PREMIUM VFS®
THREADING TOOLS

100% Net prices from the company

100% Guaranteed quality Made in Italy

TOP UFS

MJ UNJC UNJF AVIO

DIAMETRO ESTERNO ARROTONDATO
WITH ROUNDED CREST
DIAMÈTRE EXTÉRIEUR ARRONDI

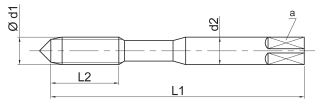
Ti | TITANIO - TITANIUM - TITANE

M

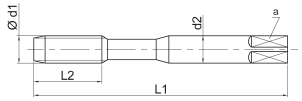
MASCHI A MACCHINA - Scanalature diritte per ghisa
MACHINE TAPS - Straight flutes for cast iron
TARAUDS MACHINE - Goujures droites pour fonte

DIN13 | GG | GHISA - CAST IRON - FONTE

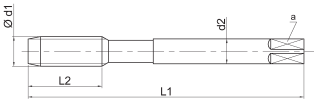
DIN 371 d1 ≤ M6

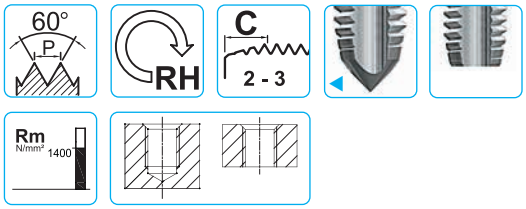


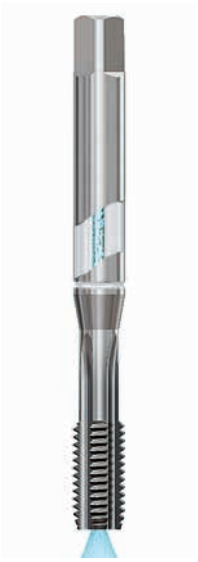
DIN 371 d1 ≤ M10

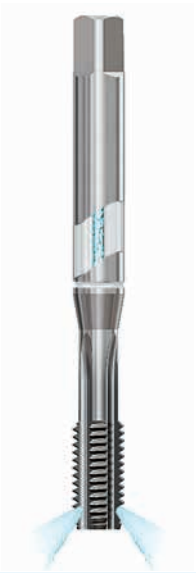


DIN 376 d1 ≥ M12









Profondità di filettatura - Thread depth - Prof. de filetage	**3xD**	**3,5xD**	**3,5xD**
Materiale - Tool Material - Substrat	**PM3**	**PM3**	**PM3**
Tolleranza - Thread tolerance - Tolérance du filetage	**6HX**	**6HX**	**6HX**
Trattamento superficiale - Surface treatment - Revêtement	**TiALn**	**TiALn**	**TiALn**

DIN 371	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE		
◀	**4**	**0,7**	63	13	4,5	3,4	3	3,3	K26M4TX		
◀	**5**	**0,8**	70	13	6	4,9	3	4,2	K26M5TX		
◀	**6**	**1**	80	16	6	4,9	4	5	K26M6TX		
	8	**1,25**	90	18	8	6,2	4	6,8	K26M8SP-TX		
	10	**1,5**	100	20	10	8	4	8,5	K26M10SP-TX		
	6	**1**	80	16	6	4,9	4	5		K26M6FOR-TX	K26M6FORY-TX
	8	**1,25**	90	18	8	6,2	4	6,8		K26M8FOR-TX	K26M8FORY-TX
	10	**1,5**	100	20	10	8	4	8,5		K26M10FOR-TX	K26M10FORY-TX

DIN 376	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE		
	12	**1,75**	110	25	9	7	4	10,3	K27M12TX	K27M12FOR-TX	K27M12FORY-TX
	14	**2**	110	28	11	9	4	12	K27M14TX	K27M14FOR-TX	K27M14FORY-TX
	16	**2**	110	28	12	9	4	14	K27M16TX	K27M16FOR-TX	K27M16FORY-TX
	18	**2,5**	125	33	14	11	5	15,5	K27M18TX	K27M18FOR-TX	K27M18FORY-TX
	20	**2,5**	140	33	16	12	5	17,5	K27M20TX	K27M20FOR-TX	K27M20FORY-TX

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min														
K	Ghisa - Cast iron - Fonte	•3.1 25-30	•3.2 20-25	○3.3 20-25	○3.4 25-30	•3.5 10-15	•3.1 25-30	•3.2 20-25	○3.3 20-25	○3.4 25-30	•3.5 10-15	•3.1 25-30	•3.2 20-25	○3.3 20-25	○3.4 25-30	•3.5 10-15

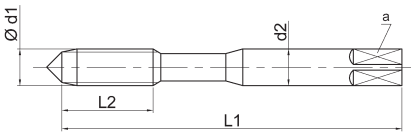
• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

M

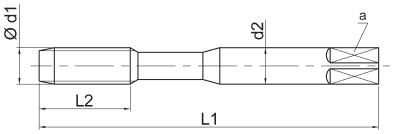
MASCHI A MACCHINA - Imbocco corretto per fori passanti
MACHINE TAPS - Straight flutes with spiral point for through holes
TARAUDS MACHINE - Goujures droites, entrée gun, pour trous débouchant

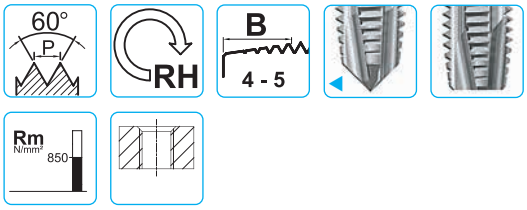
DIN13 | USO GENERALE - GENERAL PURPOSE - USAGE GÉNÉRAL

DIN 371 d1 ≤ M10



DIN 371 d1 =M9





Profondità di filettatura - Thread depth - Prof. de filetage	3xD	3xD	3xD
Materiale - Tool Material - Substrat	HSSE	HSSE	HSSE
Tolleranza - Thread tolerance - Tolérance du filetage	ISO2/6H	ISO2/6H	ISO2/6H
Trattamento superficiale - Surface treatment - Revêtement		V	TiN

DIN 371	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE		
◀	3	0,5	56	10	3,5	2,7	3	2,5	E24M3	E24M3V	E24M3T
◀	4	0,7	63	13	4,5	3,4	3	3,3	E24M4	E24M4V	E24M4T
◀	5	0,8	70	13	6	4,9	3	4,2	E24M5	E24M5V	E24M5T
◀	6	1	80	16	6	4,9	3	5	E24M6	E24M6V	E24M6T
◀	8	1,25	90	18	8	6,2	3	6,8	E24M8	E24M8V	E24M8T
◀	10	1,5	100	20	10	8	3	8,5	E24M10	E24M10V	E24M10T

DIN 376	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE		
	12	1,75	110	25	9	7	3	10,3	E25M12	E25M12V	E25M12T
	14	2	110	28	11	9	3	12	E25M14	E25M14V	E25M14T
	16	2	110	28	12	9	3	14	E25M16	E25M16V	E25M16T
	18	2,5	125	33	14	11	4	15,5	E25M18	E25M18V	E25M18T
	20	2,5	140	33	16	12	4	17,5	E25M20	E25M20V	E25M20T

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min											
P	Acciaio – Steel – Acier - Rm ≤ 850 N/mm²	○1.1 10-15	•1.2 10-15	•1.3 10-12	○1.4 8-10	•1.1 10-15	•1.2 10-15	•1.3 10-12	○1.4 8-10	•1.1 20-30	•1.2 20-30	•1.3 20-25	•1.4 15-20
M	Acciaio inox - Stainless steel - Acier inoxydable												
K	Ghisa - Cast iron - Fonte									○3.3 10-15	•3.4 15-20		
N	Leghe di Allumino – Al alloys - Alliage Al	○4.1 10-15	•4.2 15-20			•4.1 10-15	•4.2 15-20			○4.1 20-25	•4.2 25-30	○4.3 20-25	
N	Leghe di Rame - Copper alloys - Alliages de cuivre	○5.1 8-12	○5.2 10-15			•5.1 8-12	•5.2 10-15			○5.1 15-20	•5.2 20-25		

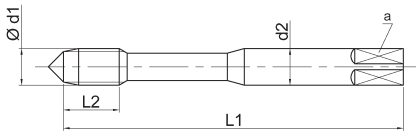
• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

M

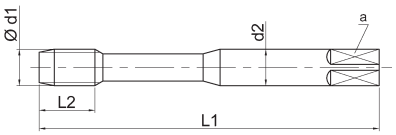
MASCHI A MACCHINA - Elica destra a 40° per fori ciechi
MACHINE TAPS - Spiral flutes 40° for blind holes
TARAUDS MACHINE - Goujures hélicoïdales 40° pour trous borgnes

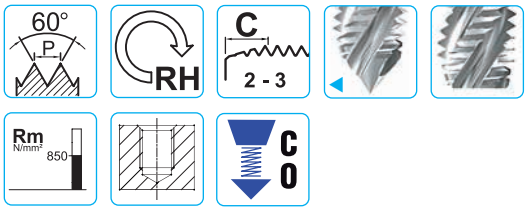
DIN13 | USO GENERALE - GENERAL PURPOSE - USAGE GÉNÉRAL

DIN 371 d1 ≤ M6



DIN 371 d1 ≥ M7





Profondità di filettatura - Thread depth - Prof. de filetage	**2,5xD**	**2,5xD**	**2,5xD**
Materiale - Tool Material - Substrat	**HSSE**	**HSSE**	**HSSE**
Tolleranza - Thread tolerance - Tolérance du filetage	**ISO2/6H**	**ISO2/6H**	**ISO2/6H**
Trattamento superficiale - Surface treatment - Revêtement		**V**	**TiN**

DIN 371	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z	
◀	**3**	**0,5**	56	5	3,5	2,7	3	2,5
◀	**4**	**0,7**	63	7	4,5	3,4	3	3,3
◀	**5**	**0,8**	70	8	6	4,9	3	4,2
◀	**6**	**1**	80	10	6	4,9	3	5
	8	**1,25**	90	13	8	6,2	3	6,8
	10	**1,5**	100	15	10	8	3	8,5

CODE		
E60M3	E60M3V	E60M3T
E60M4	E60M4V	E60M4T
E60M5	E60M5V	E60M5T
E60M6	E60M6V	E60M6T
E60M8	E60M8V	E60M8T
E60M10	E60M10V	E60M10T

DIN 376	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z	
	12	**1,75**	110	18	9	7	3	10,3
	14	**2**	110	20	11	9	3	12
	16	**2**	110	20	12	9	3	14
	18	**2,5**	125	25	14	11	4	15,5
	20	**2,5**	140	25	16	12	4	17,5

CODE		
E61M12	E61M12V	E61M12T
E61M14	E61M14V	E61M14T
E61M16	E61M16V	E61M16T
E61M18	E61M18V	E61M18T
E61M20	E61M20V	E61M20T

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min											
P	Acciaio - Steel - Acier - Rm ≤ 850 N/mm²	○1.1 10-15	•1.2 10-15	•1.3 10-12	○1.4 8-10	•1.1 10-15	•1.2 10-15	•1.3 10-12	○1.4 8-10	•1.1 20-30	•1.2 20-30	•1.3 20-25	•1.4 15-20
M	Acciaio inox - Stainless steel - Acier inoxydable												
K	Ghisa - Cast iron - Fonte									○3.3 10-15	•3.4 15-20		
N	Leghe di Allumino - Al alloys - Alliage Al	○4.1 10-15	•4.2 15-20			•4.1 10-15	•4.2 15-20			○4.1 20-25	•4.2 25-30	○4.3 20-25	
N	Leghe di Rame - Copper alloys - Alliages de cuivre	○5.1 8-12	○5.2 10-15			•5.1 8-12	•5.2 10-15			○5.1 15-20	•5.2 20-25		

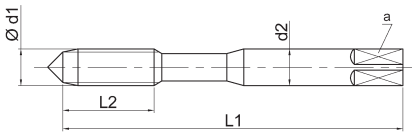
• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

M

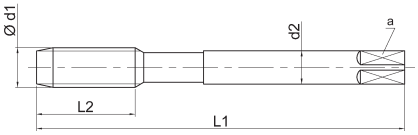
MASCHI A MACCHINA - Imbocco corretto per fori passanti toll. 6G+0,03 e 6H+0,1
MACHINE TAPS - Straight flutes with spiral point for through holes tolerance 6G+0,03 and 6H+0,1
TARAUDS MACHINE - Goujures droites, entrée gun, pour trous débouchant tolérance 6G+0,03 et 6H+0,1

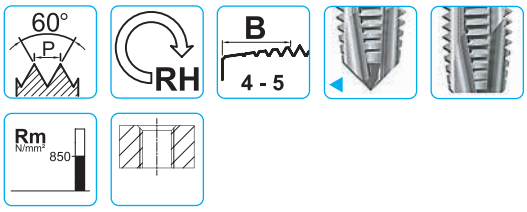
DIN13 | USO GENERALE - GENERAL PURPOSE - USAGE GÉNÉRAL

DIN 371 d1 ≤ M10



DIN 376 d1 ≥ M12





Profondità di filettatura - Thread depth - Prof. de filetage	**3xD**	**3xD**
Materiale - Tool Material - Substrat	**HSSE**	**HSSE**
Tolleranza - Thread tolerance - Tolérance du filetage	**6G+0,03**	**6H+0,1**
Trattamento superficiale - Surface treatment - Revêtement		

DIN 371	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE	
◀	**3**	**0,5**	56	10	3,5	2,7	3	2,5	-	E24M3+0,1
◀	**4**	**0,7**	63	13	4,5	3,4	3	3,3	-	E24M4+0,1
◀	**5**	**0,8**	70	13	6	4,9	3	4,2	E24M5-7G	E24M5+0,1
◀	**6**	**1**	80	16	6	4,9	3	5	E24M6-7G	E24M6+0,1
◀	**8**	**1,25**	90	18	8	6,2	3	6,8	E24M8-7G	E24M8+0,1
◀	**10**	**1,5**	100	20	10	8	3	8,5	E24M10-7G	E24M10+0,1

DIN 376	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE	
	12	**1,75**	110	25	9	7	3	10,3	E25M12-7G	E25M12+0,1

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min							
P	Acciaio - Steel - Acier - Rm ≤ 850 N/mm²	○1.1 10-15	•1.2 10-15	•1.3 10-12	○1.4 8-10	○1.1 10-15	•1.2 10-15	•1.3 10-12	○1.4 8- 10
K	Ghisa - Cast iron - Fonte								
N	Leghe di Allumino – Al alloys - Alliage Al	○4.1 10-15	•4.2 15-20			○4.1 10-15	•4.2 15-20		
N	Leghe di Rame - Copper alloys - Alliages de cuivre	○5.1 8-12	○5.2 10-15			○5.1 8-12	○5.2 10-15		

• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

M

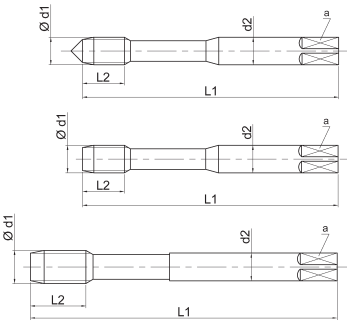
MASCHI A MACCHINA - Elicoidali 40° per fori ciechi tolleranza 6G+0,03 e 6H+0,1
MACHINE TAPS - Spiral flutes 40° for blind holes tolerance 6G+0,03 and 6H+0,1
TARAUDS MACHINE - Goujures hélicoïdales 40° pour trous borgnes tolérance 6G+0,03 et 6H+0,1

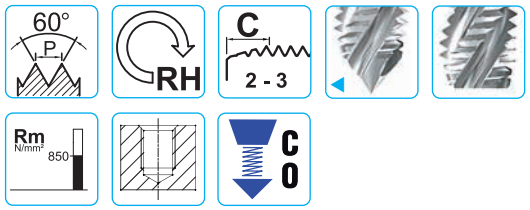
DIN13 USO GENERALE - GENERAL PURPOSE - USAGE GÉNÉRAL

DIN 371 d1 ≤ M6

DIN 371 d1 M8, M10

DIN 376 d1 ≥ M12





Profondità di filettatura - Thread depth - Prof. de filetage	**2,5xD**	**2,5xD**	
Materiale - Tool Material - Substrat	**HSSE**	**HSSE**	
Tolleranza - Thread tolerance - Tolérance du filetage	**6G+0,03**	**6H+0,1**	
Trattamento superficiale - Surface treatment - Revêtement			

DIN 371	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE		
◀	**3**	**0,5**	56	5	3,5	2,7	3	2,5	E60M3-7G	E60M3+0,1	
◀	**4**	**0,7**	63	7	4,5	3,4	3	3,3	E60M4-7G	E60M4+0,1	
◀	**5**	**0,8**	70	8	6	4,9	3	4,2	E60M5-7G	E60M5+0,1	
◀	**6**	**1**	80	10	6	4,9	3	5	E60M6-7G	E60M6+0,1	
	8	**1,25**	90	13	8	6,2	3	6,8	E60M8-7G	E60M8+0,1	
	10	**1,5**	100	15	10	8	3	8,5	E60M10-7G	E60M10+0,1	

DIN 376	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE		
	12	**1,75**	110	18	9	7	3	10,3	E61M12-7G	E61M12+0,1	
	14	**2**	110	20	11	9	3	12	E61M14-7G	E61M14+0,1	
	16	**2**	110	20	12	9	4	14	E61M16-7G	E61M16+0,1	
	18	**2,5**	125	25	14	11	4	15,5	E61M18-7G	E61M18+0,1	
	20	**2,5**	140	25	16	12	4	17,5	E61M20-7G	E61M20+0,1	

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min							
P	Acciaio - Steel - Acier - Rm ≤ 850 N/mm²	○1.1 10-15	•1.2 10-15	•1.3 10-12	○1.4 8-10	○1.1 10-15	•1.2 10-15	•1.3 10-12	○1.4 8-10
M	Acciaio inox - Stainless steel - Acier inoxydable								
K	Ghisa - Cast iron - Fonte								
N	Leghe di Allumino - Al alloys - Alliage Al	○4.1 10-15	•4.2 15-20			○4.1 10-15	•4.2 15-20		
N	Leghe di Rame - Copper alloys - Alliages de cuivre	○5.1 8-12	○5.2 10-15			○5.1 8-12	○5.2 10-15		

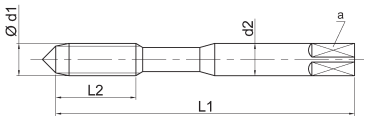
• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

M

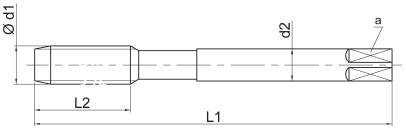
MASCHI A MACCHINA - Imbocco corretto per fori passanti
MACHINE TAPS - Straight flutes with spiral point for through holes
TARAUDS MACHINE - Goujures droites, entrée gun, pour trous débouchant

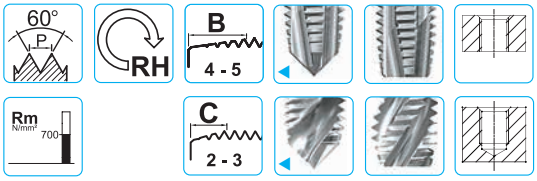
DIN13 | AL-CU-FE | ALLUMINIO, RAME, FERRO - ALUMINIUM, COPPER, IRON - ALUMINIUM, CUIVRE, FER

DIN 371 d1 ≤ M10



DIN 376 d1 ≥ M12





Profondità di filettatura - Thread depth - Prof. de filetage	3xD	3xD
Materiale - Tool Material - Substrat	HSSE	HSSE
Tolleranza - Thread tolerance - Tolérance du filetage	ISO2/6H	ISO2/6H
Trattamento superficiale - Surface treatment - Revêtement	TXC	TXC

DIN 371	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE	
◀	3	0,5	56	10	3,5	2,7	2	2,5	E24M3AL-TXC	E70M3TXC
◀	4	0,7	63	13	4,5	3,4	2	3,3	E24M4AL-TXC	E70M4TXC
◀	5	0,8	70	13	6	4,9	2	4,2	E24M5AL-TXC	E70M5TXC
◀	6	1	80	16	6	4,9	2	5	E24M6AL-TXC	E70M6TXC
◀	8	1,25	90	18	8	6,2	2	6,8	E24M8AL-TXC	E70M8TXC
◀	10	1,5	100	20	10	8	2	8,5	E24M10AL-TXC	E70M10TXC

DIN 376	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE	
	12	1,75	110	25	9	7	3	10,3	E25M12AL-TXC	E71M12TXC
	14	2	110	28	11	9	3	12	E25M14AL-TXC	E71M14TXC
	16	2	110	28	12	9	3	14	E25M16AL-TXC	E71M16TXC

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min					
P	Acciaio dolce magnetico - Magnetic soft steel Acier doux magnétique - Rm <400 N/mm²	•1.1 20-30			•1.1 20-30		
N	Leghe di Allumino - Al alloys - Alliage Al	•4.1 10-15	•4.3 20-25		•4.1 20-25	•4.2 25-30	○4.3 20-25
N	Leghe di Rame - Copper alloys - Alliages de cuivre	•5.1 8-12	•5.2 10-15		•5.1 15-20	•5.2 20-25	
S	Titanio puro - Pure titanium - Titane pur	•6.1 5-8					
S	Nichel puro - Pure nickel - Nickel pure	•7.1 6-8					
N	Materiali termoplastici - Thermoplastics - Thermoplastiques Truciolo lungo - Long chipping - Copeaux longue	•8.1 20-25					

• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

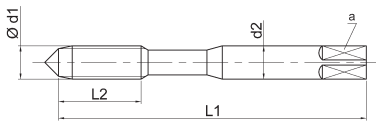
INOX | ACCIAIO INOSSIDABILE - STAINLESS STEEL - ACIER INOXYDABLE

M

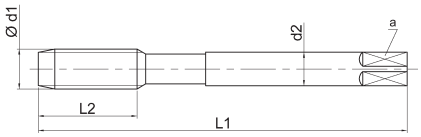
MASCHI A MACCHINA - Imbocco corretto per fori passanti
MACHINE TAPS - Straight flutes with spiral point for through holes
TARAUDS MACHINE - Goujures droites, entrée gun, pour trous débouchant

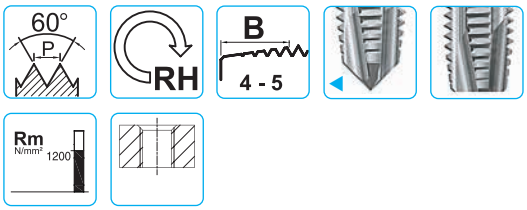
DIN13 | U | APPLICAZIONI UNIVERSALI - UNIVERSAL APPLICATIONS - USINAGE UNIVERSELS

DIN 371 d1 ≤ M10



DIN 376 d1 ≥ M12





Profondità di filettatura - Thread depth - Prof. de filetage	**3xD**	**3,5xD**
Materiale - Tool Material - Substrat	**PM3**	**PM3**
Tolleranza - Thread tolerance - Tolérance du filetage	**6HX**	**6HX**
Trattamento superficiale - Surface treatment - Revêtement	**XP**	**XP**

DIN 371	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE	
◀	**3**	**0,5**	56	10	3,5	2,7	3	2,5	K24M3XP	-
◀	**4**	**0,7**	63	13	4,5	3,4	3	3,3	K24M4XP	-
◀	**5**	**0,8**	70	13	6	4,9	3	4,2	K24M5XP	-
◀	**6**	**1**	80	16	6	4,9	3	5	K24M6XP	K24M6FORY-XP
◀	**8**	**1,25**	90	18	8	6,2	3	6,8	K24M8XP	K24M8FORY-XP
◀	**10**	**1,5**	100	20	10	8	3	8,5	K24M10XP	K24M10FORY-XP

DIN 376	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE	
	12	**1,75**	110	25	9	7	4	10,3	K25M12XP	K25M12FORY-XP
	14	**2**	110	28	11	9	4	12	K25M14XP	-
	16	**2**	110	28	12	9	4	14	K25M16XP	-
	18	**2,5**	125	33	14	11	4	15,5	K25M18XP	-
	20	**2,5**	140	33	16	12	4	17,5	K25M20XP	-

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min									
P	Acciaio - Steel - Acier - Rm ≤ 1200 N/mm²	○1.1 20-30	•1.2 20-30	•1.3 20-25	•1.4 15-20	•1.5 5-12	○1.1 20-30	•1.2 20-30	•1.3 20-25	•1.4 15-20	•1.5 5-12
M	Acciaio INOX – Stainless steel - Acier inoxydable	•2.1 10-15	•2.2 8-10	•2.3 6-8			•2.1 10-15	•2.2 8-10	•2.3 6-8		
K	Ghisa - Cast iron - Fonte	•3.3 10-15	•3.4 15-20				•3.3 10-15	•3.4 15-20			
N	Leghe di Allumino – Al alloys - Alliage Al	•4.2 25-30	•4.3 20-25				•4.2 25-30	•4.3 20-25			
N	Leghe di Rame - Copper alloys - Alliages de cuivre	•5.2 20-25					•5.2 20-25				

• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

M

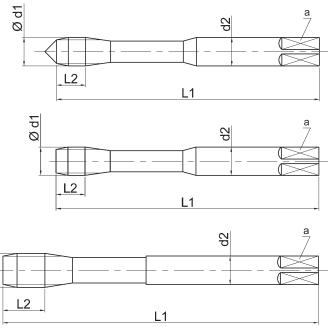
MASCHI A MACCHINA - Elicoidali 45° per fori ciechi
MACHINE TAPS - Spiral flutes 45° for blind holes
TARAUDS MACHINE - Goujures hélicoïdales 45° pour trous borgnes

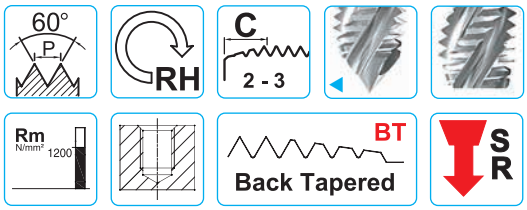
DIN13 | U | APPLICAZIONI UNIVERSALI - UNIVERSAL APPLICATIONS - USINAGE UNIVERSELS

DIN 371 d1 ≤ M6

DIN 371 d1 = M8, M10

DIN 376 d1 ≥ M12





Profondità di filettatura - Thread depth - Prof. de filetage	3xD	3,5xD
Materiale - Tool Material - Substrat	PM3	PM3
Tolleranza - Thread tolerance - Tolérance du filetage	6HX	6HX
Trattamento superficiale - Surface treatment - Revêtement	XP	XP

DIN 371	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z	
◀	3	0,5	56	5	3,5	2,7	3	2,5
◀	4	0,7	63	7	4,5	3,4	3	3,3
◀	5	0,8	70	8	6	4,9	3	4,2
◀	6	1	80	10	6	4,9	3	5
	8	1,25	90	13	8	6,2	3	6,8
	10	1,5	100	15	10	8	3	8,5

CODE	
K82M3XP	-
K82M4XP	-
K82M5XP	-
K82M6XP	K82M6FOR-XP
K82M8XP	K82M8FOR-XP
K82M10XP	K82M10FOR-XP

DIN 376	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z	
	12	1,75	110	18	9	7	4	10,3
	14	2	110	20	11	9	4	12
	16	2	110	20	12	9	4	14
	18	2,5	125	25	14	11	4	15,5
	20	2,5	140	25	16	12	4	17,5

CODE	
K83M12XP	K83M12FOR-XP
K83M14XP	K83M14FOR-XP
K83M16XP	K83M16FOR-XP
K83M18XP	K83M18FOR-XP
K83M20XP	K83M20FOR-XP

S R Raccomandato per filettatura rigida
We recommend Syncro rigid threading
Recommandè pour le taraudage rigide

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min									
P	Acciaio - Steel - Acier - Rm ≤ 1200 N/mm²	○1.1 20-30	•1.2 20-30	•1.3 20-25	•1.4 15-20	•1.5 5-12	○1.1 20-30	•1.2 20-30	•1.3 20-25	•1.4 15-20	•1.5 5-12
M	Acciaio inox - Stainless steel - Acier inoxydable	•2.1 10-15	•2.2 8-10	•2.3 6-8			•2.1 10-15	•2.2 8-10	•2.3 6-8		
K	Ghisa - Cast iron - Fonte	•3.3 10-15	•3.4 15-20				•3.3 10-15	•3.4 15-20			
N	Leghe di Allumino - Al alloys - Alliage Al	•4.2 25-30	•4.3 20-25				•4.2 25-30	•4.3 20-25			
N	Leghe di Rame - Copper alloys - Alliages de cuivre Truciolo lungo - Long chipping - Copeaux longs	•5.2 20-25					•5.2 20-25				

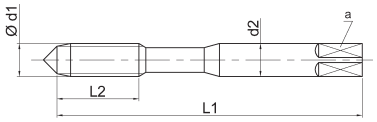
• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

M

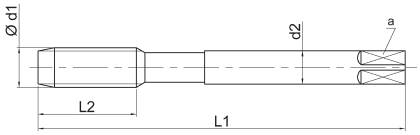
MASCHI A MACCHINA - Imbocco corretto per fori passanti
MACHINE TAPS - Straight flutes with spiral point for through holes
TARAUDS MACHINE - Goujures droites, entrée gun, pour trous débouchant

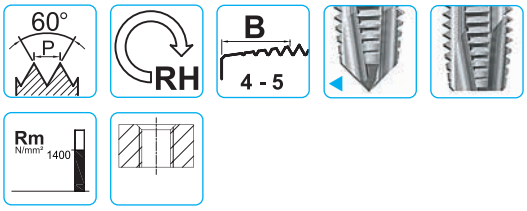
DIN13 | INOX | ACCIAIO INOSSIDABILE - STAINLESS STEEL - ACIER INOXYDABLE

DIN 371 d1 ≤ M10



DIN 376 d1 ≥ M12





Profondità di filettatura - Thread depth - Prof. de filetage	3xD	3xD
Materiale - Tool Material - Substrat	HSSV3	HSSV3
Tolleranza - Thread tolerance - Tolérance du filetage	6HX	6HX
Trattamento superficiale - Surface treatment - Revêtement	VS	TXC

DIN 371	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE	
◀	3	0,5	56	10	3,5	2,7	3	2,5	V24M3VS	V24M3TXC
◀	4	0,7	63	13	4,5	3,4	3	3,3	V24M4VS	V24M4TXC
◀	5	0,8	70	13	6	4,9	3	4,2	V24M5VS	V24M5TXC
◀	6	1	80	16	6	4,9	3	5	V24M6VS	V24M6TXC
◀	8	1,25	90	18	8	6,2	3	6,8	V24M8VS	V24M8TXC
◀	10	1,5	100	20	10	8	3	8,5	V24M10VS	V24M10TXC

DIN 376	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE	
	12	1,75	110	25	9	7	4	10,3	V25M12VS	V25M12TXC
	14	2	110	28	11	9	4	12	V25M14VS	V25M14TXC
	16	2	110	28	12	9	4	14	V25M16VS	V25M16TXC
	18	2,5	125	33	14	11	4	15,5	V25M18VS	V25M18TXC
	20	2,5	140	33	16	12	4	17,5	V25M20VS	V25M20TXC

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min							
P	Acciaio - Steel - Acier - Rm ≤ 1400 N/mm²	•1.1 10-15	•1.2 10-15		•1.3 20-25	•1.4 15-20	○1.5 5-12		
M	Acciaio INOX – Stainless steel - Acier inoxydable	•2.1 6-8	•2.2 5-7	•2.3 3-5	•2.1 10-15	•2.2 8-10	•2.3 6-8	○2.4 3-6	

• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

M

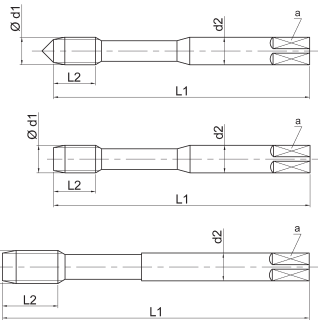
MASCHI A MACCHINA - Elicoidali 45°/48° per fori ciechi
MACHINE TAPS - Spiral flutes 45°/48° for blind holes
TARAUDS MACHINE - Goujures hélicoïdales 45°/48° pour trous borgnes

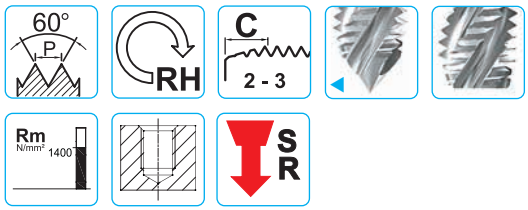
DIN13 | INOX | ACCIAIO INOSSIDABILE - STAINLESS STEEL - ACIER INOXYDABLE

DIN 371 d1 ≤ M6

DIN 371 d1 = M8, M10

DIN 376 d1 ≥ M12





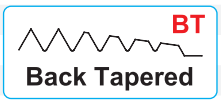
Profondità di filettatura - Thread depth - Prof. de filetage	3xD	3,5xD	3,5xD
Materiale - Tool Material - Substrat	HSSE-PM	HSSV3	HSSV3
Tolleranza - Thread tolerance - Tolérance du filetage	6HX	6HX	6HX
Trattamento superficiale - Surface treatment - Revêtement	VS	TXC	TXC

DIN 371	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z	
◀	3	0,5	56	5	3,5	2,7	3	2,5
◀	4	0,7	63	7	4,5	3,4	3	3,3
◀	5	0,8	70	8	6	4,9	3	4,2
◀	6	1	80	10	6	4,9	3	5
	8	1,25	90	13	8	6,2	3	6,8
	10	1,5	100	15	10	8	3	8,5

CODE		
E92M3VS	V82M3TXC	-
E92M4VS	V82M4TXC	-
E92M5VS	V82M5TXC	-
E92M6VS	V82M6TXC	V82M6FOR-TXC
E92M8VS	V82M8TXC	V82M8FOR-TXC
E92M10VS	V82M10TXC	V82M10FOR-TXC

DIN 376	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z	
	12	1,75	110	18	9	7	3	10,3
	14	2	110	20	11	9	3	12
	16	2	110	20	12	9	4	14
	18	2,5	125	25	14	11	4	15,5
	20	2,5	140	25	16	12	4	17,5

CODE		
E93M12VS	V83M12TXC	V83M12FOR-TXC
E93M14VS	V83M14TXC	V83M14FOR-TXC
E93M16VS	V83M16TXC	V83M16FOR-TXC
E93M18VS	V83M18TXC	-
E93M20VS	V83M20TXC	-



ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min										
P	Acciaio - Steel - Acier - Rm ≤ 1400 N/mm²	•1.1 10-15	•1.2 10-15			•1.3 20-25	•1.4 15-20	•1.5 5-12		•1.3 20-25	•1.4 15-20	•1.5 5-12	
M	Acciaio INOX - Stainless steel - Acier inoxydable	•2.1 6-8	•2.2 5-7	•2.3 3-5		•2.1 10-15	•2.2 8-10	•2.3 6-8	○2.4 3-6	•2.1 10-15	•2.2 8-10	•2.3 6-8	○2.4 3-6

• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

HR | ALTA RESISTENZA - HIGH RESISTANCE - HAUTE RÉSISTANCE

M

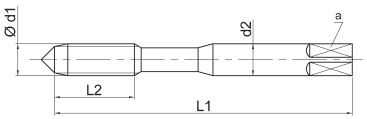
MASCHI A MACCHINA - Per fori ciechi e passanti con canalini di lubrificazione
MACHINE TAPS - For blind and through holes with oil grooves
TARAUDS MACHINE - Pour trous borgnes et débouchant avec rainures de lubrification

DIN13 | P - ROLL | MASCHI A RULLARE - ROLL FORM TAPS - TARAUDS À REFOULER

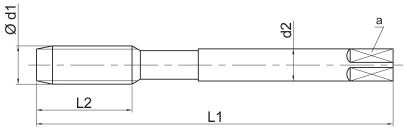
UFS ROLL

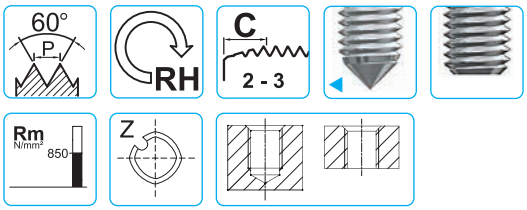
Rm < 850 Nm/m²

DIN 371 d1 ≤ M10



DIN 376 d1 ≥ M12





Profondità di filettatura - Thread depth - Prof. de filetage	**3xD**		
Materiale - Tool Material - Substrat	**PM8**		
Tolleranza - Thread tolerance - Tolérance du filetage	**6HX**		
Trattamento superficiale - Surface treatment - Revêtement	**TiN**		

DIN 371	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z	
◀	**3**	**0,5**	56	10	3,5	2,7	2	2,80
◀	**4**	**0,7**	63	13	4,5	3,4	4	3,70
◀	**5**	**0,8**	70	13	6	4,9	5	4,65
◀	**6**	**1**	80	16	6	4,9	5	5,55
◀	**8**	**1,25**	90	18	8	6,2	5	7,40
◀	**10**	**1,5**	100	20	10	8	5	9,30

CODE		
P2CCM3T		
P2CCM4T		
P2CCM5T		
P2CCM6T		
P2CCM8T		
P2CCM10T		

DIN 376	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z	
	12	**1,75**	110	25	9	7	5	11,20
	14	**2**	110	28	11	9	6	13,10
	16	**2**	110	28	12	9	6	15,10

CODE		
P2CCM12T		
P2CCM14T		
P2CCM16T		

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min			
P	Acciaio - Steel - Acier - Rm ≤ 850 N/mm²	•1.1 20-30	•1.2 20-30	•1.3 20-25	○1.4 15-20
M	Acciaio INOX – Stainless steel - Acier inoxydable	○2.1 10-15	○2.2 10-12	○2.3 6-10	
N	Leghe di Allumino – Al alloys - Alliage Al	○4.1 35-40	○4.2 40-45	○4.3 35-40	
N	Leghe di Rame - Copper alloys - Alliages de cuivre	○5.1 15-20	○5.2 15-20		

• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

M

MASCHI A MACCHINA - Per fori ciechi e passanti con canalini di lubrificazione
MACHINE TAPS - For blind and through holes with oil grooves
TARAUDS MACHINE - Pour trous borgnes et débouchant avec rainures de lubrification

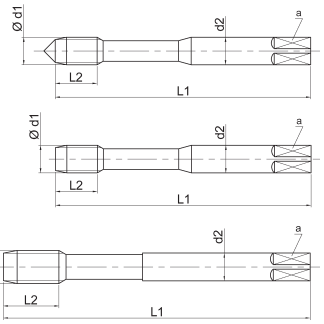
DIN13 | K-ROLL | MASCHI A RULLARE - ROLL FORM TAPS - TARAUDS À REFOULER

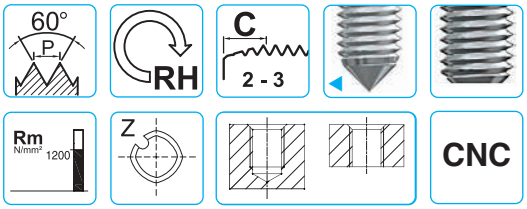
Rm < 1200 Nm/m²

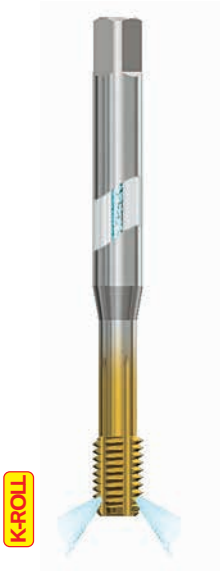
DIN 371 d1 ≤ M5

DIN 371 d1 ≤ M10

DIN 376 d1 ≥ M12







Profondità di filettatura - Thread depth - Prof. de filetage	3xD	3xD	3xD
Materiale - Tool Material - Substrat	PM8	PM8	PM8
Tolleranza - Thread tolerance - Tolérance du filetage	6HX	6HX	6HX
Trattamento superficiale - Surface treatment - Revêtement	TiN-G	TiN-G	TiN-G

DIN 371	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE		
◀	3	0,5	56	5	3,5	2,7	4	2,80	K2CCM3TG		
◀	4	0,7	63	7	4,5	3,4	4	3,70	K2CCM4TG		
◀	5	0,8	70	8	6	4,9	5	4,65	K2CCM5TG		
	6	1	80	10	6	4,9	5	5,55	K2CCM6TG	K2CCM6FOR-TG	K2CCM6FORY-TG
	8	1,25	90	13	8	6,2	5	7,40	K2CCM8TG	K2CCM8FOR-TG	K2CCM8FORY-TG
	10	1,5	100	15	10	8	8	9,30	K2CCM10TG	K2CCM10FOR-TG	K2CCM10FORY-TG

DIN 376	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE		
New	12	1,75	110	18	9	7	8	11,20	K2CCM12TG	K2CCM12FOR-TG	K2CCM12FORY-TG
New	14	2	110	20	11	9	8	13,10	K2CCM14TG	K2CCM14FOR-TG	K2CCM14FORY-TG
New	16	2	110	20	12	9	8	15,10	K2CCM16TG	K2CCM16FOR-TG	K2CCM16FORY-TG
New	18	2,5	125	25	14	11	8	16,9	K2CCM18TG	K2CCM18FOR-TG	K2CCM18FORY-TG
New	20	2,5	140	25	16	12	8	18,9	K2CCM20TG	K2CCM20FOR-TG	K2CCM20FORY-TG

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min								
P	Acciaio - Steel - Acier - Rm ≤ 1200 N/mm²	•1.3 30-35	•1.4 25-30	•1.5 15-20	•1.3 30-35	•1.4 25-30	•1.5 15-20	•1.3 30-35	•1.4 25-30	•1.5 15-20
M	Acciaio INOX - Stainless steel - Acier inoxydable	○2.2 10-12	○2.3 6-10	○2.4 6-8	○2.2 10-12	○2.3 6-10	○2.4 6-8	○2.2 10-12	○2.3 6-10	○2.4 6-8

• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

TOP UFS

MJ UNJC UNJF AVIO

DIAMETRO ESTERNO ARROTONDATO
WITH ROUNDED CREST
DIAMÈTRE EXTÉRIEUR ARRONDI

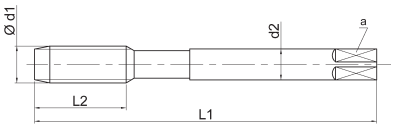
Ni | NICHEL - NICKEL

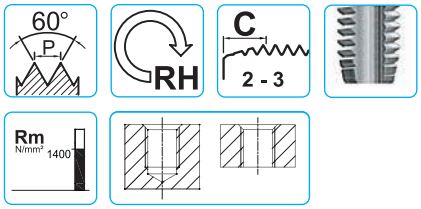
MF

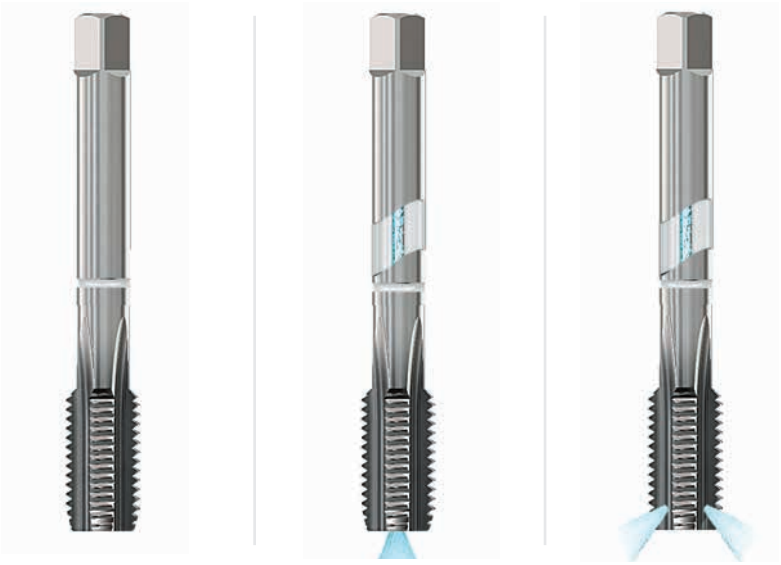
MASCHI A MACCHINA - Scanalature diritte per ghisa
MACHINE TAPS - Straight flutes for cast iron
TARAUDS MACHINE - Goujures droites pour fonte

DIN13 | GG | GHISA - CAST IRON - FONTE

DIN 374 d1 ≥ M8







Profondità di filettatura - Thread depth - Prof. de filetage	**3xD**	**3,5xD**	**3,5xD**
Materiale - Tool Material - Substrat	**PM3**	**PM3**	**PM3**
Tolleranza - Thread tolerance - Tolérance du filetage	**6HX**	**6HX**	**6HX**
Trattamento superficiale - Surface treatment - Revêtement	**TiALn**	**TiALn**	**TiALn**

DIN 374	Ød1 MF	P mm	L_1	L_2	d_2 h9	a h12	Z	
	8	**1**	90	18	6	4,9	4	7
	10	**1**	90	15	7	5,5	4	9
	10	**1,25**	100	20	7	5,5	4	8,75
	12	**1,25**	100	22	9	7	4	10,75
	12	**1,5**	100	22	9	7	4	10,5
	14	**1,5**	100	22	11	9	4	12,5
	16	**1,5**	100	22	12	9	4	14,5
	18	**1,5**	110	25	14	11	5	16,5
	20	**1,5**	125	25	16	12	5	18,5

CODE		
K27MF8X1TX	K27MF8X1FOR-TX	K27MF8X1FORY-TX
K27MF10X1TX	K27MF10X1FOR-TX	K27MF10X1FORY-TX
K27MF10X1,25TX	K27MF10X1,25FOR-TX	K27MF10X1,25FORY-TX
K27MF12X1,25TX	K27MF12X1,25FOR-TX	K27MF12X1,25FORY-TX
K27MF12X1,5TX	K27MF12X1,5FOR-TX	K27MF12X1,5FORY-TX
K27MF14X1,5TX	K27MF14X1,5FOR-TX	K27MF14X1,5FORY-TX
K27MF16X1,5TX	K27MF16X1,5FOR-TX	K27MF16X1,5FORY-TX
K27MF18X1,5TX	K27MF18X1,5FOR-TX	K27MF18X1,5FORY-TX
K27MF20X1,5TX	K27MF20X1,5FOR-TX	K27MF20X1,5FORY-TX

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min														
K	Ghisa - Cast iron - Fonte	•3.1 25-30	•3.2 20-25	○3.3 20-25	○3.4 25-30	•3.5 10-15	•3.1 25-30	•3.2 20-25	○3.3 20-25	○3.4 25-30	•3.5 10-15	•3.1 25-30	•3.2 20-25	○3.3 20-25	○3.4 25-30	•3.5 10-15

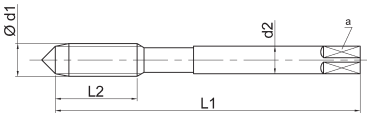
• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

MF

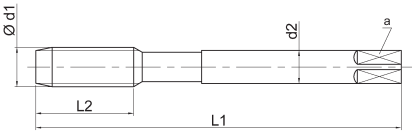
MASCHI A MACCHINA - Imbocco corretto per fori passanti
MACHINE TAPS - Straight flutes with spiral point for through holes
TARAUDS MACHINE - Goujures droites, entrée gun, pour trous débouchant

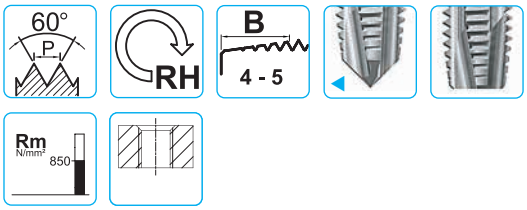
DIN13 | USO GENERALE - GENERAL PURPOSE - USAGE GÉNÉRAL

DIN 374 d1 ≤ M10



DIN 374 d1 ≥ M12





Profondità di filettatura - Thread depth - Prof. de filetage	3xD	3xD	3xD
Materiale - Tool Material - Substrat	HSSE	HSSE	HSSE
Tolleranza - Thread tolerance - Tolérance du filetage	ISO2/6H	ISO2/6H	ISO2/6H
Trattamento superficiale - Surface treatment - Revêtement		V	TiN

DIN 374	Ød1 MF	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE		
◀	8	1	90	18	6	4,9	3	7	E25MF8X1	E25MF8X1V	E25MF8X1T
◀	10	1,25	100	20	7	5,5	3	8,75	E25MF10X1,25	E25MF10X1,25V	E25MF10X1,25T
◀	12	1,25	100	22	9	7	3	10,75	E25MF12X1,25	E25MF12X1,25V	E25MF12X1,25T
	12	1,5	100	22	9	7	3	10,5	E25MF12X1,5	E25MF12X1,5V	E25MF12X1,5T
	14	1,5	100	22	11	9	4	12,5	E25MF14X1,5	E25MF14X1,5V	E25MF14X1,5T
	16	1,5	100	22	12	9	4	14,5	E25MF16X1,5	E25MF16X1,5V	E25MF16X1,5T
	18	1,5	110	25	14	11	4	16,5	E25MF18X1,5	E25MF18X1,5V	E25MF18X1,5T
	20	1,5	125	25	16	12	4	18,5	E25MF20X1,5	E25MF20X1,5V	E25MF20X1,5T

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min											
P	Acciaio - Steel - Acier - Rm ≤ 850 N/mm²	○1.1 10-15	•1.2 10-15	•1.3 10-12	○1.4 8-10	•1.1 10-15	•1.2 10-15	•1.3 10-12	○1.4 8-10	•1.1 20-30	•1.2 20-30	•1.3 20-25	•1.4 15-20
M	Acciaio inox - Stainless steel - Acier inoxydable												
K	Ghisa - Cast iron - Fonte									○3.3 10-15	•3.4 15-20		
N	Leghe di Allumino - Al alloys - Alliage Al	○4.1 10-15	•4.2 15-20			•4.1 10-15	•4.2 15-20			○4.1 20-25	•4.2 25-30	○4.3 20-25	
N	Leghe di Rame - Copper alloys - Alliages de cuivre	○5.1 8-12	○5.2 10-15			•5.1 8-12	•5.2 10-15			○5.1 15-20	•5.2 20-25		

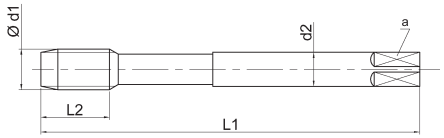
• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

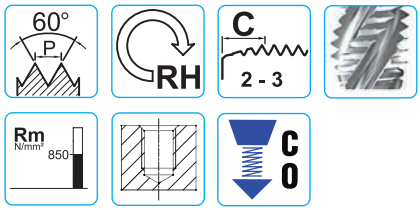
MF

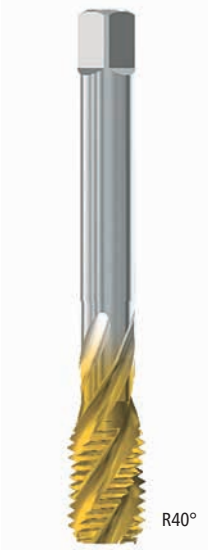
MASCHI A MACCHINA - Elica destra a 40° per fori ciechi
MACHINE TAPS - Spiral flutes 40° for blind holes
TARAUDS MACHINE - Goujures hélicoïdales 40° pour trous borgnes

DIN13 | USO GENERALE - GENERAL PURPOSE - USAGE GÉNÉRAL

DIN 374







Profondità di filettatura - Thread depth - Prof. de filetage	**2,5xD**	**2,5xD**	**2,5xD**
Materiale - Tool Material - Substrat	**HSSE**	**HSSE**	**HSSE**
Tolleranza - Thread tolerance - Tolérance du filetage	**ISO2/6H**	**ISO2/6H**	**ISO2/6H**
Trattamento superficiale - Surface treatment - Revêtement		**V**	**TiN**

DIN 374	Ød1 MF	P mm	L_1	L_2	d_2 h9	a h12	Z	
	8	**1**	90	13	6	4,9	3	7
	10	**1,25**	100	15	7	5,5	3	8,75
	12	**1,25**	100	13	9	7	3	10,75
	12	**1,5**	100	13	9	7	3	10,5
	14	**1,5**	100	15	11	9	4	12,5
	16	**1,5**	100	15	12	9	4	14,5
	18	**1,5**	110	17	14	11	4	16,5
	20	**1,5**	125	17	16	12	4	18,5

CODE		
E61MF8X1	E61MF8X1V	E61MF8X1T
E61MF10X1,25	E61MF10X1,25V	E61MF10X1,25T
E61MF12X1,25	E61MF12X1,25V	E61MF12X1,25T
E61MF12X1,5	E61MF12X1,5V	E61MF12X1,5T
E61MF14X1,5	E61MF14X1,5V	E61MF14X1,5T
E61MF16X1,5	E61MF16X1,5V	E61MF16X1,5T
E61MF18X1,5	E61MF18X1,5V	E61MF18X1,5T
E61MF20X1,5	E61MF20X1,5V	E61MF20X1,5T

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min											
P	Acciaio - Steel - Acier - Rm ≤ 850 N/mm²	○1.1 10-15	•1.2 10-15	•1.3 10-12	○1.4 8-10	•1.1 10-15	•1.2 10-15	•1.3 10-12	○1.4 8-10	•1.1 20-30	•1.2 20-30	•1.3 20-25	•1.4 15-20
M	Acciaio inox - Stainless steel - Acier inoxydable												
K	Ghisa - Cast iron - Fonte									○3.3 10-15	•3.4 15-20		
N	Leghe di Allumino - Al alloys - Alliage Al	○4.1 10-15	•4.2 15-20			•4.1 10-15	•4.2 15-20			○4.1 20-25	•4.2 25-30	○4.3 20-25	
N	Leghe di Rame - Copper alloys - Alliages de cuivre	○5.1 8-12	○5.2 10-15			•5.1 8-12	•5.2 10-15			○5.1 15-20	•5.2 20-25		

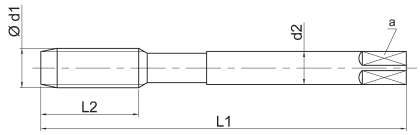
• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

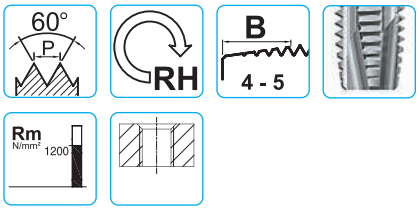
MF

MASCHI A MACCHINA - Imbocco corretto per fori passanti
MACHINE TAPS - Straight flutes with spiral point for through holes
TARAUDS MACHINE - Goujures droites, entrée gun, pour trous débouchant

DIN13 | U | APPLICAZIONI UNIVERSALI - UNIVERSAL APPLICATIONS - USINAGE UNIVERSELS

DIN 374





Profondità di filettatura - Thread depth - Prof. de filetage	**3xD**	**3,5xD**
Materiale - Tool Material - Substrat	**PM3**	**PM3**
Tolleranza - Thread tolerance - Tolérance du filetage	**6HX**	**6HX**
Trattamento superficiale - Surface treatment - Revêtement	**XP**	**XP**

DIN 374	Ød1 MF	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE	
	8	**1**	90	18	6	4,9	3	7	K25MF8X1XP	K25MF8X1FORY-XP
	10	**1,25**	100	20	7	5,5	3	8,75	K25MF10X1,25XP	K25MF10X1,25FORY-XP
	12	**1,5**	100	22	9	7	4	10,5	K25MF12X1,5XP	K25MF12X1,5FORY-XP
	14	**1,5**	100	22	11	9	4	12,5	K25MF14X1,5XP	K25MF14X1,5FORY-XP
	16	**1,5**	100	22	12	9	4	14,5	K25MF16X1,5XP	K25MF16X1,5FORY-XP
	18	**1,5**	110	25	14	11	4	16,5	K25MF18X1,5XP	K25MF18X1,5FORY-XP
	20	**1,5**	125	25	16	12	4	18,5	K25MF20X1,5XP	K25MF20X1,5FORY-XP

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min								
P	Acciaio - Steel - Acier - Rm ≤ 1200 N/mm²	❍1.1 20-30	•1.2 20-30	•1.3 20-25	•1.4 15-20	•1.5 5-12	•1.2 20-30	•1.3 20-25	•1.4 15-20	❍1.5 5-12
M	Acciaio INOX - Stainless steel - Acier inoxydable	•2.1 10-15	•2.2 8-10	•2.3 6-8						
K	Ghisa - Cast iron - Fonte	•3.3 10-15	•3.4 15-20				•3.3 10-15	•3.4 15-20		
N	Leghe di Allumino - Al alloys - Alliage Al	•4.2 25-30	•4.3 20-25				•4.3 20-25			
N	Leghe di Rame - Copper alloys - Alliages de cuivre Truciolo lungo - Long chipping - Copeaux longs	•5.2 20-25					•5.2 20-25			

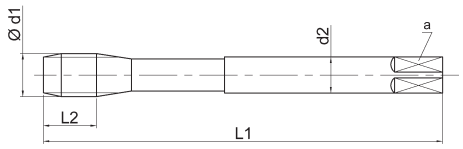
• Raccomandato - Optimal - Recommandé ❍ Adatto - Suitable - Adaptè

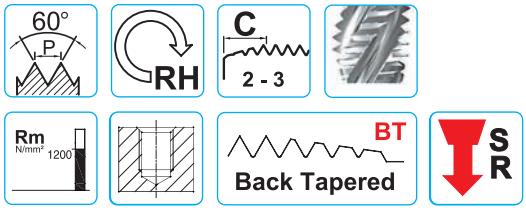
MF

MASCHI A MACCHINA - Elicoidali 45° per fori ciechi
MACHINE TAPS - Spiral flutes 45° for blind holes
TARAUDS MACHINE - Goujures hélicoïdales 45° pour trous borgnes

DIN13 | U | APPLICAZIONI UNIVERSALI - UNIVERSAL APPLICATIONS - USINAGE UNIVERSELS

DIN 374





Profondità di filettatura - Thread depth - Prof. de filetage	**3xD**	**3,5xD**
Materiale - Tool Material - Substrat	**PM3**	**PM3**
Tolleranza - Thread tolerance - Tolérance du filetage	**6HX**	**6HX**
Trattamento superficiale - Surface treatment - Revêtement	**XP**	**XP**

DIN 374	Ød1 MF	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE	
	8	**1**	90	13	6	4,9	3	7	K83MF8X1XP	K83MF8X1FOR-XP
	10	**1,25**	100	15	7	5,5	3	8,75	K83MF10X1,25XP	K83MF10X1FOR-XP
	12	**1,5**	100	13	9	7	4	10,5	K83MF12X1,5XP	K83MF12X1FOR-XP
	14	**1,5**	100	15	11	9	4	12,5	K83MF14X1,5XP	K83MF14X1,5FOR-XP
	16	**1,5**	100	15	12	9	4	14,5	K83MF16X1,5XP	K83MF16X1,5FOR-XP
	18	**1,5**	110	17	14	11	4	16,5	K83MF18X1,5XP	K83MF18X1,5FOR-XP
	20	**1,5**	125	17	16	12	4	18,5	K83MF20X1,5XP	K83MF20X1,5FOR-XP

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min									
P	Acciaio - Steel - Acier - Rm ≤ 1200 N/mm²	○1.1 20-30	•1.2 20-30	•1.3 20-25	•1.4 15-20	•1.5 5-12	○1.1 20-30	•1.2 20-30	•1.3 20-25	•1.4 15-20	•1.5 5-12
M	Acciaio INOX - Stainless steel - Acier inoxydable	•2.1 10-15	•2.2 8-10	•2.3 6-8			•2.1 10-15	•2.2 8-10	•2.3 6-8		
K	Ghisa - Cast iron - Fonte	•3.3 10-15	•3.4 15-20				•3.3 10-15	•3.4 15-20			
N	Leghe di Allumino - Al alloys - Alliage Al	•4.2 25-30	•4.3 20-25				•4.2 25-30	•4.3 20-25			
N	Leghe di Rame - Copper alloys - Alliages de cuivre Truciolo lungo - Long chipping - Copeaux longs	•5.2 20-25					•5.2 20-25				

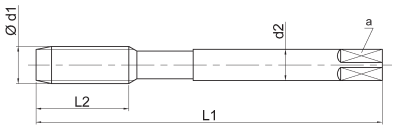
• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

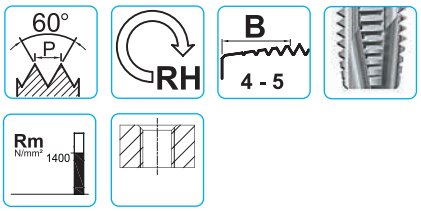
MF

MASCHI A MACCHINA - Imbocco corretto per fori passanti
MACHINE TAPS - Straight flutes with spiral point for through holes
TARAUDS MACHINE - Goujures droites, entrée gun, pour trous débouchant

DIN13 | INOX | ACCIAIO INOSSIDABILE - STAINLESS STEEL - ACIER INOXYDABLE

DIN 374





	LINE	TOP
Profondità di filettatura - Thread depth - Prof. de filetage	3xD	3xD
Materiale - Tool Material - Substrat	HSSV3	HSSV3
Tolleranza - Thread tolerance - Tolérance du filetage	6HX	6HX
Trattamento superficiale - Surface treatment - Revêtement	VS	TXC

DIN 374	Ød1 MF	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE	
	8	1	90	18	6	4,9	3	7	V25MF8X1VS	V25MF8X1TXC
	10	1,25	100	20	7	5,5	3	8,75	V25MF10X1,25VS	V25MF10X1,25TXC
	12	1,5	100	22	9	7	4	10,5	V25MF12X1,5VS	V25MF12X1,5TXC
	14	1,5	100	22	11	9	4	12,5	V25MF14X1,5VS	V25MF14X1,5TXC
	16	1,5	100	22	12	9	4	14,5	V25MF16X1,5VS	V25MF16X1,5TXC

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min							
P	Acciaio - Steel - Acier - Rm < 1400 N/mm²	•1.1 10-15	•1.2 10-15			•1.3 20-25	•1.4 15-20	○1.5 5-12	
M	Acciaio INOX – Stainless steel - Acier inoxydable	•2.1 6-8	•2.2 5-7	•2.3 3-5		•2.1 10-15	•2.2 8-10	•2.3 6-8	○2.4 3-6

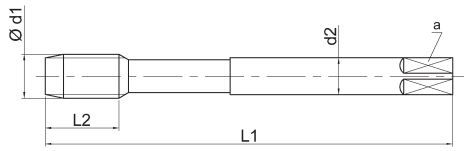
• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

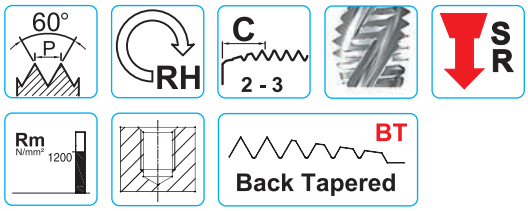
MF

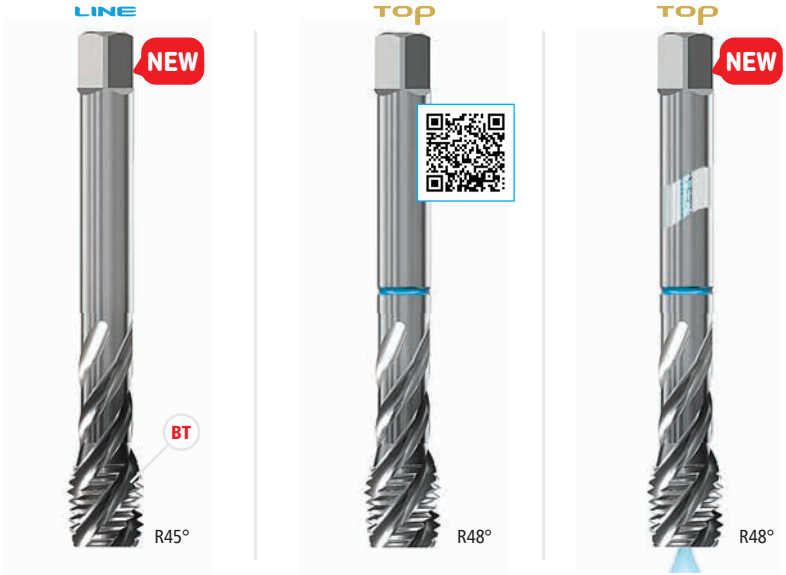
MASCHI A MACCHINA - Elicoidali 45°/48° per fori ciechi
MACHINE TAPS - Spiral flutes 45°/48° for blind holes
TARAUDS MACHINE - Goujures hélicoïdales 45°/48° pour trous borgnes

DIN13 | INOX | ACCIAIO INOSSIDABILE - STAINLESS STEEL - ACIER INOXYDABLE

DIN 374







Profondità di filettatura - Thread depth - Prof. de filetage	**3xD**	**3,5xD**	**3,5xD**
Materiale - Tool Material - Substrat	**HSSE**	**HSSV3**	**HSSV3**
Tolleranza - Thread tolerance - Tolérance du filetage	**6HX**	**6HX**	**6HX**
Trattamento superficiale - Surface treatment - Revêtement	**VS**	**TXC**	**TXC**

DIN 374	Ød1 MF	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE		
	8	**1**	90	13	6	4,9	3	7	E93MF8X1VS	V83MF8X1TXC	V83MF8X1FOR-TXC
	10	**1,25**	100	15	7	5,5	3	8,75	E93MF10X1,25VS	V83MF10X1,25TXC	V83MF10X1,25FOR-TXC
	12	**1,5**	100	13	9	7	4	10,5	E93MF12X1,5VS	V83MF12X1,5TXC	V83MF12X1,5FOR-TXC
	14	**1,5**	100	15	11	9	4	12,5	E93MF14X1,5VS	V83MF14X1,5TXC	V83MF14X1,5FOR-TXC
	16	**1,5**	100	15	12	9	4	14,5	E93MF16X1,5VS	V83MF16X1,5TXC	V83MF16X1,5FOR-TXC
	18	**1,5**	110	17	14	11	4	16,5	-	V83MF18X1,5TXC	-
	20	**1,5**	125	17	16	12	4	18,5	-	V83MF20X1,5TXC	-

BT
Back Tapered

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min											
P	Acciaio - Steel - Acier - Rm < 1200 N/mm²	•1.1 20-25	•1.2 15-20			•1.3 20-25	•1.4 15-20	○1.5 5-12		•1.3 20-25	•1.4 15-20	○1.5 5-12	
M	Acciaio INOX – Stainless steel - Acier inoxydable	•2.1 6-8	•2.2 5-7	•2.3 3-5		•2.1 10-15	•2.2 8-10	•2.3 6-8	○2.4 3-6	•2.1 10-15	•2.2 8-10	•2.3 6-8	•2.4 3-6

• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

MF

MASCHI A MACCHINA - Per fori ciechi e passanti con canalini di lubrificazione
MACHINE TAPS - For blind and through holes with oil grooves
TARAUDS MACHINE - Pour trous borgnes et débouchant avec rainures de lubrification

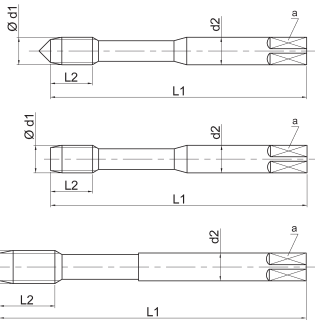
DIN13 | K-ROLL | MASCHI A RULLARE - ROLL FORM TAPS - TARAUDS À REFOULER

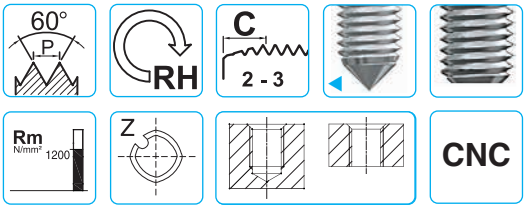
Rm < 1200 Nm/m²

DIN 371 d1 ≤ M5

DIN 371 d1 ≤ M10

DIN 374 d1 ≥ M12





Profondità di filettatura - Thread depth - Prof. de filetage	3xD	3xD	3xD
Materiale - Tool Material - Substrat	PM8	PM8	PM8
Tolleranza - Thread tolerance - Tolérance du filetage	6HX	6HX	6HX
Trattamento superficiale - Surface treatment - Revêtement	TiN-G	TiN-G	TiN-G

DIN 371	Ød1 MF	P mm	L_1	L_2	d_2 h9	a h12	Z	
◀	4	0,5	63	7	4,5	3,4	4	3,80
◀	5	0,5	70	8	6	4,9	5	4,80
	6	0,75	80	10	6	4,9	5	5,65
	8	1	90	13	8	6,2	5	7,55
	10	1,25	100	15	10	8	8	9,40

CODE		
K2CCMF4X0,5TG		
K2CCMF5X0,5TG		
K2CCMF6X0,75TG		
K2CCMF8X1TG	K2CCMF8X1FOR-TG	K2CCMF8X1FORY-TG
K2CCMF10X1,25TG	K2CCMF10X1,25FOR-TG	K2CCMF10X1,25FORY-TG

DIN 374	Ød1 MF	P mm	L_1	L_2	d_2 h9	a h12	Z	
	12	1,5	100	15	9	7	8	11,30
	14	1,5	100	15	11	9	8	13,30
	16	1,5	100	15	12	9	8	15,30
New	18	1,5	110	17	14	11	8	17,30
New	20	1,5	125	17	16	12	8	19,30

CODE		
K2CCMF12X1,5TG	K2CCMF12X1,5FOR-TG	K2CCMF12X1,5FORY-TG
K2CCMF14X1,5TG	K2CCMF14X1,5FOR-TG	K2CCMF14X1,5FORY-TG
K2CCMF16X1,5TG	K2CCMF16X1,5FOR-TG	K2CCMF16X1,5FORY-TG
K2CCMF18X1,5TG	K2CCMF18X1,5FOR-TG	K2CCMF18X1,5FORY-TG
K2CCMF20X1,5TG	K2CCMF20X1,5FOR-TG	K2CCMF20X1,5FORY-TG

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min								
P	Acciaio - Steel - Acier - Rm ≤ 1200 N/mm²	•1.3 35-50	•1.4 25-30	•1.5 15-20	•1.3 35-50	•1.4 25-30	•1.5 15-20	•1.3 35-50	•1.4 25-30	•1.5 15-20
M	Acciaio INOX - Stainless steel - Acier inoxydable	ↄ2.2 10-12	ↄ2.3 6-10	ↄ2.4 6-8	ↄ2.2 10-12	ↄ2.3 6-10	ↄ2.4 6-8	ↄ2.2 10-12	ↄ2.3 6-10	ↄ2.4 6-8

• Raccomandato - Optimal - Recommandé ↄ Adatto - Suitable - Adaptè


s-plus

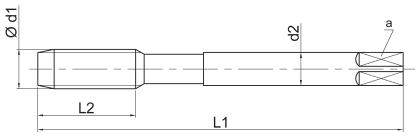
GAS

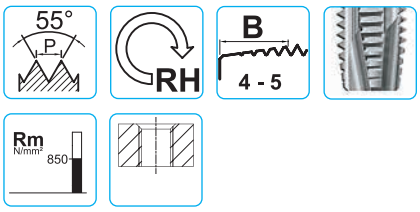
MASCHI A MACCHINA - Imbocco corretto per fori passanti
MACHINE TAPS - Straight flutes with spiral point for through holes
TARAUDS MACHINE - Goujures droites, entrée gun, pour trous débouchant

ISO 228

USO GENERALE - GENERAL PURPOSE - USAGE GÉNÉRAL

DIN 5156





Profondità di filettatura - Thread depth - Prof. de filetage	**3xD**	**3xD**	**3xD**
Materiale - Tool Material - Substrat	**HSSE**	**HSSE**	**HSSE**
Tolleranza - Thread tolerance - Tolérance du filetage	**ISO 228**	**ISO 228**	**ISO 228**
Trattamento superficiale - Surface treatment - Revêtement		**V**	**TiN**

Ød1 GAS	P TPI	Ø mm	L_1	L_2	d_2 h9	a h12	Z	
1/8	**28**	9,73	90	15	7	5,5	3	8,8
1/4	**19**	13,16	100	22	11	9	3	11,8
3/8	**19**	16,66	100	22	12	9	4	15,25
1/2	**14**	20,96	125	25	16	12	4	19
3/4	**14**	26,44	140	25	20	16	4	24,5
1"	**11**	33,25	160	30	25	20	5	30,75

CODE		
E25G1/8	E25G1/8V	E25G1/8T
E25G1/4	E25G1/4V	E25G1/4T
E25G3/8	E25G3/8V	E25G3/8T
E25G1/2	E25G1/2V	E25G1/2T
E25G3/4	E25G3/4V	E25G3/4T
E25G1"	E25G1"V	E25G1"T

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min											
P	Acciaio - Steel - Acier - Rm ≤ 850 N/mm²	○1.1 10-15	•1.2 10-15	•1.3 10-12	○1.4 8-10	•1.1 10-15	•1.2 10-15	•1.3 10-12	○1.4 8-10	•1.1 20-30	•1.2 20-30	•1.3 20-25	•1.4 15-20
M	Acciaio inox - Stainless steel - Acier inoxydable												
K	Ghisa - Cast iron - Fonte									○3.3 10-15	•3.4 15-20		
N	Leghe di Allumino - Al alloys - Alliage Al	○4.1 10-15	•4.2 15-20			•4.1 10-15	•4.2 15-20			○4.1 20-25	•4.2 25-30	○4.3 20-25	
N	Leghe di Rame - Copper alloys - Alliages de cuivre	○5.1 8-12	○5.2 10-15			•5.1 8-12	•5.2 10-15			○5.1 15-20	•5.2 20-25		

• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

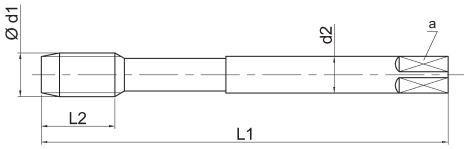
GAS

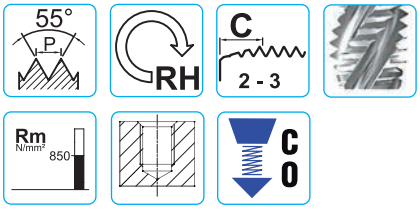
MASCHI A MACCHINA - Elica destra a 40° per fori ciechi
MACHINE TAPS - Spiral flutes 40° for blind holes
TARAUDS MACHINE - Goujures hélicoïdales 40° pour trous borgnes

ISO 228

USO GENERALE - GENERAL PURPOSE - USAGE GÉNÉRAL

DIN 5156





Profondità di filettatura - Thread depth - Prof. de filetage	**2,5xD**	**2,5xD**	**2,5xD**
Materiale - Tool Material - Substrat	**HSSE**	**HSSE**	**HSSE**
Tolleranza - Thread tolerance - Tolérance du filetage	**ISO 228**	**ISO 228**	**ISO 228**
Trattamento superficiale - Surface treatment - Revêtement		**V**	**TiN**

Ød1 GAS	P TPI	Ø mm	L_1	L_2	d_2 h9	a h12	Z		CODE		
1/8	**28**	9,73	90	15	7	5,5	3	8,8	E61G1/8	E61G1/8V	E61G1/8T
1/4	**19**	13,16	100	15	11	9	3	11,8	E61G1/4	E61G1/4V	E61G1/4T
3/8	**19**	16,66	100	15	12	9	4	15,25	E61G3/8	E61G3/8V	E61G3/8T
1/2	**14**	20,96	125	18	16	12	4	19	E61G1/2	E61G1/2V	E61G1/2T
5/8	**14**	22,91	125	18	18	14,5	4	21	E61G5/8	E61G5/8V	E61G5/8T
3/4	**14**	26,44	140	20	20	16	4	24,5	E61G3/4	E61G3/4V	E61G3/4T
7/8	**14**	30,20	150	20	22	18	4	28,25	E61G7/8	E61G7/8V	E61G7/8T
1"	**11**	33,25	160	24	25	20	5	30,75	E61G1"	E61G1"V	E61G1"T

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min											
P	Acciaio - Steel - Acier - Rm ≤ 850 N/mm²	○1.1 10-15	•1.2 10-15	•1.3 10-12	○1.4 8-10	•1.1 10-15	•1.2 10-15	•1.3 10-12	○1.4 8-10	•1.1 20-30	•1.2 20-30	•1.3 20-25	•1.4 15-20
M	Acciaio inox - Stainless steel - Acier inoxydable												
K	Ghisa - Cast iron - Fonte									○3.3 10-15	•3.4 15-20		
N	Leghe di Allumino - Al alloys - Alliage Al	○4.1 10-15	•4.2 15-20			•4.1 10-15	•4.2 15-20			○4.1 20-25	•4.2 25-30	○4.3 20-25	
N	Leghe di Rame - Copper alloys - Alliages de cuivre	○5.1 8-12	○5.2 10-15			•5.1 8-12	•5.2 10-15			○5.1 15-20	•5.2 20-25		

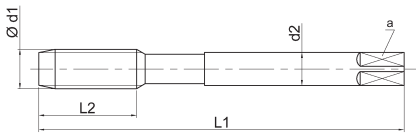
• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

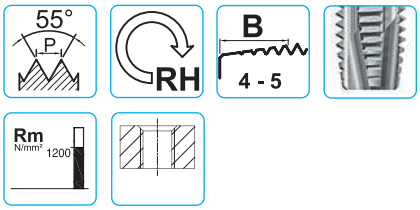
GAS

MASCHI A MACCHINA - Imbocco corretto per fori passanti
MACHINE TAPS - Straight flutes with spiral point for through holes
TARAUDS MACHINE - Goujures droites, entrée gun, pour trous débouchant

ISO 228 | U | APPLICAZIONI UNIVERSALI - UNIVERSAL APPLICATIONS - USINAGE UNIVERSELS

DIN 5156





Profondità di filettatura - Thread depth - Prof. de filetage	**3xD**
Materiale - Tool Material - Substrat	**PM3**
Tolleranza - Thread tolerance - Tolérance du filetage	**ISO228X**
Trattamento superficiale - Surface treatment - Revêtement	**XP**

Ød1 GAS	P TPI	Ø mm	L_1	L_2	d_2 h9	a h12	Z		CODE
1/8	**28**	9,73	90	15	7	5,5	3	8,8	K25G1/8XP
1/4	**19**	13,16	100	22	11	9	4	11,8	K25G1/4XP
3/8	**19**	16,66	100	22	12	9	4	15,25	K25G3/8XP
1/2	**14**	20,96	125	25	16	12	4	19	K25G1/2XP
3/4	**14**	26,44	140	25	20	16	4	24,5	K25G3/4XP

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min				
P	Acciaio - Steel - Acier - Rm ≤ 1200 N/mm²	○1.1 20-30	•1.2 20-30	•1.3 20-25	•1.4 15-20	•1.5 5-12
M	Acciaio inox - Stainless steel - Acier inoxydable	•2.1 10-15	•2.2 8-10	•2.3 6-8		
K	Ghisa - Cast iron - Fonte	•3.3 10-15	•3.4 15-20			
N	Leghe di Allumino - Al alloys - Alliage Al	•4.2 25-30	•4.3 20-25			
N	Leghe di Rame - Copper alloys - Alliages de cuivre Truciolo lungo - Long chipping - Copeaux longs	•5.2 20-25				

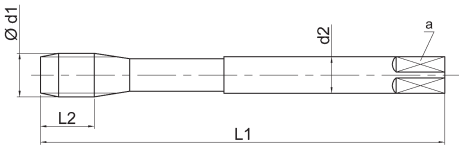
• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

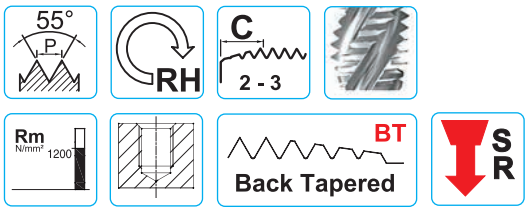
GAS

MASCHI A MACCHINA - Elicoidali 45° per fori ciechi
MACHINE TAPS - Spiral flutes 45° for blind holes
TARAUDS MACHINE - Goujures hélicoïdales 45° pour trous borgnes

ISO 228 | U | APPLICAZIONI UNIVERSALI - UNIVERSAL APPLICATIONS - USINAGE UNIVERSELS

DIN 5156





Profondità di filettatura - Thread depth - Prof. de filetage	**3xD**	**3,5xD**
Materiale - Tool Material - Substrat	**PM3**	**PM3**
Tolleranza - Thread tolerance - Tolérance du filetage	**ISO 228X**	**ISO 228X**
Trattamento superficiale - Surface treatment - Revêtement	**XP**	**XP**

Ød1 GAS	P TPI	Ø mm	L_1	L_2	d_2 h9	a h12	Z	
1/8	**28**	9,73	90	15	7	5,5	3	8,8
1/4	**19**	13,16	100	15	11	9	3	11,8
3/8	**19**	16,66	100	15	12	9	4	15,25
1/2	**14**	20,96	125	18	16	12	4	19
3/4	**14**	26,44	140	20	20	16	4	24,5
1"	**11**	33,25	160	24	25	20	5	30,75

CODE	
K83G1/8XP	K83G1/8FOR-XP
K83G1/4XP	K83G1/4FOR-XP
K83G3/8XP	K83G3/8FOR-XP
K83G1/2XP	K83G1/2FOR-XP
K83G3/4XP	K83G3/4FOR-XP
K83G1"XP	K83G1"FOR-XP

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min									
P	Acciaio - Steel - Acier - Rm ≤ 1200 N/mm²	○1.1 20-30	•1.2 20-30	•1.3 20-25	•1.4 15-20	•1.5 5-12	○1.1 20-30	•1.2 20-30	•1.3 20-25	•1.4 15-20	•1.5 5-12
M	Acciaio inox - Stainless steel - Acier inoxydable	•2.1 10-15	•2.2 8-10	•2.3 6-8			•2.1 10-15	•2.2 8-10	•2.3 6-8		
K	Ghisa - Cast iron - Fonte	•3.3 10-15	•3.4 15-20				•3.3 10-15	•3.4 15-20			
N	Leghe di Allumino - Al alloys - Alliage Al	•4.2 25-30	•4.3 20-25				•4.2 25-30	•4.3 20-25			
N	Leghe di rame - Copper alloys - Alliages de cuivre Truciolo lungo - Long chipping - Copeaux longs	•5.2 20-25					•5.2 20-25				

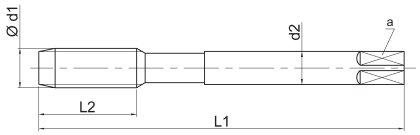
• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

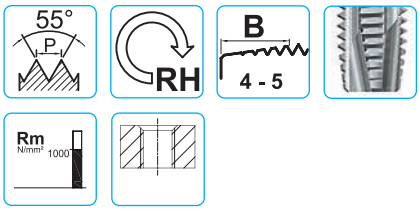
GAS

MASCHI A MACCHINA - Imbocco corretto per fori passanti
MACHINE TAPS - Straight flutes with spiral point for through holes
TARAUDS MACHINE - Goujures droites, entrée gun, pour trous débouchant

ISO 228 | INOX | ACCIAIO INOSSIDABILE - STAINLESS STEEL - ACIER INOXYDABLE

DIN 5156





Profondità di filettatura - Thread depth - Prof. de filetage	**3xD**
Materiale - Tool Material - Substrat	**HSSV3**
Tolleranza - Thread tolerance - Tolérance du filetage	**ISO 228X**
Trattamento superficiale - Surface treatment - Revêtement	**TXC**

Ød1 GAS	P TPI	Ø mm	L_1	L_2	d_2 h9	a h12	Z	
1/8	**28**	9,73	90	15	7	5,5	3	8,8
1/4	**19**	13,16	100	22	11	9	4	11,8
3/8	**19**	16,66	100	22	12	9	4	15,25
1/2	**14**	20,96	125	25	16	12	4	19
3/4	**14**	26,44	140	25	20	16	4	24,5

CODE		
V25G1/8TXC		
V25G1/4TXC		
V25G3/8TXC		
V25G1/2TXC		
V25G3/4TXC		

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min			
P	Acciaio - Steel - Acier - Rm ≤ 1200 N/mm²	•1.3 20-25	•1.4 15-20	❍1.5 5-12	
M	Acciaio inox - Stainless steel - Acier inoxydable	•2.1 10-15	•2.2 8-10	•2.3 6-8	❍2.4 3-6

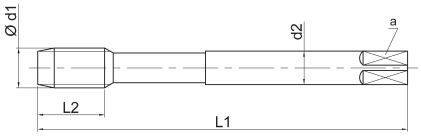
• Raccomandato - Optimal - Recommandé ❍ Adatto - Suitable - Adaptè

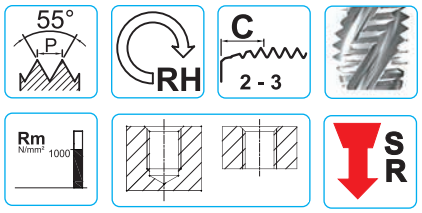
GAS

MASCHI A MACCHINA - Elicoidali 48° per fori ciechi
MACHINE TAPS - Spiral flutes 48° for blind holes
TARAUDS MACHINE - Goujures hélicoïdales 48° pour trous borgnes

ISO 228 | INOX | ACCIAIO INOSSIDABILE - STAINLESS STEEL - ACIER INOXYDABLE

DIN 5156





Profondità di filettatura - Thread depth - Prof. de filetage	**3,5xD**	**3,5xD**
Materiale - Tool Material - Substrat	**HSSV3**	**HSSV3**
Tolleranza - Thread tolerance - Tolérance du filetage	**ISO 228X**	**ISO 228X**
Trattamento superficiale - Surface treatment - Revêtement	**TXC**	**TXC**

Ød1 GAS	P TPI	Ø mm	L_1	L_2	d_2 h9	a h12	Z		CODE	
1/8	**28**	9,73	90	15	7	5,5	3	8,8	V83G1/8TXC	V83G1/8FOR-TXC
1/4	**19**	13,16	100	15	11	9	3	11,8	V83G1/4TXC	V83G1/4FOR-TXC
3/8	**19**	16,66	100	15	12	9	4	15,25	V83G3/8TXC	V83G3/8FOR-TXC
1/2	**14**	20,96	125	18	16	12	4	19	V83G1/2TXC	V83G1/2FOR-TXC
3/4	**14**	26,44	140	20	20	16	4	24,5	V83G3/4TXC	V83G3/4FOR-TXC
1"	**11**	33,25	160	24	25	20	5	30,75	V83G1"TXC	V83G1"FOR-TXC

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min							
P	Acciaio - Steel - Acier - Rm ≤ 1000 N/mm²	•1.3 20-25	•1.4 15-20	○1.5 5-12		•1.3 20-25	•1.4 15-20	○1.5 5-12	
M	Acciaio inox - Stainless steel - Acier inoxydable	•2.1 10-15	•2.2 8-10	•2.3 6-8	○2.4 3-6	•2.1 10-15	•2.2 8-10	•2.3 6-8	○2.4 3-6

• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

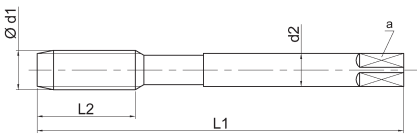
GAS

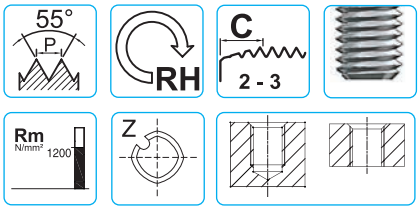
MASCHI A MACCHINA - Per fori ciechi e passanti con canalini di lubrificazione
MACHINE TAPS - For blind and through holes with oil grooves
TARAUDS MACHINE - Pour trous borgnes et débouchant avec rainures de lubrification

UFS ROLL

ISO 228 | MASCHI A RULLARE - ROLL FORM TAPS - TARAUDS À REFOULER

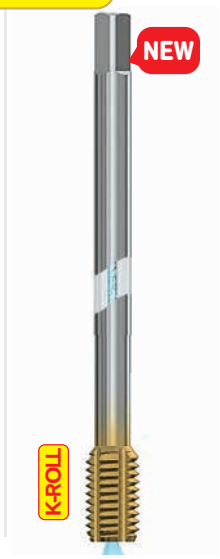
DIN 5156





Rm < 850 Nm/m²

Rm < 1200 Nm/m²



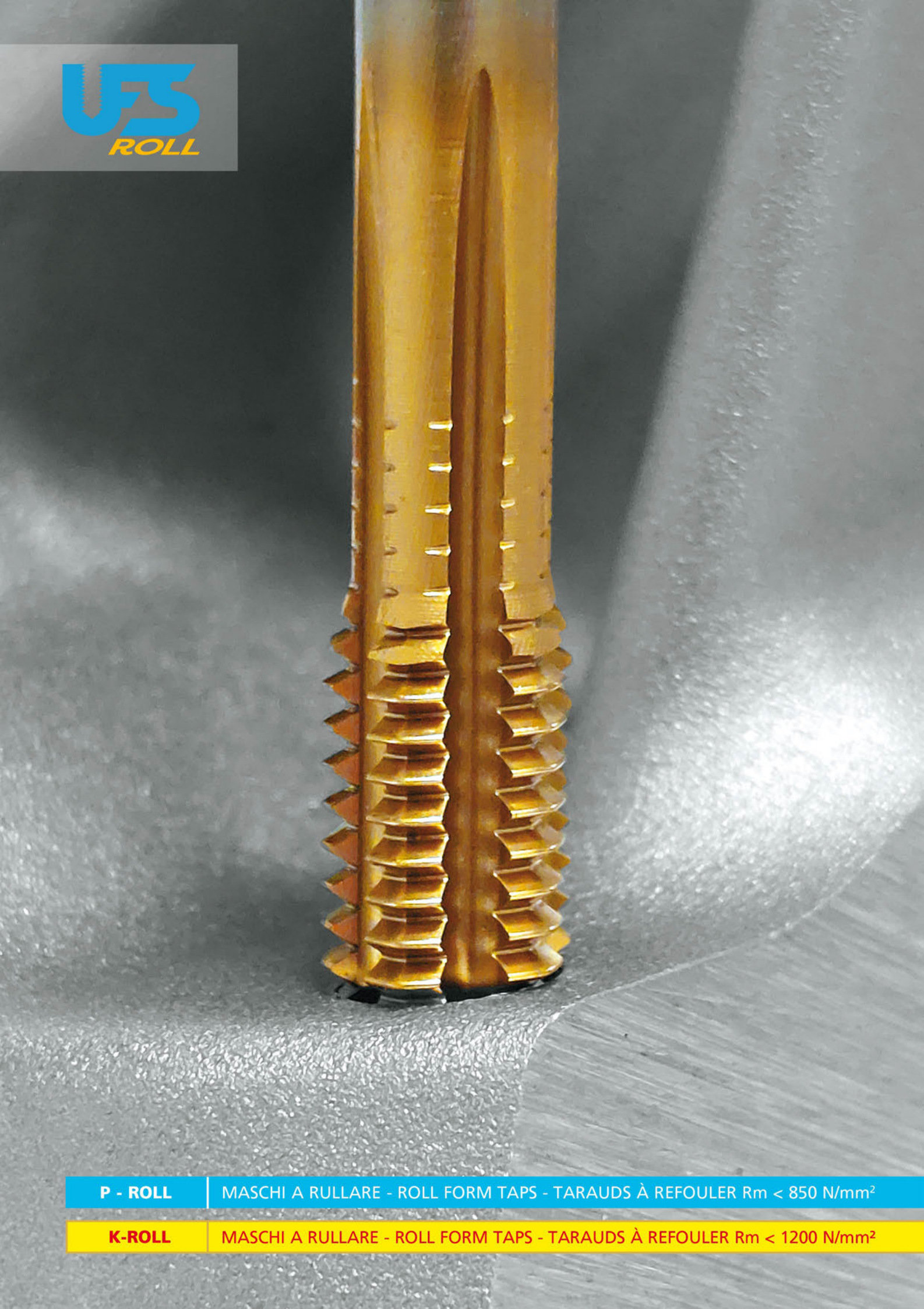
Profondità di filettatura - Thread depth - Prof. de filetage	3xD	3xD	3xD
Materiale - Tool Material - Substrat	PM8	PM8	PM8
Tolleranza - Thread tolerance - Tolérance du filetage	ISO 228X	ISO 228X	ISO 228X
Trattamento superficiale - Surface treatment - Revêtement	TiN	TiN-G	TiN-G

Ød1 GAS	P TPI	Ø mm	L_1	L_2	d_2 h9	a h12	Z		CODE		
1/8	28	9,73	90	15	7	5,5	5	9,25	P2CCG1/8T		
1/4	19	13,16	100	22	11	9	6	12,5	P2CCG1/4T		
3/8	19	16,66	100	22	12	9	6	16	P2CCG3/8T		
1/2	14	20,96	125	25	16	12	8	20	P2CCG1/2T		
3/4	14	26,44	140	25	20	16	8	25,5	P2CCG3/4T		

Ød1 GAS	P TPI	Ø mm	L_1	L_2	d_2 h9	a h12	Z		CODE	
1/8	28	9,73	90	10	7	5,5	8	9,25	K2CCG1/8TG	K2CCG1/8FOR-TG
1/4	19	13,16	100	13	11	9	8	12,5	K2CCG1/4TG	K2CCG1/4FOR-TG
3/8	19	16,66	100	13	12	9	8	16	K2CCG3/8TG	K2CCG3/8FOR-TG
1/2	14	20,96	125	18	16	12	8	20	K2CCG1/2TG	K2CCG1/2FOR-TG
5/8	14	22,91	125	18	18	14,5	8	22	K2CCG5/8TG	K2CCG5/8FOR-TG
3/4	14	26,44	140	18	20	16	8	25,5	K2CCG3/4TG	K2CCG3/4FOR-TG
7/8	14	30,20	150	18	22	18	8	29,25	K2CCG7/8TG	K2CCG7/8FOR-TG
1”	11	33,25	160	23	25	20	8	32	K2CCG1"TG	K2CCG1"FOR-TG

ISO	Campo di impiego Application range Gamme d’application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min									
P	Acciaio - Steel - Acier - Rm ≤ 1200 N/mm²	•1.1 20-30	•1.2 20-30	•1.3 20-25	○1.4 15-20	•1.3 30-35	•1.4 25-30	•1.5 15-20	•1.3 30-35	•1.4 25-30	•1.5 15-20
M	Acciaio inox - Stainless steel - Acier inoxydable	○2.1 10-15	○2.2 10-12	○2.3 6-10		○2.2 10-12	○2.3 6-10	○2.4 6-8	○2.2 10-12	○2.3 6-10	○2.4 6-8
N	Leghe di Allumino - Al alloys - Alliage Al	○4.1 35-40	○4.2 40-45	○4.3 35-40							
N	Leghe di rame - Copper alloys - Alliages de cuivre	○5.1 15-20	○5.2 15-20								

• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè



P - ROLL	MASCHI A RULLARE - ROLL FORM TAPS - TARAUDS À REFOULER Rm < 850 N/mm²
K-ROLL	MASCHI A RULLARE - ROLL FORM TAPS - TARAUDS À REFOULER Rm < 1200 N/mm²

TAPS, ROLL TAPS, THREAD PLUG GAUGES AND DIES

THREADING TOOLS ITALIAN MANUFACTURER

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