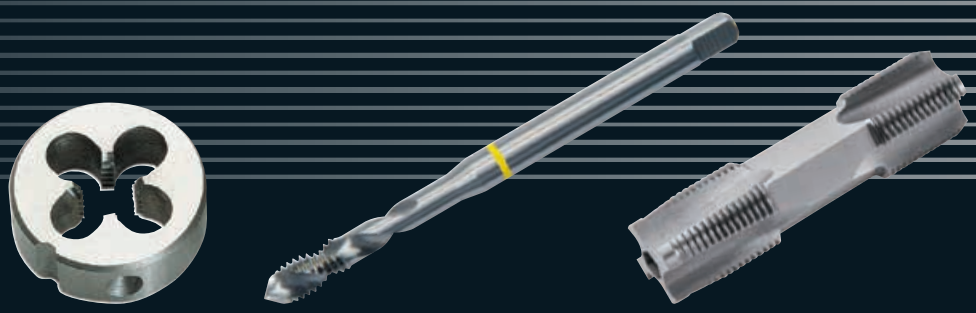
VÖLKEL

THREADING SOLUTIONS

沃克丝锥 – 螺纹专家



VA 2016

VÖLKEL
THREADING SOLUTIONS

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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
沃克螺纹专家 – 具有全球竞争力的螺纹切削工具

基于100年螺纹切削工具的生产经验，沃克已经成为全世界领先的标准螺纹切削工具的供应商，所有规格均有库存。

作为一个家族企业，我们能够灵活、快速地作出反应，以迎接未来的挑战。沃克家族(雷姆沙伊德)和卡林顿家族(伯明翰)致力于长期和可持续实施和遵守这些承诺。

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

因为可行

… 因为您可以依靠，目录上超过99%都有库存

- 常备有超过7,000个规格
- 目录上超过99%的规格都有库存
- 小订单订货当天发货
- 特别规格从1–110mm

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

因为可靠

… 因为我们承诺保证为工业市场提供质量稳定的产品，您可以受益

- 为工业市场保证提供稳定、优质的产品
- 优质的服务
- 中央处理：终检，质量管理，存贮，分拣和发货

because you

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

全为您

… 您是我们尊贵的客户，我们为您提供迈向成功的最有吸引力的综合合作。

Die Stocks - Tap Wrenches
板牙绞手 – 丝锥绞手 **9 - 13**

JIS Taps
日标丝锥 **16 - 49**

DIN Hand Taps
德标手用丝锥 **54 - 78**

DIN Short Machine Taps
德标短式机用丝锥 **80 - 88**

DIN Machine Taps
德标机用丝锥 **93 - 142**

DIN Machine Taps with coloured ring
德标彩圈机用丝锥 **146 - 163**

DIN Fluteless (Forming) Taps
德标挤压丝锥 **165 - 170**

ISO Taps
ISO丝锥 **171 - 202**

HexTap and Hex Shank Tools
六角柄丝锥和六角柄工具 **203 - 215**

Round Dies and Hexagon Die Nuts
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Tap and Die Sets
丝锥板牙套装 **271 - 298**

Technical Information
技术资料 **299 - 313**

INDEX	M	M LH	Mf	Mf LH	BSW	BSW LH	BSF	BA	W DIN 477	UNC	UNC LH	UNF	UNF LH	UNEF	UN/ UNS	UN-8	UN-12
JIS Hand Taps 日标手用丝锥	16		17		22					25		25					
JIS Spiral Point Taps 日标螺尖丝锥	18 40 42 44 46		19		23					26		27					
JIS Spiral Flute Taps 日标螺旋槽丝锥	20 41 43 45 47		21		24					28		29					
JIS Fluteless Taps 日标挤压丝锥	50									51		51					
DIN Hand Taps 德标手用丝锥	54 70	74	57 72	75	63	76	64			65	77	66	77				
DIN Short Machine Taps 德标短式机用丝锥	80		81		82				82	83		83					
DIN Machine Taps 德标机用丝锥	94	130	108	133	115					117		119					
DIN Coloured Ring Taps 德标彩圈机用丝锥	146 154 156		153 155							153 155		153 155					
DIN Fluteless Taps 德标挤压丝锥	167																
ISO Straight Flute Taps ISO直槽丝锥	172 200		176		191 202		194	196		180 201		182 201		187		184	
ISO Spiral Point Taps ISO螺尖丝锥	173 200		179		192		195			181		183		188	190	185	185
ISO Spiral Flute Taps ISO螺旋槽丝锥	174 200				193		195			181		183		189		186	186
HexTap 六角柄丝锥	206		207														
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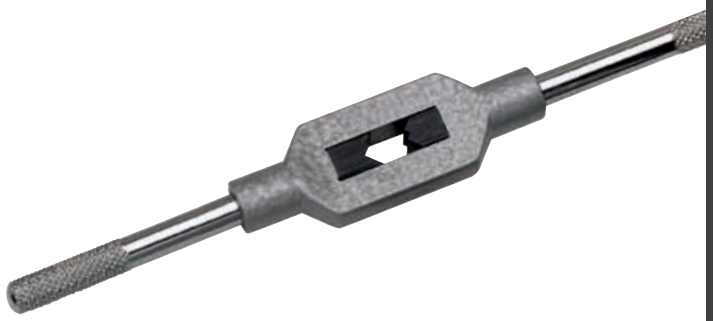
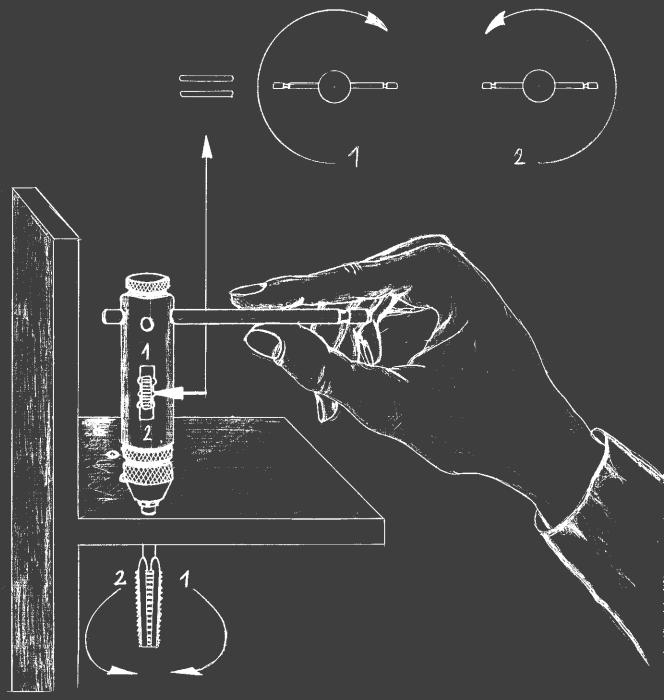
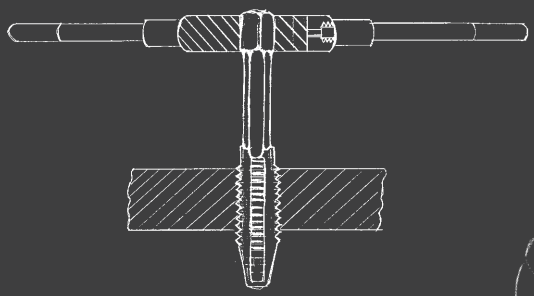
JIS Round Dies 日标圆板牙	218		219														
DIN Round Dies 德标圆板牙	224 242	245 246	227 243		233	249	233			234	250	235	250	236			
ISO Round Dies ISO圆板牙	252		253		254		255	258		256		257					
Hexagon Dies 六方板牙	260	269	261		263					264		264				265	
Tap and Die Sets 丝锥板牙套装	272 278 280		272		276 278		276 278	279		276 279		276 279					
INDEX	M	M LH	Mf	Mf LH	BSW	BSW LH	BSF	BA	W DIN 477	UNC	UNC LH	UNF	UNF LH	UNEF	UN/ UNS	UN-8	UN-12

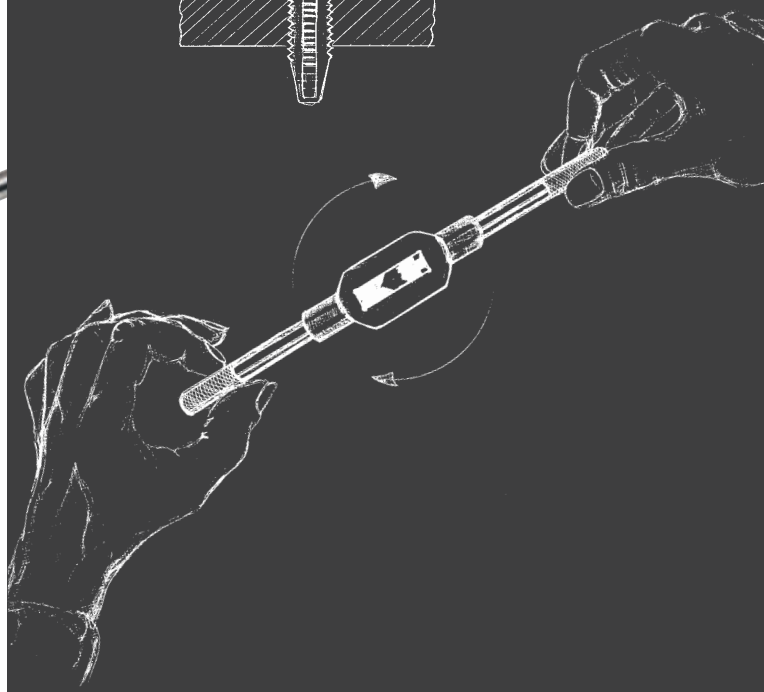
INDEX	G (BSPF/PF)	G (BSPF/PF) LH	Rc (BSPT/PT)	Rp (BSPP/PS)	PG	Tr Tr-LH	NPT	NPT LH	NPTF	NPS	Rd	FG	BSC	Vg
JIS Hand Taps 日标手用丝锥	31		33	30			34			36				
JIS Spiral Point Taps 日标螺尖丝锥	32		33				34		35					
JIS Spiral Flute Taps 日标螺旋槽丝锥	32		33	30			34		35	36				
JIS Fluteless Taps 日标挤压丝锥														
DIN Hand Taps 德标手用丝锥	67 73	78			68	69								
DIN Short Machine Taps 德标短式机用丝锥	84		85		86		87	88						
DIN Machine Taps 德标机用丝锥	121	139	124				125				126	127	128	129
DIN Coloured Ring Taps 德标彩圈机用丝锥	153 155													
DIN Fluteless Taps 德标挤压丝锥														
ISO Straight Flute Taps ISO直槽丝锥	197		199				199							
ISO Spiral Point Taps ISO螺尖丝锥	198													
ISO Spiral Flute Taps ISO螺旋槽丝锥	198													
HexTap 六角柄丝锥	211													
Combined Taps 复合丝锥														
Machine Nut Taps 机用螺母丝锥						142								
JIS Round Dies 日标圆板牙	220		221	220			222		222	223				
DIN Round Dies 德标圆板牙	237 244	251			238		239					241	240	240
ISO Round Dies ISO圆板牙		259												
Hexagon Dies 六方板牙	266	270	267											
Tap and Die Sets 丝锥板牙套装	272 276						276							
INDEX	G (BSPF/PF)	G (BSPF/PF) LH	Rc (BSPT/PT)	Rp (BSPP/PS)	PG	Tr Tr-LH	NPT	NPT LH	NPTF	NPS	Rd	FG	BSC	Vg

DIE STOCKS - TAP WRENCHES
板牙绞手 – 丝锥绞手









DIE STOCKS - TAP WRENCHES
板牙绞手 – 丝锥绞手

		Zinc die cast 锌合金压铸	Steel 钢制	Inch 英制
Tap Holder with Ratchet 丝锥棘轮绞手			10	
Adjustable Tap Wrenches 可调丝锥绞手		12	12	
Die Stocks 板牙绞手		11	11	10
Tap Extensions 丝锥接杆		13		

VÖLKEL
THREADING SOLUTIONS

Tap Holder with Ratchet

for right- and left-hand-turn

all steel quality

丝锥棘轮绞手

可以左旋和右旋

全钢制品质

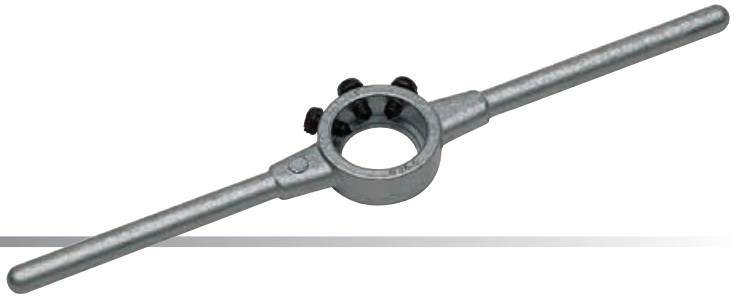
No.	for Taps		Square mm	Length mm	Weight kg		Art.-No.
1	M 3-10	1/8-3/8	2.4-5.5	85	0,165	10	10001
2	M 5-12	7/32-1/2	4.5-8.0	100	0,310	10	10002
10	M 3-10	1/8-3/8	2.4-5.5	250	0,250	10	10010
20	M 5-12	7/32-1/2	4.5-8.0	300	0,440	10	10020
Jaws and Spring for No. 1 und 10						10	10091
Jaws and Spring for No.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

Die Stocks

Inch - with 3 screws

板牙绞手

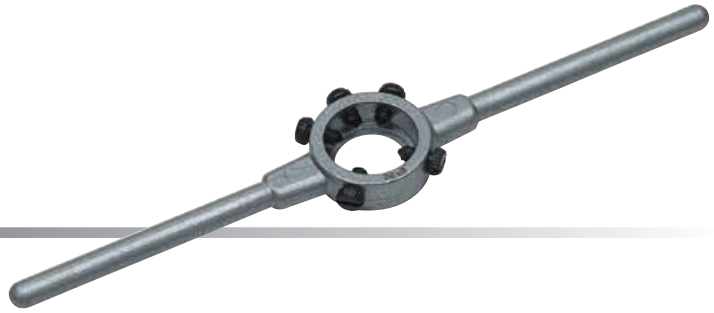
英制 – 带3颗螺丝



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

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

板牙绞手
DIN 225 (DIN EN 22568), 锌合金压铸



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
20 x 5	M 3-4	BSW 1/8-5/32	200	0,065	5	15002
20 x 7	M 4.5-6	BSW 3/16-1/4	200	0,065	5	15003
25 x 9	M 7-9	BSW 5/16	224	0,105	5	15004
30 x 11	M 10-11	BSW 3/8-7/16	280	0,190	5	15005
38 x 10	Mf 12-15	G 1/4	315	0,340	5	15006
38 x 14	M 12-14	BSW 1/2-9/16	315	0,340	5	15007
45 x 14	Mf 16-20	G 3/8-1/2	450	0,650	1	15008
45 x 18	M 16-20	BSW 5/8-13/16	450	0,650	1	15009
55 x 16	Mf 22-26	G 5/8-3/4	560	0,900	1	15010
55 x 22	M 22-24	BSW 7/8-1"	560	0,900	1	15011
65 x 18	Mf 27-36	G 7/8-1"	630	1,400	1	15012
65 x 25	M 27-36	BSW 1.1/8-1.3/8	630	1,400	1	15013

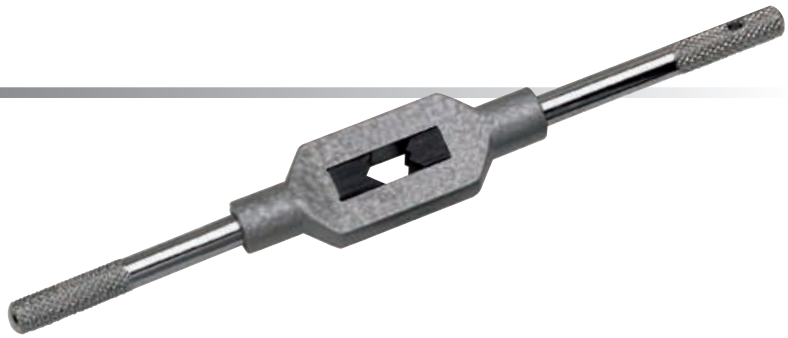
Die Stocks
DIN 225 (DIN EN 22568), STEEL

板牙绞手
DIN 225 (DIN EN 22568), 钢制

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
55 x 22	M 22-24	BSW 7/8-1"	560	0,900	1	15211
65 x 25	M 27-36	BSW 1.1/8-1.3/8	630	1,400	1	15213
75 x 20	Mf 38-42	G 1.1/8-1.1/4	800	2,250	1	15214
75 x 30	M 38-42	BSW 1.1/2-1.5/8	800	2,100	1	15215
90 x 22	Mf 45-52	G 1.3/8-1.5/8	900	3,200	1	15216
90 x 36	M 45-52	BSW 1.3/4-2"	900	3,000	1	15217
105 x 22	Mf 54-63	G 1.3/4-2"	975	3,500	1	15218
105 x 36	M 54-63	BSW 2.1/4"-2.1/2"	975	3,500	1	15219
120 x 22	Mf 64-71	G 2.1/4-2.3/4	956	3,170	1	15220
120 x 36	M 64-71	BSW 2.3/4"	956	3,910	1	15221
130 x 25		G 3"	966	3,505	1	15222
130 x 36			966	4,025	1	15223
140 x 22			976	3,620	1	15224
150 x 25		G 3.1/2"	986	3,950	1	15226
160 x 25		G 4"	996	4,115	1	15228

Adjustable Tap Wrenches
DIN 1814 Zinc die cast

可调丝锥绞手
DIN 1814, 锌合金压铸



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
1	M 1-10	1/16-3/8	G 1/8	2.0-6.3	176	0,095	5	13010
1.1/2	M 1-12	1/16-1/2	G 1/8	2.1-8.0	176	0,120	5	13015
2	M 4-12	5/32-1/2	G 1/8	3.0-9.0	280	0,285	5	13020
3	M 5-20	7/32-3/4	G 1/8-1/2	4.9-12	380	0,660	1	13030
4	M 11-27	7/16-1"	G 1/4-3/4	5.5-16	505	1,500	1	13040
5 L	M 13-32	1/2 -1.1/4	G 1/4-1"	7-20	700	1,800	1	13050

Adjustable Tap Wrenches
DIN 1814, STEEL

可调丝锥绞手
DIN 1814, 钢制

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
1	M 1-10	1/16-3/8		2.0-6.3	176	0,100	5	14010
1.1/2	M 1-12	1/16-1/2	G 1/8	2.1-8.0	176	0,120	5	14015
2	M 4-12	5/32-1/2	G 1/8	3.0-9.0	280	0,285	5	14020
3	M 5-20	7/32-3/4	G 1/8-1/2	4.9-12	380	0,660	1	14030
4	M 11-27	7/16-1"	G 1/4-3/4	5.5-16	500	1,500	1	14040
5	M 13-32	1/2-1.1/4	G 1/4-1"	7-20	700	1,800	1	14050
6	M 18-42	3/4-1.1/2	G 1/2-1.1/4	11-24	1000	2,600	1	14060
7	M 27-52	1.1/8-2"	G 3/4-1.3/4	16-32	1250	4,500	1	14070
8	M 27-64	1.1/8"-3"	G 3/4-3"	16-40	1250	4,500	1	14080

Tap Extensions

DIN 377, Squares according to DIN 10

丝锥接杆

DIN 377, 方头符合DIN 10

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

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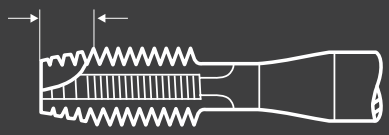
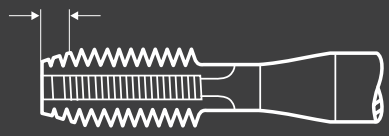
THREADING SOLUTIONS

JIS TAPS
日标丝锥

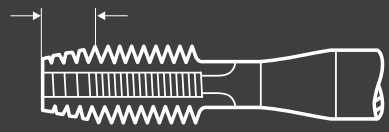
Form B
4-5 Threads Lead with Spiral Point for through holes
4–5齿铲梢，带螺尖，用于通孔



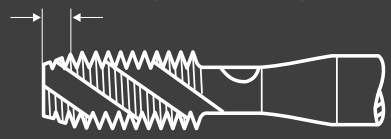
Form C
2–3 Threads Lead, for blind holes
2–3齿铲梢，用于盲孔



Form D
4–5 Threads Lead, for through and blind holes
4–5齿铲梢，用于通孔和盲孔

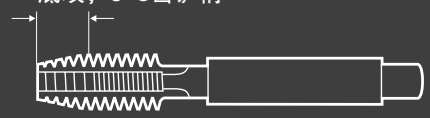


Form C/35° RSP
2-3 Threads Lead, 35° Spiral Flute, for blind holes
2–3齿铲梢，35° 螺旋槽，用于盲孔

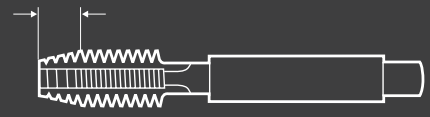


JIS HAND TAPS
日标手用丝锥

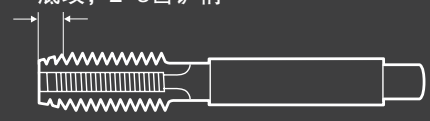
No. 1 - Form A
Finisher, 6-8 Threads Lead
底攻，6–8齿铲梢



No. 2 - Form D
Finisher, 4-5 Threads Lead
底攻，4–5齿铲梢



No. 3 - Form C
Finisher, 2-3 Threads Lead
底攻，2–3齿铲梢



JIS TAPS
日标丝锥

	HT 手用丝锥	PO 螺尖丝锥	SP 螺旋槽丝锥
M	16	18	20
Mf	17	19	21
BSW	22	23	24
UNC	25	26	28
UNF	25	27	29
PS (BSPP / RP)	30		30
PF (BSPF / G)	31	32	32
PT (BSPT / Rc)	33	33	33
NPT	34	34	34
NPTF		35	35
NPS	36		36

JIS MACHINE TAPS WITH COLOURED RING 37
日标彩圈机用丝锥

JIS FLUTESLESS TAPS R-S 49
日标挤压丝锥

HT Hand Taps

metric ISO-thread DIN 13

手用丝锥

公制ISO螺纹 DIN 13

JIS B 4430 HSS-G Tol. ISO2/6H

M

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

Application:

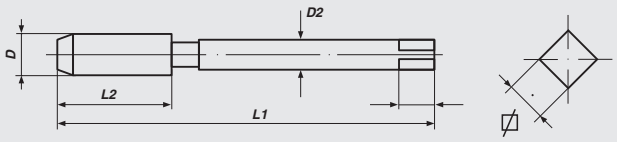
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

应用:

通用
–抗拉强度小于900N/mm²的非研磨材料
–非合金钢和低合金钢
–通孔和盲孔
–手用

How to order/如何订货:

M3	=	90422
M3, No. 1	=	90422-1
M3, No. 2	=	90422-2
M3, No. 3	=	90422-3



HT Hand Taps
metric-fine ISO-thread DIN 13

手用丝锥
公制细牙ISO螺纹 DIN 13

JIS B 4430 HSS-G Tol. ISO2/6H

Mf

Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.
M 5 x 0.75	60	22	5.5	4.5	90431
M 6 x 0.75	62	24	6.0	4.5	90440
M 8 x 1.0	70	30	6.2	5.0	90448
M 8 x 0.75	70	30	6.2	5.0	90450
M 10 x 1.25	75	32	7.0	5.5	90455
M 10 x 1.0	75	32	7.0	5.5	90456
M 12 x 1.5	82	38	8.5	6.5	90462
M 12 x 1.25	82	38	8.5	6.5	90463
M 12 x 1.0	82	38	8.5	6.5	90464
M 14 x 1.5	88	42	10.5	8.0	90468
M 14 x 1.25	88	39	10.5	8.0	90469
M 14 x 1.0	70	30	10.5	8.0	90470
M 16 x 1.5	95	45	12.5	10.0	90474
M 16 x 1.0	75	30	12.5	10.0	90476
M 18 x 1.5	95	45	14.0	11.0	90480
M 18 x 1.0	95	45	14.0	11.0	90482
M 20 x 1.5	95	45	15.0	12.0	90486
M 20 x 1.0	80	30	15.0	12.0	90488
M 22 x 2.0	95	45	17.0	13.0	90493
M 22 x 1.5	95	45	17.0	13.0	90492
M 22 x 1.0	95	45	17.0	13.0	90494
M 24 x 1.5	95	45	19.0	15.0	90498
M 27 x 1.5	95	45	20.0	15.0	91406
M 30 x 1.5	105	45	23.0	17.0	91409

Application:

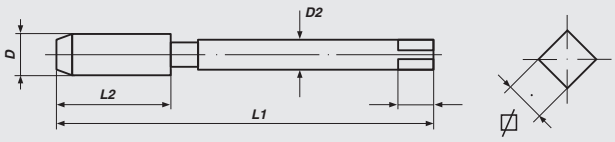
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔和盲孔
– 手用

How to order/如何订货:

M3	=	90448
M3, No. 1	=	90448-1
M3, No. 2	=	90448-2
M3, No. 3	=	90448-3



PO Spiral Pointed Taps

metric ISO-thread DIN 13

螺尖丝锥

公制ISO螺纹 DIN 13

JIS B 4430 HSS-E Tol. ISO2/6H

M

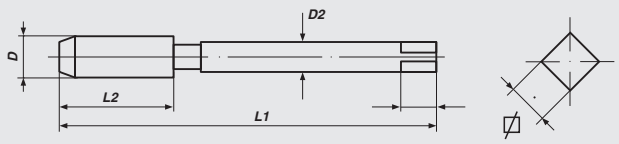
Nominal Diameter D		L 1	L 2	D 2	⊠	Art.-No.
M	2.6 x 0.45	44	16	3.0	2.5	90520
M	3.0 x 0.5	46	18	4.0	3.2	90522
M	3.5 x 0.6	48	18	4.0	3.2	90524
M	4 x 0.7	52	20	5.0	4.0	90526
M	5 x 0.8	60	22	5.5	4.5	90530
M	6 x 1.0	62	24	6.0	4.5	90538
M	7 x 1.0	65	26	6.2	4.5	90544
M	8 x 1.25	70	30	6.2	5.0	90546
M	10 x 1.5	75	32	7.0	5.5	90554
M	12 x 1.75	82	38	8.5	6.5	90560
M	14 x 2.0	88	42	10.5	8.0	90566
M	16 x 2.0	95	45	12.5	10.0	90572
M	18 x 2.5	100	48	14.0	11.0	90578
M	20 x 2.5	105	50	15.0	12.0	90584
M	22 x 2.5	115	55	17.0	13.0	90590
M	24 x 3.0	120	58	19.0	15.0	90596
M	27 x 3.0	130	62	20.0	15.0	91502
M	30 x 3.5	135	65	23.0	17.0	91508

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

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔
– 手用和机用



PO Spiral Pointed Taps
metric-fine ISO-thread DIN 13

螺尖丝锥
公制细牙ISO螺纹 DIN 13

JIS B 4430 HSS-E Tol. ISO2/6H

Mf

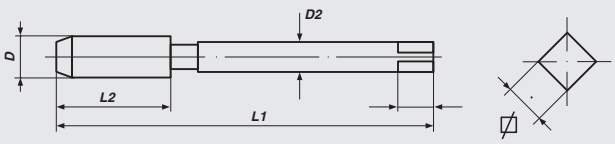
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.
M 6 x 0.75	62	24	6.0	4.5	90540
M 8 x 1.0	70	30	6.2	5.0	90548
M 8 x 0.75	70	30	6.2	5.0	90550
M 10 x 1.25	75	32	7.0	5.5	90555
M 10 x 1.0	75	32	7.0	5.5	90556
M 12 x 1.5	82	38	8.5	6.5	90562
M 12 x 1.25	82	38	8.5	6.5	90563
M 12 x 1.0	82	38	8.5	6.5	90564
M 14 x 1.5	88	42	10.5	8.0	90568
M 14 x 1.25	88	39	10.5	8.0	90569
M 14 x 1.0	70	30	10.5	8.0	90570
M 16 x 1.5	95	45	12.5	10.0	90574
M 16 x 1.0	75	30	12.5	10.0	90576
M 18 x 1.5	95	45	14.0	11.0	90580
M 18 x 1.0	95	45	14.0	11.0	90582
M 20 x 1.5	95	45	15.0	12.0	90586
M 20 x 1.0	80	30	15.0	12.0	90588
M 22 x 2.0	95	45	17.0	13.0	90593
M 22 x 1.5	95	45	17.0	13.0	90592
M 22 x 1.0	95	45	17.0	13.0	90594
M 24 x 1.5	95	45	19.0	15.0	90598
M 27 x 1.5	95	45	20.0	15.0	91506
M 30 x 1.5	105	45	23.0	17.0	91509

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

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔
– 手用和机用



VÖLKEL THREADING SOLUTIONS

SP Spiral Fluted Taps
metric ISO-thread DIN 13

螺旋槽丝锥
公制ISO螺纹 DIN 13

JIS B 4430 HSS-E Tol. ISO2/6H

M

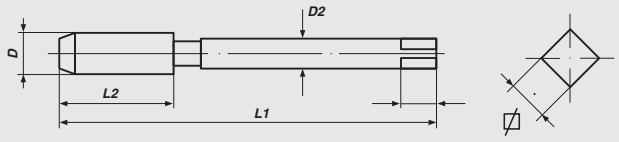
Nominal Diameter D	L 1	L 2	D 2	⊠	Art.-No.
M 2.5 x 0.45	44	16	3.0	2.5	90718
M 2.6 x 0.45	44	16	3.0	2.5	90720
M 3 x 0.5	46	18	4.0	3.2	90722
M 3.5 x 0.6	48	18	4.0	3.2	90724
M 4 x 0.7	52	20	5.0	4.0	90726
M 5 x 0.8	60	22	5.5	4.5	90730
M 6 x 1.0	62	24	6.0	4.5	90738
M 7 x 1.0	65	26	6.2	4.5	90744
M 8 x 1.25	70	30	6.2	5.0	90746
M 10 x 1.5	75	32	7.0	5.5	90754
M 12 x 1.75	82	38	8.5	6.5	90760
M 14 x 2.0	88	42	10.5	8.0	90766
M 16 x 2.0	95	45	12.5	10.0	90772
M 18 x 2.5	100	48	14.0	11.0	90778
M 20 x 2.5	105	50	15.0	12.0	90784
M 22 x 2.5	115	55	17.0	13.0	90790
M 24 x 3.0	120	58	19.0	15.0	90796
M 27 x 3.0	130	62	20.0	15.0	91702
M 30 x 3.5	135	65	23.0	17.0	91708

Application:

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

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 盲孔
– 手用和机用



SP Spiral Fluted Taps
metric-fine ISO-thread DIN 13

螺旋槽丝锥
公制细牙ISO螺纹 DIN 13

JIS B 4430 HSS-E Tol. 2B

Mf

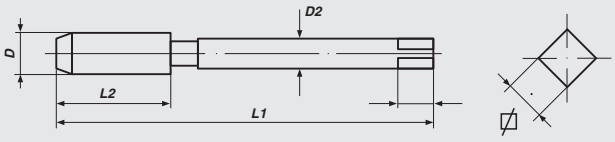
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.
M 6 x 0.75	62	24	6.0	4.5	90740
M 8 x 1.0	70	30	6.2	5.0	90748
M 8 x 0.75	70	30	6.2	5.0	90750
M 10 x 1.25	75	32	7.0	5.5	90755
M 10 x 1.0	75	32	7.0	5.5	90756
M 12 x 1.5	82	38	8.5	6.5	90762
M 12 x 1.25	82	38	8.5	6.5	90763
M 12 x 1.0	82	38	8.5	6.5	90764
M 14 x 1.5	88	42	10.5	8.0	90768
M 14 x 1.25	88	39	10.5	8.0	90769
M 14 x 1.0	70	30	10.5	8.0	90770
M 16 x 1.5	95	45	12.5	10.0	90774
M 16 x 1.0	75	30	12.5	10.0	90776
M 18 x 1.5	95	45	14.0	11.0	90780
M 18 x 1.0	95	45	14.0	11.0	90782
M 20 x 1.5	95	45	15.0	12.0	90786
M 20 x 1.0	80	30	15.0	12.0	90788
M 22 x 2.0	95	45	17.0	13.0	90793
M 22 x 1.5	95	45	17.0	13.0	90792
M 22 x 1.0	95	45	17.0	13.0	90794
M 24 x 1.5	95	45	19.0	15.0	90798
M 27 x 1.5	95	45	20.0	15.0	91706
M 30 x 1.5	105	45	23.0	17.0	91709

Application:

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

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 盲孔
– 手用和机用



VÖLKEL
THREADING SOLUTIONS

HT Hand Taps
Whitworth-thread BS 84

手用丝锥
惠氏螺纹 BS 84

JIS B 4430 HSS-G Tol. ISO2/6H

W (BSW)

Nominal Diameter D	L 1	L 2	D 2	⊠	Art.-No.
W 1/8x40	47	11	4.0	3.2	94406
W 5/32x32	53	14	5.0	4.0	94408
W 3/16x24	60	17	5.5	4.5	94410
W 1/4x20	62	20	6.0	4.5	94414
W 5/16x18	70	23	6.1	5.0	94416
W 3/8x16	75	25	7.0	5.5	94418
W 7/16x14	80	24	8.0	6.0	94420
W 1/2x13	85	30	9.0	7.0	94422
W 9/16x12	90	30	10.5	8.0	94424
W 5/8x11	95	32	12.0	9.0	94426
W 3/4x10	105	38	14.0	11.0	94430
W 7/8x 9	115	38	17.0	13.0	94434
W 1"x 8	126	45	20.0	15.0	94438
W 1.1/4x 7	145	51	24.0	19.0	94440

Application:

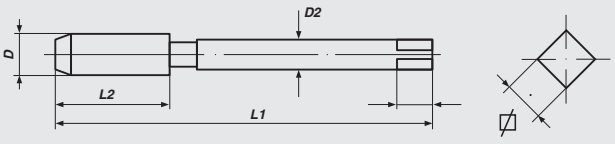
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand and machine

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔和盲孔
– 手用和机用

How to order / 如何订货:

W 1/8	=	94406
W 1/8, No. 1	=	94406-1
W 1/8, No. 2	=	94406-2
W 1/8, No. 3	=	94406-3



PO Spiral Pointed Taps

Whitworth-thread BS 84

螺尖丝锥

惠氏螺纹 BS 84

JIS B 4430 HSS-E

W (BSW)

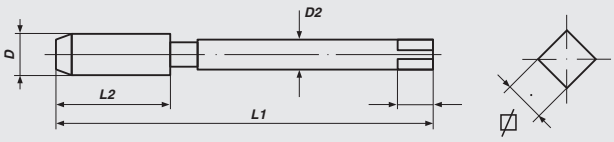
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.
W 1/8x40	47	11	4.0	3.2	94506
W 5/32x32	53	14	5.0	4.0	94508
W 3/16x24	60	17	5.5	4.5	94510
W 1/4x20	62	20	6.0	4.5	94514
W 5/16x18	70	23	6.1	5.0	94516
W 3/8x16	75	25	7.0	5.5	94518
W 7/16x14	80	24	8.0	6.0	94520
W 1/2x13	85	30	9.0	7.0	94522
W 9/16x12	90	30	10.5	8.0	94524
W 5/8x11	95	32	12.0	9.0	94526
W 3/4x10	105	38	14.0	11.0	94530
W 7/8x 9	115	38	17.0	13.0	94534
W 1"x 8	126	45	20.0	15.0	94538
W 1.1/4x 7	145	51	24.0	19.0	94540

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

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔
– 手用和机用



VÖLKEL
THREADING SOLUTIONS

SP Spiral Fluted Taps

Whitworth-thread BS 84

螺旋槽丝锥

惠氏螺纹 BS 84

JIS B 4430 HSS-E

W (BSW)

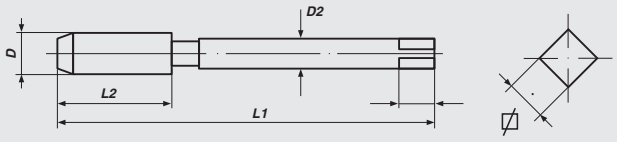
Nominal Diameter D	L 1	L 2	D 2	⊠	Art.-No.
W 1/8x40	47	11	4.0	3.2	94706
W 5/32x32	53	14	5.0	4.0	94708
W 3/16x24	60	17	5.5	4.5	94710
W 1/4x20	62	20	6.0	4.5	94714
W 5/16x18	70	23	6.1	5.0	94716
W 3/8x16	75	25	7.0	5.5	94718
W 7/16x14	80	24	8.0	6.0	94720
W 1/2x13	85	30	9.0	7.0	94722
W 9/16x12	90	30	10.5	8.0	94724
W 5/8x11	95	32	12.0	9.0	94726
W 3/4x10	105	38	14.0	11.0	94730
W 7/8x 9	115	38	17.0	13.0	94734
W 1"x 8	126	45	20.0	15.0	94738
W 1.1/4x17	145	51	24.0	19.0	94740

Application:

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

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 盲孔
– 手用和机用



HT Hand Taps
Unified thread ANSI B 1.1

手用丝锥
统一制螺纹 ANSI B 1.1

JIS B 4430 HSS-G Tol. 2B

UNC / UNF

Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.
UNC					
UNC 3/16x24	60	17	5.5	4.5	93413
UNC 1/4x20	62	20	6.0	4.5	93414
UNC 5/16x18	70	23	6.1	5.0	93415
UNC 3/8x16	75	25	7.0	5.5	93416
UNC 7/16x14	80	24	8.0	6.0	93417
UNC 1/2x13	85	30	9.0	7.0	93418
UNC 5/8x11	95	32	12.0	9.0	93420
UNC 3/4x10	105	38	14.0	11.0	93422
UNC 7/8x 9	115	38	17.0	13.0	93424
UNC 1"x 8	126	45	20.0	15.0	93426
UNF					
UNF 3/16x32	60	17	5.5	4.5	93463
UNF 1/4x28	62	20	6.0	4.5	93464
UNF 5/16x24	70	23	6.1	5.0	93465
UNF 3/8x24	75	25	7.0	5.5	93466
UNF 7/16x20	80	24	8.0	6.0	93467
UNF 1/2x20	85	30	9.0	7.0	93468
UNF 5/8x18	95	32	12.0	9.0	93470
UNF 3/4x16	105	38	14.0	11.0	93472
UNF 7/8x14	115	38	17.0	13.0	93474
UNF 1"x12	126	45	20.0	15.0	93476

Application:

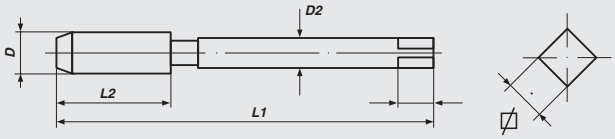
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand and machine

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔和盲孔
– 手用和机用

How to order/如何订货:

UNC 1/4	=	93414
UNC 1/4, No. 1	=	93414-1
UNC 1/4, No. 2	=	93414-2
UNC 1/4, No. 3	=	93414-3



VÖLKEL
THREADING SOLUTIONS

PO Spiral Pointed Taps

Unified Coarse thread ANSI B 1.1

螺尖丝锥

统一制粗牙螺纹 ANSI B 1.1

JIS B 4430 HSS-E Tol. 2B

UNC

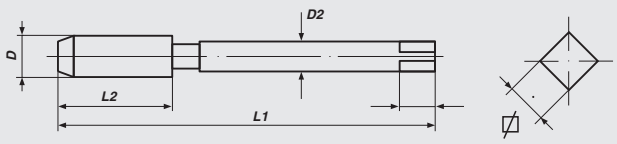
Nominal Diameter D	L 1	L 2	D 2	⊠	Art.-No.
UNC Nr. 4x40	45	10	3.0	2.5	93504
UNC Nr. 5x40	47	12	4.0	3.2	93505
UNC Nr. 6x32	49	14	4.0	3.2	93506
UNC Nr. 8x32	53	14	5.0	4.0	93508
UNC Nr. 10x24	61	17	5.5	4.5	93509
UNC Nr. 12x24	61	17	5.5	4.5	93510
UNC 1/4x20	62	20	6.0	4.5	93514
UNC 5/16x18	70	23	6.1	5.0	93515
UNC 3/8x16	75	25	7.0	5.5	93516
UNC 7/16x14	80	24	8.0	6.0	93517
UNC 1/2x13	85	30	9.0	7.0	93518
UNC 9/16x12	90	30	10.5	8.0	93519
UNC 5/8x11	95	32	12.0	9.0	93520
UNC 3/4x10	105	38	14.0	11.0	93522
UNC 7/8x 9	115	38	17.0	13.0	93524
UNC 1"x 8	126	45	20.0	15.0	93526

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

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔
– 手用和机用



PO Spiral Pointed Taps
Unified Fine thread ANSI B 1.1

螺尖丝锥
统一制细牙螺纹 ANSI B 1.1

JIS B 4430 HSS-E Tol. 2B

UNF

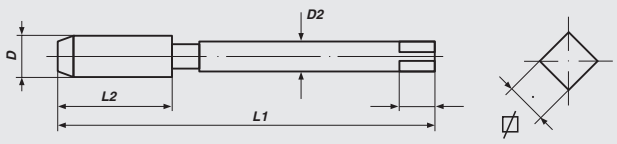
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.
UNF Nr. 4x48	45	10	3.0	2.5	93554
UNF Nr. 5x44	47	12	4.0	3.2	93555
UNF Nr. 6x40	49	14	4.0	3.2	93556
UNF Nr. 8x36	53	14	5.0	4.0	93558
UNF Nr. 10x32	61	17	5.5	4.5	93559
UNF Nr. 12x28	61	17	5.5	4.5	93560
UNF 1/8x44	47	11	4.0	3.2	93561
UNF 5/32x36	53	14	5.0	4.0	93562
UNF 3/16x32	60	17	5.5	4.5	93563
UNF 1/4x28	62	20	6.0	4.5	93564
UNF 5/16x24	70	23	6.1	5.0	93565
UNF 3/8x24	75	25	7.0	5.5	93566
UNF 7/16x20	80	24	8.0	6.0	93567
UNF 1/2x20	85	30	9.0	7.0	93568
UNF 9/16x18	90	30	10.5	8.0	93569
UNF 5/8x18	95	32	12.0	9.0	93570
UNF 3/4x16	105	38	14.0	11.0	93572
UNF 7/8x14	115	38	17.0	13.0	93574
UNF 1"x12	126	45	20.0	15.0	93576

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

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔
– 手用和机用



VÖLKEL
THREADING SOLUTIONS

SP Spiral Fluted Taps

Unified Coarse thread ANSI B 1.1

螺旋槽丝锥

统一制粗牙螺纹 ANSI B 1.1

JIS B 4430 HSS-E Tol. 2B

UNC

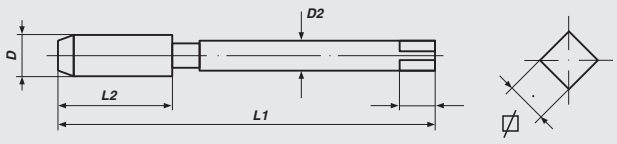
Nominal Diameter D	L 1	L 2	D 2	⊠	Art.-No.
UNC Nr. 4x40	45	10	3.0	2.5	93704
UNC Nr. 5x40	47	12	4.0	3.2	93705
UNC Nr. 6x32	49	14	4.0	3.2	93706
UNC Nr. 8x32	53	14	5.0	4.0	93708
UNC Nr. 10x24	61	17	5.5	4.5	93709
UNC Nr. 12x24	61	17	5.5	4.5	93710
UNC 1/8x40	47	11	4.0	3.2	93711
UNC 5/32x32	53	14	5.0	4.0	93712
UNC 3/16x24	60	17	5.5	4.5	93713
UNC 1/4x20	62	20	6.0	4.5	93714
UNC 5/16x18	70	23	6.1	5.0	93715
UNC 3/8x16	75	25	7.0	5.5	93716
UNC 7/16x14	80	24	8.0	6.0	93717
UNC 1/2x13	85	30	9.0	7.0	93718
UNC 9/16x12	90	30	10.5	8.0	93719
UNC 5/8x11	95	32	12.0	9.0	93720
UNC 3/4x10	105	38	14.0	11.0	93722
UNC 7/8x 9	115	38	17.0	13.0	93724
UNC 1"x 8	126	45	20.0	15.0	93726

Application:

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

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 盲孔
– 手用和机用



SP Spiral Fluted Taps
Unified Fine thread ANSI B 1.1

螺旋槽丝锥
统一制细牙螺纹 ANSI B 1.1

JIS B 4430 HSS-E Tol. 2B

UNF

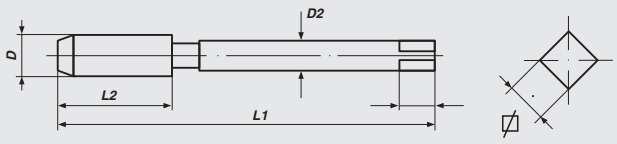
Nominal Diameter D	L 1	L 2	D 2	⊠	Art.-No.
UNF Nr. 4x48	45	10	3.0	2.5	93754
UNF Nr. 5x44	47	12	4.0	3.2	93755
UNF Nr. 6x40	49	14	4.0	3.2	93756
UNF Nr. 8x36	53	14	5.0	4.0	93758
UNF Nr. 10x32	61	17	5.5	4.5	93759
UNF Nr. 12x28	61	17	5.5	4.5	93760
UNF 1/8x44	47	11	4.0	3.2	93761
UNF 5/32x36	53	14	5.0	4.0	93762
UNF 3/16x32	60	17	5.5	4.5	93763
UNF 1/4x28	62	20	6.0	4.5	93764
UNF 5/16x24	70	23	6.1	5.0	93765
UNF 3/8x24	75	25	7.0	5.5	93766
UNF 7/16x20	80	24	8.0	6.0	93767
UNF 1/2x20	85	30	9.0	7.0	93768
UNF 9/16x18	90	30	10.5	8.0	93769
UNF 5/8x18	95	32	12.0	9.0	93770
UNF 3/4x16	105	38	14.0	11.0	93772
UNF 7/8x14	115	38	17.0	13.0	93774
UNF 1"x12	126	45	20.0	15.0	93776

Application:

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

应用:

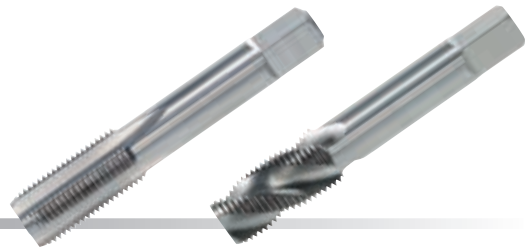
通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 盲孔
– 手用和机用



VÖLKEL
THREADING SOLUTIONS

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

机用丝锥
管螺纹 ISO 7–1 (DIN EN 10226–1)



JIS B 4430 HSS-G

PS (BSPP / Rp)

Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.
HT Straight Flute Form C / 直槽 Form C					
PS 1/16 x 28	55	19	6.5	5.0	95402
PS 1/8 x 28	55	19	8.0	6.0	95406
PS 1/4 x 19	62	28	11.0	9.0	95414
PS 3/8 x 19	65	28	14.0	11.0	95418
PS 1/2 x 14	80	35	18.0	14.0	95422
PS 3/4 x 14	85	35	23.0	17.0	95430
PS 1" x 11	95	45	26.0	21.0	95438
PS 1.1/4 x 11	105	45	32.0	26.0	95446
PS 1.1/2 x 11	110	45	38.0	29.0	95454
PS 2" x 11	120	50	46.0	35.0	95470
SP Spiral Flute / 螺旋槽					
PS 1/16 x 28	55	19	6.5	5.0	95702
PS 1/8 x 28	55	19	8.0	6.0	95706
PS 1/4 x 19	62	28	11.0	9.0	95714
PS 3/8 x 19	65	28	14.0	11.0	95718
PS 1/2 x 14	80	35	18.0	14.0	95722
PS 3/4 x 14	85	35	23.0	17.0	95730
PS 1" x 11	95	45	26.0	21.0	95738
PS 1.1/4 x 11	105	45	32.0	26.0	95746
PS 1.1/2 x 11	110	45	38.0	29.0	95754
PS 2" x 11	120	50	46.0	35.0	95770

Application:

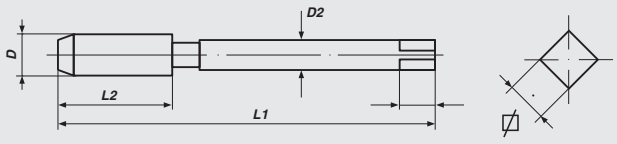
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for thread cutting by hand and machine

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

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 手用和机用

Form C: 用于通孔和盲孔
螺旋槽: 用于盲孔



HT Hand Taps
Pipe-thread DIN ISO 228

手用丝锥
管螺纹 DIN ISO 228

JIS B 4430 HSS-G

PF (BSPF / G)

Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.
PF 1/16x28	55	17.5	8.0	6.0	96402
PF 1/8x28	55	19.0	8.0	6.0	96406
PF 1/4x19	62	28.0	11.0	9.0	96414
PF 3/8x19	65	28.0	14.0	11.0	96418
PF 1/2x14	80	35.0	18.0	14.0	96422
PF 3/4x14	85	35.0	23.0	17.0	96430
PF 1"x11	95	45.0	26.0	21.0	96438
PF 1.1/4x11	105	45.0	32.0	26.0	96446
PF 1.1/2x11	110	45.0	38.0	29.0	96454
PF 2"x11	120	50.0	46.0	35.0	96470

Application:

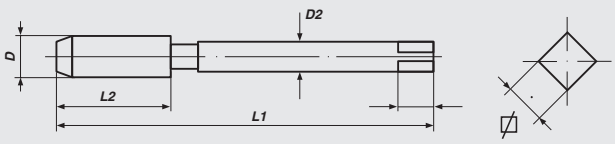
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand and machine

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔和盲孔
– 手用和机用

How to order/如何订货:

PF 1/4	=	96402
PF 1/4, No. 1	=	96402-1
PF 1/4, No. 3	=	96402-3



VÖLKEL
THREADING SOLUTIONS

Machine Taps
Pipe-thread DIN ISO 228

机用丝锥
管螺纹 DIN ISO 228

JIS B 4430 HSS-E

PF (BSPF / G)

Nominal Diameter D	L 1	L 2	D 2	⊠	Art.-No.
PO Spiral Point / 螺尖					
PF 1/16x28	55	17.5	8.0	6.0	96502
PF 1/8x28	55	19.0	8.0	6.0	96506
PF 1/4x19	62	28.0	11.0	9.0	96514
PF 3/8x19	65	28.0	14.0	11.0	96518
PF 1/2x14	80	35.0	18.0	14.0	96522
PF 3/4x14	85	35.0	23.0	17.0	96530
PF 1"x11	95	45.0	26.0	21.0	96538
PF 1.1/4x11	105	45.0	32.0	26.0	96546
PF 1.1/2x11	110	45.0	38.0	29.0	96554
PF 2"x11	120	50.0	46.0	35.0	96570
SP Spiral Flute / 螺旋槽					
PF 1/16x28	55	17.5	8.0	6.0	96702
PF 1/8x28	55	19.0	8.0	6.0	96706
PF 1/4x19	62	28.0	11.0	9.0	96714
PF 3/8x19	65	28.0	14.0	11.0	96718
PF 1/2x14	80	35.0	18.0	14.0	96722
PF 3/4x14	85	35.0	23.0	17.0	96730
PF 1"x11	95	45.0	26.0	21.0	96738
PF 1.1/4x11	105	45.0	32.0	26.0	96746
PF 1.1/2x11	110	45.0	38.0	29.0	96754
PF 2"x11	120	50.0	46.0	35.0	96770

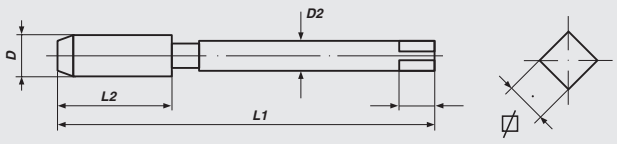
Application:

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

PO: for through holes
SP: for blind holes

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 手用和机用
螺尖: 用于通孔
螺旋槽: 用于盲孔



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

机用丝锥
锥管螺纹, 锥度 1:16, 牙型角55°

JIS B 4430 HSS-G

PT (BSPT / Rc)

Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.
HT Straigt Flute Form C / 直槽Form C					
PT 1/16 x 28	55	17.5	8.0	6.0	97402
PT 1/8 x 28	55	19.0	8.0	6.0	97406
PT 1/4 x 19	62	28.0	11.0	9.0	97414
PT 3/8 x 19	65	28.0	14.0	11.0	97418
PT 1/2 x 14	80	35.0	18.0	14.0	97422
PT 3/4 x 14	85	35.0	23.0	17.0	97430
PT 1" x 11	95	45.0	26.0	21.0	97438
PT 1.1/4 x 11	105	45.0	32.0	26.0	97446
PT 1.1/2 x 11	110	45.0	38.0	29.0	97454
PT 2" x 11	120	50.0	46.0	35.0	97470
PO Spiral Point / 螺尖					
PT 1/16 x 28	55	17.5	8.0	6.0	97502
PT 1/8 x 28	55	19.0	8.0	6.0	97506
PT 1/4 x 19	62	28.0	11.0	9.0	97514
PT 3/8 x 19	65	28.0	14.0	11.0	97518
PT 1/2 x 14	80	35.0	18.0	14.0	97522
PT 3/4 x 14	85	35.0	23.0	17.0	97530
PT 1" x 11	95	45.0	26.0	21.0	97538
PT 1.1/4 x 11	105	45.0	32.0	26.0	97546
PT 1.1/2 x 11	110	45.0	38.0	29.0	97554
PT 2" x 11	120	50.0	46.0	35.0	97570
SP Spiral Flute / 螺旋槽					
PT 1/16 x 28	55	17.5	8.0	6.0	97702
PT 1/8 x 28	55	19.0	8.0	6.0	97706
PT 1/4 x 19	62	28.0	11.0	9.0	97714
PT 3/8 x 19	65	28.0	14.0	11.0	97718
PT 1/2 x 14	80	35.0	18.0	14.0	97722
PT 3/4 x 14	85	35.0	23.0	17.0	97730
PT 1" x 11	95	45.0	26.0	21.0	97738
PT 1.1/4 x 11	105	45.0	32.0	26.0	97746
PT 1.1/2 x 11	110	45.0	38.0	29.0	97754
PT 2" x 11	120	50.0	46.0	35.0	97770

Application:

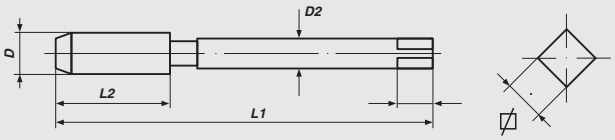
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for thread cutting by hand and machine

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

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 手用和机用

Form C: 用于通孔和盲孔
螺尖: 用于通孔
螺旋槽: 用于盲孔



VÖLKEL
THREADING SOLUTIONS

Machine Taps
american tapered pipe thread, taper 1:16

机用丝锥
美标锥管螺纹, 锥度 1:16

JIS B 4430 HSS-G

NPT

Nominal Diameter D	L 1	L 2	D 2	⊠	Art.-No.
Straight Flute Form C / 直槽 Form C					
NPT 1/16 x 27	55	17.5	8.0	6.0	98402
NPT 1/8 x 27	55	19.0	8.0	6.0	98406
NPT 1/4 x 18	62	28.0	11.0	9.0	98414
NPT 3/8 x 18	65	28.0	14.0	11.0	98418
NPT 1/2 x 14	80	35.0	18.0	14.0	98422
NPT 3/4 x 14	85	35.0	23.0	17.0	98430
NPT 1" x 11.5	95	45.0	26.0	21.0	98438
NPT 1.1/4 x 11.5	105	45.0	32.0	26.0	98446
NPT 1.1/2 x 11.5	110	45.0	38.0	29.0	98454
NPT 2" x 11.5	120	50.0	46.0	35.0	98470
PO Spiral Point / 螺尖					
NPT 1/16 x 27	55	17.5	8.0	6.0	98502
NPT 1/8 x 27	55	19.0	8.0	6.0	98506
NPT 1/4 x 18	62	28.0	11.0	9.0	98514
NPT 3/8 x 18	65	28.0	14.0	11.0	98518
NPT 1/2 x 14	80	35.0	18.0	14.0	98522
NPT 3/4 x 14	85	35.0	23.0	17.0	98530
NPT 1" x 11.5	95	45.0	26.0	21.0	98538
NPT 1.1/4 x 11.5	105	45.0	32.0	26.0	98546
NPT 1.1/2 x 11.5	110	45.0	38.0	29.0	98554
NPT 2" x 11.5	120	50.0	46.0	35.0	98570
SP Spiral Flute / 螺旋槽					
NPT 1/16 x 27	55	17.5	8.0	6.0	98702
NPT 1/8 x 27	55	19.0	8.0	6.0	98706
NPT 1/4 x 18	62	28.0	11.0	9.0	98714
NPT 3/8 x 18	65	28.0	14.0	11.0	98718
NPT 1/2 x 14	80	35.0	18.0	14.0	98722
NPT 3/4 x 14	85	35.0	23.0	17.0	98730
NPT 1" x 11.5	95	45.0	26.0	21.0	98738
NPT 1.1/4 x 11.5	105	45.0	32.0	26.0	98746
NPT 1.1/2 x 11.5	110	45.0	38.0	29.0	98754
NPT 2" x 11.5	120	50.0	46.0	35.0	98770

Application:

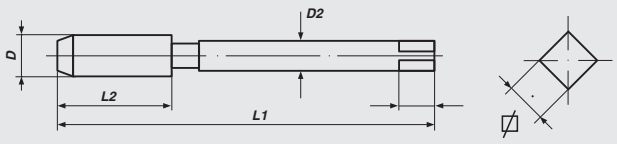
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for thread cutting by hand and machine

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

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 手用和机用

Form C: 用于通孔和盲孔
螺尖: 用于通孔
螺旋槽: 用于盲孔



Machine Taps
american tapered pipe thread, taper 1:16

机用丝锥
美标锥管螺纹, 锥度 1:16

JIS B 4430 HSS-E

NPTF

Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.
PO Spiral Point / 螺尖					
NPTF 1/16 x 27	55	19	6.5	5.0	98571
NPTF 1/8 x 27	55	19	8.0	6.0	98572
NPTF 1/4 x 18	62	28	11.0	9.0	98574
NPTF 3/8 x 18	65	28	14.0	11.0	98576
NPTF 1/2 x 14	80	35	18.0	14.0	98578
NPTF 3/4 x 14	85	35	23.0	17.0	98580
NPTF 1" x 11.5	95	45	26.0	21.0	98582
NPTF 1.1/4 x 11.5	105	45	32.0	26.0	98584
NPTF 1.1/2 x 11.5	110	45	38.0	29.0	98586
NPTF 2" x 11.5	120	50	46.0	35.0	98588
SP Spiral Flute / 螺旋槽					
NPTF 1/8 x 27	55	19	8.0	6.0	98772
NPTF 1/4 x 18	62	28	11.0	9.0	98774
NPTF 3/8 x 18	65	28	14.0	11.0	98776
NPTF 1/2 x 14	80	35	18.0	14.0	98778
NPTF 3/4 x 14	85	35	23.0	17.0	98780
NPTF 1" x 11.5	95	45	26.0	21.0	98782

Application:

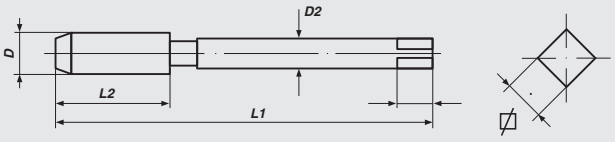
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for thread cutting by hand and machine

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

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 手用和机用

螺尖: 用于通孔
螺旋槽: 用于盲孔



VÖLKEL
THREADING SOLUTIONS

Machine Taps
american tapered pipe thread,

机用丝锥
美标锥管螺纹

JIS B 4430 HSS-E

NPS

Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.
HT Straight Flute Form C / 直槽 Form C					
NPS 1/16 x 27	54	17.5	8.0	6.0	99402
NPS 1/8 x 27	55	19.0	8.0	6.0	99406
NPS 1/4 x 18	62	28.0	11.0	9.0	99414
NPS 3/8 x 18	65	28.0	14.0	11.0	99418
NPS 1/2 x 14	80	35.0	18.0	14.0	99422
NPS 3/4 x 14	85	35.0	23.0	17.0	99430
NPS 1" x 11.5	95	45.0	26.0	21.0	99438
NPS 1.1/4 x 11.5	105	45.0	32.0	26.0	99446
NPS 1.1/2 x 11.5	110	45.0	38.0	29.0	99454
NPS 2" x 11.5	120	50.0	46.0	35.0	99470
SP Spiral Flute / 螺旋槽					
NPS 1/16 x 27	54	17.5	8.0	6.0	99702
NPS 1/8 x 27	55	19.0	8.0	6.0	99706
NPS 1/4 x 18	62	28.0	11.0	9.0	99714
NPS 3/8 x 18	65	28.0	14.0	11.0	99718
NPS 1/2 x 14	80	35.0	18.0	14.0	99722
NPS 3/4 x 14	85	35.0	23.0	17.0	99730
NPS 1" x 11.5	95	45.0	26.0	21.0	99738
NPS 1.1/4 x 11.5	105	45.0	32.0	26.0	99746
NPS 1.1/2 x 11.5	110	45.0	38.0	29.0	99754
NPS 2" x 11.5	120	50.0	46.0	35.0	99770

Application:

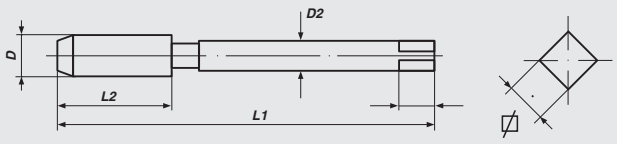
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for thread cutting by hand and machine

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

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 手用和机用

Form C: 用于通孔和盲孔
螺旋槽: 用于盲孔



MACHINE TAPS WITH COLOURED RING
彩圈机用丝锥

	Form B/A/C	39°RSP	TwinBox
for general use 通用	40	41	161
PM for general use 通用	42	43	
for wear resistant steel 耐磨钢	44	45	162
for stainless steel 不锈钢	46	47	163
for cast iron 铸铁	156		
Material from 1200 N/mm² tensile strength 抗拉强度大于1200 N/mm²的材料	159		
for aluminium alloys 铝合金		157	
for brass 黄铜	158		

RECOMMENDED APPLICATION OF COLOURED RING MACHINE TAPS
彩圈机用丝锥使用建议

Material **材料**	Lubricant 润滑剂	Cutting Speed 切削速度 m/min.
Steel, unalloyed and low alloyed, short-chipping 非合金钢和低合金钢, 短屑	S/E	10-20
non abrasive Material, short-chipping 非研磨材料, 短屑	S/E	6-15
Steel, heat resistant, long-chipping 耐热钢, 长屑	S	4- 8
Steel, heat resistant, short-chipping 耐热钢, 短屑	S	4- 8
Steel, cementation and heat treatable, short-chipping 渗碳钢、可热处理钢, 短屑	S	4- 8
Steel, Tool Steel up to 1200 N/mm² 工具钢, 抗拉强度小于1200 N/mm²	S	2- 5
Steel, Tool Steel over 1200 N/mm² 工具钢, 抗拉强度大于1200 N/mm²	S	2- 5
Steel stainless, short-chipping 不锈钢, 短屑	S	5-10
Steel stainless, long-chipping 不锈钢, 长屑	S	5-10
Iron, Cast 铸铁	P/T	6-20
Iron, spheroidal graphite 球墨铸铁	P/T	6-20
Iron, Malleable Cast 可锻铸铁	E	6-12
Brass, short-chipping 黄铜, 短屑	E	20-30
Brass, long-chipping 黄铜, 长屑	S/E	10-15
Bronze, short-chipping 青铜, 短屑	S/E	6-15
Bronze, long-chipping 青铜, 长屑	S/E	6-15
Copper 紫铜	S/E	10-15
Aluminium-alloys, short-chipping 铝合金, 短屑	S/E	15-30
Aluminium-alloys, long-chipping 铝合金, 长屑	E	10-20
Zinc Alloys 锌合金	S/E	10-15
Magnesium Alloys 镁合金	E/T	10-20
Titanium, short-chipping 钛合金, 短屑	S	3- 4
Titanium, long-chipping 钛合金, 长屑	S	3- 4
Plastics, thermoplastics 热塑性塑料	E/T	5-15
Plastics, thermosetting 热固性塑料	T	5-15

S = cutting oil /切削油　　E = oil emulsion /乳化油　　P = kerosene / 煤油　　T = dry / 干性

RECOMMENDED APPLICATION OF COLOURED RING MACHINE TAPS
彩圈机用丝锥使用建议

Material **材料**	Green Ring 绿圈	Blue Ring 蓝圈	White Ring 白圈	Black Ring 黑圈	Red Ring 红圈	Yellow Ring 黄圈	Orange Ring 橙圈
Steel, unalloyed and low alloyed, short-chipping 非合金钢和低合金钢, 短屑	● PM						
non abrasive Material, short-chipping 非研磨材料, 短屑	● PM						
Steel, heat resistant, long-chipping 耐热钢, 长屑	PM		○				
Steel, heat resistant, short-chipping 耐热钢, 短屑	PM	●					
Steel, cementation and heat treatable, short-chipping 渗碳钢、可热处理钢, 短屑	PM	●					
Steel, Tool Steel up to 1200 N/mm² 工具钢, 抗拉强度小于1200 N/mm²		●					
Steel, Tool Steel over 1200 N/mm² 工具钢, 抗拉强度大于1200 N/mm²					●		
Steel stainless, short-chipping 不锈钢, 短屑	PM	●					
Steel stainless, long-chipping 不锈钢, 长屑	PM		○				
Iron, Cast 铸铁				●			
Iron, spheroidal graphite 球墨铸铁		●					
Iron, Malleable Cast 可锻铸铁	● PM						
Brass, short-chipping 黄铜, 短屑		●		●			●
Brass, long-chipping 黄铜, 长屑	● PM						
Bronze, short-chipping 青铜, 短屑		●		●			
Bronze, long-chipping 青铜, 长屑	● PM						
Copper 紫铜	● PM						
Aluminium-alloys, short-chipping 铝合金, 短屑		●					
Aluminium-alloys, long-chipping 铝合金, 长屑	● PM					●	
Zinc Alloys 锌合金	● PM						
Magnesium Alloys 镁合金	● PM	●					
Titanium, short-chipping 钛合金, 短屑		●					
Titanium, long-chipping 钛合金, 长屑			○				
Plastics, thermoplastics 热塑性塑料	● PM						
Plastics, thermosetting 热固性塑料				●	●		

VÖLKEL
THREADING SOLUTIONS

GREEN RING PO Machine Taps
metric ISO-thread DIN 13

绿圈螺尖机用丝锥
公制ISO螺纹 DIN 13

JIS B - 4430 PO Spiral Point HSS-E

M

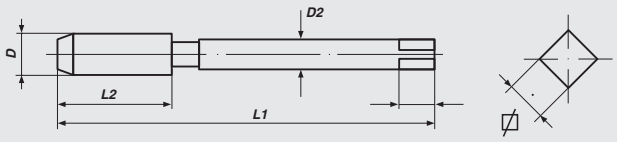
Nominal Diameter D		L 1	L 2	D 2	⊠	Tolerance	Art.-No.
M	2 x 0.4	42	8	3.0	2.5	OH1	91601
M	2.3 x 0.4	42	8	3.0	2.5	OH1	91602
M	2.5 x 0.45	44	8	3.0	2.5	OH2	91603
M	2.6 x 0.45	44	8	3.0	2.5	OH2	91604
M	3 x 0.5	46	9	4.0	3.2	OH2	91605
M	3.5 x 0.6	48	11	4.0	3.2	OH2	91606
M	4 x 0.7	52	11	5.0	4.0	OH2	91607
M	5 x 0.8	60	14	5.5	4.5	OH2	91609
M	6 x 1.0	62	17	6.0	4.5	OH2	91611
M	6 x 0.75	62	17	6.0	4.5	OH2	91612
M	8 x 1.25	70	20	6.2	5.0	OH3	91613
M	8 x 1.0	70	20	6.2	5.0	OH3	91614
M	8 x 0.75	70	20	6.2	5.0	OH3	91624
M	10 x 1.5	75	22	7.0	5.5	OH3	91615
M	10 x 1.25	75	22	7.0	5.5	OH3	91616
M	10 x 1.0	75	22	7.0	5.5	OH3	91626
M	12 x 1.75	82	27	8.5	6.5	OH4	91617
M	12 x 1.5	82	27	8.5	6.5	OH4	91690
M	12 x 1.25	82	27	8.5	6.5	OH4	91618
M	12 x 1.0	82	27	8.5	6.5	OH4	91627
M	14 x 2.0	88	28	10.5	8.0	OH4	91619
M	14 x 1.5	88	28	10.5	8.0	OH4	91620
M	14 x 1.25	88	28	10.5	8.0	OH4	91628
M	16 x 2.0	95	30	12.5	10.0	OH4	91621
M	16 x 1.5	95	30	12.5	10.0	OH4	91622
M	16 x 1.0	95	30	12.5	10.0	OH4	91629
M	18 x 2.5	100	32	14.0	11.0	OH4	91623
M	20 x 2.5	105	32	15.0	12.0	OH4	91625

Application:

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

应用:

通用
– 抗拉强度小于1000N/mm²的非研磨材料
– 非合金钢和低合金钢
– 长屑
– 通孔



GREEN RING SP Machine Taps

metric ISO-thread DIN 13

绿圈螺旋槽机用丝锥

公制ISO螺纹 DIN 13

JIS B - 4430 SP Spiral Flute HSS-E

M

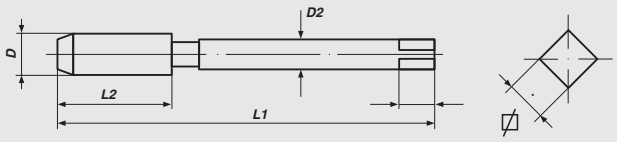
Nominal Diameter D	L 1	L 2	D 2	⊠	Tolerance	Art.-No.
M 2 x 0.4	42	6	3.0	2.5	OH1	91801
M 2.3 x 0.4	42	6	3.0	2.5	OH1	91802
M 2.5 x 0.45	44	6	3.0	2.5	OH1	91803
M 2.6 x 0.45	44	6	3.0	2.5	OH1	91804
M 3 x 0.5	46	6	4.0	3.2	OH1	91805
M 3.5 x 0.6	48	7	4.0	3.2	OH2	91806
M 4 x 0.7	52	7	5.0	4.0	OH2	91807
M 5 x 0.8	60	8	5.5	4.5	OH2	91809
M 6 x 1.0	62	10	6.0	4.5	OH2	91811
M 6 x 0.75	62	10	6.0	4.5	OH2	91812
M 8 x 1.25	70	14	6.2	5.0	OH2	91813
M 8 x 1.0	70	14	6.2	5.0	OH2	91814
M 8 x 0.75	70	14	6.2	5.0	OH2	91824
M 10 x 1.5	75	16	7.0	5.5	OH2	91815
M 10 x 1.25	75	16	7.0	5.5	OH2	91816
M 10 x 1.0	75	16	7.0	5.5	OH2	91826
M 12 x 1.75	82	18	8.5	6.5	OH2	91817
M 12 x 1.5	82	18	8.5	6.5	OH2	91890
M 12 x 1.25	82	18	8.5	6.5	OH2	91818
M 12 x 1.0	82	18	8.5	6.5	OH2	91827
M 14 x 2.0	88	20	10.5	8.0	OH2	91819
M 14 x 1.5	88	20	10.5	8.0	OH2	91820
M 14 x 1.25	88	20	10.5	8.0	OH2	91828
M 16 x 2.0	95	22	12.5	10.0	OH2	91821
M 16 x 1.5	95	22	12.5	10.0	OH2	91822
M 16 x 1.0	95	22	12.5	10.0	OH2	91829
M 18 x 2.5	100	25	14.0	11.0	OH3	91823
M 20 x 2.5	105	25	15.0	12.0	OH3	91825

Application:

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

应用:

通用
– 抗拉强度小于1000N/mm²的非研磨材料
– 非合金钢和低合金钢
– 长屑
– 盲孔



VÖLKEL THREADING SOLUTIONS

GREEN RING PO Machine Taps

metric ISO-thread DIN 13

绿圈螺尖机用丝锥

公制ISO螺纹 DIN 13

JIS B - 4430 PO Spiral Point HSSE-PM-TIN

M

Nominal Diameter D		L 1	L 2	D 2	⧄	Tolerance	Art.-No.
M	3 x 0.5	46	9	4.0	3.2	OH2	91105
M	4 x 0.7	52	11	5.0	4.0	OH2	91107
M	5 x 0.8	60	14	5.5	4.5	OH2	91108
M	6 x 1.0	62	17	6.0	4.5	OH2	91109
M	8 x 1.25	70	20	6.2	5.0	OH3	91111
M	10 x 1.5	75	22	7.0	5.5	OH3	91113
M	12 x 1.75	82	27	8.5	6.5	OH4	91115
M	14 x 2.0	88	28	10.5	8.0	OH4	91116
M	16 x 2.0	95	30	12.5	10.0	OH4	91117

Application:

for general use
- non abrasive material up to 1000 N/mm²
- stainless and alloyed steel
- unalloyed and low alloyed steel
- copper and aluminium alloys
- PO Spiral Point 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

应用:

通用
– 抗拉强度小于1000N/mm²的非研磨材料
– 不锈钢和合金钢
– 非合金钢和低合金钢
– 紫铜和铝合金
– 通孔

HSSE-PM-TIN的优点
– 增加韧性和耐磨性
– TiN涂层减少摩擦、磨损和切屑粘在工具表面

GREEN RING SP Machine Taps
metric ISO-thread DIN 13

绿圈螺旋槽机用丝锥
公制ISO螺纹 DIN 13

JIS B - 4430 SP Spiral Flute HSSE-PM-TIN

M

Nominal Diameter D	L 1	L 2	D 2	⧄	Tolerance	Art.-No.
M 3 x 0.5	46	6	4.0	3.2	OH1	91155
M 4 x 0.7	52	7	5.0	4.0	OH2	91157
M 5 x 0.8	60	8	5.5	4.5	OH2	91158
M 6 x 1.0	62	10	6.0	4.5	OH2	91159
M 8 x 1.25	70	14	6.2	5.0	OH2	91161
M 10 x 1.5	75	16	7.0	5.5	OH2	91163
M 12 x 1.75	82	18	8.5	6.5	OH2	91165
M 14 x 2.0	88	20	10.5	8.0	OH2	91166
M 16 x 2.0	95	22	12.5	10.0	OH2	91167

Application:

for general use
- non abrasive material up to 1000 N/mm²
- stainless and alloyed steel
- unalloyed and low alloyed steel
- copper and aluminium alloys
- SP Spiral Flute 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

应用:

通用
– 抗拉强度小于1000N/mm²的非研磨材料
– 不锈钢和合金钢
– 非合金钢和低合金钢
– 紫铜和铝合金
– 盲孔

HSSE-PM-TIN的优点
– 增加韧性和耐磨性
– TiN涂层减少摩擦、磨损和切屑粘在工具表面

VÖLKEL
THREADING SOLUTIONS

BLUE RING PO Machine Taps

metric ISO-thread DIN 13

蓝圈螺尖机用丝锥

公制ISO螺纹 DIN 13

JIS B - 4430 PO Spiral Point HSS-E

M

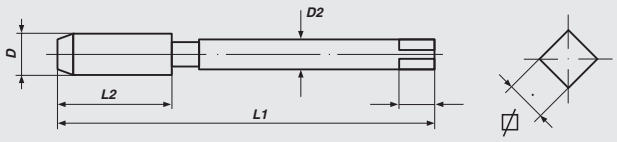
Nominal Diameter D		L 1	L 2	D 2	⧄	Tolerance	Art.-No.
M	3 x 0.5	46	9	4.0	3.2	OH2	91305
M	4 x 0.7	52	11	5.0	4.0	OH2	91307
M	5 x 0.8	60	14	5.5	4.5	OH2	91308
M	6 x 1.0	62	17	6.0	4.5	OH2	91309
M	6 x 0.75	62	17	6.0	4.5	OH2	91330
M	8 x 1.25	70	20	6.2	5.0	OH3	91311
M	8 x 1.0	70	20	6.2	5.0	OH3	91331
M	8 x 0.75	70	20	6.2	5.0	OH3	91332
M	10 x 1.5	75	22	7.0	5.5	OH3	91313
M	10 x 1.25	75	22	7.0	5.5	OH3	91333
M	10 x 1.0	75	22	7.0	5.5	OH3	91334
M	12 x 1.75	82	27	8.5	6.5	OH4	91315
M	12 x 1.5	82	27	8.5	6.5	OH4	91335
M	12 x 1.25	82	27	8.5	6.5	OH4	91336
M	12 x 1.0	82	27	8.5	6.5	OH4	91337
M	14 x 2.0	88	28	10.5	8.0	OH4	91316
M	14 x 1.5	88	28	10.5	8.0	OH4	91338
M	14 x 1.25	88	28	10.5	8.0	OH4	91339
M	16 x 2.0	95	30	12.5	10.0	OH4	91317
M	16 x 1.5	95	30	12.5	10.0	OH4	91340
M	16 x 1.0	95	30	12.5	10.0	OH4	91341

Application:

wear resistant steel up to 1200 N/mm²
- high alloy steel
- short chipping material
- short chipping stainless steel
- alloy tools steel
- PO Spiral Point for through holes

应用:

抗拉强度小于1200N/mm²的非研磨材料
– 高合金钢
– 短屑
– 不锈钢，短屑
– 合金工具钢
– 通孔



BLUE RING SP Machine Taps
metric ISO-thread DIN 13

蓝圈螺旋槽机用丝锥
公制ISO螺纹 DIN 13

JIS B - 4430 SP Spiral Flute HSS-E

M

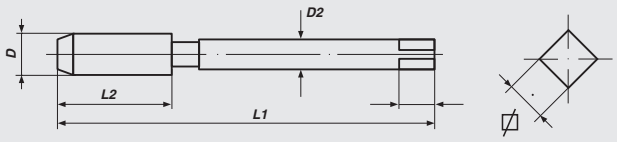
Nominal Diameter D	L 1	L 2	D 2	⧄	Tolerance	Art.-No.
M 3 x 0.5	46	6	4.0	3.2	OH2	91355
M 4 x 0.7	52	7	5.0	4.0	OH2	91357
M 5 x 0.8	60	8	5.5	4.5	OH2	91358
M 6 x 1.0	62	10	6.0	4.5	OH2	91359
M 6 x 0.75	62	10	6.0	4.5	OH2	91380
M 8 x 1.25	70	14	6.2	5.0	OH3	91361
M 8 x 1.0	70	14	6.2	5.0	OH2	91381
M 8 x 0.75	70	14	6.2	5.0	OH2	91382
M 10 x 1.5	75	16	7.0	5.5	OH3	91363
M 10 x 1.25	75	16	7.0	5.5	OH3	91383
M 10 x 1.0	75	16	7.0	5.5	OH2	91384
M 12 x 1.75	82	18	8.5	6.5	OH3	91365
M 12 x 1.5	82	18	8.5	6.5	OH3	91385
M 12 x 1.25	82	18	8.5	6.5	OH3	91386
M 12 x 1.0	82	18	8.5	6.5	OH2	91387
M 14 x 2.0	88	20	10.5	8.0	OH3	91366
M 14 x 1.5	88	20	10.5	8.0	OH3	91388
M 14 x 1.25	88	20	10.5	8.0	OH3	91389
M 16 x 2.0	95	22	12.5	10.0	OH3	91367
M 16 x 1.5	95	22	12.5	10.0	OH3	91390
M 16 x 1.0	95	22	12.5	10.0	OH3	91391

Application:

wear resistant steel up to 1200 N/mm²
- high alloy steel
- short chipping material
- short chipping stainless steel
- alloy tools steel
- SP Spiral Flute for blind holes

应用:

抗拉强度小于1200N/mm²的非研磨材料
– 高合金钢
– 短屑
– 不锈钢，短屑
– 合金工具钢
– 盲孔



VÖLKEL
THREADING SOLUTIONS

WHITE RING PO Machine Taps

metric ISO-thread DIN 13

白圈螺尖机用丝锥

公制ISO螺纹 DIN 13

JIS B - 4430 PO Spiral Point HSS-E

M

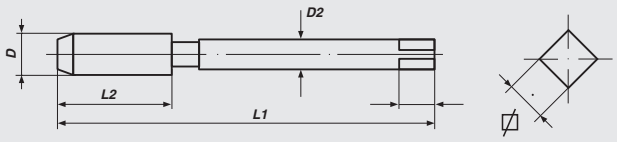
Nominal Diameter D	L 1	L 2	D 2	⧄	Tolerance	Art.-No.
M 3 x 0.5	46	9	4.0	3.2	OH2	91205
M 4 x 0.7	52	11	5.0	4.0	OH2	91207
M 5 x 0.8	60	14	5.5	4.5	OH2	91208
M 6 x 1.0	62	17	6.0	4.5	OH2	91209
M 6 x 0.75	62	17	6.0	4.5	OH2	91230
M 8 x 1.25	70	20	6.2	5.0	OH3	91211
M 8 x 1.0	70	20	6.2	5.0	OH3	91231
M 8 x 0.75	70	20	6.2	5.0	OH3	91232
M 10 x 1.5	75	22	7.0	5.5	OH3	91213
M 10 x 1.25	75	22	7.0	5.5	OH3	91233
M 10 x 1.0	75	22	7.0	5.5	OH3	91234
M 12 x 1.75	82	27	8.5	6.5	OH3	91215
M 12 x 1.5	82	27	8.5	6.5	OH3	91235
M 12 x 1.25	82	27	8.5	6.5	OH3	91236
M 12 x 1.0	82	27	8.5	6.5	OH3	91237
M 14 x 2.0	88	28	10.5	8.0	OH3	91216
M 14 x 1.5	88	28	10.5	8.0	OH3	91238
M 14 x 1.25	88	28	10.5	8.0	OH3	91239
M 16 x 2.0	95	30	12.5	10.0	OH3	91217
M 16 x 1.5	95	30	12.5	10.0	OH3	91240
M 16 x 1.0	95	30	12.5	10.0	OH3	91241

Application:

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

应用:

不锈钢，长屑
抗拉强度小于1000N/mm²
– 研磨材料
– 铬镍合金
– 表面蒸汽处理
– 通孔



WHITE RING SP Machine Taps

metric ISO-thread DIN 13

白圈螺旋槽机用丝锥

公制ISO螺纹 DIN 13

JIS B - 4430 SP Spiral Flute HSS-E

M

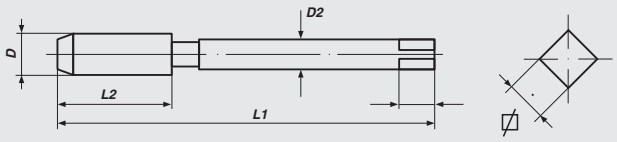
Nominal Diameter D	L 1	L 2	D 2	⧄	Tolerance	Art.-No.
M 3 x 0.5	46	6	4.0	3,2	OH2	91255
M 4 x 0.7	52	7	5.0	4,0	OH2	91257
M 5 x 0.8	60	8	5.5	4,5	OH2	91258
M 6 x 1.0	62	10	6.0	4,5	OH2	91259
M 6 x 0.75	62	10	6.0	4,5	OH2	91280
M 8 x 1.25	70	14	6.2	5,0	OH3	91261
M 8 x 1.0	70	14	6.2	5,0	OH2	91281
M 8 x 0.75	70	14	6.2	5,0	OH2	91282
M 10 x 1.5	75	16	7.0	5,5	OH3	91263
M 10 x 1.25	75	16	7.0	5,5	OH3	91283
M 10 x 1.0	75	16	7.0	5,5	OH2	91284
M 12 x 1.75	82	18	8.5	6,5	OH3	91265
M 12 x 1.5	82	18	8.5	6,5	OH3	91285
M 12 x 1.25	82	18	8.5	6,5	OH3	91286
M 12 x 1.0	82	18	8.5	6,5	OH2	91287
M 14 x 2.0	88	20	10.5	8,0	OH3	91266
M 14 x 1.5	88	20	10.5	8,0	OH3	91288
M 14 x 1.25	88	20	10.5	8,0	OH3	91289
M 16 x 2.0	95	22	12.5	10,0	OH3	91267
M 16 x 1.5	95	22	12.5	10,0	OH3	91290
M 16 x 1.0	95	22	12.5	10,0	OH3	91291

Application:

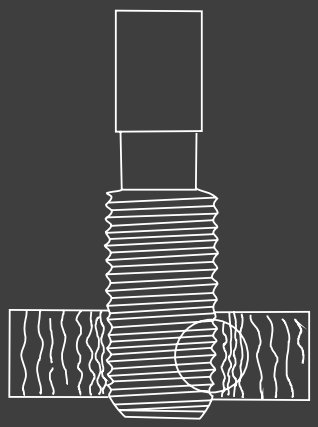
Stainless Steel (INOX),
long chipping up to 1000 N/mm²
- abrasive material
- chrome-nickel alloys
- surface treatment: steam tempered
- SP Spiral Flute for blind holes

应用:

不锈钢，长屑
抗拉强度小于1000N/mm²
– 研磨材料
– 铬镍合金
– 表面蒸汽处理
– 盲孔



FLUTELESS MACHINE TAPS
挤压丝锥

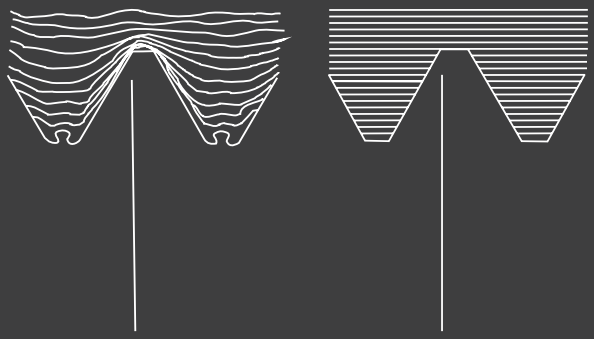


Application:

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

应用:

– 非合金钢和低合金钢
– 结构钢
– 耐热钢
– 不锈钢
– 有色金属，长屑
– 锌合金
– 通孔和盲孔



Fibre structure
of thread forming
挤压丝锥攻丝后的组
织结构

Fibre structure
of thread cutting
切削丝锥攻丝后的组织
结构

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

优点:

✓ 比切削丝锥更耐用
✓ 更高的切削速度
✓ 尺寸和轮廓稳定精确
✓ 挤压而成的螺纹具有高稳定性
✓ 不易折断
✓ 不用排屑, 没有切屑干扰

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.

挤压丝锥是使用挤压形成内螺纹，不需要切削。
螺纹由形变产生，不会破坏材料的组织结构。

FLUTELESS MACHINE TAPS
挤压丝锥

	blank 白身	VAP	TIN
6HX ISO2X	50	168	169
6GX ISO3X	170		
UNC / UNF	51		

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

应用：

白身：
– 用于有良好延展性的有色金属

VAP(蒸汽处理)：
– 用于抗拉强度小于700N/mm²的钢材

TIN(氮化钛涂层)：
– 用于抗拉强度小于900N/mm²的钢材
提高耐磨度和切削速度

R-S Fluteless Machine Taps (Forming Taps)

metric ISO-thread DIN 13

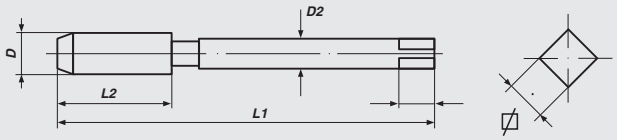
挤压丝锥

公制ISO螺纹 DIN 13

JIS B - 4430 2.1/2 Thread Start HSS-E Tolerance ISO2X/6H

M

Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.
without Oil Groove / 无油槽					
M 2 x 0.4	40	8	3.0	2.5	90814
M 2.3 x 0.4	42	9.5	3.0	2.5	90816
M 2.5 x 0.45	44	9.5	3.0	2.5	90818
M 2.6 x 0.45	44	9.5	3.0	2.5	90820
M 3 x 0.5	46	11	4.0	3.2	90822
M 4 x 0.7	52	13	5.0	4.0	90826
M 5 x 0.8	60	16	5.5	4.5	90830
M 6 x 1.0	62	19	6.0	4.5	90838
M 8 x 1.25	70	13	6.2	5.0	90846
M 10 x 1.5	75	15	7.0	5.5	90854
with Oil Groove / 带油槽					
M 2 x 0.4	40	8	3.0	2.5	90914
M 2.3 x 0.4	42	9.5	3.0	2.5	90916
M 2.5 x 0.45	44	9.5	3.0	2.5	90918
M 2.6 x 0.45	44	9.5	3.0	2.5	90920
M 3 x 0.5	46	11	4.0	3.2	90922
M 4 x 0.7	52	13	5.0	4.0	90926
M 5 x 0.8	60	16	5.5	4.5	90930
M 6 x 1.0	62	19	6.0	4.5	90938
M 8 x 1.25	70	13	6.2	5.0	90946
M 10 x 1.5	75	15	7.0	5.5	90954



R-S Fluteless Machine Taps (Forming Taps)

Unified thread ANSI B 1.1

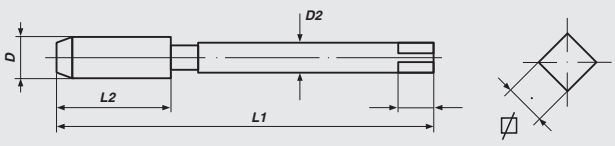
挤压丝锥

统一制螺纹 ANSI B 1.1

JIS B 4430 HSS-G Tolerance 2BX

UNC / UNF

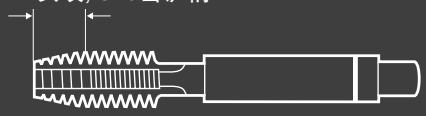
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.
without Oil Groove / 无油槽					
UNC Nr. 4x40	45	10	3.0	2.5	93804
UNC Nr. 6x32	49	14	4.0	3.2	93806
UNC Nr. 8x32	53	14	5.0	4.0	93808
UNC Nr. 10x24	61	17	5.5	4.5	93809
UNF Nr. 10x32	61	17	5.5	4.5	93859
with Oil Groove / 带油槽					
UNC Nr. 4x40	45	10	3.0	2.5	93904
UNC Nr. 6x32	49	14	4.0	3.2	93906
UNC Nr. 8x32	53	14	5.0	4.0	93908
UNC Nr. 10x24	61	17	5.5	4.5	93909
UNF Nr. 10x32	61	17	5.5	4.5	93959



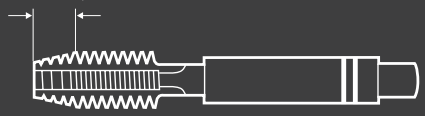
VÖLKEL
THREADING SOLUTIONS

DIN HAND TAPS
德标手用丝锥

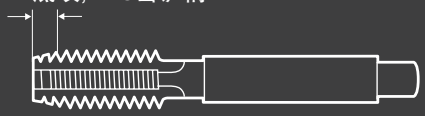
No. 1
Rougher, 6-8 Threads Lead
头攻, 6–8齿铲梢



No. 2
Intermediate, 4-5 Threads Lead
二攻, 4–5齿铲梢

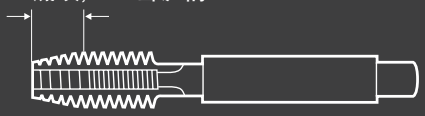


No. 3
Finisher, 2-3 Threads Lead
底攻, 2–3齿铲梢

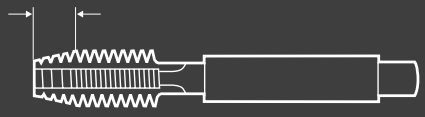


NON-SERIAL FORM
无圈

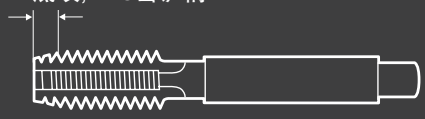
No. 1 - Form A
Finisher, 6-8 Threads Lead
底攻, 6–8齿铲梢



No. 2 - Form D
Finisher, 4-5 Threads Lead
底攻, 4–5齿铲梢



No. 3 - Form C
Finisher, 2-3 Threads Lead
底攻, 2–3齿铲梢



DIN HAND TAPS
德标手用丝锥

	HSS-G	HSS-E	HSS-G Left Hand/左旋
M	54 - 56	70 - 71	74
Mf	57 - 62	72	75
BSW	63		76
BSF	64		
BA			
UNC	65		77
UNF	66		77
UNEF			
G (BSP)	67	73	78
PG	68		
Tr	69		

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

HSS–G应用:
– 通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔和盲孔
– 手用

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

HSS–E应用:
– 高切削性能
– 研磨材料
– 抗拉强度小于1200N/mm²钢材
– 通用

VÖLKEL THREADING SOLUTIONS

Hand Taps
metric ISO-thread DIN 13

手用丝锥
公制ISO螺纹 DIN 13

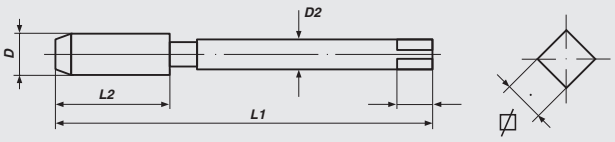
DIN 352 HSS-G Tol. ISO2/6H

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
M 1.1 x 0.25	32	5.5	2.5	2.1	27304
M 1.2 x 0.25	32	5.5	2.5	2.1	27306
M 1.4 x 0.3	32	7.0	2.5	2.1	27308
M 1.6 x 0.35	32	8.0	2.5	2.1	27310
M 1.7 x 0.35	32	8.0	2.5	2.1	27312
M 1.8 x 0.35	32	8.0	2.5	2.1	27314
M 2 x 0.4	36	8.0	2.8	2.1	27316
M 2.2 x 0.45	36	9.0	2.8	2.1	27318
M 2.3 x 0.4	36	9.0	2.8	2.1	27320
M 2.5 x 0.45	40	9.0	2.8	2.1	27322
M 2.6 x 0.45	40	9.0	2.8	2.1	27324
M 3 x 0.5	40	11.0	3.5	2.7	27326
M 3.5 x 0.6	45	13.0	4.0	3.0	27328
M 4 x 0.7	45	13.0	4.5	3.4	27330
M 4.5 x 0.75	50	16.0	6.0	4.9	27332
M 5 x 0.8	50	16.0	6.0	4.9	27334
M 5.5 x 0.9	50	18.0	6.0	4.9	27336
M 6 x 1.0	50	19.0	6.0	4.9	27338
M 7 x 1.0	50	19.0	6.0	4.9	27340
M 8 x 1.25	56	22.0	6.0	4.9	27342
M 9 x 1.25	63	22.0	7.0	5.5	27344
M 10 x 1.5	70	24.0	7.0	5.5	27346
M 11 x 1.5	70	24.0	8.0	6.2	27348
M 12 x 1.75	75	29.0	9.0	7.0	27350
M 14 x 2.0	80	30.0	11.0	9.0	27354
M 15 x 2.0	80	32.0	12.0	9.0	27356
M 16 x 2.0	80	32.0	12.0	9.0	27358
M 18 x 2.5	95	40.0	14.0	11.0	27362
M 20 x 2.5	95	40.0	16.0	12.0	27366
M 22 x 2.5	100	40.0	18.0	14.5	27370
M 24 x 3.0	110	50.0	18.0	14.5	27374
M 27 x 3.0	110	50.0	20.0	16.0	27376
M 30 x 3.5	125	56.0	22.0	18.0	27378
M 33 x 3.5	125	56.0	25.0	20.0	27380
M 36 x 4.0	150	63.0	28.0	22.0	27382
M 39 x 4.0	150	63.0	32.0	24.0	27384
M 42 x 4.5	150	63.0	32.0	24.0	27386
M 45 x 4.5	160	70.0	36.0	29.0	27388
M 48 x 5.0	180	75.0	36.0	29.0	27390
M 52 x 5.0	180	75.0	40.0	32.0	27392
M 56 x 5.5	200	85.0	45.0	35.0	27394
M 60 x 5.5	200	85.0	45.0	35.0	27396
M 64 x 6.0	220	90.0	50.0	39.0	27398
M 68 x 6.0	220	90.0	50.0	39.0	27399

How to order / 如何订货:

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



Hand Taps
metric ISO-thread DIN 13

手用丝锥
公制ISO螺纹 DIN 13

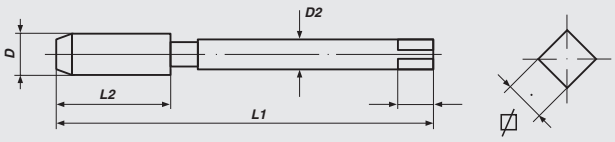
DIN 352 HSS-G Tol. ISO2/6H

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
M 76 x 6.0	240	80.0	50.0	39.0	28131
M 80 x 6.0	260	85.0	50.0	39.0	28132
M 84 x 6.0	260	85.0	50.0	39.0	28133
M 88 x 6.0	260	85.0	50.0	39.0	28134
M 90 x 6.0	260	85.0	50.0	39.0	28135
M 92 x 6.0	280	90.0	56.0	44.0	28136
M 96 x 6.0	280	90.0	56.0	44.0	28137
M 100 x 6.0	280	90.0	56.0	44.0	28138

How to order/如何订货:

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



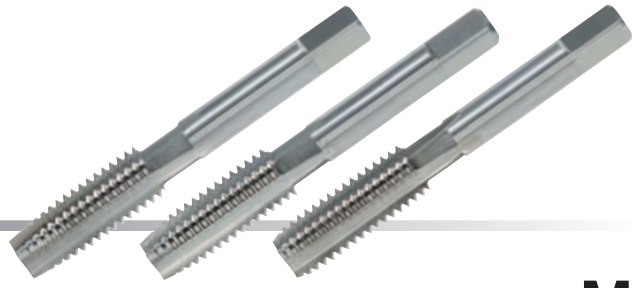
VÖLKEL
THREADING SOLUTIONS

Hand Taps, *non-serial form*

metric ISO-thread DIN 13

手用丝锥, 无圈

公制ISO螺纹 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
M	2.5 x 0.45	40	9	2.8	2.1	27622
M	3 x 0.5	40	11	3.5	2.7	27626
M	4 x 0.7	45	13	4.5	3.4	27630
M	5 x 0.8	50	16	6.0	4.9	27634
M	6 x 1.0	50	19	6.0	4.9	27638
M	8 x 1.25	56	22	6.0	4.9	27642
M	9 x 1.25	63	22	7.0	5.5	27644
M	10 x 1.5	70	24	7.0	5.5	27646
M	11 x 1.5	70	24	8.0	6.2	27648
M	12 x 1.75	75	29	9.0	7.0	27650
M	13 x 1.75	75	29	9.0	7.0	27652
M	14 x 2.0	80	30	11.0	9.0	27654
M	16 x 2.0	80	32	12.0	9.0	27658
M	18 x 2.5	95	40	14.0	11.0	27662
M	19 x 2.5	95	40	14.0	11.0	27664
M	20 x 2.5	95	40	16.0	12.0	27666
M	22 x 2.5	100	40	18.0	14.5	27670
M	24 x 3.0	110	50	18.0	14.5	27674
M	27 x 3.0	110	50	20.0	16.0	27676
M	30 x 3.5	125	56	22.0	18.0	27678
M	33 x 3.5	125	56	25.0	20.0	27680
M	36 x 4.0	150	63	28.0	22.0	27682
M	39 x 4.0	150	63	32.0	24.0	27684
M	42 x 4.5	150	63	32.0	24.0	27686
M	3 x 0.6	40	11	3.5	2.7	27627
M	4 x 0.75	45	13	4.5	3.4	27631
M	5 x 0.9	50	16	6.0	4.9	27635

Application:

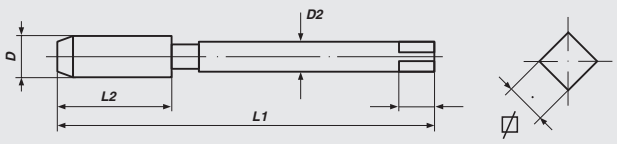
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔和盲孔
– 手用

How to order/如何订货:

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



Hand Taps
metric-fine ISO-thread DIN 13

手用丝锥
公制细牙ISO螺纹 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
M 2.6 x 0.35	40	9	2.8	2.1	26305
M 3 x 0.35	40	9	3.5	2.7	26308
M 3.5 x 0.35	45	10	4.0	3.0	26309
M 4 x 0.35	45	10	4.5	3.4	26310
M 4 x 0.5	45	10	4.5	3.4	26312
M 4.5 x 0.5	50	12	6.0	4.9	26313
M 5 x 0.5	50	12	6.0	4.9	26314
M 5 x 0.75	50	12	6.0	4.9	26316
M 5.5 x 0.5	50	12	6.0	4.9	26315
M 6 x 0.5	50	14	6.0	4.9	26317
M 6 x 0.75	50	14	6.0	4.9	26318
M 7 x 0.5	50	14	6.0	4.9	26319
M 7 x 0.75	50	14	6.0	4.9	26320
M 8 x 0.5	50	19	6.0	4.9	26322
M 8 x 0.75	50	19	6.0	4.9	26324
M 8 x 1.0	56	22	6.0	4.9	26326
M 9 x 0.5	56	19	7.0	5.5	26327
M 9 x 0.75	56	19	7.0	5.5	26328
M 9 x 1.0	63	20	7.0	5.5	26330
M 10 x 0.5	63	20	7.0	5.5	26331
M 10 x 0.75	63	20	7.0	5.5	26332
M 10 x 1.0	63	20	7.0	5.5	26336
M 10 x 1.25	70	24	7.0	5.5	26338
M 11 x 0.75	63	20	8.0	6.2	26339
M 11 x 1.0	63	20	8.0	6.2	26340
M 11 x 1.25	63	22	8.0	6.2	26342
M 12 x 0.5	70	22	9.0	7.0	26345
M 12 x 0.75	70	22	9.0	7.0	26343
M 12 x 1.0	70	22	9.0	7.0	26344
M 12 x 1.25	70	22	9.0	7.0	26346
M 12 x 1.5	70	22	9.0	7.0	26348
M 13 x 0.5	70	22	11.0	9.0	26347
M 13 x 0.75	70	22	11.0	9.0	26349
M 13 x 1.0	70	22	11.0	9.0	26350
M 13 x 1.5	70	22	11.0	9.0	26351
M 14 x 0.5	70	22	11.0	9.0	26355

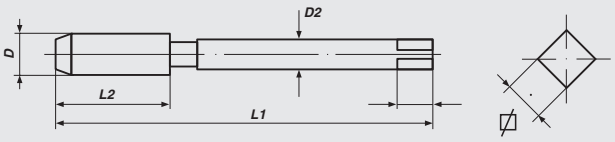
Application:

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

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔和盲孔
– 手用

How to order / 如何订货:
M3x0,35 = 26308
M3x0,35, No. 1 = 26308-1
M3x0,35, No. 2 = 26308-2



VÖLKEL THREADING SOLUTIONS

Hand Taps
metric-fine ISO-thread DIN 13

手用丝锥
公制细牙ISO螺纹 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
M 14 x 1.0	70	22	11.0	9.0	26353
M 14 x 1.25	70	22	11.0	9.0	26354
M 14 x 1.5	70	22	11.0	9.0	26356
M 15 x 0.75	70	22	12.0	9.0	26357
M 15 x 1.0	70	22	12.0	9.0	26358
M 15 x 1.5	70	22	12.0	9.0	26360
M 16 x 0.5	70	22	12.0	9.0	26361
M 16 x 0.75	70	22	12.0	9.0	26363
M 16 x 1.0	70	22	12.0	9.0	26362
M 16 x 1.25	70	22	12.0	9.0	26364
M 16 x 1.5	70	22	12.0	9.0	26366
M 17 x 1.0	70	22	12.0	9.0	26368
M 17 x 1.5	70	22	12.0	9.0	26369
M 18 x 0.5	80	22	14.0	11.0	26367
M 18 x 0.75	80	22	14.0	11.0	26373
M 18 x 1.0	80	22	14.0	11.0	26370
M 18 x 1.25	80	22	14.0	11.0	26371
M 18 x 1.5	80	22	14.0	11.0	26372
M 18 x 2.0	80	22	14.0	11.0	26374
M 19 x 1.0	80	22	14.0	11.0	26375
M 19 x 1.5	80	22	14.0	11.0	26376
M 20 x 0.5	80	22	16.0	12.0	26377
M 20 x 0.75	80	22	16.0	12.0	26379
M 20 x 1.0	80	22	16.0	12.0	26378
M 20 x 1.25	80	22	16.0	12.0	26380
M 20 x 1.5	80	22	16.0	12.0	26384
M 20 x 2.0	80	22	16.0	12.0	26386
M 21 x 1.0	80	22	16.0	12.0	26387
M 21 x 1.5	80	22	16.0	12.0	26388
M 22 x 0.5	80	22	18.0	14.5	26389
M 22 x 0.75	80	22	18.0	14.5	26391
M 22 x 1.0	80	22	18.0	14.5	26390
M 22 x 1.25	80	22	18.0	14.5	26392
M 22 x 1.5	80	22	18.0	14.5	26394
M 22 x 2.0	80	22	18.0	14.5	26396
M 23 x 1.0	80	22	18.0	14.5	26397
M 23 x 1.5	80	22	18.0	14.5	26398
M 24 x 0.5	90	22	18.0	14.5	26501
M 24 x 0.75	90	22	18.0	14.5	26503
M 24 x 1.0	90	22	18.0	14.5	26500
M 24 x 1.25	90	22	18.0	14.5	26502
M 24 x 1.5	90	22	18.0	14.5	26504
M 24 x 2.0	90	22	18.0	14.5	26506
M 25 x 1.0	90	22	18.0	14.5	26507
M 25 x 1.5	90	22	18.0	14.5	26508
M 26 x 1.0	90	22	18.0	14.5	26510
M 26 x 1.5	90	22	18.0	14.5	26512
M 26 x 2.0	90	22	18.0	14.5	26514
M 27 x 1.0	90	22	20.0	16.0	26516

Hand Taps
metric-fine ISO-thread DIN 13

手用丝锥
公制细牙ISO螺纹 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
M 27 x 2.0	90	22	20.0	16.0	26518
M 28 x 1.0	90	22	20.0	16.0	26520
M 28 x 1.5	90	22	20.0	16.0	26522
M 28 x 2.0	90	22	20.0	16.0	26524
M 29 x 1.5	90	22	22.0	18.0	26526
M 30 x 1.0	90	22	22.0	18.0	26528
M 30 x 1.5	90	22	22.0	18.0	26530
M 30 x 2.0	90	22	22.0	18.0	26532
M 30 x 2.5	125	56	22.0	18.0	26533
M 30 x 3.0	125	56	22.0	18.0	26534
M 32 x 1.0	90	22	22.0	18.0	26539
M 32 x 1.5	90	22	22.0	18.0	26536
M 32 x 2.0	90	22	22.0	18.0	26535
M 32 x 3.0	125	56	22.0	18.0	26537
M 33 x 1.5	100	25	25.0	20.0	26538
M 33 x 2.0	100	25	25.0	20.0	26540
M 33 x 3.0	125	56	25.0	20.0	26542
M 34 x 1.0	100	25	28.0	22.0	26543
M 34 x 1.5	100	25	28.0	22.0	26544
M 34 x 2.0	125	40	28.0	22.0	26546
M 35 x 1.0	100	25	28.0	22.0	26547
M 35 x 1.5	100	25	28.0	22.0	26548
M 35 x 2.0	125	40	28.0	22.0	26549
M 36 x 1.0	100	25	28.0	22.0	26551
M 36 x 1.5	100	25	28.0	22.0	26550
M 36 x 2.0	125	40	28.0	22.0	26552
M 36 x 3.0	125	40	28.0	22.0	26554
M 37 x 1.5	100	25	28.0	22.0	26553
M 38 x 1.0	100	25	28.0	22.0	26555
M 38 x 1.5	100	25	28.0	22.0	26556
M 38 x 2.0	125	40	28.0	22.0	26557
M 38 x 3.0	125	40	28.0	22.0	26559
M 39 x 1.5	110	25	32.0	24.0	26558
M 39 x 2.0	125	40	32.0	24.0	26560
M 39 x 3.0	125	40	32.0	24.0	26562
M 40 x 1.0	110	25	32.0	24.0	26563
M 40 x 1.5	110	25	32.0	24.0	26564
M 40 x 2.0	125	40	32.0	24.0	26566
M 40 x 3.0	125	40	32.0	24.0	26568
M 42 x 1.0	110	25	32.0	24.0	26569
M 42 x 1.5	110	25	32.0	24.0	26570
M 42 x 2.0	125	40	32.0	24.0	26572
M 42 x 3.0	125	40	32.0	24.0	26574
M 44 x 1.5	110	25	36.0	29.0	26571
M 44 x 2.0	125	40	36.0	29.0	26573
M 45 x 1.0	110	25	36.0	29.0	26575
M 45 x 1.5	110	25	36.0	29.0	26576
M 45 x 2.0	125	40	36.0	29.0	26578
M 45 x 3.0	125	40	36.0	29.0	26580

VÖLKEL THREADING SOLUTIONS

Hand Taps
metric-fine ISO-thread DIN 13

手用丝锥
公制细牙ISO螺纹 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
M 48 x 1.0	140	40	36	29.0	26583
M 48 x 1.5	140	40	36	29.0	26582
M 48 x 2.0	140	40	36	29.0	26584
M 48 x 3.0	140	40	36	29.0	26586
M 50 x 1.5	140	40	36	29.0	26588
M 50 x 2.0	140	40	36	29.0	26590
M 50 x 3.0	140	40	36	29.0	26592
M 52 x 1.5	140	40	40	32.0	26594
M 52 x 2.0	140	40	40	32.0	26596
M 52 x 3.0	140	40	40	32.0	26598
M 54 x 1.0	140	32	40	32.0	28118
M 54 x 1.5	140	32	40	32.0	28001
M 54 x 2.0	140	36	40	32.0	28002
M 54 x 3.0	140	40	40	32.0	28003
M 54 x 4.0	180	50	40	32.0	28004
M 55 x 1.5	140	32	40	32.0	28005
M 55 x 2.0	140	36	40	32.0	28006
M 55 x 3.0	140	40	40	32.0	28007
M 55 x 4.0	180	50	40	32.0	28008
M 56 x 1.0	140	32	40	32.0	28119
M 56 x 1.5	140	32	40	32.0	28009
M 56 x 2.0	140	36	40	32.0	28010
M 56 x 3.0	140	40	40	32.0	28011
M 56 x 4.0	180	50	40	32.0	28012
M 58 x 1.0	160	32	45	35.0	28120
M 58 x 1.5	160	32	45	35.0	28013
M 58 x 2.0	160	36	45	35.0	28014
M 58 x 3.0	160	40	45	35.0	28015
M 58 x 4.0	200	55	45	35.0	28016
M 60 x 1.5	160	34	45	35.0	28017
M 60 x 2.0	160	36	45	35.0	28018
M 60 x 3.0	160	40	45	35.0	28019
M 60 x 4.0	200	55	45	35.0	28020
M 62 x 1.5	160	34	50	39.0	28021
M 62 x 2.0	160	36	50	39.0	28022
M 62 x 3.0	180	45	50	39.0	28023
M 62 x 4.0	220	55	50	39.0	28024
M 63 x 1.5	160	32	50	39.0	28025
M 64 x 1.5	160	34	50	39.0	28026
M 64 x 2.0	160	36	50	39.0	28027
M 64 x 3.0	180	45	50	39.0	28028
M 64 x 4.0	220	60	50	39.0	28029
M 65 x 1.5	160	34	50	39.0	28030
M 65 x 2.0	160	36	50	39.0	28031
M 65 x 3.0	180	45	50	39.0	28032
M 65 x 4.0	220	60	50	39.0	28033
M 68 x 1.5	160	36	50	39.0	28034
M 68 x 2.0	160	40	50	39.0	28035
M 68 x 3.0	180	50	50	39.0	28036

Hand Taps
metric-fine ISO-thread DIN 13

手用丝锥
公制细牙ISO螺纹 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
M 70 x 1.5	160	36	50	39.0	28038
M 70 x 2.0	160	40	50	39.0	28039
M 70 x 3.0	200	50	50	39.0	28040
M 70 x 4.0	240	60	50	39.0	28041
M 72 x 1.5	160	36	50	39.0	28042
M 72 x 2.0	160	40	50	39.0	28043
M 72 x 3.0	200	50	50	39.0	28044
M 72 x 4.0	240	60	50	39.0	28045
M 74 x 1.5	160	36	50	39.0	28046
M 74 x 2.0	160	40	50	39.0	28047
M 74 x 3.0	200	50	50	39.0	28048
M 74 x 4.0	240	60	50	39.0	28049
M 75 x 1.5	160	36	50	39.0	28050
M 75 x 2.0	160	40	50	39.0	28051
M 75 x 3.0	200	50	50	39.0	28052
M 75 x 4.0	240	60	50	39.0	28053
M 76 x 1.5	160	36	50	39.0	28054
M 76 x 2.0	160	40	50	39.0	28055
M 76 x 3.0	220	50	50	39.0	28056
M 76 x 4.0	260	60	50	39.0	28057
M 78 x 1.5	160	36	50	39.0	28058
M 78 x 2.0	160	40	50	39.0	28059
M 78 x 3.0	220	55	50	39.0	28060
M 78 x 4.0	260	65	50	39.0	28061
M 80 x 1.5	160	36	50	39.0	28062
M 80 x 2.0	160	40	50	39.0	28063
M 80 x 3.0	220	55	50	39.0	28064
M 80 x 4.0	260	65	50	39.0	28065
M 82 x 1.5	160	36	50	39.0	28066
M 82 x 2.0	160	40	50	39.0	28067
M 82 x 3.0	220	55	50	39.0	28068
M 82 x 4.0	260	65	50	39.0	28069
M 84 x 1.5	160	36	50	39.0	28070
M 84 x 2.0	160	40	50	39.0	28071
M 84 x 3.0	220	55	50	39.0	28072
M 84 x 4.0	260	65	50	39.0	28073
M 85 x 1.5	160	36	50	39.0	28074
M 85 x 2.0	160	40	50	39.0	28075
M 85 x 3.0	220	55	50	39.0	28076
M 85 x 4.0	260	65	50	39.0	28077
M 86 x 1.5	160	36	50	39.0	28078
M 86 x 2.0	160	40	50	39.0	28079
M 86 x 3.0	220	55	50	39.0	28080
M 86 x 4.0	260	65	50	39.0	28081
M 88 x 1.5	160	38	50	39.0	28082
M 88 x 2.0	160	40	50	39.0	28083
M 88 x 3.0	220	55	50	39.0	28084
M 88 x 4.0	260	65	50	39.0	28085
M 90 x 1.5	160	38	50	39.0	28086

VÖLKEL THREADING SOLUTIONS

Hand Taps
metric-fine ISO-thread DIN 13

手用丝锥
公制细牙ISO螺纹 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
M 90 x 3.0	220	55	50	39.0	28088
M 90 x 4.0	260	65	50	39.0	28089
M 92 x 1.5	180	40	56	44.0	28090
M 92 x 2.0	180	45	56	44.0	28091
M 92 x 3.0	240	60	56	44.0	28092
M 92 x 4.0	280	70	56	44.0	28093
M 95 x 1.5	180	40	56	44.0	28094
M 95 x 2.0	180	45	56	44.0	28095
M 95 x 3.0	240	60	56	44.0	28096
M 95 x 4.0	280	70	56	44.0	28097
M 96 x 1.5	180	40	56	44.0	28098
M 96 x 2.0	180	45	56	44.0	28099
M 96 x 3.0	240	60	56	44.0	28100
M 96 x 4.0	280	70	56	44.0	28101
M 98 x 1.5	180	40	56	44.0	28102
M 98 x 2.0	180	45	56	44.0	28103
M 98 x 3.0	240	60	56	44.0	28104
M 98 x 4.0	280	70	56	44.0	28105
M 100 x 1.5	180	45	56	44.0	28106
M 100 x 2.0	180	50	56	44.0	28107
M 100 x 3.0	240	65	56	44.0	28108
M 100 x 4.0	280	75	56	44.0	28109
M 105 x 1.5	180	45	56	44.0	28110
M 105 x 2.0	180	50	56	44.0	28111
M 105 x 3.0	240	65	56	44.0	28112
M 105 x 4.0	280	75	56	44.0	28113
M 110 x 1.5	180	45	56	44.0	28114
M 110 x 2.0	180	50	56	44.0	28115
M 110 x 3.0	240	65	56	44.0	28116
M 110 x 4.0	280	75	56	44.0	28117

Hand Taps
Whitworth-thread BS 84

手用丝锥
惠氏螺纹 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
BSW 3/32 x 48	36	10	2.8	2.1	22304
BSW 1/8 x 40	40	12	3.5	2.7	22306
BSW 5/32 x 32	45	14	4.5	3.4	22308
BSW 3/16 x 24	50	18	6.0	4.9	22310
BSW 7/32 x 24	50	18	6.0	4.9	22312
BSW 1/4 x 20	50	19	6.0	4.9	22314
BSW 5/16 x 18	56	22	6.0	4.9	22316
BSW 3/8 x 16	70	24	7.0	5.5	22318
BSW 7/16 x 14	70	24	8.0	6.2	22320
BSW 1/2 x 12	75	29	9.0	7.0	22322
BSW 9/16 x 12	80	30	11.0	9.0	22324
BSW 5/8 x 11	80	32	12.0	9.0	22326
BSW 3/4 x 10	95	40	14.0	11.0	22330
BSW 7/8 x 9	100	40	18.0	14.5	22334
BSW 1" x 8	110	50	18.0	14.5	22338
BSW 1.1/8 x 7	132	56	22.0	18.0	22342
BSW 1.1/4 x 7	132	56	22.0	18.0	22346
BSW 1.3/8 x 6	150	63	28.0	22.0	22350
BSW 1.1/2 x 6	150	63	32.0	24.0	22354
BSW 1.5/8 x 5	160	70	32.0	24.0	22358
BSW 1.3/4 x 5	160	70	36.0	29.0	22362
BSW 1.7/8 x 4.1/2	190	80	36.0	29.0	22366
BSW 2" x 4.1/2	190	80	40.0	32.0	22370
BSW 2.1/4 x 4	220	80	45.0	35.0	22372
BSW 2.1/2 x 4	220	80	50.0	39.0	22374
BSW 2.3/4 x 3.1/2	240	80	50.0	39.0	22376
BSW 3" x 3.1/2	260	80	50.0	39.0	22378

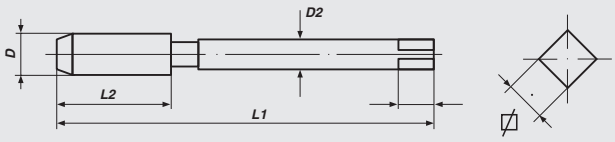
Application:

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

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔和盲孔
– 手用

How to order / 如何订货:
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



VÖLKEL
THREADING SOLUTIONS

Hand Taps
British-Standard-Fine-thread BS 84

手用丝锥
英标细牙螺纹 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
BSF 1/4 x 26	50	18	6.0	4.9	22714
BSF 5/16 x 22	56	22	6.0	4.9	22716
BSF 3/8 x 20	63	22	7.0	5.5	22718
BSF 7/16 x 18	63	22	8.0	6.2	22720
BSF 1/2 x 16	75	24	9.0	7.0	22722
BSF 9/16 x 16	80	28	11.0	9.0	22724
BSF 5/8 x 14	80	28	12.0	9.0	22726
BSF 3/4 x 12	95	32	14.0	11.0	22730
BSF 7/8 x 11	100	36	18.0	14.5	22734
BSF 1" x 10	110	40	18.0	14.5	22738

Application:

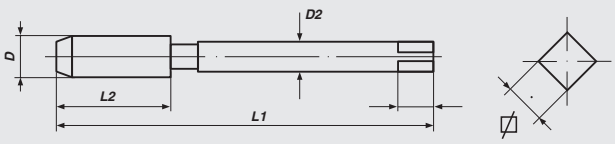
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔和盲孔
– 手用

How to order/如何订货:

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



Hand Taps
Unified Coarse thread ANSI B 1.1

手用丝锥
统一制粗牙螺纹 ANSI B 1.1

≈ 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
UNC Nr. 2 x 56	36	11	2.8	2.1	23302
UNC Nr. 3 x 48	36	11	2.8	2.1	23303
UNC Nr. 4 x 40	40	12	3.5	2.7	23304
UNC Nr. 5 x 40	40	12	3.5	2.7	23305
UNC Nr. 6 x 32	45	14	4.0	3.0	23306
UNC Nr. 8 x 32	45	14	4.5	3.4	23308
UNC Nr. 10 x 24	50	16	6.0	4.9	23310
UNC Nr. 12 x 24	50	18	6.0	4.9	23312
UNC 1/4 x 20	50	19	6.0	4.9	23314
UNC 5/16 x 18	56	22	6.0	4.9	23316
UNC 3/8 x 16	70	24	7.0	5.5	23318
UNC 7/16 x 14	70	24	8.0	6.2	23320
UNC 1/2 x 13	75	29	9.0	7.0	23322
UNC 9/16 x 12	80	30	11.0	9.0	23324
UNC 5/8 x 11	80	32	12.0	9.0	23326
UNC 3/4 x 10	95	40	14.0	11.0	23330
UNC 7/8 x 9	100	40	18.0	14.5	23334
UNC 1" x 8	110	50	18.0	14.5	23338
UNC 1.1/8 x 7	132	56	22.0	18.0	23342
UNC 1.1/4 x 7	132	56	22.0	18.0	23346
UNC 1.3/8 x 6	150	63	28.0	22.0	23350
UNC 1.1/2 x 6	150	63	32.0	24.0	23354
UNC 1.5/8 x 5	160	70	32.0	24.0	23358
UNC 1.3/4 x 5	160	70	36.0	29.0	23362
UNC 1.7/8 x 4.1/2	190	80	36.0	29.0	23366
UNC 2" x 4.1/2	190	80	40.0	32.0	23370
UNC 2.1/4 x 4.1/2	220	80	45.0	35.0	23372
UNC 2.1/2 x 4	220	80	50.0	39.0	23374
UNC 2.3/4 x 4	240	80	50.0	39.0	23376
UNC 3" x 4	260	80	50.0	39.0	23378

Application:

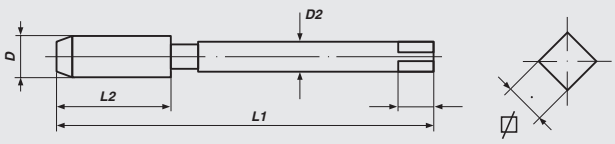
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

应用:

通用
– 抗拉强度小于900/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔和盲孔
– 手用

How to order / 如何订货:

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

手用丝锥
统一制细牙螺纹 ANSI B 1.1

≈ 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
UNF Nr. 1 x 72	32	9	2.8	2.1	24301
UNF Nr. 2 x 64	32	10	2.8	2.1	24302
UNF Nr. 3 x 56	32	10	2.8	2.1	24303
UNF Nr. 4 x 48	36	11	3.5	2.7	24304
UNF Nr. 5 x 44	36	11	3.5	2.7	24305
UNF Nr. 6 x 40	40	12	4.5	3.4	24306
UNF Nr. 8 x 36	40	12	4.5	3.4	24308
UNF Nr. 10 x 32	45	14	6.0	4.9	24310
UNF Nr. 12 x 28	50	14	6.0	4.9	24312
UNF 1/4 x 28	50	18	6.0	4.9	24314
UNF 5/16 x 24	56	22	6.0	4.9	24316
UNF 3/8 x 24	63	22	7.0	5.5	24318
UNF 7/16 x 20	63	22	8.0	6.2	24320
UNF 1/2 x 20	75	24	9.0	7.0	24322
UNF 9/16 x 18	80	28	11.0	9.0	24324
UNF 5/8 x 18	80	28	12.0	9.0	24326
UNF 3/4 x 16	95	32	14.0	11.0	24330
UNF 7/8 x 14	100	36	18.0	14.5	24334
UNF 1" x 12	110	40	18.0	14.5	24338
UNF 1" x 14	110	40	18.0	14.5	24340
UNF 1.1/8 x 12	110	50	22.0	18.0	24342
UNF 1.1/4 x 12	132	56	22.0	18.0	24346
UNF 1.3/8 x 12	132	56	28.0	22.0	24350
UNF 1.1/2 x 12	150	63	32.0	24.0	24354

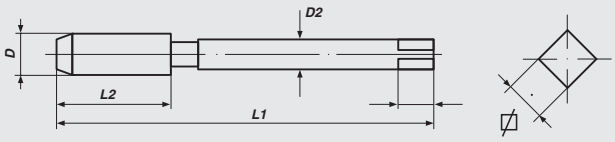
Application:

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

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔和盲孔
– 手用

How to order/如何订货:
UNF 1/4 = 24314
UNF 1/4, No. 1 = 24314-1
UNF 1/4, No. 3 = 24314-3



Hand Taps
Pipe-thread DIN ISO 228

手用丝锥
管螺纹 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
G	1/4 x 19	70	22	11	9.0	25314
G	3/8 x 19	70	22	12	9.0	25316
G	1/2 x 14	80	22	16	12.0	25318
G	5/8 x 14	80	22	18	14.5	25320
G	3/4 x 14	90	22	20	16.0	25322
G	7/8 x 14	90	22	22	18.0	25324
G	1" x 11	100	25	25	20.0	25326
G	1.1/8 x 11	125	40	28	22.0	25330
G	1.1/4 x 11	125	40	32	24.0	25334
G	1.3/8 x 11	140	40	36	29.0	25338
G	1.1/2 x 11	140	40	36	29.0	25342
G	1.5/8 x 11	140	40	40	32.0	25346
G	1.3/4 x 11	140	40	40	32.0	25350
G	2" x 11	160	40	45	35.0	25354
G	2.1/4 x 11	160	40	50	39.0	25358
G	2.1/2 x 11	160	40	50	39.0	25362
G	2.3/4 x 11	160	40	50	39.0	25366
G	3" x 11	160	40	50	39.0	25370
G	3.1/2 x 11	180	45	56	44.0	25374
G	4" x 11	180	45	56	44.0	25378

Application:

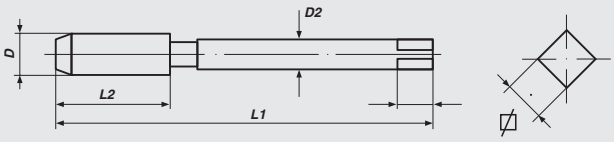
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔和盲孔
– 手用

How to order / 如何订货:

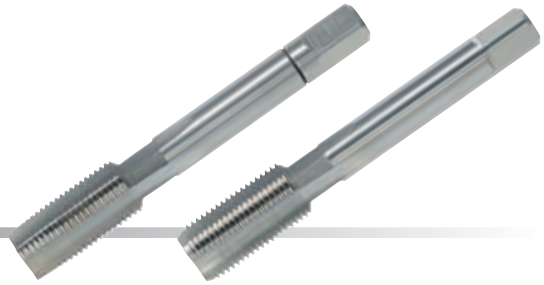
G 1/4	=	25314
G 1/4, No. 1	=	25314-1
G 1/4, No. 2	=	25314-2



VÖLKEL
THREADING SOLUTIONS

Hand Taps
armoured tube thread DIN 40 430

手用丝锥
装甲管螺纹 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
PG	9 x 18	70	22	12.0	9.0	25709
PG	11 x 18	80	22	14.0	11.0	25711
PG	13.5 x 18	80	22	16.0	12.0	25713
PG	16 x 18	80	22	18.0	14.5	25716
PG	21 x 16	90	22	22.0	18.0	25721
PG	29 x 16	100	25	28.0	22.0	25729
PG	36 x 16	140	40	36.0	29.0	25736
PG	42 x 16	140	40	40.0	32.0	25742
PG	48 x 16	160	40	45.0	35.0	25748

Application:

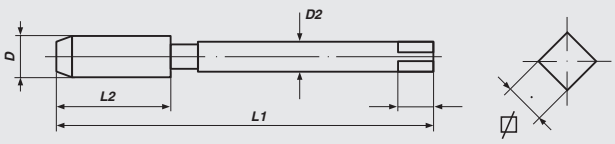
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔和盲孔
– 手用

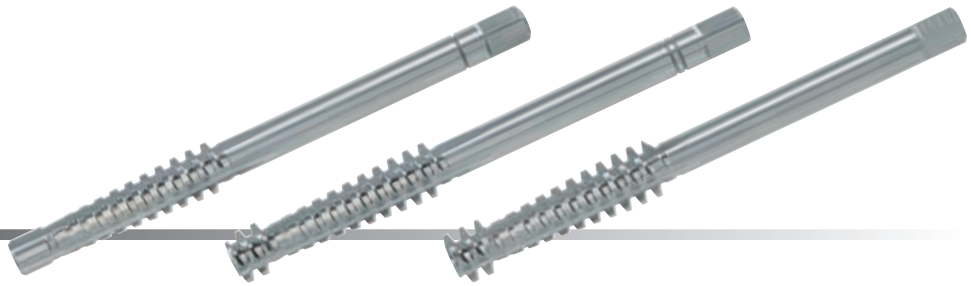
How to order/如何订货:

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



Hand Taps
trapezoidal thread DIN 103

手用丝锥
梯形螺纹 DIN 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
Tr 10 x 3	100	40	7	5.5	25112
Tr 12 x 3	110	40	8	6.2	25116
Tr 14 x 3	130	45	10	8.0	25120
Tr 14 x 4	130	55	10	8.0	25124
Tr 16 x 4	140	55	11	9.0	25128
Tr 18 x 4	150	55	12	9.0	25132
Tr 20 x 4	160	55	14	11.0	25136
Tr 22 x 5	175	65	16	12.0	25140
Tr 24 x 5	190	65	18	14.5	25144
Tr 26 x 5	210	70	20	16.0	25148
Tr 28 x 5	220	70	22	18.0	25152
Tr 30 x 6	240	80	22	18.0	25156
Tr 32 x 6	255	80	25	20.0	25160

Application:

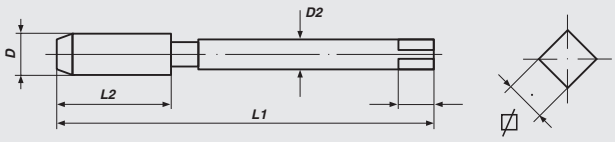
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔和盲孔
– 手用

How to order / 如何订货:

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



VÖLKEL
THREADING SOLUTIONS

Hand Taps
metric ISO-thread DIN 13

手用丝锥
公制ISO螺纹 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
M	4 x 0.7	45	13	4.5	3.4	57330
M	5 x 0.8	50	16	6.0	4.9	57334
M	6 x 1.0	50	19	6.0	4.9	57338
M	8 x 1.25	56	22	6.0	4.9	57342
M	10 x 1.5	70	24	7.0	5.5	57346
M	12 x 1.75	75	29	9.0	7.0	57350
M	14 x 2.0	80	30	11.0	9.0	57354
M	16 x 2.0	80	32	12.0	9.0	57358
M	18 x 2.5	95	40	14.0	11.0	57362
M	20 x 2.5	95	40	16.0	12.0	57366
M	22 x 2.5	100	40	18.0	14.5	57370
M	24 x 3.0	110	50	18.0	14.5	57374
M	27 x 3.0	110	50	20.0	16.0	57376
M	30 x 3.5	125	56	22.0	18.0	57378

Application:

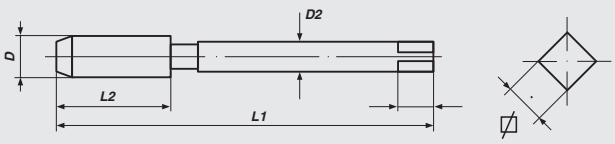
- high cutting ability
- abrasive material
- steels up to 1200 N/mm²
- and general use

应用:

– 高切削性能
– 研磨材料
– 抗拉强度小于1200N/mm²的钢材
– 通用

How to order / 如何订货:

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



Hand Taps
metric ISO-thread DIN 13
Rougher piloted

手用丝锥
公制ISO螺纹 DIN 13
头攻带导向

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
M 4 x 0.7	45	13	4.5	3.4	57730
M 5 x 0.8	50	16	6.0	4.9	57734
M 6 x 1.0	50	19	6.0	4.9	57738
M 8 x 1.25	56	22	6.0	4.9	57742
M 10 x 1.5	70	24	7.0	5.5	57746
M 12 x 1.75	75	29	9.0	7.0	57750

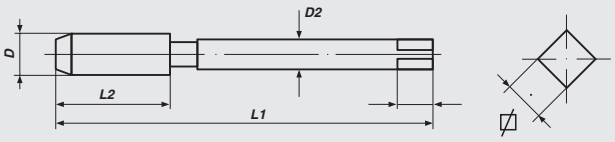
Application:
wear resistant steel up to 1400 N/mm²
- high alloy steel
- heat resistant steel
- stainless steel
- alloy tool steel
- cast iron

Surface treatment: steam tempered

应用:
抗拉强度小于1400N/m㎡的耐磨钢
– 高合金钢
– 耐热钢
– 不锈钢
– 合金工具钢
– 铸铁

表面处理: 蒸汽处理

How to order /如何订货:
M 3 = 57726
M 3, No. 1 = 57726-1
M 3, No. 2 = 57726-2
M 3, No. 3 = 57726-3



VÖLKEL
THREADING SOLUTIONS

Hand Taps
metric-fine ISO-thread DIN 13

手用丝锥
公制细牙ISO螺纹 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
M 8 x 0.75	50	19	6.0	4.9	56324
M 8 x 1.0	56	22	6.0	4.9	56326
M 10 x 1.0	63	20	7.0	5.5	56336
M 10 x 1.25	70	24	7.0	5.5	56338
M 12 x 1.0	70	22	9.0	7.0	56344
M 12 x 1.25	70	22	9.0	7.0	56346
M 12 x 1.5	70	22	9.0	7.0	56348
M 14 x 1.25	70	22	11.0	9.0	56354
M 14 x 1.5	70	22	11.0	9.0	56356
M 16 x 1.5	70	22	12.0	9.0	56366
M 18 x 1.5	80	22	14.0	11.0	56372
M 18 x 2.0	80	22	14.0	11.0	56374
M 20 x 1.5	80	22	16.0	12.0	56384
M 20 x 2.0	80	22	16.0	12.0	56386
M 22 x 1.5	80	22	18.0	14.5	56394
M 22 x 2.0	80	22	18.0	14.5	56396
M 24 x 1.5	90	22	18.0	14.5	56504

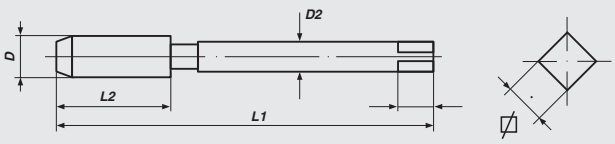
Application:

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

应用:

– 高切削性能
– 研磨材料
– 抗拉强度小于1200N/mm²的钢材
– 通用

How to order / 如何订货:
M 6x0,75 = 56318
M 6x0,75, No. 1 = 56318-1
M 6x0,75, No. 2 = 56318-2



Hand Taps
Pipe-thread DIN ISO 228

手用丝锥
管螺纹 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
G 1/4 x 19	70	22	11.0	9.0	55314
G 3/8 x 19	70	22	12.0	9.0	55316
G 1/2 x 14	80	22	16.0	12.0	55318
G 3/4 x 14	90	22	20.0	16.0	55322
G 1" x 11	100	25	25.0	20.0	55326

Application:

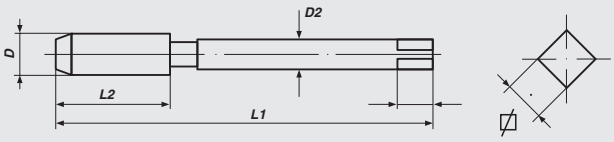
- high cutting ability
- abrasive material
- steels up to 1200 N/mm²
- and general use

应用:

– 高切削性能
– 研磨材料
– 抗拉强度小于1200N/mm²的钢材
– 通用

How to order / 如何订货:

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



VÖLKEL
THREADING SOLUTIONS

Hand Taps, *Left Hand*

metric ISO-thread DIN 13

手用丝锥, 左旋

公制ISO螺纹 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
M 4 x 0.7	45	13	4.5	3.4	27030
M 5 x 0.8	50	16	6.0	4.9	27034
M 6 x 1.0	50	19	6.0	4.9	27038
M 8 x 1.25	56	22	6.0	4.9	27042
M 10 x 1.5	70	24	7.0	5.5	27046
M 12 x 1.75	75	29	9.0	7.0	27050
M 14 x 2.0	80	30	11.0	9.0	27054
M 16 x 2.0	80	32	12.0	9.0	27058
M 18 x 2.5	95	40	14.0	11.0	27062
M 20 x 2.5	95	40	16.0	12.0	27066
M 22 x 2.5	100	40	18.0	14.5	27070
M 24 x 3.0	110	50	18.0	14.5	27074
M 27 x 3.0	110	50	20.0	16.0	27076
M 30 x 3.5	125	56	22.0	18.0	27078
M 33 x 3.5	125	56	25.0	20.0	27080
M 36 x 4.0	150	63	28.0	22.0	27082
M 39 x 4.0	150	63	32.0	24.0	27084
M 42 x 4.5	150	63	32.0	24.0	27086
M 45 x 4.5	160	70	36.0	29.0	27088
M 48 x 5.0	180	75	36.0	29.0	27090
M 52 x 5.0	180	75	40.0	32.0	27092

Application:

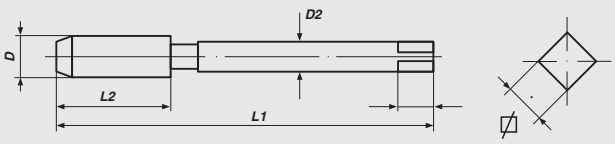
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔和盲孔
– 手用

How to order/ 如何订货:

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



Hand Taps, *Left Hand*

metric-fine ISO-thread DIN 13

手用丝锥, 左旋

公制细牙ISO螺纹 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
M 8 x 0.75	50	19	6.0	4.9	26010
M 8 x 1.0	56	22	6.0	4.9	26011
M 10 x 1.0	63	20	7.0	5.5	26015
M 10 x 1.25	70	24	7.0	5.5	26016
M 12 x 1.0	70	22	9.0	7.0	26020
M 12 x 1.25	70	22	9.0	7.0	26021
M 12 x 1.5	70	22	9.0	7.0	26022
M 14 x 1.25	70	22	11.0	9.0	26027
M 14 x 1.5	70	22	11.0	9.0	26028
M 16 x 1.0	70	22	12.0	9.0	26031
M 16 x 1.5	70	22	12.0	9.0	26033
M 18 x 1.5	80	22	14.0	11.0	26036
M 20 x 1.5	80	22	16.0	12.0	26040
M 22 x 1.5	80	22	18.0	14.5	26045
M 24 x 1.5	90	22	18.0	14.5	26050
M 24 x 2.0	90	22	18.0	14.5	26051
M 30 x 1.5	90	22	22.0	18.0	26063
M 30 x 2.0	90	22	22.0	18.0	26064

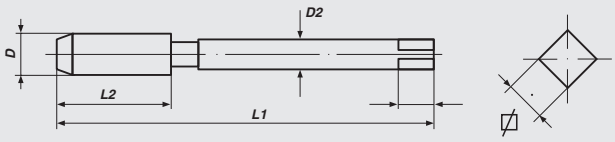
Application:

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

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔和盲孔
– 手用

How to order/ 如何订货:
M 6x0,75 = 26007
M 6x0,75, No. 1 = 26007-1
M 6x0,75, No. 2 = 26007-2



VÖLKEL
THREADING SOLUTIONS

Hand Taps, *Left Hand*

Whitworth-thread BS 84

手用丝锥, 左旋

惠氏螺纹 BS 84

BSW

≈ **DIN 352** **HSS-G**

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

Application:

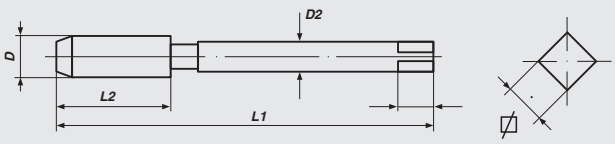
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔和盲孔
– 手用

How to order/ 如何订货:

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



Hand Taps, *Left Hand*

Unified thread ANSI B 1.1

手用丝锥, 左旋

统一制螺纹 ANSI B 1.1

≈ **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
UNC Nr. 8 x 32	45	14	4.5	3.4	23008
UNC Nr. 10 x 24	50	16	6.0	4.9	23010
UNC Nr. 12 x 24	50	18	6.0	4.9	23012
UNC 1/4 x 20	50	19	6.0	4.9	23014
UNC 5/16 x 18	56	22	6.0	4.9	23016
UNC 3/8 x 16	70	24	7.0	5.5	23018
UNC 7/16 x 14	70	24	8.0	6.2	23020
UNC 1/2 x 13	75	29	9.0	7.0	23022
UNC 9/16 x 12	80	30	11.0	9.0	23024
UNC 5/8 x 11	80	32	12.0	9.0	23026
UNC 3/4 x 10	95	40	14.0	11.0	23030
UNC 7/8 x 9	100	40	18.0	14.5	23034
UNC 1" x 8	110	50	18.0	14.5	23038
UNF 2-pcs					
UNF Nr. 10 x 32	45	14	6.0	4.9	24010
UNF 1/4 x 28	50	18	6.0	4.9	24014
UNF 5/16 x 24	56	22	6.0	4.9	24016
UNF 3/8 x 24	63	22	7.0	5.5	24018
UNF 7/16 x 20	63	22	8.0	6.2	24020
UNF 1/2 x 20	75	24	9.0	7.0	24022
UNF 9/16 x 18	80	28	11.0	9.0	24024
UNF 5/8 x 18	80	28	12.0	9.0	24026
UNF 3/4 x 16	95	32	14.0	11.0	24030
UNF 7/8 x 14	100	36	18.0	14.5	24034
UNF 1" x 12	110	40	18.0	14.5	24038

Application:

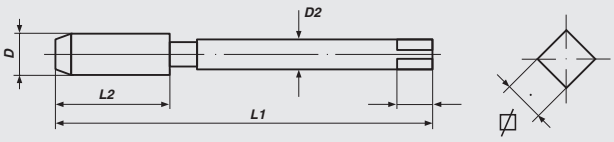
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔和盲孔
– 手用

How to order/ 如何订货:

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



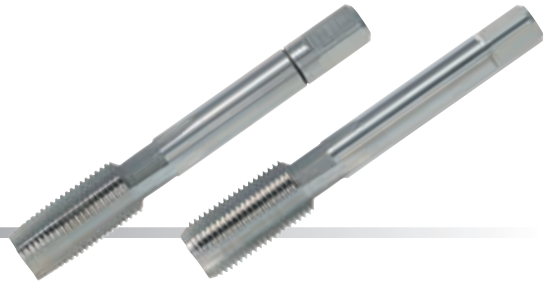
VÖLKEL THREADING SOLUTIONS

Hand Taps, *Left Hand*

Pipe-thread DIN ISO 228

手用丝锥, 左旋

管螺纹 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
G 1/4 x 19	70	22	11.0	9.0	25014
G 3/8 x 19	70	22	12.0	9.0	25016
G 1/2 x 14	80	22	16.0	12.0	25018
G 5/8 x 14	80	22	18.0	14.5	25020
G 3/4 x 14	90	22	20.0	16.0	25022
G 1" x 11	100	25	25.0	20.0	25026
G 1.1/8 x 11	125	40	28.0	22.0	25030
G 1.1/4 x 11	125	40	32.0	24.0	25034
G 1.3/8 x 11	140	40	36.0	29.0	25038
G 1.1/2 x 11	140	40	36.0	29.0	25042
G 1.3/4 x 11	140	40	40.0	32.0	25050
G 2" x 11	160	40	45.0	35.0	25054

Application:

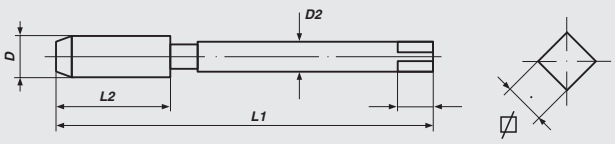
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔和盲孔
– 手用

How to order/ 如何订货:

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



DIN SHORT MACHINE TAPS
德标短式机用丝锥

	Form C	Form D	Form B	35° RSP	B-AZ
M			80	80	80
Mf		81			
BSW		82			
W (DIN 477)		82			
UNC		83			
UNF		83			
G (BSP)		84			
Rc (BSPT)	85				
PG		86			
NPT	87				
NPT - LH	88				

VÖLKEL
THREADING SOLUTIONS

Short Machine Taps
metric ISO-thread DIN 13

短式机用丝锥
公制ISO螺纹 DIN 13

DIN 352 **HSS-E** **Tol. ISO2/6H** **M**

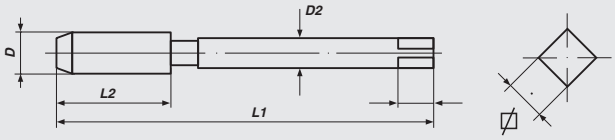
Nominal Diameter D		L 1	L 2	D 2	⧄	Art.-No.
Spiral Point / 螺尖						
M	3 x 0.5	40	11	3.5	2.7	61526
M	4 x 0.7	45	13	4.5	3.4	61530
M	5 x 0.8	48	16	6.0	4.9	61534
M	6 x 1.0	50	19	6.0	4.9	61538
M	8 x 1.25	56	22	6.0	4.9	61542
M	10 x 1.5	70	24	7.0	5.5	61546
M	12 x 1.75	75	29	9.0	7.0	61550
M	14 x 2.0	80	30	11.0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

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

应用:
通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 手用和机用

螺尖：用于通孔
螺旋槽：用于盲孔
Form B–AZ：用于通孔



Short Machine Taps
metric-fine ISO-thread DIN 13

短式机用丝锥
公制细牙ISO螺纹 DIN 13

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

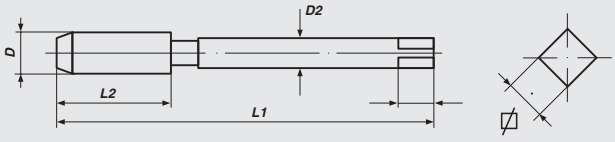
Nominal Diameter D		L 1	L 2	D 2	⌀	Art.-No.
M	6 x 0.75	50	14	6.0	4.9	66318
M	8 x 0.75	50	19	6.0	4.9	66324
M	8 x 1.0	56	22	6.0	4.9	66326
M	9 x 0.75	56	19	7.0	5.5	66328
M	9 x 1.0	63	20	7.0	5.5	66330
M	10 x 0.75	63	20	7.0	5.5	66332
M	10 x 1.0	63	20	7.0	5.5	66336
M	10 x 1.25	70	24	7.0	5.5	66338
M	12 x 1.0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

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

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔
– 手用和机用



Short Machine Taps
Whitworth-thread BS 84

短式机用丝锥
惠氏螺纹 BS 84

≈ DIN 352 **Form D** **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	62306
BSW 3/16 x 24	50	18	6.0	4.9	62310
BSW 1/4 x 20	50	19	6.0	4.9	62314
BSW 5/16 x 18	56	22	6.0	4.9	62316
BSW 3/8 x 16	70	24	7.0	5.5	62318
BSW 7/16 x 14	70	24	8.0	6.2	62320
BSW 1/2 x 12	75	29	9.0	7.0	62322
BSW 9/16 x 12	80	30	11.0	9.0	62324
BSW 5/8 x 11	80	32	12.0	9.0	62326
BSW 3/4 x 10	95	40	14.0	11.0	62330
BSW 7/8 x 9	100	40	18.0	14.5	62334
BSW 1" x 8	110	50	18.0	14.5	62338

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

短式机用丝锥
惠氏锥度煤气瓶螺丝螺纹
锥度: 3:25, DIN 477

≈ DIN 352 **Form D** **HSS-G** **W**

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

Short Machine Taps
Unified Coarse and Fine thread ANSI B 1.1

短式机用丝锥
统一制粗牙和细牙螺纹 ANSI B 1.1

≈ DIN 352 **Form D** **HSS-G** **Tol. 2B** **UNC / UNF**

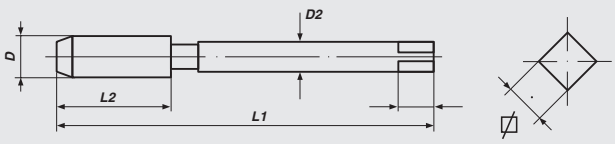
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.
UNC					
UNC 1/4 x 20	50	19	6.0	4.9	63314
UNC 5/16 x 18	56	22	6.0	4.9	63316
UNC 3/8 x 16	70	24	7.0	5.5	63318
UNC 7/16 x 14	70	24	8.0	6.2	63320
UNC 1/2 x 13	75	29	9.0	7.0	63322
UNC 9/16 x 12	80	30	11.0	9.0	63324
UNC 5/8 x 11	80	32	12.0	9.0	63326
UNC 3/4 x 10	95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

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

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔
– 手用和机用



VÖLKEL
THREADING SOLUTIONS

Short Machine Taps
Pipe-thread DIN ISO 228

短式机用丝锥
管螺纹 DIN ISO 228

DIN 5157 Form D HSS-G

G (BSP)

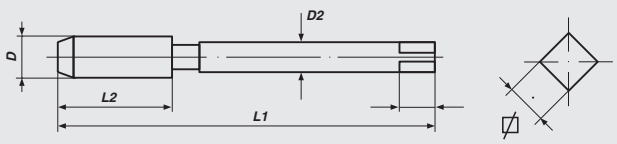
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.
G 1/8 x 28	63	20	7	5.5	65312
G 1/4 x 19	70	22	11	9.0	65314
G 3/8 x 19	70	22	12	9.0	65316
G 1/2 x 14	80	22	16	12.0	65318
G 3/4 x 14	90	22	20	16.0	65322
G 1" x 11	100	25	25	20.0	65326
G 1.1/4 x 11	125	40	32	24.0	65334
G 1.1/2 x 11	140	40	36	29.0	65342
G 1.3/4 x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

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

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔
– 手用和机用



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

短式机用丝锥
锥管螺纹, 锥度 1: 16, 牙型角55°

Form C **HSS-G** **Rc (BSPT)**

Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.
PT 1/8 x 28	65	19.0	7.0	5.5	63712
PT 1/4 x 19	70	25.0	11.0	9.0	63714
PT 3/8 x 19	75	26.0	12.0	9.0	63716
PT 1/2 x 14	80	31.0	16.0	12.0	63718
PT 3/4 x 14	100	33.0	20.0	16.0	63722
PT 1" x 11	110	38.0	25.0	20.0	63726

Application:

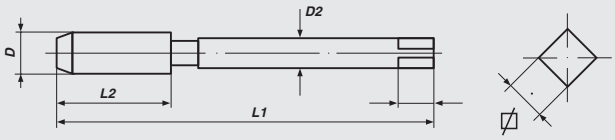
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for thread cutting by hand and machine

Form C: for through and blind holes

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 手用和机用

Form C：用于通孔和盲孔



VÖLKEL
THREADING SOLUTIONS

Short Machine Taps
armoured tube thread DIN 40 430

短式机用丝锥
装甲管螺纹 DIN 40 430

DIN 40432 Form D HSS-G

PG

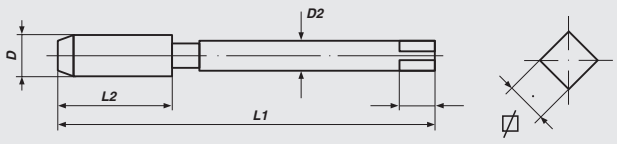
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.
PG 7 x 20	70	22	9.0	7.0	65707
PG 9 x 18	70	22	12.0	9.0	65709
PG 11 x 18	80	22	14.0	11.0	65711
PG 13.5 x 18	80	22	16.0	12.0	65713
PG 16 x 18	80	22	18.0	14.5	65716
PG 21 x 16	90	22	22.0	18.0	65721
PG 29 x 16	100	25	28.0	22.0	65729
PG 36 x 16	140	40	36.0	29.0	65736
PG 42 x 16	140	40	40.0	32.0	65742
PG 48 x 16	160	40	45.0	35.0	65748

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

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔
– 手用和机用



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

短式机用丝锥
美制锥管螺纹, 锥度 1: 16

Form C HSS-G

NPT

Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.
NPT 1/16 x 27	65	19	7	5.5	63510
NPT 1/8 x 27	65	19	7	5.5	63512
NPT 1/4 x 18	70	25	11	9.0	63514
NPT 3/8 x 18	75	26	12	9.0	63516
NPT 1/2 x 14	80	31	16	12.0	63518
NPT 3/4 x 14	100	33	20	16.0	63522
NPT 1" x 11.5	110	38	25	20.0	63526
NPT 1.1/4 x 11.5	125	41	32	24.0	63534
NPT 1.1/2 x 11.5	140	42	36	29.0	63542
NPT 2" x 11.5	160	44	36	29.0	63554

Application:

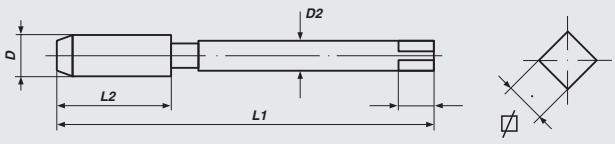
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for thread cutting by hand and machine

Form C: for through and blind holes

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 手用和机用

Form C: 用于通孔和盲孔



VÖLKEL
THREADING SOLUTIONS

Short Machine Taps, *Left Hand*

american tapered pipe thread, taper 1:16

短式机用丝锥, 左旋

美制锥管螺纹, 锥度 1: 16

Form C HSS-G

NPT

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

Application:

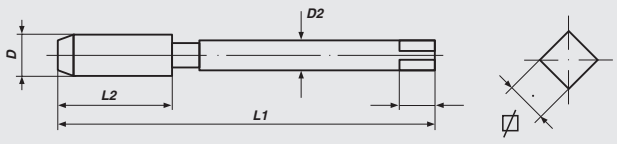
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for thread cutting by hand and machine

Form C: for through and blind holes

应用:

通用
– 抗拉强度小于为900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 手用和机用

Form C: 用于通孔和盲孔



DIN MACHINE TAPS HSS-E
德标机用丝锥 HSS–E

	Form A	Form C	Form B	15° RSP	35° RSP	B-AZ	TwinBox
M	94	95	96	100	98	101	93
M - extra long			102		103		
M - 6G - 7G - +0,1 - 4H			104/105		106/107		
M - LH		130	131		132		
Mf		108	109		112		
Mf - LH			133		136		
BSW			115		116		
UNC			117		118		
UNF			119		120		
G (BSP)		121	122		123		
G (BSP) - LH		139					
Rc (BSPT)		124					
NPT		125					
Rd		126					
FG		127					
BSC		128					
Vg		129					

COMBINED MACHINE TAPS
复合机用丝锥

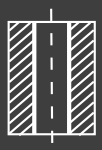
M	140
BSW	140

MACHINE NUT TAPS
机用螺母丝锥

M	141
Tr	142

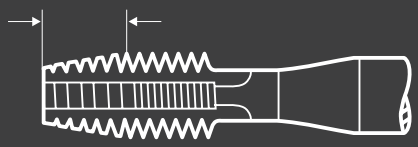
VÖLKEL
THREADING SOLUTIONS

DIN MACHINE TAPS HSS-E
德标机用丝锥HSS–E

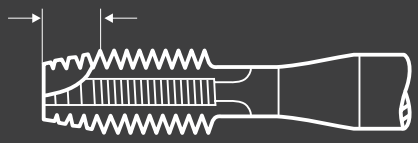


Through hole
通孔

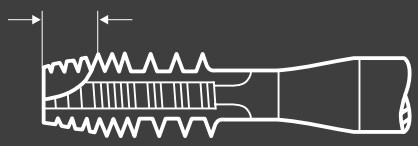
Form A
6-8 Threads Lead
6–8齿铲梢



Form B
4-5 Threads Lead with Spiral Point
4–5齿铲梢，带螺尖

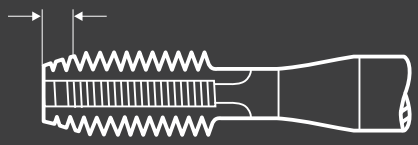


Form B-AZ
4-5 Threads Lead, Spiral Point with interrupted threads
4–5齿铲梢，带螺尖，带跳牙

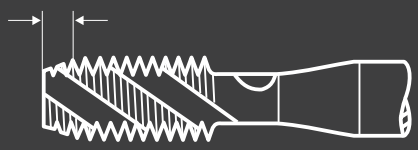


Blind hole
盲孔

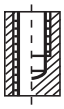
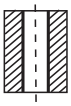
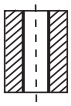
Form C
2-3 Threads Lead
2–3齿铲梢



Form C/RSP
2-3 Threads Lead, 35° Spiral Flute
2–3齿铲梢, 35° 螺旋槽



RECOMMENDED APPLICATION OF MACHINE TAPS
机用丝锥使用建议

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/丝锥类型	**A**	**C**	**B**	**15°RSP**	**35°RSP**	**B-AZ**
Typ of hole/底孔类型						
Material/材料						
Structural Steel up to 500N/mm² 抗拉强度小于500 N/mm²结构钢	○	○	○	○	○	○
Structural Steel over 500 N/mm² 抗拉强度大于500 N/mm²结构钢	○	○	○	○	○	
free-cutting Steel 易切削钢			○		○	
Cementation Steel, heat treatable Steel 渗碳钢、可热处理钢			○		○	○
Tool Steel 工具钢			○		○	
Stainless Steel 不锈钢			○		○	○
Cast Steel 铸钢			○	○	○	
Cast Iron, spheroidal graphite Iron 铸铁、球墨铸铁		○				
Malleable Cast Iron 可锻铸铁	○	○	○	○	○	
Brass, short-chipping 黄铜, 短屑		○				
Brass, long-chipping 黄铜, 长屑			○	○	○	
Bronzes 青铜			○		○	
Copper 紫铜			○	○	○	
Al-alloys, short-chipping 铝合金, 短屑		○	○		○	
Al-alloys, long-chipping 铝合金, 长屑			○	○	○	○
Zinc Alloys 锌合金			○	○	○	
Magnesium Alloys 镁合金		○	○		○	○
Thermoplastics 热塑性塑料			○		○	
Thermosetting Plastics 热固性塑料		○				

RECOMMENDED CUTTING SPEED
COOLANTS AND LUBRICANTS
建议切削速度
冷却和润滑

Material/材料	Lubricant 润滑剂	Cutting Speed 切削速度 m/min.
Steel, unalloyed and low alloyed, short-chipping 非合金钢和低合金钢, 短屑	S/E	10-20
non abrasive Material, short-chipping 非研磨材料, 短屑	S/E	6-15
Steel, heat resistant, long-chipping 耐热钢, 长屑	S	4- 8
Steel, heat resistant, short-chipping 耐热钢, 短屑	S	4- 8
Steel, cementation and heat treatable, short-chipping 渗碳钢、可热处理钢, 短屑	S	4- 8
Steel, Tool Steel up to 1200 N/mm² 工具钢, 抗拉强度小于1200 N/mm²	S	2- 5
Steel, Tool Steel over 1200 N/mm² 工具钢, 抗拉强度大于1200 N/mm²	S	2- 5
Steel stainless, short-chipping 不锈钢, 短屑	S	5-10
Steel stainless, long-chipping 不锈钢, 长屑	S	5-10
Iron, Cast 铸铁	P/T	6-20
Iron, spheroidal graphite 球墨铸铁	P/T	6-20
Iron, Malleable Cast 可锻铸铁	E	6-12
Brass, short-chipping 黄铜, 短屑	E	20-30
Brass, long-chipping 黄铜, 长屑	S/E	10-15
Bronze, short-chipping 青铜, 短屑	S/E	6-15
Bronze, long-chipping 青铜, 长屑	S/E	6-15
Copper 紫铜	S/E	10-15
Aluminium-alloys, short-chipping 铝合金, 短屑	S/E	15-30
Aluminium-alloys, long-chipping 铝合金, 长屑	E	10-20
Zinc Alloys 锌合金	S/E	10-15
Magnesium Alloys 镁合金	E/T	10-20
Titanium, short-chipping 钛合金, 短屑	S	3- 4
Titanium, long-chipping 钛合金, 长屑	S	3- 4
Plastics, thermoplastics 热塑性塑料	E/T	5-15
Plastics, thermosetting 热固性塑料	T	5-15

S = cutting oil/切削油 E = oil emulsion/乳化油 P = kerosene/煤油 T = dry/干性

Standard TwinBox

Machine Tap + Twist Drill
metric ISO-thread DIN 13

标准套装

机用丝锥 + 钻头
公制ISO螺纹 DIN 13

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

M

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

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

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
螺尖用于通孔
螺旋槽用于盲孔

全磨钻头 DIN338, N型
白身, 全磨

Machine Taps
metric ISO-thread DIN 13

机用丝锥
公制ISO螺纹 DIN 13

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

M

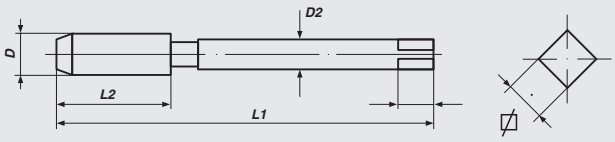
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.
DIN 371					
M 2 x 0.4	45	8	2.8	2.1	37316
M 2.3 x 0.4	45	9	2.8	2.1	37318
M 2.5 x 0.45	50	9	2.8	2.1	37322
M 2.6 x 0.45	50	9	2.8	2.1	37324
M 3 x 0.5	56	11	3.5	2.7	37326
M 4 x 0.7	63	13	4.5	3.4	37330
M 5 x 0.8	70	16	6.0	4.9	37334
M 6 x 1.0	80	19	6.0	4.9	37338
M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

Application:

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

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔



Machine Taps
metric ISO-thread DIN 13

机用丝锥
公制ISO螺纹 DIN 13

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

M

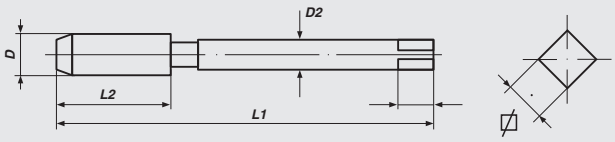
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.
DIN 371					
M 2 x 0.4	45	8	2.8	2.1	37416
M 2.3 x 0.4	45	9	2.8	2.1	37418
M 2.5 x 0.45	50	9	2.8	2.1	37422
M 2.6 x 0.45	50	9	2.8	2.1	37424
M 3 x 0.5	56	11	3.5	2.7	37426
M 3.5 x 0.6	56	13	4.0	3.0	37428
M 4 x 0.7	63	13	4.5	3.4	37430
M 5 x 0.8	70	16	6.0	4.9	37434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

Application:

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

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔和盲孔



VÖLKEL
THREADING SOLUTIONS

Machine Taps
metric ISO-thread DIN 13

机用丝锥
公制ISO螺纹 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
M 1.1 x 0.25	40	5	2.5	2.1	37504
M 1.2 x 0.25	40	5	2.5	2.1	37506
M 1.4 x 0.3	40	7	2.5	2.1	37508
M 1.6 x 0.35	40	8	2.5	2.1	37510
M 1.7 x 0.35	40	8	2.5	2.1	37512
M 1.8 x 0.35	40	8	2.5	2.1	37514
M 2 x 0.4	45	8	2.8	2.1	37516
M 2.5 x 0.45	50	9	2.8	2.1	37522
M 3 x 0.5	56	11	3.5	2.7	37526
M 3.5 x 0.6	56	13	4.0	3.0	37528
M 4 x 0.7	63	13	4.5	3.4	37530
M 5 x 0.8	70	16	6.0	4.9	37534
M 6 x 1.0	80	19	6.0	4.9	37538
M 7 x 1.0	80	19	7.0	5.5	37540
M 8 x 1.25	90	22	8.0	6.2	37542
M 10 x 1.5	100	24	10.0	8.0	37546
TIN					
M 3 x 0.5	56	11	3.5	2.7	31526
M 4 x 0.7	63	13	4.5	3.4	31530
M 5 x 0.8	70	16	6.0	4.9	31534
M 6 x 1.0	80	19	6.0	4.9	31538
M 8 x 1.25	90	22	8.0	6.2	31542
M 10 x 1.5	100	24	10.0	8.0	31546
VAP					
M 3 x 0.5	56	11	3.5	2.7	31570
M 4 x 0.7	63	13	4.5	3.4	31571
M 5 x 0.8	70	16	6.0	4.9	31572
M 6 x 1.0	80	19	6.0	4.9	31573
M 8 x 1.25	90	22	8.0	6.2	31574
M 10 x 1.5	100	24	10.0	8.0	31575

Application:

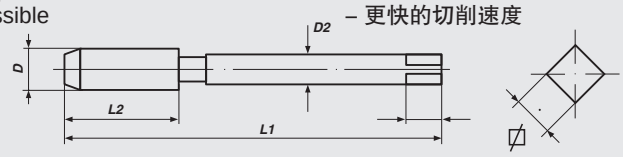
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through holes

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

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔

TIN涂层:
– 提高耐磨性
– 优异的抗摩擦性能
– 更快的切削速度



Machine Taps
metric ISO-thread DIN 13

机用丝锥
公制ISO螺纹 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
M 4 x 0.7	63	13	2.8	2.1	38530
M 5 x 0.8	70	16	3.5	2.7	38534
M 6 x 1.0	80	19	4.5	3.4	38538
M 8 x 1.25	90	22	6.0	4.9	38542
M 9 x 1.25	90	22	7.0	5.5	38544
M 10 x 1.5	100	24	7.0	5.5	38546
M 12 x 1.75	110	29	9.0	7.0	38550
M 14 x 2.0	110	30	11.0	9.0	38554
M 16 x 2.0	110	32	12.0	9.0	38558
M 18 x 2.5	125	34	14.0	11.0	38562
M 20 x 2.5	140	34	16.0	12.0	38566
M 22 x 2.5	140	34	18.0	14.5	38570
M 24 x 3.0	160	38	18.0	14.5	38574
M 27 x 3.0	160	38	20.0	16.0	38576
M 30 x 3.5	180	45	22.0	18.0	38578
M 33 x 3.5	180	50	25.0	20.0	38580
M 36 x 4.0	200	56	28.0	22.0	38582
M 39 x 4.0	200	60	32.0	24.0	38584
M 42 x 4.5	200	60	32.0	24.0	38586
M 45 x 4.5	220	65	36.0	29.0	38588
M 48 x 5.0	250	70	36.0	29.0	38590
M 52 x 5.0	250	70	40.0	32.0	38592
TIN					
M 12 x 1.75	110	29	9.0	7.0	31550
M 14 x 2.0	110	30	11.0	9.0	31554
M 16 x 2.0	110	32	12.0	9.0	31558
M 18 x 2.5	125	34	14.0	11.0	31562
M 20 x 2.5	104	34	16.0	12.0	31566
VAP					
M 12 x 1.75	110	29	9.0	7.0	31576
M 14 x 2.0	110	30	11.0	9.0	31577
M 16 x 2.0	110	32	12.0	9.0	31578
M 18 x 2.5	125	34	14.0	11.0	31579
M 20 x 2.5	140	34	16.0	12.0	31580

Application:

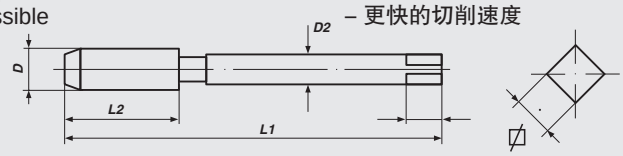
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through holes

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

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔

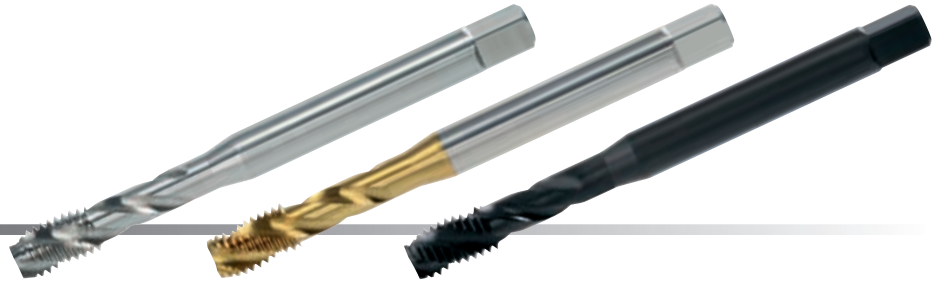
TIN涂层:
– 提高耐磨性
– 优异的抗摩擦性能
– 更快的切削速度



VÖLKEL
THREADING SOLUTIONS

Machine Taps
metric ISO-thread DIN 13

机用丝锥
公制ISO螺纹 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
M 1.1 x 0.25	40	4	2.5	2.1	37704
M 1.2 x 0.25	40	4	2.5	2.1	37706
M 1.4 x 0.3	40	5	2.5	2.1	37708
M 1.6 x 0.35	40	6	2.5	2.1	37710
M 1.7 x 0.35	40	6	2.5	2.1	37712
M 1.8 x 0.35	40	6	2.5	2.1	37714
M 2 x 0.4	45	6	2.8	2.1	37716
M 2.5 x 0.45	50	6	2.8	2.1	37722
M 3 x 0.5	56	6	3.5	2.7	37726
M 3.5 x 0.6	56	6	4.0	3.0	37728
M 4 x 0.7	63	7	4.5	3.4	37730
M 5 x 0.8	70	8	6.0	4.9	37734
M 6 x 1.0	80	10	6.0	4.9	37738
M 7 x 1.0	80	12	7.0	5.5	37740
M 8 x 1.25	90	14	8.0	6.2	37742
M 10 x 1.5	100	16	10.0	8.0	37746
TIN					
M 3 x 0.5	56	6	3.5	2.7	31726
M 4 x 0.7	63	7	4.5	3.4	31730
M 5 x 0.8	70	8	6.0	4.9	31734
M 6 x 1.0	80	10	6.0	4.9	31738
M 8 x 1.25	90	14	8.0	6.2	31742
M 10 x 1.5	100	16	10.0	8.0	31746
VAP					
M 3 x 0.5	56	6	3.5	2.7	31770
M 4 x 0.7	63	7	4.5	3.4	31771
M 5 x 0.8	70	8	6.0	4.9	31772
M 6 x 1.0	80	10	6.0	4.9	31773
M 8 x 1.25	90	14	8.0	6.2	31774
M 10 x 1.5	100	16	10.0	8.0	31775

Application:

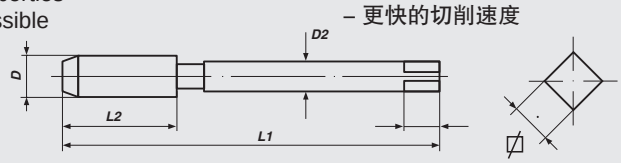
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for blind holes

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

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 盲孔

TIN涂层:
– 提高耐磨性
– 优异的抗摩擦性能
– 更快的切削速度



Machine Taps
metric ISO-thread DIN 13

机用丝锥
公制ISO螺纹 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
M 4 x 0.7	63	7	2.8	2.1	38730
M 5 x 0.8	70	8	3.5	2.7	38734
M 6 x 1.0	80	10	4.5	3.4	38738
M 8 x 1.25	90	14	6.0	4.9	38742
M 10 x 1.5	100	16	7.0	5.5	38746
M 12 x 1.75	110	18	9.0	7.0	38750
M 14 x 2.0	110	20	11.0	9.0	38754
M 16 x 2.0	110	22	12.0	9.0	38758
M 18 x 2.5	125	25	14.0	11.0	38762
M 20 x 2.5	140	25	16.0	12.0	38766
M 22 x 2.5	140	27	18.0	14.5	38770
M 24 x 3.0	160	30	18.0	14.5	38774
M 27 x 3.0	160	30	20.0	16.0	38776
M 30 x 3.5	180	35	22.0	18.0	38778
M 33 x 3.5	180	35	25.0	20.0	38780
M 36 x 4.0	200	40	28.0	22.0	38782
M 39 x 4.0	200	40	32.0	24.0	38784
M 42 x 4.5	200	45	32.0	24.0	38786
M 45 x 4.5	220	45	36.0	29.0	38788
M 48 x 5.0	250	50	36.0	29.0	38790
M 52 x 5.0	250	50	40.0	32.0	38792
TIN					
M 12 x 1.75	110	18	9.0	7.0	31750
M 14 x 2.0	110	20	11.0	9.0	31754
M 16 x 2.0	110	22	12.0	9.0	31758
M 18 x 2.5	125	25	14.0	11.0	31762
M 20 x 2.5	104	25	16.0	12.0	31766
VAP					
M 12 x 1.75	110	18	9.0	7.0	31776
M 14 x 2.0	110	20	11.0	9.0	31777
M 16 x 2.0	110	22	12.0	9.0	31778
M 18 x 2.5	125	25	14.0	11.0	31779
M 20 x 2.5	140	25	16.0	12.0	31780

Application:

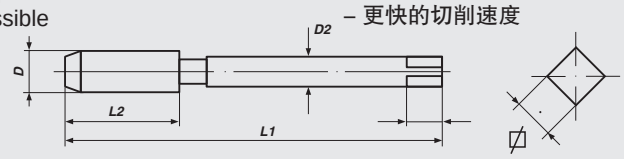
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for blind holes

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

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 盲孔

TIN涂层:
– 提高耐磨性
– 优异的抗摩擦性能
– 更快的切削速度



VÖLKEL
THREADING SOLUTIONS

Machine Taps
metric ISO-thread DIN 13

机用丝锥
公制ISO螺纹 DIN 13

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

M

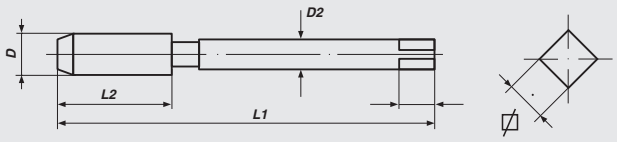
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.
DIN 371					
M 3 x 0.5	56	11	3.5	2.7	37626
M 3.5 x 0.6	56	13	4.0	3.0	37628
M 4 x 0.7	63	13	4.5	3.4	37630
M 5 x 0.8	70	16	6.0	4.9	37634
M 6 x 1.0	80	19	6.0	4.9	37638
M 7 x 1.0	80	19	7.0	5.5	37640
M 8 x 1.25	90	22	8.0	6.2	37642
M 10 x 1.5	100	24	10.0	8.0	37646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

Application:

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

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 盲孔



Machine Taps
metric ISO-thread DIN 13

机用丝锥
公制ISO螺纹 DIN 13

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

M

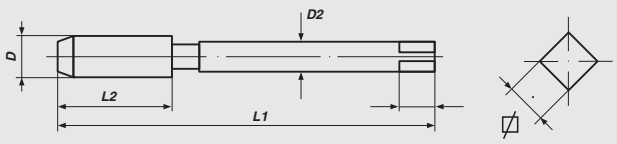
Nominal Diameter D	L 1	L 2	D 2	⌀	Art.-No.
DIN 371					
M 3 x 0.5	56	11	3.5	2.7	37926
M 4 x 0.7	63	13	4.5	3.4	37930
M 5 x 0.8	70	16	6.0	4.9	37934
M 6 x 1.0	80	19	6.0	4.9	37938
M 8 x 1.25	90	22	8.0	6.2	37942
M 10 x 1.5	100	24	10.0	8.0	37946
DIN 376					
M 3 x 0.5	56	11	2.2	—	38926
M 4 x 0.7	63	13	2.8	2.1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

Application:

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

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔



VÖLKEL
THREADING SOLUTIONS

Machine Taps, *extra long*

metric ISO-thread DIN 13

机用丝锥, 加长

公制ISO螺纹 DIN 13

≈ DIN 371 Form B HSS-E Tol. ISO2/6H

M

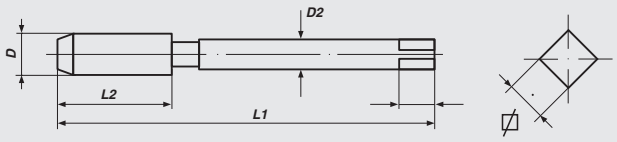
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.
100 mm					
M 3 x 0.5	100	11	3.5	2.7	32010
M 4 x 0.7	100	13	4.5	3.4	32011
M 5 x 0.8	100	16	6.0	4.9	32012
M 6 x 1.0	100	19	6.0	4.9	32013
M 8 x 1.25	100	22	8.0	6.2	32014
M 10 x 1.5	100	24	10.0	8.0	32015
M 12 x 1.75	100	29	12.0	9.0	32016
120 mm					
M 4 x 0.7	120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

Application:

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

应用:

通用, 适用于不方便加工的地方
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔



Machine Taps, *extra long*

metric ISO-thread DIN 13

机用丝锥, 加长

公制ISO螺纹 DIN 13

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

M

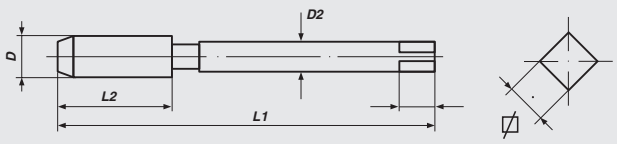
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.
100 mm					
M 3 x 0.5	100	6	3.5	2.7	32040
M 4 x 0.7	100	7	4.5	3.4	32041
M 5 x 0.8	100	8	6.0	4.9	32042
M 6 x 1.0	100	10	6.0	4.9	32043
M 8 x 1.25	100	14	8.0	6.2	32044
M 10 x 1.5	100	16	10.0	8.0	32045
M 12 x 1.75	100	18	12.0	9.0	32046
120 mm					
M 4 x 0.7	120	7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

Application:

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

应用:

通用, 适用于不方便加工的地方
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 盲孔



VÖLKEL
THREADING SOLUTIONS

Machine Taps, *with oversize*

metric ISO-thread DIN 13

机用丝锥, 中径加大

公制ISO螺纹 DIN 13

DIN 371/376 Form B HSS-E

M

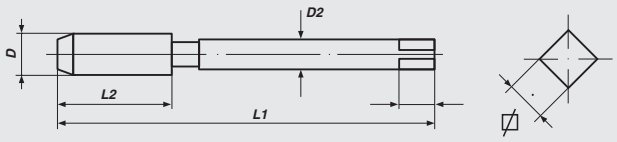
Nominal Diameter D		L 1	L 2	D 2	⊡	Art.-No.
6G		DIN 371				
M	2.5 x 0.45	50	9	2.8	2.1	32522
M	3 x 0.5	56	11	3.5	2.7	32526
M	4 x 0.7	63	13	4.5	3.4	32530
M	5 x 0.8	70	16	6.0	4.9	32534
M	6 x 1.0	80	19	6.0	4.9	32538
M	8 x 1.25	90	22	8.0	6.2	32542
M	10 x 1.5	100	24	10.0	8.0	32546
		DIN 376				
M	12 x 1.75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

Application:

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

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 长屑
– 通孔



Machine Taps, *with undersize*

metric ISO-thread DIN13

机用丝锥, 中径减少

公制ISO螺纹 DIN 13

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

M

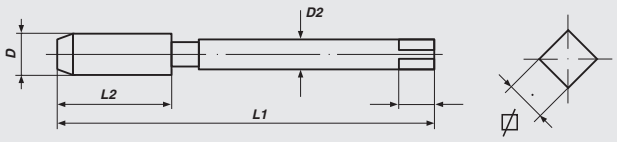
Nominal Diameter D		L 1	L 2	D 2	⧄	Art.-No.
4H		DIN 371				
M	3 x 0.5	56	11	3.5	2.7	32612
M	4 x 0.7	63	13	4.5	3.4	32614
M	5 x 0.8	70	16	6.0	4.9	32616
M	6 x 1.0	80	19	6.0	4.9	32618
M	8 x 1.25	90	22	8.0	6.2	32620
M	10 x 1.5	100	24	10.0	8.0	32622
		DIN 376				
M	12 x 1.75	110	29	9.0	7.0	32624
M	14 x 2.0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

Application:

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

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 长屑
– 通孔



VÖLKEL
THREADING SOLUTIONS

Machine Taps, *with oversize*

metric ISO-thread DIN 13

机用丝锥, 中径加大

公制ISO螺纹 DIN 13

DIN 371/376 Form C/35°RSP HSS-E

M

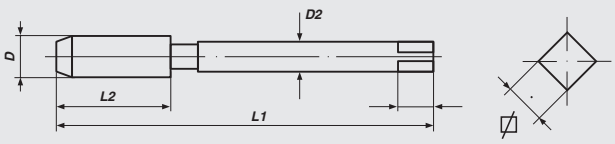
Nominal Diameter D		L 1	L 2	D 2	⊡	Art.-No.
6G		DIN 371				
M	3 x 0.5	56	6	3.5	2.7	32726
M	4 x 0.7	63	7	4.5	3.4	32730
M	5 x 0.8	70	8	6.0	4.9	32734
M	6 x 1.0	80	10	6.0	4.9	32738
M	8 x 1.25	90	14	8.0	6.2	32742
M	10 x 1.5	100	16	10.0	8.0	32746
		DIN 376				
M	12 x 1.75	110	18	9.0	7.0	32750
M	14 x 2.0	110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

Application:

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

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 长屑
– 盲孔



Machine Taps, *with undersize*

metric ISO-thread DIN 13

机用丝锥, 中径减少

公制ISO螺纹 DIN 13

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

M

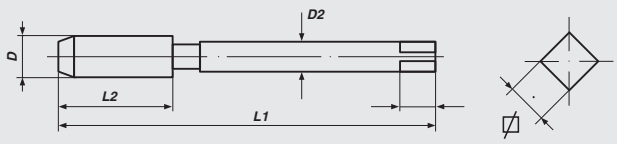
Nominal Diameter D		L 1	L 2	D 2	⌀	Art.-No.
4H		DIN 371				
M	3 x 0.5	56	6	3.5	2.7	32652
M	4 x 0.7	63	7	4.5	3.4	32654
M	5 x 0.8	70	8	6.0	4.9	32656
M	6 x 1.0	80	10	6.0	4.9	32658
M	8 x 1.25	90	14	8.0	6.2	32660
M	10 x 1.5	100	16	10.0	8.0	32662
		DIN 376				
M	12 x 1.75	110	18	9.0	7.0	32664
M	14 x 2.0	110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

Application:

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

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 长屑
– 盲孔



VÖLKEL THREADING SOLUTIONS

Machine Taps
metric-fine ISO-thread DIN 13

机用丝锥
公制细牙ISO螺纹 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
M 5 x 0.5	70	12	3.5	2.7	39404
M 6 x 0.75	80	14	4.5	3.4	39407
M 8 x 0.75	80	19	6.0	4.9	39410
M 8 x 1.0	90	22	6.0	4.9	39411
M 10 x 1.0	90	20	7.0	5.5	39415
M 10 x 1.25	100	24	7.0	5.5	39416
M 12 x 1.0	100	22	9.0	7.0	39420
M 12 x 1.25	100	22	9.0	7.0	39421
M 12 x 1.5	100	22	9.0	7.0	39422
M 14 x 1.0	100	22	11.0	9.0	39426
M 14 x 1.25	100	22	11.0	9.0	39427
M 14 x 1.5	100	22	11.0	9.0	39428
M 16 x 1.0	100	22	12.0	9.0	39431
M 16 x 1.5	100	22	12.0	9.0	39433
M 18 x 1.0	110	25	14.0	11.0	39434
M 18 x 1.5	110	25	14.0	11.0	39436
M 18 x 2.0	125	34	14.0	11.0	39437
M 20 x 1.0	125	25	16.0	12.0	39438
M 20 x 1.25	125	25	16.0	12.0	39439
M 20 x 1.5	125	25	16.0	12.0	39440
M 20 x 2.0	140	34	16.0	12.0	39441
M 22 x 1.0	125	25	18.0	14.5	39443
M 22 x 1.5	125	25	18.0	14.5	39445
M 22 x 2.0	140	34	18.0	14.5	39446
M 24 x 1.0	140	28	18.0	14.5	39448
M 24 x 1.5	140	28	18.0	14.5	39450
M 24 x 2.0	140	28	18.0	14.5	39451
M 25 x 1.0	140	28	18.0	14.5	39452
M 26 x 1.5	140	28	18.0	14.5	39454
M 27 x 1.5	140	28	20.0	16.0	39456
M 27 x 2.0	140	28	20.0	16.0	39457
M 28 x 1.5	140	28	20.0	16.0	39459
M 30 x 1.5	150	28	22.0	18.0	39463
M 30 x 2.0	150	28	22.0	18.0	39464
M 32 x 1.5	150	28	22.0	18.0	39466
M 32 x 2.0	150	28	22.0	18.0	39467
M 33 x 2.0	160	30	25.0	20.0	39468
M 35 x 1.5	170	30	28.0	22.0	39472
M 36 x 1.5	170	30	28.0	22.0	39473
M 36 x 2.0	170	30	28.0	22.0	39474
M 38 x 1.5	170	30	28.0	22.0	39476
M 40 x 1.5	170	30	32.0	24.0	39480
M 42 x 1.5	170	30	32.0	24.0	39483
M 45 x 1.5	180	32	36.0	29.0	39486
M 48 x 1.5	190	32	36.0	29.0	39489
M 50 x 1.5	190	32	36.0	29.0	39494
M 52 x 1.5	190	32	40.0	32.0	39497

Machine Taps
metric-fine ISO-thread DIN 13

机用丝锥
公制细牙ISO螺纹 DIN 13

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

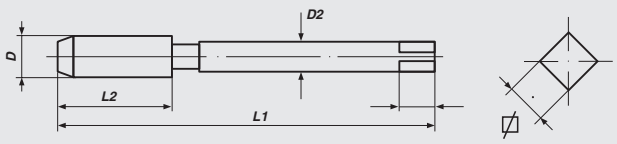
Nominal Diameter D	L 1	L 2	D 2	⌀	Art.-No.
M 3 x 0.35	56	9	2.2	-	39501
M 4 x 0.35	63	10	2.8	2.1	39502
M 4 x 0.5	63	10	2.8	2.1	39503
M 5 x 0.5	70	12	3.5	2.7	39504
M 5 x 0.75	70	12	3.5	2.7	39505
M 6 x 0.5	80	14	4.5	3.4	39506
M 6 x 0.75	80	14	4.5	3.4	39507
M 7 x 0.75	80	14	5.5	4.3	39508
M 8 x 0.5	80	19	6.0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

Application:

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

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔



VÖLKEL
THREADING SOLUTIONS

Machine Taps
metric-fine ISO-thread DIN 13

机用丝锥
公制细牙ISO螺纹 DIN 13

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

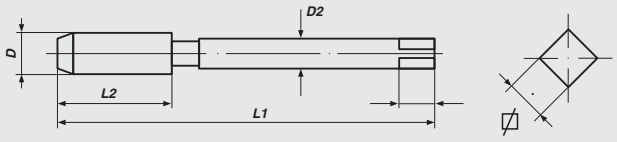
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.
M 20 x 1.0	125	25	16.0	12.0	39538
M 20 x 1.25	125	25	16.0	12.0	39539
M 20 x 1.5	125	25	16.0	12.0	39540
M 20 x 2.0	140	34	16.0	12.0	39541
M 21 x 1.5	125	25	16.0	12.0	39542
M 22 x 1.0	125	25	18.0	14.5	39543
M 22 x 1.25	125	25	18.0	14.5	39544
M 22 x 1.5	125	25	18.0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

Application:

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

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔



Machine Taps
metric-fine ISO-thread DIN 13

机用丝锥
公制细牙ISO螺纹 DIN 13

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

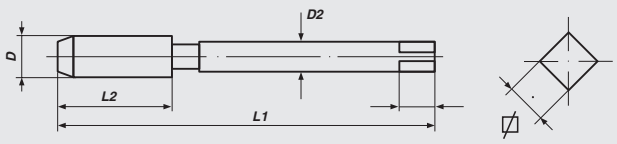
Nominal Diameter D	L 1	L 2	D 2	⌀	Art.-No.
M 34 x 1.5	170	30	28.0	22.0	39570
M 34 x 2.0	170	30	28.0	22.0	39571
M 35 x 1.5	170	30	28.0	22.0	39572
M 36 x 1.5	170	30	28.0	22.0	39573
M 36 x 2.0	170	30	28.0	22.0	39574
M 36 x 3.0	200	56	28.0	22.0	39575
M 38 x 1.5	170	30	28.0	22.0	39576
M 39 x 1.5	170	30	32.0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

Application:

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

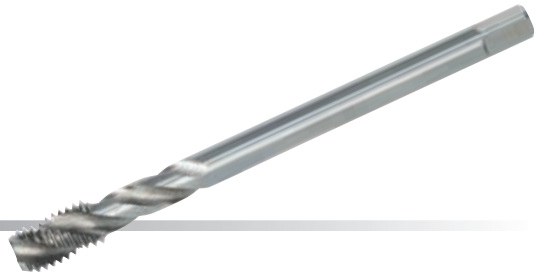
应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔



Machine Taps
metric-fine ISO-thread DIN 13

机用丝锥
公制细牙ISO螺纹 DIN 13



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

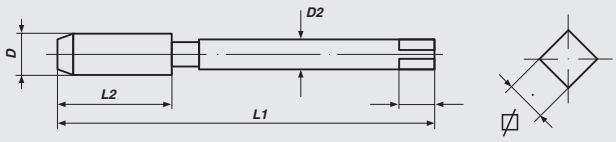
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.
M 3 x 0.35	56	5	2.2	-	39701
M 4 x 0.35	63	5	2.8	2.1	39702
M 4 x 0.5	63	5	2.8	2.1	39703
M 5 x 0.5	70	5	3.5	2.7	39704
M 5 x 0.75	70	8	3.5	2.7	39705
M 6 x 0.5	80	5	4.5	3.4	39706
M 6 x 0.75	80	8	4.5	3.4	39707
M 7 x 0.75	80	8	5.5	4.3	39708
M 8 x 0.5	80	8	6.0	4.9	39709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

Application:

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

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 盲孔



Machine Taps
metric-fine ISO-thread DIN 13

机用丝锥
公制细牙ISO螺纹 DIN 13

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

Mf

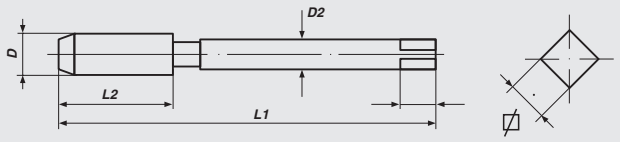
Nominal Diameter D	L 1	L 2	D 2	⌀	Art.-No.
M 20 x 1.0	125	14	16.0	12.0	39738
M 20 x 1.25	125	17	16.0	12.0	39739
M 20 x 1.5	125	17	16.0	12.0	39740
M 20 x 2.0	140	20	16.0	12.0	39741
M 21 x 1.5	125	17	16.0	12.0	39742
M 22 x 1.0	125	14	18.0	14.5	39743
M 22 x 1.25	125	17	18.0	14.5	39744
M 22 x 1.5	125	17	18.0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

Application:

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

应用:

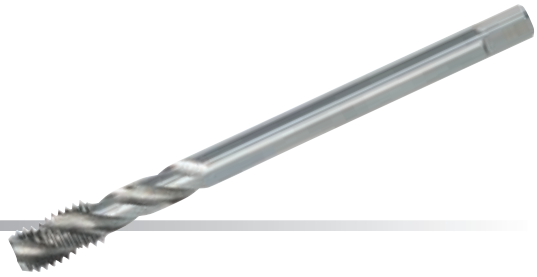
通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 盲孔



VÖLKEL THREADING SOLUTIONS

Machine Taps
metric-fine ISO-thread DIN 13

机用丝锥
公制细牙ISO螺纹 DIN 13



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

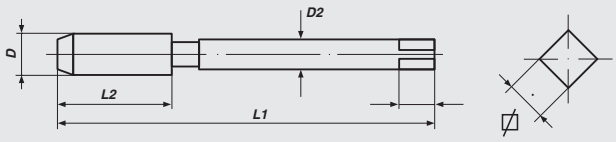
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.
M 34 x 1.5	170	24	28.0	22.0	39770
M 34 x 2.0	170	24	28.0	22.0	39771
M 35 x 1.5	170	24	28.0	22.0	39772
M 36 x 1.5	170	24	28.0	22.0	39773
M 36 x 2.0	170	24	28.0	22.0	39774
M 36 x 3.0	200	30	28.0	22.0	39775
M 38 x 1.5	170	24	28.0	22.0	39776
M 39 x 1.5	170	25	32.0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

Application:

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

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 盲孔



Machine Taps
Withworth-thread BS 84

机用丝锥
惠氏螺纹 BS 84

≈ DIN 371/376 Form B HSS-E

BSW

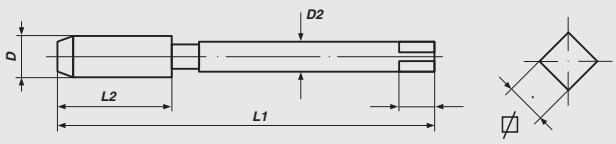
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.
≈ DIN 371					
BSW 1/8 x 40	56	11	3.5	2.7	70506
BSW 5/32 x 32	63	13	4.5	3.4	70508
BSW 3/16 x 24	70	15	6.0	4.9	70510
BSW 1/4 x 20	80	17	7.0	5.5	70514
BSW 5/16 x 18	90	20	8.0	6.2	70516
BSW 3/8 x 16	100	22	9.0	7.0	70518
BSW 7/16 x 14	100	22	11.0	9.0	70520
BSW 1/2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

Application:

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

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔



Machine Taps
Withworth-thread BS 84

机用丝锥
惠氏螺纹 BS 84

≈ DIN 371/376 Form C/35° RSP HSS-E

BSW

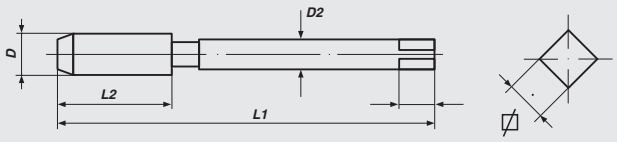
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.
≈ DIN 371					
BSW 1/8 x 40	56	7	3.5	2.7	70706
BSW 5/32 x 32	63	7	4.5	3.4	70708
BSW 3/16 x 24	70	10	6.0	4.9	70710
BSW 1/4 x 20	80	13	7.0	5.5	70714
BSW 5/16 x 18	90	14	8.0	6.2	70716
BSW 3/8 x 16	100	16	9.0	7.0	70718
BSW 7/16 x 14	100	17	11.0	9.0	70720
BSW 1/2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

Application:

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

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 盲孔



Machine Taps

Unified Coarse thread ANSI B 1.1

机用丝锥

统一制粗牙螺纹 ANSI B 1.1

≈ DIN 371/376 Form B HSS-E Tol. 2B

UNC

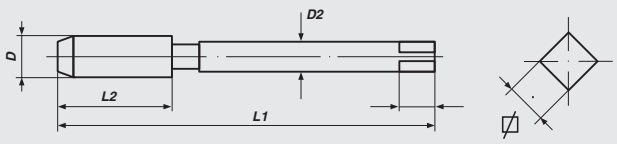
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.
≈ DIN 371					
UNC No. 4 x 40	50	10	3.5	2.7	74504
UNC No. 5 x 40	56	11	3.5	2.7	74505
UNC No. 6 x 32	56	12	4.0	3.0	74506
UNC No. 8 x 32	63	13	4.5	3.4	74508
UNC No. 10 x 24	70	15	6.0	4.9	74510
UNC No. 12 x 24	70	16	6.0	4.9	74512
UNC 1/4 x 20	80	17	7.0	5.5	74514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

Application:

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

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔



Machine Taps
Unified Coarse thread ANSI B 1.1

机用丝锥
统一制粗牙螺纹 ANSI B 1.1

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

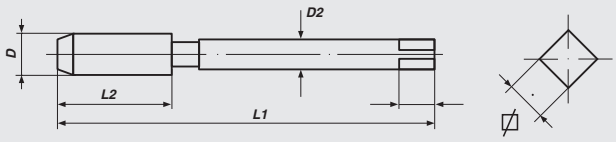
Nominal Diameter D	L 1	L 2	D 2	⊡	Art.-No.
≈ DIN 371					
UNC No. 4 x 40	50	6	3.5	2.7	74704
UNC No. 5 x 40	56	7	3.5	2.7	74705
UNC No. 6 x 32	56	7	4.0	3.0	74706
UNC No. 8 x 32	63	8	4.5	3.4	74708
UNC No. 10 x 24	70	10	6.0	4.9	74710
UNC No. 12 x 24	70	10	6.0	4.9	74712
UNC 1/4 x 20	80	13	7.0	5.5	74714
UNC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

Application:

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

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 盲孔



Machine Taps
Unified Fine thread ANSI B 1.1

机用丝锥
统一制细牙螺纹 ANSI B 1.1

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

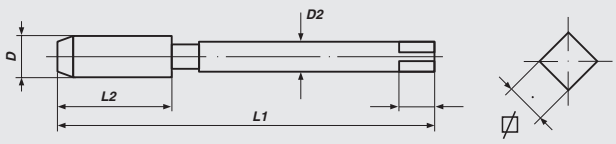
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.
≈ DIN 371					
UNF No. 4 x 48	50	10	3.5	2.7	76504
UNF No. 5 x 44	56	11	3.5	2.7	76505
UNF No. 6 x 40	56	12	4.0	3.0	76506
UNF No. 8 x 36	63	13	4.5	3.4	76508
UNF No. 10 x 32	70	15	6.0	4.9	76510
UNF No. 12 x 28	70	16	6.0	4.9	76512
UNF 1/4 x 28	80	17	7.0	5.5	76514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

Application:

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

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔



Machine Taps
Unified Fine thread ANSI B 1.1

机用丝锥
统一制细牙螺纹 ANSI B 1.1

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

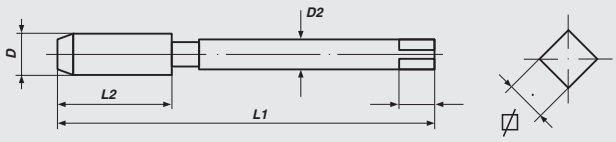
Nominal Diameter D	L 1	L 2	D 2	⊡	Art.-No.
≈ DIN 371					
UNF No. 4 x 48	50	6	3.5	2.7	76704
UNF No. 5 x 44	56	7	3.5	2.7	76705
UNF No. 6 x 40	56	7	4.0	3.0	76706
UNF No. 8 x 36	63	8	4.5	3.4	76708
UNF No. 10 x 32	70	10	6.0	4.9	76710
UNF No. 12 x 28	70	10	6.0	4.9	76712
UNF 1/4 x 28	80	10	7.0	5.5	76714
UNF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

Application:

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

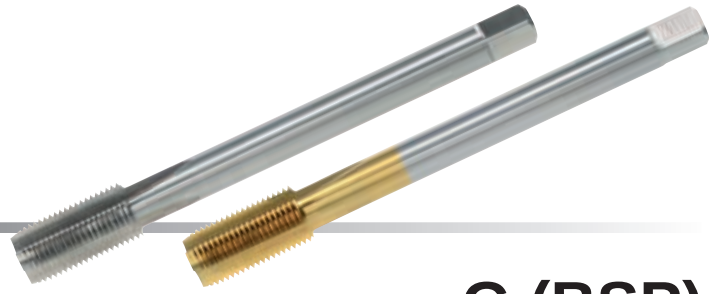
应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 盲孔



Machine Taps
Pipe-thread DIN ISO 228

机用丝锥
管螺纹 DIN ISO 228



DIN 5156 Form C HSS-E

G (BSP)

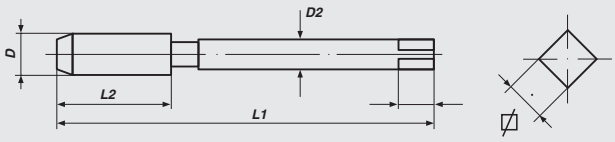
Nominal Diameter D		L 1	L 2	D 2	⧄	Art.-No.
G	1/8 x 28	90	20	7.0	5.5	78412
G	1/4 x 19	100	22	11.0	9.0	78414
G	3/8 x 19	100	22	12.0	9.0	78416
G	1/2 x 14	125	25	16.0	12.0	78418
G	5/8 x 14	125	25	18.0	14.5	78420
G	3/4 x 14	140	28	20.0	16.0	78422
G	7/8 x 14	150	28	22.0	18.0	78424
G	1" x 11	160	30	25.0	20.0	78426
G	1.1/8 x 11	170	30	28.0	22.0	78430
G	1.1/4 x 11	170	30	32.0	24.0	78434
G	1.3/8 x 11	180	32	36.0	29.0	78438
G	1.1/2 x 11	190	32	36.0	29.0	78442
G	1.3/4 x 11	190	32	40.0	32.0	78450
G	2" x 11	220	40	45.0	35.0	78454
TIN						
G	1/8 x 28	90	20	7.0	5.5	78413
G	1/4 x 19	100	22	11.0	9.0	78415
G	3/8 x 19	100	22	12.0	9.0	78417
G	1/2 x 14	125	25	16.0	12.0	78419
G	3/4 x 14	140	28	20.0	16.0	78423
G	1" x 11	160	30	25.0	20.0	78427

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

应用:
通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔和盲孔

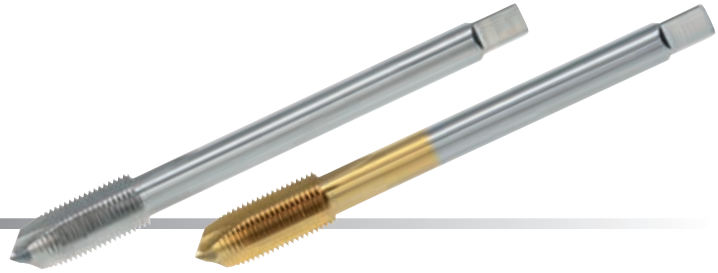
TIN涂层:
– 提高耐磨性
– 优异的抗摩擦性能
– 更快的切削速度



VÖLKEL
THREADING SOLUTIONS

Machine Taps
Pipe-thread DIN ISO 228

机用丝锥
管螺纹 DIN ISO 228



DIN 5156 Form B HSS-E

G (BSP)

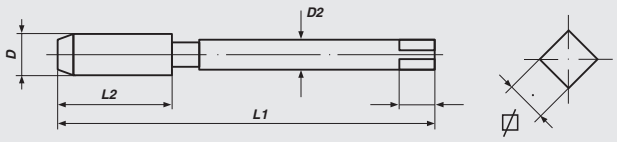
Nominal Diameter D		L 1	L 2	D 2	⧄	Art.-No.
G	1/8 x 28	90	20	7.0	5.5	78512
G	1/4 x 19	100	22	11.0	9.0	78514
G	3/8 x 19	100	22	12.0	9.0	78516
G	1/2 x 14	125	25	16.0	12.0	78518
G	5/8 x 14	125	25	18.0	14.5	78520
G	3/4 x 14	140	28	20.0	16.0	78522
G	7/8 x 14	150	28	22.0	18.0	78524
G	1" x 11	160	30	25.0	20.0	78526
G	1.1/8 x 11	170	30	28.0	22.0	78530
G	1.1/4 x 11	170	30	32.0	24.0	78534
G	1.3/8 x 11	180	32	36.0	29.0	78538
G	1.1/2 x 11	190	32	36.0	29.0	78542
G	1.3/4 x 11	190	32	40.0	32.0	78550
G	2" x 11	220	40	45.0	35.0	78554
TIN						
G	1/8 x 28	90	20	7.0	5.5	78513
G	1/4 x 19	100	22	11.0	9.0	78515
G	3/8 x 19	100	22	12.0	9.0	78517
G	1/2 x 14	125	25	16.0	12.0	78519
G	3/4 x 14	140	28	20.0	16.0	78523
G	1" x 11	160	30	25.0	20.0	78527

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

应用:
通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔

TIN涂层:
– 提高耐磨性
– 优异的抗摩擦性能
– 更快的切削速度



Machine Taps
Pipe-thread DIN ISO 228

机用丝锥
管螺纹 DIN ISO 228

DIN 5156 Form C/35° RSP HSS-E G (BSP)

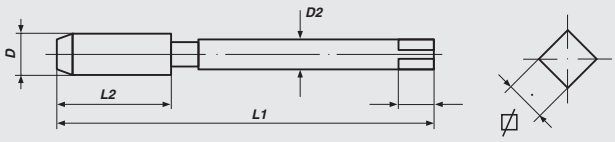
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.
G 1/8 x 28	90	20	7.0	5.5	78712
G 1/4 x 19	100	22	11.0	9.0	78714
G 3/8 x 19	100	22	12.0	9.0	78716
G 1/2 x 14	125	25	16.0	12.0	78718
G 5/8 x 14	125	25	18.0	14.5	78720
G 3/4 x 14	140	28	20.0	16.0	78722
G 7/8 x 14	150	28	22.0	18.0	78724
G 1" x 11	160	30	25.0	20.0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

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

应用:
通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 盲孔

TIN涂层:
– 提高耐磨性
– 优异的抗摩擦性能
– 更快的切削速度



VÖLKEL
THREADING SOLUTIONS

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

机用丝锥
锥管螺纹, 锥度1:16, 牙型角55°

DIN 5156 Form C HSS-E

Rc (BSPT)

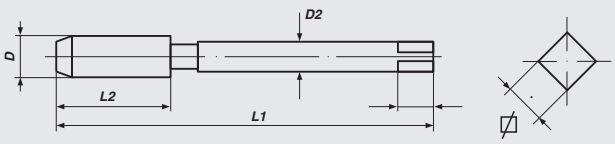
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.
Rc 1/8 x 28	90	20	7.0	5.5	73404
Rc 1/4 x 19	100	22	11.0	9.0	73406
Rc 3/8 x 19	100	22	12.0	9.0	73408
Rc 1/2 x 14	125	28	16.0	12.0	73410
Rc 3/4 x 14	140	28	20.0	16.0	73412
Rc 1" x 11	160	38	25.0	20.0	73414

Application:

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

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔和盲孔



Machine Taps
american tapered pipe thread, taper 1:16

机用丝锥
美制锥管螺纹, 锥度1:16

Form C **HSS-E** **NPT**

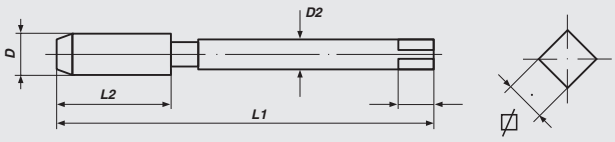
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.
NPT 1/16 x 27	90	20	6.0	4.9	73432
NPT 1/8 x 27	90	20	7.0	5.5	73434
NPT 1/4 x 18	100	22	11.0	9.0	73436
NPT 3/8 x 18	100	22	12.0	9.0	73438
NPT 1/2 x 14	125	28	16.0	12.0	73440
NPT 3/4 x 14	140	28	20.0	16.0	73442
NPT 1" x 11.5	160	38	25.0	20.0	73444

Application:

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

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔和盲孔



Machine Taps
Knuckle thread DIN 405

机用丝锥
圆螺纹DIN 405

DIN 374 Form C HSS-E Tol. 7H

Rd

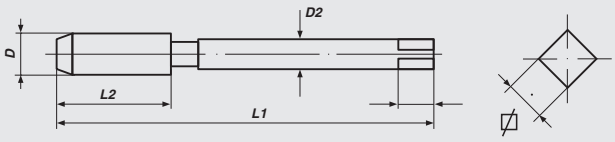
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.
Rd 8 x 1/10	90	26	6.0	4.9	79440
Rd 9 x 1/10	90	26	7.0	5.5	79441
Rd 10 x 1/10	100	28	7.0	5.5	79442
Rd 11 x 1/10	100	28	8.0	6.2	79443
Rd 12 x 1/10	110	28	9.0	7.0	79444
Rd 14 x 1/8	110	32	11.0	9.0	79445
Rd 16 x 1/8	110	32	12.0	9.0	79446
Rd 18 x 1/8	125	32	14.0	11.0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

Application:

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

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔和盲孔



Machine Taps
Cycle thread DIN 79012

机用丝锥
自行车螺纹DIN 79012

DIN 374 **Form C** **HSS-E** **Tol. medium** **FG**

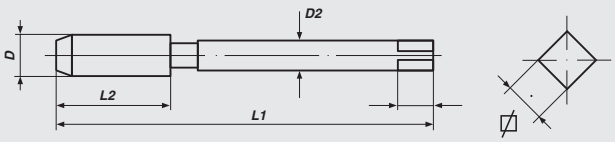
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.
FG 2 x 56	45	8	2.8	2.1	79401
FG 2.3 x 56	45	8	2.8	2.1	79402
FG 2.6 x 56	56	8	3.5	2.7	79403
FG 6.35 x 26	80	14	7.0	5.5	79404
FG 7.9 x 26	90	16	8.0	6.2	79405
FG 9.5 x 26	90	16	7.0	5.5	79406
FG 14.3 x 20	100	22	11.0	9.0	79407
FG 14.3 x 20 - LH	100	22	11.0	9.0	79408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

Application:

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

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔和盲孔



Machine Taps
Cycle thread BS 811

机用丝锥
自行车螺纹BS 811

DIN 374 **Form C** **HSS-E** **Tol. medium** **BSC**

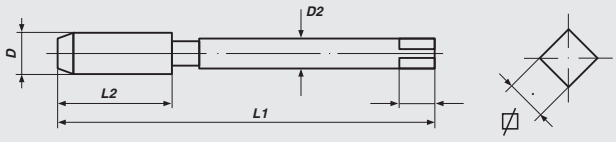
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.
BSC 1/4 x 26	80	14	7.0	5.5	79420
BSC 5/16 x 26	90	16	8.0	6.2	79421
BSC 3/8 x 26	90	16	7.0	5.5	79422
BSC 9/16 x 20	100	22	11.0	9.0	79423
BSC 9/16 x 20 - LH	100	22	11.0	9.0	79424
BSC 1" x 24	140	24	18.0	14.5	79425

Application:

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

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔和盲孔



Machine Taps
Valve thread DIN 7756

机用丝锥
阀门螺纹DIN 7756

DIN 374 Form C HSS-E Tol. medium Vg

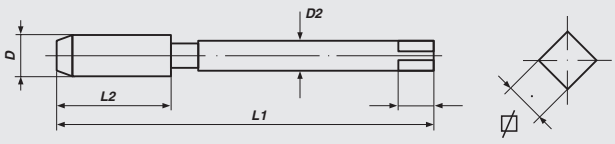
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.
Vg 5 x 36	70	12	6.0	4.9	79430
Vg 5.2 x 24	80	17	6.0	4.9	79431
Vg 6 x 32	80	14	7.0	5.5	79432
Vg 8 x 32	80	16	8.0	6.2	79433
Vg 10 x 28	90	18	8.0	6.2	79434
Vg 12 x 26	100	22	9.0	7.0	79435

Application:

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

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔和盲孔



Machine Taps, *Left Hand*

metric ISO-thread DIN 13

机用丝锥, 左旋

公制ISO螺纹 DIN 13

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

M

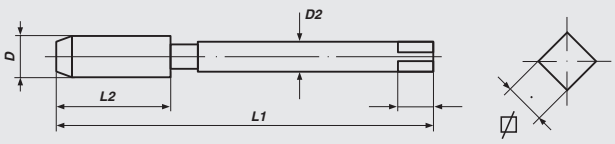
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.
DIN 371					
M 3 x 0.5	56	11	3.5	2.7	33426
M 4 x 0.7	63	13	4.5	3.4	33430
M 5 x 0.8	70	16	6.0	4.9	33434
M 6 x 1.0	80	19	6.0	4.9	33438
M 8 x 1.25	90	22	8.0	6.2	33442
M 10 x 1.5	100	24	10.0	8.0	33446
DIN 376					
M 12 x 1.75	110	29	9.0	7.0	34450
M 14 x 2.0	110	30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

Application:

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

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔和盲孔



Machine Taps, *Left Hand*

metric ISO-thread DIN 13

机用丝锥, 左旋

公制ISO螺纹 DIN 13

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

M

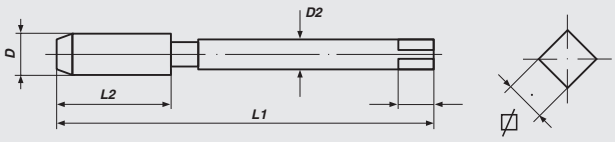
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.
DIN 371					
M 3 x 0.5	56	11	3.5	2.7	33526
M 4 x 0.7	63	13	4.5	3.4	33530
M 5 x 0.8	70	16	6.0	4.9	33534
M 6 x 1.0	80	19	6.0	4.9	33538
M 7 x 1.0	80	19	7.0	5.5	33540
M 8 x 1.25	90	22	8.0	6.2	33542
M 10 x 1.5	100	24	10.0	8.0	33546
DIN 376					
M 3 x 0.5	56	11	2.2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

Application:

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

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔



Machine Taps, *Left Hand*

metric ISO-thread DIN 13

机用丝锥, 左旋

公制ISO螺纹 DIN 13

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

M

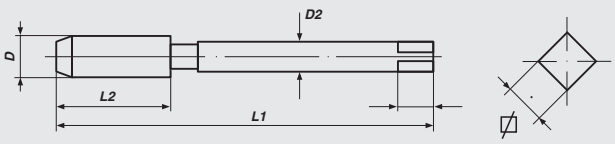
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.
DIN 371					
M 3 x 0.5	56	6	3.5	2.7	33726
M 4 x 0.7	63	7	4.5	3.4	33730
M 5 x 0.8	70	8	6.0	4.9	33734
M 6 x 1.0	80	10	6.0	4.9	33738
M 8 x 1.25	90	14	8.0	6.2	33742
M 10 x 1.5	100	16	10.0	8.0	33746
DIN 376					
M 3 x 0.5	56	6	2.2	—	34726
M 4 x 0.7	63	7	2.8	2.1	34730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

Application:

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

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 盲孔



Machine Taps, *Left Hand*

metric-fine ISO-thread DIN 13

机用丝锥, 左旋

公制细牙ISO螺纹 DIN 13

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

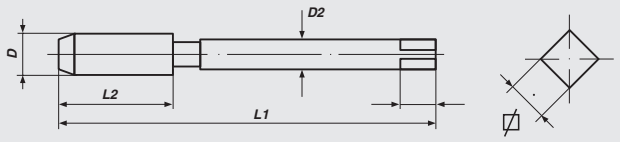
Nominal Diameter D	L 1	L 2	D 2	⌀	Art.-No.
M 3 x 0.35	56	9	2.2	-	34801
M 4 x 0.35	63	10	2.8	2.1	34802
M 4 x 0.5	63	10	2.8	2.1	34803
M 5 x 0.5	70	12	3.5	2.7	34804
M 5 x 0.75	70	12	3.5	2.7	34805
M 6 x 0.5	80	14	4.5	3.4	34806
M 6 x 0.75	80	14	4.5	3.4	34807
M 7 x 0.75	80	14	5.5	4.3	34808
M 8 x 0.5	80	19	6.0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

Application:

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

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔



VÖLKEL
THREADING SOLUTIONS

Machine Taps, *Left Hand*

metric-fine ISO-thread DIN 13

机用丝锥, 左旋

公制细牙ISO螺纹 DIN 13

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

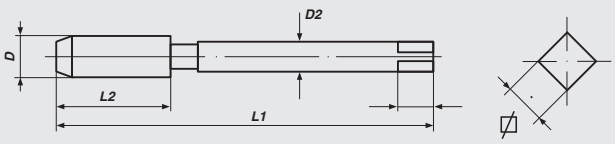
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.
M 20 x 1.0	125	25	16.0	12.0	34838
M 20 x 1.25	125	25	16.0	12.0	34839
M 20 x 1.5	125	25	16.0	12.0	34840
M 20 x 2.0	140	34	16.0	12.0	34841
M 21 x 1.5	125	25	16.0	12.0	34842
M 22 x 1.0	125	25	18.0	14.5	34843
M 22 x 1.25	125	25	18.0	14.5	34844
M 22 x 1.5	125	25	18.0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

Application:

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

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔



Machine Taps, *Left Hand*

metric-fine ISO-thread DIN 13

机用丝锥, 左旋

公制细牙ISO螺纹 DIN 13

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

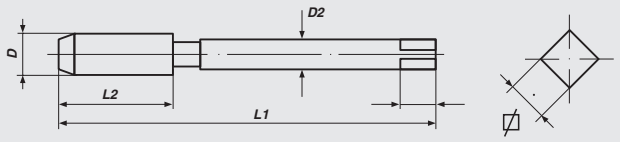
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.
M 34 x 1.5	170	30	28.0	22.0	34870
M 34 x 2.0	170	30	28.0	22.0	34871
M 35 x 1.5	170	30	28.0	22.0	34872
M 36 x 1.5	170	30	28.0	22.0	34873
M 36 x 2.0	170	30	28.0	22.0	34874
M 36 x 3.0	200	56	28.0	22.0	34875
M 38 x 1.5	170	30	28.0	22.0	34876
M 39 x 1.5	170	30	32.0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

Application:

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

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔



VÖLKEL
THREADING SOLUTIONS

Machine Taps, *Left Hand*

metric-fine ISO-thread DIN 13

机用丝锥, 左旋

公制细牙ISO螺纹 DIN 13

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

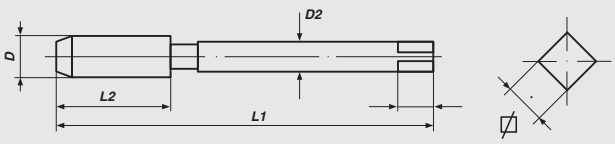
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.
M 3 x 0.35	56	5	2.2	-	34901
M 4 x 0.35	63	5	2.8	2.1	34902
M 4 x 0.5	63	5	2.8	2.1	34903
M 5 x 0.5	70	5	3.5	2.7	34904
M 5 x 0.75	70	8	3.5	2.7	34905
M 6 x 0.5	80	5	4.5	3.4	34906
M 6 x 0.75	80	8	4.5	3.4	34907
M 7 x 0.75	80	8	5.5	4.3	34908
M 8 x 0.5	80	8	6.0	4.9	34909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

Application:

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

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 盲孔



Machine Taps, *Left Hand*

metric-fine ISO-thread DIN 13

机用丝锥, 左旋

公制细牙ISO螺纹 DIN 13

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

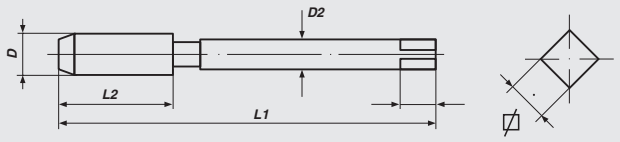
Nominal Diameter D	L 1	L 2	D 2	⌀	Art.-No.
M 20 x 1.0	125	14	16.0	12.0	34938
M 20 x 1.25	125	17	16.0	12.0	34939
M 20 x 1.5	125	17	16.0	12.0	34940
M 20 x 2.0	140	20	16.0	12.0	34941
M 21 x 1.5	125	17	16.0	12.0	34942
M 22 x 1.0	125	14	18.0	14.5	34943
M 22 x 1.25	125	17	18.0	14.5	34944
M 22 x 1.5	125	17	18.0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

Application:

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

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 盲孔



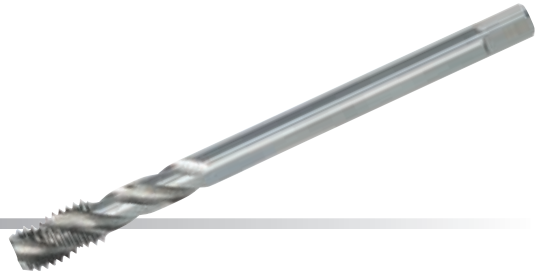
VÖLKEL
THREADING SOLUTIONS

Machine Taps, *Left Hand*

metric-fine ISO-thread DIN 13

机用丝锥, 左旋

公制细牙ISO螺纹 DIN 13



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

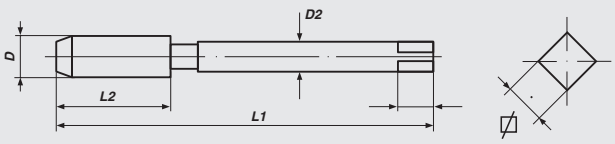
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.
M 34 x 1.5	170	24	28.0	22.0	34970
M 34 x 2.0	170	24	28.0	22.0	34971
M 35 x 1.5	170	24	28.0	22.0	34972
M 36 x 1.5	170	24	28.0	22.0	34973
M 36 x 2.0	170	24	28.0	22.0	34974
M 36 x 3.0	200	30	28.0	22.0	34975
M 38 x 1.5	170	24	28.0	22.0	34976
M 39 x 1.5	170	25	32.0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

Application:

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

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 盲孔



Machine Taps, *Left Hand*

Pipe-thread DIN ISO 228

机用丝锥, 左旋

管螺纹 DIN ISO 228

DIN 5156 Form C HSS-E

G (BSP)

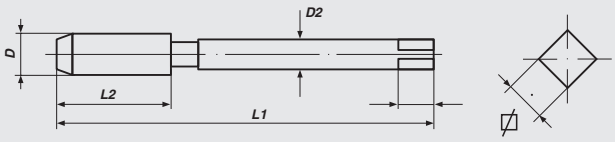
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.
G 1/8 x 28	90	20	7.0	5.5	78202
G 1/4 x 19	100	22	11.0	9.0	78203
G 3/8 x 19	100	22	12.0	9.0	78204
G 1/2 x 14	125	25	16.0	12.0	78205
G 5/8 x 14	125	25	18.0	14.5	78206
G 3/4 x 14	140	28	20.0	16.0	78207
G 1" x 11	160	30	25.0	20.0	78209

Application:

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

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔和盲孔



Combined Machine Tap

metric ISO-thread DIN 13

复合机用丝锥

公制ISO螺纹 DIN 13

HSS-E Tol. ISO2/6H

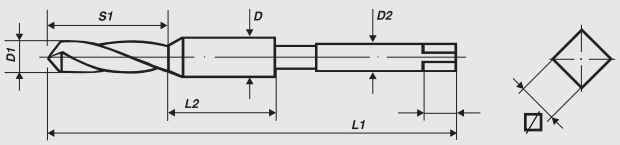
Nominal Diameter D		L 1	S 1	L 2	D 1	D 2	⧄	Art.-No.
M								
M	3 x 0.5	56	16	11	2.5	3.0	2.4	37026
M	4 x 0.7	63	18	14	3.3	4.0	3.0	37030
M	5 x 0.8	71	20	18	4.2	5.0	3.8	37034
M	6 x 1.0	80	22	22	5.0	6.0	4.9	37038
M	8 x 1.25	95	26	25	6.8	8.0	6.2	37042
M	10 x 1.5	106	30	31	8.5	10.0	8.0	37046
M	12 x 1.75	115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

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.

应用:

复合丝锥能够提供给使用者不需要更换工具就可以一次完成钻孔和攻丝。
复合丝锥螺纹的前端是钻头，可以进行最大深度为2 x D的攻丝。
复合丝锥适合使用在中等机械性能的材料上：抗拉强度小于600N/mm²的非合金钢和合金钢、可锻铸铁、球墨铸铁、紫铜、黄铜、铝合金、铝镁合金、锌合金、青铜、电子金属和压铸锌。
建议在具有转速切换开关的机器上使用。
钻孔和攻丝的进给量要适合具体的生产要求。
不能使用带有压力补偿的攻丝夹头。



Machine Nut Taps
metric ISO-thread DIN 13

机用螺母丝锥
公制ISO螺纹 DIN 13

DIN 357 HSS-E Tol. ISO2/6H

M

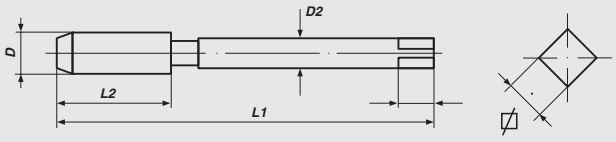
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.
M 3 x 0.5	70	22	2.2	—	37126
M 4 x 0.7	90	25	2.8	2.1	37130
M 5 x 0.8	100	28	3.5	2.7	37134
M 6 x 1.0	110	32	4.5	3.4	37138
M 8 x 1.25	125	40	6.0	4.9	37142
M 10 x 1.5	140	45	7.0	5.5	37146
M 12 x 1.75	180	50	9.0	7.0	37150
M 14 x 2.0	200	56	11.0	9.0	37154
M 16 x 2.0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

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

应用:
– 长细柄可以让螺母通过
– 螺纹深度可达1 x D
– 可以攻难以到达的孔
– 通孔

通用
– 抗拉强度小于800N/mm²的非研磨材料
– 非合金钢和低合金钢



Machine Nut Taps
piloted, trapezoidal thread DIN 103

机用螺母丝锥
带导向, 梯形螺纹 DIN 103

HSS-G Tol. 7H

Tr

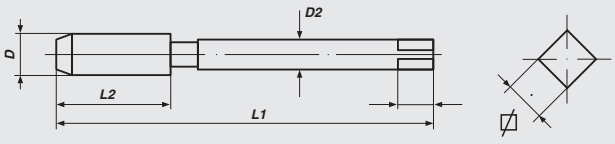
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.
Tr 10 x 2	110	63	7	5.5	79108
Tr 10 x 3	125	75	7	5.5	79112
Tr 12 x 3	165	111	8	6.2	79116
Tr 14 x 3	140	85	10	8.0	79120
Tr 14 x 4	170	112	10	8.0	79124
Tr 16 x 4	180	116	11	9.0	79128
Tr 18 x 4	190	120	12	9.0	79132
Tr 20 x 4	200	124	14	11.0	79136
Tr 22 x 4	210	130	16	12.0	79139
Tr 22 x 5	235	155	16	12.0	79140
Tr 24 x 5	245	160	18	14.5	79144
Tr 26 x 5	255	165	20	16.0	79148
Tr 28 x 5	265	170	22	18.0	79152
Tr 30 x 6	290	185	22	18.0	79156
Tr 32 x 6	300	191	25	20.0	79160
Tr 36 x 6	310	200	28	22.0	79164
LEFT HAND THREAD / 左旋					
Tr 10 x 2	110	63	7	5.5	79108-L
Tr 10 x 3	125	75	7	5.5	79112-L
Tr 12 x 3	165	111	8	6.2	79116-L
Tr 14 x 3	140	85	10	8.0	79120-L
Tr 14 x 4	170	112	10	8.0	79124-L
Tr 16 x 4	180	116	11	9.0	79128-L
Tr 18 x 4	190	120	12	9.0	79132-L
Tr 20 x 4	200	124	14	11.0	79136-L
Tr 22 x 5	235	155	16	12.0	79140-L
Tr 24 x 5	245	160	18	14.5	79144-L
Tr 26 x 5	255	165	20	16.0	79148-L
Tr 28 x 5	265	170	22	18.0	79152-L
Tr 30 x 6	290	185	22	18.0	79156-L
Tr 32 x 6	300	191	25	20.0	79160-L
Tr 36 x 6	310	200	28	22.0	79164-L

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

应用:

通用
– 抗拉强度小于700N/mm²的非研磨材料
– 非合金钢和低合金钢
– 螺纹深度可达1 x D
– 通孔



MACHINE TAPS WITH COLOURED RING
彩圈机用丝锥

	Form B/A/C	39°RSP	TwinBox
for general use 通用	146	147	161
PM for general use 通用	148	149	
for wear resistant steel 耐磨钢	150	151	162
for stainless steel 不锈钢	152	154	163
for cast iron 铸铁	156		
Material from 1200 N/mm² tensile strength 抗拉强度大于1200N/mm²的材料	159		
for aluminium alloys 铝合金		157	
for brass 黄铜	158		

RECOMMENDED APPLICATION OF COLOURED RING MACHINE TAPS
彩圈机用丝锥使用建议

Material **材料**	Lubricant 润滑剂	Cutting Speed 切削速度 m/min.
Steel, unalloyed and low alloyed, short-chipping 非合金钢和低合金钢, 短屑	S/E	10-20
non abrasive Material, short-chipping 非研磨材料, 短屑	S/E	6-15
Steel, heat resistant, long-chipping 耐热钢, 长屑	S	4- 8
Steel, heat resistant, short-chipping 耐热钢, 短屑	S	4- 8
Steel, cementation and heat treatable, short-chipping 渗碳钢、可热处理钢, 短屑	S	4- 8
Steel, Tool Steel up to 1200 N/mm² 工具钢, 抗拉强度小于1200 N/mm²	S	2- 5
Steel, Tool Steel over 1200 N/mm² 工具钢, 抗拉强度大于1200 N/mm²	S	2- 5
Steel stainless, short-chipping 不锈钢, 短屑	S	5-10
Steel stainless, long-chipping 不锈钢, 长屑	S	5-10
Iron, Cast 铸铁	P/T	6-20
Iron, spheroidal graphite 球墨铸铁	P/T	6-20
Iron, Malleable Cast 可锻铸铁	E	6-12
Brass, short-chipping 黄铜, 短屑	E	20-30
Brass, long-chipping 黄铜, 长屑	S/E	10-15
Bronze, short-chipping 青铜, 短屑	S/E	6-15
Bronze, long-chipping 青铜, 长屑	S/E	6-15
Copper 紫铜	S/E	10-15
Aluminium-alloys, short-chipping 铝合金, 短屑	S/E	15-30
Aluminium-alloys, long-chipping 铝合金, 长屑	E	10-20
Zinc Alloys 锌合金	S/E	10-15
Magnesium Alloys 镁合金	E/T	10-20
Titanium, short-chipping 钛合金, 短屑	S	3- 4
Titanium, long-chipping 钛合金, 长屑	S	3- 4
Plastics, thermoplastics 热塑性塑料	E/T	5-15
Plastics, thermosetting 热固性塑料	T	5-15

S = cutting oil / 切削油　　E = oil emulsion / 乳化油　　P = kerosene / 煤油　　T = dry / 干性

RECOMMENDED APPLICATION OF COLOURED RING MACHINE TAPS
彩圈机用丝锥使用建议

Material **材料**	Green Ring 绿圈	Blue Ring 蓝圈	White Ring 白圈	Black Ring 黑圈	Red Ring 红圈	Yellow Ring 黄圈	Orange Ring 橙圈
Steel, unalloyed and low alloyed, short-chipping 非合金钢和低合金钢, 短屑	● PM						
non abrasive Material, short-chipping 非研磨材料, 短屑	● PM						
Steel, heat resistant, long-chipping 耐热钢, 长屑	PM		○				
Steel, heat resistant, short-chipping 耐热钢, 短屑	PM	●					
Steel, cementation and heat treatable, short-chipping 渗碳钢、可热处理钢, 短屑	PM	●					
Steel, Tool Steel up to 1200 N/mm² 工具钢, 抗拉强度小于1200 N/mm²		●					
Steel, Tool Steel over 1200 N/mm² 工具钢, 抗拉强度大于1200 N/mm²					●		
Steel stainless, short-chipping 不锈钢, 短屑	PM	●					
Steel stainless, long-chipping 不锈钢, 长屑	PM		○				
Iron, Cast 铸铁				●			
Iron, spheroidal graphite 球墨铸铁		●					
Iron, Malleable Cast 可锻铸铁	● PM						
Brass, short-chipping 黄铜, 短屑		●		●			●
Brass, long-chipping 黄铜, 长屑	● PM						
Bronze, short-chipping 青铜, 短屑		●		●			
Bronze, long-chipping 青铜, 长屑	● PM						
Copper 紫铜	● PM						
Aluminium-alloys, short-chipping 铝合金, 短屑		●					
Aluminium-alloys, long-chipping 铝合金, 长屑	● PM					●	
Zinc Alloys 锌合金	● PM						
Magnesium Alloys 镁合金	● PM	●					
Titanium, short-chipping 钛合金, 短屑		●					
Titanium, long-chipping 钛合金, 长屑			○				
Plastics, thermoplastics 热塑性塑料	● PM						
Plastics, thermosetting 热固性塑料				●	●		

GREEN RING-Machine Taps

metric ISO-thread DIN 13

绿圈机用丝锥

公制ISO螺纹 DIN 13

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

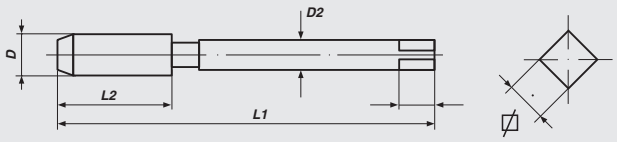
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.
DIN 371					
M 3 x 0.5	56	11	3.5	2.7	35326
M 4 x 0.7	63	13	4.5	3.4	35330
M 5 x 0.8	70	16	6.0	4.9	35334
M 6 x 1.0	80	19	6.0	4.9	35338
M 8 x 1.25	90	22	8.0	6.2	35342
M 10 x 1.5	100	24	10.0	8.0	35346
DIN 376					
M 12 x 1.75	110	29	9.0	7.0	35350
M 14 x 2.0	110	30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

Application:

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

应用:

通用
– 抗拉强度小于1000N/mm²的非研磨材料
– 非合金钢和低合金钢
– 长屑
– 通孔

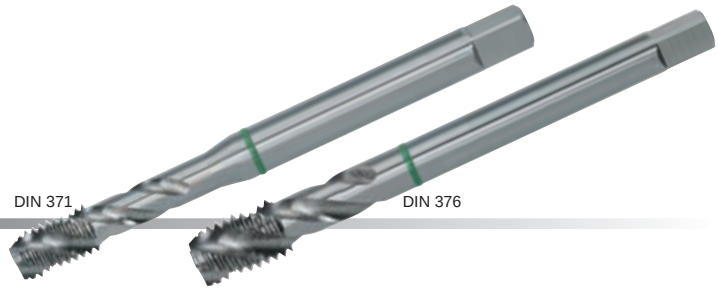


GREEN RING-Machine Taps

metric ISO-thread DIN 13

绿圈机用丝锥

公制ISO螺纹 DIN 13



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

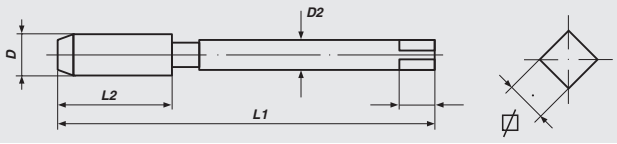
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.
DIN 371					
M 3 x 0.5	56	6	3.5	2.7	36326
M 4 x 0.7	63	7	4.5	3.4	36330
M 5 x 0.8	70	8	6.0	4.9	36334
M 6 x 1.0	80	10	6.0	4.9	36338
M 8 x 1.25	90	14	8.0	6.2	36342
M 10 x 1.5	100	16	10.0	8.0	36346
DIN 376					
M 12 x 1.75	110	18	9.0	7.0	36350
M 14 x 2.0	110	20	11.0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

Application:

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

应用:

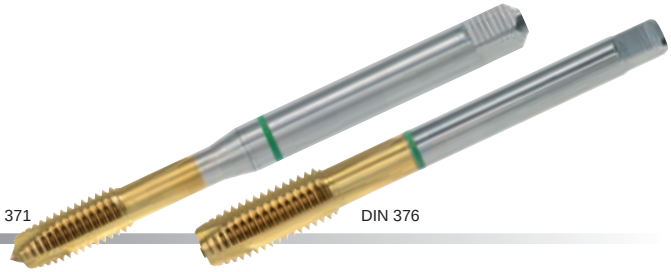
通用
– 抗拉强度小于1000N/mm²的非研磨材料
– 非合金钢和低合金钢
– 长屑
– 盲孔



VÖLKEL
THREADING SOLUTIONS

GREEN RING-Machine Taps
metric ISO-thread DIN 13

绿圈机用丝锥
公制ISO螺纹 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
M 4 x 0.7	63	13	4.5	3.4	30032
M 5 x 0.8	70	14	6.0	4.9	30033
M 6 x 1.0	80	16	6.0	4.9	30034
M 8 x 1.25	90	18	8.0	6.2	30035
M 10 x 1.5	100	22	10.0	8.0	30036
DIN 376					
M 12 x 1.75	110	29	9.0	7.0	30037
M 14 x 2.0	110	30	11.0	9.0	30038
M 16 x 2.0	110	32	12.0	9.0	30039

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

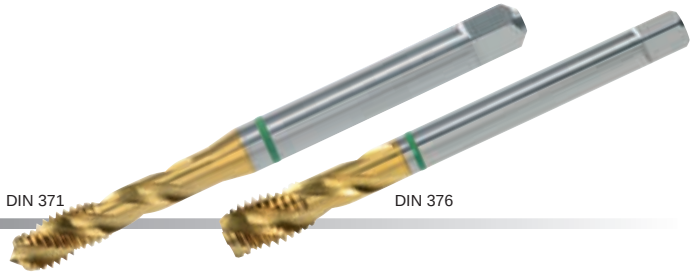
Advantages HSSE-PM-TIN
- increased wear resistance and toughness
- TiN-coating improves anti-friction properties, thereby improved wear-resistance and reduced tendency of build-up edge

应用:
通用
– 抗拉强度小于1000N/mm²的非研磨材料
– 不锈钢和合金钢
– 非合金钢和低合金钢
– 紫铜和铝合金
– 通孔

HSSE-PM-TIN 的优点
– 增加韧性和耐磨性
– TiN涂层减少摩擦、磨损和切屑粘在工具表面

GREEN RING-Machine Taps
metric ISO-thread DIN 13

绿圈机用丝锥
公制ISO螺纹 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
M 4 x 0.7	63	7	4.5	3.4	30132
M 5 x 0.8	70	8	6.0	4.9	30133
M 6 x 1.0	80	10	6.0	4.9	30134
M 8 x 1.25	90	14	8.0	6.2	30135
M 10 x 1.5	100	16	10.0	8.0	30136
DIN 376					
M 12 x 1.75	110	18	9.0	7.0	30137
M 14 x 2.0	110	20	11.0	9.0	30138
M 16 x 2.0	110	22	12.0	9.0	30139

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

应用:
通用
– 抗拉强度小于1000N/mm²的非研磨材料
– 不锈钢和合金钢
– 非合金钢和低合金钢
– 紫铜和铝合金
– 盲孔

HSSE-PM-TIN 的优点
– 增加韧性和耐磨性
– TiN涂层减少摩擦、磨损和切屑粘在工具表面

BLUE RING-Machine Taps

metric ISO-thread DIN 13

蓝圈机用丝锥

公制ISO螺纹 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
M 4 x 0.7	63	13	4.5	3.4	35430
M 5 x 0.8	70	16	6.0	4.9	35434
M 6 x 1.0	80	19	6.0	4.9	35438
M 8 x 1.25	90	22	8.0	6.2	35442
M 10 x 1.5	100	24	10.0	8.0	35446
DIN 376					
M 12 x 1.75	110	29	9.0	7.0	35450
M 14 x 2.0	110	30	11.0	9.0	35454
M 16 x 2.0	110	32	12.0	9.0	35458
M 18 x 2.5	125	34	14.0	11.0	35462
M 20 x 2.5	140	34	16.0	12.0	35466
SET					
M 3 - 12	M 3-4-5-6-8-10 (DIN 371), M 12 (DIN 376)				47854
TiCN					
DIN 371					
M 3 x 0.5	56	11	3.5	2.7	35427
M 4 x 0.7	63	13	4.5	3.4	35431
M 5 x 0.8	70	16	6.0	4.9	35435
M 6 x 1.0	80	19	6.0	4.9	35439
M 8 x 1.25	90	22	8.0	6.2	35443
M 10 x 1.5	100	24	10.0	8.0	35447
DIN 376					
M 12 x 1.75	110	29	9.0	7.0	35451
M 14 x 2.0	110	30	11.0	9.0	35455
M 16 x 2.0	110	32	12.0	9.0	35459
M 18 x 2.5	125	34	14.0	11.0	35463
M 20 x 2.5	140	34	16.0	12.0	35467

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

应用:

抗拉强度小于1200N/mm²
– 高合金钢
– 短屑
– 不锈钢, 短屑
– 合金工具钢
– 通孔

TiCN
– 由于改进了硬度和韧性，具有优秀的耐磨性
– 最佳的冷却减低热阻

BLUE RING-Machine Taps
metric ISO-thread DIN 13

蓝圈机用丝锥
公制ISO螺纹 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
M 4 x 0.7	63	7	4.5	3.4	36430
M 5 x 0.8	70	8	6.0	4.9	36434
M 6 x 1.0	80	10	6.0	4.9	36438
M 8 x 1.25	90	14	8.0	6.2	36442
M 10 x 1.5	100	16	10.0	8.0	36446
DIN 376					
M 12 x 1.75	110	18	9.0	7.0	36450
M 14 x 2.0	110	20	11.0	9.0	36454
M 16 x 2.0	110	22	12.0	9.0	36458
M 18 x 2.5	125	25	14.0	11.0	36462
M 20 x 2.5	140	25	16.0	12.0	36466
SET					
M 3 - 12	M 3-4-5-6-8-10 (DIN 371). M 12 (DIN 376)				47864

TiCN

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

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

应用:

抗拉强度小于1200N/mm²
– 高合金钢
– 短屑
– 不锈钢, 短屑
– 合金工具钢
– 盲孔

TiCN
– 由于改进了硬度和韧性，具有优秀的耐磨性
– 最佳的冷却减低热阻

VÖLKEL
THREADING SOLUTIONS

WHITE RING-Machine Taps
metric ISO-thread DIN 13

白圈机用丝锥
公制ISO螺纹 DIN 13

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

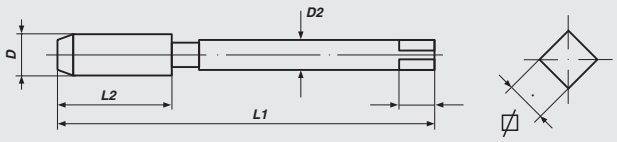
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.
DIN 371					
M 3 x 0.5	56	11	3.5	2.7	35226
M 4 x 0.7	63	13	4.5	3.4	35230
M 5 x 0.8	70	16	6.0	4.9	35234
M 6 x 1.0	80	19	6.0	4.9	35238
M 8 x 1.25	90	22	8.0	6.2	35242
M 10 x 1.5	100	24	10.0	8.0	35246
DIN 376					
M 12 x 1.75	110	29	9.0	7.0	35250
M 14 x 2.0	110	30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

Application:

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

应用:

不锈钢, 长屑
抗拉强度小于1000N/mm²
– 研磨材料
– 铬镍合金
– 表面蒸汽处理
– 通孔



WHITE RING-Machine Taps

白圈机用丝锥

Form B HSS-E

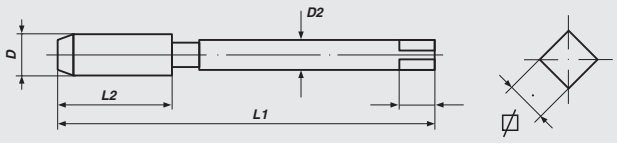
Nominal Diameter D		L 1	L 2	D 2	⧄	Art.-No.
MF		DIN 374				
M	5 x 0.5	70	12	3.5	2.7	35903
M	6 x 0.75	80	14	4.5	3.4	35904
M	8 x 0.75	80	19	6.0	4.9	35906
M	8 x 1.0	90	22	6.0	4.9	35907
M	10 x 1.0	90	20	7.0	5.5	35909
M	10 x 1.25	100	24	7.0	5.5	35910
M	12 x 1.25	100	22	9.0	7.0	35913
M	12 x 1.5	100	22	9.0	7.0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

Application:

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

应用:

不锈钢, 长屑
抗拉强度小于1000N/mm²
– 研磨材料
– 铬镍合金
– 表面蒸汽处理
– 通孔



VÖLKEL
THREADING SOLUTIONS

WHITE RING-Machine Taps
metric ISO-thread DIN 13

白圈机用丝锥
公制ISO螺纹 DIN 13

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

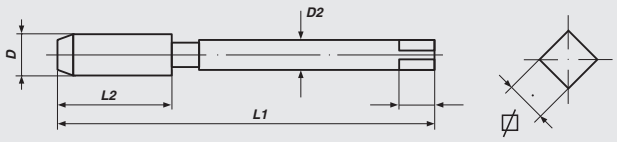
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.
DIN 371					
M 3 x 0.5	56	6	3.5	2.7	36226
M 4 x 0.7	63	7	4.5	3.4	36230
M 5 x 0.8	70	8	6.0	4.9	36234
M 6 x 1.0	80	10	6.0	4.9	36238
M 8 x 1.25	90	14	8.0	6.2	36242
M 10 x 1.5	100	16	10.0	8.0	36246
DIN 376					
M 12 x 1.75	110	18	9.0	7.0	36250
M 14 x 2.0	110	20	11.0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

Application:

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

应用:

不锈钢, 长屑
抗拉强度小于1000N/mm²
– 研磨材料
– 铬镍合金
– 表面蒸汽处理
– 盲孔



WHITE RING-Machine Taps

白圈机用丝锥

Form C/39° RSP HSS-E

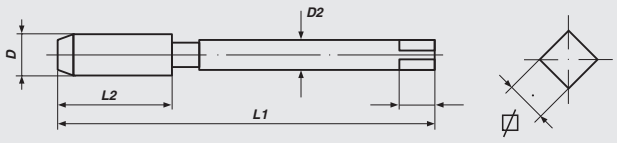
Nominal Diameter D		L 1	L 2	D 2	⧄	Art.-No.
MF	DIN 374					
M	5 x 0.5	70	5	3.5	2.7	36903
M	6 x 0.75	80	8	4.5	3.4	36904
M	8 x 0.75	80	8	6.0	4.9	36906
M	8 x 1.0	90	10	6.0	4.9	36907
M	10 x 1.0	90	10	7.0	5.5	36909
M	10 x 1.25	100	16	7.0	5.5	36910
M	12 x 1.25	100	15	9.0	7.0	36913
M	12 x 1.5	100	15	9.0	7.0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

Application:

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

应用:

不锈钢, 长屑
抗拉强度小于1000N/mm²
– 研磨材料
– 铬镍合金
– 表面蒸汽处理
– 盲孔



BLACK RING-Machine Taps

metric ISO-thread DIN 13

黑圈机用丝锥

公制ISO螺纹 DIN 13

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

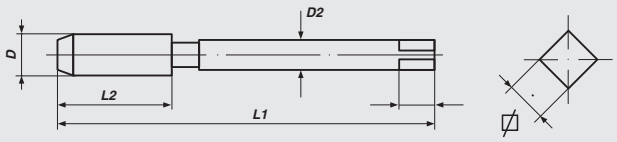
Nominal Diameter D	L 1	L 2	D 2	⊠	Art.-No.
DIN 371					
M 3 x 0.5	56	11	3.5	2.7	35126
M 4 x 0.7	63	13	4.5	3.4	35130
M 5 x 0.8	70	16	6.0	4.9	35134
M 6 x 1.0	80	19	6.0	4.9	35138
M 8 x 1.25	90	22	8.0	6.2	35142
M 10 x 1.5	100	24	10.0	8.0	35146
DIN 376					
M 12 x 1.75	110	29	9.0	7.0	35150
M 14 x 2.0	110	30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

Application:

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

应用:

铸铁
球墨铸铁
– 镁合金
– 表面氮化处理
– 通孔和盲孔



YELLOW RING-Machine Taps
metric ISO-thread DIN 13

黄圈机用丝锥
公制ISO螺纹 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
M 4 x 0.7	63	7	4.5	3.4	36530
M 5 x 0.8	70	8	6.0	4.9	36534
M 6 x 1.0	80	10	6.0	4.9	36538
M 8 x 1.25	90	14	8.0	6.2	36542
M 10 x 1.5	100	16	10.0	8.0	36546
DIN 376					
M 12 x 1.75	110	18	9.0	7.0	36550
M 14 x 2.0	110	20	11.0	9.0	36554
M 16 x 2.0	110	22	12.0	9.0	36558
SET					
M 3 - 12	M 3-4-5-6-8-10 (DIN 371), M 12 (DIN 376)				47860

Application:

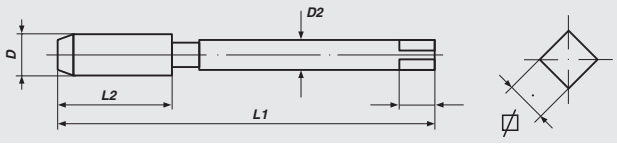
Aluminium-alloys, long chipping

- for blind holes
- with 2 flutes

应用:

铝合金, 长屑

– 盲孔
– 两槽



VÖLKEL
THREADING SOLUTIONS

ORANGE RING-Machine Taps
metric ISO-thread DIN 13

橙圈机用丝锥
公制ISO螺纹 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
M 4 x 0.7	63	13	4.5	3.4	35730
M 5 x 0.8	70	16	6.0	4.9	35734
M 6 x 1.0	80	19	6.0	4.9	35738
M 8 x 1.25	90	22	8.0	6.2	35742
M 10 x 1.5	100	24	10.0	8.0	35746
DIN 376					
M 12 x 1.75	110	29	9.0	7.0	35750
M 14 x 2.0	110	30	11.0	9.0	35754
M 16 x 2.0	110	32	12.0	9.0	35758
SET					
M 3 - 12	M 3-4-5-6-8-10 (DIN 371), M 12 (DIN 376)				47850

Application:

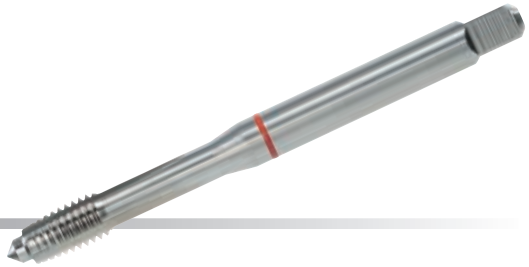
Ms
Brass, short chipping
- for through and blind holes

应用:

Ms
黄铜, 短屑
– 通孔和盲孔

RED RING-Machine Taps
metric ISO-thread DIN 13

红圈机用丝锥
公制ISO螺纹 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
M 5 x 0.8	70	11	6.0	4.9	36134
M 6 x 1.0	80	13	6.0	4.9	36138
M 8 x 1.25	90	15	8.0	6.2	36142
M 10 x 1.5	100	16	10.0	8.0	36146

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.

应用:

抗拉强度大于1200N/m㎡的材料, 短屑
通孔和盲孔

槽形经过特别设计, 适用于特别难加工的材料。
特别短的铲梢, 加工更容易。

TWINBOX
Machine Tap + Twist Drill
机用丝锥 + 钻头

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.

根据应用选择合适的机用丝锥可以达到最佳的效果。
套装包括了彩圈机用丝锥和对应尺寸的钻头，可以达到高效和最佳效果。
根据应用使用合适的机用丝锥和钻头，可以提高螺纹的质量和降低费用。

93 + 163 - 165

GREEN RING TwinBox

Machine Tap + Twist Drill
metric ISO-thread DIN 13

绿圈机用丝锥套装

机用丝锥 + 钻头
公制ISO螺纹 DIN 13

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

Nominal Diameter D			Art.-No.
Form B, Spiral Point / 螺尖			
M 3 x 0.5	DIN 371	2.5 mm	35390
M 4 x 0.7	DIN 371	3.3 mm	35391
M 5 x 0.8	DIN 371	4.2 mm	35392
M 6 x 1.0	DIN 371	5.0 mm	35393
M 8 x 1.25	DIN 371	6.8 mm	35394
M 10 x 1.5	DIN 371	8.5 mm	35395
M 12 x 1.75	DIN 376	10.2 mm	35396
M 14 x 2.0	DIN 376	12.0 mm	35397
M 16 x 2.0	DIN 376	14.0 mm	35398
Form C, Spiral Flute / 螺旋槽			
M 3 x 0.5	DIN 371	2.5 mm	36390
M 4 x 0.7	DIN 371	3.3 mm	36391
M 5 x 0.8	DIN 371	4.2 mm	36392
M 6 x 1.0	DIN 371	5.0 mm	36393
M 8 x 1.25	DIN 371	6.8 mm	36394
M 10 x 1.5	DIN 371	8.5 mm	36395
M 12 x 1.75	DIN 376	10.2 mm	36396
M 14 x 2.0	DIN 376	12.0 mm	36397
M 16 x 2.0	DIN 376	14.0 mm	36398

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°

应用:

通用
– 抗拉强度小于1000N/mm²的非研磨材料
– 非合金钢和低合金钢
– 可锻铸铁和锌合金

螺尖用于通孔
螺旋槽用于盲孔

HSS–CO钻头, DIN338
N型右旋, 118° , 螺旋角: 25–30°

VÖLKEL
THREADING SOLUTIONS

BLUE RING TwinBox

Machine Tap + Twist Drill
metric ISO-thread DIN 13

蓝圈机用丝锥套装

机用丝锥 + 钻头
公制ISO螺纹 DIN 13

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

Nominal Diameter D				Art.-No.
Form B, Spiral Point / 螺尖				
M	3 x 0.5	DIN 371	2.5 mm	35490
M	4 x 0.7	DIN 371	3.3 mm	35491
M	5 x 0.8	DIN 371	4.2 mm	35492
M	6 x 1.0	DIN 371	5.0 mm	35493
M	8 x 1.25	DIN 371	6.8 mm	35494
M	10 x 1.5	DIN 371	8.5 mm	35495
M	12 x 1.75	DIN 376	10.2 mm	35496
M	14 x 2.0	DIN 376	12.0 mm	35497
M	16 x 2.0	DIN 376	14.0 mm	35498
Form C, Spiral Flute / 螺旋槽				
M	3 x 0.5	DIN 371	2.5 mm	36490
M	4 x 0.7	DIN 371	3.3 mm	36491
M	5 x 0.8	DIN 371	4.2 mm	36492
M	6 x 1.0	DIN 371	5.0 mm	36493
M	8 x 1.25	DIN 371	6.8 mm	36494
M	10 x 1.5	DIN 371	8.5 mm	36495
M	12 x 1.75	DIN 376	10.2 mm	36496
M	14 x 2.0	DIN 376	12.0 mm	36497
M	16 x 2.0	DIN 376	14.0 mm	36498

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

应用:

抗拉强度小于1200N/mm²
– 高合金钢
– 短屑
– 不锈钢, 短屑
– 合金工具钢

螺尖用于通孔
螺旋槽用于盲孔

HSS–CO钻头, DIN338
C型右旋, 130° 双后角, 螺旋角: 25–30°

WHITE RING TwinBox

Machine Tap + Twist Drill
metric ISO-thread DIN 13

白圈机用丝锥套装

机用丝锥 + 钻头
公制ISO螺纹 DIN 13

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

Nominal Diameter D				Art.-No.
Form B, Spiral Point / 螺尖				
M	3 x 0.5	DIN 371	2.5 mm	35290
M	4 x 0.7	DIN 371	3.3 mm	35291
M	5 x 0.8	DIN 371	4.2 mm	35292
M	6 x 1.0	DIN 371	5.0 mm	35293
M	8 x 1.25	DIN 371	6.8 mm	35294
M	10 x 1.5	DIN 371	8.5 mm	35295
M	12 x 1.75	DIN 376	10.2 mm	35296
M	14 x 2.0	DIN 376	12.0 mm	35297
M	16 x 2.0	DIN 376	14.0 mm	35298
Form C, Spiral Flute / 螺旋槽				
M	3 x 0.5	DIN 371	2.5 mm	36290
M	4 x 0.7	DIN 371	3.3 mm	36291
M	5 x 0.8	DIN 371	4.2 mm	36292
M	6 x 1.0	DIN 371	5.0 mm	36293
M	8 x 1.25	DIN 371	6.8 mm	36294
M	10 x 1.5	DIN 371	8.5 mm	36295
M	12 x 1.75	DIN 376	10.2 mm	36296
M	14 x 2.0	DIN 376	12.0 mm	36297
M	16 x 2.0	DIN 376	14.0 mm	36298

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

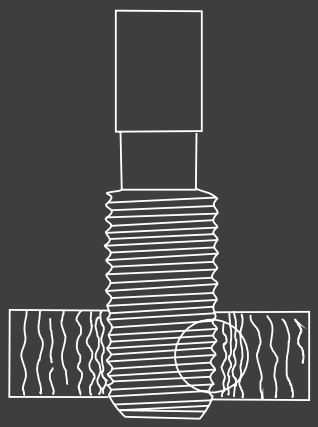
HSS-CO Twist Drills DIN 338
Form C right, 130° - Spiral: 25-30°
with Split Point

应用:

不锈钢, 长屑,
抗拉强度小于1000N/mm²
– 耐热钢, 长屑
– 研磨材料
– 表面蒸汽处理
螺尖用于通孔
螺旋槽用于盲孔

HSS–CO钻头, DIN338
C型右旋, 130° 双后角, 螺旋角: 25–30°

FLUTELESS MACHINE TAPS
挤压丝锥

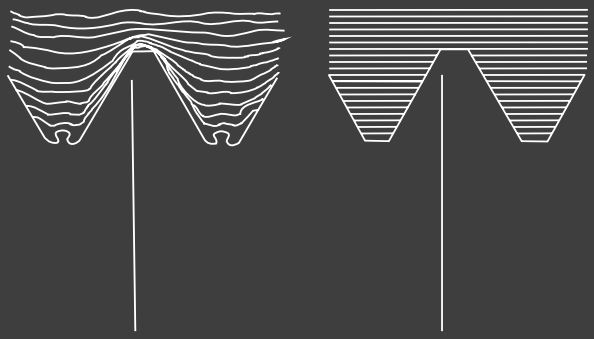


Application:

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

应用:

– 非合金钢和低合金钢
– 结构钢
– 耐热钢
– 不锈钢
– 有色金属，长屑
– 锌合金
– 通孔和盲孔



Fibre structure
of thread forming
挤压丝锥攻丝后的组织结构

Fibre structure
of thread cutting
切削丝锥攻丝后的组织结构

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

优点:

✓ 比切削丝锥更耐用
✓ 更高的切削速度
✓ 尺寸和轮廓稳定精确
✓ 挤压而成的螺纹具有高稳定性
✓ 不易折断
✓ 不用排屑, 没有切屑干扰

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.

挤压丝锥是使用挤压形成内螺纹，不需要切削。
螺纹由形变产生，不会破坏材料的组织结构。

FLUTELESS MACHINE TAPS
挤压丝锥

	blank 白身	VAP	TIN
6H ISO2	167	168	169
6G ISO3	170		

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

应用:

白身:
用于有良好延展性的有色金属

VAP(蒸汽处理):
– 用于抗拉强度小于700N/mm²的钢材

TIN(氮化钛涂层):
– 用于抗拉强度小于900N/mm²的钢材
提高耐磨度和切削速度

RECOMMENDED APPLICATION OF FLUTELESS MACHINE TAPS
挤压丝锥使用建议

Material 材料	bright 白身	VAP	TIN
unalloyed and low alloyed Steel 非合金钢和低合金钢			x
heat resistant Steel 耐热钢			x
Stainless Steel 不锈钢		x	x
Constructional Steel 结构钢		x	x
Brass, long-chipping 黄铜, 长屑	x		
Bronzes, long-chipping 青铜, 长屑	x		
Copper 紫铜	x		
Al-alloys, long-chipping 铝合金, 长屑	x		
Zinc Alloyes 锌合金	x		

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

油槽:
螺纹深度超过1.5 x D时, 使用带油槽的挤压丝锥可充分润滑。

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

润滑:
好的润滑对挤压螺纹非常重要。
使用石墨润滑/润滑油或增加合适的添加剂。

RECOMMENDED CORE HOLE DIAMETER
建议底孔直径

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

挤压丝锥

公制ISO螺纹 DIN 13

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

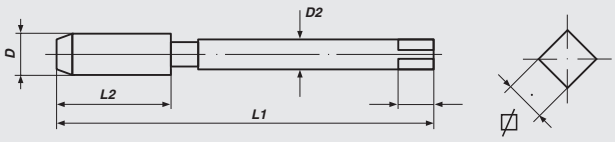
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.
without Oil Groove / 无油槽					
DIN 371					
M 1 x 0.25	40	5	2.5	2.1	35500
M 1.1 x 0.25	40	5	2.5	2.1	35501
M 1.2 x 0.25	40	5	2.5	2.1	35502
M 1.4 x 0.3	40	7	2.5	2.1	35503
M 1.6 x 0.35	40	8	2.5	2.1	35504
M 1.7 x 0.35	40	8	2.5	2.1	35505
M 1.8 x 0.35	40	8	2.5	2.1	35506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

Application:

bright:
- for nonferrous metal of good ductility

应用:

白身:
– 用于有良好延展性的有色金属



Fluteless Machine Taps
metric ISO-thread DIN 13

挤压丝锥
公制ISO螺纹 DIN 13

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

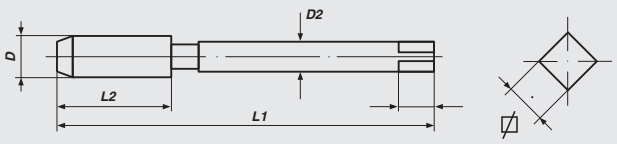
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.
without Oil Groove / 无油槽					
DIN 371					
M 3 x 0.5	56	11	3.5	2.7	35550
M 4 x 0.7	63	13	4.5	3.4	35552
M 5 x 0.8	70	16	6.0	4.9	35553
M 6 x 1.0	80	19	6.0	4.9	35554
M 8 x 1.25	90	22	8.0	6.2	35555
M 10 x 1.5	100	24	10.0	8.0	35556
DIN 376					
M 12 x 1.75	110	29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

Application:

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

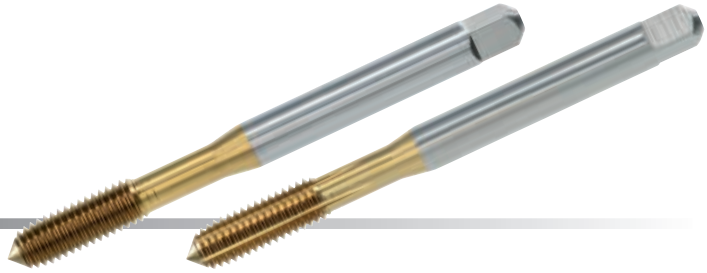
应用:

VAP(蒸汽处理):
– 用于抗拉强度小于700N/mm²的钢材



Fluteless Machine Taps
metric ISO-thread DIN 13

挤压丝锥, 带油槽
公制ISO螺纹 DIN 13



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

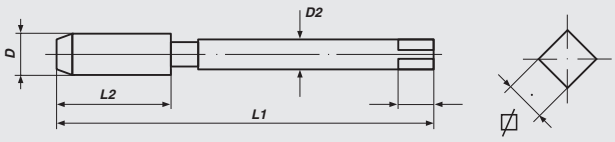
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.
without Oil Groove / 无油槽					
DIN 371					
M 1 x 0.25	40	5	2.5	2.1	35520
M 1.1 x 0.25	40	5	2.5	2.1	35521
M 1.2 x 0.25	40	5	2.5	2.1	35522
M 1.4 x 0.3	40	7	2.5	2.1	35523
M 1.6 x 0.35	40	8	2.5	2.1	35524
M 1.7 x 0.35	40	8	2.5	2.1	35525
M 1.8 x 0.35	40	8	2.5	2.1	35526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

Application:

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

应用:

TIN(氮化钛涂层)
– 用于抗拉强度小于900N/mm²的钢材
提高耐磨度和切削速度



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

metric ISO-thread DIN 13

挤压丝锥， 中径加大

公制ISO螺纹 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 / 无油槽					
DIN 371					
M 3 x 0.5	56	11	3.5	2.7	35510-6G
M 4 x 0.7	63	13	4.5	3.4	35512-6G
M 5 x 0.8	70	16	6.0	4.9	35513-6G
M 6 x 1.0	80	19	6.0	4.9	35514-6G
M 8 x 1.25	90	22	8.0	6.2	35515-6G
M 10 x 1.5	100	24	10.0	8.0	35516-6G
DIN 376					
M 12 x 1.75	110	29	9.0	7.0	35517-6G
with Oil Groove / 带油槽					
DIN 371					
M 3 x 0.5	56	11	3.5	2.7	35610-6G
M 4 x 0.7	63	13	4.5	3.4	35612-6G
M 5 x 0.8	70	16	6.0	4.9	35613-6G
M 6 x 1.0	80	19	6.0	4.9	35614-6G
M 8 x 1.25	90	22	8.0	6.2	35615-6G
M 10 x 1.5	100	24	10.0	8.0	35616-6G
DIN 376					
M 12 x 1.75	110	29	9.0	7.0	35617-6G

Application:

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

应用：

公差 ISO 3 (6G) =
加大0.02 – 0.4mm
电镀前板材

ISO TAPS
ISO丝锥

	Straight Flute 直槽	Spiral Point 螺尖	Spiral Flute 螺旋槽	Left Hand 左旋
Metric	172	173	174	200
Metric - Long Shank	175			
Metric Fine	176	179		
UNC	180	181	181	201
UNF	182	183	183	201
8-UN / 12-UN	184	185	186	
UNEF	187	188	189	
UNS / UN		190		
BSW	191	192	193	202
BSF	194	195	195	
BA	196			
G (BSPF)	197	198	198	
BSPT	199			
NPT	199			

Taps - Straight Flute

Metric ISO-thread DIN 13

直槽丝锥

公制ISO螺纹 DIN 13

ISO 529 HSS-G Tol. ISO2/6H

M

Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.
M 1.6 x 0.35	41	8	2.5	2.0	80410
M 2 x 0.4	41	8	2.5	2.0	80416
M 2.2 x 0.45	44.5	9.5	2.8	2.24	80418
M 2.5 x 0.45	44.5	9.5	2.8	2.24	80422
M 3 x 0.5	48	11	3.15	2.5	80426
M 3.5 x 0.6	50	13	3.55	2.8	80428
M 4 x 0.7	53	13	4.0	3.15	80430
M 4.5 x 0.75	53	13	4.5	3.55	80432
M 5 x 0.8	58	16	5.0	4.0	80434
M 6 x 1.0	66	19	6.3	5.0	80438
M 7 x 1.0	66	19	7.1	5.6	80440
M 8 x 1.25	72	22	8.0	6.3	80442
M 9 x 1.25	72	22	9.0	7.1	80444
M 10 x 1.5	80	24	10.0	8.0	80446
M 11 x 1.5	85	25	8.0	6.3	80448
M 12 x 1.75	89	29	9.0	7.1	80450
M 14 x 2.0	95	30	11.2	9.0	80454
M 16 x 2.0	102	32	12.5	10.0	80458
M 18 x 2.5	110	37	14.0	11.2	80462
M 20 x 2.5	112	37	14.0	11.2	80466
M 22 x 2.5	118	38	16.0	12.5	80470
M 24 x 3.0	130	45	18.0	14.0	80474
M 27 x 3.0	135	45	20.0	16.0	80476
M 30 x 3.5	138	48	20.0	16.0	80478
M 33 x 3.5	151	51	22.4	18.0	80480
M 36 x 4.0	162	57	25.0	20.0	80482
M 39 x 4.0	170	60	28.0	22.4	80484
M 42 x 4.5	170	60	28.0	22.4	80486
M 45 x 4.5	187	67	31.5	25.0	80488
M 48 x 5.0	187	67	31.5	25.0	80490
M 52 x 5.0	200	70	35.5	28.0	80492
M 56 x 5.5	200	70	35.5	28.0	80494
M 60 x 5.5	221	76	40.0	31.5	80496
M 64 x 6.0	224	79	40.0	31.5	80498
M 68 x 6.0	234	79	45.0	35.5	80499

Application:

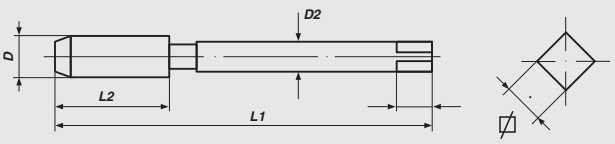
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand and machine

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔和盲孔
– 手用和机用

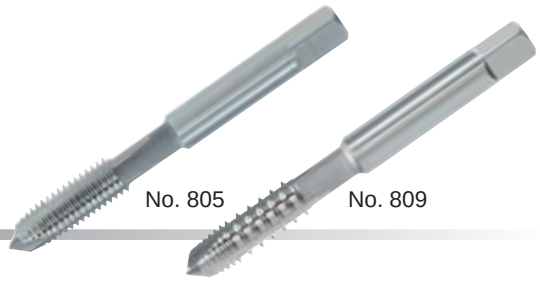
How to order/如何订货:

M3 Set = 80426
M3 Taper = 80426-1
M3 Second = 80426-2
M3 Plug = 80426-3



Machine Taps
metric ISO-thread DIN 13

机用丝锥
公制ISO螺纹 DIN 13



ISO 529 Spiral Point HSS-G Tol. ISO2/6H

M

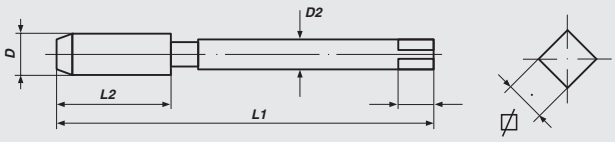
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.
M 2 x 0.4	41.0	8.0	2.50	2.00	80516
M 2.5 x 0.45	44.5	9.5	2.80	2.24	80522
M 2.6 x 0.45	44.5	9.5	2.90	2.24	80524
M 3 x 0.5	48.0	11.0	3.15	2.50	80526
M 3.5 x 0.6	50.0	13.0	3.55	2.80	80528
M 4 x 0.7	53.0	13.0	4.00	3.15	80530
M 5 x 0.8	58.0	16.0	5.00	4.00	80534
M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

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

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔
– 手用和机用



VÖLKEL THREADING SOLUTIONS

Machine Taps
metric ISO-thread DIN 13

机用丝锥
公制ISO螺纹 DIN 13

ISO 529 Spiral Flute 35° HSS-G Tol. ISO2/6H

M

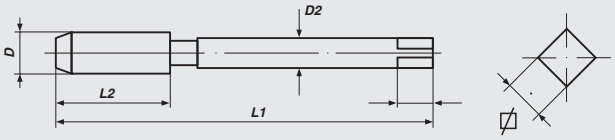
Nominal Diameter D	L 1	L 2	D 2	⊡	Art.-No.
M 2.5 x 0.45	44.5	9.5	2.80	2.24	80722
M 2.6 x 0.45	44.5	9.5	2.90	2.24	80724
M 3 x 0.5	48.0	11.0	3.15	2.50	80726
M 4 x 0.7	53.0	13.0	4.00	3.15	80730
M 5 x 0.8	58.0	16.0	5.00	4.00	80734
M 6 x 1.0	66.0	19.0	6.30	5.00	80738
M 8 x 1.25	72.0	22.0	8.00	6.30	80742
M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

Application:

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

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 盲孔
– 手用和机用



Taps - Straight Flute - *Long Shank*

metric ISO-thread DIN 13

直槽丝锥 – 长柄

公制ISO螺纹 DIN 13

ISO 2283 **HSS-G** **Tol. ISO2/6H** **M**

Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.
M 3.5 x 0.6	73	13	3.15	2.5	80104
M 4 x 0.7	73	13	3.15	2.5	80105
M 5 x 0.8	79	16	4.0	3.15	80106
M 6 x 1.0	89	19	4.5	3.55	80107
M 8 x 1.25	97	22	6.3	5.0	80108
M 10 x 1.5	108	24	8.0	6.3	80109
M 12 x 1.75	119	29	9.0	7.1	80110

Application:

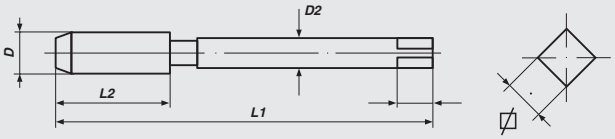
Straight Flute
- non abrasive material up to 900N/mm²
- for through and blind holes

应用:

直槽
– 抗拉强度小于900N/mm²的非研磨材料
– 通孔和盲孔

How to order / 如何订货:

M4 Set	=	80105
M4 Taper	=	80105-1
M4 Second	=	80105-2
M4 Plug	=	80105-3



VÖLKEL THREADING SOLUTIONS

Taps - Straight Flute

Metric Fine ISO-thread DIN 13

直槽丝锥

公制细牙ISO螺纹 DIN 13

ISO 529 **HSS-G** **Tol. ISO2/6H** **Mf**

Nominal Diameter D		L 1	L 2	D 2	⧄	Art.-No.
M	3 x 0.35	48	11	3.15	2.5	81401
M	3.5 x 0.50	53	13	3.15	2.5	81402
M	4 x 0.50	53	13	4.0	3.15	81403
M	4.5 x 0.50	53	13	4.0	3.15	81404
M	5 x 0.50	58	16	5.0	4.0	81405
M	6 x 0.50	66	16	6.3	5.0	81406
M	6 x 0.75	66	19	6.3	5.0	81407
M	7 x 0.50	66	19	6.3	5.0	81408
M	7 x 0.75	66	19	7.1	5.6	81409
M	7 x 1.25	66	19	7.1	5.6	81410
M	7.5 x 0.75	66	19	7.1	5.6	81411
M	8 x 0.75	69	19	8.0	6.3	81412
M	8 x 1.0	69	19	8.0	6.3	81413
M	9 x 0.50	76	20	10.0	8.0	81414
M	9 x 0.75	76	20	10.0	8.0	81415
M	9 x 1.0	76	20	10.0	8.0	81416
M	10 x 0.75	76	20	10.0	8.0	81417
M	10 x 1.0	76	20	10.0	8.0	81418
M	10 x 1.25	76	20	10.0	8.0	81419
M	11 x 1.0	77	17	8.0	6.3	81420
M	11 x 1.25	77	17	8.0	6.3	81421
M	12 x 0.50	75	15	9.0	7.1	81422
M	12 x 1.0	84	24	9.0	7.1	81423
M	12 x 1.25	84	24	9.0	7.1	81424
M	12 x 1.5	89	29	9.0	7.1	81425
M	13 x 1.0	89	29	11.2	7.1	81426
M	13 x 1.50	89	29	11.2	7.1	81427
M	13 x 1.75	89	29	11.2	7.1	81428
M	14 x 1.0	90	25	11.2	9.0	81429
M	14 x 1.25	90	25	11.2	9.0	81430
M	14 x 1.5	95	30	12.5	9.0	81431
M	14 x 1.75	95	30	12.5	9.0	81432
M	15 x 1.0	95	30	12.5	9.0	81433
M	15 x 1.50	95	30	12.5	9.0	81434
M	15 x 1.75	95	30	12.5	9.0	81435
M	16 x 1.0	95	25	12.5	10.0	81436
M	16 x 1.25	102	32	12.5	10.0	81437
M	16 x 1.5	102	32	14.0	10.0	81438
M	16 x 1.75	102	32	14.0	10.0	81439

Application:

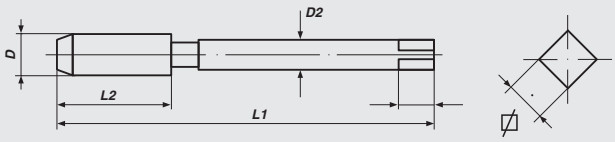
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand and machine

How to order/如何订货:

M3 x 0,35 Set	=	81401
M3 x 0,35 Taper	=	81401-1
M3 x 0,35 Second	=	81401-2
M3 x 0,35 Plug	=	81401-3

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔和盲孔
– 手用和机用



Taps - Straight Flute

Metric Fine ISO-thread DIN 13

直槽丝锥

公制细牙ISO螺纹 DIN 13

ISO 529 HSS-G Tol. ISO2/6H

Mf

Nominal Diameter D		L 1	L 2	D 2	⧄	Art.-No.
M	18 x 1.0	104	29	14.0	11.2	81440
M	18 x 1.25	104	29	14.0	11.2	81441
M	18 x 1.5	104	29	14.0	11.2	81442
M	18 x 2.0	112	37	14.0	11.2	81443
M	20 x 1.0	104	29	14.0	11.2	81444
M	20 x 1.25	104	29	14.0	11.2	81445
M	20 x 1.50	104	29	14.0	11.2	81446
M	20 x 2.0	112	37	14.0	11.2	81447
M	22 x 1.0	113	33	16.0	12.5	81448
M	22 x 1.25	113	33	16.0	12.5	81449
M	22 x 1.5	113	33	16.0	12.5	81450
M	22 x 2.0	113	33	16.0	12.5	81451
M	24 x 1.0	120	35	18.0	14.0	81452
M	24 x 1.25	120	35	18.0	14.0	81453
M	24 x 1.5	120	35	18.0	14.0	81454
M	24 x 2.0	120	35	18.0	14.0	81455
M	25 x 1.0	120	35	18.0	14.0	81456
M	25 x 1.5	120	35	18.0	14.0	81457
M	26 x 1.0	120	35	18.0	14.0	81458
M	26 x 1.5	120	35	18.0	14.0	81459
M	27 x 1.5	127	37	20.0	16.0	81460
M	27 x 2.0	127	37	20.0	16.0	81461
M	28 x 1.5	127	37	20.0	16.0	81462
M	30 x 1.5	127	37	20.0	16.0	81463
M	30 x 2.0	127	37	20.0	16.0	81464
M	30 x 3.0	127	37	20.0	16.0	81465
M	32 x 1.5	137	37	22.4	18.0	81466
M	32 x 2.0	137	37	22.4	18.0	81467
M	33 x 1.5	137	37	22.4	18.0	81468
M	33 x 2.0	137	37	22.4	18.0	81469
M	33 x 3.0	137	37	22.4	18.0	81470
M	35 x 1.5	144	39	25.0	20.0	81471
M	36 x 1.5	144	39	25.0	20.0	81472
M	36 x 2.0	144	39	25.0	20.0	81473
M	36 x 3.0	144	39	25.0	20.0	81474

Application:

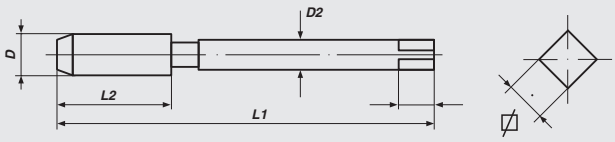
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand and machine

How to order/如何订货:

M3 x 0,35 Set	=	81401
M3 x 0,35 Taper	=	81401-1
M3 x 0,35 Second	=	81401-2
M3 x 0,35 Plug	=	81401-3

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔和盲孔
– 手用和机用



Taps - Straight Flute

Metric Fine ISO-thread DIN 13

直槽丝锥

公制细牙ISO螺纹 DIN 13

ISO 529 **HSS-G** **Tol. ISO2/6H** **Mf**

Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.
M 39 x 1.5	149	39	28.0	22.4	81475
M 39 x 2.0	149	39	28.0	22.4	81476
M 39 x 3.0	149	39	28.0	22.4	81477
M 40 x 1.5	149	39	28.0	22.4	81478
M 42 x 1.5	149	39	28.0	22.4	81479
M 42 x 2.0	149	39	28.0	22.4	81480
M 42 x 3.0	149	39	28.0	22.4	81481
M 45 x 3.0	187	67	31.5	25.0	81482
M 48 x 1.5	165	45	31.5	25.0	81483
M 48 x 2.0	165	45	31.5	25.0	81484
M 48 x 3.0	187	67	31.5	25.0	81485
M 50 x 1.5	165	45	31.5	25.0	81486
M 50 x 2.0	165	45	31.5	25.0	81487
M 50 x 3.0	187	67	31.5	25.0	81488
M 52 x 1.5	165	45	31.5	25.0	81489
M 52 x 2.0	165	45	31.5	25.0	81490
M 52 x 3.0	200	70	35.5	28.0	81491
M 60 x 1.50	165	45	31.5	25.0	81492

Application:

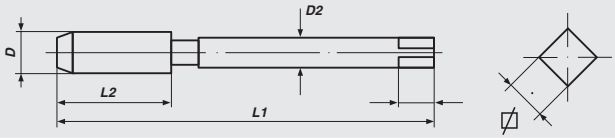
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand and machine

How to order/如何订货:

M3 x 0,35 Set	=	81401
M3 x 0,35 Taper	=	81401-1
M3 x 0,35 Second	=	81401-2
M3 x 0,35 Plug	=	81401-3

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔和盲孔
– 手用和机用



Machine Taps
Metric Fine ISO-thread DIN 13

机用丝锥
公制细牙ISO螺纹 DIN 13

ISO 529 Spiral Point HSS-G Tol. ISO2/6H

Mf

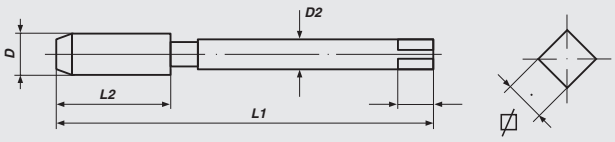
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.
M 3 x 0.35	48	11	3.15	2.5	81501
M 4 x 0.5	53	13	4.0	3.15	81503
M 5 x 0.5	58	16	5.0	4.0	81505
M 6 x 0.75	66	19	6.3	5.0	81507
M 8 x 1.0	69	19	8.0	6.3	81513
M 10 x 1.0	76	20	10.0	8.0	81518
M 10 x 1.25	76	20	10.0	8.0	81519
M 12 x 1.0	84	24	9.0	7.1	81523
M 12 x 1.25	84	24	9.0	7.1	81524
M 12 x 1.5	89	29	9.0	7.1	81525

Application:

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

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔



VÖLKEL
THREADING SOLUTIONS

Taps - Straight Flute

Unified Coarse thread ANSI B 1.1

直槽丝锥

统一制粗牙螺纹 ANSI B 1.1

ISO 529 HSS-G Tol. 2B

UNC

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

Application:

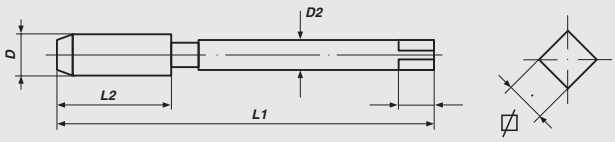
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand and machine

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔和盲孔
– 手用和机用

How to order/如何订货:

1/4 UNC Set	=	82414
1/4 UNC Taper	=	82414-1
1/4 UNC Second	=	82414-2
1/4 UNC Plug	=	82414-3



Machine Taps
Unified Coarse thread ANSI B 1.1

机用丝锥
统一制粗牙螺纹 ANSI B 1.1

ISO 529 HSS-G Tol. 2B

UNC

Nominal Diameter D	L 1	L 2	D 2	⌀	Art.-No.
Spiral Point / 螺尖					
UNC 10 x 24	58	16	5.0	4.0	82510
UNC 1/4 x 20	66	19	6.3	5.0	82514
UNC 5/16 x 18	72	22	8.0	6.3	82516
UNC 3/8 x 16	80	24	10.0	8.0	82518
UNC 7/16 x 14	85	25	8.0	6.3	82520
UNC 1/2 x 13	89	29	9.0	7.1	82522
UNC 9/16 x 12	95	30	11.2	9.0	82524
UNC 5/8 x 11	102	32	12.5	10.0	82526
UNC 3/4 x 10	112	37	14.0	11.2	82530
UNC 7/8 x 9	118	38	18.0	12.5	82534
UNC 1" x 8	130	45	16.0	14.0	82538
UNC 1.1/8 x 7	138	48	20.0	16.0	82540
UNC 1.1/4 x 7	151	51	22.4	18.0	82542
UNC 1.3/8 x 6	162	57	25.0	20.0	82544
UNC 1.1/2 x 6	170	60	28.0	22.4	82546
UNC 1.5/8 x 5	170	60	28.0	22.4	82547
UNC 1.3/4 x 5	187	67	31.5	25.0	82548
UNC 1.7/8 x 5	187	67	31.5	25.0	82549
UNC 2" x 4.5	200	70	35.5	28.0	82550
Spiral Flute 35° / 螺旋槽					
UNC 10 x 24	58	16	5.0	4.0	82710
UNC 1/4 x 20	66	19	6.3	5.0	82714
UNC 5/16 x 18	72	22	8.0	6.3	82716
UNC 3/8 x 16	80	24	10.0	8.0	82718
UNC 7/16 x 14	85	25	8.0	6.3	82720
UNC 1/2 x 13	89	29	9.0	7.1	82722
UNC 9/16 x 12	95	30	11.2	9.0	82724
UNC 5/8 x 11	102	32	12.5	10.0	82726
UNC 3/4 x 10	112	37	14.0	11.2	82730
UNC 7/8 x 9	118	38	16.0	12.5	82734
UNC 1" x 8	130	45	18.0	14.0	82738
UNC 1.1/8 x 7	138	48	20.0	16.0	82740
UNC 1.1/4 x 7	151	51	22.4	18.0	82742
UNC 1.3/8 x 6	162	57	25.0	20.0	82744
UNC 1.1/2 x 6	170	60	28.0	22.4	82746
UNC 1.5/8 x 5	170	60	28.0	22.4	82748
UNC 1.3/4 x 5	187	67	31.5	25.0	82750
UNC 1.7/8 x 5	187	67	31.5	25.0	82752
UNC 2" x 4.5	200	70	35.5	28.0	82754

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

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
螺尖用于通孔
螺旋槽用于盲孔

Taps - Straight Flute

Unified Fine thread ANSI B 1.1

直槽丝锥

统一制细牙螺纹 ANSI B 1.1

ISO 529 **HSS-G** **Tol. 2B** **UNF**

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

Application:

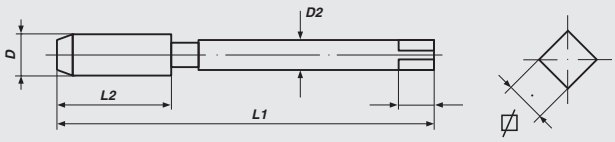
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand and machine

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔和盲孔
– 手用和机用

How to order/如何订货:

1/4 UNF Set	=	83414
1/4 UNF Taper	=	83414-1
1/4 UNF Second	=	83414-2
1/4 UNF Plug	=	83414-3



Machine Taps
Unified Fine thread ANSI B 1.1

机用丝锥
统一制细牙螺纹 ANSI B 1.1

ISO 529 HSS-G Tol. 2B UNF

Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.
Spiral Point / 螺尖					
UNF 1/4 x 28	66	19	6.3	5.0	83514
UNF 5/16 x 24	69	19	8.0	6.3	83516
UNF 3/8 x 24	76	20	10.0	8.0	83518
UNF 7/16 x 20	82	22	8.0	6.3	83520
UNF 1/2 x 20	84	24	9.0	7.1	83522
UNF 9/16 x 18	90	25	11.2	9.0	83524
UNF 5/8 x 18	95	25	12.5	10.0	83526
UNF 3/4 x 16	104	29	14.0	11.2	83530
UNF 7/8 x 14	113	33	16.0	12.5	83534
UNF 1" x 12	120	35	18.0	14.0	83538
UNF 1.1/8 x 12	127	37	20.0	16.0	83540
UNF 1.1/4 x 12	137	37	22.4	18.0	83542
UNF 1.3/8 x 12	144	39	25.0	20.0	83544
UNF 1.1/2 x 12	149	39	28.0	22.4	83546
Spiral Flute 35° / 螺旋槽					
UNF 1/4 x 28	66	19	6.3	5.0	83714
UNF 5/16 x 24	69	19	8.0	6.3	83716
UNF 3/8 x 24	76	20	10.0	8.0	83718
UNF 7/16 x 20	82	22	8.0	6.3	83720
UNF 1/2 x 20	84	24	9.0	7.1	83722
UNF 9/16 x 18	90	25	11.2	9.0	83724
UNF 5/8 x 18	95	25	12.5	10.0	83726
UNF 3/4 x 16	104	29	14.0	11.2	83730
UNF 7/8 x 14	113	33	16.0	12.5	83734
UNF 1" x 12	120	35	18.0	14.0	83738
UNF 1.1/8 x 12	127	37	20.0	16.0	83740
UNF 1.1/4 x 12	137	37	22.4	18.0	83742
UNF 1.3/8 x 12	144	39	25.0	20.0	83744
UNF 1.1/2 x 12	149	39	28.0	22.4	83746

Application:

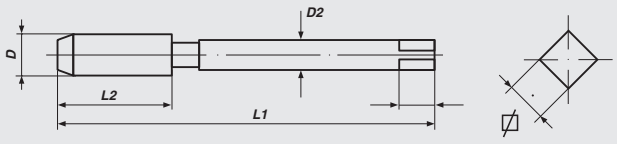
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel

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

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢

螺尖： 用于通孔
螺旋槽： 用于盲孔



VÖLKEL
THREADING SOLUTIONS

Taps - Straight Flute
Unified thread ANSI B 1.1

直槽丝锥
统一制螺纹 ANSI B 1.1

ISO 529 HSS-G Tol. 2B

UN

Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.
UN 1.1/8 x 8	138	48	20.0	16.0	82940
UN 1.1/4 x 8	151	51	22.4	18.0	82942
UN 1.3/8 x 8	162	57	25.0	20.0	82944
UN 1.1/2 x 8	170	60	28.0	22.4	82946
UN 1.5/8 x 8	170	60	28.0	22.4	82947
UN 1.3/4 x 8	187	67	31.5	25.0	82948
UN 1.7/8 x 8	187	67	31.5	25.0	82949
UN 2" x 8	200	70	35.5	28.0	82950
UN 2.1/8 x 8	200	70	35.5	28.0	82951
UN 2.1/4 x 8	221	76	40.0	31.5	82952
UN 2.3/8 x 8	224	79	40.0	31.5	82953
UN 2.1/2 x 8	224	79	40.0	31.5	82954
UN 2.3/4 x 8	234	79	45.0	35.5	82956
UN 3" x 8	258	83	50.0	40.0	82958
UN 3.1/2 x 8	261	86	50.0	40.0	82960
UN 4" x 8	279	89	56.0	45.0	82962

Application:

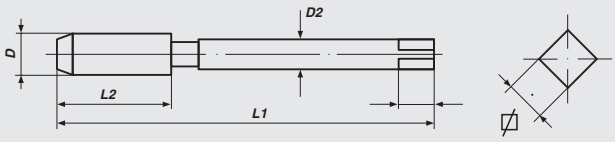
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand and machine

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔和盲孔
– 手用和机用

How to order/如何订货:

1.1/4 UN Set	=	82942
1.1/4 UN Taper	=	82942-1
1.1/4 UN Second	=	82942-2
1.1/4 UN Plug	=	82942-3



Machine Taps
Unified thread ANSI B 1.1

机用丝锥
统一制螺纹 ANSI B 1.1

ISO 529 Spiral Point HSS-E Tol. 2B

UN

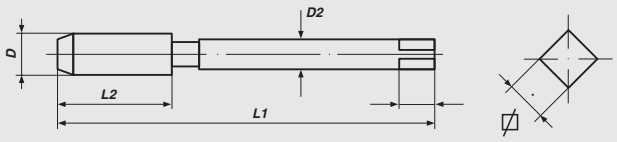
Nominal Diameter D	L 1	L 2	D 2	⌀	Art.-No.
8-UN					
UN 1.1/16 x 8	138	48	20.0	16.0	83101
UN 1.1/8 x 8	138	48	20.0	16.0	83102
UN 1.3/16 x 8	151	51	22.4	18.0	83103
UN 1.1/4 x 8	151	51	22.4	18.0	83104
UN 1.5/16 x 8	162	57	25.0	20.0	83105
UN 1.3/8 x 8	162	57	25.0	20.0	83106
UN 1.1/2 x 8	170	60	28.0	22.4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

Application:

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

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔



Machine Taps
Unified thread ANSI B 1.1

机用丝锥
统一制螺纹 ANSI B 1.1

ISO 529 Spiral Flute 35° HSS-E Tol. 2B

UN

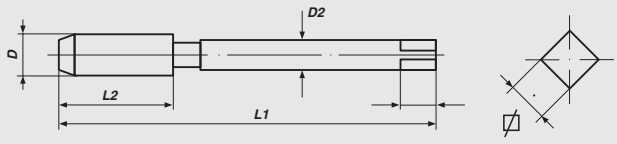
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.
8-UN					
UN 1.1/16 x 8	138	48	20.0	16.0	83151
UN 1.1/8 x 8	138	48	20.0	16.0	83152
UN 1.3/16 x 8	151	51	22.4	18.0	83153
UN 1.1/4 x 8	151	51	22.4	18.0	83154
UN 1.5/16 x 8	162	57	25.0	20.0	83155
UN 1.3/8 x 8	162	57	25.0	20.0	83156
UN 1.1/2 x 8	170	60	28.0	22.4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

Application:

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

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 盲孔



Taps - Straight Flute

Unified Extra Fine thread ANSI B 1.1

直槽丝锥

统一制特细牙螺纹 ANSI B 1.1

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
UNEF 5/16 x 32	72	22	8.0	6.3	83822
UNEF 3/8 x 32	80	24	10.0	8.0	83823
UNEF 7/16 x 28	85	25	8.0	6.3	83824
UNEF 1/2 x 28	89	29	9.0	7.1	83825
UNEF 9/16 x 24	95	30	11.2	9.0	83826
UNEF 5/8 x 24	102	32	12.5	10.0	83827
UNEF 3/4 x 20	112	37	14.0	11.2	83829
UNEF 7/8 x 20	118	38	16.0	12.5	83831
UNEF 1" x 20	130	45	16.0	14.0	83833

Application:

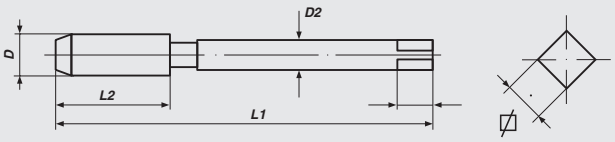
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔和盲孔
– 手用

How to order/如何订货:

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

Machine Taps
Unified Extra Fine thread ANSI B 1.1

机用丝锥
统一制特细牙螺纹 ANSI B 1.1

ISO 529 Spiral Point HSS-E Tol. 2B UNEF

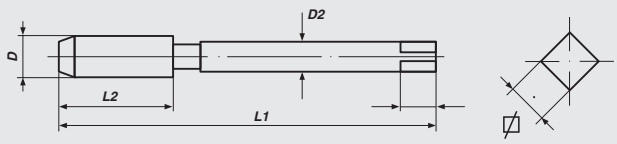
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.
UNEF Nr.12 x 32	62	17	5.6	4.5	83320
UNEF 1/4 x 32	66	19	6.3	5.0	83321
UNEF 5/16 x 32	72	22	8.0	6.3	83322
UNEF 3/8 x 32	80	24	10.0	8.0	83323
UNEF 7/16 x 28	85	25	8.0	6.3	83324
UNEF 1/2 x 28	89	29	9.0	7.1	83325
UNEF 9/16 x 24	95	30	11.2	9.0	83326
UNEF 5/8 x 24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

Application:

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

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔



Machine Taps
Unified Extra Fine thread ANSI B 1.1

机用丝锥
统一制特细牙螺纹 ANSI B 1.1

ISO 529 Spiral Flute 35° HSS-E Tol. 2B

UNEF

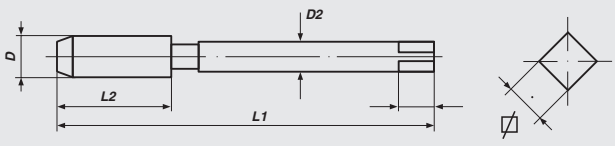
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.
UNEF Nr. 12 x 32	62	17	5.6	4.5	83370
UNEF 1/4 x 32	66	19	6.3	5.0	83371
UNEF 5/16 x 32	72	22	8.0	6.3	83372
UNEF 3/8 x 32	80	24	10.0	8.0	83373
UNEF 7/16 x 28	85	25	8.0	6.3	83374
UNEF 1/2 x 28	89	29	9.0	7.1	83375
UNEF 9/16 x 24	95	30	11.2	9.0	83376
UNEF 5/8 x 24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

Application:

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

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 盲孔



VÖLKEL
THREADING SOLUTIONS

Machine Taps
Unified thread ANSI B 1.1

机用丝锥
统一制螺纹 ANSI B 1.1

ISO 529 Spiral Point HSS-E Tol. 2B

UN

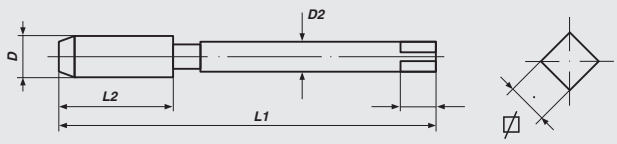
Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.
UNS					
UNS 1/4 x 24	66	19	6.3	5.0	83201
UNS 1/4 x 36	66	19	6.3	5.0	83202
UNS 1/4 x 40	66	19	6.3	5.0	83203
UNS 3/8 x 27	80	24	10.0	8.0	83204
UNS 7/16 x 24	85	25	8.0	6.3	83205
UNS 1/2 x 24	89	29	9.0	7.1	83206
UNS 5/8 x 27	102	32	12.5	10.0	83207
UNS 3/4 x 24	112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

Application:

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

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔



Taps – Straight Flute

Whitworth thread BS 84

直槽丝锥

惠氏螺纹 BS 84

ISO 529 HSS-G

BSW

Nominal Diameter D	L 1	L 2	D 2	⌀	Art.-No.
BSW 1/16 x 60	41	8	2.5	2.0	84402
BSW 3/32 x 48	44.5	9.5	2.8	2.24	84404
BSW 1/8 x 40	48	11	3.15	2.5	84406
BSW 5/32 x 32	53	13	4.0	3.15	84408
BSW 3/16 x 24	58	16	5.0	4.0	84410
BSW 7/32 x 24	62	17	5.6	4.5	84412
BSW 1/4 x 20	66	19	6.3	5.0	84414
BSW 9/32 x 20	72	22	8.0	6.3	84415
BSW 5/16 x 18	72	22	8.0	6.3	84416
BSW 3/8 x 16	80	24	10.0	8.0	84418
BSW 7/16 x 14	85	25	8.0	6.3	84420
BSW 1/2 x 12	89	29	9.0	7.1	84422
BSW 9/16 x 12	95	30	11.2	9.0	84424
BSW 5/8 x 11	102	32	12.5	10.0	84426
BSW 3/4 x 10	112	37	14.0	11.2	84430
BSW 7/8 x 9	118	38	16.0	12.5	84434
BSW 1" x 8	130	45	18.0	14.0	84438
BSW 1.1/8 x 7	138	48	20.0	16.0	84440
BSW 1.1/4 x 7	151	51	22.4	18.0	84442
BSW 1.3/8 x 6	162	57	25.0	20.0	84444
BSW 1.1/2 x 6	170	60	28.0	22.4	84446
BSW 1.5/8 x 5	170	60	28.0	22.4	84448
BSW 1.3/4 x 5	187	67	31.5	25.0	84450
BSW 1.7/8 x 4.5	187	67	31.5	25.0	84452
BSW 2" x 4.5	200	70	35.5	28.0	84454
BSW 2.1/4 x 4	221	76	40.0	31.5	84456
BSW 2.1/2 x 4	224	79	40.0	31.5	84458

Application:

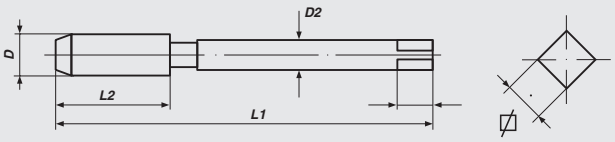
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand and machine

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔和盲孔
– 手用和机用

How to order / 如何订货:

1/4 BSW Se	=	84414
1/4 BSW Taper	=	84414-1
1/4 BSW Second	=	84414-2
1/4 BSW Plug	=	84414-3



VÖLKEL
THREADING SOLUTIONS

Machine Taps
Whitworth thread BS 84

机用丝锥
惠氏螺纹 BS 84

ISO 529 Spiral Point HSS-G

BSW

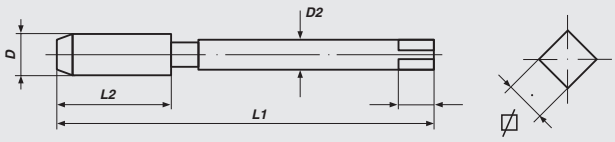
Nominal Diameter D	L 1	L 2	D 2	⊡	Art.-No.
BSW 1/8 x 40	48	11	3.15	2.5	84506
BSW 5/32 x 24	53	13	4.0	3.15	84508
BSW 3/16 x 24	58	16	5.0	4.0	84510
BSW 7/32 x 24	62	17	5.6	4.5	84512
BSW 1/4 x 20	66	19	6.3	5.0	84514
BSW 5/16 x 18	72	22	8.0	6.3	84516
BSW 3/8 x 16	80	24	10.0	8.0	84518
BSW 7/16 x 14	85	25	8.0	6.3	84520
BSW 1/2 x 12	89	29	9.0	7.1	84522
BSW 9/16 x 12	95	30	11.2	9.0	84524
BSW 5/8 x 11	102	32	12.5	10.0	84526
BSW 3/4 x 10	112	37	14.0	11.2	84530
BSW 7/8 x 9	118	38	16.0	12.5	84534
BSW 1" x 8	130	45	18.0	14.0	84538
BSW 1.1/8 x 7	138	48	20.0	16.0	84540
BSW 1.1/4 x 7	151	51	22.4	18.0	84542
BSW 1.1/2 x 6	170	60	28.0	22.4	84546
BSW 1.5/8 x 5	170	60	28.0	22.4	84548
BSW 1.3/4 x 5	187	67	31.5	25.0	84550
BSW 2.1/4 x 4	221	76	40.0	31.5	84556
BSW 2.1/2 x 4	224	79	40.0	31.5	84558

Application:

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

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔



Machine Taps
Whitworth thread BS 84

机用丝锥
惠氏螺纹 BS 84

ISO 529 Spiral Flute 35° HSS-G

BSW

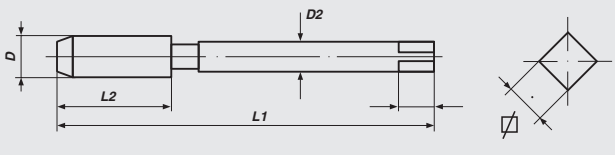
Nominal Diameter D	L 1	L 2	D 2	⌀	Art.-No.
BSW 1/8 x 40	48	11	3.15	2.5	84706
BSW 3/16 x 24	58	16	5.0	4.0	84710
BSW 1/4 x 20	66	19	6.3	5.0	84714
BSW 5/16 x 18	72	22	8.0	6.3	84716
BSW 3/8 x 16	80	24	10.0	8.0	84718
BSW 7/16 x 14	85	25	8.0	6.3	84720
BSW 1/2 x 12	89	29	9.0	7.1	84722
BSW 9/16 x 12	95	30	11.2	9.0	84724
BSW 5/8 x 11	102	32	12.5	10.0	84726
BSW 3/4 x 10	112	37	14.0	11.2	84730
BSW 7/8 x 9	118	38	16.0	12.5	84734
BSW 1" x 8	130	45	18.0	14.0	84738
BSW 1.1/8 x 7	138	48	20.0	16.0	84740
BSW 1.1/4 x 7	151	51	22.4	18.0	84742
BSW 1.3/8 x 7	162	57	25.0	20.0	84744
BSW 1.1/2 x 6	170	60	28.0	22.4	84746

Application:

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

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 盲孔



Taps - Straight Flute

British Standard Fine thread BS 84

直槽丝锥

英标细牙螺纹 BS 84

ISO 529 HSS-G

BSF

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

Application:

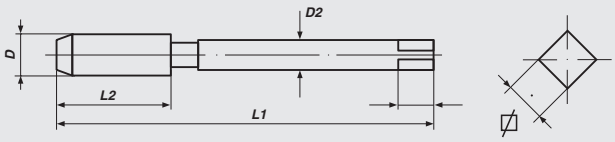
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand and machine

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔和盲孔
– 手用和机用

How to order/如何订货:

1/4 BSF Set	=	85414
1/4 BSF Taper	=	85414-1
1/4 BSF Second	=	85414-2
1/4 BSF Plug	=	85414-3



Machine Taps
British Standard Fine thread BS 84

机用丝锥
英标细牙螺纹 BS 84

ISO 529 HSS-G

BSF

Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.
Spiral Point / 螺尖					
BSF 3/16 x 32	58	16	5.0	4.0	85510
BSF 1/4 x 26	66	19	6.3	5.0	85514
BSF 5/16 x 22	69	19	8.0	6.3	85516
BSF 3/8 x 20	76	20	10.0	8.0	85518
BSF 7/16 x 18	82	22	8.0	6.3	85520
BSF 1/2 x 16	84	24	9.0	7.1	85522
BSF 5/8 x 14	95	25	12.5	10.0	85526
BSF 3/4 x 12	104	29	14.0	11.2	85530
BSF 7/8 x 11	113	33	16.0	12.5	85534
BSF 1" x 10	120	35	18.0	14.0	85538
Spiral Flute 35° / 螺旋槽					
BSF 3/16 x 32	58	16	5.0	4.0	85710
BSF 1/4 x 26	66	19	6.3	5.0	85714
BSF 5/16 x 22	69	19	8.0	6.3	85716
BSF 3/8 x 20	76	20	10.0	8.0	85718
BSF 7/16 x 18	82	22	8.0	6.3	85720
BSF 1/2 x 16	84	24	9.0	7.1	85722
BSF 5/8 x 14	95	25	12.5	10.0	85726
BSF 3/4 x 12	104	29	14.0	11.2	85730
BSF 7/8 x 11	113	33	16.0	12.5	85734
BSF 1" x 10	120	35	18.0	14.0	85738

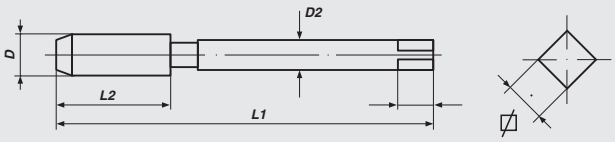
Application:

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

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
螺尖用于通孔
螺旋槽用于盲孔



Taps - Straight Flute

BA-thread BS 93

直槽丝锥

BA螺纹 BS 93

ISO 529 HSS-G

BA

Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.
BA0	66	19	6.3	5.0	89400
BA1	62	17	5.6	4.5	89401
BA2	58	16	5.0	4.0	89402
BA3	53	13	4.5	3.55	89403
BA4	50	13	3.55	2.8	89404
BA5	48	11	3.15	2.5	89405
BA6	45	9.5	2.8	2.24	89406

Application:

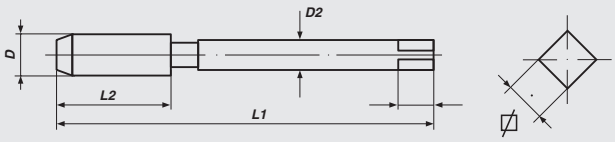
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand and machine

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔和盲孔
– 手用和机用

How to order/如何订货:

2 BA	=	89402
2 BA, No. 1	=	89402-1
2 BA, No. 2	=	89402-2
2 BA, No. 3	=	89402-3



Taps - Straight Flute

Pipe-thread DIN ISO 228

直槽丝锥

管螺纹 DIN ISO 228

ISO 529 HSS-G

G (BSPF)

Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.
G 1/8 x 28	59	15	8.0	6.3	86412
G 1/4 x 19	67	19	10.0	8.0	86414
G 3/8 x 19	75	21	12.5	10.0	86416
G 1/2 x 14	87	26	16.0	12.5	86418
G 5/8 x 14	91	26	18.0	14.0	86420
G 3/4 x 14	96	28	20.0	16.0	86422
G 7/8 x 14	102	29	22.4	18.0	86424
G 1" x 11	109	33	25.0	20.0	86426
G 1.1/8 x 11	115	34	28.0	22.4	86430
G 1.1/4 x 11	119	36	31.5	25.0	86434
G 1.1/2 x 11	125	37	35.5	28.0	86442
G 1.3/4 x 11	132	39	35.5	28.0	86448
G 2" x 11	140	41	40.0	31.5	86454
G 2.1/4 x 11	142	42	40.0	31.5	86458
G 2.1/2 x 11	153	45	45.0	35.5	86460
G 3" x 11	164	48	50.0	40.0	86464
G 4" x 11	185	53	71.0	56.0	86478

Application:

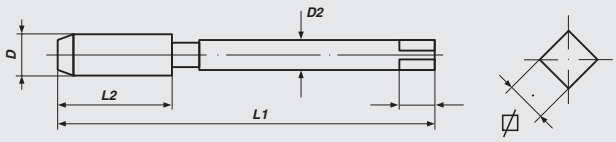
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand and machine

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔和盲孔
– 手用和机用

How to order / 如何订货:

1/4 BSPF Set	=	86414
1/4 BSPF Taper	=	86414-1
1/4 BSPF Second	=	86414-2
1/4 BSPF Plug	=	86414-3



Machine Taps
Pipe-thread DIN ISO 228

机用丝锥
管螺纹 DIN ISO 228

ISO 529 HSS-G

G (BSPF)

Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.
Spiral Point / 螺尖					
G 1/8 x 28	59	15	8.0	6.3	86512
G 1/4 x 19	67	19	10.0	8.0	86514
G 3/8 x 19	75	21	12.5	10.0	86516
G 1/2 x 14	87	26	16.0	12.5	86518
G 3/4 x 14	96	28	20.0	16.0	86522
G 1 x 14	109	33	25.0	20.0	86526
Spiral Flute 35° / 螺旋槽					
G 1/8 x 28	59	15	8.0	6.3	86712
G 1/4 x 19	67	19	10.0	8.0	86714
G 3/8 x 19	75	21	12.5	10.0	86716
G 1/2 x 14	87	26	16.0	12.5	86718
G 3/4 x 14	96	28	20.0	16.0	86722

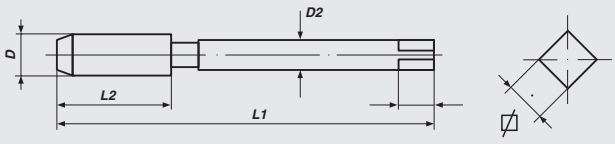
Application:

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

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
螺尖用于通孔
螺旋槽用于盲孔



Taps - Straight Flute

Tapered Pipe-thread, taper 1:16

直槽丝锥

锥管螺纹, 锥度 1:16

ISO 529 HSS-G

BSPT / NPT

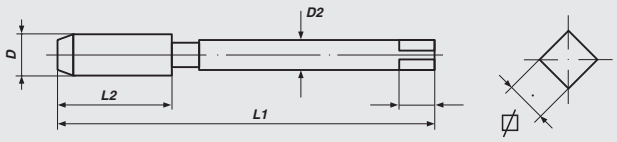
Nominal Diameter D	L 1	L 2	D 2	⌀	Art.-No.
BSPT					
BSPT 1/8 x 28	59	15	8.0	6.3	87412
BSPT 1/4 x 19	67	19	10.0	8.0	87414
BSPT 3/8 x 19	75	21	12.5	10.0	87416
BSPT 1/2 x 14	87	26	16.0	12.5	87418
BSPT 5/8 x 14	91	27	18.0	14.0	87419
BSPT 3/4 x 14	96	28	20.0	16.0	87422
BSPT 7/8 x 14	96	28	20.0	16.0	87423
BSPT 1" x 11	109	33	25.0	20.0	87426
BSPT 1.1/4 x 11	119	36	31.5	25.0	87434
BSPT 1.1/2 x 11	125	37	35.5	28.0	87442
BSPT 2" x 11	140	41	40.0	31.5	87454
BSPT 2.1/2 x 11	153	45	45.0	35.5	87464
NPT					
NPT 1/16 x 27	52	14	5.6	4.5	88410
NPT 1/8 x 27	59	15	8.0	6.3	88412
NPT 1/4 x 18	67	19	10.0	8.0	88414
NPT 3/8 x 18	75	21	12.5	10.0	88416
NPT 1/2 x 14	87	26	16.0	12.5	88418
NPT 3/4 x 14	96	28	20.0	16.0	88422
NPT 1" x 11.5	109	33	25.0	20.0	88426
NPT 1.1/4 x 11.5	119	36	31.5	25.0	88434
NPT 1.1/2 x 11.5	125	37	35.5	28.0	88442
NPT 2" x 11.5	140	41	40.0	31.5	88454
NPT 2.1/2 x 8	153	45	45.0	35.5	88464

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 and machine

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔和盲孔
– 手用和机用



VÖLKEL
THREADING SOLUTIONS

Hand and Machine Taps - *LEFT HAND*

Metric ISO-thread DIN 13

手用和机用丝锥 – 左旋

公制ISO螺纹 DIN 13

ISO 529 HSS-G Tol. ISO2/6H

M

Nominal Diameter D		L 1	L 2	D 2	⧄	Art.-No.
Straight Flute Set of 3 pcs. / 直槽, 3支/套						
M	3 x 0.5	48	11	3.15	2.5	80326
M	4 x 0.7	53	13	4.00	3.15	80330
M	5 x 0.8	58	16	5.00	4.0	80334
M	6 x 1.0	66	19	6.30	5.0	80338
M	8 x 1.25	72	22	8.00	6.3	80342
M	10 x 1.5	80	24	10.00	8.0	80346
M	12 x 1.75	89	29	9.00	7.1	80350
M	14 x 2.0	95	30	11.20	9.0	80354
M	16 x 2.0	102	32	12.50	10.0	80358
M	18 x 2.5	110	37	14.00	11.2	80362
M	20 x 2.5	112	37	14.00	11.2	80366
M	22 x 2.5	118	35	16.00	12.5	80370
M	24 x 3.0	130	45	18.00	14.0	80374
M	27 x 3.0	135	45	20.00	16.0	80376
M	30 x 3.5	138	48	20.00	18.0	80378
Spiral Point / 螺尖						
M	3 x 0.5	48	11	3.15	2.5	80810
M	4 x 0.7	53	13	4.00	3.15	80812
M	5 x 0.8	58	16	5.00	4.0	80814
M	6 x 1.0	66	19	6.30	5.0	80816
M	8 x 1.25	72	22	8.00	6.3	80818
M	10 x 1.5	80	24	10.00	8.0	80820
M	12 x 1.75	89	29	9.00	7.1	80822
Spiral Flute 35° / 螺旋槽						
M	3 x 0.5	48	11	3.15	2.5	80850
M	4 x 0.7	53	13	4.00	3.15	80852
M	5 x 0.8	58	16	5.00	4.0	80854
M	6 x 1.0	66	19	6.30	5.0	80856
M	8 x 1.25	72	22	8.00	6.3	80858
M	10 x 1.5	80	24	10.00	8.0	80860
M	12 x 1.75	89	29	9.00	7.1	80862

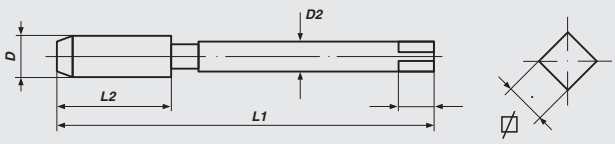
Application:

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

Straight Flute
for through and blind holes
Spiral Point
for through holes
Spiral Flute
for blind holes

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
直槽用于通孔和盲孔
螺尖用于通孔
螺旋槽用于盲孔



Taps - Straight Flute - *LEFT HAND*

Unified thread ANSI B 1.1

直槽丝锥 – 左旋

统一制螺纹 ANSI B 1.1

ISO 529 **HSS-G** **Tol. 2B**

UNC / UNF

Nominal Diameter D	L 1	L 2	D 2	⧄	Art.-No.
UNC					
UNC 1/4 x 20	66	19	6.3	5.0	82310
UNC 5/16 x 18	72	22	8.0	6.3	82311
UNC 3/8 x 16	80	24	10.0	8.0	82312
UNC 7/16 x 14	85	25	8.0	6.3	82313
UNC 1/2 x 13	89	29	9.0	7.1	82314
UNC 9/16 x 12	95	30	11.2	9.0	82315
UNC 5/8 x 11	102	32	12.5	10.0	82316
UNC 3/4 x 10	112	37	14.0	11.2	82317
UNC 7/8 x 9	118	38	16.0	12.5	82318
UNC 1" x 8	130	45	18.0	14.0	82319
UNF					
UNF 1/4 x 28	66	19	6.3	5.0	82350
UNF 5/16 x 24	69	19	8.0	6.3	82351
UNF 3/8 x 24	76	20	10.0	8.0	82352
UNF 7/16 x 20	83	22	8.0	6.3	82353
UNF 1/2 x 20	84	24	9.0	7.1	82354
UNF 9/16 x 18	90	25	11.2	9.0	82355
UNF 5/8 x 18	95	25	12.5	10.0	82356
UNF 3/4 x 16	104	29	14.0	11.2	82357
UNF 7/8 x 14	113	33	16.0	12.5	82358
UNF 1" x 12	120	35	18.0	14.0	82359

Application:

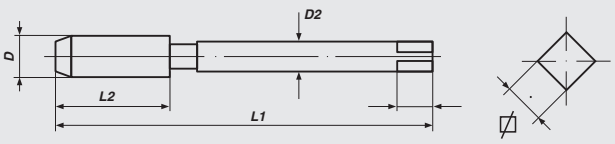
for general use
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand and machine

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔和盲孔
– 手用和机用

How to order / 如何订货:

1/4 UNF Set	=	82350
1/4 UNF Taper	=	82350-1
1/4 UNF Second	=	82350-2
1/4 UNF Plug	=	82350-3



Taps - Straight Flute - *LEFT HAND*

Whitworth thread BS 84

直槽丝锥 – 左旋

惠氏螺纹 BS 84

ISO 529 HSS-G

BSW

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

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 and machine

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
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How to order/如何订货:

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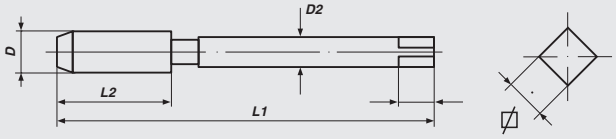


BIT EDITION
六角柄系列

	M	Mf	UNC/UNF	BSW	G(BSP)
HexTap 六角柄丝锥	206	207			211
Combined Bits 六角柄复合丝锥	212		213		
TriBit² 六角柄工具套装	214				
Drill Bits 六角柄钻头	214				
Countersink Bits 六角柄倒角刀	215				

VÖLKEL
THREADING SOLUTIONS

HEX TAP DS
六角柄双头丝锥

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

优点：
– 导向可以使丝锥精确对准
– 同一丝锥包含头攻和底攻
– 可用于不方便加工的地方
– 可用于攻新的螺纹
– 可用于清牙和修复损坏的螺纹

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:

六角柄丝锥

技术资料:

VOLKEL六角柄丝锥是设计用于充电式电动起子和带有左旋和右旋功能的手电钻进行攻丝的工具。
也适用于手动或固定钻床攻丝。
充电式电动起子的最低电压为7.5伏。
请注意底孔的中心轴和丝锥的中心轴要对齐，使用合适的切削油。

以下技术参数适用于充电式电动起子和手电钻进行攻丝:

Dimensions/尺寸	M 3	M 4	M 5	M 6	M 8	M 10
Core hole dia./底孔直径	2,5 mm	3,3 mm	4,2 mm	5,0 mm	6,8 mm	8,5 mm
RPM/转速	Lowest setting (0 - 450 RPM)/最小设定(0 – 450 RPM)					
Torque/扭力	Maximum setting/最大设定					

HexTap DS

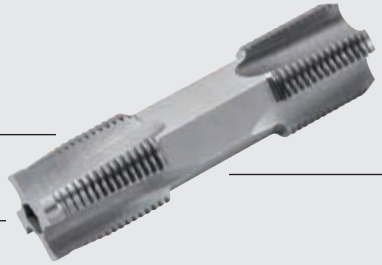
Application:

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

六角柄双头丝锥

应用:

通用
– 抗拉强度小于900N/mm²的非研磨材料
– 非合金钢和低合金钢
– 通孔和盲孔
– 手用



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

优点:
导向可以使丝锥精确对准
同一丝锥包含头攻和底攻
可用于不方便加工的地方
可用于攻新的螺纹
可用于清牙和修复损坏的螺纹

HexTap S

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

六角柄丝锥

带1/4”六角柄
公制ISO螺纹 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
M 3.5	S	33.5	10	1/4"	67028
M 4	S	35.0	12	1/4"	67030
M 4.5	S	35.0	12	1/4"	67032
M 5	S	36.0	15	1/4"	67034
M 5.5	S	35.0	15	1/4"	67036
M 6	S	39.0	18	1/4"	67038
M 7	S	37.5	16	1/4"	67040
M 8	S	40.0	19	1/4"	67042
M 9	S	40.5	18	1/4"	67044
M 10	S	41.0	21	1/4"	67046

HexTap DS

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

六角柄双头丝锥

双头丝锥, 多种驱动
公制ISO螺纹 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
M 12	DS	70	22	8	4	67050
M 14	DS	70	22	10	4	67051
M 16	DS	70	22	10	4	67052
M 18	DS	80	24	13	5	67053
M 20	DS	80	24	13	6	67054
M 22	DS	80	24	15	6	67055
M 24	DS	90	27	15	8	67056
M 27	DS	90	27	19	8	67057
M 30	DS	90	27	19	10	67058
M 33	DS	100	29	24	10	67059
M 36	DS	100	29	24	10	67060
M 39	DS	110	32	27	12	67061
M 42	DS	110	27	27	12	67062
M 45	DS	110	27	32	17	67063
M 48	DS	140	42	32	17	67064
M 52	DS	140	42	36	19	67065

HexTap S

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

六角柄丝锥

带1/4”六角柄
公制细牙ISO螺纹 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
M	3.5 x 0.35	S	33,5	10	1/4"	67701
M	4 x 0.35	S	35,0	12	1/4"	67702
M	4 x 0.5	S	35,0	12	1/4"	67703
M	4.5 x 0.5	S	35,0	12	1/4"	67704
M	5 x 0.5	S	36,0	15	1/4"	67705
M	5 x 0.75	S	36,0	15	1/4"	67706
M	5.5 x 0.5	S	35,0	15	1/4"	67707
M	6 x 0.5	S	39,0	18	1/4"	67708
M	6 x 0.75	S	39,0	18	1/4"	67709
M	7 x 0.5	S	37,5	16	1/4"	67710
M	7 x 0.75	S	37,5	16	1/4"	67711
M	8 x 0.5	S	40,0	19	1/4"	67712
M	8 x 0.75	S	40,0	19	1/4"	67713
M	8 x 1.0	S	40,0	19	1/4"	67714
M	9 x 0.5	S	40,5	18	1/4"	67715
M	9 x 0.75	S	40,5	18	1/4"	67716
M	9 x 1.0	S	40,5	18	1/4"	67717
M	10 x 0.5	S	41,0	21	1/4"	67718
M	10 x 0.75	S	41,0	21	1/4"	67719
M	10 x 1.0	S	41,0	21	1/4"	67720
M	10 x 1.25	S	41,0	21	1/4"	67721

VÖLKEL THREADING SOLUTIONS

HexTap DS

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

六角柄双头丝锥

双头丝锥, 多种驱动
公制细牙ISO螺纹 DIN 13

HSS-G Tol. ISO2/6H

Mf

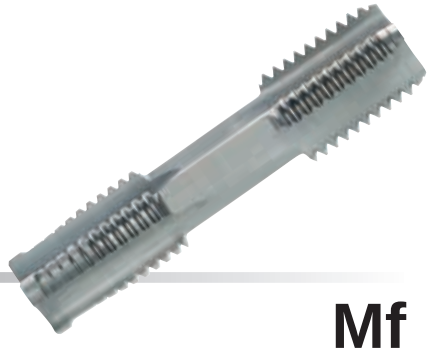
Size		Typ	L 1	L 4	SW1	SW2	Art.-No.
M	11 x 0,75	DS	70	22	8	4	67722
M	11 x 1.0	DS	70	22	8	4	67723
M	11 x 1.25	DS	70	22	8	4	67724
M	12 x 0.5	DS	70	22	8	4	67725
M	12 x 0.75	DS	70	22	8	4	67726
M	12 x 1	DS	70	22	8	4	67727
M	12 x 1.25	DS	70	22	8	4	67728
M	12 x 1.5	DS	70	22	8	4	67729
M	13 x 0.5	DS	70	22	10	4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

HexTap DS

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

六角柄双头丝锥

双头丝锥, 多种驱动
公制细牙ISO螺纹 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
M	23 x 1.5	DS	80	24	17	6	67772
M	24 x 0.5	DS	80	24	19	8	67773
M	24 x 0,75	DS	80	24	19	8	67774
M	24 x 1.0	DS	80	24	19	8	67775
M	24 x 1,25	DS	80	24	19	8	67776
M	24 x 1.5	DS	90	27	19	8	67777
M	24 x 2.0	DS	90	27	17	8	67778
M	25 x 1.0	DS	90	27	19	8	67779
M	25 x 1.5	DS	90	27	19	8	67780
M	26 x 1.0	DS	90	27	19	8	67781
M	26 x 1.5	DS	90	27	19	8	67782
M	26 x 2.0	DS	90	27	19	8	67783
M	27 x 1.0	DS	90	27	19	8	67784
M	27 x 1.5	DS	90	27	19	8	67785
M	27 x 2.0	DS	90	27	19	8	67786
M	28 x 1.0	DS	90	27	19	8	67787
M	28 x 1.5	DS	90	27	19	8	67788
M	28 x 2.0	DS	90	27	19	8	67789
M	29 x 1.5	DS	90	27	19	8	67790
M	30 x 1.0	DS	90	27	24	10	67791
M	30 x 1.5	DS	90	27	24	10	67792
M	30 x 2.0	DS	90	27	24	10	67793
M	30 x 2.5	DS	90	27	22	10	67794
M	30 x 3.0	DS	90	27	22	10	67795
M	32 x 1.0	DS	90	27	24	10	67796
M	32 x 1.5	DS	90	27	24	10	67797
M	32 x 2.0	DS	90	27	24	10	67798
M	32 x 3.0	DS	90	27	24	10	67799
M	33 x 1.5	DS	100	29	24	10	67800
M	33 x 2.0	DS	100	29	24	10	67801
M	33 x 3.0	DS	100	29	24	10	67802
M	34 x 1.0	DS	100	29	27	10	67803
M	34 x 1.5	DS	100	29	27	10	67804
M	34 x 2.0	DS	100	29	27	10	67805
M	35 x 1.0	DS	100	29	27	10	67806
M	35 x 1.5	DS	100	29	27	10	67807
M	35 x 2.0	DS	100	29	27	10	67808
M	36 x 1.0	DS	100	29	27	10	67809
M	36 x 1.5	DS	100	29	27	10	67810
M	36 x 2.0	DS	100	29	27	10	67811
M	36 x 3.0	DS	100	29	27	10	67812
M	37 x 1.5	DS	100	29	27	10	67813
M	38 x 1.0	DS	110	32	27	12	67814
M	38 x 1.5	DS	110	32	27	12	67815
M	38 x 2.0	DS	110	32	27	12	67816
M	38 x 3.0	DS	110	32	27	12	67817
M	39 x 1.5	DS	110	32	32	12	67818
M	39 x 2.0	DS	110	32	27	12	67819

VÖLKEL THREADING SOLUTIONS

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

六角柄双头丝锥
双头丝锥, 多种驱动
公制细牙ISO螺纹 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
M	40 x 1.0	DS	110	32	32	12	67821
M	40 x 1.5	DS	110	32	32	12	67822
M	40 x 2.0	DS	110	32	32	12	67823
M	40 x 3.0	DS	110	32	27	12	67824
M	42 x 1.0	DS	110	32	32	12	67825
M	42 x 1.5	DS	110	27	32	12	67828
M	42 x 2.0	DS	110	27	32	12	67826
M	42 x 3.0	DS	110	27	32	12	67827
M	44 x 1.5	DS	110	27	36	12	67829
M	44 x 2.0	DS	110	27	36	12	67830
M	45 x 1.0	DS	110	27	36	17	67831
M	45 x 1.5	DS	110	27	36	17	67832
M	45 x 2.0	DS	110	27	36	17	67833
M	45 x 3.0	DS	110	27	36	17	67834
M	46 x 1.5	DS	110	27	36	17	67835
M	48 x 1.0	DS	140	45	36	17	67836
M	48 x 1.5	DS	140	45	36	17	67837
M	48 x 2.0	DS	140	45	36	17	67838
M	48 x 3.0	DS	140	45	36	17	67839
M	50 x 1.5	DS	140	42	41	17	67840
M	50 x 2.0	DS	140	42	41	17	67841
M	50 x 3.0	DS	140	42	36	17	67842
M	52 x 1.5	DS	140	42	41	19	67843
M	52 x 2.0	DS	140	42	41	19	67844
M	52 x 3.0	DS	140	42	41	19	67845
M	63 x 1.5	DS	160	47	50	19	67846

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

六角柄丝锥
带1/4”六角柄
管螺纹 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

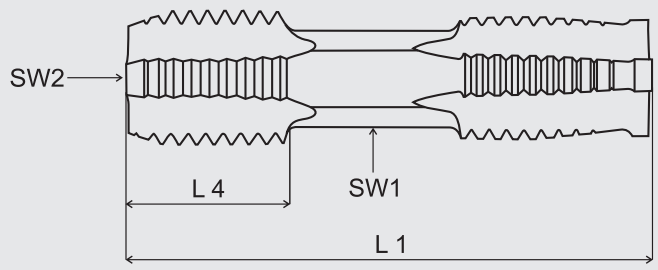
HexTap DS
Double Ended Tap, Multi-Drive
Pipe-thread DIN ISO 228

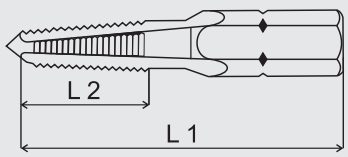
六角柄双头丝锥
双头丝锥, 多种驱动
管螺纹 DIN ISO 228

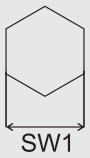
HSS-G

G (BSP)

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







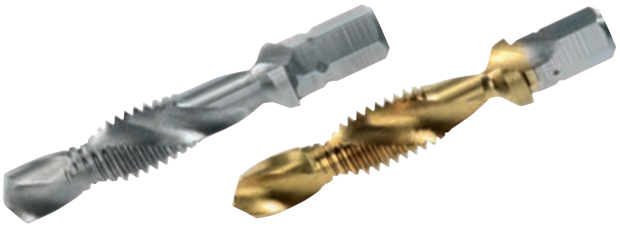
VÖLKEL
THREADING SOLUTIONS

Combined Bits

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

复合丝锥

带1/4”六角柄
一次完成钻孔、攻丝、倒角



HSS-G Tol. ISO2/6H

M

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

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:

技术资料:

VOLKEL六角柄复合丝锥是设计用于充电式电动起子和带有左旋和右旋功能的手电钻进行一次完成钻孔、攻丝、倒角的工具,也适用于手动或固定钻床。复合丝锥通用于中等机械强度的材料、有色金属、热塑性材料(抗拉强度小于600N/mm²)。复合丝锥最大的攻丝深度为1 x D, 特别适合用于安装和小批量生产。请注意孔的中心轴和丝锥的中心轴要对齐,使用合适的切削油。

以下技术参数适用于充电式电动起子和手电钻进行攻丝:

Dimensions/尺寸	M 3	M 4	M 5	M 6	M 8	M 10
Core hole dia./底孔直径	2,5 mm	3,3 mm	4,2 mm	5,0 mm	6,8 mm	8,5 mm
max. RPM/最大转速	1600 UpM	1200 UpM	950 UpM	800 UpM	600 UpM	450 UpM

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

复合丝锥
一次完成钻孔、攻丝、倒角
带1/4”六角柄

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
UNC Nr. 5 x 40	2.6	36	1/4"	67281
UNC Nr. 6 x 32	2.85	39	1/4"	67282
UNC Nr. 8 x 32	3.5	39	1/4"	67283
UNC Nr. 10 x 24	3.9	41	1/4"	67284
UNC Nr. 12 x 24	4.5	41	1/4"	67285
UNC 1/4 x 20	5.2	44	1/4"	67286
UNC 5/16 x 18	6.6	50	1/4"	67287
UNC 3/8 x 16	8.0	59	1/4"	67288
UNF				
UNF Nr. 4 x 48	2.4	36	1/4"	67290
UNF Nr. 5 x 44	2.7	36	1/4"	67291
UNF Nr. 6 x 40	3.0	39	1/4"	67292
UNF Nr. 8 x 36	3.5	39	1/4"	67293
UNF Nr. 10 x 32	4.1	41	1/4"	67294
UNF Nr. 12 x 28	4.7	41	1/4"	67295
UNF 1/4 x 28	5.5	44	1/4"	67296
UNF 5/16 x 24	6.9	50	1/4"	67297
UNF 3/8 x 24	8.5	59	1/4"	67298

TriBit²

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

六角柄工具套装

套装带有钻孔、攻丝、
倒角工具和复合丝锥

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
M 4 x 0.7	3.3 mm	8.3 mm	M 4	M 4	67404
M 5 x 0.8	4.2 mm	10.4 mm	M 5	M 5	67405
M 6 x 1.0	5.0 mm	12.4 mm	M 6	M 6	67406
M 8 x 1.25	6.8 mm	16.5 mm	M 8	M 8	67408
M 10 x 1.5	8.5 mm	20.5 mm	M 10	M 10	67410

Wood Drill Bits

with 1/4" Hexagon Drive

六角柄木工钻

带1/4”六角柄

HSS-G

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

Drill Bits
with 1/4" Hexagon Drive

六角柄钻头
带1/4”六角柄

HSS-G

M

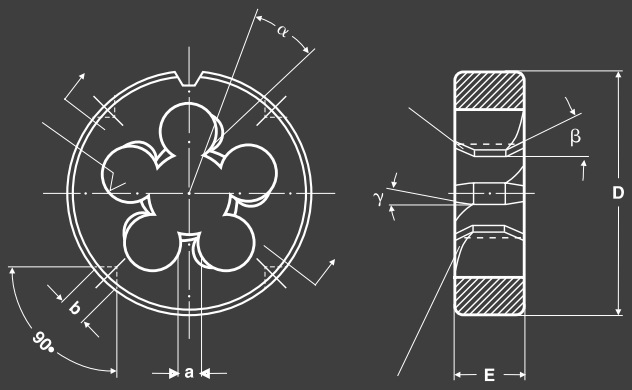
Nominal Diameter D		L 1	S 2	⬡	Art.-No.
1.0 mm		32	7	1/4"	67110
1.5 mm		32	10	1/4"	67115
2.0 mm		34	12	1/4"	67120
2.5 mm	(M3)	36	14	1/4"	67125
3.0 mm		38	16	1/4"	67130
3.3 mm	(M4)	40	18	1/4"	67133
3.5 mm		40	18	1/4"	67135
4.0 mm		44	20	1/4"	67140
4.2 mm	(M5)	45	20	1/4"	67142
4.5 mm		46	24	1/4"	67145
5.0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

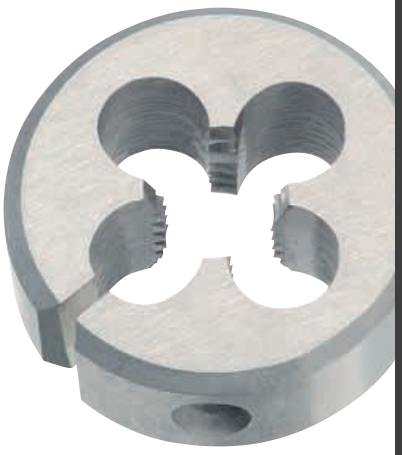
Countersink Bits
90° - 3 Flutes
with 1/4" Hexagon Drive

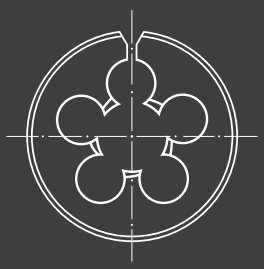
六角柄倒角刀
90° – 3 槽
带1/4”六角柄

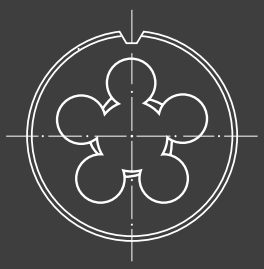
HSS

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


α
β
γ
D
b
90°
a
E







ROUND DIES
HEXAGON DIE NUTS
圆板牙
六方板牙

JIS	HSS	HSSE	LH	HSS	LH
M	218				
Mf	219				
PS (BSPP / Rp)	220				
PF (BSPF / G)	220				
PT (BSPT / R)	221				
NPT	222				
NPTF	222				
NPS	223				

DIN	HSS	HSSE	LH	HSS	LH
M	224	242	245	260	269
M - 6e	226				
Mf	227	243	246	261	
BSW	233		249	263	
BSF	233			263	
UNC	234		250	264	
UNF	235		250	264	
8 - UN				265	
UNEF	236				
G (BSPF / PF)	237	244	251	266	270
R (BSPT / PT)				267	
PG	238				
NPT	239			268	

ISO	HSS	HSSE	LH	HSS	LH
M	252				
Mf	253				
BSW	254				
BSF	255				
UNC	256				
UNF	257				
BA	258				
G (BSPF / PF)	259				

Round Split Dies
metric ISO-thread DIN 13

可调圆板牙
公制ISO螺纹 DIN 13

JIS B 4451 HSS Tol: 6g

M

Nominal Diameter mm	Ø o / d	Art.-No.
M 3 x 0.5	25 mm	90022
M 3.5 x 0.6	25 mm	90024
M 4 x 0.7	25 mm	90026
M 5 x 0.8	25 mm	90030
M 5 x 0.8	38 mm	90031
M 6 x 1.0	25 mm	90038
M 6 x 1.0	38 mm	90039
M 7 x 1.0	25 mm	90044
M 7 x 1.0	38 mm	90045
M 8 x 1.25	25 mm	90046
M 8 x 1.25	38 mm	90047
M 8 x 1.25	50 mm	90150
M 10 x 1.5	25 mm	90054
M 10 x 1.5	38 mm	90055
M 10 x 1.5	50 mm	90153
M 12 x 1.75	38 mm	90060
M 12 x 1.75	50 mm	90061
M 14 x 2.0	38 mm	90066
M 14 x 2.0	50 mm	90067
M 16 x 2.0	38 mm	90072
M 16 x 2.0	50 mm	90073
M 18 x 2.5	50 mm	90078
M 20 x 2.5	50 mm	90084
M 22 x 2.5	50 mm	90090
M 22 x 2.5	65 mm	90091
M 24 x 3.0	65 mm	90096
M 24 x 3.0	50 mm	90097
M 27 x 3.0	65 mm	90102
M 30 x 3.5	65 mm	90108
M 33 x 3.5	65 mm	90116
M 36 x 4.0	65 mm	90124

Application:

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

应用:

通用
– 抗拉强度小于800N/mm²的非研磨材料
– 非合金钢和低合金钢

Round Split Dies
metric-fine ISO-thread DIN 13

可调圆板牙
公制细牙ISO螺纹 DIN 13

JIS B 4451 HSS Tol: 6g

Mf

Nominal Diameter mm	Ø o / d	Art.-No.
M 8 x 1.0	25 mm	90048
M 8 x 1.0	38 mm	90049
M 8 x 0.75	25 mm	90050
M 8 x 0.75	38 mm	90051
M 10 x 1.25	25 mm	90052
M 10 x 1.25	38 mm	90059
M 10 x 1.25	50 mm	90154
M 10 x 1.0	25 mm	90056
M 10 x 1.0	38 mm	90057
M 10 x 1.0	50 mm	90155
M 12 x 1.5	38 mm	90062
M 12 x 1.5	50 mm	90063
M 12 x 1.25	50 mm	90156
M 12 x 1.0	38 mm	90064
M 12 x 1.0	50 mm	90065
M 14 x 1.5	38 mm	90068
M 14 x 1.5	50 mm	90069
M 14 x 1.25	50 mm	90157
M 14 x 1.0	38 mm	90070
M 14 x 1.0	50 mm	90071
M 16 x 1.5	38 mm	90074
M 16 x 1.5	50 mm	90075
M 16 x 1.0	38 mm	90076
M 16 x 1.0	50 mm	90077
M 18 x 1.5	50 mm	90080
M 18 x 1.0	50 mm	90082
M 20 x 1.5	50 mm	90086
M 20 x 1.0	50 mm	90088
M 22 x 1.5	50 mm	90092
M 22 x 1.5	65 mm	90093
M 22 x 1.0	50 mm	90094
M 22 x 1.0	65 mm	90095
M 24 x 1.5	65 mm	90098
M 24 x 1.5	50 mm	90099
M 24 x 1.0	65 mm	90100
M 24 x 1.0	50 mm	90101
M 27 x 2.0	65 mm	90104
M 27 x 1.5	65 mm	90106
M 30 x 1.5	65 mm	90112
M 33 x 1.5	65 mm	90120
M 36 x 1.5	65 mm	90130

Application:

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

应用:

通用
– 抗拉强度小于800N/mm²的非研磨材料
– 非合金钢和低合金钢

VÖLKEL
THREADING SOLUTIONS

Round Split Dies
Pipe thread

可调圆板牙
管螺纹

JIS B 4451 HSS

PS / PF

Nominal Diameter mm	Ø o / d	Art.-No.
PS (BSPP / Rp)		
PS 1/8 x 28	50 mm	95008
PS 1/4 x 19	50 mm	95016
PS 3/8 x 19	50 mm	95020
PS 1/2 x 14	50 mm	95022
PS 3/4 x 14	50 mm	95030
PS 1" x 11	50 mm	95038
PF (BSPF / G)		
PF 1/8 x 28	38 mm	96006
PF 1/8 x 28	50 mm	96008
PF 1/4 x 19	38 mm	96014
PF 1/4 x 19	50 mm	96016
PF 3/8 x 19	38 mm	96018
PF 3/8 x 19	50 mm	96020
PF 1/2 x 14	50 mm	96022
PF 3/4 x 14	50 mm	96030
PF 3/4 x 14	65 mm	96032
PF 1" x 11	50 mm	96038
PF 1" x 11	65 mm	96040
PF 1" x 11	75 mm	96042
PF 1.1/4 x 11	65 mm	96046
PF 1.1/4 x 11	75 mm	96048

Application:

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

应用:

通用
– 抗拉强度小于800N/mm²的非研磨材料
– 非合金钢和低合金钢

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

可调圆板牙
锥管螺纹, 锥度 1:16, 牙型角55°

JIS B 4451 HSS

PT (BSPT / R)

Nominal Diameter mm	Ø o / d	Art.-No.
PT 1/8 x 28	38 mm	97006
PT 1/8 x 28	50 mm	97008
PT 1/4 x 19	38 mm	97014
PT 1/4 x 19	50 mm	97016
PT 3/8 x 19	38 mm	97018
PT 3/8 x 19	50 mm	97020
PT 1/2 x 14	50 mm	97022
PT 5/8 x 14	50 mm	97026
PT 3/4 x 14	50 mm	97030
PT 3/4 x 14	65 mm	97032
PT 7/8 x 14	65 mm	97036
PT 1" x 11	50 mm	97038
PT 1" x 11	65 mm	97040
PT 1" x 11	75 mm	97042
PT 1.1/4 x 11	65 mm	97046
PT 1.1/4 x 11	75 mm	97048
PT 1.1/2 x 11	90 mm	97054

Application:

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

应用:

通用
– 抗拉强度小于800N/mm²的非研磨材料
– 非合金钢和低合金钢

VÖLKEL THREADING SOLUTIONS

Round Split Dies
american tapered pipe-thread, taper 1:16

可调圆板牙
美制锥管螺纹, 锥度 1:16

JIS B 4451 HSS

NPT / NPTF

Nominal Diameter mm		Ø o / d	Art.-No.
NPT			
NPT	1/8 x 27	38 mm	98006
NPT	1/8 x 27	50 mm	98008
NPT	1/4 x 18	38 mm	98014
NPT	1/4 x 18	50 mm	98016
NPT	3/8 x 18	38 mm	98018
NPT	3/8 x 18	50 mm	98020
NPT	1/2 x 14	38 mm	98022
NPT	3/4 x 14	50 mm	98030
NPT	3/4 x 14	38 mm	98032
NPT	1" x 11.5	50 mm	98038
NPT	1" x 11.5	38 mm	98040
NPT	1" x 11.5	50 mm	98042
NPT	1.1/4 x 11.5	38 mm	98046
NPT	1.1/4 x 11.5	50 mm	98048
NPTF			
NPTF	1/8 x 27	50 mm	98072
NPTF	1/4 x 18	50 mm	98074
NPTF	3/8 x 18	50 mm	98076
NPTF	1/2 x 14	50 mm	98078
NPTF	3/4 x 14	50 mm	98080
NPTF	1" x 11.5	50 mm	98082

Application:

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

应用:

通用
– 抗拉强度小于800N/mm²的非研磨材料
– 非合金钢和低合金钢

Round Split Dies
american tapered pipe thread

可调圆板牙
美制锥管螺纹

JIS B 4451 HSS

NPS

Nominal Diameter mm		Ø o / d	Art.-No.
NPS	1/8 x 27	50 mm	99008
NPS	1/4 x 18	50 mm	99016
NPS	3/8 x 18	50 mm	99020
NPS	1/2 x 14	50 mm	99022
NPS	3/4 x 14	50 mm	99030
NPS	1" x 11.5	50 mm	99038

Application:

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

应用:

通用
– 抗拉强度小于800N/mm²的非研磨材料
– 非合金钢和低合金钢

VÖLKEL THREADING SOLUTIONS

Round Dies
metric ISO-thread DIN 13

圆板牙
公制ISO螺纹 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
M 1.1 x 0.25	16 x 5	27404
M 1.2 x 0.25	16 x 5	27406
M 1.4 x 0.3	16 x 5	27408
M 1.6 x 0.35	16 x 5	27410
M 1.7 x 0.35	16 x 5	27412
M 1.8 x 0.35	16 x 5	27414
M 2 x 0.4	16 x 5	27416
M 2.2 x 0.45	16 x 5	27418
M 2.3 x 0.4	16 x 5	27420
M 2.5 x 0.45	16 x 5	27422
M 2.6 x 0.45	16 x 5	27424
M 3 x 0.5	20 x 5	27426
M 3.5 x 0.6	20 x 5	27428
M 4 x 0.7	20 x 5	27430
M 4.5 x 0.75	20 x 7	27432
M 5 x 0.8	20 x 7	27434
M 5.5 x 0.9	20 x 7	27436
M 6 x 1.0	20 x 7	27438
M 7 x 1.0	25 x 9	27440
M 8 x 1.25	25 x 9	27442
M 9 x 1.25	25 x 9	27444
M 10 x 1.5	30 x 11	27446
M 11 x 1.5	30 x 11	27448
M 12 x 1.75	38 x 14	27450
M 14 x 2.0	38 x 14	27454
M 15 x 2.0	38 x 14	27456
M 16 x 2.0	45 x 18	27458
M 18 x 2.5	45 x 18	27462
M 19 x 2.5	45 x 18	27464
M 20 x 2.5	45 x 18	27466
M 22 x 2.5	55 x 22	27470
M 24 x 3.0	55 x 22	27474
M 27 x 3.0	65 x 25	27476
M 30 x 3.5	65 x 25	27478
M 33 x 3.5	65 x 25	27480
M 36 x 4.0	65 x 25	27482
M 39 x 4.0	75 x 30	27484
M 42 x 4.5	75 x 30	27486
M 45 x 4.5	90 x 36	27488
M 48 x 5.0	90 x 36	27490
M 52 x 5.0	90 x 36	27492
M 56 x 5.5	105 x 36	27494
M 60 x 5.5	105 x 36	27496
M 64 x 6.0	120 x 36	27498
M 68 x 6.0	120 x 36	27499

Application:

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

应用:

通用
– 抗拉强度小于800N/mm²的非研磨材料
– 非合金钢和低合金钢

Round Dies
metric ISO-thread DIN 13

圆板牙
公制ISO螺纹 DIN 13

HSS Tol. 6g

M

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

Application:

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

应用:

通用
– 抗拉强度小于800N/mm²的非研磨材料
– 非合金钢和低合金钢

Round Dies
metric ISO-thread DIN 13

圆板牙
公制ISO螺纹 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
M 4 x 0.7	20 x 5	27505
M 5 x 0.8	20 x 7	27507
M 6 x 1.0	20 x 7	27509
M 8 x 1.25	25 x 9	27511
M 10 x 1.5	30 x 11	27513
M 12 x 1.75	38 x 14	27515
M 14 x 2.0	38 x 14	27516
M 16 x 2.0	45 x 18	27517
M 18 x 2.5	45 x 18	27518
M 20 x 2.5	45 x 18	27519

Application:

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

应用:

通用
– 抗拉强度小于800N/mm²的非研磨材料
– 非合金钢和低合金钢

Round Dies
metric-fine ISO-thread DIN 13

圆板牙
公制细牙ISO螺纹 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
M 2.6 x 0.35	16 x 5	26405
M 3 x 0.35	20 x 5	26408
M 3.5 x 0.35	20 x 5	26409
M 4 x 0.35	20 x 5	26410
M 4 x 0.5	20 x 5	26412
M 4.5 x 0.5	20 x 5	26413
M 5 x 0.5	20 x 5	26414
M 5 x 0.75	20 x 7	26416
M 5.5 x 0.5	20 x 5	26415
M 6 x 0.5	20 x 5	26417
M 6 x 0.75	20 x 7	26418
M 7 x 0.5	25 x 9	26419
M 7 x 0.75	25 x 9	26420
M 8 x 0.5	25 x 9	26422
M 8 x 0.75	25 x 9	26424
M 8 x 1.0	25 x 9	26426
M 9 x 0.5	25 x 9	26427
M 9 x 0.75	25 x 9	26428
M 9 x 1.0	25 x 9	26430
M 10 x 0.5	30 x 11	26431
M 10 x 0.75	30 x 11	26432
M 10 x 1.0	30 x 11	26436
M 10 x 1.25	30 x 11	26438
M 11 x 1.0	30 x 11	26440
M 11 x 1.25	30 x 11	26442
M 12 x 0.5	38 x 10	26445
M 12 x 0.75	38 x 10	26443
M 12 x 1.0	38 x 10	26444
M 12 x 1.25	38 x 10	26446
M 12 x 1.5	38 x 10	26448
M 13 x 0.5	38 x 10	26447
M 13 x 0.75	38 x 10	26449
M 13 x 1.0	38 x 10	26450
M 13 x 1.5	38 x 10	26451
M 14 x 0.5	38 x 10	26455
M 14 x 0.75	38 x 10	26452
M 14 x 1.0	38 x 10	26453
M 14 x 1.25	38 x 10	26454
M 14 x 1.5	38 x 10	26456
M 15 x 0.75	38 x 10	26457
M 15 x 1.0	38 x 10	26458
M 15 x 1.5	38 x 10	26460
M 16 x 0.5	45 x 14	26461
M 16 x 0.75	45 x 14	26463

►►►

Application:

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

应用:

通用
– 抗拉强度小于800N/mm²的非研磨材料
– 非合金钢和低合金钢

VÖLKEL THREADING SOLUTIONS

Round Dies
metric-fine ISO-thread DIN 13

圆板牙
公制细牙ISO螺纹 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
M 16 x 1.25	45 x 14	26464
M 16 x 1.5	45 x 14	26466
M 17 x 1.0	45 x 14	26468
M 17 x 1.5	45 x 14	26469
M 18 x 0.5	45 x 14	26467
M 18 x 0.75	45 x 14	26473
M 18 x 1.0	45 x 14	26470
M 18 x 1.25	45 x 14	26471
M 18 x 1.5	45 x 14	26472
M 18 x 2.0	45 x 14	26474
M 19 x 1.0	45 x 14	26475
M 19 x 1.5	45 x 14	26476
M 20 x 0.5	45 x 14	26477
M 20 x 0.75	45 x 14	26479
M 20 x 1.0	45 x 14	26478
M 20 x 1.25	45 x 14	26480
M 20 x 1.5	45 x 14	26484
M 20 x 2.0	45 x 14	26486
M 21 x 1.0	45 x 14	26487
M 21 x 1.5	45 x 14	26488
M 22 x 0.5	55 x 16	26489
M 22 x 0.75	55 x 16	26491
M 22 x 1.0	55 x 16	26490
M 22 x 1.25	55 x 16	26492
M 22 x 1.5	55 x 16	26494
M 22 x 2.0	55 x 16	26496
M 23 x 1.0	55 x 16	26497
M 23 x 1.5	55 x 16	26498
M 24 x 0.5	55 x 16	26601
M 24 x 0.75	55 x 16	26603
M 24 x 1.0	55 x 16	26600
M 24 x 1.25	55 x 16	26602
M 24 x 1.5	55 x 16	26604
M 24 x 2.0	55 x 16	26606
M 25 x 1.0	55 x 16	26607
M 25 x 1.5	55 x 16	26608
M 26 x 1.0	55 x 16	26610
M 26 x 1.5	55 x 16	26612
M 26 x 2.0	55 x 16	26614
M 27 x 1.0	65 x 18	26616
M 27 x 1.5	65 x 18	26617
M 27 x 2.0	65 x 18	26618
M 28 x 1.0	65 x 18	26620
M 28 x 1.5	65 x 18	26622
M 28 x 2.0	65 x 18	26624
M 29 x 1.5	65 x 18	26626
M 30 x 1.0	65 x 18	26628
M 30 x 1.5	65 x 18	26630
M 30 x 2.0	65 x 18	26632

Round Dies
metric-fine ISO-thread DIN 13

圆板牙
公制细牙ISO螺纹 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
M 30 x 3.0	65 x 25	26634
M 32 x 1.0	65 x 18	26639
M 32 x 1.5	65 x 18	26636
M 32 x 2.0	65 x 18	26635
M 32 x 3.0	65 x 25	26637
M 33 x 1.5	65 x 18	26638
M 33 x 2.0	65 x 18	26640
M 33 x 3.0	65 x 25	26642
M 34 x 1.0	65 x 18	26643
M 34 x 1.5	65 x 18	26644
M 34 x 2.0	65 x 18	26646
M 35 x 1.0	65 x 18	26647
M 35 x 1.5	65 x 18	26648
M 35 x 2.0	65 x 18	26649
M 36 x 1.0	65 x 18	26651
M 36 x 1.5	65 x 18	26650
M 36 x 2.0	65 x 18	26652
M 36 x 3.0	65 x 25	26654
M 37 x 1.5	65 x 18	26653
M 38 x 1.0	75 x 20	26655
M 38 x 1.5	75 x 20	26656
M 38 x 2.0	75 x 20	26657
M 38 x 3.0	75 x 30	26659
M 39 x 1.5	75 x 20	26658
M 39 x 2.0	75 x 20	26660
M 39 x 3.0	75 x 30	26662
M 40 x 1.0	75 x 20	26663
M 40 x 1.5	75 x 20	26664
M 40 x 2.0	75 x 20	26666
M 40 x 3.0	75 x 30	26668
M 42 x 1.0	75 x 20	26669
M 42 x 1.5	75 x 20	26670
M 42 x 2.0	75 x 20	26672
M 42 x 3.0	75 x 30	26674
M 44 x 1.5	90 x 22	26671
M 44 x 2.0	90 x 22	26673
M 45 x 1.0	90 x 22	26675
M 45 x 1.5	90 x 22	26676
M 45 x 2.0	90 x 22	26678
M 45 x 3.0	90 x 36	26680
M 46 x 1.5	90 x 22	26681
M 48 x 1.0	90 x 22	26683
M 48 x 1.5	90 x 22	26682
M 48 x 2.0	90 x 22	26684
M 48 x 3.0	90 x 36	26686
M 50 x 1.5	90 x 22	26688
M 50 x 2.0	90 x 22	26690
M 50 x 3.0	90 x 36	26692
M 52 x 1.5	90 x 22	26694

Round Dies
metric-fine ISO-thread DIN 13

圆板牙
公制细牙ISO螺纹 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
M 52 x 3.0	90 x 36	26698
M 54 x 1.0	105 x 22	28267
M 54 x 1.5	105 x 22	28150
M 54 x 2.0	105 x 22	28151
M 54 x 3.0	105 x 36	28152
M 54 x 4.0	105 x 36	28153
M 55 x 1.5	105 x 22	28154
M 55 x 2.0	105 x 22	28155
M 55 x 3.0	105 x 36	28156
M 55 x 4.0	105 x 36	28157
M 56 x 1.0	105 x 22	28268
M 56 x 1.5	105 x 22	28158
M 56 x 2.0	105 x 22	28159
M 56 x 3.0	105 x 36	28160
M 56 x 4.0	105 x 36	28161
M 58 x 1.0	105 x 22	28269
M 58 x 1.5	105 x 22	28162
M 58 x 2.0	105 x 22	28163
M 58 x 3.0	105 x 36	28164
M 58 x 4.0	105 x 36	28165
M 60 x 1.5	105 x 22	28166
M 60 x 2.0	105 x 22	28167
M 60 x 3.0	105 x 36	28168
M 60 x 4.0	105 x 36	28169
M 62 x 1.5	105 x 22	28170
M 62 x 2.0	105 x 22	28171
M 62 x 3.0	105 x 36	28172
M 62 x 4.0	105 x 36	28173
M 63 x 1.5	105 x 22	28174
M 64 x 1.5	120 x 22	28175
M 64 x 2.0	120 x 22	28176
M 64 x 3.0	120 x 36	28177
M 64 x 4.0	120 x 36	28178
M 65 x 1.5	120 x 22	28179
M 65 x 2.0	120 x 22	28180
M 65 x 3.0	120 x 36	28181
M 65 x 4.0	120 x 36	28182
M 68 x 1.5	120 x 22	28183
M 68 x 2.0	120 x 22	28184
M 68 x 3.0	120 x 36	28185
M 68 x 4.0	120 x 36	28186
M 70 x 1.5	120 x 22	28187
M 70 x 2.0	120 x 22	28188
M 70 x 3.0	120 x 36	28189
M 70 x 4.0	120 x 36	28190
M 72 x 1.5	120 x 22	28191
M 72 x 2.0	120 x 22	28192
M 72 x 3.0	120 x 36	28193
M 72 x 4.0	120 x 36	28194

Round Dies
metric-fine ISO-thread DIN 13

圆板牙
公制细牙ISO螺纹 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
M 74 x 2.0	120 x 22	28196
M 74 x 3.0	120 x 36	28197
M 74 x 4.0	120 x 36	28198
M 75 x 1.5	120 x 22	28199
M 75 x 2.0	120 x 22	28200
M 75 x 3.0	120 x 36	28201
M 75 x 4.0	120 x 36	28202
M 76 x 1.5	120 x 22	28203
M 76 x 2.0	120 x 22	28204
M 76 x 3.0	120 x 36	28205
M 76 x 4.0	120 x 36	28206
M 78 x 1.5	120 x 22	28207
M 78 x 2.0	120 x 22	28208
M 78 x 3.0	120 x 36	28209
M 78 x 4.0	120 x 36	28210
M 80 x 1.5	120 x 22	28211
M 80 x 2.0	120 x 22	28212
M 80 x 3.0	120 x 36	28213
M 80 x 4.0	120 x 36	28214
M 82 x 1.5	130 x 25	28215
M 82 x 2.0	130 x 25	28216
M 82 x 3.0	130 x 36	28217
M 82 x 4.0	130 x 36	28218
M 84 x 1.5	130 x 25	28219
M 84 x 2.0	130 x 25	28220
M 84 x 3.0	130 x 36	28221
M 84 x 4.0	130 x 36	28222
M 85 x 1.5	130 x 25	28223
M 85 x 2.0	130 x 25	28224
M 85 x 3.0	130 x 36	28225
M 85 x 4.0	130 x 36	28226
M 86 x 1.5	140 x 22	28227
M 86 x 2.0	140 x 22	28228
M 86 x 3.0	140 x 22	28229
M 86 x 4.0	140 x 22	28230
M 88 x 1.5	140 x 22	28231
M 88 x 2.0	140 x 22	28232
M 88 x 3.0	140 x 22	28233
M 88 x 4.0	140 x 22	28234
M 90 x 1.5	140 x 22	28235
M 90 x 2.0	140 x 22	28236
M 90 x 3.0	140 x 22	28237
M 90 x 4.0	140 x 22	28238
M 92 x 1.5	140 x 22	28239
M 92 x 2.0	140 x 22	28240
M 92 x 3.0	140 x 22	28241
M 92 x 4.0	140 x 22	28242
M 95 x 1.5	140 x 22	28243
M 95 x 2.0	140 x 22	28244

Round Dies
metric-fine ISO-thread DIN 13

圆板牙
公制细牙ISO螺纹 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
M 95 x 4.0	140 x 22	28246
M 96 x 1.5	140 x 22	28247
M 96 x 2.0	140 x 22	28248
M 96 x 3.0	140 x 22	28249
M 96 x 4.0	140 x 22	28250
M 98 x 1.5	150 x 25	28251
M 98 x 2.0	150 x 25	28252
M 98 x 3.0	150 x 25	28253
M 98 x 4.0	150 x 25	28254
M 100 x 1.5	150 x 25	28255
M 100 x 2.0	150 x 25	28256
M 100 x 3.0	150 x 25	28257
M 100 x 4.0	150 x 25	28258
M 105 x 1.5	150 x 25	28259
M 105 x 2.0	150 x 25	28260
M 105 x 3.0	150 x 25	28261
M 105 x 4.0	150 x 25	28262
M 110 x 1.5	160 x 25	28263
M 110 x 2.0	160 x 25	28264
M 110 x 3.0	160 x 25	28265
M 110 x 4.0	160 x 25	28266

Round Dies
Whitworth-thread BS 84

圆板牙
惠氏螺纹 BS 84

BSW / BSF

DIN 223 (DIN EN 22568) HSS

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

Application:

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

应用:

通用
– 抗拉强度小于800N/mm²的非研磨材料
– 非合金钢和低合金钢

VÖLKEL THREADING SOLUTIONS

Round Dies
Unified Coarse thread ANSI B 1.1

圆板牙
统一制粗牙螺纹 ANSI B 1.1

DIN 223 (DIN EN 22568) HSS

UNC

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

Application:

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

应用:

通用
– 抗拉强度小于800N/mm²的非研磨材料
– 非合金钢和低合金钢

Round Dies
Unified Fine thread ANSI B 1.1

圆板牙
统一制细牙螺纹 ANSI B 1.1

DIN 223 (DIN EN 22568) HSS

UNF

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

Application:

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

应用:

通用
– 抗拉强度小于800N/mm²的非研磨材料
– 非合金钢和低合金钢

Round Dies
Unified Extra Fine thread ANSI B 1.1

圆板牙
统一制特细牙螺纹 ANSI B 1.1

DIN 223 (DIN EN 22568) HSS

UNEF

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

Application:

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

应用:

通用
– 抗拉强度小于800N/mm²的非研磨材料
– 非合金钢和低合金钢

Round Dies
Pipe-thread DIN ISO 228

圆板牙
管螺纹 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
G 1/4 x 19	38 x 10	25414
G 3/8 x 19	45 x 14	25416
G 1/2 x 14	45 x 14	25418
G 5/8 x 14	55 x 16	25420
G 3/4 x 14	55 x 16	25422
G 7/8 x 14	65 x 18	25424
G 1" x 11	65 x 18	25426
G 1.1/8 x 11	75 x 20	25430
G 1.1/4 x 11	75 x 20	25434
G 1.3/8 x 11	90 x 22	25438
G 1.1/2 x 11	90 x 22	25442
G 1.5/8 x 11	90 x 22	25446
G 1.3/4 x 11	105 x 22	25450
G 2" x 11	90 x 22	25452
G 2" x 11	105 x 22	25454
G 2.1/4 x 11	120 x 22	25458
G 2.1/2 x 11	120 x 22	25462
G 2.3/4 x 11	120 x 22	25466
G 3" x 11	130 x 25	25470
G 3.1/2 x 11	150 x 25	25474
G 4" x 11	160 x 25	25478

Application:

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

应用:

通用
– 抗拉强度小于800N/mm²的非研磨材料
– 非合金钢和低合金钢

Round Dies
armoured tube thread DIN 40 430

圆板牙
装甲管螺纹 DIN 40 430

DIN 40434 HSS

PG

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

Application:

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

应用:

通用
– 抗拉强度小于800N/mm²的非研磨材料
– 非合金钢和低合金钢

Round Dies
american tapered pipe thread, taper 1:16

圆板牙
美制锥管螺纹, 锥度 1: 16

HSS

NPT

Nominal Diameter	Ø o / d	Art.-No.
NPT 1/16 x 27	25 x 9	23610
NPT 1/8 x 27	30 x 11	23612
NPT 1/4 x 18	38 x 14	23614
NPT 3/8 x 18	45 x 14	23616
NPT 1/2 x 14	45 x 18	23618
NPT 5/8 x 14	55 x 22	23620
NPT 3/4 x 14	55 x 22	23622
NPT 7/8 x 14	65 x 25	23624
NPT 1" x 11.5	65 x 25	23626
NPT 1.1/4 x 11.5	75 x 26	23634
NPT 1.1/2 x 11.5	90 x 27	23642
NPT 2" x 11.5	105 x 28	23654

Application:

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

应用:

通用
– 抗拉强度小于800N/mm²的非研磨材料
– 非合金钢和低合金钢

VÖLKEL THREADING SOLUTIONS

Round Dies
Cycle thread DIN 79012 and BS 811

圆板牙
自行车螺纹DIN 79012和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
FG 2.3 x 56	16 x 5	79302
FG 2.6 x 56	16 x 5	79303
FG 6.35 x 26	20 x 7	79304
FG 7.9 x 26	25 x 9	79305
FG 9.5 x 26	30 x 11	79306
FG 14.3 x 20	38 x 10	79307
FG 14.3 x 20 - LH	38 x 10	79308
FG 25.4 x 24	55 x 16	79309
BSC (BS 811)		
BSC 1/4 x 26	20 x 7	79320
BSC 5/16 x 26	25 x 9	79321
BSC 3/8 x 26	30 x 11	79322
BSC 9/16 x 20	38 x 10	79323
BSC 9/16 x 20 - LH	38 x 10	79324
BSC 1" x 24	55 x 16	79325

Application:

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

应用:

通用
– 抗拉强度小于800N/mm²的非研磨材料
– 非合金钢和低合金钢

Round Dies
Valve thread DIN 7756

圆板牙
阀门螺纹DIN 7756

DIN 223 (DIN EN 22568) HSS

Vg

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

Application:

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

应用:

通用
– 抗拉强度小于800N/mm²的非研磨材料
– 非合金钢和低合金钢

VÖLKEL THREADING SOLUTIONS

Round Dies, gun nosed
metric ISO-thread DIN 13

圆板牙, 螺尖
公制ISO螺纹 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
M 4 x 0.7	20 x 5	57430
M 5 x 0.8	20 x 7	57434
M 6 x 1.0	20 x 7	57438
M 8 x 1.25	25 x 9	57442
M 10 x 1.5	30 x 11	57446
M 12 x 1.75	38 x 14	57450
M 14 x 2.0	38 x 14	57454
M 16 x 2.0	45 x 18	57458
M 18 x 2.5	45 x 18	57462
M 20 x 2.5	45 x 18	57466
M 22 x 2.5	55 x 22	57470
M 24 x 3.0	55 x 22	57474
M 27 x 3.0	65 x 25	57476
M 30 x 3.5	65 x 25	57478

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

优点:
– 高切削性能
– 减少扭矩
– 切屑沿进给的方向不断流出
– 防止切屑堵塞

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

应用:
– 抗拉强度小于1200N/mm²的非研磨材料
– 不锈钢
– 通用

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

圆板牙, 螺尖
公制细牙ISO螺纹 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
M 8 x 0.75	25 x 9	56424
M 8 x 1.0	25 x 9	56426
M 10 x 1.0	30 x 11	56436
M 10 x 1.25	30 x 11	56438
M 12 x 1.0	38 x 10	56444
M 12 x 1.25	38 x 10	56446
M 12 x 1.5	38 x 10	56448
M 14 x 1.25	38 x 10	56454
M 14 x 1.5	38 x 10	56456
M 16 x 1.5	45 x 14	56466
M 18 x 1.5	45 x 14	56472
M 18 x 2.0	45 x 14	56474
M 20 x 1.5	45 x 14	56484
M 20 x 2.0	45 x 14	56486
M 22 x 1.5	55 x 16	56494
M 24 x 1.5	55 x 16	56604

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

优点:
– 高切削性能
– 减少扭矩
– 切屑沿进给的方向不断流出
– 防止切屑堵塞

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

应用:
– 抗拉强度小于1200N/mm²的非研磨材料
– 不锈钢
– 通用

VÖLKEL
THREADING SOLUTIONS

Round Dies, gun nosed
Pipe-thread DIN ISO 228

圆板牙, 螺尖
管螺纹 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
G 1/4 x 19	38 x 10	55414
G 3/8 x 19	45 x 14	55416
G 1/2 x 14	45 x 14	55418
G 3/4 x 14	55 x 16	55422
G 1" x 11	65 x 18	55426

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

优点:
– 高切削性能
– 减少扭矩
– 切屑沿进给的方向不断流出
– 防止切屑堵塞

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

应用:
– 抗拉强度小于1200N/mm²的非研磨材料
– 不锈钢
– 通用

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

圆板牙, 左旋
公制ISO螺纹 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
M 3 x 0.5	20 x 5	27226
M 4 x 0.7	20 x 5	27230
M 5 x 0.8	20 x 7	27234
M 6 x 1.0	20 x 7	27238
M 8 x 1.25	25 x 9	27242
M 10 x 1.5	30 x 11	27246
M 12 x 1.75	38 x 14	27250
M 14 x 2.0	38 x 14	27254
M 16 x 2.0	45 x 18	27258
M 18 x 2.5	45 x 18	27262
M 20 x 2.5	45 x 18	27266
M 22 x 2.5	55 x 22	27270
M 24 x 3.0	55 x 22	27274
M 27 x 3.0	65 x 25	27276
M 30 x 3.5	65 x 25	27278
M 33 x 3.5	65 x 25	27280
M 36 x 4.0	65 x 25	27282
M 39 x 4.0	75 x 30	27284
M 42 x 4.5	75 x 30	27286
M 45 x 4.5	90 x 36	27288
M 48 x 5.0	90 x 36	27290
M 52 x 5.0	90 x 36	27292

Application:

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

应用:

通用
– 抗拉强度小于800N/mm²的非研磨材料
– 非合金钢和低合金钢

VÖLKEL
THREADING SOLUTIONS

Round Dies, *Left Hand*

metric-fine ISO-thread DIN 13

圆板牙, 左旋

公制细牙ISO螺纹 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
M 3 x 0.35	20 x 5	26802
M 3.5 x 0.35	20 x 5	26803
M 4 x 0.35	20 x 5	26804
M 4 x 0.5	20 x 5	26805
M 4.5 x 0.5	20 x 5	26806
M 5 x 0.5	20 x 5	26807
M 5 x 0.75	20 x 7	26808
M 5.5 x 0.5	20 x 5	26809
M 6 x 0.5	20 x 5	26810
M 6 x 0.75	20 x 7	26207
M 7 x 0.5	25 x 9	26811
M 7 x 0.75	25 x 9	26812
M 8 x 0.5	25 x 9	26813
M 8 x 0.75	25 x 9	26210
M 8 x 1.0	25 x 9	26211
M 9 x 0.5	25 x 9	26814
M 9 x 0.75	25 x 9	26815
M 9 x 1.0	25 x 9	26816
M 10 x 0.5	30 x 11	26817
M 10 x 0.75	30 x 11	26818
M 10 x 1.0	30 x 11	26215
M 10 x 1.25	30 x 11	26216
M 11 x 1.0	30 x 11	26819
M 11 x 1.25	30 x 11	26820
M 12 x 0.5	38 x 10	26821
M 12 x 0.75	38 x 10	26822
M 12 x 1.0	38 x 10	26220
M 12 x 1.25	38 x 10	26221
M 12 x 1.5	38 x 10	26222
M 13 x 0.5	38 x 10	26823
M 13 x 0.75	38 x 10	26824
M 13 x 1.0	38 x 10	26825
M 13 x 1.5	38 x 10	26826
M 14 x 0.5	38 x 10	26827
M 14 x 0.75	38 x 10	26828
M 14 x 1.0	38 x 10	26829
M 14 x 1.25	38 x 10	26227
M 14 x 1.5	38 x 10	26228
M 15 x 0.75	38 x 10	26830
M 15 x 1.0	38 x 10	26831
M 15 x 1.5	38 x 10	26832
M 16 x 0.75	45 x 14	26833
M 16 x 1.0	45 x 14	26231
M 16 x 1.25	45 x 14	26834
M 16 x 1.5	45 x 14	26233

►►►

Application:

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

应用:

通用
– 抗拉强度小于800N/mm²的非研磨材料
– 非合金钢和低合金钢

Round Dies, *Left Hand*

metric-fine ISO-thread DIN 13

圆板牙, 左旋

公制细牙ISO螺纹 DIN 13

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

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

Application:

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

应用:

通用
– 抗拉强度小于800N/mm²的非研磨材料
– 非合金钢和低合金钢

VÖLKEL THREADING SOLUTIONS

Round Dies, *Left Hand*

metric-fine ISO-thread DIN 13

圆板牙, 左旋

公制细牙ISO螺纹 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
M 33 x 3.0	65 x 25	26273
M 34 x 1.0	65 x 18	26274
M 34 x 1.5	65 x 18	26275
M 34 x 2.0	65 x 18	26276
M 35 x 1.0	65 x 18	26277
M 35 x 1.5	65 x 18	26278
M 35 x 2.0	65 x 18	26279
M 36 x 1.0	65 x 18	26280
M 36 x 1.5	65 x 18	26281
M 36 x 2.0	65 x 18	26282
M 36 x 3.0	65 x 25	26283
M 37 x 1.5	65 x 18	26284
M 38 x 1.0	75 x 20	26285
M 38 x 1.5	75 x 20	26286
M 38 x 2.0	75 x 20	26287
M 38 x 3.0	75 x 30	26288
M 39 x 1.5	75 x 20	26289
M 39 x 2.0	75 x 20	26290
M 39 x 3.0	75 x 30	26291
M 40 x 1.0	75 x 20	26292
M 40 x 1.5	75 x 20	26293
M 40 x 2.0	75 x 20	26294
M 40 x 3.0	75 x 30	26295
M 42 x 1.0	75 x 20	26296
M 42 x 1.5	75 x 20	26297
M 42 x 2.0	75 x 20	26298
M 42 x 3.0	75 x 30	26299
M 44 x 1.5	90 x 22	26868
M 45 x 1.5	90 x 22	26869
M 45 x 2.0	90 x 22	26870
M 45 x 3.0	90 x 36	26871
M 46 x 1.5	90 x 22	26872
M 48 x 1.5	90 x 22	26873
M 48 x 2.0	90 x 22	26874
M 48 x 3.0	90 x 36	26875
M 50 x 1.5	90 x 22	26876
M 50 x 2.0	90 x 22	26877
M 50 x 3.0	90 x 36	26878
M 52 x 1.5	90 x 22	26879
M 52 x 2.0	90 x 22	26880
M 52 x 3.0	90 x 36	26881

Application:

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

应用:

通用
– 抗拉强度小于800N/mm²的非研磨材料
– 非合金钢和低合金钢

Round Dies, *Left Hand*

Whitworth-thread BS 84

圆板牙, 左旋

惠氏螺纹 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
BSW 5/32 x 32	20 x 5	22208
BSW 3/16 x 24	20 x 7	22210
BSW 1/4 x 20	20 x 7	22214
BSW 5/16 x 18	25 x 9	22216
BSW 3/8 x 16	30 x 11	22218
BSW 7/16 x 14	30 x 11	22220
BSW 1/2 x 12	38 x 14	22222
BSW 9/16 x 12	38 x 14	22224
BSW 5/8 x 11	45 x 18	22226
BSW 3/4 x 10	45 x 18	22230
BSW 7/8 x 9	55 x 22	22234
BSW 1" x 8	55 x 22	22238

Application:

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

应用:

通用
– 抗拉强度小于800N/mm²的非研磨材料
– 非合金钢和低合金钢

VÖLKEL
THREADING SOLUTIONS

Round Dies, *Left Hand*

Unified thread ANSI B 1.1

圆板牙, 左旋

统一制螺纹 ANSI B 1.1

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
UNC Nr. 8 x 32	20 x 7	23208
UNC Nr.10 x 24	20 x 7	23210
UNC 1/4 x 20	20 x 7	23214
UNC 5/16 x 18	25 x 9	23216
UNC 3/8 x 16	30 x 11	23218
UNC 7/16 x 14	38 x 14	23220
UNC 1/2 x 13	38 x 14	23222
UNC 9/16 x 12	38 x 14	23224
UNC 5/8 x 11	45 x 18	23226
UNC 3/4 x 10	45 x 18	23230
UNC 7/8 x 9	55 x 22	23234
UNC 1" x 8	55 x 22	23238
UNF		
UNF Nr. 10 x 32	20 x 7	24210
UNF 1/4 x 28	20 x 7	24214
UNF 5/16 x 24	25 x 9	24216
UNF 3/8 x 24	30 x 11	24218
UNF 7/16 x 20	30 x 11	24220
UNF 1/2 x 20	38 x 10	24222
UNF 9/16 x 18	38 x 10	24224
UNF 5/8 x 18	45 x 14	24226
UNF 3/4 x 16	45 x 14	24230
UNF 7/8 x 14	55 x 16	24234
UNF 1" x 12	55 x 16	24238

Application:

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

应用:

通用
– 抗拉强度小于800N/mm²的非研磨材料
– 非合金钢和低合金钢

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

圆板牙, 左旋
管螺纹 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
G 1/4 x 19	38 x 10	25214
G 3/8 x 19	45 x 14	25216
G 1/2 x 14	45 x 14	25218
G 5/8 x 14	55 x 16	25220
G 3/4 x 14	55 x 16	25222
G 7/8 x 14	65 x 18	25224
G 1" x 11	65 x 18	25226
G 1.1/8 x 11	75 x 20	25230
G 1.1/4 x 11	75 x 20	25234
G 1.3/8 x 11	90 x 22	25238
G 1.1/2 x 11	90 x 22	25242
G 1.5/8 x 11	90 x 22	25246
G 1.3/4 x 11	105 x 22	25250
G 2" x 11	105 x 22	25254

Application:

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

应用:

通用
– 抗拉强度小于800N/mm²的非研磨材料
– 非合金钢和低合金钢

Round Split Dies
metric ISO-thread DIN 13

可调圆板牙
公制ISO螺纹 DIN 13

BS1127 ; 1950 HSS Tol: 6g

M

Nominal Diameter mm	o / d	Width	Art.-No.
M 2 x 0.4	13/16	1/4	80000
M 2.2 x 0.45	13/16	1/4	80001
M 2.5 x 0.45	13/16	1/4	80002
M 3 x 0.5	13/16	1/4	80003
M 3.5 x 0.6	13/16	1/4	80004
M 4 x 0.7	13/16	1/4	80005
M 4.5 x 0.75	13/16	1/4	80006
M 5 x 0.8	13/16	1/4	80007
M 6 x 1.0	13/16	1/4	80008
M 7 x 1.0	13/16	1/4	80009
M 5 x 0.8	1"	3/8	80010
M 6 x 1.0	1"	3/8	80011
M 7 x 1.0	1"	3/8	80012
M 8 x 1.25	1"	3/8	80013
M 9 x 1.25	1"	3/8	80014
M 10 x 1.5	1"	3/8	80015
M 12 x 1,75	1"	3/8	80016
M 6 x 1.0	1.5/16	7/16	80020
M 7 x 1.0	1.5/16	7/16	80021
M 8 x 1.25	1.5/16	7/16	80022
M 9 x 1.25	1.5/16	7/16	80023
M 10 x 1.5	1.5/16	7/16	80024
M 11 x 1.5	1.5/16	7/16	80025
M 12 x 1.75	1.5/16	7/16	80026
M 14 x 2.0	1.5/16	7/16	80027
M 10 x 1.5	1.1/2	1/2	80030
M 11 x 1.5	1.1/2	1/2	80031
M 12 x 1.75	1.1/2	1/2	80032
M 14 x 2.0	1.1/2	1/2	80033
M 16 x 2.0	1.1/2	1/2	80034
M 18 x 2.5	1.1/2	1/2	80035
M 20 x 2.5	1.1/2	1/2	80036
M 12 x 1.75	2"	5/8	80040
M 14 x 2.0	2"	5/8	80041
M 16 x 2.0	2"	5/8	80042
M 18 x 2.5	2"	5/8	80043
M 20 x 2.5	2"	5/8	80044
M 22 x 2.5	2"	5/8	80045
M 24 x 3.0	2"	5/8	80046
M 27 x 3.0	3"	7/8	80050
M 30 x 3.5	3"	7/8	80051
M 33 x 3.5	3"	7/8	80052
M 36 x 4.0	3"	7/8	80053
M 39 x 4.0	3"	7/8	80054
M 42 x 4.5	4"	1	80060
M 45 x 4.5	4"	1	80061
M 48 x 5.0	4"	1	80062

Round Split Dies
metric-fine ISO-thread DIN 13

可调圆板牙
公制细牙ISO螺纹 DIN 13

BS1127 ; 1950 HSS Tol: 6g

Mf

Nominal Diameter mm	o / d	Width	Art.-No.
M 3 x 0.35	13/16	1/4	81010
M 4 x 0.5	13/16	1/4	81011
M 4 x 0.75	13/16	1/4	81012
M 5 x 0.5	13/16	1/4	81013
M 5 x 0.90	13/16	1/4	81014
M 6 x 0.75	13/16	1/4	81015
M 6 x 0.75	1"	3/8	81020
M 8 x 0.75	1"	3/8	81021
M 8 x 1.0	1"	3/8	81022
M 9 x 1.0	1"	3/8	81023
M 10 x 0.75	1"	3/8	81024
M 10 x 1.0	1"	3/8	81025
M 10 x 1.25	1"	3/8	81026
M 12 x 1.0	1.5/16	7/16	81030
M 12 x 1.25	1.5/16	7/16	81031
M 12 x 1.5	1.5/16	7/16	81032
M 14 x 1.25	1.5/16	7/16	81033
M 14 x 1.5	1.5/16	7/16	81034
M 16 x 1.5	1.5/16	7/16	81035
M 14 x 1.0	1.1/2	1/2	81040
M 14 x 1.25	1.1/2	1/2	81041
M 14 x 1.5	1.1/2	1/2	81042
M 16 x 1.0	1.1/2	1/2	81043
M 16 x 1.5	1.1/2	1/2	81044
M 18 x 1.0	1.1/2	1/2	81045
M 18 x 1.25	1.1/2	1/2	81046
M 18 x 1.5	1.1/2	1/2	81047
M 18 x 2.0	1.1/2	1/2	81048
M 20 x 1.0	1.1/2	1/2	81049
M 20 x 1.25	1.1/2	1/2	81050
M 20 x 1.5	1.1/2	1/2	81051
M 20 x 2.0	1.1/2	1/2	81052
M 18 x 1.5	2"	5/8	81060
M 20 x 1.0	2"	5/8	81061
M 20 x 1.5	2"	5/8	81062
M 22 x 1.5	2"	5/8	81063
M 24 x 1.5	2"	5/8	81064
M 24 x 2.0	2"	5/8	81065
M 25 x 1.5	2"	5/8	81066
M 26 x 1.5	2"	5/8	81067
M 27 x 2.0	2.1/4"	3/4	81080
M 30 x 2.0	2.1/4"	3/4	81081
M 27 x 1.5	3"	7/8	81090
M 30 x 1.5	3"	7/8	81091
M 36 x 2.0	3"	7/8	81092
M 36 x 3.0	3"	7/8	81093

Application:

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

应用:

通用
– 抗拉强度小于800N/mm²的非研磨材料
– 非合金钢和低合金钢

VÖLKEL
THREADING SOLUTIONS

Round Split Dies
Whitworth-thread BS 84

可调圆板牙
惠氏螺纹 BS 84

BS1127 ; 1950 HSS

BSW

Nominal Diameter mm	o / d	Width	Art.-No.
BSW			
BSW 3/32 x 48	13/16	1/4	84001
BSW 1/8 x 40	13/16	1/4	84002
BSW 5/32 x 32	13/16	1/4	84003
BSW 3/16 x 24	13/16	1/4	84004
BSW 7/32 x 24	13/16	1/4	84005
BSW 1/4 x 20	13/16	1/4	84006
BSW 1/4 x 20	1"	3/8	84010
BSW 5/16 x 18	1"	3/8	84011
BSW 3/8 x 16	1"	3/8	84012
BSW 7/16 x 14	1"	3/8	84013
BSW 1/2 x 12	1"	3/8	84014
BSW 1/4 x 20	1.5/16	7/16	84020
BSW 5/16 x 18	1.5/16	7/16	84021
BSW 3/8 x 16	1.5/16	7/16	84022
BSW 7/16 x 14	1.5/16	7/16	84023
BSW 1/2 x 12	1.5/16	7/16	84024
BSW 9/16 x 12	1.5/16	7/16	84025
BSW 3/8 x 16	1.1/2	1/2	84030
BSW 7/16 x 14	1.1/2	1/2	84031
BSW 1/2 x 12	1.1/2	1/2	84032
BSW 9/16 x 12	1.1/2	1/2	84033
BSW 5/8 x 11	1.1/2	1/2	84034
BSW 3/4 x 10	1.1/2	1/2	84035
BSW 1/2 x 12	2"	5/8	84040
BSW 9/16 x 12	2"	5/8	84041
BSW 5/8 x 11	2"	5/8	84042
BSW 3/4 x 10	2"	5/8	84043
BSW 7/8 x 9	2"	5/8	84044
BSW 1 x 8	2"	5/8	84045
BSW 1.1/8 x 7	3"	7/6	84050
BSW 1.1/4 x 7	3"	7/6	84051
BSW 1.3/8 x 6	3"	7/8	84052
BSW 1.1/2 x 6	3"	7/8	84053
BSW Fine			
BSW 1/4 x 26	1"	3/8	84110
BSW 5/16 x 26	1"	3/8	84111
BSW 3/8 x 26	1"	3/8	84112
BSW 7/16 x 26	1.5/16	7/16	84120
BSW 1/2 x 26	1.5/16	7/16	84121

Application:

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

应用:

通用
– 抗拉强度小于800N/mm²的非研磨材料
– 非合金钢和低合金钢

Round Split Dies
British Standard Fine thread BS 84

可调圆板牙
英标细牙螺纹 BS 84

BS1127 ; 1950 HSS

BSF

Nominal Diameter mm	o / d	Width	Art.-No.
BSF 3/16 x 32	13/16	1/4	85004
BSF 7/32 x 30	13/16	1/4	85005
BSF 1/4 x 26	13/16	1/4	85006
BSF 1/4 x 26	1"	3/8	85010
BSF 5/16 x 22	1"	3/8	85011
BSF 3/8 x 20	1"	3/8	85012
BSF 7/16 x 18	1"	3/8	85013
BSF 1/2 x 16	1"	3/8	85014
BSF 1/4 x 26	1.5/16	7/16	85020
BSF 5/16 x 22	1.5/16	7/16	85021
BSF 3/8 x 20	1.5/16	7/16	85022
BSF 7/16 x 18	1.5/16	7/16	85023
BSF 1/2 x 16	1.5/16	7/16	85024
BSF 9/16 x 16	1.5/16	7/16	85025
BSF 3/8 x 20	1.1/2	1/2	85030
BSF 7/16 x 18	1.1/2	1/2	85031
BSF 1/2 x 16	1.1/2	1/2	85032
BSF 9/16 x 16	1.1/2	1/2	85033
BSF 5/8 x 14	1.1/2	1/2	85034
BSF 3/4 x 12	1.1/2	1/2	85035
BSF 1/2 x 16	2"	1/2	85040
BSF 9/16 x 16	2"	5/8	85041
BSF 5/8 x 14	2"	5/8	85042
BSF 3/4 x 12	2"	5/8	85043
BSF 7/8 x 11	2"	5/8	85044
BSF 1 x 10	2"	5/8	85045

Application:

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

应用:

通用
– 抗拉强度小于800N/mm²的非研磨材料
– 非合金钢和低合金钢

Round Split Dies

Unified Coarse thread ANSI B 1.1

可调圆板牙

统一制粗牙螺纹 ANSI B 1.1

BS1127 ; 1950 HSS

UNC

Nominal Diameter mm		o / d	Width	Art.-No.
UNC	4 x 40	13/16	1/4	82004
UNC	5 x 40	13/16	1/4	82005
UNC	6 x 32	13/16	1/4	82006
UNC	8 x 32	13/16	1/4	82008
UNC	10 x 24	13/16	1/4	82010
UNC	12 x 24	13/16	1/4	82012
UNC	1/4 x 20	13/16	1/4	82013
UNC	1/4 x 20	1"	3/8	82020
UNC	5/16 x 18	1"	3/8	82021
UNC	3/8 x 16	1"	3/8	82022
UNC	7/16 x 14	1"	3/8	82023
UNC	1/2 x 13	1"	3/8	82024
UNC	1/4 x 20	1.5/16	7/16	82030
UNC	5/16 x 18	1.5/16	7/16	82031
UNC	3/8 x 16	1.5/16	7/16	82032
UNC	7/16 x 14	1.5/16	7/16	82033
UNC	1/2 x 13	1.5/16	7/16	82034
UNC	9/16 x 12	1.5/16	7/16	82035
UNC	3/8 x 16	1.1/2	1/2	82040
UNC	7/16 x 14	1.1/2	1/2	82041
UNC	1/2 x 13	1.1/2	1/2	82042
UNC	9/16 x 12	1.1/2	1/2	82043
UNC	5/8 x 11	1.1/2	1/2	82044
UNC	3/4 x 10	1.1/2	1/2	82045
UNC	1/2 x 13	2"	5/8	82050
UNC	9/16 x 12	2"	5/8	82051
UNC	5/8 x 11	2"	5/8	82052
UNC	3/4 x 10	2"	5/8	82053
UNC	7/8 x 9	2"	5/8	82054
UNC	1 x 8	2"	5/8	82055
UNC	1.1/4 x 7	3"	7/8	82056
UNC	1.3/8 x 6	3"	7/8	82057
UNC	1.1/2 x 6	3"	7/8	82058

Application:

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

应用:

通用
– 抗拉强度小于800N/mm²的非研磨材料
– 非合金钢和低合金钢

Round Split Dies
Unified Fine thread ANSI B 1.1

可调圆板牙
统一制细牙螺纹 ANSI B 1.1

BS1127 ; 1950 HSS UNF

Nominal Diameter mm		o / d	Width	Art.-No.
UNF	4 x 48	13/16	1/4	83004
UNF	5 x 44	13/16	1/4	83005
UNF	6 x 40	13/16	1/4	83006
UNF	8 x 36	13/16	1/4	83008
UNF	10 x 32	13/16	1/4	83010
UNF	12 x 28	13/16	1/4	83012
UNF	1/4 x 28	13/16	1/4	83013
UNF	1/4 x 28	1"	3/8	83020
UNF	5/16 x 24	1"	3/8	83021
UNF	3/8 x 24	1"	3/8	83022
UNF	7/16 x 20	1"	3/8	83023
UNF	1/2 x 20	1"	3/8	83024
UNF	1/4 x 28	1.5/16	7/16	83030
UNF	5/16 x 24	1.5/16	7/16	83031
UNF	3/8 x 24	1.5/16	7/16	83032
UNF	7/16 x 20	1.5/16	7/16	83033
UNF	1/2 x 20	1.5/16	7/16	83034
UNF	9/16 x 18	1.5/16	7/16	83035
UNF	3/8 x 24	1.1/2	1/2	83040
UNF	7/16 x 20	1.1/2	1/2	83041
UNF	1/2 x 20	1.1/2	1/2	83042
UNF	9/16 x 18	1.1/2	1/2	83043
UNF	5/8 x 18	1.1/2	1/2	83044
UNF	3/4 x 16	1.1/2	1/2	83045
UNF	1/2 x 20	2"	5/8	83050
UNF	9/16 x 18	2"	5/8	83051
UNF	5/8 x 18	2"	5/8	83052
UNF	3/4 x 16	2"	5/8	83053
UNF	7/8 x 14	2"	5/8	83054
UNF	1 x 12	2"	5/8	83055
UNF	1 x 14	2"	5/8	83056
UNF	1.1/8 x 12	3"	7/8	83057
UNF	1.1/4 x 12	3"	7/8	83059
UNF	1.3/8 x 12	3"	7/8	83061
UNF	1.1/2 x 12	3"	7/8	83063

Application:

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

应用:

通用
– 抗拉强度小于800N/mm²的非研磨材料
– 非合金钢和低合金钢

Round Split Dies

BA-thread BS 93

可调圆板牙

BA螺纹 BS 93

BS1127 ; 1950 HSS

BA

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

Application:

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

应用:

通用
– 抗拉强度小于800N/mm²的非研磨材料
– 非合金钢和低合金钢

Round Split Dies
Pipe-thread DIN ISO 228

可调圆板牙
管螺纹 DIN ISO 228

BS1127 ; 1950 HSS

G (BSPF)

Nominal Diameter mm		o / d	Width	Art.-No.
G	1/8 x 28	1"	3/8	86004
G	1/8 x 28	1.5/16	7/16	86012
G	1/4 x 19	1.5/16	7/16	86014
G	1/8 x 28	1.1/2	1/2	86020
G	1/4 x 19	1.1/2	1/2	86022
G	3/8 x 19	1.1/2	1/2	86024
G	1/2 x 19	1.1/2	1/2	86026
G	1/4 x 19	2"	5/8	86030
G	3/8 x 19	2"	5/8	86031
G	1/2 x 14	2"	5/8	86032
G	5/8 x 14	2"	5/8	86033
G	3/4 x 14	2"	5/8	86034
G	3/8 x 19	2.1/4	11/16	86040
G	3/4 x 14	2.1/4	11/16	86041
G	7/8 x 14	2.1/4	11/16	86042
G	1 x 11	2.1/4	11/16	86043
G	1 x 11	3"	7/8	86050
G	1.1/4 x 11	3"	7/8	86054
G	1.1/2 x 11	4"	1	86060
G	2 x 11	4"	1	86064

Application:

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

应用:

通用
– 抗拉强度小于800N/mm²的非研磨材料
– 非合金钢和低合金钢

Hexagon Die Nuts
metric ISO-thread DIN 13

六方板牙
公制ISO螺纹 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
M 3.5 x 0.6	19 x 5	27128
M 4 x 0.7	19 x 5	27130
M 5 x 0.8	19 x 7	27134
M 6 x 1.0	19 x 7	27138
M 7 x 1.0	22 x 9	27140
M 8 x 1.25	22 x 9	27142
M 9 x 1.25	22 x 9	27144
M 10 x 1.5	27 x 11	27146
M 11 x 1.5	27 x 11	27148
M 12 x 1.75	36 x 14	27150
M 14 x 2.0	36 x 14	27154
M 16 x 2.0	41 x 18	27158
M 18 x 2.5	41 x 18	27162
M 20 x 2.5	41 x 18	27166
M 22 x 2.5	50 x 22	27170
M 24 x 3.0	50 x 22	27174
M 27 x 3.0	60 x 25	27176
M 30 x 3.5	60 x 25	27178
M 33 x 3.5	60 x 25	27180
M 36 x 4.0	60 x 25	27182
M 39 x 4.0	70 x 30	27184
M 42 x 4.5	70 x 30	27186
M 45 x 4.5	85 x 36	27188
M 48 x 5.0	85 x 36	27190
M 52 x 5.0	85 x 36	27192
M 56 x 5.5	100 x 36	27194
M 60 x 5.5	100 x 36	27196
M 64 x 6.0	100 x 36	27198
M 68 x 6.0	115 x 36	27199

Application:

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

应用:

清牙和修复损坏的螺纹
通用于不方便加工的地方

Hexagon Die Nuts
metric-fine ISO-thread DIN 13

六方板牙
公制细牙ISO螺纹 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
M 4 x 0.35	19 x 5	26110
M 4 x 0.5	19 x 5	26112
M 5 x 0.5	19 x 5	26114
M 5 x 0.75	19 x 7	26116
M 6 x 0.5	19 x 5	26117
M 6 x 0.75	19 x 7	26118
M 7 x 0.75	22 x 9	26120
M 8 x 0.5	22 x 9	26122
M 8 x 0.75	22 x 9	26124
M 8 x 1.0	22 x 9	26126
M 9 x 0.75	22 x 9	26128
M 9 x 1.0	22 x 9	26130
M 10 x 0.75	27 x 11	26132
M 10 x 1.0	27 x 11	26136
M 10 x 1.25	27 x 11	26138
M 11 x 1.0	27 x 11	26140
M 11 x 1.25	27 x 11	26142
M 12 x 0.75	36 x 10	26143
M 12 x 1.0	36 x 10	26144
M 12 x 1.25	36 x 10	26146
M 12 x 1.5	36 x 10	26148
M 13 x 1.0	36 x 10	26150
M 13 x 1.5	36 x 10	26151
M 14 x 0.75	36 x 10	26152
M 14 x 1.0	36 x 10	26153
M 14 x 1.25	36 x 10	26154
M 14 x 1.5	36 x 10	26156
M 15 x 1.0	36 x 10	26158
M 15 x 1.5	36 x 10	26160
M 16 x 1.0	41 x 14	26162
M 16 x 1.25	41 x 14	26164
M 16 x 1.5	41 x 14	26166
M 18 x 1.0	41 x 14	26170
M 18 x 1.25	41 x 14	26171
M 18 x 1.5	41 x 14	26172
M 18 x 2.0	41 x 14	26174
M 20 x 1.0	41 x 14	26178
M 20 x 1.25	41 x 14	26180
M 20 x 1.5	41 x 14	26184
M 20 x 2.0	41 x 14	26186
M 21 x 1.5	41 x 14	26188
M 22 x 1.0	50 x 16	26190
M 22 x 1.25	50 x 16	26192
M 22 x 1.5	50 x 16	26194
M 22 x 2.0	50 x 16	26196
M 23 x 1.5	50 x 16	26198
M 24 x 1.0	50 x 16	26700
M 24 x 1.25	50 x 16	26702
M 24 x 1.5	50 x 16	26704

Hexagon Die Nuts
metric-fine ISO-thread DIN 13

六方板牙
公制细牙ISO螺纹 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
M 25 x 1.0	50 x 16	26707
M 25 x 1.5	50 x 16	26708
M 26 x 1.0	50 x 16	26710
M 26 x 1.5	50 x 16	26712
M 26 x 2.0	50 x 16	26714
M 27 x 1.0	60 x 18	26717
M 27 x 1.5	60 x 18	26716
M 27 x 2.0	60 x 18	26718
M 28 x 1.0	60 x 18	26720
M 28 x 1.5	60 x 18	26722
M 28 x 2.0	60 x 18	26724
M 29 x 1.5	60 x 18	26726
M 30 x 1.0	60 x 18	26728
M 30 x 1.5	60 x 18	26730
M 30 x 2.0	60 x 18	26732
M 30 x 3.0	60 x 25	26734
M 32 x 1.5	60 x 18	26736
M 32 x 2.0	60 x 18	26735
M 32 x 3.0	60 x 25	26737
M 33 x 1.5	60 x 18	26738
M 33 x 2.0	60 x 18	26740
M 33 x 3.0	60 x 25	26742
M 34 x 1.5	60 x 18	26744
M 34 x 2.0	60 x 18	26746
M 35 x 1.5	60 x 18	26748
M 36 x 1.5	60 x 18	26750
M 36 x 2.0	60 x 18	26752
M 36 x 3.0	60 x 25	26754
M 38 x 1.5	70 x 20	26756
M 39 x 1.5	70 x 20	26758
M 39 x 2.0	70 x 20	26760
M 39 x 3.0	70 x 30	26762
M 40 x 1.5	70 x 20	26764
M 40 x 2.0	70 x 20	26766
M 40 x 3.0	70 x 30	26768
M 42 x 1.5	70 x 20	26770
M 42 x 2.0	70 x 20	26772
M 42 x 3.0	70 x 30	26774
M 45 x 1.5	85 x 22	26776
M 45 x 2.0	85 x 22	26778
M 45 x 3.0	85 x 36	26780
M 48 x 1.5	85 x 22	26782
M 48 x 2.0	85 x 22	26784
M 48 x 3.0	85 x 36	26786
M 50 x 1.5	85 x 22	26788
M 50 x 2.0	85 x 22	26790
M 50 x 3.0	85 x 36	26792
M 52 x 1.5	85 x 22	26794
M 52 x 2.0	85 x 22	26796
M 52 x 3.0	85 x 36	26798

Hexagon Die Nuts
Whitworth-thread BS 84

六方板牙
惠氏螺纹 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
BSW 3/16 x 24	19 x 7	22110
BSW 1/4 x 20	19 x 7	22114
BSW 5/16 x 18	22 x 9	22116
BSW 3/8 x 16	27 x 11	22118
BSW 7/16 x 14	27 x 11	22120
BSW 1/2 x 12	36 x 14	22122
BSW 9/16 x 12	36 x 14	22124
BSW 5/8 x 11	41 x 18	22126
BSW 3/4 x 10	41 x 18	22130
BSW 7/8 x 9	50 x 22	22134
BSW 1" x 8	50 x 22	22138
BSW 1.1/8 x 7	60 x 25	22142
BSW 1.1/4 x 7	60 x 25	22146
BSW 1.3/8 x 6	60 x 25	22150
BSW 1.1/2 x 6	70 x 30	22154
BSW 2" x 4.1/2	85 x 36	22170
BSW 2.1/4 x 4	100 x 36	22172
BSW 2.1/2 x 4	115 x 36	22174
BSW 2.3/4 x 3.1/2	115 x 36	22176
BSW 3" x 3.1/2	115 x 36	22178
BSF		
BSF 3/16 x 32	19 x 7	22510
BSF 1/4 x 26	19 x 7	22514
BSF 5/16 x 22	22 x 9	22516
BSF 3/8 x 20	27 x 11	22518
BSF 7/16 x 18	27 x 11	22520
BSF 1/2 x 16	36 x 10	22522
BSF 9/16 x 16	36 x 10	22524
BSF 5/8 x 14	41 x 14	22526
BSF 3/4 x 12	41 x 14	22530
BSF 7/8 x 11	50 x 16	22534
BSF 1" x 10	50 x 16	22538

Application:

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

应用:

清牙和修复损坏的螺纹
通用于不方便加工的地方

VÖLKEL THREADING SOLUTIONS

Hexagon Die Nuts
Unified thread ANSI B 1.1

六方板牙
统一制螺纹 ANSI B 1.1

DIN 382 HSS

UNC / UNF

Nominal Diameter	Width across flats mm	Art.-No.
UNC		
UNC 1/4 x 20	19 x 7	23114
UNC 5/16 x 18	22 x 9	23116
UNC 3/8 x 16	27 x 11	23118
UNC 7/16 x 14	27 x 11	23120
UNC 1/2 x 13	36 x 14	23122
UNC 9/16 x 12	36 x 14	23124
UNC 5/8 x 11	41 x 18	23126
UNC 3/4 x 10	41 x 18	23130
UNC 7/8 x 9	50 x 22	23134
UNC 1" x 8	50 x 22	23138
UNC 1.1/8 x 7	60 x 25	23142
UNC 1.1/4 x 7	60 x 25	23146
UNC 1.3/8 x 6	60 x 25	23150
UNC 1.1/2 x 6	70 x 30	23154
UNF		
UNF 1/4 x 28	19 x 7	24114
UNF 5/16 x 24	22 x 9	24116
UNF 3/8 x 24	27 x 11	24118
UNF 7/16 x 20	27 x 11	24120
UNF 1/2 x 20	36 x 10	24122
UNF 9/16 x 18	36 x 10	24124
UNF 5/8 x 18	41 x 14	24126
UNF 3/4 x 16	41 x 14	24130
UNF 7/8 x 14	50 x 16	24134
UNF 1" x 12	50 x 16	24138
UNF 1.1/8 x 12	60 x 18	24142
UNF 1.1/4 x 12	60 x 18	24146
UNF 1.3/8 x 12	60 x 18	24150
UNF 1.1/2 x 12	70 x 20	24154

Application:

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

应用:

清牙和修复损坏的螺纹
通用于不方便加工的地方

Hexagon Die Nuts
Unified thread ANSI B 1.1

六方板牙
统一制螺纹 ANSI B 1.1

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
UN 1.1/4 x 8	60 x 25	24172
UN 1.3/8 x 8	60 x 25	24173
UN 1.1/2 x 8	70 x 30	24174
UN 1.5/8 x 8	70 x 30	24175
UN 1.3/4 x 8	85 x 36	24176
UN 1.7/8 x 8	85 x 22	24177
UN 2" x 8	85 x 22	24178
UN 2.1/8 x 8	85 x 22	24179
UN 2.1/4 x 8	100 x 22	24180
UN 2.1/2 x 8	115 x 22	24181

Application:

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

应用:

清牙和修复损坏的螺纹
通用于不方便加工的地方

Hexagon Die Nuts
Pipe-thread DIN ISO 228

六方板牙
管螺纹 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
G 1/4 x 19	36 x 10	25514
G 3/8 x 19	41 x 14	25516
G 1/2 x 14	41 x 14	25518
G 5/8 x 14	50 x 16	25520
G 3/4 x 14	50 x 16	25522
G 7/8 x 14	60 x 18	25524
G 1" x 11	60 x 18	25526
G 1.1/8 x 11	70 x 20	25530
G 1.1/4 x 11	70 x 20	25534
G 1.3/8 x 11	85 x 22	25538
G 1.1/2 x 11	85 x 22	25542
G 1.5/8 x 11	85 x 22	25546
G 1.3/4 x 11	100 x 22	25550
G 2" x 11	100 x 22	25554

Application:

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

应用：

清牙和修复损坏的螺纹
通用于不方便加工的地方

Hexagon Die Nuts

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

六方板牙

锥管螺纹, 锥度 1:16, 牙型角55°

DIN 382 HSS

R (BSPT)

Nominal Diameter	Width across flats mm	Art.-No.
R 1/8 x 28	27 x 11	23562
R 1/4 x 19	36 x 14	23564
R 3/8 x 19	41 x 15	23566
R 1/2 x 14	50 x 19	23568
R 3/4 x 14	60 x 20	23572
R 1" x 11	60 x 25	23576
R 1.1/4 x 11	85 x 26	23578
R 1.1/2 x 11	85 x 26	23580
R 2" x 11	100 x 31	23584

Application:

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

应用:

清牙和修复损坏的螺纹
通用于不方便加工的地方

Hexagon Die Nuts

american tapered pipe thread, taper 1:16

六方板牙

美制锥管螺纹, 锥度 1:16

DIN 382 HSS

NPT

Nominal Diameter	Width across flats mm	Art.-No.
NPT 1/16 x 27	22 x 9	23510
NPT 1/8 x 27	27 x 11	23512
NPT 1/4 x 18	36 x 14	23514
NPT 3/8 x 18	41 x 14	23516
NPT 1/2 x 14	50 x 16	23518
NPT 3/4 x 14	60 x 18	23522
NPT 1" x 11.5	60 x 25	23526
NPT 1.1/4 x 11.5	70 x 25	23528
NPT 1.1/2 x 11.5	85 x 28	23530
NPT 2" x 11.5	100 x 28	23534

Application:

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

应用:

清牙和修复损坏的螺纹
通用于不方便加工的地方

Hexagon Die Nuts, *Left Hand*

metric ISO-thread DIN 13

六方板牙，左旋

公制ISO螺纹 DIN 13

DIN 382 HSS

M

Nominal Diameter	Width across flats mm	Art.-No.
M 3 x 0.5	19 x 5	28426
M 4 x 0.7	19 x 5	28430
M 5 x 0.8	19 x 7	28434
M 6 x 1.0	19 x 7	28438
M 8 x 1.25	22 x 9	28442
M 10 x 1.5	27 x 11	28446
M 12 x 1.75	36 x 14	28450
M 14 x 2.0	36 x 14	28454
M 16 x 2.0	41 x 18	28458
M 18 x 2.5	41 x 18	28462
M 20 x 2.5	41 x 18	28466
M 22 x 2.5	50 x 22	28470
M 24 x 3.0	50 x 22	28474
M 27 x 3.0	60 x 25	28476
M 30 x 3.5	60 x 25	28478
M 33 x 3.5	60 x 25	28480
M 36 x 4.0	60 x 25	28482
M 39 x 4.0	70 x 30	28484
M 42 x 4.5	70 x 30	28486
M 45 x 4.5	85 x 36	28488
M 48 x 5.0	85 x 36	28490
M 52 x 5.0	85 x 36	28492

Application:

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

应用：

清牙和修复损坏的螺纹
通用于不方便加工的地方

VÖLKEL
THREADING SOLUTIONS

Hexagon Die Nuts, *Left Hand*

Pipe-thread DIN ISO 228

六方板牙，左旋

管螺纹 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
G 1/4 x 19	36 x 10	25614
G 3/8 x 19	41 x 14	25616
G 1/2 x 14	41 x 14	25618
G 5/8 x 14	50 x 16	25620
G 3/4 x 14	50 x 16	25622
G 1" x 11	60 x 18	25626
G 1.1/8 x 11	70 x 20	25630
G 1.1/4 x 11	70 x 20	25634
G 1.3/8 x 11	85 x 22	25638
G 1.1/2 x 11	85 x 22	25642
G 1.3/4 x 11	100 x 22	25650
G 2" x 11	100 x 22	25654

Application:

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

应用：

清牙和修复损坏的螺纹
通用于不方便加工的地方

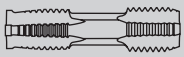
SETS
套装

HexTap
六角柄丝锥

DIN Hand Taps and Dies 德标手用丝锥板牙	273	280	281	282	283
DIN Hand Taps 德标手用丝锥	275				
ISO Hand Taps and Dies ISO手用丝锥板牙	278				
Round Dies 圆板牙	284				
Hexagon Die Nuts 六方板牙	284				
Short Machine Taps 短式机用丝锥	285				
Machine Taps 机用丝锥	287				
Combined Taps 复合丝锥	291				
Tools with hexagon shank 六角柄工具	292 + 295				
Q.C.-Boxes Q.C.套装	293 - 294 - 295				
Displays 展示架	296				

HexTap Sets
in wooden boxes

六角柄丝锥套装
木盒装

	Art.-No
M	
M 3-4-5-6-8-10-12-14-16-18-20	48601
M 3-4-5-6-8-10-12-14-16-18-20-22-24	48602
M 3-4-5-6-8-10-12-14-16-18-20-22-24-27-3C	48603
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
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
G (BSP)	
G 1/8 - 1/4 - 3/8 - 1/2 - 3/4 - 1"	48608
G 1/8 - 1/4 - 3/8 - 1/2 - 3/4 - 1" - 1.1/4 - 1.1/2	48609

HexTap Sets
in wooden boxes

六角柄丝锥套装
木盒装

	Art.-No
M	
M 3-4-5-6-8-10-12-14-16-18-20	48621
M 3-4-5-6-8-10-12-14-16-18-20-22-24	48622
M 3-4-5-6-8-10-12-14-16-18-20-22-24-27-30	48623
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
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
G (BSP)	
G 1/8 - 1/4 - 3/8 - 1/2 - 3/4 - 1"	48628
G 1/8 - 1/4 - 3/8 - 1/2 - 3/4 - 1" - 1.1/4 - 1.1/2	48629

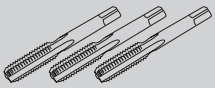
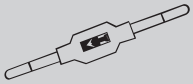
HexTap Sets
in wooden boxes

六角柄丝锥套装
木盒装

	Art.-No
M	
M 3-4-5-6-8-10-12-14-16-18-20	48641
M 3-4-5-6-8-10-12-14-16-18-20-22-24	48642
M 3-4-5-6-8-10-12-14-16-18-20-22-24-27-30	48643
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
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
G (BSP)	
G 1/8 - 1/4 - 3/8 - 1/2 - 3/4 - 1"	48648
G 1/8 - 1/4 - 3/8 - 1/2 - 3/4 - 1" - 1.1/4 - 1.1/2	48649

Tap & Die Sets
in metal cases
DIN standards

丝锥板牙套装
铁盒装
德标

						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
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
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
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
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
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
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
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
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

Tap & Die Sets
in metal cases
DIN standards

丝锥板牙套装
铁盒装
德标

						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
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
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
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
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
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
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
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
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
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
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
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

Tap & Die Sets
in metal cases
DIN standards

丝锥板牙套装
铁盒装
德标

						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
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
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
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
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
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
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
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
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
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

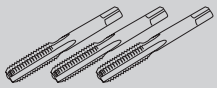
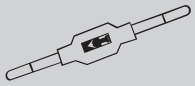
VÖLKEL
THREADING SOLUTIONS

Tap & Die Sets

in metal and wooden cases
ISO standards
Hand Taps in sets of 2 pcs.

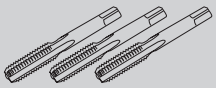
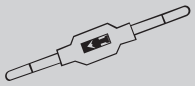
丝锥板牙套装

铁盒+木盒装
ISO标准
2支/套手用丝锥

				Art.-No
M				
M2, 3, 4, 5, 6	No. 0	13/16		48801
M3, 4, 5, 6, 7, 8, 9, 10	No. 1 + 2	13/16 - 1"	No.1	48802
M2, 3, 4, 5, 6, 7, 8, 9, 10, 11, 12	No. 1 + 2	3/16 - 1" - 1.5/16	No.1	48803
M3, 4, 5, 6, 8, 10, 12	No. 1 + 2	13/16 - 1.5/16	No.1	48804
M5, 6, 7, 8, 9, 10, 11, 12	No. 1 + 2	13/16 - 1" - 1.5/16	No.1	48805
M6, 7, 8, 9, 10, 11, 12	No. 1 + 2	13/16 - 1" - 1.5/16	No.1	48806
M6, 7, 8, 9, 10, 11, 12, M14, 16, 18, 20	No. 1, 2 + 3	1" - 1.5/16 - 1.1/2		48807
M6, 8, 10, 12, 14, 16, 18, M20, 22, 24	No. 2 + 4	1" - 1.1/2 - 2"		48808
M6, 7, 8, 9, 10, 11, 12, 14, M16, 18, 20, 22, 24	No. 2 + 4	1" - 1.1/2 - 2"		48809
BSW				
1/8, 3/16, 1/4, 5/16, 3/8, 7/16, 1/2	No. 1 + 2	13/16 - 1 - 1.5/16	No.1	48810
1/4, 5/16, 3/8, 7/16, 1/2	No. 1 + 2	1" - 1.5/16	No.1	48811
1/4, 5/16, 3/8, 7/16, 1/2, 5/8, 3/4	No. 1, 2 + 3	1" - 1.1/2		48812
1/4, 5/16, 3/8, 7/16, 1/2, 5/8, 3/4, 7/8, 1	No. 2 + 4	1" - 1.1/2 - 2"		48813
BSF				
1/4, 5/16, 3/8, 7/16, 1/2	No. 1 + 2	1" - 1.5/16	No.1	48820
1/4, 5/16, 3/8, 7/16, 1/2, 5/8, 3/4	No. 1, 2 + 3	1" - 1.1/2		48821
1/4, 5/16, 3/8, 7/16, 1/2, 5/8, 3/4, 7/8, 1	No. 2 + 4	1" - 1.1/2 - 2"		48822

Tap & Die Sets
in metal and wooden cases
ISO standards
Hand Taps in sets of 2 pcs.

丝锥板牙套装
铁盒+木盒装
ISO标准
2支/套手用丝锥

				Art.-No
UNC				
1/4, 5/16, 3/8, 7/16, 1/2	No. 1 + 2	1" - 1.5/16	No.1	48830
1/4, 5/16, 3/8, 7/16, 1/2 5/8, 3/4	No. 1, 2 + 3	1" - 1.1/2		48832
1/4, 5/16, 3/8, 7/16, 1/2, 5/8, 3/4, 7/8, 1	No. 2 + 4	1" - 1.1/2 - 2"		48834
UNF				
1/4, 5/16, 3/8, 7/16, 1/2	No. 1 + 2	1" - 1.5/16	No.1	48840
1/4, 5/16, 3/8, 7/16, 1/2, 5/8, 3/4	No. 1, 2 + 3	1" - 1.1/2		48842
1/4, 5/16, 3/8, 7/16, 1/2, 5/8, 3/4, 7/8, 1	No. 2 + 4	1" - 1.1/2 - 2"		48844
BA				
0, 2, 4, 6, 8	No. 0	13/16		48828
0, 1, 2, 3, 4, 5, 6, 7, 8, 9, 10	No. 0	13/16		48829

Tap & Die Sets
in metal cases
DIN standards

丝锥板牙套装
铁盒装
德标

Hand Taps DIN 352
in sets of 3 pieces
Round Dies DIN 223

手用丝锥DIN352
3支/套
圆板牙DIN223

								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
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
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
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
	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

Tap & Die Sets
in metal cases
DIN standards

丝锥板牙套装
铁盒装
德标

F.Z. 1
Hand Taps DIN 352, HSSE
Rougher piloted
Round Dies DIN 223, HSSE
+ 7 Guides for Round Dies

手用丝锥DIN352, HSSE
头攻带导向
圆板牙DIN223, HSSE
+ 7只圆板牙导向轮

S.F. 1
Hand Taps DIN 352, HSS-G
Round Dies DIN 223, HSS
+ 7 Guides for Round Dies

手用丝锥DIN352, HSS–G
圆板牙DIN223, HSS
+ 7只圆板牙导向轮

								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
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
drilbox	M 10-12	6.8 / 8.5 / 10.2 mm	No. 2	30 x 11	38 x 14			

Tap & Die Sets
in metal cases
DIN standards

丝锥板牙套装
铁盒装
德标

Hand Taps DIN 352
in sets of 3 pieces
Round Dies DIN 223

手用丝锥DIN352
3支/套
圆板牙DIN223

							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
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
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
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
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

Tap & Die Sets
in metal cases

丝锥板牙套装
铁盒装

Hand Taps DIN 352
in sets of 3 pieces

手用丝锥DIN352
3支/套

					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
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

Hand Taps DIN 352
in sets of 3 pieces
Round Dies 25 x 9 mm ø

手用丝锥DIN352
3支/套
圆板牙 25x9mm ø

					Art.-No
P.V.12	M 3-4-5-6-8-10-12	No. 1.1/2	25 x 9	No. 1	49501
P.V.15 drilbox	M 3-4-5-6-8-10-12	No. 1.1/2	25 x 9	No. 1	49505

Die Sets
in metal cases
DIN standards

板牙套装
铁盒装
德标

				Art.-No
P.V.97		M 3-4-5-6-8-10-12		49521
P.V.98	*HSSE*	M 3-4-5-6-8-10-12		49522
P.V.99			M 3-4-5-6-8-10-12	49520
			UNC 1/4-5/16-3/8-7/16-1/2	49530
			UNF 1/4-5/16-3/8-7/16-1/2	49540
P.V.92	o/d 25x9	M 3-4-5-6-8-10-12		49525

Round Dies DIN 223
+ 7 Guides

圆板牙DIN223
+ 7只导向轮

					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
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

Tap Sets
in plastic boxes
DIN standards

丝锥套装
塑料盒装
德标

Hand Taps DIN 352
in sets of 3 pieces

手用丝锥DIN352
3支/套

				Art.-No
P.K.20	M 3-4-5-6-8-10-12	No. 1.1/2		47001
P.K.21	M 3-4-5-6-8-10-12	No. 1.1/2	No. 1	47005
HSSE	M 3-4-5-6-8-10-12	No. 1.1/2	No. 1	47055
LH	M 3-4-5-6-8-10-12	No. 1.1/2	No. 1	47075

Short Machine Taps DIN 352,
Spiral Point

短式机用丝锥DIN352
螺尖

					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
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

Tap & Die Sets
in plastic box
ISO standards

丝锥板牙套装
塑料盒装
ISO标准

Machine Taps ISO 529
Spiral Point (Form B)

机用丝锥ISO529
螺尖(Form 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

Machine Taps ISO 529

机用丝锥ISO529

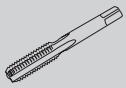
		Art.-No
Form B	M 3-4-5-6-8-10-12	80500
Form B-AZ	M 3-4-5-6-8-10-12	80900
Form C/35°RSP	M 3-4-5-6-8-10-12	80700

Machine Tap Sets
in plastic boxes

机用丝锥套装
塑料盒装

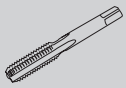
Machine Taps ***HSSE***
Spiral Point and Spiral Flute

机用丝锥HSSE
螺尖和螺旋槽

			Art.-No
P.K.40	M 3-4-5-6-8-10-12		47901
P.K.41	M 3-4-5-6-8-10-12	***TIN***	47921

Combined Taps ***HSSE***

复合丝锥HSSE

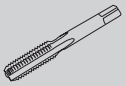
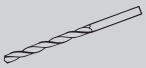
		Art.-No
P.K.370	M 3-4-5-6-8-10-12	47837
P.K.700	BSW 1/8-5/32-3/16-1/4-5/16-3/8-1/2	47870

Machine Tap Sets
in plastic boxes

机用丝锥套装
塑料盒装

Machine Taps ***HSSE***
Spiral Point

机用丝锥HSSE
螺尖

				Art.-No
P.K.28	M 3-4-5-6-8-10-12			47815
P.K.29	M 3-4-5-6-8-10-12	***TIN***		47825
●	M 3-4-5-6-8-10-12			47853
●	M 3-4-5-6-8-10-12			47854
○	M 3-4-5-6-8-10-12			47852
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
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
●	M 3-4-5-6-8-10-12		2.5/3.3/4.2/5.0/6.8/8.5/10.2 mm	47856
●	M 3-4-5-6-8-10-12		2.5/3.3/4.2/5.0/6.8/8.5/10.2 mm	47857
○	M 3-4-5-6-8-10-12		2.5/3.3/4.2/5.0/6.8/8.5/10.2 mm	47855

Machine Tap Sets
in plastic boxes

机用丝锥套装
塑料盒装

Machine Taps ***HSSE***
Spiral Flute

机用丝锥HSSE
螺旋槽

				Art.-No
P.K.30	M 3-4-5-6-8-10-12			47817
P.K.31	M 3-4-5-6-8-10-12	***TIN***		47827
●	M 3-4-5-6-8-10-12			47863
●	M 3-4-5-6-8-10-12			47864
○	M 3-4-5-6-8-10-12			47862
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
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
●	M 3-4-5-6-8-10-12		2.5/3.3/4.2/5.0/6.8/8.5/10.2 mm	47866
●	M 3-4-5-6-8-10-12		2.5/3.3/4.2/5.0/6.8/8.5/10.2 mm	47867
○	M 3-4-5-6-8-10-12		2.5/3.3/4.2/5.0/6.8/8.5/10.2 mm	47865

Electrical Conduit Set
in plastic box

电线管绞手套装
塑料盒装

			Art.-No
M 20x1.5 - M 25x1.25	M 20x1.5 - M 25x1.25	42 mm	18012
M 20x1.5			18002
M 25x1.5			18003

Tap Sets
in wooden boxes
DIN standards

丝锥套装
木盒装
德标

Hand Taps DIN 352
in sets of 3 pieces

手用丝锥DIN352
3支/套

		Art.-No
M 1-1.2-1.4-1.7 M 2.0-2.3-2.6	No. 0	48001

Combined-Bit-Set
in pastic box

六角柄复合丝锥套装
塑料盒装

HSS-G

				Art.-No
M	3-4-5-6-8-10		1/4"	67200
M	3-4-5-6-8-10	***TIN***	1/4"	67209
UNC	No.8 - No.10 - No.12 - 1/4 - 5/16 - 3/8"		1/4"	67272
UNF	No.8 - No.10 - No.12 - 1/4 - 5/16 - 3/8"		1/4"	67274

Threading-Bit-Set
with Twist–Drill–Bits in plastic box

六角柄丝锥套装
带六角柄钻头, 塑料盒装

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

Threading-Bit-Set
in plastic box

六角柄丝锥套装
塑料盒装

Form D **M 3-10** **HSS-G** **Tol. ISO2/6H**

	Art.-No
M 3-4-5-6-8-10	67010

Drill Bit-Set
in plastic box

六角柄钻头套装
塑料盒装

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

Countersink-Bit-Set
in plastic box

六角柄倒角刀套装
塑料盒装

6,3 - 20,5 mm **HSS**

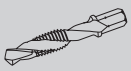
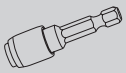
	Art.-No
6.3 / 8.3 / 10.4 / 12.4 / 16.5 / 20.5	67300

Q.C. 1

Combined Bits

六角柄复合丝锥套装
带1/4”六角柄

M 3 - M 10 HSS-G

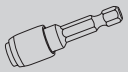
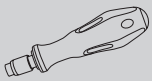
		Art.-No
M 3-4-5-6-8-10	non-magnetic 1/4"	67421

Q.C. 2

Threading-Bits

六角柄丝锥套装
带1/4”六角柄

M 3 - M 10 HSS-G

			Art.-No
M 3-4-5-6-8-10	non-magnetic 1/4"	non-magnetic 1/4"	67422

Q.C. 3

Countersink Bits

六角柄倒角刀套装
带1/4”六角柄

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

Q.C. 4

Drill Bits

六角柄钻头套装
带1/4”六角柄

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

Q.C. 5

WOOD Drill Bits

六角柄木工钻套装
带1/4”六角柄

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

Drill Bit-Set
in plastic box

六角柄钻头套装
塑料盒装
木工钻

3,0 - 10,0 mm HSS-G

		Art.-No
3.0 / 4.0 / 5.0 / 6.0 / 8.0 / 10.0	for wood 3.0 / 4.0 / 5.0 / 6.0 / 8.0 / 10.0	67101

SD 2600
Art.-No. 48926

SD 6000
Art.-No. 48960

SD 670
Art.-No. 48967

SD 3000

SD 672

Art.-No	Contents	
48980	20 Sets	67200
48981	10 Sets	67200
	10 Sets	67020
48982	10 Sets	67200
	10 Sets	67100
48983	10 Sets	67200
	10 Sets	67300

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SURFACE FINISHES
表面处理

Each VÖLKEL Tap and each VÖLKEL Die can be supplied with any coating or surface finish quickly.

任何一款沃克的丝锥和板牙都可以快速地提供任何涂层或表面处理

SURFACE FINISHES
表面处理

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.

蒸汽处理(VAP):

通过蒸汽处理, 在工具的表面形成一层氧化膜, 这会改善冷却液的附着力, 从而帮助防止切屑粘在工具表面。

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.

氮化处理:

通过氮化处理, 在工具表面充满了氮原子, 从而使工具具有高耐磨性和提高抗摩擦性能。

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.

氮化钛涂层(TiN):

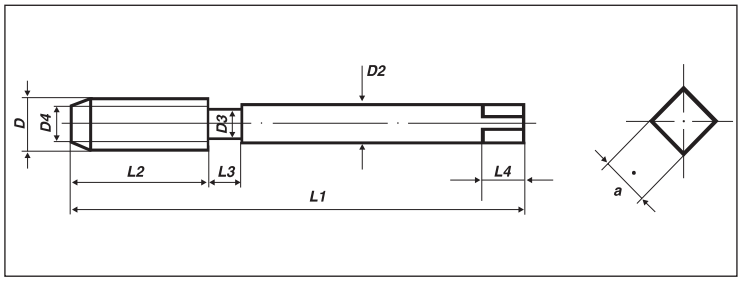
在大约500℃的真空室经过PVD处理, 减少了工具的表面粗糙度, 工具具有卓越的硬度,从而使工具具有优异的抗摩擦性能和高耐磨性。
TIN涂层丝锥可以使用相当高的切削速度。

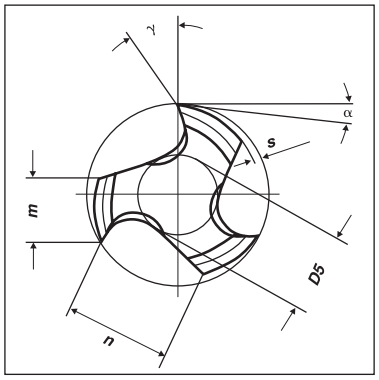
TiCN (Titanium CarboNitride Coating):

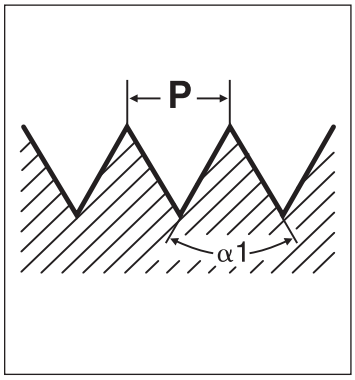
The TiCN-coating is particularly suitable for wear-resistant and abrasive material. The TiCN- coating has an hardness of 3.000 HV and thus is harder as the TiN-coating (2.600 HV). As a result the TiCN-coating has an excellent wear-resistance. Also the hardness and the toughness is higher, the heat resistance is reduced. Therefore intensive and optimum cooling is essential.

碳氮化钛涂层(TiCN):

碳氮化钛涂层特别适用于耐磨材料和研磨材料，碳氮化钛的硬度(3,000HV)比氮化钛(2,600HV)要高，所以碳氮化钛具有卓越的耐磨性，同时由于硬度和韧性更高，热阻降低，因此具有最佳的冷却。



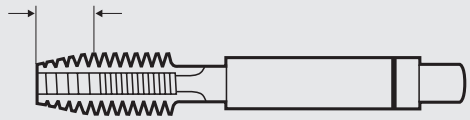




D	Nominal diameter	公称直径
D2	Shank diameter	柄径
D3	Neck diameter	颈径
D4	Point diameter	切削锥直径
D5	Web diameter	芯厚圆直径
L1	Overall length	总长
L2	Thread length	刃长
L3	Neck length	颈长
L4	Square length	方长
P	Pitch	螺距
a	Square size	方宽
m	Land width	刃宽
n	Flute width	槽宽
s	Thread relief	螺纹铲背量
α	Relief angle	后角
γ	Rake angle	前角
α_1	Thread angle	牙型角

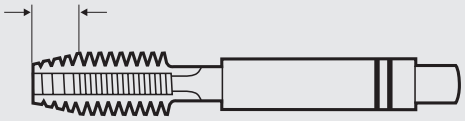
Leads of Hand Taps, Sets of 3 pcs.
3支/套手用丝锥铲梢

6-8 threads/齿



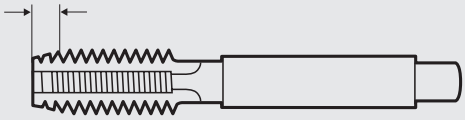
Nr. 1
Rougher, 6-8 Threads Lead
头攻, 6–8齿铲梢

4-5 threads/齿



Nr. 2
Intermediate, 4-5 Threads Lead
二攻, 4–5齿铲梢

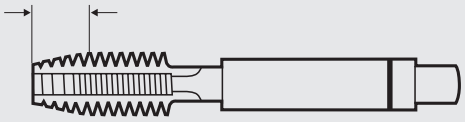
2-3 threads/齿



Nr. 3
Finisher, 2-3 Threads Lead
底攻, 2–3齿铲梢

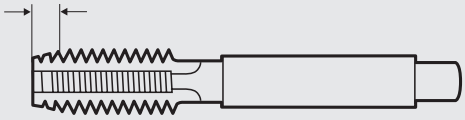
Leads of Hand Taps, Sets of 2 pcs.
2支/套手用丝锥铲梢

5-6 threads/齿

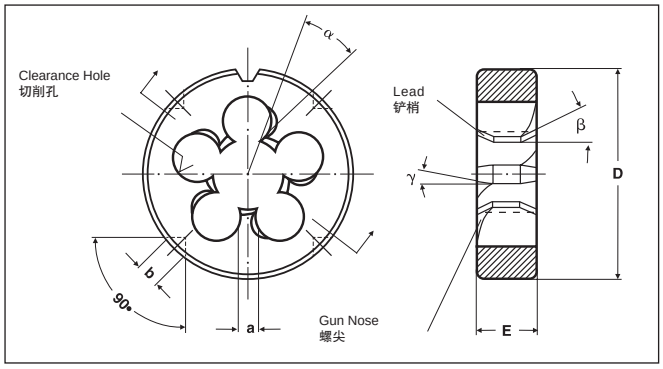


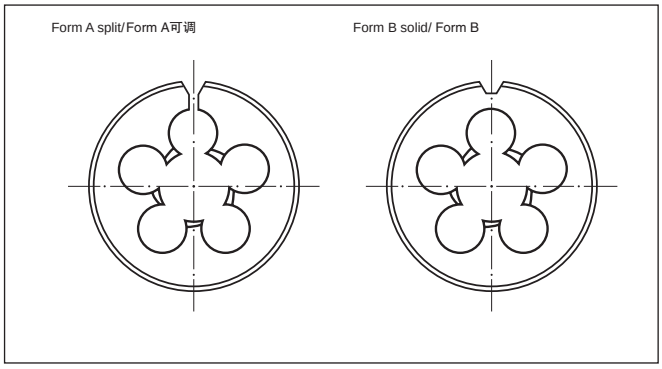
Nr. 1
Rougher, 5-6 Threads Lead
头攻, 5–6齿铲梢

2-3 threads/齿



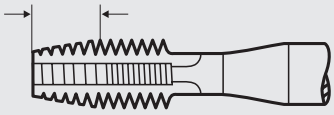
Nr. 2
Finisher, 2-3 Threads Lead
底攻, 2–3齿铲梢





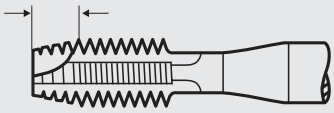
D	Outside diameter	外圆直径
E	Width of die	厚度
a	Width of land	刃宽
b	Hole for holding screws	定位孔
α	Rake angle	前角
β	Lead angle	铲梢锥度角
γ	Angle of gun nose	螺尖角度

6-8 threads/齿



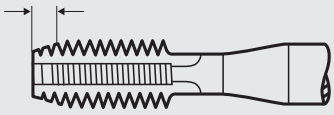
Form A
6-8 Threads Lead, for short through holes
6–8齿铲梢, 用于短通孔

4-5 threads/齿



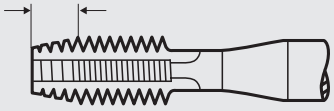
Form B
4-5 Threads Lead with Spiral Point for through holes
4–5齿铲梢, 带螺尖, 用于通孔

2-3 threads/齿



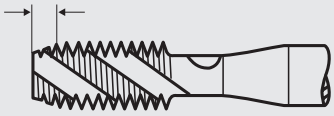
Form C
2-3 Threads Lead, for blind holes
2–3齿铲梢, 用于盲孔

4-5 threads/齿



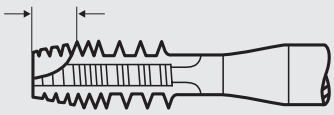
Form D
4-5 Threads Lead, for through and blind holes
4–5齿铲梢, 用于通孔和盲孔

2-3 threads/齿



Form C/35° RSP
2-3 Threads Lead, 35° Spiral Flute, for blind holes
2–3齿铲梢, 35° 螺旋槽, 用于盲孔

4-5 threads/齿



Form B-AZ
4-5 Threads Lead with Spiral Point and interrupted threads for through holes
4–5齿铲梢, 带螺尖, 带跳牙, 用于通孔

Tolerance of the tap 丝锥公差 Designation according 依据 DIN 802 DIN	DIN EN 22857 ISO 2857	Tolerance of the nut thread 螺母螺纹公差	Explanation 解释
4H	ISO 1	4H, 5H	undersize / 中径减少
6H	ISO 2	4G, 5G, 6H	standard / 标准
6G	ISO 3	6G, 7H, 8H	oversize (M12x1,5 7G = ISO2/6H + 0,03 mm) 中径加大
7G	./.	7G, 8G, (6E)	oversize (M12x1,5 7G = ISO2/6H + 0,06 mm) 中径加大
4HX	ISO 1X	4H, 5H	manufacturer tolerance for special materials (X = small oversize, 4HX ≈ ISO2/6H) 生产商对特别材料制定的公差 (X = 中径稍加大，4HX ≈ ISO2/6H)
6HX	ISO 2X	6H	manufacturer tolerance for special materials (X = small oversize, 6HX ≈ ISO3/6G) 生产商对特别材料制定的公差 (X = 中径稍加大，6HX ≈ ISO3/6G)
6GX	ISO 3X	6G	manufacturer tolerance for special materials (X = small oversize, 6GX ≈ 7G) 生产商对特别材料制定的公差 (X = 中径稍加大，6GX ≈ 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 +0.1 mm 中径加大，用于电镀或表面处理厚度达到25µm
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 +0.2 mm 中径加大，用于电镀或表面处理厚度达到50µm

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)
电镀需要的丝锥中径加大尺寸依据螺纹角度。
中径加大尺寸 O 可以近似以下公式计算: O = S x F
S = 镀层厚度 / F = 依赖螺纹角的因素(F = 2 / sin a/2)

Thread angle /螺纹角 F=	30° 7,727	47°/30' 4,966	55° 4,331	60° 4,000	80° 3,111	90° 2,828

Conversion table - pitch per inch into mm
转换表 – 螺距公英制

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*
抗拉强度和硬度转换表

N/mm²	HRC	Rockwell HRA	HRB	HRF	Vickers HV (≥98N)	Brinell 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　　*不承担任何责任

CONVERSION TABLE OF CUTTING SPEED M/MIN. TO R/MIN.
切削速度换算表 M/MIN. – R/MIN.

m/min.		4	6	8	9	10	12	15	18	21	25	27	30	36
Size mm	inch	Revolutions per Minute (rpm) 每分钟转数(rpm)												
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
建议切削速度
冷却和润滑

Material/材料	Lubricant 润滑剂	Cutting Speed 切削速度 m/min.
Steel, unalloyed and low alloyed, short-chipping 非合金钢和低合金钢, 短屑	S/E	10-20
non abrasive Material, short-chipping 非研磨材料, 短屑	S/E	6-15
Steel, heat resistant, long-chipping 耐热钢, 长屑	S	4- 8
Steel, heat resistant, short-chipping 耐热钢, 短屑	S	4- 8
Steel, cementation and heat treatable, short-chipping 渗碳钢、可热处理钢, 短屑	S	4- 8
Steel, Tool Steel up to 1200 N/mm² 工具钢, 抗拉强度小于1200 N/mm²	S	2- 5
Steel, Tool Steel over 1200 N/mm² 工具钢, 抗拉强度大于1200 N/mm²	S	2- 5
Steel stainless, short-chipping 不锈钢, 短屑	S	5-10
Steel stainless, long-chipping 不锈钢, 长屑	S	5-10
Iron, Cast 铸铁	P/T	6-20
Iron, spheroidal graphite 球墨铸铁	P/T	6-20
Iron, Malleable Cast 可锻铸铁	E	6-12
Brass, short-chipping 黄铜, 短屑	E	20-30
Brass, long-chipping 黄铜, 长屑	S/E	10-15
Bronze, short-chipping 青铜, 短屑	S/E	6-15
Bronze, long-chipping 青铜, 长屑	S/E	6-15
Copper 紫铜	S/E	10-15
Aluminium-alloys, short-chipping 铝合金, 短屑	S/E	15-30
Aluminium-alloys, long-chipping 铝合金, 长屑	E	10-20
Zinc Alloys 锌合金	S/E	10-15
Magnesium Alloys 镁合金	E/T	10-20
Titanium, short-chipping 钛合金, 短屑	S	3- 4
Titanium, long-chipping 钛合金, 长屑	S	3- 4
Plastics, thermoplastics 热塑性塑料	E/T	5-15
Plastics, thermosetting 热固性塑料	T	5-15

S = cutting oil/切削油 E = oil emulsion/乳化油 P = kerosene/煤油 T = dry/干性

CONVERSION TABLE INCH-MM
公英制转换表

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
装甲管螺纹 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
建议外径尺寸

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
建议攻丝底孔钻头尺寸

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
建议攻丝底孔钻头尺寸

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

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258	238	379	101	777	120
260	75	383	94	782	139
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