3.0	130 x 36	28217	383,00
M 82 x 4.0	130 x 36	28218	383,00
M 84 x 1.5	130 x 25	28219	383,00
M 84 x 2.0	130 x 25	28220	383,00
M 84 x 3.0	130 x 36	28221	383,00
M 84 x 4.0	130 x 36	28222	383,00
M 85 x 1.5	130 x 25	28223	383,00
M 85 x 2.0	130 x 25	28224	383,00
M 85 x 3.0	130 x 36	28225	383,00
M 85 x 4.0	130 x 36	28226	383,00
M 86 x 1.5	140 x 22	28227	477,00
M 86 x 2.0	140 x 22	28228	477,00
M 86 x 3.0	140 x 22	28229	477,00
M 86 x 4.0	140 x 22	28230	477,00
M 88 x 1.5	140 x 22	28231	477,00
M 88 x 2.0	140 x 22	28232	477,00
M 88 x 3.0	140 x 22	28233	477,00
M 88 x 4.0	140 x 22	28234	477,00
M 90 x 1.5	140 x 22	28235	477,00
M 90 x 2.0	140 x 22	28236	477,00
M 90 x 3.0	140 x 22	28237	477,00
M 90 x 4.0	140 x 22	28238	477,00
M 92 x 1.5	140 x 22	28239	477,00
M 92 x 2.0	140 x 22	28240	477,00
M 92 x 3.0	140 x 22	28241	477,00
M 92 x 4.0	140 x 22	28242	477,00
M 95 x 1.5	140 x 22	28243	477,00
M 95 x 2.0	140 x 22	28244	477,00

Round Dies
metric-fine ISO-thread DIN 13

Filiere tonde
filettatura metrica fine ISO DIN 13

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

Mf

Nominal Diameter mm	Ø o / d	Art.-No.	€
M 95 x 3.0	140 x 22	28245	477,00
M 95 x 4.0	140 x 22	28246	477,00
M 96 x 1.5	140 x 22	28247	477,00
M 96 x 2.0	140 x 22	28248	477,00
M 96 x 3.0	140 x 22	28249	477,00
M 96 x 4.0	140 x 22	28250	477,00
M 98 x 1.5	150 x 25	28251	574,00
M 98 x 2.0	150 x 25	28252	574,00
M 98 x 3.0	150 x 25	28253	574,00
M 98 x 4.0	150 x 25	28254	574,00
M 100 x 1.5	150 x 25	28255	574,00
M 100 x 2.0	150 x 25	28256	574,00
M 100 x 3.0	150 x 25	28257	574,00
M 100 x 4.0	150 x 25	28258	574,00
M 105 x 1.5	150 x 25	28259	574,00
M 105 x 2.0	150 x 25	28260	574,00
M 105 x 3.0	150 x 25	28261	574,00
M 105 x 4.0	150 x 25	28262	574,00
M 110 x 1.5	160 x 25	28263	626,00
M 110 x 2.0	160 x 25	28264	626,00
M 110 x 3.0	160 x 25	28265	626,00
M 110 x 4.0	160 x 25	28266	626,00

Round Dies
Whitworth-thread BS 84

Filiere tonde
filettatura Whitworth BS 84

DIN 223 (DIN EN 22568) HSS

BSW / BSF

Nominal Diameter	Ø o / d	Art.-No.	€
BSW			
BSW 1/16 x 60	16 x 5	22402	10,00
BSW 3/32 x 48	16 x 5	22404	10,00
BSW 1/8 x 40	20 x 5	22406	10,00
BSW 5/32 x 32	20 x 5	22408	10,00
BSW 3/16 x 24	20 x 7	22410	10,00
BSW 7/32 x 24	20 x 7	22412	10,00
BSW 1/4 x 20	20 x 7	22414	10,00
BSW 5/16 x 18	25 x 9	22416	11,50
BSW 3/8 x 16	30 x 11	22418	12,70
BSW 7/16 x 14	30 x 11	22420	14,70
BSW 1/2 x 12	38 x 14	22422	16,50
BSW 9/16 x 12	38 x 14	22424	20,40
BSW 5/8 x 11	45 x 18	22426	22,30
BSW 3/4 x 10	45 x 18	22430	22,30
BSW 7/8 x 9	55 x 22	22434	34,50
BSW 1" x 8	55 x 22	22438	34,50
BSW 1.1/8 x 7	65 x 25	22442	57,50
BSW 1.1/4 x 7	65 x 25	22446	57,50
BSW 1.3/8 x 6	65 x 25	22450	57,50
BSW 1.1/2 x 6	65 x 25	22452	57,50
BSW 1.1/2 x 6	75 x 30	22454	102,90
BSW 1.5/8 x 5	75 x 30	22458	102,90
BSW 1.3/4 x 5	90 x 36	22462	155,00
BSW 1.7/8 x 4.1/2	90 x 36	22466	155,00
BSW 2" x 4.1/2	90 x 36	22470	155,00
BSW 2.1/4 x 4	105 x 36	22472	404,00
BSW 2.1/2 x 4	105 x 36	22474	404,00
BSW 2.3/4 x 3.1/2	120 x 36	22476	496,00
BSW 3" x 3.1/2	120 x 36	22478	496,00
BSF			
BSF 3/16 x 32	20 x 7	22810	10,00
BSF 1/4 x 26	20 x 7	22814	10,00
BSF 5/16 x 22	25 x 9	22816	11,50
BSF 3/8 x 20	30 x 11	22818	13,20
BSF 7/16 x 18	30 x 11	22820	14,70
BSF 1/2 x 16	38 x 10	22822	19,80
BSF 9/16 x 16	38 x 10	22824	22,00
BSF 5/8 x 14	45 x 14	22826	30,00
BSF 3/4 x 12	45 x 14	22830	30,00
BSF 7/8 x 11	55 x 16	22834	39,00
BSF 1" x 10	55 x 22	22838	39,00

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

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

Round Split Dies
BA-thread BS 93

Filiere tonde
filettatura BA, BS 93

BS1127 HSS

BA

Nominal Diameter	Ø o / d		Art.-No.	€
BA 0	20.6 x 6.35	Form A	89000	9,90
BA 1	20.6 x 6.35	Form A	89001	9,90
BA 2	20.6 x 6.35	Form A	89002	9,90
BA 3	20.6 x 6.35	Form A	89003	9,90
BA 4	20.6 x 6.35	Form A	89004	9,90
BA 5	20.6 x 6.35	Form A	89005	9,90
BA 6	20.6 x 6.35	Form A	89006	9,90

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

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

Round Dies
Unified Coarse thread

Filiere tonde
filettatura unificata, serie grossa ANSI B1.1

DIN 223 (DIN EN 22568) HSS UNC

Nominal Diameter	Ø o / d	Art.-No.	€
UNC Nr. 1 x 64	16 x 5	23401	18,80
UNC Nr. 2 x 56	16 x 5	23402	18,80
UNC Nr. 3 x 48	16 x 5	23403	18,80
UNC Nr. 4 x 40	20 x 5	23404	13,00
UNC Nr. 5 x 40	20 x 5	23405	13,00
UNC Nr. 6 x 32	20 x 7	23406	13,00
UNC Nr. 8 x 32	20 x 7	23408	13,00
UNC Nr.10 x 24	20 x 7	23410	13,00
UNC Nr.12 x 24	20 x 7	23412	13,00
UNC 1/4 x 20	20 x 7	23414	10,00
UNC 5/16 x 18	25 x 9	23416	11,50
UNC 3/8 x 16	30 x 11	23418	12,70
UNC 7/16 x 14	30 x 11	23420	14,70
UNC 1/2 x 13	38 x 14	23422	16,50
UNC 9/16 x 12	38 x 14	23424	20,40
UNC 5/8 x 11	45 x 18	23426	22,30
UNC 3/4 x 10	45 x 18	23430	22,30
UNC 7/8 x 9	55 x 22	23434	34,50
UNC 1" x 8	55 x 22	23438	34,50
UNC 1.1/8 x 7	65 x 25	23442	57,50
UNC 1.1/4 x 7	65 x 25	23446	57,50
UNC 1.3/8 x 6	65 x 25	23450	57,50
UNC 1.1/2 x 6	65 x 25	23452	57,50
UNC 1.1/2 x 6	75 x 30	23454	102,90
UNC 1.5/8 x 5	75 x 30	23458	102,90
UNC 1.3/4 x 5	90 x 36	23462	155,00
UNC 1.7/8 x 4.1/2	90 x 36	23466	155,00
UNC 2" x 4.1/2	90 x 36	23470	155,00

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

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

VÖLKEL
THREADING SOLUTIONS

Round Dies
Unified Fine thread

Filiere tonde
filettatura unificata, serie fina ANSI B1.1

DIN 223 (DIN EN 22568) HSS UNF

Nominal Diameter	Ø o / d	Art.-No.	€
UNF Nr. 0 x 80	16 x 5	24400	18,80
UNF Nr. 1 x 72	16 x 5	24401	18,80
UNF Nr. 2 x 64	16 x 5	24402	18,80
UNF Nr. 3 x 56	16 x 5	24403	18,80
UNF Nr. 4 x 48	20 x 5	24404	13,00
UNF Nr. 5 x 44	20 x 5	24405	13,00
UNF Nr. 6 x 40	20 x 5	24406	13,00
UNF Nr. 8 x 36	20 x 7	24408	13,00
UNF Nr. 10 x 32	20 x 7	24410	13,00
UNF Nr. 12 x 28	20 x 7	24412	13,00
UNF 1/4 x 28	20 x 7	24414	10,00
UNF 5/16 x 24	25 x 9	24416	11,50
UNF 3/8 x 24	30 x 11	24418	12,70
UNF 7/16 x 20	30 x 11	24420	14,70
UNF 1/2 x 20	38 x 10	24422	16,50
UNF 9/16 x 18	38 x 10	24424	20,40
UNF 5/8 x 18	45 x 14	24426	22,30
UNF 3/4 x 16	45 x 14	24430	22,30
UNF 7/8 x 14	55 x 16	24434	34,50
UNF 1" x 12	55 x 16	24438	34,50
UNF 1" x 14	55 x 16	24440	34,50
UNF 1.1/8 x 12	65 x 18	24442	57,50
UNF 1.1/4 x 12	65 x 18	24446	57,50
UNF 1.3/8 x 12	65 x 18	24450	57,50
UNF 1.1/2 x 12	65 x 18	24452	57,50
UNF 1.1/2 x 12	75 x 20	24454	102,90

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

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

Round Dies
Unified Extra Fine thread ANSI B 1.1

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

DIN 223 (DIN EN 22568) HSS UNEF

Nominal Diameter	Ø o / d	Art.-No.	€
UNEF Nr. 12 x 32	20 x 7	24612	13,00
UNEF 1/4 x 32	20 x 7	24614	13,00
UNEF 5/16 x 32	25 x 9	24615	16,00
UNEF 3/8 x 32	30 x 11	24616	18,00
UNEF 7/16 x 28	30 x 11	24620	18,00
UNEF 1/2 x 28	38 x 10	24621	27,50
UNEF 9/16 x 24	38 x 10	24625	27,50
UNEF 5/8 x 24	45 x 14	24626	44,00
UNEF 11/16 x 24	45 x 14	24627	44,00
UNEF 3/4 x 20	45 x 14	24633	44,00
UNEF 13/16 x 20	55 x 16	24634	52,00
UNEF 7/8 x 20	55 x 16	24635	52,00
UNEF 15/16 x 20	55 x 16	24636	52,00
UNEF 1" x 20	55 x 16	24637	52,00
UNEF 1.1/16 x 18	65 x 18	24645	83,00
UNEF 1.1/8 x 18	65 x 18	24646	83,00
UNEF 1.3/16 x 18	65 x 18	24647	83,00
UNEF 1.1/4 x 18	65 x 18	24648	83,00
UNEF 1.5/16 x 18	65 x 18	24649	83,00
UNEF 1.3/8 x 18	65 x 18	24650	83,00
UNEF 1.7/16 x 18	75 x 20	24651	104,00
UNEF 1.1/2 x 18	75 x 20	24652	104,00

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

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

VÖLKEL
THREADING SOLUTIONS

Round Dies
Pipe-thread DIN ISO 228

Filiere tonde
filettatura per tubi gas DIN ISO 228

DIN 5158 (DIN EN 24231) HSS

G (BSP)

Nominal Diameter	Ø o / d	Art.-No.	€
G 1/8 x 28	30 x 11	25412	15,00
G 1/4 x 19	38 x 10	25414	15,00
G 3/8 x 19	45 x 14	25416	20,00
G 1/2 x 14	45 x 14	25418	20,00
G 5/8 x 14	55 x 16	25420	33,50
G 3/4 x 14	55 x 16	25422	33,50
G 7/8 x 14	65 x 18	25424	45,20
G 1" x 11	65 x 18	25426	45,20
G 1.1/8 x 11	75 x 20	25430	69,00
G 1.1/4 x 11	75 x 20	25434	69,00
G 1.3/8 x 11	90 x 22	25438	117,00
G 1.1/2 x 11	90 x 22	25442	117,00
G 1.5/8 x 11	90 x 22	25446	117,00
G 1.3/4 x 11	105 x 22	25450	245,00
G 2" x 11	90 x 22	25452	117,00
G 2" x 11	105 x 22	25454	245,00
G 2.1/4 x 11	120 x 22	25458	336,00
G 2.1/2 x 11	120 x 22	25462	445,00
G 2.3/4 x 11	120 x 22	25466	445,00
G 3" x 11	130 x 25	25470	493,00
G 3.1/2 x 11	150 x 25	25474	798,00
G 4" x 11	160 x 25	25478	987,00

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

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

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

Filiere tonde
filettatura conica per tubi, cono 1:16

HSS

R (BSPT)

Nominal Diameter		Ø o / d		Art.-No.	€
PT	1/8 x 28	38 x 11	Form A	97006	16,00
PT	1/4 x 19	38 x 16	Form A	97014	16,00
PT	3/8 x 19	50 x 18	Form A	97020	32,50
PT	1/2 x 14	50 x 22	Form A	97022	32,50
PT	3/4 x 14	50 x 24	Form A	97030	32,50
PT	1" x 11	63 x 28	Form A	97040	54,00
PT	1.1/4 x 11	75 x 32	Form A	97048	73,00

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

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

VÖLKEL
THREADING SOLUTIONS

Round Dies
armoured tube thread DIN 40 430

Filiere tonde
filettatura per tubi corazzati DIN 40 430

DIN 40434 HSS

PG

Nominal Diameter	Ø o / d	Art.-No.	€
PG 7 x 20	38 x 10	25807	37,00
PG 9 x 18	45 x 14	25809	45,00
PG 11 x 18	45 x 14	25811	45,00
PG 13.5 x 18	45 x 14	25813	45,00
PG 16 x 18	55 x 16	25816	53,00
PG 21 x 16	65 x 18	25821	82,00
PG 29 x 16	65 x 18	25829	82,00
PG 36 x 16	90 x 22	25836	162,00
PG 42 x 16	105 x 22	25842	206,00
PG 48 x 16	105 x 22	25848	206,00

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

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

Round Dies
american tapered pipe thread, taper 1:16

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

HSS

NPT / NPTF

Nominal Diameter	Ø o / d		Art.-No.	€
NPT				
NPT 1/16 x 27	25 x 9		23610	30,00
NPT 1/8 x 27	30 x 11		23612	32,00
NPT 1/4 x 18	38 x 14		23614	39,00
NPT 3/8 x 18	45 x 14		23616	49,00
NPT 1/2 x 14	45 x 18		23618	49,00
NPT 5/8 x 14	55 x 22		23620	79,00
NPT 3/4 x 14	55 x 22		23622	79,00
NPT 7/8 x 14	65 x 25		23624	117,00
NPT 1" x 11.5	65 x 25		23626	117,00
NPT 1.1/4 x 11.5	75 x 26		23634	138,00
NPT 1.1/2 x 11.5	90 x 27		23642	225,00
NPT 2" x 11.5	105 x 28		23654	298,00
NPTF				
NPTF 1/8 x 27	50 x 11	Form A	98072	33,00
NPTF 1/4 x 18	50 x 14	Form A	98074	33,00
NPTF 3/8 x 18	50 x 14	Form A	98076	33,00
NPTF 1/2 x 14	50 x 18	Form A	98078	33,00
NPTF 3/4 x 14	50 x 22	Form A	98080	33,00
NPTF 1" x 11.5	50 x 25	Form A	98082	33,00

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

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

VÖLKEL
THREADING SOLUTIONS

Round Dies
Cycle thread DIN 79012 and BS 811

Filiere tonde
filettatura per biciclette DIN 79012 e BS 811

DIN 223 (DIN EN 22568) HSS

FG / BSC

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

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

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

Round Dies
Valve thread DIN 7756

Filiere tonde
filettatura per valvole DIN 7756

DIN 223 (DIN EN 22568) HSS

Vg

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

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

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

VÖLKEL THREADING SOLUTIONS

Round Dies, gun nosed
metric ISO-thread DIN 13

Filiere tonde con imbocco corretto
filettatura metrica ISO DIN 13

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

Nominal Diameter mm	Ø o / d	Art.-No.	€
M 3 x 0.5	20 x 5	57426	7,70
M 4 x 0.7	20 x 5	57430	7,70
M 5 x 0.8	20 x 7	57434	8,00
M 6 x 1.0	20 x 7	57438	8,00
M 8 x 1.25	25 x 9	57442	11,30
M 10 x 1.5	30 x 11	57446	16,10
M 12 x 1.75	38 x 14	57450	25,40
M 14 x 2.0	38 x 14	57454	25,40
M 16 x 2.0	45 x 18	57458	38,30
M 18 x 2.5	45 x 18	57462	38,30
M 20 x 2.5	45 x 18	57466	38,30
M 22 x 2.5	55 x 22	57470	68,20
M 24 x 3.0	55 x 22	57474	68,20
M 27 x 3.0	65 x 25	57476	100,80
M 30 x 3.5	65 x 25	57478	100,80

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

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

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

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

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

Filiere tonde con imbocco corretto
filettatura metrica fine ISO DIN 13

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

Nominal Diameter mm	Ø o / d	Art.-No.	€
M 6 x 0.75	20 x 7	56418	10,90
M 8 x 0.75	25 x 9	56424	12,10
M 8 x 1.0	25 x 9	56426	12,10
M 10 x 1.0	30 x 11	56436	13,40
M 10 x 1.25	30 x 11	56438	13,40
M 12 x 1.0	38 x 10	56444	23,10
M 12 x 1.25	38 x 10	56446	23,10
M 12 x 1.5	38 x 10	56448	23,10
M 14 x 1.25	38 x 10	56454	23,10
M 14 x 1.5	38 x 10	56456	23,10
M 16 x 1.5	45 x 14	56466	37,00
M 18 x 1.5	45 x 14	56472	37,00
M 18 x 2.0	45 x 14	56474	37,00
M 20 x 1.5	45 x 14	56484	37,00
M 20 x 2.0	45 x 14	56486	37,00
M 22 x 1.5	55 x 16	56494	82,00
M 24 x 1.5	55 x 16	56604	82,00

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

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

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

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

VÖLKEL
THREADING SOLUTIONS

Round Dies, gun nosed
Pipe-thread DIN ISO 228

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

DIN 5158 (DIN EN 24231) HSS-E

G (BSP)

Nominal Diameter	Ø o / d	Art.-No.	€
G 1/8 x 28	30 x 11	55412	23,00
G 1/4 x 19	38 x 10	55414	23,00
G 3/8 x 19	45 x 14	55416	34,50
G 1/2 x 14	45 x 14	55418	34,50
G 3/4 x 14	55 x 16	55422	63,00
G 1" x 11	65 x 18	55426	90,00

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

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

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

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

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

Filiere tonde, *filetto sinistro*
filettatura metrica ISO DIN 13

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

Nominal Diameter mm	Ø o / d	Art.-No.	€
M 2 x 0.4	16 x 5	27216	18,00
M 3 x 0.5	20 x 5	27226	7,90
M 4 x 0.7	20 x 5	27230	7,90
M 5 x 0.8	20 x 7	27234	8,50
M 6 x 1.0	20 x 7	27238	8,50
M 8 x 1.25	25 x 9	27242	9,80
M 10 x 1.5	30 x 11	27246	13,00
M 12 x 1.75	38 x 14	27250	18,20
M 14 x 2.0	38 x 14	27254	21,00
M 16 x 2.0	45 x 18	27258	29,00
M 18 x 2.5	45 x 18	27262	29,00
M 20 x 2.5	45 x 18	27266	29,00
M 22 x 2.5	55 x 22	27270	43,00
M 24 x 3.0	55 x 22	27274	43,00
M 27 x 3.0	65 x 25	27276	79,00
M 30 x 3.5	65 x 25	27278	79,00
M 33 x 3.5	65 x 25	27280	79,00
M 36 x 4.0	65 x 25	27282	79,00
M 39 x 4.0	75 x 30	27284	131,00
M 42 x 4.5	75 x 30	27286	131,00
M 45 x 4.5	90 x 36	27288	209,00
M 48 x 5.0	90 x 36	27290	209,00
M 52 x 5.0	90 x 36	27292	209,00

Application:

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

Applicazione:

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

VÖLKEL
THREADING SOLUTIONS

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

Filiere tonde, *filetto sinistro*
filettatura metrica fine ISO DIN 13

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

Nominal Diameter mm	Ø o / d	Art.-No.	€
M 2.5 x 0.35	16 x 5	26801	13,50
M 3 x 0.35	20 x 5	26802	13,50
M 3.5 x 0.35	20 x 5	26803	13,50
M 4 x 0.35	20 x 5	26804	13,50
M 4 x 0.5	20 x 5	26805	13,50
M 4.5 x 0.5	20 x 5	26806	13,50
M 5 x 0.5	20 x 5	26807	13,50
M 5 x 0.75	20 x 7	26808	13,50
M 5.5 x 0.5	20 x 5	26809	13,50
M 6 x 0.5	20 x 5	26810	13,50
M 6 x 0.75	20 x 7	26207	13,50
M 7 x 0.5	25 x 9	26811	16,00
M 7 x 0.75	25 x 9	26812	16,00
M 8 x 0.5	25 x 9	26813	16,00
M 8 x 0.75	25 x 9	26210	16,00
M 8 x 1.0	25 x 9	26211	16,00
M 9 x 0.5	25 x 9	26814	16,00
M 9 x 0.75	25 x 9	26815	16,00
M 9 x 1.0	25 x 9	26816	16,00
M 10 x 0.5	30 x 11	26817	20,00
M 10 x 0.75	30 x 11	26818	20,00
M 10 x 1.0	30 x 11	26215	20,00
M 10 x 1.25	30 x 11	26216	20,00
M 11 x 1.0	30 x 11	26819	20,00
M 11 x 1.25	30 x 11	26820	20,00
M 12 x 0.5	38 x 10	26821	26,00
M 12 x 0.75	38 x 10	26822	26,00
M 12 x 1.0	38 x 10	26220	26,00
M 12 x 1.25	38 x 10	26221	26,00
M 12 x 1.5	38 x 10	26222	26,00
M 13 x 0.5	38 x 10	26823	26,00
M 13 x 0.75	38 x 10	26824	26,00
M 13 x 1.0	38 x 10	26825	26,00
M 13 x 1.5	38 x 10	26826	26,00
M 14 x 0.5	38 x 10	26827	26,00
M 14 x 0.75	38 x 10	26828	26,00
M 14 x 1.0	38 x 10	26829	26,00
M 14 x 1.25	38 x 10	26227	26,00
M 14 x 1.5	38 x 10	26228	26,00
M 15 x 0.75	38 x 10	26830	26,00
M 15 x 1.0	38 x 10	26831	26,00
M 15 x 1.5	38 x 10	26832	26,00
M 16 x 0.75	45 x 14	26833	39,00
M 16 x 1.0	45 x 14	26231	39,00
M 16 x 1.25	45 x 14	26834	39,00
M 16 x 1.5	45 x 14	26233	39,00

►►►

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

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

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

Filiere tonde, *filetto sinistro*
filettatura metrica fine ISO DIN 13

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

Nominal Diameter	Ø o / d	Art.-No.	€
M 17 x 1.0	45 x 14	26835	39,00
M 17 x 1.5	45 x 14	26836	39,00
M 18 x 0.75	45 x 14	26837	39,00
M 18 x 1.0	45 x 14	26838	39,00
M 18 x 1.25	45 x 14	26839	39,00
M 18 x 1.5	45 x 14	26236	39,00
M 18 x 2.0	45 x 14	26840	39,00
M 19 x 1.0	45 x 14	26841	39,00
M 19 x 1.5	45 x 14	26842	39,00
M 20 x 0.5	45 x 14	26843	39,00
M 20 x 0.75	45 x 14	26844	39,00
M 20 x 1.0	45 x 14	26845	39,00
M 20 x 1.25	45 x 14	26846	39,00
M 20 x 1.5	45 x 14	26240	39,00
M 20 x 2.0	45 x 14	26847	39,00
M 21 x 1.0	45 x 14	26848	39,00
M 21 x 1.5	45 x 14	26849	39,00
M 22 x 1.0	55 x 16	26850	62,00
M 22 x 1.25	55 x 16	26851	62,00
M 22 x 1.5	55 x 16	26245	62,00
M 22 x 2.0	55 x 16	26852	62,00
M 24 x 1.25	55 x 16	26853	62,00
M 24 x 1.5	55 x 16	26250	62,00
M 24 x 2.0	55 x 16	26251	62,00
M 25 x 1.0	55 x 16	26854	62,00
M 25 x 1.5	55 x 16	26855	62,00
M 26 x 1.0	55 x 16	26856	62,00
M 26 x 1.5	55 x 16	26857	62,00
M 26 x 2.0	55 x 16	26858	62,00
M 27 x 1.0	65 x 18	26859	98,00
M 27 x 1.5	65 x 18	26860	98,00
M 27 x 2.0	65 x 18	26861	98,00
M 28 x 1.0	65 x 18	26862	98,00
M 28 x 1.5	65 x 18	26863	98,00
M 28 x 2.0	65 x 18	26864	98,00
M 29 x 1.5	65 x 18	26865	98,00
M 30 x 1.0	65 x 18	26866	98,00
M 30 x 1.5	65 x 18	26867	98,00
M 30 x 2.0	65 x 18	26264	98,00
M 30 x 2.5	65 x 18	26265	98,00
M 30 x 3.0	65 x 25	26266	98,00
M 32 x 1.0	65 x 18	26267	98,00
M 32 x 1.5	65 x 18	26268	98,00
M 32 x 2.0	65 x 18	26269	98,00
M 32 x 3.0	65 x 25	26270	98,00
M 33 x 1.5	65 x 18	26271	98,00

►►►

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

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

VÖLKEL
THREADING SOLUTIONS

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

Filiere tonde, *filetto sinistro*
filettatura metrica fine ISO DIN 13

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

Nominal Diameter	Ø o / d	Art.-No.	€
M 33 x 2.0	65 x 18	26272	98,00
M 33 x 3.0	65 x 25	26273	98,00
M 34 x 1.0	65 x 18	26274	98,00
M 34 x 1.5	65 x 18	26275	98,00
M 34 x 2.0	65 x 18	26276	98,00
M 35 x 1.0	65 x 18	26277	98,00
M 35 x 1.5	65 x 18	26278	98,00
M 35 x 2.0	65 x 18	26279	98,00
M 36 x 1.0	65 x 18	26280	98,00
M 36 x 1.5	65 x 18	26281	98,00
M 36 x 2.0	65 x 18	26282	98,00
M 36 x 3.0	65 x 25	26283	98,00
M 37 x 1.5	65 x 18	26284	98,00
M 38 x 1.0	75 x 20	26285	149,00
M 38 x 1.5	75 x 20	26286	149,00
M 38 x 2.0	75 x 20	26287	149,00
M 38 x 3.0	75 x 30	26288	149,00
M 39 x 1.5	75 x 20	26289	149,00
M 39 x 2.0	75 x 20	26290	149,00
M 39 x 3.0	75 x 30	26291	149,00
M 40 x 1.0	75 x 20	26292	149,00
M 40 x 1.5	75 x 20	26293	149,00
M 40 x 2.0	75 x 20	26294	149,00
M 40 x 3.0	75 x 30	26295	149,00
M 42 x 1.0	75 x 20	26296	149,00
M 42 x 1.5	75 x 20	26297	149,00
M 42 x 2.0	75 x 20	26298	149,00
M 42 x 3.0	75 x 30	26299	149,00
M 44 x 1.5	90 x 22	26868	267,00
M 45 x 1.5	90 x 22	26869	267,00
M 45 x 2.0	90 x 22	26870	267,00
M 45 x 3.0	90 x 36	26871	267,00
M 46 x 1.5	90 x 22	26872	267,00
M 48 x 1.5	90 x 22	26873	267,00
M 48 x 2.0	90 x 22	26874	267,00
M 48 x 3.0	90 x 36	26875	267,00
M 50 x 1.5	90 x 22	26876	267,00
M 50 x 2.0	90 x 22	26877	267,00
M 50 x 3.0	90 x 36	26878	267,00
M 52 x 1.5	90 x 22	26879	267,00
M 52 x 2.0	90 x 22	26880	267,00
M 52 x 3.0	90 x 36	26881	267,00

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

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

Round Dies, *Left Hand*
Whitworth-thread BS 84

Filiere tonde, *filetto sinistro*
filettatura Whitworth BS 84

DIN 223 (DIN EN 22568) HSS **BSW**

Nominal Diameter	Ø o / d	Art.-No.	€
BSW 1/8 x 40	20 x 5	22206	15,50
BSW 5/32 x 32	20 x 5	22208	15,50
BSW 3/16 x 24	20 x 7	22210	15,50
BSW 1/4 x 20	20 x 7	22214	15,50
BSW 5/16 x 18	25 x 9	22216	18,00
BSW 3/8 x 16	30 x 11	22218	22,00
BSW 7/16 x 14	30 x 11	22220	22,00
BSW 1/2 x 12	38 x 14	22222	34,50
BSW 9/16 x 12	38 x 14	22224	34,50
BSW 5/8 x 11	45 x 18	22226	44,00
BSW 3/4 x 10	45 x 18	22230	44,00
BSW 7/8 x 9	55 x 22	22234	64,00
BSW 1" x 8	55 x 22	22238	64,00

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

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

VÖLKEL
THREADING SOLUTIONS

Round Dies, *Left Hand*
Unified thread ANSI B 1.1

Filiere tonde, *filetto sinistro*
filettatura unificata ANSI B1.1

DIN 223 (DIN EN 22568) HSS UNC / UNF

Nominal Diameter mm	Width across flats mm	Art.-No.	€
UNC			
UNC Nr. 6 x 32	20 x 7	23206	19,00
UNC Nr. 8 x 32	20 x 7	23208	19,00
UNC Nr.10 x 24	20 x 7	23210	19,00
UNC 1/4 x 20	20 x 7	23214	15,50
UNC 5/16 x 18	25 x 9	23216	18,00
UNC 3/8 x 16	30 x 11	23218	22,00
UNC 7/16 x 14	38 x 14	23220	22,00
UNC 1/2 x 13	38 x 14	23222	34,50
UNC 9/16 x 12	38 x 14	23224	34,50
UNC 5/8 x 11	45 x 18	23226	44,00
UNC 3/4 x 10	45 x 18	23230	44,00
UNC 7/8 x 9	55 x 22	23234	64,00
UNC 1" x 8	55 x 22	23238	64,00
UNF			
UNF Nr. 10 x 32	20 x 7	24210	19,00
UNF 1/4 x 28	20 x 7	24214	15,50
UNF 5/16 x 24	25 x 9	24216	18,00
UNF 3/8 x 24	30 x 11	24218	22,00
UNF 7/16 x 20	30 x 11	24220	22,00
UNF 1/2 x 20	38 x 10	24222	34,50
UNF 9/16 x 18	38 x 10	24224	34,50
UNF 5/8 x 18	45 x 14	24226	44,00
UNF 3/4 x 16	45 x 14	24230	44,00
UNF 7/8 x 14	55 x 16	24234	64,00
UNF 1" x 12	55 x 16	24238	64,00

Application:

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

Applicazione:

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

Round Dies, *Left Hand*
Pipe-thread DIN ISO 228

Filiere tonde, *filetto sinistro*
filettatura per tubi gas DIN ISO 228

DIN 5158 (DIN EN 24231) HSS

G (BSP)

Nominal Diameter	Width across flats mm	Art.-No.	€
G 1/8 x 28	30 x 11	25212	27,00
G 1/4 x 19	38 x 10	25214	31,00
G 3/8 x 19	45 x 14	25216	45,00
G 1/2 x 14	45 x 14	25218	45,00
G 5/8 x 14	55 x 16	25220	60,70
G 3/4 x 14	55 x 16	25222	76,00
G 7/8 x 14	65 x 18	25224	83,00
G 1" x 11	65 x 18	25226	83,00
G 1.1/8 x 11	75 x 20	25230	102,00
G 1.1/4 x 11	75 x 20	25234	102,00
G 1.3/8 x 11	90 x 22	25238	161,00
G 1.1/2 x 11	90 x 22	25242	161,00
G 1.5/8 x 11	90 x 22	25246	161,00
G 1.3/4 x 11	105 x 22	25250	298,00
G 2" x 11	105 x 22	25254	298,00

Application:

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

Applicazione:

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

VÖLKEL THREADING SOLUTIONS

Hexagon Die Nuts
metric ISO-thread DIN 13

Filiere esagonali
filettatura metrica ISO DIN 13

DIN 382 HSS Tol. 6g

M

Nominal Diameter mm	Width across flats mm	Art.-No.	€
M 3 x 0.5	19 x 5	27126	9,80
M 3.5 x 0.6	19 x 5	27128	9,80
M 4 x 0.7	19 x 5	27130	9,80
M 5 x 0.8	19 x 7	27134	9,80
M 6 x 1.0	19 x 7	27138	9,80
M 7 x 1.0	22 x 9	27140	10,50
M 8 x 1.25	22 x 9	27142	10,50
M 9 x 1.25	22 x 9	27144	10,50
M 10 x 1.5	27 x 11	27146	12,40
M 11 x 1.5	27 x 11	27148	12,40
M 12 x 1.75	36 x 14	27150	17,00
M 14 x 2.0	36 x 14	27154	17,00
M 16 x 2.0	41 x 18	27158	24,00
M 18 x 2.5	41 x 18	27162	24,00
M 20 x 2.5	41 x 18	27166	24,00
M 22 x 2.5	50 x 22	27170	41,00
M 24 x 3.0	50 x 22	27174	49,00
M 27 x 3.0	60 x 25	27176	75,00
M 30 x 3.5	60 x 25	27178	75,00
M 33 x 3.5	60 x 25	27180	75,00
M 36 x 4.0	60 x 25	27182	75,00
M 39 x 4.0	70 x 30	27184	124,00
M 42 x 4.5	70 x 30	27186	124,00
M 45 x 4.5	85 x 36	27188	172,00
M 48 x 5.0	85 x 36	27190	172,00
M 52 x 5.0	85 x 36	27192	172,00
M 56 x 5.5	100 x 36	27194	298,00
M 60 x 5.5	100 x 36	27196	298,00
M 64 x 6.0	100 x 36	27198	298,00
M 68 x 6.0	115 x 36	27199	390,00

Application:

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

Applicazione:

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

Hexagon Die Nuts
metric-fine ISO-thread DIN 13

Filiere esagonali
filettatura metrica fine ISO DIN 13

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

Nominal Diameter mm	Width across flats mm	Art.-No.	€
M 3 x 0.35	19 x 5	26108	19,00
M 4 x 0.35	19 x 5	26110	19,00
M 4 x 0.5	19 x 5	26112	19,00
M 5 x 0.5	19 x 5	26114	19,00
M 5 x 0.75	19 x 7	26116	19,00
M 6 x 0.5	19 x 5	26117	19,00
M 6 x 0.75	19 x 7	26118	19,00
M 7 x 0.75	22 x 9	26120	20,00
M 8 x 0.5	22 x 9	26122	20,00
M 8 x 0.75	22 x 9	26124	20,00
M 8 x 1.0	22 x 9	26126	20,00
M 9 x 0.75	22 x 9	26128	20,00
M 9 x 1.0	22 x 9	26130	20,00
M 10 x 0.75	27 x 11	26132	20,00
M 10 x 1.0	27 x 11	26136	20,00
M 10 x 1.25	27 x 11	26138	20,00
M 11 x 1.0	27 x 11	26140	28,00
M 11 x 1.25	27 x 11	26142	28,00
M 12 x 0.75	36 x 10	26143	28,00
M 12 x 1.0	36 x 10	26144	28,00
M 12 x 1.25	36 x 10	26146	28,00
M 12 x 1.5	36 x 10	26148	28,00
M 13 x 1.0	36 x 10	26150	32,00
M 13 x 1.5	36 x 10	26151	32,00
M 14 x 0.75	36 x 10	26152	32,00
M 14 x 1.0	36 x 10	26153	32,00
M 14 x 1.25	36 x 10	26154	32,00
M 14 x 1.5	36 x 10	26156	32,00
M 15 x 1.0	36 x 10	26158	38,00
M 15 x 1.5	36 x 10	26160	38,00
M 16 x 1.0	41 x 14	26162	39,00
M 16 x 1.25	41 x 14	26164	39,00
M 16 x 1.5	41 x 14	26166	39,00
M 18 x 1.0	41 x 14	26170	41,00
M 18 x 1.25	41 x 14	26171	41,00
M 18 x 1.5	41 x 14	26172	41,00
M 18 x 2.0	41 x 14	26174	41,00
M 20 x 1.0	41 x 14	26178	41,00
M 20 x 1.25	41 x 14	26180	41,00
M 20 x 1.5	41 x 14	26184	41,00
M 20 x 2.0	41 x 14	26186	41,00
M 21 x 1.5	41 x 14	26188	60,00
M 22 x 1.0	50 x 16	26190	60,00
M 22 x 1.25	50 x 16	26192	60,00
M 22 x 1.5	50 x 16	26194	60,00
M 22 x 2.0	50 x 16	26196	60,00
M 23 x 1.5	50 x 16	26198	60,00
M 24 x 1.0	50 x 16	26700	60,00
M 24 x 1.25	50 x 16	26702	60,00
M 24 x 1.5	50 x 16	26704	60,00

VÖLKEL THREADING SOLUTIONS

Hexagon Die Nuts
metric-fine ISO-thread DIN 13

Filiere esagonali
filettatura metrica fine ISO DIN 13

DIN 382 HSS Tol. 6g Mf

Nominal Diameter mm	Width across flats mm	Art.-No.	€
M 24 x 2.0	50 x 16	26706	60,00
M 25 x 1.0	50 x 16	26707	87,00
M 25 x 1.5	50 x 16	26708	87,00
M 26 x 1.0	50 x 16	26710	87,00
M 26 x 1.5	50 x 16	26712	87,00
M 26 x 2.0	50 x 16	26714	87,00
M 27 x 1.0	60 x 18	26717	90,00
M 27 x 1.5	60 x 18	26716	90,00
M 27 x 2.0	60 x 18	26718	90,00
M 28 x 1.0	60 x 18	26720	90,00
M 28 x 1.5	60 x 18	26722	90,00
M 28 x 2.0	60 x 18	26724	90,00
M 29 x 1.5	60 x 18	26726	90,00
M 30 x 1.0	60 x 18	26728	90,00
M 30 x 1.5	60 x 18	26730	90,00
M 30 x 2.0	60 x 18	26732	90,00
M 30 x 3.0	60 x 25	26734	90,00
M 32 x 1.5	60 x 18	26736	90,00
M 32 x 2.0	60 x 18	26735	90,00
M 32 x 3.0	60 x 25	26737	90,00
M 33 x 1.5	60 x 18	26738	90,00
M 33 x 2.0	60 x 18	26740	90,00
M 33 x 3.0	60 x 25	26742	90,00
M 34 x 1.5	60 x 18	26744	90,00
M 34 x 2.0	60 x 18	26746	90,00
M 35 x 1.5	60 x 18	26748	90,00
M 36 x 1.5	60 x 18	26750	90,00
M 36 x 2.0	60 x 18	26752	90,00
M 36 x 3.0	60 x 25	26754	90,00
M 38 x 1.5	70 x 20	26756	150,00
M 39 x 1.5	70 x 20	26758	150,00
M 39 x 2.0	70 x 20	26760	150,00
M 39 x 3.0	70 x 30	26762	150,00
M 40 x 1.5	70 x 20	26764	150,00
M 40 x 2.0	70 x 20	26766	150,00
M 40 x 3.0	70 x 30	26768	150,00
M 42 x 1.5	70 x 20	26770	150,00
M 42 x 2.0	70 x 20	26772	150,00
M 42 x 3.0	70 x 30	26774	150,00
M 45 x 1.5	85 x 22	26776	220,00
M 45 x 2.0	85 x 22	26778	220,00
M 45 x 3.0	85 x 36	26780	220,00
M 48 x 1.5	85 x 22	26782	220,00
M 48 x 2.0	85 x 22	26784	220,00
M 48 x 3.0	85 x 36	26786	220,00
M 50 x 1.5	85 x 22	26788	220,00
M 50 x 2.0	85 x 22	26790	220,00
M 50 x 3.0	85 x 36	26792	220,00
M 52 x 1.5	85 x 22	26794	220,00
M 52 x 2.0	85 x 22	26796	220,00
M 52 x 3.0	85 x 36	26798	220,00

Hexagon Die Nuts
Whitworth-thread BS 84

Filiere esagonali
filettatura Whitworth BS 84

DIN 382 HSS

BSW / BSF

Nominal Diameter mm	Width across flats mm	Art.-No.	€
BSW			
BSW 1/8 x 40	19 x 5	22106	12,50
BSW 3/16 x 24	19 x 7	22110	12,50
BSW 1/4 x 20	19 x 7	22114	12,50
BSW 5/16 x 18	22 x 9	22116	13,00
BSW 3/8 x 16	27 x 11	22118	15,50
BSW 7/16 x 14	27 x 11	22120	15,50
BSW 1/2 x 12	36 x 14	22122	19,00
BSW 9/16 x 12	36 x 14	22124	19,00
BSW 5/8 x 11	41 x 18	22126	26,00
BSW 3/4 x 10	41 x 18	22130	26,00
BSW 7/8 x 9	50 x 22	22134	54,00
BSW 1" x 8	50 x 22	22138	54,00
BSW 1.1/8 x 7	60 x 25	22142	82,00
BSW 1.1/4 x 7	60 x 25	22146	82,00
BSW 1.3/8 x 6	60 x 25	22150	82,00
BSW 1.1/2 x 6	70 x 30	22154	98,00
BSW 2" x 4.1/2	85 x 36	22170	128,00
BSW 2.1/4 x 4	100 x 36	22172	450,00
BSW 2.1/2 x 4	115 x 36	22174	450,00
BSW 2.3/4 x 3.1/2	115 x 36	22176	560,00
BSW 3" x 3.1/2	115 x 36	22178	560,00
BSF			
BSF 3/16 x 32	19 x 7	22510	14,00
BSF 1/4 x 26	19 x 7	22514	14,00
BSF 5/16 x 22	22 x 9	22516	15,50
BSF 3/8 x 20	27 x 11	22518	19,00
BSF 7/16 x 18	27 x 11	22520	19,00
BSF 1/2 x 16	36 x 10	22522	30,00
BSF 9/16 x 16	36 x 10	22524	30,00
BSF 5/8 x 14	41 x 14	22526	46,00
BSF 3/4 x 12	41 x 14	22530	46,00
BSF 7/8 x 11	50 x 16	22534	54,00
BSF 1" x 10	50 x 16	22538	54,00

Application:

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

Applicazione:

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

VÖLKEL
THREADING SOLUTIONS

Hexagon Die Nuts
Whitworth-thread BS 84

Filiere esagonali
filettatura unificata ANSI B1.1

DIN 382 HSS

UNC / UNF

Nominal Diameter	Width across flats mm	Art.-No.	€
UNC			
UNC 1/4 x 20	19 x 7	23114	12,50
UNC 5/16 x 18	22 x 9	23116	13,00
UNC 3/8 x 16	27 x 11	23118	15,50
UNC 7/16 x 14	27 x 11	23120	15,50
UNC 1/2 x 13	36 x 14	23122	19,00
UNC 9/16 x 12	36 x 14	23124	19,00
UNC 5/8 x 11	41 x 18	23126	26,00
UNC 3/4 x 10	41 x 18	23130	26,00
UNC 7/8 x 9	50 x 22	23134	54,00
UNC 1" x 8	50 x 22	23138	54,00
UNC 1.1/8 x 7	60 x 25	23142	82,00
UNC 1.1/4 x 7	60 x 25	23146	82,00
UNC 1.3/8 x 6	60 x 25	23150	82,00
UNC 1.1/2 x 6	70 x 30	23154	98,00
UNF			
UNF 1/4 x 28	19 x 7	24114	12,50
UNF 5/16 x 24	22 x 9	24116	13,00
UNF 3/8 x 24	27 x 11	24118	15,50
UNF 7/16 x 20	27 x 11	24120	15,50
UNF 1/2 x 20	36 x 10	24122	19,00
UNF 9/16 x 18	36 x 10	24124	19,00
UNF 5/8 x 18	41 x 14	24126	26,00
UNF 3/4 x 16	41 x 14	24130	26,00
UNF 7/8 x 14	50 x 16	24134	54,00
UNF 1" x 12	50 x 16	24138	54,00
UNF 1.1/8 x 12	60 x 18	24142	82,00
UNF 1.1/4 x 12	60 x 18	24146	82,00
UNF 1.3/8 x 12	60 x 18	24150	82,00
UNF 1.1/2 x 12	70 x 20	24154	98,00

Application:

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

Applicazione:

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

Hexagon Die Nuts
Unified thread ANSI B 1.1

Filiere esagonali
filettatura unificata ANSI B1.1

DIN 382 HSS Tol. 2B 8-UN

Nominal Diameter	Width across flats mm	Art.-No.	€
UN 1.1/8 x 8	60 x 25	24171	82,00
UN 1.1/4 x 8	60 x 25	24172	82,00
UN 1.3/8 x 8	60 x 25	24173	82,00
UN 1.1/2 x 8	70 x 30	24174	150,00
UN 1.5/8 x 8	70 x 30	24175	150,00
UN 1.3/4 x 8	85 x 36	24176	150,00
UN 1.7/8 x 8	85 x 22	24177	150,00
UN 2" x 8	85 x 22	24178	150,00
UN 2.1/8 x 8	85 x 22	24179	254,00
UN 2.1/4 x 8	100 x 22	24180	254,00
UN 2.1/2 x 8	115 x 22	24181	380,00

Application:

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

Applicazione:

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

Hexagon Die Nuts
Pipe-thread DIN ISO 228

Filiere esagonali
filettatura per tubi gas DIN ISO 228

DIN 382 HSS

G (BSP)

Nominal Diameter	Width across flats mm	Art.-No.	€
G 1/8 x 28	27 x 11	25512	17,80
G 1/4 x 19	36 x 10	25514	20,70
G 3/8 x 19	41 x 14	25516	30,60
G 1/2 x 14	41 x 14	25518	30,60
G 5/8 x 14	50 x 16	25520	51,00
G 3/4 x 14	50 x 16	25522	51,00
G 7/8 x 14	60 x 18	25524	69,00
G 1" x 11	60 x 18	25526	69,00
G 1.1/8 x 11	70 x 20	25530	102,00
G 1.1/4 x 11	70 x 20	25534	102,00
G 1.3/8 x 11	85 x 22	25538	169,00
G 1.1/2 x 11	85 x 22	25542	169,00
G 1.5/8 x 11	85 x 22	25546	169,00
G 1.3/4 x 11	100 x 22	25550	254,00
G 2" x 11	100 x 22	25554	254,00

Application:

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

Applicazione:

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

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

Filiere esagonali
rfilettatura conica per tubi, cono 1:16

DIN 382 **HSS**

R (BSPT)

Nominal Diameter	Width across flats mm	Art.-No.	€
R 1/8 x 28	27 x 11	23562	37,00
R 1/4 x 19	36 x 14	23564	45,00
R 3/8 x 19	41 x 15	23566	57,00
R 1/2 x 14	50 x 19	23568	57,00
R 3/4 x 14	60 x 20	23572	90,00
R 1" x 11	60 x 25	23576	134,00
R 1.1/4 x 11	85 x 26	23578	159,00
R 1.1/2 x 11	85 x 26	23580	258,00
R 2" x 11	100 x 31	23584	346,00

Application:

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

Applicazione:

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

VÖLKEL
THREADING SOLUTIONS

Hexagon Die Nuts
american tapered pipe thread, taper 1:16

Filiere esagonali
filettatura americana conica per tubi, cono 1:16

DIN 382 HSS NPT

Nominal Diameter	Width across flats mm	Art.-No.	€
NPT 1/16 x 27	22 x 9	23510	34,50
NPT 1/8 x 27	27 x 11	23512	37,00
NPT 1/4 x 18	36 x 14	23514	45,00
NPT 3/8 x 18	41 x 14	23516	57,00
NPT 1/2 x 14	50 x 16	23518	57,00
NPT 3/4 x 14	60 x 18	23522	90,00
NPT 1" x 11.5	60 x 25	23526	134,00
NPT 1.1/4 x 11.5	70 x 25	23528	159,00
NPT 1.1/2 x 11.5	85 x 28	23530	258,00
NPT 2" x 11.5	100 x 28	23534	346,00

Application:

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

Applicazione:

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

Hexagon Die Nuts, *Left Hand*

metric ISO-thread DIN 13

Filiere esagonali, *filetto sinistro*

filettatura metrica ISO DIN 13

DIN 382 HSS

M

Nominal Diameter	Width across flats mm	Art.-No.	€
M 3 x 0.5	19 x 5	28426	11,50
M 4 x 0.7	19 x 5	28430	11,50
M 5 x 0.8	19 x 7	28434	12,80
M 6 x 1.0	19 x 7	28438	12,80
M 8 x 1.25	22 x 9	28442	14,00
M 10 x 1.5	27 x 11	28446	19,70
M 12 x 1.75	36 x 14	28450	30,00
M 14 x 2.0	36 x 14	28454	30,00
M 16 x 2.0	41 x 18	28458	47,00
M 18 x 2.5	41 x 18	28462	47,00
M 20 x 2.5	41 x 18	28466	47,00
M 22 x 2.5	50 x 22	28470	63,00
M 24 x 3.0	50 x 22	28474	63,00
M 27 x 3.0	60 x 25	28476	97,00
M 30 x 3.5	60 x 25	28478	97,00
M 33 x 3.5	60 x 25	28480	97,00
M 36 x 4.0	60 x 25	28482	97,00
M 39 x 4.0	70 x 30	28484	162,00
M 42 x 4.5	70 x 30	28486	162,00
M 45 x 4.5	85 x 36	28488	229,00
M 48 x 5.0	85 x 36	28490	229,00
M 52 x 5.0	85 x 36	28492	229,00

Application:

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

Applicazione:

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

VÖLKEL
THREADING SOLUTIONS

Hexagon Die Nuts, *Left Hand*

Pipe-thread DIN ISO 228

Filiere esagonali, *filetto sinistro*

filettatura per tubi gas DIN ISO 228

DIN 382 HSS

G (BSP)

Nominal Diameter	Width across flats mm	Art.-No.	€
G 1/8 x 28	27 x 11	25612	30,00
G 1/4 x 19	36 x 10	25614	34,00
G 3/8 x 19	41 x 14	25616	50,00
G 1/2 x 14	41 x 14	25618	50,00
G 5/8 x 14	50 x 16	25620	67,00
G 3/4 x 14	50 x 16	25622	67,00
G 1" x 11	60 x 18	25626	86,00
G 1.1/8 x 11	70 x 20	25630	133,00
G 1.1/4 x 11	70 x 20	25634	133,00
G 1.3/8 x 11	85 x 22	25638	220,00
G 1.1/2 x 11	85 x 22	25642	220,00
G 1.3/4 x 11	100 x 22	25650	330,00
G 2" x 11	100 x 22	25654	330,00

Application:

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

Applicazione:

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

SETS
ASSORTIMENTO

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

HexTap Sets
in wooden boxes

Assortimento HexTap
in cassetta di legna

	Art.-No	€
M		
M 3-4-5-6-8-10-12-14-16-18-20	48601	143,00
M 3-4-5-6-8-10-12-14-16-18-20-22-24	48602	220,00
M 3-4-5-6-8-10-12-14-16-18-20-22-24-27-30	48603	340,00
Mf		
M 4x0.5 - 5x0.5 - 6x0.75 - 8x0.75 - 8x1 - 10x1 M 12x1 - 12x1.5 - 14x1.25 - 14x1.5 - 16x1.5 M 18x1.5 - M 20x1.5	48605	196,00
M 4x0.5 - 5x0.5 - 6x0.75 - 8x0.75 - 8x1 - 10x1 M 12x1 - 12x1.5 - 14x1.25 - 14x1.5 - 16x1.5 M 18x1.5 - M 20x1.5 - 22x1.5 - 24x1. 5	48606	288,00
G (BSP)		
G 1/8 - 1/4 - 3/8 - 1/2 - 3/4 - 1"	48608	185,00
G 1/8 - 1/4 - 3/8 - 1/2 - 3/4 - 1" - 1.1/4 - 1.1/2	48609	427,00

HexTap Sets
in wooden boxes

Assortimento HexTap
in cassetta di legna

	Art.-No	€
M		
M 3-4-5-6-8-10-12-14-16-18-20	48621	277,00
M 3-4-5-6-8-10-12-14-16-18-20-22-24	48622	405,00
M 3-4-5-6-8-10-12-14-16-18-20-22-24-27-30	48623	635,00
Mf		
M 4x0.5 - 5x0.5 - 6x0.75 - 8x0.75 - 8x1 - 10x1 M 12x1 - 12x1.5 - 14x1.25 - 14x1.5 - 16x1.5 M 18x1.5 - M 20x1.5	48625	390,00
M 4x0.5 - 5x0.5 - 6x0.75 - 8x0.75 - 8x1 - 10x1 M 12x1 - 12x1.5 - 14x1.25 - 14x1.5 - 16x1.5 M 18x1.5 - M 20x1.5 - 22x1.5 - 24x1.5	48626	533,00
G (BSP)		
G 1/8 - 1/4 - 3/8 - 1/2 - 3/4 - 1"	48628	346,00
G 1/8 - 1/4 - 3/8 - 1/2 - 3/4 - 1" - 1.1/4 - 1.1/2	48629	798,00

HexTap Sets
in wooden boxes

Assortimento HexTap
in cassetta di legna

	Art.-No	€
M		
M 3-4-5-6-8-10-12-14-16-18-20	48641	312,00
M 3-4-5-6-8-10-12-14-16-18-20-22-24	48642	455,00
M 3-4-5-6-8-10-12-14-16-18-20-22-24-27-30	48643	692,00
Mf		
M 4x0.5 - 5x0.5 - 6x0.75 - 8x0.75 - 8x1 - 10x1 M 12x1 - 12x1.5 - 14x1.25 - 14x1.5 - 16x1.5 M 18x1.5 - M 20x1.5	48645	418,00
M 4x0.5 - 5x0.5 - 6x0.75 - 8x0.75 - 8x1 - 10x1 M 12x1 - 12x1.5 - 14x1.25 - 14x1.5 - 16x1.5 M 18x1.5 - M 20x1.5 - 22x1.5 - 24x1.5	48646	594,00
G (BSP)		
G 1/8 - 1/4 - 3/8 - 1/2 - 3/4 - 1"	48648	381,00
G 1/8 - 1/4 - 3/8 - 1/2 - 3/4 - 1" - 1.1/4 - 1.1/2	48649	860,00

Tap & Die Sets
in metal cases
DIN standards

Utensili per filettare in assortimento
in cassetta metallica
versione DIN

						Art.-No	€
M							
M 1-1.2-1.4-1.7-2.0-2.3-2.6 M 3-3.5-4-5-6-8-10	No. 0 No. 1	16 x 5 25 x 9	20 x 5 30 x 11	20 x 7	No. 1	48002	345,00
M 3-4-5-6-7-8-9-10-11-12	No. 1 + 2	20 x 5 30 x 11	20 x 7 38 x 14	25 x 9	No. 1	48003	320,00
M 5-6-7-8-9-10-11-12	No. 1 + 2	20 x 7 30 x 11	25 x 9 38 x 14		No. 1	48004	294,00
M 5-6-7-8-9-10-11-12-14-16 M 18-20	No. 1 + 3	20 x 7 38 x 14	25 x 9 45 x 18	30 x 11		48005	483,00
M 3-4-5-6-8-10-12-14-16-18-20 M 22-24	No. 1 + 4	20 x 5 30 x 11 55 x 22	20 x 7 38 x 14	25 x 9 45 x 18		48006	654,00
M 5-6-8-10-12-14-16-18-20-22 M 24-27-30	No. 1 No. 3 + 5	20 x 7 38 x 14 65 x 25	25 x 9 45 x 18	30 x 11 55 x 22		48007	1.150,00
Mf							
Mf 3 x 0.35-4 x 0.5-5 x 0.5 Mf 6 x 0.75-8 x 0.75-8 x 1.0 Mf 10 x 1.0-12 x 1.5	No. 1 + 2	20 x 5 38 x 10	25 x 9	30 x 11	No. 1	48010	250,00
Mf 6 x 0.75-8 x 0.75-8 x 1.0-10 x 1.0 Mf 12 x 1.0-12 x 1.5-14 x 1.25-14 x 1.5 Mf 16 x 1.5-18 x 1.5-20 x 1.5	No. 1 + 3	20 x 7 38 x 10	25 x 9 45 x14	30 x 11		48011	440,00
Mf 6 x 0.75-8 x 0.75-8 x 1.0-10 x 1.0 Mf 12 x 1.0-12 x 1.5-14 x 1.25-14 x 1.5 Mf 16 x 1.5-18 x 1.5-20 x 1.5-22 x 1.5 Mf 24 x 1.5	No. 1 + 4	20 x 7 38 x 10	25 x 9 45 x 14	30 x 11 55 x 16		48012	635,00

VÖLKEL
THREADING SOLUTIONS

Tap & Die Sets
in metal cases
DIN standards

Utensili per filettare in assortimento
in cassetta metallica
versione DIN

						Art.-No	€
G (BSP)							
G 1/8-1/4-3/8-1/2-3/4-1"	No. 1 + 3 + 5	30 x 11 55 x 16	38 x 10 65 x 18	45 x 14		48020	540,00
G 1/8-1/4-3/8-1/2-5/8-3/4-7/8-1"	No. 1 + 3 + 5	30 x 11 55 x 16	38 x 10 65 x 18	45 x 14		48021	724,00
G 1/4-3/8-1/2-3/4-1"-1.1/4-1.1/2	No. 2 + 4 + 7	38 x 10 65 x 18	45 x 14 75 x 20	55 x 16 90 x 22		48022	1.454,00
BSW							
BSW 1/8-3/16-1/4-5/16-3/8-7/16-1/2	No. 1 + 2	20 x 5 30 x 11	20 x 7 38 x 14	25 x 9	No. 1	48030	280,00
BSW 1/4-5/16-3/8-7/16-1/2	No. 1 + 2	20 x 7 38 x 14	25 x 9	30 x 11	No. 1	48031	236,00
BSW 1/4-5/16-3/8-7/16-1/2-5/8-3/4	No. 1 + 3	20 x 7 38 x 14	25 x 9 45 x 18	30 x 11		48032	415,00
BSW 1/4-5/16-3/8-7/16-1/2-5/8 BSW 3/4-7/8-1"	No. 1 + 4	20 x 7 38 x 14	25 x 9 45 x 18	30 x 11 55 x 22		48034	620,00
BSW 1/4-5/16-3/8-7/16-1/2-5/8-3/4 BSW 7/8-1"-1.1/8-1.1/4-1.3/8-1.1/2"	No. 1 No. 3 + 5	20 x 7 38 x 14 65 x 25	25 x 9 45 x 18	30 x 11 55 x 22		48035	1.570,00
BSF							
BSF 1/4-5/16-3/8-7/16-1/2	No. 1 + 2	20 x 7 38 x 10	25 x 9	30 x 11	No. 1	48041	230,00
BSF 1/4-5/16-3/8-7/16-1/2-5/8-3/4	No. 1 + 3	20 x 7 38 x 10	25 x 9 45 x 14	30 x 11		48042	395,00
BSF 1/4-5/16-3/8-7/16-1/2-5/8 BSF 3/4-7/8-1"	No. 1 + 4	20 x 7 38 x 10	25 x 9 45 x 14	30 x 11 55 x 16		48044	605,00
BSW / BSF							
BSW/BSF 1/4-5/16-3/8-7/16-1/2 BSW/BSF 5/8-3/4	No. 1 + 3	20 x 7 38 x 14	25 x 9 45 x 18	30 x 11		48046	670,00

Tap & Die Sets
in metal cases
DIN standards

Utensili per filettare in assortimento
in cassetta metallica
versione DIN

						Art.-No	€
NPT							
NPT 1/8-1/4-3/8-1/2-3/4-1"	No. 1 + 3 + 5	30 x 11 55 x 22	38 x 14 65 x 25	45 x 18		48025	698,00
NPT 1/8-1/4-3/8-1/2-3/4-1" NPT 1.1/4-1.1/2-2"	No. 2 + 4 + 7	30 x 11 55 x 22 90 x 36	38 x 14 65 x 25 105 x 36	45 x 18 75 x 30		48027	2.606,00
UNC							
UNC 1/4-5/16-3/8-7/16-1/2	No. 1 + 2	20 x 7 38 x 14	25 x 9	30 x 11	No. 1	48050	236,00
UNC 1/4-5/16-3/8-7/16-1/2-5/8-3/4	No. 1 + 3	20 x 7 38 x 14	25 x 9 45 x 18	30 x 11		48051	415,00
UNC 1/4-5/16-3/8-7/16-1/2-5/8 UNC 3/4-7/8-1"	No. 1 + 4	20 x 7 38 x 14	25 x 9 45 x 18	30 x 11 55 x 22		48053	620,00
UNC 1/4-5/16-3/8-7/16-1/2-5/8-3/4 UNC 7/8-1"-1.1/8-1.1/4-1.3/8-1.1/2"	No. 1 No. 3 + 5	20 x 7 38 x 14 65 x 25	25 x 9 45 x 18	30 x 11 55 x 22		48054	1.570,00
UNF							
UNF 1/4-5/16-3/8-7/16-1/2	No. 1 + 2	20 x 7 38 x 10	25 x 9	30 x 11	No. 1	48060	218,00
UNF 1/4-5/16-3/8-7/16-1/2-5/8-3/4	No. 1 + 3	20 x 7 38 x 10	25 x 9 45 x 14	30 x 11		48061	365,00
UNF 1/4-5/16-3/8-7/16-1/2-5/8 UNF 3/4-7/8-1"	No. 1 + 4	20 x 7 38 x 10	25 x 9 45 x 14	30 x 11 55 x 16		48063	551,00
UNC / UNF							
UNC/UNF 1/4-5/16-3/8-7/16-1/2 UNC/UNF 5/8-3/4	No. 1 + 3	20 x 7 38 x 14	25 x 9 45 x 18	30 x 11		48066	670,00

Tap & Die Sets
in metal cases
DIN standards

Utensili per filettare in assortimento
in cassetta metallica
versione DIN

Hand Taps DIN 352
in sets of 3 pieces
Round Dies DIN 223

Maschi a mano DIN 352
Serie 3 pezzi
Filiere tonde DIN 223

								Art.-No	€
P.V.1 drilbox	M 3-4-5-6-8 M 10-12	2.5/3.3/4.2/5.0 6.8/8.5/10.2 mm	No. 1 No. 2	20 x 5 30 x 11	20 x 7 38 x 14	25 x 9	No. 1	49101	170,00
drilbox	M 3-4-5-6-8 M 10-12		No. 1 No. 2	20 x 5 30 x 11	20 x 7 38 x 14	25 x 9		49107	154,00
HSSE drilbox	M 3-4-5-6-8 M 10-12	2.5/3.3/4.2/5.0 6.8/8.5/10.2 mm	No. 1 No. 2	20 x 5 30 x 11	20 x 7 38 x 14	25 x 9	No. 1	49151	252,00
LH drilbox	M 3-4-5-6-8 M 10-12	2.5/3.3/4.2/5.0 6.8/8.5/10.2 mm	No. 1 No. 2	20 x 5 30 x 11	20 x 7 38 x 14	25 x 9	No. 1	49171	248,00
	M 3-4-5-6-8 M 10-12	2.5/3.3/4.2/5.0 6.8/8.5/10.2 mm	No. 1 No. 2	20 x 5 30 x 11	20 x 7 38 x 14	25 x 9		49111	140,00

Tap & Die Sets
in metal cases
DIN standards

Utensili per filettare in assortimento
in cassetta metallica
versione DIN

F.Z. 1
Hand Taps DIN 352, HSSE
Rougher piloted
Round Dies DIN 223, HSSE
+ 7 Guides for Round Dies

Maschi a mano DIN 352, HSSE
Sgrossatore con guida
Filiere DIN 223, HSSE
+ 7 guida per filiera

S.F. 1
Hand Taps DIN 352, HSS-G
Round Dies DIN 223, HSS
+ 7 Guides for Round Dies

Maschi a mano DIN 352, HSS-G
Filiere DIN 223, HSS
+ 7 guida per filiera

								Art.-No	€
F.Z.1	M 3-4-5-6-8	2.5/3.3/4.2/5.0	No. 1	20 x 5	20 x 7	25 x 9	No. 1	49150	258,00
drilbox	M 10-12	6.8/8.5/10.2 mm	No. 2	30 x 11	38 x 14				
S.F.1	M 3-4-5-6-8	2.5/3.3/4.2/5.0	No. 1	20 x 5	20 x 7	25 x 9	No. 1	49106	187,00
drilbox	M 10-12	6.8/8.5/10.2 mm	No. 2	30 x 11	38 x 14				

VÖLKEL
THREADING SOLUTIONS

Tap & Die Sets
in metal cases
DIN standards

Utensili per filettare in assortimento
in cassetta metallica
versione DIN

Hand Taps DIN 352
in sets of 3 pieces
Round Dies DIN 223

Maschi a mano DIN 352
Serie 3 pezzi
Filiere tonde DIN 223

							Art.-No	€
P.V.2	M 3-4-5-6-8-10-12-14 M 16-18-20	No. 1 No. 3	20 x 5 30 x 11	20 x 7 38 x 14	25 x 9 45 x 18	No. 1 No. 2	49201	310,00
HSSE drilbox	M 3-4-5-6-8-10-12-14 M 16-18-20	No. 1 No. 3	20 x 5 30 x 11	20 x 7 38 x 14	25 x 9 45 x 18		49251	588,00
LH drilbox	M 3-4-5-6-8-10-12-14 M 16-18-20	No. 1 No. 3	20 x 5 30 x 11	20 x 7 38 x 14	25 x 9 45 x 18		49271	530,00
P.V.3	M 5-6-8-10-12-14 M 16-18-20	No. 1 No. 3	20 x 7 38 x 14	25 x 9 45 x 18	30 x 11	No. 1 No. 2	49301	309,00
P.V.5 drilbox	M 3-4-5-6-8-10-12-14 M 16-18-20	No. 1 No. 3	20 x 5 30 x 11	20 x 7 38 x 14	25 x 9 45 x 18		49205	370,00

Tap & Die Sets
in metal cases

Utensili per filettare in assortimento
in cassetta metallica

Hand Taps DIN 352
in sets of 3 pieces

Maschi a mano DIN 352
Serie 3 pezzi

					Art.-No	€
P.V.22	M 3-4-5-6-8 M 10-12	2.5/3.3/4.2/5.0 6.8/8.5/10.2 mm	No. 1.1/2		49510	90,00
P.V.23	M 3-4-5-6-8 M 10-12	2.5/3.3/4.2/5.0 6.8/8.5/10.2 mm	No. 1.1/2	No. 1	49511	97,00

Hand Taps DIN 352
in sets of 3 pieces
Round Dies 25 x 9 mm ø

Maschi a mano DIN 352
Serie 3 pezzi
Filiere tonde 25 x 9 ø

					Art.-No	€
P.V.12	M 3-4-5-6-8-10-12	No. 1.1/2	25 x 9	No. 1	49501	103,00
P.V.15 drilbox	M 3-4-5-6-8-10-12	No. 1.1/2	25 x 9	No. 1	49505	115,00

Die Sets
in metal cases
DIN standards

Utensili per filettare in assortimento
in cassetta metallica
versione DIN

				Art.-No	€
P.V.97		M 3-4-5-6-8-10-12		49521	66,00
P.V.98	***HSSE***	M 3-4-5-6-8-10-12		49522	86,00
P.V.99			M 3-4-5-6-8-10-12	49520	77,00
			UNC 1/4-5/16-3/8-7/16-1/2	49530	105,00
			UNF 1/4-5/16-3/8-7/16-1/2	49540	105,00
P.V.92	o/d 25x9	M 3-4-5-6-8-10-12		49525	45,00

Round Dies DIN 223
+ 7 Guides

Filiere tonde DIN 223
+ 7 guida per filiera

					Art.-No	€
P.V.14	M 3-4-5-6-8-10-12	20 x 5 30 x 11	20 x 7 38 x 14	25 x 9	49599	75,00
LH	M 3-4-5-6-8-10-12	20 x 5 30 x 11	20 x 7 38 x 14	25 x 9	49598	101,00

Tap Sets
in plastic boxes
DIN standards

Utensili per filettare in assortimento
in cassetta di plastica
versione DIN

Hand Taps DIN 352
in sets of 3 pieces

Maschi a mano DIN 352
Serie 3 pezzi

				Art.-No	€
P.K.20	M 3-4-5-6-8-10-12	No. 1.1/2		47001	69,00
P.K.21	M 3-4-5-6-8-10-12	No. 1.1/2	No. 1	47005	77,00
HSSE	M 3-4-5-6-8-10-12	No. 1.1/2	No. 1	47055	120,00
LH	M 3-4-5-6-8-10-12	No. 1.1/2	No. 1	47075	107,00

Short Machine Taps DIN 352,
Spiral Point

Maschi a macchina corti DIN 352/B
con imbocco corretto

					Art.-No	€
P.K.25	M 3-4-5-6-8 M 10-12	2.5/3.3/4.2/5.0 6.8/8.5/10.2 mm	No. 1.1/2	No. 1	47605	55,00
P.K.26	M 3-4-5-6-8 M 10-12	2.5/3.3/4.2/5.0 6.8/8.5/10.2 mm	No. 1.1/2		47601	49,00

VÖLKEL
THREADING SOLUTIONS

Tap & Die Sets
in plastic box
ISO standards

Utensili per filettare in assortimento
in cassetta di plastica

Machine Taps ISO 529
Spiral Point (Form B)

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

			Art.-No	€
P.K.85	M 3-4-5-6-8-10	2.5/3.3/4.2/5.0/6.8/8.5	80501	68,00

Machine Taps ISO 529

Maschi a macchina ISO 529

		Art.-No	€
Form B	M 3-4-5-6-8-10-12	80500	39,00
Form B-AZ	M 3-4-5-6-8-10-12	80900	52,00
Form C/35°RSP	M 3-4-5-6-8-10-12	80700	45,00

Machine Tap Sets
in plastic boxes

Maschi a macchina
in cassetta di plastica

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

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

			Art.-No	€
P.K.40	M 3-4-5-6-8-10-12		47901	120,00
P.K.41	M 3-4-5-6-8-10-12	***TIN***	47921	200,00

Combined Taps ***HSSE***

Maschi combinati con punte ***HSSE***

		Art.-No	€
P.K.370	M 3-4-5-6-8-10-12	47837	126,50
P.K.700	BSW 1/8-5/32-3/16-1/4-5/16-3/8-1/2	47870	127,00

Machine Tap Sets
in plastic boxes

Maschi a macchina
in cassetta di plastica

Machine Taps ***HSSE***
Spiral Point

Maschi a macchina ***HSSE***
con imbocco corretto

				Art.-No	€
P.K.28	M 3-4-5-6-8-10-12			47815	54,00
P.K.29	M 3-4-5-6-8-10-12	***TIN***		47825	95,00
●	M 3-4-5-6-8-10-12			47853	82,00
●	M 3-4-5-6-8-10-12			47854	82,00
○	M 3-4-5-6-8-10-12			47852	90,00
P.K.35	M 3-4-5-6-8-10-12		2.5/3.3/4.2/5.0/6.8/8.5/10.2 mm	47835	64,00
P.K.36	M 3-4-5-6-8-10-12	***TIN***	2.5/3.3/4.2/5.0/6.8/8.5/10.2 mm	47836	105,00
●	M 3-4-5-6-8-10-12		2.5/3.3/4.2/5.0/6.8/8.5/10.2 mm	47856	100,00
●	M 3-4-5-6-8-10-12		2.5/3.3/4.2/5.0/6.8/8.5/10.2 mm	47857	108,00
○	M 3-4-5-6-8-10-12		2.5/3.3/4.2/5.0/6.8/8.5/10.2 mm	47855	108,00

Machine Tap Sets
in plastic boxes

Maschi a macchina
in cassetta di plastica

Machine Taps ***HSSE***
Spiral Flute

Maschi a macchina ***HSSE***
con spirale destra a 35°

				Art.-No	€
P.K.30	M 3-4-5-6-8-10-12			47817	62,50
P.K.31	M 3-4-5-6-8-10-12	***TIN***		47827	101,00
●	M 3-4-5-6-8-10-12			47863	98,00
●	M 3-4-5-6-8-10-12			47864	98,00
○	M 3-4-5-6-8-10-12			47862	108,00
P.K.47	M 3-4-5-6-8-10-12		2.5/3.3/4.2/5.0/6.8/8.5/10.2 mm	47847	74,00
P.K.48	M 3-4-5-6-8-10-12	***TIN***	2.5/3.3/4.2/5.0/6.8/8.5/10.2 mm	47848	109,00
●	M 3-4-5-6-8-10-12		2.5/3.3/4.2/5.0/6.8/8.5/10.2 mm	47866	118,00
●	M 3-4-5-6-8-10-12		2.5/3.3/4.2/5.0/6.8/8.5/10.2 mm	47867	130,00
○	M 3-4-5-6-8-10-12		2.5/3.3/4.2/5.0/6.8/8.5/10.2 mm	47865	130,00

Electrical Conduit Set
in plastic box

Assortimento per tubatura elettrica
in cassetta di plastica

			Art.-No	€
M 20x1.5 - M 25x1.25	M 20x1.5 - M 25x1.25	42 mm	18012	49,50
M 20x1.5			18002	6,80
M 25x1.5			18003	6,80

Tap Sets
in wooden boxes
DIN standards

Utensili per filettare in assortimento
in cassetta di legna
versione DIN

Hand Taps DIN 352
in sets of 3 pieces

Maschi a mano DIN 352
Serie 3 pezzi

		Art.-No	€
M 1-1.2-1.4-1.7 M 2.0-2.3-2.6	No. 0	48001	185,00

Combined-Bit-Set
in pastic box

Assortimento di maschi a macchina combinati
in cassetta di plastica

HSS-G

				Art.-No	€
M	3-4-5-6-8-10		1/4"	67200	46,00
M	3-4-5-6-8-10	***TIN***	1/4"	67209	87,00
UNC	No.8 - No.10 - No.12 - 1/4 - 5/16 - 3/8"		1/4"	67272	59,00
UNF	No.8 - No.10 - No.12 - 1/4 - 5/16 - 3/8"		1/4"	67274	59,00

Threading-Bit-Set
with Twist-Drill-Bits in plastic box

Assortimento di maschi e punte
con attacco esagonale 1/4” in cassetta di plastica

Form D M 3-10 HSS-G Tol. ISO2/6H

			Art.-No	€
M 3-4-5-6-8-10	2.5/3.3/4.2/5.0/6.8/8.5 mm	1/4"	67020	42,00

Threading-Bit-Set
in plastic box

Assortimento di maschi con attacco esagonale 1/4”
in cassetta di plastica

Form D **M 3-10** **HSS-G** **Tol. ISO2/6H**

	Art.-No	€
M 3-4-5-6-8-10	67010	28,00

Drill Bit-Set
in plastic box

Assortimento di punte con attacco esagonale 1/4”
in cassetta di plastica

1,0 - 10,0 mm **HSS-G**

	Art.-No	€
1.0 / 1.5 / 2.0 / 2.5 / 3.0 / 3.5 4.0 / 4.5 / 5.0 / 5.5 / 6.0 / 6.5 7.0 / 7.5 / 8.0 / 8.5 / 9.0 / 9.5 / 10.0	67100	56,00

Countersink-Bit-Set
in plastic box

Assortimento di frese per svasare
con attacco esagonale 1/4”, in cassetta di plastica

6,3 - 20,5 mm **HSS**

	Art.-No	€
6.3/8.3/10.4/12.4/16.5/20,5	67300	56,00

Q.C. 1

Combined Bits

Assortimento di maschi a macchina combinati

M 3 - M 10 HSS-G

		Art.-No	€
M 3-4-5-6-8-10	non-magnetic 1/4"	67421	57,00

Q.C. 2

Threading-Bits

Maschi con attacco esagonale 1/4”

M 3 - M 10 HSS-G

			Art.-No	€
M 3-4-5-6-8-10	non-magnetic 1/4"	non-magnetic 1/4"	67422	50,50

Q.C. 3

Countersink Bits

Frese per svasare
con attacco esagonale 1/4”

6,3 - 20,5 mm HSS

			Art.-No	€
6.3/8.3/10.4/12.4/16.5/20.5	non-magnetic 1/4"	non-magnetic 1/4"	67423	75,50

Q.C. 4

Drill Bits

Punte
con attacco esagonale 1/4”

3,0 - 10,0 mm HSS-G

				Art.-No	€
3.0/4.0/5.0/6.0/8.0/10.0	6 Bits: 2xPH1, 3xPH2, 1xPH3	6 Torx Bits: T10, T15, T20, T25, T30, T40	non-magnetic 1/4"	67424	37,50

Q.C. 5

WOOD Drill Bits

Punte per legna
con attacco esagonale 1/4”

3,0 - 10,0 mm HSS-G

				Art.-No	€
3.0/4.0/5.0/6.0/8.0/10.0	6 Bits: 2xPZ1, 3xPZ2, 1xPZ3	6 Torx Bits: T10, T15, T20, T25, T30, T40	magnetic 1/4"	67425	37,50

Drill Bit-Set
in plastic box

Punte con attacco esagonale 1/4”
in cassetta di plastica

3,0 - 10,0 mm HSS-G

		Art.-No	€
3.0 / 4.0 / 5.0 / 6.0 / 8.0 / 10.0	for wood / per legna 3.0 / 4.0 / 5.0 / 6.0 / 8.0 / 10,0	67101	43,00

SD 2600
Art.-No. 48926

€ 1.750,00

SD 6000
Art.-No. 48960

€ 546,00

SD 670
Art.-No. 48967

€ 725,00

SD 3000

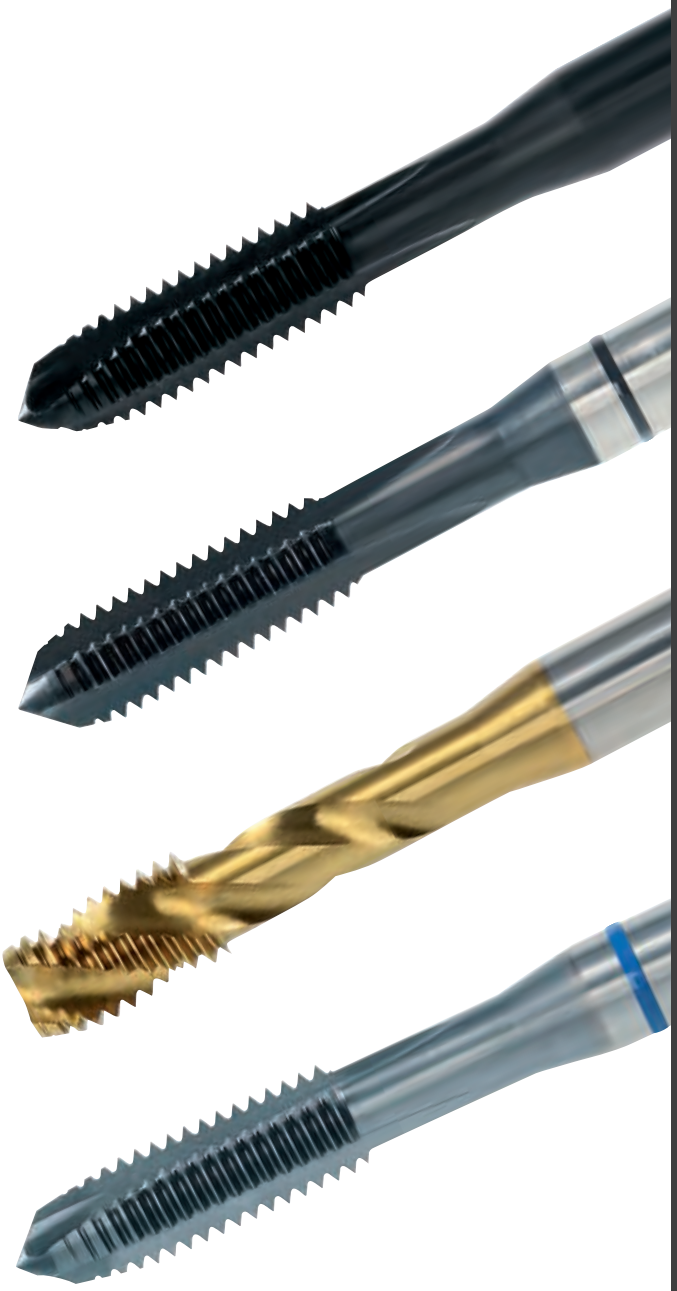
SD 672

Art.-No	Contents		€
48980	20 Sets	67200	920,00
48981	10 Sets	67200	880,00
	10 Sets	67020	
48982	10 Sets	67200	995,00
	10 Sets	67100	
48983	10 Sets	67200	1.020,00
	10 Sets	67300	

TECHNICAL INFORMATION
INFORMAZIONI TECNICHE

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

SURFACE FINISHES
ACABADOS SUPEFICIALES



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

Ogni maschi VÖLKEL e filiere VÖLKEL può essere offerto con qualsiasi rivestimento o trat-tamenti termici breve

SURFACE FINISHES
ACABADOS SUPEFICIALES

Steam Tempered:

An iron oxide film is created on the tool surface by heat treatment.
This improves the adhesion of the coolant and as a result helps to prevent cold welding of the chip to the tool surface.

Vaporizzazione

Attraverso un trattamento termico sull'utensile finito si deposita uno strato di ossido di ferro sulla superficie dell'utensile.
Questo strato migliora l'aderenza del refrigerante e del lubrificante, riducendo così il rischio di rottura del film lubrificante evitando la formazione di saldature a freddo di scorie.

Nitriding:

The surface hardness is increased by enriching the surface of the tap with nitrogen. This results in high abrasion resistance and improved anti-friction properties.

Nitrurazione

L'arricchimento della superficie del maschio con azoto permette di aumentare la durezza della superficie dell'utensile. Si ottiene altresì un miglioramento della resistenza all'abrasione e delle proprietà antifrizione.

TiN (Titanium Nitride Coating):

Following PVD processing, the tap undergoes titanium nitride vapour-deposition within the vacuum chamber at approx. 500°C. Excellent anti-friction properties and high resistance to wear and abrasion result from the reduced surface roughness and remarkable hardness.
TIN coated taps can be employed using cinsiderably faster cutting speeds.

TiN (Rivestimento al Nitruro di Titanio):

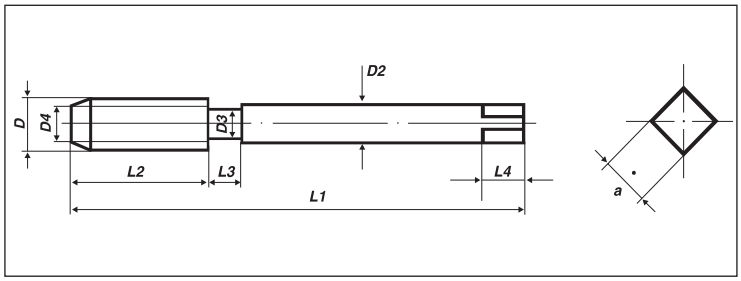
Attraverso il procedimento di metallizzazione a vuoto a 500°C ca. (PVD) viene depositato sull'utensile uno strato vaporizzato di nitrito di Titanio. La riduzione della rugosità della superficie e la durezza estrema permettono di ottenere eccellenti proprietà antifrizione e una forte resistenza all'usura e all'abrasione.
I maschi rivestiti al TiN possono essere utilizzati con velocità di taglio nettamente più elevate.

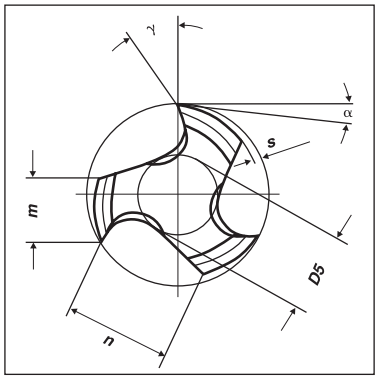
TiCN (Titanium CarboNitride Coating):

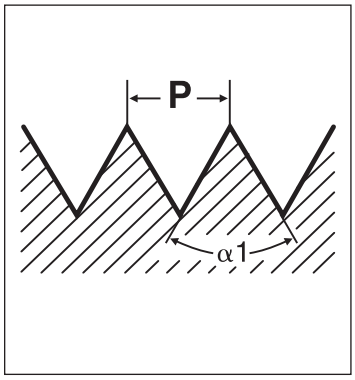
The TiCN-coating is particularly suitable for wear-resistant and abrasive material. The TiCN-coating has an hardness of 3.000 HV and thus is harder as the TiN-coating (2.600 HV). As a result the TiCN-coating has an excellent wear-resistance. Also the hardness and the toughness is higher, the heat resistance is reduced. Therefore intensive and optimum cooling is essential.

TiCN (Rivestimento con carbonitruro di titanio):

Il rivestimento TiCN è particolarmente indicato per acciai ad elevata resistenza all'abrasione e materiali altamente abrasivi. Il rivestimento TiCN ha una durezza pari a 3.000 HV quindi risulta essere più duro rispetto al rivestimento TiN (2.600 HV); ciò comporta un miglioramento della resistenza all'usura dell'utensile. Una maggiore tenacità all'abrasione è contrapposta a una minore resistenza alle elevate temperature. Perciò è fondamentale una ottima refrigerazione dell'utensile rivestito.



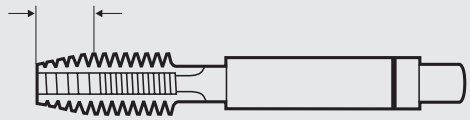




D	Nominal diameter	Diametro nominale
D2	Shank diameter	Diametro del gambo
D3	Neck diameter	Diametro dell'imbocco
D4	Point diameter	Diametro del collarino
D5	Web diameter	Diametro del nucleo
L1	Overall length	Lunghezza totale
L2	Thread length	Lunghezza filetto
L3	Neck length	Lunghezza utile
L4	Square length	Lunghezza quadro
P	Pitch	Passo
a	Square size	Quadro
m	Land width	Larghezza settore
n	Flute width	Larghezza scanalatura
s	Thread relief	Spoglia sul filetto
α	Relief angle	Angolo di spoglia sul filetto
γ	Rake angle	Angolo di taglio
α_1	Thread angle	Angolo del profilo

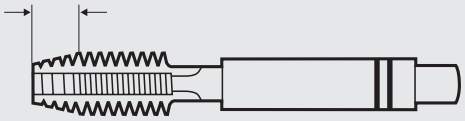
Leads of Hand Taps, Sets of 3 pcs.
Lunghezza di Imbocco – Maschi a mano, serie 3 pezzi

6-8 threads/spire



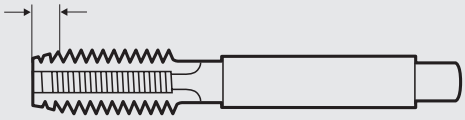
Nr. 1
Rougher, 6-8 Threads Lead
Sgrossatore, Imbocco a 6-8 spire

4-5 threads/spire



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

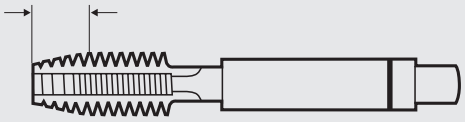
2-3 threads/spire



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

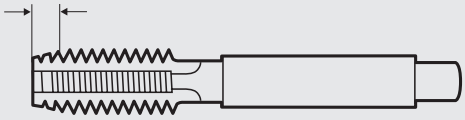
Leads of Hand Taps, Sets of 2 pcs.
Orden de los machos, juegos de 2 piezas

5-6 threads/spire

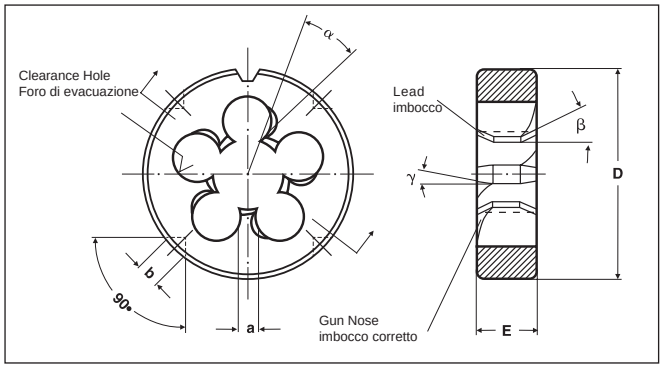


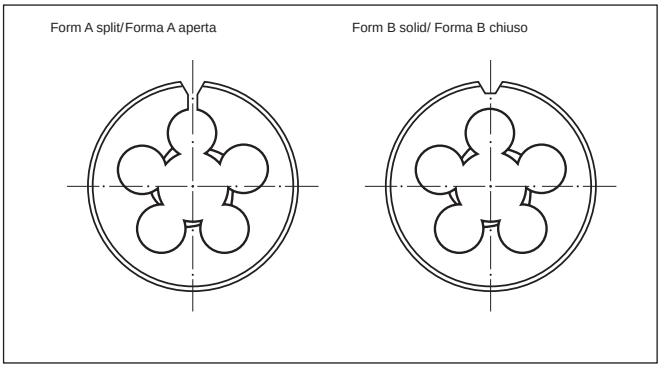
Nr. 1
Rougher, 5-6 Threads Lead
Sgrossatore, Imbocco a 6-8 spire

2-3 threads/spire



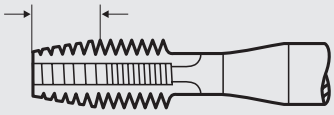
Nr. 2
Finisher, 2-3 Threads Lead
Finitore, Imbocco a 2-3 spire





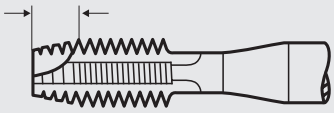
D	Outside diameter	Diametro esterno
E	Width of die	Spessore
a	Width of land	Ampiezza del dente
b	Hole for holding screws	Diametro fissaggio vite
α	Rake angle	Angolo di taglio
β	Lead angle	Angolo dell'imbocco
γ	Angle of gun nose	Angolo dell'imbocco corretto

6-8 threads/spire



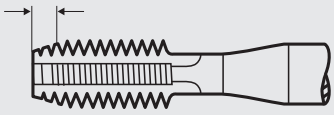
Form A
6-8 Threads Lead, for short through holes
Imbocco a 6-8 spire, per fori passanti corti

4-5 threads/spire



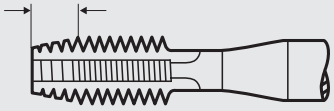
Form B
4-5 Threads Lead with Spiral Point for through holes
Imbocco a 4-5 spire con imbocco corretto, per tutti i fori passanti

2-3 threads/spire



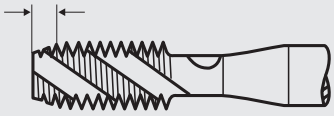
Form C
2-3 Threads Lead, for blind holes
Imbocco a 2-3 spire, per fori ciechi

4-5 threads/spire



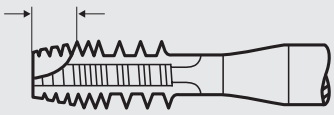
Form D
4-5 Threads Lead, for through and blind holes
Imbocco a 4-5 spire, per fori passante e ciechi

2-3 threads/spire



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

4-5 threads/spire



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

Tolerance of the tap **Classe di tolleranza del maschio** Designation according Definizione a tenore di		Tolerance of the nut thread Utilizzabile nel campo di tolleranza per la filettatura del dado	Explanation commento
DIN 802 DIN	DIN EN 22857 ISO 2857		
4H	ISO 1	4H, 5H	undersize / Fine
6H	ISO 2	4G, 5G, 6H	standard / Normale
6G	ISO 3	6G, 7H, 8H	oversize (M12x1,5 7G = ISO2/6H + 0,03 mm) tolleranza maggiorata (p.es. a M 12x1,5-6G = ca. + 0,03 mm, riferito a ISO 2/6H)
7G	./.	7G, 8G, (6E)	oversize (M12x1,5 7G = ISO2/6H + 0,06 mm) tolleranza maggiorata (p.es. a M 12x1,5-7G = ca. + 0,06 mm riferito a ISO 2/6H)
4HX	ISO 1X	4H, 5H	manufacturer tolerance for special materials (X = small oversize, 4HX ≈ ISO2/6H) Classe di tolleranza speciale per materiale speciale (X = minor tolleranza maggiorata 4 HX corrisponde ≈ ISO 2/6H)
6HX	ISO 2X	6H	manufacturer tolerance for special materials (X = small oversize, 6HX ≈ ISO3/6G) Classe di tolleranza speciale per materiale speciale (X = minor tolleranza maggiorata 6HX corrisponde ≈ ISO 3/6G)
6GX	ISO 3X	6G	manufacturer tolerance for special materials (X = small oversize, 6GX ≈ 7G) Classe di tolleranza speciale per materiale speciale (X = minor tolleranza maggiorata 6GX corrisponde ≈ 7G)
6H + 0,1	ISO 2 + 0,1	4G, 5G, 6H	+ 0,1 mm oversize for galvanic coatings and surface finishing with thickness of Layer up to 25 µm tolleranza maggiorata 0,1 mm, per strato di protezione galvanica e superficie raffinato con spessore fino 25 µm
6H + 0,2	ISO 2 + 0,2	4G, 5G, 6H	+ 0,2 mm oversize for galvanic coatings and surface finishing with thickness of Layer up to 50 µm tolleranza maggiorata 0,2 mm, per strato di protezione galvanica e superficie raffinato con spessore fino 25 µm

The required oversize of the tap with galvanic coatings depends on the thread angle.
The oversize O can be calculated with the following approach formula: O = S x F
S = thickness of the layer / F = factor depending on the thread angle a (F = 2 / sin a / 2)
tolleranza maggiorata necessaria da strato di protezione galvanica e dipendente dall'angolo del profilo
tolleranza maggiorata O può essere calcolata con la seguente formula: O = S x F
S = spessore dell rivestimento galvanico / F = fattore dipendente di angolo del profilo a (F = 2 / sin / 2)

Thread angle /Angolo del profilo	30°	47°/30'	55°	60°	80°	90°
F=	7,727	4,966	4,331	4,000	3,111	2,828

Conversion table - pitch per inch into mm
Tabella di conversione - Paso pollice in mm

P (Gg/1")	mm
100	0,254 000
96	0,264 583
80	0,317 500
72	0,352 778
64	0,396 875
60	0,423 333
56	0,453 571
48	0,529 167
44	0,577 273
40	0,635 000
36	0,705 555
32	0,793 750
28	0,907 143
27	0,940 741
26	0,976 923
25	1,016 000

P (Gg/1")	mm
24	1,058 333
22	1,154 545
20	1,270 000
19	1,336 842
18	1,411 111
16	1,587 500
14	1,814 286
13	1,953 846
12	2,116 667
11.1/2	2,208 696
11	2,309 091
10	2,540 000
9	2,822 222
8	3,175 000
7	3,628 571
6	4,233 333

P (Gg/1")	mm
5	5,080 000
4.1/2	5,644 444
4	6,350 000
3.1/2	7.257 143
3.1/4	7,815 385
3	8,466 667
2.7/8	8,834 783
2.3/4	9,236 364
2.5/8	9,676 190
2.1/2	10,160 000
2.1/4	11,288 889
2	12,700 000

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

		Rockwell			Vickers	Brinell
N/mm²	HRC	HRA	HRB	HRF	HV (≥98N)	HB 30
255	-	-	-	-	80	76
285	-	-	48	83	90	86
320	-	-	56	87	100	95
350	-	-	62	91	110	105
385	-	-	67	94	120	114
415	-	-	71	96	130	124
450	-	-	75	99	140	133
480	-	-	79	101	150	143
510	-	-	82	104	160	152
545	-	-	85	106	170	162
575	-	-	87	107	180	171
610	-	-	90	109	190	181
640	-	-	92	110	200	190
675	-	-	94	111	210	199
705	-	-	95	112	220	209
740	-	-	97	113	230	219
770	20	61	98	114	240	228
800	22	62	100	115	250	238
835	24	62	101	-	260	247
865	26	63	102	-	270	257
900	27	64	104	-	280	266
930	29	65	105	-	290	276
965	30	65	-	-	300	285
1030	32	66	-	-	320	304
1095	34	68	-	-	340	323
1155	37	69	-	-	360	342
1220	39	70	-	-	380	361
1290	41	71	-	-	400	380
1350	43	72	-	-	420	399
1420	45	73	-	-	440	418
1485	46	74	-	-	460	437
1555	48	75	-	-	480	456
1595	48	75	-	-	490	466
1665	50	76	-	-	510	485
1740	51	76	-	-	530	504
1810	52	77	-	-	550	523
1880	54	78	-	-	570	542
1955	55	78	-	-	590	561
2030	56	79	-	-	610	580
2105	57	80	-	-	630	599
2180	58	80	-	-	650	618
-	59	81	-	-	670	636
-	60	81	-	-	690	-
-	61	82	-	-	720	-
-	63	83	-	-	760	-
-	64	83	-	-	800	-
-	65	84	-	-	840	-
-	66	85	-	-	880	-

*no liability assumed *senza garanzia

CONVERSION TABLE OF CUTTING SPEED M/MIN. TO R/MIN.

TRADUZIONE DELLA VELOCITÀ DI M/MIN IN U/MIN

m/min.		4	6	8	9	10	12	15	18	21	25	27	30	36
Size		Revolutions per Minute (rpm)												
mm	inch	giri al minuto U/min												
1,6	1/16	800	1194	1592	1791	1988	2386	2983	3579	4176	4971	5369	5965	7158
1,8		708	1065	1415	1598	1768	2121	2652	3182	3712	4419	4743	5303	6364
2		637	955	1274	1433	1591	1909	2386	2863	3341	3977	4295	4773	5727
2,2	3/32	579	869	1158	1303	1446	1736	2169	2603	3037	3616	3905	4339	5207
2,5		510	764	1019	1147	1274	1527	1909	2291	2673	3182	3436	3818	4582
3	1/8	425	637	849	955	1061	1273	1591	1909	2227	2651	2864	3182	3818
3,5		364	546	728	819	909	1091	1364	1636	1909	2273	2455	2727	3273
4	5/32	318	478	637	718	796	955	1193	1432	1671	1989	2148	2387	2864
4,5		283	425	566	637	707	849	1061	1273	1485	1768	1909	2122	2546
5	3/16	255	382	510	573	637	764	955	1146	1337	1591	1719	1909	2292
6	1/4	212	319	425	477	530	636	795	954	1113	1326	1432	1592	1909
7	9/32	182	273	364	409	455	546	682	818	955	1136	1227	1364	1636
8	5/16	159	239	319	358	398	477	597	716	835	994	1074	1193	1432
9		142	212	283	318	354	425	531	637	742	885	955	1061	1293
10	3/8	127	191	255	286	318	382	477	573	668	795	859	955	1146
11		116	174	232	260	289	347	434	521	608	723	781	868	1041
12	1/2	106	159	212	238	265	318	398	477	557	663	716	796	955
13		98	147	196	220	245	294	367	441	514	612	661	734	881
14	9/16	91	136	182	205	277	273	341	409	477	568	614	682	818
16	5/8	80	119	159	179	199	239	298	358	418	497	537	597	716
18		71	106	141	159	177	212	265	318	371	442	477	530	636
20	3/4	64	96	127	143	159	191	239	286	334	398	430	477	573
22	7/8	58	87	116	130	145	174	217	260	304	362	391	434	521
24	1"	53	80	106	119	133	159	199	239	275	331	353	398	477
27		47	71	94	106	118	141	177	212	245	295	318	354	424
30	1-1/8	43	64	85	95	106	127	159	191	223	265	286	318	382
33	1-1/4	39	58	77	87	96	116	145	174	203	241	260	289	347
36		35	53	71	80	88	106	133	159	186	221	239	265	318
39	1-1/2	33	49	65	73	82	98	122	147	171	204	220	245	294
42		30	46	61	68	76	91	114	136	159	189	205	227	273
45	1-3/4	28	42	57	64	71	85	106	127	149	177	191	212	255
48		27	40	53	60	66	80	99	119	139	166	179	199	239
52		24	37	49	55	61	73	92	110	129	153	165	184	220
56	2"	23	34	46	51	57	68	85	102	119	142	153	170	205

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

Material/Materiali	Lubricant lubrificante	Cutting Speed velocità di taglio m/min.
Steel, unalloyed and low alloyed, short-chipping Acciaio non legati e e baso legati, truciolo corto	S/E	10-20
non abrasive Material, short-chipping Materiali buona truciodibilità, truciolo corto	S/E	6-15
Steel, heat resistant, long-chipping Acciaio resistenti al calore, truciolo lungo	S	4- 8
Steel, heat resistant, short-chipping Acciaio resistenti al calore, truciolo corto	S	4- 8
Steel, cementation and heat treatable, short-chipping Acciaio da cementazione, Acciaio bonificato, truciolo corto	S	4- 8
Steel, Tool Steel up to 1200 N/mm² Acciaio, Acciaio utensili a 1.200 N/mm²	S	2- 5
Steel, Tool Steel over 1200 N/mm² Acciaio, Acciaio utensili da 1.200 N/mm²	S	2- 5
Steel stainless, short-chipping Acciaio inossidabile, truciolo corto	S	5-10
Steel stainless, long-chipping Acciaio inossidabile, truciolo lungo	S	5-10
Iron, Cast Ghisa grigia	P/T	6-20
Iron, spheroidal graphite Ghisa sferoidale	P/T	6-20
Iron, Malleable Cast Ghisa malleabile	E	6-12
Brass, short-chipping Ottone, truciolo corto	E	20-30
Brass, long-chipping Ottone, truciolo lungo	S/E	10-15
Bronze, short-chipping Bronzo, truciolo corto	S/E	6-15
Bronze, long-chipping Bronzo, truciolo lungo	S/E	6-15
Copper Rame	S/E	10-15
Aluminium-alloys, short-chipping Alluminio, truciolo corto	S/E	15-30
Aluminium-alloys, long-chipping Alluminio, truciolo lungo	E	10-20
Zinc Alloys Leghe forgiate	S/E	10-15
Magnesium Alloys Leghe di magnesio	E/T	10-20
Titanium, short-chipping Titanio, truciolo corto	S	3- 4
Titanium, long-chipping Titanio, truciolo lungo	S	3- 4
Plastics, thermoplastics Materiali plastici, materiali termoplastici	E/T	5-15
Plastics, thermosetting Materiali plastici, materiali termodurenti	T	5-15

S = cutting oil/olii da taglio E = oil emulsion/emulsione P = kerosene/petrolio T = dry/secco

CONVERSION TABLE INCH-MM
TABELLA DI CONVERSIONE POLLICE – MM

Nominal-Ø Inch	BSW Pitch Inch	BSF Pitch Inch	UNC Pitch Inch	UNF Pitch Inch	UNEF Pitch Inch	Thread-Ø mm
No. 0	-	-	-	80	-	1,520
No. 1	-	-	64	72	-	1,850
No. 2	-	-	56	64	-	2,180
No. 3	-	-	48	56	-	2,520
No. 4	-	-	40	48	-	2,850
No. 5	-	-	40	44	-	3,180
No. 6	-	-	32	40	-	3,510
No. 8	-	-	32	36	-	4,170
No. 10	-	-	24	32	-	4,830
No. 12	-	-	24	28	32	5,490
1/16"	60	-	-	-	-	1,587
3/32"	48	-	-	-	-	2,381
1/8"	40	-	-	-	-	3,175
5/32"	32	-	-	-	-	3,969
3/16	24	32	-	-	-	4,762
7,32"	24	28	-	-	-	5,556
1/4"	20	26	20	28	32	6,350
5/16"	18	22	18	24	32	7,938
3/8"	16	20	16	24	32	9,525
7/16"	14	18	14	20	28	11,113
1/2"	12	16	13	20	28	12,700
9/16"	12	16	12	18	24	14,288
5/8"	11	14	11	18	24	15,876
11/16"	-	14	-	-	24	17,463
3/4"	10	12	10	16	20	19,051
13/16"	-	12	-	-	20	20,638
7/8"	9	11	9	14	20	22,226
15/16"	-	11	-	-	20	23,813
1"	8	10	8	12	20	25,401
1 1/16"	-	-	-	-	18	26,988
1 1/8"	7	9	7	12	18	28,576
1 3/16"	-	-	-	-	18	30,163
1 1/4"	7	9	7	12	18	31,751
1 5/16"	.	.	.	.	18	33,338
1 3/8"	6	8	6	12	18	34,926
1 7/16"	-	-	-	-	18	36,512
1 1/2"	6	8	6	12	18	38,101
1 5/8"	5	8	5	-	18	41,277
1 3/4"	5	7	5	-	18	44,452
1 7/8"	4,5	-	4,5	-	18	47,627
2"	4,5	7	4,5	-	18	50,802
2 1/4"	4	-	4,5	-	-	57,152
2 1/2"	4	-	4	-	-	63,502
2 3/4"	3,5	-	4	-	-	69,853
3"	3,5	-	4	-	-	76,203

Nominal-Ø Inch	BSP (G) Pitch Inch	Thread-Ø mm
G 1/8"	28	9,728
G 1/4"	19	13,157
G 3/8"	19	16,662
G 1/2"	14	20,955
G 5/8"	14	22,911
G 3/4	14	26,441
G 7/8"	14	30,201
G 1"	11	33,249
G 1 1/8	11	37,897
G 1 1/4"	11	41,910
G 1 3/8"	11	44,323
G 1 1/2"	11	47,803
G 1 3/4"	11	53,746
G 2"	11	59,614
G 2 1/4"	11	65,710
G 2 1/2"	11	75,184
G 2 3/4"	11	81,534
G 3"	11	87,884
G 3 1/4"	11	93,980
G 3 1/2	11	100,330
G 3 3/4"	11	106,680
G 4"	11	113,030

armoured tube thread PG

Nominal-Ø	Pitch Inch	Thread-Ø mm
PG 7	20	12,500
PG 9	18	15,200
PG 11	18	18,600
PG 13,5	18	20,400
PG 16	18	22,500
PH 21	16	28,300
PG 29	16	37,000
PG 36	16	47,000
PG 42	16	54,000
PG 48	16	59,500

RECOMMENDED OUTSIDE DIAMETER
DIAMETRI DEI PERNI DA FILLETTARE RACCOMANDATO

M		Ø mm
M 1	0,25	0,97
M 1,1	0,25	1,07
M 1,2	0,25	1,17
M 1,4	0,3	1,36
M 1,6	0,35	1,54
M (1,7)	0,35	1,64
M 1,8	0,35	1,74
M 2	0,4	1,93
M 2,2	0,45	2,13
M (2,3)	0,4	2,23
M 2,5	0,45	2,43
M (2,6)	0,45	2,53
M 3	0,5	2,92
M 3	0,6	2,91
M 3,5	0,6	3,41
M 3,5	0,75	3,41
M 4	0,7	3,91
M 4	0,75	3,91
M 4,5	0,75	4,41
M 5	0,8	4,90
M 5	0,9	4,89
M 6	1	5,88
M 7	1	6,88
M 8	1,25	7,87
M 9	1,25	8,87
M 10	1,5	9,85
M 11	1,5	10,85
M 12	1,75	11,83
M 14	2	13,82
M 16	2	15,82
M 18	2,5	17,79
M 20	2,5	19,79
M 22	2,5	21,79
M 24	3	23,77
M 27	3	26,77
M 30	3,5	29,73
M 33	3,5	32,73
M 36	4	35,70
M 39	4	38,70
M 42	4,5	41,69
M 45	4,5	44,69
M 48	5	47,66
M 52	5	51,66

Mf		Ø mm
M 3	x 0,35	2,94
M 3,5	x 0,35	3,44
M 4	x 0,35	3,94
M 4	x 0,5	3,93
M 5	x 0,5	4,93
M 6	x 0,5	5,93
M 6	x 0,75	5,90
M 7	x 0,75	6,90
M 8	x 0,5	7,93
M 8	x 0,75	7,90
M 8	x 1	7,83
M 9	x 1	8,88
M 10	x 0,5	9,93
M 10	x 0,75	9,90
M 10	x 1	9,88
M 10	x 1,25	9,86
M 11	x 1	10,88
M 12	x 0,75	11,90
M 12	x 1	11,88
M 12	x 1,25	11,86
M 12	x 1,5	11,85
M 13	x 1	12,88
M 13	x 1,5	12,85

Mf		Ø mm
M 13	x 1,75	12,83
M 14	x 1	13,88
M 14	x 1,25	13,86
M 14	x 1,5	13,85
M 15	x 1	14,88
M 15	x 1,5	14,85
M 15	x 2	14,82
M 16	x 1	15,88
M 16	x 1,5	15,85
M 18	x 1	17,88
M 18	x 1,5	17,85
M 18	x 2	17,82
M 20	x 1	19,88
M 20	x 1,5	19,85
M 20	x 2	19,82
M 22	x 1	21,88
M 22	x 1,5	21,85
M 22	x 2	21,82
M 24	x 1	23,88
M 24	x 1,5	23,85
M 24	x 2	23,82
M 25	x 1	24,88
M 25	x 1,5	24,85
M 26	x 1	25,88
M 26	x 1,5	25,85
M 27	x 1	26,88
M 27	x 1,5	26,85
M 27	x 2	26,82
M 28	x 1,5	27,85
M 28	x 2	27,82
M 30	x 1	29,88
M 30	x 1,5	29,85
M 30	x 2	29,82
M 32	x 1,5	31,85
M 33	x 1,5	32,85
M 33	x 2	32,82
M 34	x 1,5	33,85
M 35	x 1,5	34,85
M 36	x 1,5	35,85
M 36	x 2	35,82
M 36	x 3	35,76
M 38	x 1,5	37,85
M 39	x 1,5	38,85
M 39	x 2	38,82
M 39	x 3	38,76
M 40	x 1,5	39,85
M 40	x 2	39,82
M 40	x 3	39,76
M 42	x 1,5	41,85
M 42	x 2	41,82
M 42	x 3	41,76
M 45	x 1,5	44,85
M 45	x 2	44,82
M 45	x 3	44,76
M 48	x 1,5	47,85
M 48	x 2	47,82
M 48	x 3	47,46
M 50	x 1,5	49,85
M 50	x 2	49,82
M 50	x 3	49,76
M 52	x 1,5	51,85
M 52	x 2	51,82
M 52	x 3	51,76

BSW	Ø mm
W 1/4	6,16
W 5/16	7,76
W 3/8	9,30
W 7/16	10,89
W 1/2	12,43
W 9/16	13,92
W 5/8	15,62
W 3/4	18,76
W 7/8	21,89
W 1"	25,08
W 1.1/8	28,21

BSF	Ø mm
BSF 3/16	4,67
BSF 1/4	6,25
BSF 5/16	7,82
BSF 3/8	9,39
BSF 7/16	10,97
BSF 1/2	12,54
BSF 9/16	14,12
BSF 5/8	15,71
BSF 3/4	18,85
BSF 7/8	22,02
BSF 1"	25,17

UNC	Ø mm
No. 1-64	1,79
No. 2-56	2,12
No. 3-48	2,44
No. 4-40	2,76
No. 5-40	3,09
No. 6-32	3,41
No. 8-32	4,07
No. 10-24	4,71
No. 12-24	5,37
1/4-20	6,22
5/16-18	7,80
3/8-16	9,37
7/16-14	10,95
1/2-13	12,52
9/16-12	14,10
5/8-11	15,68
3/4-10	18,84
7/8- 9	22
1"- 8	25,16
1.1/8- 7	28,31
1.1/4- 7	31,49
1.3/8- 6	34,63
1.1/2- 6	37,81
1.3/4- 5	44,12
2"- 4,5	50,45
2.1/4- 4,5	56,80
2.1/2- 4	63,10
2.3/4- 4	69,45
3"- 4	75,80

UNF	Ø mm
No. 0-80	1,47
No. 1-72	1,79
No. 2-64	2,12
No. 3-56	2,44
No. 4-48	2,77
No. 5-44	3,10
No. 6-40	3,42
No. 8-36	4,08
No. 10-32	4,73
No. 12-28	5,38
1/4-28	6,24
5/16-24	7,82
3/8-24	9,41
7/16-20	10,98
1/2-20	12,56
9/16-18	14,14
5/8-18	15,73
3/4-16	18,89
7/8-14	22,05
1"-12	25,21
1.1/8-12	28,38
1.1/4-12	31,56
1.3/8-12	34,73
1.1/2-12	37,91

BSP G	Ø mm
G 1/8	9,62
G 1/4	13,03
G 3/8	16,53
G 1/2	20,81
G 5/8	22,77
G 3/4	26,30
G 7/8	30,06
G 1"	33,07
G 1.1/8	37,71
G 1.1/4	41,73
G 1.3/8	44,14
G 1.1/2	47,62
G 1.3/4	53,56
G 2"	59,43

PG	Ø mm
PG 7	12,40
PG 9	15,10
PG 11	18,50
PG 13,5	20,30
PG 16	22,40
PG 21	28,15
PG 29	36,85
PG 36	46,85
PG 42	53,85
PG 48	59,15

NPT	Ø mm
1/16	8,17
1/8	10,55
1/4	14,10
3/8	17,52
1/2	21,85
3/4	27,16
1"	34,16
1.1/4	42,74
1.1/2	48,87
2"	60,95

FG		Ø mm
FG 2	x 56	2,03
FG 2,3	x 56	2,23
FG 2,6	x 56	2,53
FG 6,35	x 26	6,23
FG 7,9	x 26	7,81
FG 9,5	x 26	9,40
FG 14,3	x 20	14,14
FG 14,3	x 20-LH	14,14
FG 25,4	x 24	25,26

BSC	Ø mm
BSC 1/4 x 26	6,23
BSC 5/16 x 26	7,81
BSC 3/8 x 26	9,40
BSC 9/16 x 20	14,14
BSC 9/16 x 20LH	14,14
BSC 1" x 24	25,26

Vg		Ø mm
Vg 5	x 36	5,05
Vg 5,2	x 24	5,12
Vg 6	x 32	5,87
Vg 8	x 32	7,57
Vg 10	x 28	10,16
Vg 12	x 26	12,04

RECOMMENDED TAPPING DRILL SIZES
PREFORI PER MASCHI RACCOMANDATO

M		Ø mm
M 1	0,25	0,75
M 1,1	0,25	0,85
M 1,2	0,25	0,95
M 1,4	0,3	1,1
M 1,6	0,35	1,25
M (1,7)	0,35	1,3
M 1,8	0,35	1,45
M 2	0,4	1,6
M 2,2	0,45	1,75
M (2,3)	0,4	1,9
M 2,5	0,45	2,05
M (2,6)	0,45	2,1
M 3	0,5	2,5
M 3,5	0,6	2,9
M 4	0,7	3,3
M 4,5	0,75	3,7
M 5	0,8	4,2
M 6	1	5
M 7	1	6
M 8	1,25	6,8
M 9	1,25	7,8
M 10	1,5	8,5
M 11	1,5	9,5
M 12	1,75	10,2
M 14	2	12
M 16	2	14
M 18	2,5	15,5
M 20	2,5	17,5
M 22	2,5	19,5
M 24	3	21
M 27	3	24
M 30	3,5	26,5
M 33	3,5	29,5
M 36	4	32
M 39	4	35
M 42	4,5	37,5
M 45	4,5	40,5
M 48	5	43
M 52	5	47
M 3	0,6	2,4
M 3,5	0,75	2,75
M 4	0,75	3,25
M 5	0,9	4,1

Mf	Ø mm
M 2,5 x 0,35	2,15
M 2,6 x 0,35	2,25
M 3 x 0.35	2,65
M 3,5 x 0,35	3,15
M 4 x 0,35	3,65
M 4 x 0,5	3,5
M 4,5 x 0,5	4
M 5 x 0,5	4,5
M 5 x 0,75	4,25
M 5,5 x 0,5	5
M 6 x 0,5	5,5
M 6 x 0,75	5,2
M 7 x 0,5	6,5
M 7 x 0,75	6,2
M 8 x 0,5	7,5
M 8 x 0,75	7,2
M 8 x 1,0	7
M 9 x 0,5	8,5
M 9 x 0,75	8,2
M 9 x 1,0	8
M 10 x 0,5	9,5
M 10 x 0,75	9,2
M 10 x 1,0	9

Mf	Ø mm
M 10 x 1,25	8,8
M 11 x 1,0	10
M 11 x 1,25	9,8
M 12 x 0,75	11,2
M 12 x 1,0	11
M 12 x 0,5	11,5
M 12 x 1,25	10,8
M 13 x 0,5	12,5
M 12 x 1,5	10,5
M 13 x 0,75	12,25
M 13 x 1,0	12
M 13 x 1,5	11,5
M 14 x 0,75	13,25
M 14 x 1,0	13
M 14 x 1,25	12,8
M 14 x 0,5	13,5
M 14 x 1,5	12,5
M 15 x 0,75	14,25
M 15 x 1,0	14
M 15 x 1,5	13,5
M 16 x 0,5	15,5
M 16 x 1,0	15
M 16 x 0,75	15,25
M 16 x 1,25	14,75
M 16 x 1,5	14,5
M 18 x 0,5	17,5
M 17 x 1,0	16
M 18 x 1,0	17
M 18 x 1,25	16,75
M 18 x 1,5	16,5
M 18 x 0,75	17,25
M 18 x 2,0	16
M 19 x 1,0	18
M 19 x 1,5	17,5
M 20 x 0,5	19,5
M 20 x 1,0	19
M 20 x 0,75	19,25
M 20 x 1,25	18,75
M 20 x 1,5	18,5
M 20 x 2,0	18
M 21 x 1,0	20
M 21 x 1,5	19,5
M 22 x 0,5	21,5
M 22 x 1,0	21
M 22 x 0,75	21,25
M 22 x 1,25	20,75
M 22 x 1,5	20,5
M 22 x 2,0	20
M 23 x 1,0	22
M 23 x 1,5	21,5
M 24 x 1,0	23
M 24 x 0,5	23,5
M 24 x 1,25	22,75
M 24 x 0,75	23,25
M 24 x 1,5	22,5
M 24 x 2,0	22
M 25 x 1,0	24
M 25 x 1,5	23,5
M 26 x 1,0	25
M 26 x 1,5	24,5
M 26 x 2,0	24
M 27 x 1,0	26
M 27 x 1,5	25,5
M 27 x 2,0	25
M 28 x 1,0	27
M 28 x 1,5	26,5
M 28 x 2,0	26
M 29 x 1,5	27,5

Mf	Ø mm
M 30 x 1,0	29
M 30 x 1,5	28,5
M 30 x 2,0	28
M 30 x 2,5	27,5
M 30 x 3,0	27
M 32 x 2	30
M 32 x 1,5	29,5
M 32 x 3,0	29
M 33 x 1,5	31,5
M 32 x 1	31
M 33 x 2,0	31
M 33 x 3,0	30
M 34 x 1	33
M 34 x 1,5	32,5
M 34 x 2,0	32
M 35 x 1	34
M 35 x 1,5	33,5
M 35 x 2	33
M 36 x 1,5	34,5
M 36 x 1	35
M 36 x 2,0	34
M 37 x 1,5	35,5
M 36 x 3,0	33
M 38 x 1	37
M 38 x 1,5	36,5
M 38 x 2,0	36
M 39 x 1,5	37,5
M 38 x 3	35
M 39 x 2,0	37
M 39 x 3,0	36
M 40 x 1	39
M 40 x 1,5	38,5
M 40 x 2,0	38
M 40 x 3,0	37
M 42 x 1	41
M 42 x 1,5	40,5
M 44 x 1,5	42,5
M 42 x 2,0	40
M 44 x 2	42
M 42 x 3,0	39
M 45 x 1	44
M 45 x 1,5	43,5
M 45 x 2,0	43
M 45 x 3,0	42
M 46 x 1,5	44,5
M 48 x 1,5	46,5
M 48 x 1	47
M 48 x 2,0	46
M 48 x 3,0	45
M 50 x 1,5	48,5
M 50 x 2,0	48
M 50 x 3,0	47
M 52 x 1,5	50,5
M 52 x 2,0	50
M 52 x 3,0	49
M 54 x 1,0	53
M 54 x 1,5	52,5
M 54 x 2,0	52
M 54 x 3,0	51
M 54 x 4,0	50
M 55 x 1,5	53,5
M 55 x 2,0	53
M 55 x 3,0	52
M 55 x 4,0	51
M 56 x 1,0	55
M 56 x 1,5	54,5
M 56 x 2,0	54
M 56 x 3,0	53

Mf	Ø mm
M 56 x 4,0	52
M 58 x 1,0	57
M 58 x 1,5	56,5
M 58 x 2,0	56
M 58 x 3,0	55
M 58 x 4,0	54
M 60 x 1,5	58,5
M 60 x 2,0	58
M 60 x 3,0	57
M 60 x 4,0	56
M 62 x 1,5	60,5
M 62 x 2,0	60
M 62 x 3,0	59
M 62 x 4,0	58
M 63 x 1,5	61,5
M 64 x 1,5	62,5
M 64 x 2,0	62
M 64 x 3,0	61
M 64 x 4,0	60
M 65 x 1,5	63,5
M 65 x 2,0	63
M 65 x 3,0	62
M 65 x 4,0	61
M 68 x 1,5	66,5
M 68 x 2,0	66
M 68 x 3,0	65
M 68 x 4,0	64
M 70 x 1,5	68,5
M 70 x 2,0	68
M 70 x 3,0	67
M 70 x 4,0	66
M 72 x 1,5	70,5
M 72 x 2,0	70
M 72 x 3,0	69
M 72 x 4,0	68
M 74 x 1,5	72,5
M 74 x 2,0	72
M 74 x 3,0	71
M 74 x 4,0	70
M 75 x 1,5	73,5
M 75 x 2,0	73
M 75 x 3,0	72
M 75 x 4,0	71
M 76 x 1,5	74,5
M 76 x 2,0	74
M 76 x 3,0	73
M 76 x 4,0	72
M 78 x 1,5	76,5
M 78 x 2,0	76
M 78 x 3,0	75
M 78 x 4,0	74
M 80 x 1,5	78,5
M 80 x 2,0	78
M 80 x 3,0	77
M 80 x 4,0	76
M 82 x 1,5	80,5
M 82 x 2,0	80
M 82 x 3,0	79
M 82 x 4,0	78
M 84 x 1,5	82,5
M 84 x 2,0	82
M 84 x 3,0	81
M 84 x 4,0	80
M 85 x 1,5	83,5
M 85 x 2,0	83
M 85 x 3,0	82
M 85 x 4,0	81
M 86 x 1,5	84,5

Mf	Ø mm
M 86 x 2,0	84
M 86 x 3,0	83
M 86 x 4,0	82
M 88 x 1,5	86,5
M 88 x 2,0	86
M 88 x 3,0	85
M 88 x 4,0	84
M 90 x 1,5	88,5
M 90 x 2,0	88
M 90 x 3,0	87
M 90 x 4,0	86
M 92 x 1,5	90,5
M 92 x 2,0	90
M 92 x 3,0	89
M 92 x 4,0	88
M 95 x 1,5	93,5
M 95 x 2,0	93
M 95 x 3,0	92
M 95 x 4,0	91
M 96 x 1,5	94,5
M 96 x 2,0	94
M 96 x 3,0	93
M 96 x 4,0	92
M 98 x 1,5	96,5
M 98 x 2,0	96
M 98 x 3,0	95
M 98 x 4,0	94
M 100 x 1,5	98,5
M 100 x 2,0	98
M 100 x 3,0	97
M 100 x 4,0	96
M 105 x 1,5	103,5
M 105 x 2,0	103
M 105 x 3,0	102
M 105 x 4,0	101
M 110 x 1,5	108,5
M 110 x 2,0	108
M 110 x 3,0	107
M 110 x 4,0	106

BSW	Ø mm
W 3/32	1,8
W 1/8	2,6
W 5/32	3,1
W 3/16	3,6
W 7/32	4,4
W 1/4	5,1
W 5/16	6,5
W 3/8	7,9
W 7/16	9,3
W 1/2	10,5
W 9/16	12
W 5/8	13,5
W 3/4	16,5
W 7/8	19,25
W 1"	22
W 1.1/8	24,75
W 1.1/4	27,75
W 1.3/8	30,2
W 1.1/2	33,5
W 1.3/4	38,5
W 2"	44,5

RECOMMENDED TAPPING DRILL SIZES
PREFORI PER MASCHI RACCOMANDATO

BSF	Ø mm
BSF 1/4	5,2
BSF 5/16	6,6
BSF 3/8	8,1
BSF 7/16	9,5
BSF 1/2	11
BSF 5/8	14
BSF 3/4	16,5
BSF 7/8	19,5
BSF 1"	22,5

BSP G	Ø mm
G 1/8	8,8
G 1/4	11,8
G 3/8	15,25
G 1/2	19
G 5/8	21
G 3/4	24,5
G 7/8	28,25
G 1"	30,75
G 1.1/8	35,3
G 1.1/4	39,5
G 1.3/8	41,7
G 1.1/2	45,25
G 1.3/4	51,1
G 2"	57
G 2.1/4	63,1
G 2.1/2	72,6
G 2.3/4	78,9
G 3"	85,3

BA	Ø mm
BA 0	5,1
BA 1	4,5
BA 2	4
BA 3	3,4
BA 4	3
BA 5	2,65
BA 6	2,3

UNC	Ø mm
No. 1-64	1,5
No. 2-56	1,8
No. 3-48	2,1
No. 4-40	2,3
No. 5-40	2,6
No. 6-32	2,85
No. 8-32	3,5
No. 10-24	3,9
No. 12-24	4,5
1/4-20	5,2
5/16-18	6,6
5/16-18	6,6
3/8-16	8
7/16-14	9,4
1/2-13	10,8
9/16-12	12,2
5/8-11	13,5
3/4-10	16,5
7/8- 9	19,5
1"- 8	22,25
1.1/8- 7	25
1.1/4- 7	28,25
1.3/8- 6	30,75
1.1/2- 6	34
1.3/4- 5	39,5
2"- 4,5	45
2.1/4- 4,5	51,5
2.1/2- 4	57,25

UNC	Ø mm
2"- 4,5	45
2.1/4- 4,5	51,5
2.1/2- 4	57,25
2.3/4- 4	63,5
3"- 4	70
3.1/4- 4	76,2
3.1/2- 4	82,6

UNF	Ø mm
No. 0-80	1,3
No. 1-72	1,6
No. 2-64	1,9
No. 3-56	2,1
No. 4-48	2,4
No. 5-44	2,7
No. 6-40	3
No. 8-36	3,5
No. 10-32	4,1
No. 12-28	4,7
1/4-28	5,5
5/16-24	6,9
3/8-24	8,5
7/16-20	9,9
1/2-20	11,5
9/16-18	12,9
5/8-18	14,5
3/4-16	17,5
7/8-14	20,25
1"-12	23,25
1.1/8-12	26,5
1.1/4-12	29,5
1.3/8-12	32,5
1.1/2-12	36

12-UN	Ø mm
UN 1.5/8-12	39,2
UN 1.3/4-12	42,4
UN 1.7/8-12	45,6
UN 2"-12	48,75
UN 2.1/8-12	51,9
UN 2.1/4-12	55,1
UN 2.1/2-12	61,5
UN 2.3/4-12	67,8
UN 3"-12	74,2
UN 3.1/4-12	80,5
UN 3.1/2-12	86,9
UN 3.3/4-12	93,2
UN 4"-12	99,6

8-UN	Ø mm
UN 1.1/16-8	23,9
UN 1.1/8-8	25,5
UN 1.3/16-8	27,1
UN 1.1/4-8	28,75
UN 1.5/16-8	30,3
UN 1.3/8-8	31,75
UN 1.1/2-8	35
UN 1.5/8-8	38
UN 1.3/4-8	41,5
UN 1.7/8-8	44,5
UN 2"-8	47,75
UN 2.1/8-8	50,9
UN 2.1/4-8	54
UN 2.1/2-8	60,4
UN 2.3/4-8	66,7
UN 3"-8	73,1
UN 3.1/4-8	79,4
UN 3.1/2-8	85,8
UN 3.3/4-8	92,1
UN 4"-8	98,5

UN	Ø mm
UN 5/16-28	7
UN 3/8-20	8,3
UN 3/8-28	8,6
UN 7/16-32	10,3
UN 1/2-32	11,9
UN 9/16-20	10,9
UN 9/16-28	11,3
UN 9/16-32	11,4
UN 5/8-20	14,6
UN 5/8-28	15
UN 11/16-20	16,2
UN 11/16-16	15,9
UN 1"-32	24,6

UNEF	Ø mm
No. 12-32	4,75
1/4-32	5,6
5/16-32	7,2
3/8-32	8,8
7/16-28	10,25
1/2-28	11,8
9/16-24	13,3
5/8-24	14,9
11/16-24	16,5
3/4-20	17,75
13/16-20	19,5
7/8-20	21
15/16-20	22,5
1"-20	24,25
1.1/16-18	25,7
1.1/8-18	27,25
1.3/16-18	28,75
1.1/4-18	30,5
1.5/16-18	32
1.3/8-18	33,5
1.7/16-18	35,2
1.1/2-18	36,8
1.9/16-18	38,4
1.5/8-18	40
1.11/16-18	41,5
1.3/4-18	43
2"-18	49,4

UNS	Ø mm
UNS 1/4-24	5,4
UNS 1/4-36	5,7
UNS 1/4-40	5,75
UNS 3/8-27	8,35
UNS 7/16-24	10,1
UNS 1/2-24	11,75
UNS 5/8-27	14,7
UNS 3/4-24	18
UNS 7/8-18	21
UNS 1"-14	23,75

PG	Ø mm
PG 7	11,4
PG 9	14
PG 11	17,25
PG 13,5	19
PG 16	21,25
PG 21	26,75
PG 29	35,5
PG 36	45,5
PG 42	52,5
PG 48	58

NPT	Ø mm
1/16-27	6,3
1/8-27	8,5
1/4-18	11,2
3/8-18	14,5
1/2-14	18
3/4-14	23
1"-11,5	29
1.1/4-11,5	38
1.1/2-11,5	44
2"-11,5	56
2.1/2- 8	67
3- 8	83

W DIN 477	Ø mm
W 19,8	15,1
W 28,8	23,5
W 31,3	26,0

FG	Ø mm
FG 2 x 56	1,7
FG 2,3 x 56	1,9
FG 2,6 x 56	2,2
FG 6,35 x 26	5,5
FG 7,9 x 26	7
FG 9,5 x 26	8,6
FG 14,3 x 20	13,1
FG 14,3 x 20-LH	13,1
FG 25,4 x 24	24,5

BSC	Ø mm
BSC 1/4 x 26	5,5
BSC 5/16 x 26	7
BSC 3/8 x 26	8,6
BSC 9/16 x 20	13,1
BSC 9/16 x 20 LH	13,1
BSC 1" x 24	24,5

Vg	Ø mm
Vg 5 x 36	4,7
Vg 5,2 x 24	4,3
Vg 6 x 32	5,4
Vg 8 x 32	6,9
Vg 10 x 28	9,4
Vg 12 x 26	11,2

Rd	Ø mm
Rd 8 x 1/10	6
Rd 9 x 1/10	7
Rd 10 x 1/10	8
Rd 11 x 1/10	9
Rd 12 x 1/10	10
Rd 14 x 1/8	11,5
Rd 16 x 1/8	13,5
Rd 18 x 1/8	15,5
Rd 20 x 1/8	17,5
Rd 22 x 1/8	19,5
Rd 24 x 1/8	21,5
Rd 26 x 1/8	23,5
Rd 28 x 1/8	25,5
Rd 30 x 1/8	27,5
Rd 32 x 1/8	29,5
Rd 34 x 1/8	31,5
Rd 36 x 1/8	33,5
Rd 38 x 1/8	35,5
Rd 40 x 1/6	36,6
Rd 42 x 1/6	38,6
Rd 44 x 1/6	40,6

Tr	Ø mm
Tr 10 x 2	8,2
Tr 10 x 3	7,5
Tr 12 x 3	9,25
Tr 14 x 3	11,25
Tr 14 x 4	10,5
Tr 16 x 4	12,25
Tr 18 x 4	14,25
Tr 20 x 4	16,25
Tr 22 x 4	18,25
Tr 22 x 5	17,25
Tr 24 x 5	19,25
Tr 26 x 5	21,25
Tr 28 x 5	23,25
Tr 30 x 6	24,25
Tr 32 x 6	26,25
Tr 36 x 6	30,25

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

VÖLKEL GmbH
Morsbachtalstraße 18
D-42855 Remscheid

Postfach 15 01 28
D-42828 Remscheid

Telefon +49 2191 490112
Telefax +49 2191 490125

E-Mail: info@voelkel.com
Internet: www.voelkel.com

05.15.6,0.D.Pr.