

# 02

## MASCHI TRADIZIONALI TAPS

B  
02



### B.02.01

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Guida alla selezione dell'utensile  
Tool selection guide

480-517

### B.02.02

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Gamma prodotti  
Products range

519-629

### B.02.03

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Parametri di taglio  
Cutting data

631-651

**MASCHI TRADIZIONALI**  
TAPS

# B.02.01

**Guida alla selezione dell'utensile**  
Tool selection guide

## Descrizione famiglia prodotto | Family product description

► HSS ► HSS-Co

<p><b>N</b></p> <p>p. 485, 489, 493</p>	<p><b>Maschi a mano e macchina in HSS, HSS-Co a scanalature dritte per fori passanti e ciechi, idonei per lavorazioni di acciaio, Alluminio e materiale non ferroso.</b></p> <p>HSS-Co straight flute hand taps and machine taps for steel, Aluminium and non ferrous materials through and blind holes.</p>
<p><b>VA</b></p> <p>p. 487, 490 500</p>	<p><b>Maschi a mano e macchina in HSS-Co a scanalature dritte ed imbocco corretto per fori passanti, idonei per lavorazioni di acciaio inossidabile, leghe di Alluminio e materiale non ferroso.</b></p> <p>HSS-Co spiral pointed hand and machine taps for stainless steel, Aluminium alloy and non ferrous materials through holes.</p>

► HSS-Co

<p><b>RAPID</b></p> <p>p. 489, 491</p>	<p><b>Maschi a macchina in HSS-Co a scanalature dritte ed imbocco corretto per fori passanti, idonei per lavorazioni di acciaio fino a 1000 N/mm<sup>2</sup> e leghe di Alluminio con Si &lt; 12%.</b></p> <p>HSS-Co machine taps with straight flute and spiral pointed, for steel with tensile strength up to 1000 N/mm<sup>2</sup> and Aluminium alloy with silicon &lt; 12% through holes.</p>
<p><b>RAPID 2</b></p> <p>p. 493</p>	<p><b>Maschi a macchina in HSS-Co a 2 taglienti dritti ed imbocco corretto per fori passanti, idonei per lavorazioni di Alluminio e materiale non ferroso.</b></p> <p>HSS-Co machine taps with straight flute and spiral pointed, two cutting edges for Aluminium with tensile strength up to 800 N/mm<sup>2</sup> and non ferrous materials through holes.</p>
<p><b>N SX</b></p> <p>p. 495</p>	<p><b>Maschi a macchina in HSS-Co a scanalature dritte, filettatura sinistra per fori passanti e ciechi, idonei per lavorazioni di acciaio, Alluminio e materiale non ferroso.</b></p> <p>HSS-Co machine taps, left hand thread with straight flute for steel, Aluminium and non ferrous materials through and blind holes.</p>
<p><b>N 15°</b></p> <p>p. 489, 497</p>	<p><b>Maschi a macchina in HSS-Co elica 15° per fori ciechi, idonei per lavorazioni di acciaio fino a 1000 N/mm<sup>2</sup> leghe di Alluminio con Si &lt; 12%.</b></p> <p>HSS-Co machine taps with 15° flute, for steel up to 1000 N/mm<sup>2</sup> and Aluminium alloy with silicon &lt;12% blind holes.</p>
<p><b>NL 15°</b></p> <p>p. 495</p>	<p><b>Maschi a macchina in HSS-Co taglio destro, elica 15° a sinistra per fori passanti, idonei per lavorazioni di acciaio fino a 800 N/mm<sup>2</sup>, ghisa sferoidale.</b></p> <p>HSS-Co machine taps with 15° left flute, right cutting, for steel up to 1000 N/mm<sup>2</sup>, Aluminium and long chip nodular cast iron through holes.</p>
<p><b>N 40°</b></p> <p>p. 489, 497</p>	<p><b>Maschi a macchina in HSS-Co elica 40° per fori ciechi, idonei per lavorazioni di acciaio fino a 1000 N/mm<sup>2</sup> leghe di Alluminio con Si &lt; 12%.</b></p> <p>HSS-Co machine taps with 40° flute, for steel up to 1000 N/mm<sup>2</sup> and Aluminium alloy with silicon &lt;12% blind holes.</p>
<p><b>N SX 40°</b></p> <p>p. 500</p>	<p><b>Maschi a macchina in HSS-Co elica 40°, filettatura sinistra per fori passanti e ciechi in acciaio, idonei per lavorazioni di Alluminio e materiale non ferroso.</b></p> <p>HSS-Co machine taps, left hand thread with 40° flute for steel, Aluminium and non ferrous materials through and blind holes.</p>

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## Descrizione famiglia prodotto | Family product description

### ► HSS-Co

<b>VA 15°</b>	<b>Maschi a macchina in HSS-Co elica 15° per fori ciechi, idonei per lavorazioni di acciaio inossidabile, leghe di Alluminio e materiale non ferroso.</b>
<p>p. 490, 502</p>	<p>HSS-Co machine taps with 15° flute, for stainless steel, Aluminium alloy and non ferrous materials blind holes.</p>
<b>VA i 15°</b>	<b>Maschi a macchina in HSS-Co elica 15° con foro di lubrificazione assiale per fori ciechi, idonei per lavorazioni di acciaio inossidabile, leghe di Alluminio e materiale non ferroso.</b>
<p>p. 502</p>	<p>HSS-Co machine taps with 15° flute, with axial internal coolant for stainless steel, Aluminium alloy and non ferrous materials blind holes.</p>
<b>VA 35°</b>	<b>Maschi a macchina in HSS-Co elica 35° per fori ciechi, idonei per lavorazioni di acciaio inossidabile, leghe di Alluminio e materiale non ferroso.</b>
<p>p. 503</p>	<p>HSS-Co machine taps with 35° flute, for stainless steel, Aluminium alloy and non ferrous materials blind holes.</p>
<b>VR 35°</b>	<b>Maschi a macchina in HSS-Co rastremati elica 35° per fori ciechi, idonei per lavorazioni di acciaio inossidabile.</b>
<p>p. 504</p>	<p>HSS-Co machine taps with 35° flute tapered, for stainless steel blind holes.</p>
<b>VR 50°</b>	<b>Maschi a macchina in HSS-Co rastremati elica 50° per fori ciechi, idonei per lavorazioni di acciaio inossidabile.</b>
<p>p. 505</p>	<p>HSS-Co machine taps with 50° flute tapered, for stainless steel blind holes.</p>
<b>HD</b>	<b>Maschi a macchina in HSS-Co a scanalature dritte per fori passanti e ciechi, idonei per lavorazioni di acciaio legato e bonificato fino a 1300 N/mm<sup>2</sup>.</b>
<p>p. 506</p>	<p>HSS-Co machine taps with straight flute for alloy and hardened steel with tensile strenght up to 1300 N/mm<sup>2</sup> through and blind holes.</p>
<b>HD 15°</b>	<b>Maschi a macchina in HSS-Co elica 15° per fori ciechi, idonei per lavorazioni di acciaio legato e bonificato fino a 1300 N/mm<sup>2</sup>.</b>
<p>p. 507</p>	<p>HSS-Co machine taps with 15° flute for alloy and hardened steel with tensile strenght up to 1300 N/mm<sup>2</sup> blind holes.</p>
<b>HD 40°</b>	<b>Maschi a macchina in HSS-Co elica 40° per fori ciechi, idonei per lavorazioni di acciaio legato e bonificato fino a 1300 N/mm<sup>2</sup>.</b>
<p>p. 508</p>	<p>HSS-Co machine taps with 40° flute for alloy and hardened steel with tensile strenght up to 1300 N/mm<sup>2</sup> blind holes.</p>
<b>HR 40°</b>	<b>Maschi a macchina in HSS-Co rastremati elica 40° per fori ciechi, idonei per lavorazioni di acciaio legato e bonificato fino a 1300 N/mm<sup>2</sup>.</b>
<p>p. 508</p>	<p>HSS-Co machine taps with 40° flute tapered, for alloy and hardened steel with tensile strenght up to 1300 N/mm<sup>2</sup> blind holes.</p>
<b>GG</b>	<b>Maschi a macchina in HSS-Co a scanalature dritte per fori passanti e ciechi, idonei per lavorazioni di ghisa grigia, ghisa sferoidale e materiali termoresistenti.</b>
<p>p. 509</p>	<p>HSS-Co machine taps with straight flute for grey cast iron, nodular cast iron and heat-resistant materials through and blind holes.</p>



## Descrizione famiglia prodotto | Family product description

### ► HSS-Co

<b>MULTI GG i</b>	<b>Maschi a macchina in HSS-Co a scanalature dritte con foro di lubrificazione assiale per fori passanti e ciechi, idonei per lavorazioni di ghisa grigia, ghisa sferoidale e materiali termoresistenti.</b>
<p>p. 509</p>	<p>HSS-Co machine taps with straight flute, with axial internal coolant, for grey cast iron, nodular cast iron and heat-resistant materials through and blind holes.</p>
<b>AZ</b>	<b>Maschi a macchina in HSS-Co a taglienti alternati per fori passanti e ciechi, idonei per lavorazioni di Alluminio e materiale non ferroso.</b>
<p>p. 490, 510</p>	<p>HSS-Co machine taps with alternating cutting edges for Aluminium and non ferrous materials through and blind holes.</p>
<b>AZ 35°</b>	<b>Maschi a macchina in HSS-Co elica 35° a taglienti alternati per fori ciechi, idonei per lavorazioni di Alluminio e materiale non ferroso.</b>
<p>p. 510</p>	<p>HSS-Co machine taps with 35° flute angle alternating cutting edges for Aluminium and non ferrous materials blind holes.</p>
<b>ALU</b>	<b>Maschi a macchina in HSS-Co a scanalature dritte per fori passanti, idonei per lavorazioni di Alluminio e materiale non ferroso.</b>
<p>p. 511</p>	<p>HSS-Co machine taps with straight flute for Aluminium and non ferrous materials through holes.</p>
<b>ALU 45°</b>	<b>Maschi a macchina in HSS-Co elica 45° per fori ciechi, idonei per lavorazioni di Alluminio e materiale non ferroso.</b>
<p>p. 511</p>	<p>HSS-Co machine taps with 45° flute angle for Aluminium and non ferrous materials blind holes.</p>
<b>BAK</b>	<b>Maschi a macchina in HSS-Co a scanalature dritte per fori passanti e ciechi , idonei per lavorazioni di bachelite.</b>
<p>p. 512</p>	<p>HSS-Co machine taps with straight flute for bakelite through and blind holes.</p>
<b>ULTRA</b>	<b>Maschi a macchina in HSS-Co a scanalature dritte per fori passanti, idonei per lavorazioni di lamiera 1xD.</b>
<p>p. 512</p>	<p>HSS-Co machine taps with straight flute with depth up to 1xD on sheet metal through holes.</p>
<b>ULTRA S</b>	<b>Maschi a macchina in HSS-Co a scanalature dritte per fori passanti, idonei per lavorazioni di lamiera 1,5xD.</b>
<p>p. 512</p>	<p>HSS-Co machine taps with straight flute with depth up to 1,5xD on sheet metal through holes</p>
<b>Ti</b>	<b>Maschi a mano in HSS-Co idonei per fori passanti e ciechi, idonei per lavorazioni di lega di Titanio.</b>
<p>p. 488</p>	<p>HSS-Co hand taps for Titanium alloy through and blind holes.</p>
<b>MS</b>	<b>Maschi a macchina in HSS-Co a scanalature dritte per fori passanti e ciechi, idonei per lavorazioni di ottone.</b>
<p>p. 490</p>	<p>HSS-Co machine taps with straight flute for brass through and blind holes.</p>

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## Descrizione famiglia prodotto | Family product description

### ► HSS-Co

<b>EG (M)</b> <p>p. 512</p>	<p><b>Maschi a macchina in HSS-Co per filetti riportati (Helicoil), fori passanti, idonei per lavorazioni di leghe di Alluminio.</b></p> <p>HSS-Co machine taps for wire thread inserts (Helicoil) for steel and Aluminium alloys through holes.</p>
<b>EG (M) 40°</b> <p>p. 513</p>	<p><b>Maschi a macchina in HSS-Co elica 40° per filetti riportati (Helicoil), fori ciechi, idonei per lavorazioni di leghe di Alluminio.</b></p> <p>HSS-Co machine taps for wire thread inserts (Helicoil) with 40° flute angle for steel and Aluminium alloys blind holes.</p>
<b>TR</b> <p>p. 488, 514</p>	<p><b>Maschi a mano e macchina in HSS-Co a profilo trapezoidale per fori passanti e ciechi, idonei per lavorazioni generiche.</b></p> <p>HSS-Co hand and machine taps with trapezoidal thread for machining for general purpose applications through and blind holes.</p>

### ► HSS-Co

<b>FORMER</b> <p>p. 514</p>	<p><b>Maschi a rullare HSS-Co per fori passanti e ciechi, idonei per lavorazioni generiche di materiali con coefficiente di allungamento <math>\geq 10\%</math> e <math>R_m \leq 1000 \text{ N/mm}^2</math>.</b></p> <p>HSS-Co cold forming taps for machining general purpose applications in all materials with tensile strength <math>\geq 10\%</math> e <math>R_m \leq 1000 \text{ N/mm}^2</math>, through and blind holes.</p>
<b>FORMER S</b> <p>p. 515</p>	<p><b>Maschi a rullare in HSS-Co con canalini di lubrificazione per fori passanti e ciechi, idonei per lavorazioni generiche di materiali con coefficiente di allungamento <math>\geq 10\%</math> e <math>R_m \leq 1000 \text{ N/mm}^2</math>.</b></p> <p>HSS-Co cold forming taps with oil grooves for machining general purpose applications in all materials with tensile strength <math>\geq 10\%</math> e <math>R_m \leq 1000 \text{ N/mm}^2</math>, through and blind holes.</p>



Codice Utensile   Tool code	Materiale utensile Tool material	Tipologia filetto Thread Type	DIN	Tipologia foro Hole type	Angolo elica Helix angle	Tolleranza Tolerance	Forma imbocco Chamfer Form	Rivestimento Coating	Gamma diametri Diameters range	P M K N S H	Pagina utensile Tool page
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## ► N (maschi a mano | hand taps)

6615		<b>SET</b>	HSS	M DIN 13	352 DIN		0°	6H	-	-	1 ÷ 68		520
6615P			HSS	M DIN 13	352 DIN		0°	6H	A 5-6	-	1 ÷ 68		520
6615S			HSS	M DIN 13	352 DIN		0°	6H	D 3-4	-	1 ÷ 68		520
6615T			HSS	M DIN 13	352 DIN		0°	6H	C 2,5-3	-	1 ÷ 68		520
6618		<b>SET</b>	HSS	M DIN 13	352 DIN		0°	6H	-	-	3 ÷ 20		520
6618P		Direzione taglio sinistro Left cutting direction	HSS	M DIN 13	352 DIN		0°	6H	A 5-6	-	3 ÷ 20		520
6618S		Direzione taglio sinistro Left cutting direction	HSS	M DIN 13	352 DIN		0°	6H	D 3-4	-	3 ÷ 20		520
6618T		Direzione taglio sinistro Left cutting direction	HSS	M DIN 13	352 DIN		0°	6H	C 2,5-3	-	3 ÷ 20		520
6633		<b>SET</b>	HSS	MF DIN 13	2181 DIN		0°	6H	-	-	2 ÷ 52		568
6633P			HSS	MF DIN 13	2181 DIN		0°	6H	A 5-6	-	2 ÷ 52		568
6633T			HSS	MF DIN 13	2181 DIN		0°	6H	C 2,5-3	-	2 ÷ 52		568

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Codice Utensile   Tool code	Materiale utensile Tool material	Tipologia filetto Thread Type	DIN	Tipologia foro Hole type	Angolo elica Helix angle	Tolleranza Tolerance	Forma imbocco Chamfer Form	Rivestimento Coating	Gamma diametri Diameters range	P M K N S H	Pagina utensile Tool page
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► **N**  
(maschi a mano | hand taps)

6775		<b>SET</b>	HSS	UNC ASME B.1.1	2184 2 DIN		0°	2B	-	-	nr.1-64 ÷ 2"		585
6775P			HSS	UNC ASME B.1.1	2184 2 DIN		0°	2B	A 5-6	-	nr.1-64 ÷ 2"		585
6775S			HSS	UNC ASME B.1.1	2184 2 DIN		0°	2B	D 3-4	-	nr.1-64 ÷ 2"		585
6775T			HSS	UNC ASME B.1.1	2184 2 DIN		0°	2B	C 2,5-3	-	nr.1-64 ÷ 2"		585
6776		<b>SET</b>	HSS	UNF ASME B.1.1	2184 2 DIN		0°	2B	-	-	nr.1-72 ÷ 1 1/2		595
6776P			HSS	UNF ASME B.1.1	2184 2 DIN		0°	2B	A 5-6	-	nr.1-72 ÷ 1 1/2		595
6776T			HSS	UNF ASME B.1.1	2184 2 DIN		0°	2B	C 2,5-3	-	nr.1-72 ÷ 1 1/2		595
6603		<b>SET</b>	HSS	BSW DIN 11	-352 DIN		0°	-	-	-	1/16 ÷ 2"		605
6603P			HSS	BSW DIN 11	2184 2 DIN		0°	-	A 5-6	-	1/16 ÷ 2"		605
6603S			HSS	BSW DIN 11	2184 2 DIN		0°	-	D 3-4	-	1/16 ÷ 2"		605
6603T			HSS	BSW DIN 11	2184 2 DIN		0°	-	C 2,5-3	-	1/16 ÷ 2"		605

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Codice Utensile   Tool code	Materiale utensile Tool material	Tipologia filetto Thread Type	DIN	Tipologia foro Hole type	Angolo elica Helix angle	Tolleranza Tolerance	Forma imbocco Chamfer Form	Rivestimento Coating	Gamma diametri Diameters range	P M K N S H	Pagina utensile Tool page
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► **N**  
(maschi a mano | hand taps)

6627		<b>SET</b>	HSS	G (BSP) DIN EN ISO 228	2184 2 DIN		0°	-	-	-	1/8 ÷ 2"		609
6627P			HSS	G (BSP) DIN EN ISO 228	2184 2 DIN		0°	-	A 5-6	-	1/8 ÷ 2"		609
6627T			HSS	G (BSP) DIN EN ISO 228	2184 2 DIN		0°	-	C 2,5-3	-	1/8 ÷ 2"		609

► **N**  
(SET maschi a mano | hand taps SET)

6608 3/12			SET Maschi a mano in serie di 3 pezzi in cassetta metallica Hand taps SET, series in set of 3 pieces in metal cases										
			HSS	M DIN 13	352 DIN		0°	6H	-	-	3 ÷ 12		524
6609 3/12			SET Maschi a mano in serie di 3 pezzi e relative misure di punte (DIN 338) per preforatura. Hand taps SET, series in set of 3 pieces and twist drills for tap drill hole according to DIN 338.										
			HSS	M DIN 13	352 DIN		0°	6H	-	-	3 ÷ 12		525

► **VA**  
(maschi a mano | hand taps)

6614		<b>SET</b>	HSS-Co	M DIN 13	352 DIN		0°	6HX	-	-	2 ÷ 20		521
6614P			HSS-Co	M DIN 13	352 DIN		0°	6HX	A 5-6	-	2 ÷ 20		521
6614S			HSS-Co	M DIN 13	352 DIN		0°	6HX	D 3-4	-	2 ÷ 20		521
6614T			HSS-Co	M DIN 13	352 DIN		0°	6HX	C 2,5-3	-	2 ÷ 20		521



Codice Utensile   Tool code	Materiale utensile Tool material	Tipologia filetto Thread Type	DIN	Tipologia foro Hole type	Angolo elica Helix angle	Tolleranza Tolerance	Forma imbocco Chamfer Form	Rivestimento Coating	Gamma diametri Diameters range	P	M	K	N	S	H	Pagina utensile Tool page
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► **Ti**  
(maschi a mano | hand taps)

6625		<b>SET</b>	HSS-Co	M DIN 13	352 DIN		0°	6HX	-	NIT	2 ÷ 20	-	-	-	-	521
6625P			HSS-Co	M DIN 13	352 DIN		0°	6HX	A 5-6	NIT	2 ÷ 20	-	-	-	-	521
6625S			HSS-Co	M DIN 13	352 DIN		0°	6HX	D 3-4	NIT	2 ÷ 20	-	-	-	-	521
6625T			HSS-Co	M DIN 13	352 DIN		0°	6HX	C 2,5-3	NIT	2 ÷ 20	-	-	-	-	521

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► **TR**  
(maschi a mano | hand taps)

6937		<b>SET</b>	HSS-Co	TR	103 DIN		0°	7H	-	-	10 ÷ 30	-	-	-	-	628
6937P			HSS-Co	TR	103 DIN		0°	7H	A 5-6	-	10 ÷ 30	-	-	-	-	628
6937S			HSS-Co	TR	103 DIN		0°	7H	D 3-4	-	20	-	-	-	-	628
6937T			HSS-Co	TR	103 DIN		0°	7H	C 2,5-3	-	10 ÷ 30	-	-	-	-	628

Codice Utensile   Tool code	Materiale utensile Tool material	Tipologia filetto Thread Type	DIN	Tipologia foro Hole type	Angolo elica Helix angle	Tolleranza Tolerance	Forma imbocco Chamfer Form	Rivestimento Coating	Gamma diametri Diameters range	P	M	K	N	S	H	Pagina utensile Tool page
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## ▶ RAPID

(Maschi a macchina corti | Short machine taps)

6679		HSS-Co	M DIN 13	352 DIN		0° 	6H	B 4-5	-	2 ÷ 20						526
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## ▶ N

(Maschi a macchina corti | Short machine taps)

6678		HSS-Co	M DIN 13	352 DIN		0° 	6H	C 2,5-3	-	2 ÷ 20						526
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6899		HSS-Co	MF DIN 13	2181 DIN		0° 	6H	C 2,5-3	-	6 ÷ 20						570
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6858		HSS-Co	G (BSP) DIN EN ISO 228	5157 DIN		0° 	-	C 2,5-3	-	1/16 ÷ 1 1/4						610
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## ▶ N 15°

(Maschi a macchina corti | Short machine taps)

6659		HSS-Co	M DIN 13	352 DIN		15° 	6H	C 2,5-3	-	3 ÷ 20						526
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6656		HSS-Co	MF DIN 13	2181 DIN		15° 	6H	C 2,5-3	-	5 ÷ 18						570
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6905		HSS-Co	G (BSP) DIN EN ISO 228	5157 DIN		15° 	ISO 228 +0,1	E 1-2	-	1/4 ÷ 3/4						610
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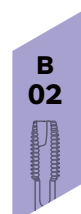
## ▶ N 40°

(Maschi a macchina corti | Short machine taps)

6639		HSS-Co	M DIN 13	352 DIN		40° 	6H	C 2,5-3	-	3 ÷ 20						526
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6604		HSS-Co	M DIN 13	352 DIN		40° 	6H	E 1,5-2	-	3 ÷ 24						526
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66046G		HSS-Co	M DIN 13	352 DIN		40° 	6G	C 2,5-3	-	3 ÷ 12						526
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Codice Utensile   Tool code	Materiale utensile Tool material	Tipologia filetto Thread Type	DIN	Tipologia foro Hole type	Angolo elica Helix angle	Tolleranza Tolerance	Forma imbocco Chamfer Form	Rivestimento Coating	Gamma diametri Diameters range	P	M	K	N	S	H	Pagina utensile Tool page
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► **VA**  
(Maschi a macchina corti | Short machine taps)

6857		HSS-Co	<b>G</b> <small>(BSP)</small> DIN EN ISO 228	<b>5157</b> DIN		0°	-	<b>C</b> 2,5-3	-	1/16 ÷ 1 1/2		-	-	-	-	<b>611</b>
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► **VA 15°**  
(Maschi a macchina corti | Short machine taps)

6648		HSS-Co	<b>M</b> DIN 13	<b>352</b> DIN		15°	<b>6HX</b>	<b>C</b> 2,5-3	-	3 ÷ 16		-	-	-	-	<b>527</b>
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6612		HSS-Co	<b>M</b> DIN 13	<b>352</b> DIN		15°	<b>6HX</b>	<b>E</b> 1,5-2	-	3 ÷ 16		-	-	-	-	<b>527</b>
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6951		HSS-Co	<b>G</b> <small>(BSP)</small> DIN EN ISO 228	<b>5157</b> DIN		15°	-	<b>E</b> 1-2	-	1/16 ÷ 1"		-	-	-	-	<b>610</b>
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► **MS**  
(Maschi a macchina corti | Short machine taps)

6624		HSS-Co	<b>M</b> DIN 13	<b>352</b> DIN		0°	<b>6H</b>	<b>E</b> 1,5-2	-	2 ÷ 12		-	-	-	-	<b>527</b>
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6724		HSS-Co	<b>MF</b> DIN 13	<b>2181</b> DIN		0°	<b>6H</b>	<b>C</b> 2,5-3	-	4 ÷ 12		-	-	-	-	<b>570</b>
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6913		HSS-Co	<b>G</b> <small>(BSP)</small> DIN EN ISO 228	<b>5157</b> DIN		0°	<b>ISO 228 +0,1</b>	<b>E</b> 1,5-2	-	1/16 ÷ 1 1/2		-	-	-	-	<b>610</b>
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► **AZ**  
(Maschi a macchina corti | Short machine taps)

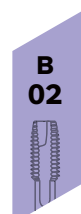
6621		HSS-Co	<b>M</b> DIN 13	<b>352</b> DIN		0°	<b>6H</b>	<b>C</b> 2,5-3	-	3 ÷ 16		-	-	-	-	<b>527</b>
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6613		HSS-Co	<b>M</b> DIN 13	<b>352</b> DIN		0°	<b>6H</b>	<b>B</b> 4-5	-	3 ÷ 16		-	-	-	-	<b>527</b>
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**B  
02**

Codice Utensile   Tool code		Materiale utensile Tool material	Tipologia filetto Thread Type	DIN	Tipologia foro Hole type	Angolo elica Helix angle	Tolleranza Tolerance	Forma imbocco Chamfer Form	Rivestimento Coating	Gamma diametri Diameters range	P	M	K	N	S	H	Pagina utensile Tool page
<b>6707</b>		HSS-Co	M	371		0°	6H	B 4-5	-	2 ÷ 10							536
<b>6707VP</b>		HSS-Co	M	371		0°	6H	B 4-5	VAP	2 ÷ 10							536
<b>67076G</b>		HSS-Co	M	371		0°	6G	B 4-5	-	2 ÷ 10							536
<b>6707TN*</b>		HSS-Co	M	371		0°	6H	B 4-5	TiN	2 ÷ 10							537
<b>67074H</b>		HSS-Co	M	371		0°	4H	B 4-5	-	2 ÷ 10							536
<b>67077G</b>		HSS-Co	M	371		0°	7G	B 4-5	-	2 ÷ 10							536
<b>6707TC</b>		HSS-Co	M	371		0°	6H	B 4-5	TiCN	2 ÷ 10							537
<b>6711</b>		HSS-Co	M	376		0°	6H	B 4-5	-	2 ÷ 52							554
<b>6711VP</b>		HSS-Co	M	376		0°	6H	B 4-5	VAP	2 ÷ 52							554
<b>67116G</b>		HSS-Co	M	376		0°	6G	B 4-5	-	2 ÷ 36							554
<b>6711TN</b>		HSS-Co	M	376		0°	6H	B 4-5	TiN	6 ÷ 30							554
<b>6711TC</b>		HSS-Co	M	376		0°	6H	B 4-5	TiCN	6 ÷ 30							555
<b>67117G</b>		HSS-Co	M	376		0°	7G	B 4-5	-	12 ÷ 24							555

\* Per tolleranza 6G codice d'ordine 6707TN (6G) | For 6G tolerance, order code 6707TN (6G)



Codice Utensile   Tool code	Materiale utensile Tool material	Tipologia filetto Thread Type	DIN	Tipologia foro Hole type	Angolo elica Helix angle	Tolleranza Tolerance	Forma imbocco Chamfer Form	Rivestimento Coating	Gamma diametri Diameters range	P	M	K	N	S	H	Pagina utensile Tool page
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**▶ RAPID**  
(Maschi a macchina | Machine taps)

6730		HSS-Co	MF DIN 13	374 DIN		0°	6H	B 4-5	-	3 ÷ 52		-	-	-	-	580
6730VP		HSS-Co	MF DIN 13	374 DIN		0°	6H	B 4-5	VAP	3 ÷ 52		-	-	-	-	580
6730TN		HSS-Co	MF DIN 13	374 DIN		0°	6H	B 4-5	TIN	3 ÷ 52		-	-	-	-	580
6730TC		HSS-Co	MF DIN 13	374 DIN		0°	6H	B 4-5	TiCN	3 ÷ 52		-	-	-	-	580
6690		HSS-Co	UNC ASME B.1.1	2184-1 DIN		0°	2B	B 4-5	-	nr.1-64 ÷ 3/8		-	-	-	-	588
66903B		HSS-Co	UNC ASME B.1.1	2184-1 DIN		0°	3B	B 4-5	-	nr.4-40 ÷ 3/8		-	-	-	-	588
6690TN		HSS-Co	UNC ASME B.1.1	2184-1 DIN		0°	2B	B 4-5	TIN	nr.16-4 ÷ 3/8		-	-	-	-	588
6693		HSS-Co	UNC ASME B.1.1	2184-1 DIN		0°	2B	B 4-5	-	7/16 ÷ 2"		-	-	-	-	594
66933B		HSS-Co	UNC ASME B.1.1	2184-1 DIN		0°	3B	B 4-5	-	7/16 ÷ 2"		-	-	-	-	594
6607		HSS-Co	UNF ASME B.1.1	2184-1 DIN		0°	2B	B 4-5	-	nr.2-64 ÷ 3/8		-	-	-	-	598
66073B		HSS-Co	UNF ASME B.1.1	2184-1 DIN		0°	3B	B 4-5	-	nr.8-36 ÷ 3/8		-	-	-	-	598
6607TN		HSS-Co	UNF ASME B.1.1	2184-1 DIN		0°	2B	B 4-5	TIN	nr.2-64 ÷ 3/8		-	-	-	-	598
6687		HSS-Co	UNF ASME B.1.1	2184-1 DIN		0°	2B	B 4-5	-	7/16 ÷ 1 1/2		-	-	-	-	602

B  
02

Codice Utensile   Tool code	Materiale utensile Tool material	Tipologia filetto Thread Type	DIN	Tipologia foro Hole type	Angolo elica Helix angle	Tolleranza Tolerance	Forma imbocco Chamfer Form	Rivestimento Coating	Gamma diametri Diameters range	P	M	K	N	S	H	Pagina utensile Tool page
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## ► RAPID

(Maschi a macchina | Machine taps)

66873B		HSS-Co	UNF <small>ASME B.1.1</small>	2184 -1 <small>DIN</small>		0°	3B	B 4-5	-	7/16 ÷ 1 1/2						602
6697		HSS-Co	BSW	2184 -1 <small>DIN 11</small>		0°	-	B 4-5	-	1/8 ÷ 5/16						606
6636		HSS-Co	BSW	2184 -1 <small>DIN 11</small>		0°	-	B 4-5	-	7/16 ÷ 1"						607
6704		HSS-Co	G <small>(BSP)</small> <small>DIN EN ISO 228</small>	5156 <small>DIN</small>		0°	-	B 4-5	-	1/8 ÷ 2"						616
6704VP		HSS-Co	G <small>(BSP)</small> <small>DIN EN ISO 228</small>	5156 <small>DIN</small>		0°	-	B 4-5	VAP	1/8 ÷ 2"						616
6704TN		HSS-Co	G <small>(BSP)</small> <small>DIN EN ISO 228</small>	5156 <small>DIN</small>		0°	-	B 4-5	TIN	1/8 ÷ 2"						616
6673		HSS-Co	Rp <small>(BSPF)</small> <small>ISO 7-1</small>	5156 <small>DIN</small>		0°	-	B 4-5	-	1/16 ÷ 2"						608
6710		HSS-Co	PG	40432 <small>DIN</small>		0°	-	B 4-5	-	7 ÷ 48						622

## ► RAPID 2

(Maschi a macchina | Machine taps)

6640		HSS-Co	M	371 <small>DIN 13</small>		0°	6H	B 4-5	-	2 ÷ 10						537
66406G		HSS-Co	M	371 <small>DIN 13</small>		0°	6G	B 4-5	-	2 ÷ 10						537

## ► N

(Maschi a macchina | Machine taps)

6706		HSS-Co	M	371 <small>DIN 13</small>		0°	6H	C 2,5-3	-	1 ÷ 10						528
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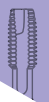


Codice Utensile   Tool code	Materiale utensile Tool material	Tipologia filetto Thread Type	DIN	Tipologia foro Hole type	Angolo elica Helix angle	Tolleranza Tolerance	Forma imbocco Chamfer Form	Rivestimento Coating	Gamma diametri Diameters range	P	M	K	N	S	H	Pagina utensile Tool page
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► **N**  
(Maschi a macchina | Machine taps)

6706TN		HSS-Co	M DIN 13	371 DIN		0°	6H	C 2,5-3	TIN	1 ÷ 10	-	-	-	-	-	528
6705		HSS-Co	M DIN 13	376 DIN		0°	6H	C 2,5-3	-	2 ÷ 52	-	-	-	-	-	546
6705TN		HSS-Co	M DIN 13	376 DIN		0°	6H	C 2,5-3	TIN	2 ÷ 33	-	-	-	-	-	546
6726		HSS-Co	MF DIN 13	374 DIN		0°	6H	C 2,5-3	-	3 ÷ 52	-	-	-	-	-	572
6726TN		HSS-Co	MF DIN 13	374 DIN		0°	6H	C 2,5-3	TIN	3 ÷ 52	-	-	-	-	-	572
6726TC		HSS-Co	MF DIN 13	374 DIN		0°	6H	C 2,5-3	TiCN	3 ÷ 52	-	-	-	-	-	572
6823		HSS-Co	UNC ASME B.1.1	2184 -1 DIN		0°	2B	C 2,5-3	-	nr.3-48 ÷ 5/16	-	-	-	-	-	586
6824		HSS-Co	UNC ASME B.1.1	2184 -1 DIN		0°	2B	C 2,5-3	-	7/16 ÷ 1"	-	-	-	-	-	592
6838		HSS-Co	UNF ASME B.1.1	2184 -1 DIN		0°	2B	C 2,5-3	-	nr.1-72 ÷ 3/8	-	-	-	-	-	596
6839		HSS-Co	UNF ASME B.1.1	2184 -1 DIN		0°	2B	C 2,5-3	-	7/16 ÷ 1 1/2	-	-	-	-	-	600
6699		HSS-Co	BSW DIN 11	2184 -1 DIN		0°	-	C 2,5-3	-	1/8 ÷ 3/8	-	-	-	-	-	606
6610		HSS-Co	NPT ASME B1.20.1	2181 DIN		0°	-	C 2,5-3	-	1/16 ÷ 2"	-	-	-	-	-	619
6611		HSS-Co	NPTF ANSI B1.20.3	2181 DIN		0°	-	C 2,5-3	-	1/16 ÷ 1 1/2	-	-	-	-	-	619

B  
02





Codice Utensile   Tool code	Materiale utensile Tool material	Tipologia filetto Thread Type	DIN	Tipologia foro Hole type	Angolo elica Helix angle	Tolleranza Tolerance	Forma imbocco Chamfer Form	Rivestimento Coating	Gamma diametri Diameters range	P	M	K	N	S	H	Pagina utensile Tool page
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## ► N (Maschi a macchina | Machine taps)

6915		HSS-Co	PG	40432 DIN		0°	-	C 2,5-3	-	7 ÷ 48	-	-	-	-	-	622
6914		HSS-Co	PG	40432 DIN		0°	-	D 4-5	-	7 ÷ 36	-	-	-	-	-	623
6790		HSS-Co	RC BSPT	5156 DIN		0°	-	C 2,5-3	-	1/8 ÷ 1"	-	-	-	-	-	618

## ► N SX (Maschi a macchina, filettatura sinistra | Machine taps, left hand thread)

6712		HSS-Co	M DIN 13	371 DIN		0°	6H	C 2,5-3	-	3 ÷ 10	-	-	-	-	-	528
6859		HSS-Co	M DIN 13	371 DIN		0°	6H	B 4-5	-	3 ÷ 10	-	-	-	-	-	537
6715		HSS-Co	M DIN 13	376 DIN		0°	6H	C 2,5-3	-	12 ÷ 24	-	-	-	-	-	546
6860		HSS-Co	M DIN 13	376 DIN		0°	6H	B 4-5	-	12 ÷ 20	-	-	-	-	-	555
6863		HSS-Co	MF DIN 13	374 DIN		0°	6H	B 4-5	-	8 ÷ 20	-	-	-	-	-	580

## ► NL 15° (Maschi a macchina, taglio destro, elica 15° a sinistra | Machine taps, right hand thread, left 15° flute)

6727		HSS-Co	M DIN 13	371 DIN		15°	6H	D 4-5	-	3 ÷ 10	-	-	-	-	-	539
6740		HSS-Co	M DIN 13	376 DIN		15°	6H	B 4-5	-	12 ÷ 20	-	-	-	-	-	558
6741		HSS-Co	MF DIN 13	374 DIN		15°	6H	B 4-5	-	8 ÷ 20	-	-	-	-	-	580



Codice Utensile   Tool code	Materiale utensile Tool material	Tipologia filetto Thread Type	DIN	Tipologia foro Hole type	Angolo elica Helix angle	Tolleranza Tolerance	Forma imbocco Chamfer Form	Rivestimento Coating	Gamma diametri Diameters range	P	M	K	N	S	H	Pagina utensile Tool page
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► **N 15°**  
(Maschi a macchina | Machine taps)

6657		HSS-Co	M DIN 13	371 DIN		15°	6H	C 2,5-3	-	2 ÷ 10	-	-	-	-	-	528
66576G		HSS-Co	M DIN 13	371 DIN		15°	6G	C 2,5-3	-	2 ÷ 10	-	-	-	-	-	528
6657TN		HSS-Co	M DIN 13	371 DIN		15°	6H	C 2,5-3	TIN	2,3 ÷ 10	-	-	-	-	-	529
6657TC		HSS-Co	M DIN 13	371 DIN		15°	6H	C 2,5-3	TiCN	2,5 ÷ 10	-	-	-	-	-	529
6902		HSS-Co	M DIN 13	371 DIN		15°	6H +0,1	C 2,5-3	-	3 ÷ 10	-	-	-	-	-	529
6658		HSS-Co	M DIN 13	376 DIN		15°	6H	C 2,5-3	-	8 ÷ 30	-	-	-	-	-	546
6658TC		HSS-Co	M DIN 13	376 DIN		15°	6H	C 2,5-3	TiCN	12 ÷ 30	-	-	-	-	-	546
6664		HSS-Co	MF DIN 13	374 DIN		15°	6H	C 2,5-3	-	8 ÷ 30	-	-	-	-	-	572
6664TN		HSS-Co	MF DIN 13	374 DIN		15°	6H	C 2,5-3	TIN	8 ÷ 30	-	-	-	-	-	572
6904		HSS-Co	MF DIN 13	374 DIN		15°	6H +0,1	E 1-2	-	20 ÷ 24	-	-	-	-	-	572
6696		HSS-Co	UNC ASME B.1.1	2184 -1 DIN		15°	2B	C 2,5-3	-	nr. 3-48 ÷ 5/16	-	-	-	-	-	586
6728		HSS-Co	UNC ASME B.1.1	2184 -1 DIN		15°	2B	C 2,5-3	-	7/16 ÷ 1/8	-	-	-	-	-	592
6719		HSS-Co	UNF ASME B.1.1	2184 -1 DIN		15°	2B	C 2,5-3	-	nr. 5-44 ÷ 3/8	-	-	-	-	-	596

B  
02

Codice Utensile   Tool code	Materiale utensile Tool material	Tipologia filetto Thread Type	DIN	Tipologia foro Hole type	Angolo elica Helix angle	Tolleranza Tolerance	Forma imbocco Chamfer Form	Rivestimento Coating	Gamma diametri Diameters range	P	M	K	N	S	H	Pagina utensile Tool page
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## ► N 15° (Maschi a macchina | Machine taps)

6729		HSS-Co	UNF <small>ASME B.1.1</small>	2184 -1 <small>DIN</small>		15°	2B	C 2,5-3	-	7/16 ÷ 1"	-	-	-	-	-	600
6665		HSS-Co	G <small>(BSP)</small> <small>DIN EN ISO 228</small>	5156 <small>DIN</small>		15°	-	C 2,5-3	-	1/8 ÷ 1"	-	-	-	-	-	613
6675		HSS-Co	Rp <small>(BSP)</small> <small>ISO 7-1</small>	5156 <small>DIN</small>		15°	-	C 2,5-3	-	1/8 ÷ 1"	-	-	-	-	-	608

## ► N 40° (Maschi a macchina | Machine taps)



























6644		HSS-Co	M <small>DIN 13</small>	371 <small>DIN</small>		40°	6H	C 2,5-3	-	2 ÷ 10	-	-	-	-	-	530
6644VP		HSS-Co	M <small>DIN 13</small>	371 <small>DIN</small>		40°	6H	C 2,5-3	VAP	2 ÷ 10	-	-	-	-	-	530
66446G		HSS-Co	M <small>DIN 13</small>	371 <small>DIN</small>		40°	6G	C 2,5-3	-	2 ÷ 10	-	-	-	-	-	530
6644TN*		HSS-Co	M <small>DIN 13</small>	371 <small>DIN</small>		40°	6H	C 2,5-3	TiN	2 ÷ 10	-	-	-	-	-	531
66447G		HSS-Co	M <small>DIN 13</small>	371 <small>DIN</small>		40°	7G	C 2,5-3	-	2 ÷ 10	-	-	-	-	-	530
6644TC		HSS-Co	M <small>DIN 13</small>	371 <small>DIN</small>		40°	6H	C 2,5-3	TiCN	2 ÷ 10	-	-	-	-	-	531
6867		HSS-Co	M <small>DIN 13</small>	371 <small>DIN</small>		40°	6H	E 1,5-2	-	3 ÷ 10	-	-	-	-	-	531
6638		HSS-Co	M <small>DIN 13</small>	376 <small>DIN</small>		40°	6H	C 2,5-3	-	3 ÷ 36	-	-	-	-	-	547
6638VP		HSS-Co	M <small>DIN 13</small>	376 <small>DIN</small>		40°	6H	C 2,5-3	VAP	3 ÷ 30	-	-	-	-	-	547

\* Per tolleranza 6G codice d'ordine 6644TN (6G) | For 6G tolerance, order code 6644TN (6G)



Codice Utensile   Tool code	Materiale utensile Tool material	Tipologia filetto Thread Type	DIN	Tipologia foro Hole type	Angolo elica Helix angle	Tolleranza Tolerance	Forma imbocco Chamfer Form	Rivestimento Coating	Gamma diametri Diameters range	P	M	K	N	S	H	Pagina utensile Tool page
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► **N 40°**  
(Maschi a macchina | Machine taps)

66386G		HSS-Co	M <small>DIN 13</small>	376 <small>DIN</small>		40°	6G	C 2,5-3	-	3 ÷ 30	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	547
66387G		HSS-Co	M <small>DIN 13</small>	376 <small>DIN</small>		40°	7G	C 2,5-3	-	8 ÷ 24	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	547
6638TN		HSS-Co	M <small>DIN 13</small>	376 <small>DIN</small>		40°	6H	C 2,5-3	TiN	12 ÷ 20	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	547
6638TC		HSS-Co	M <small>DIN 13</small>	376 <small>DIN</small>		40°	6H	C 2,5-3	TiCN	12 ÷ 20	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	547
6868		HSS-Co	M <small>DIN 13</small>	376 <small>DIN</small>		40°	6H	E 1,5-2	-	12 ÷ 20	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	547
6652		HSS-Co	MF <small>DIN 13</small>	374 <small>DIN</small>		40°	6H	C 2,5-3	-	3 ÷ 30	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	573
6652VP		HSS-Co	MF <small>DIN 13</small>	374 <small>DIN</small>		40°	6H	C 2,5-3	VAP	3 ÷ 30	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	573
6652TN		HSS-Co	MF <small>DIN 13</small>	374 <small>DIN</small>		40°	6H	C 2,5-3	TiN	3 ÷ 30	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	573
6652TC		HSS-Co	MF <small>DIN 13</small>	374 <small>DIN</small>		40°	6H	C 2,5-3	TiCN	3 ÷ 30	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	573
6877		HSS-Co	MF <small>DIN 13</small>	374 <small>DIN</small>		40°	6H	E 1-2	-	6 ÷ 20	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	573
6691		HSS-Co	UNC <small>ASME B.1.1</small>	2184 -1 <small>DIN</small>		40°	2B	C 2,5-3	-	nr. 2-56 ÷ 5/16	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	586
66913B		HSS-Co	UNC <small>ASME B.1.1</small>	2184 -1 <small>DIN</small>		40°	3B	C 2,5-3	-	nr. 2-56 ÷ 3/8	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	586
6691TN		HSS-Co	UNC <small>ASME B.1.1</small>	2184 -1 <small>DIN</small>		40°	2B	C 2,5-3	TiN	nr. 2-56 ÷ 5/16	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	586

B  
02

Codice Utensile   Tool code		Materiale utensile Tool material	Tipologia filetto Thread Type	DIN	Tipologia foro Hole type	Angolo elica Helix angle	Tolleranza Tolerance	Forma imbocco Chamfer Form	Rivestimento Coating	Gamma diametri Diameters range	P	M	K	N	S	H	Pagina utensile Tool page
6694		HSS-Co	UNC <small>ASME B.1.1</small>	2184 -1 <small>DIN</small>		40°	2B	C 2,5-3	-	7/16 ÷ 1"	-	-	-	-	-	-	592
66943B		HSS-Co	UNC <small>ASME B.1.1</small>	2184 -1 <small>DIN</small>		40°	3B	C 2,5-3	-	7/16 ÷ 1"	-	-	-	-	-	-	592
6680		HSS-Co	UNF <small>ASME B.1.1</small>	2184 -1 <small>DIN</small>		40°	2B	C 2,5-3	-	nr. 5-44 ÷ 5/16	-	-	-	-	-	-	596
66803B		HSS-Co	UNF <small>ASME B.1.1</small>	2184 -1 <small>DIN</small>		40°	3B	C 2,5-3	-	nr. 5-44 ÷ 3/8	-	-	-	-	-	-	596
6680TN		HSS-Co	UNF <small>ASME B.1.1</small>	2184 -1 <small>DIN</small>		40°	2B	C 2,5-3	TiN	nr. 5-44 ÷ 5/16	-	-	-	-	-	-	596
6688		HSS-Co	UNF <small>ASME B.1.1</small>	2184 -1 <small>DIN</small>		40°	2B	C 2,5-3	-	7/16 ÷ 1"	-	-	-	-	-	-	600
66883B		HSS-Co	UNF <small>ASME B.1.1</small>	2184 -1 <small>DIN</small>		40°	3B	C 2,5-3	-	7/16 ÷ 1"	-	-	-	-	-	-	600
6836		HSS-Co	BSW <small>DIN 11</small>	2184 -1 <small>DIN</small>		40°	-	C 2,5-3	-	1/8 ÷ 5/16	-	-	-	-	-	-	606
6837		HSS-Co	BSW <small>DIN 11</small>	2184 -1 <small>DIN</small>		40°	-	C 2,5-3	-	7/16 ÷ 1"	-	-	-	-	-	-	607
6703		HSS-Co	G (BSP) <small>DIN EN ISO 228</small>	5156 <small>DIN</small>		40°	-	C 2,5-3	-	1/16 ÷ 1"	-	-	-	-	-	-	613
6703VP		HSS-Co	G (BSP) <small>DIN EN ISO 228</small>	5156 <small>DIN</small>		40°	-	C 2,5-3	VAP	1/16 ÷ 1"	-	-	-	-	-	-	613
6703TN		HSS-Co	G (BSP) <small>DIN EN ISO 228</small>	5156 <small>DIN</small>		40°	-	C 2,5-3	TiN	1/16 ÷ 1"	-	-	-	-	-	-	613

B  
02

Codice Utensile   Tool code	Materiale utensile Tool material	Tipologia filetto Thread Type	DIN	Tipologia foro Hole type	Angolo elica Helix angle	Tolleranza Tolerance	Forma imbocco Chamfer Form	Rivestimento Coating	Gamma diametri Diameters range	P	M	K	N	S	H	Pagina utensile Tool page
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► **N SX 40°**  
(Maschi a macchina, filettatura sinistra | Machine taps, left hand thread)

<b>6861</b>		HSS-Co	M DIN 13	371 DIN		40°	6H	C 2,5-3	-	3 ÷ 10	-	-	-	-	-	<b>531</b>
<b>6862</b>		HSS-Co	M DIN 13	376 DIN		40°	6H	C 2,5-3	-	12 ÷ 20	-	-	-	-	-	<b>547</b>
<b>6864</b>		HSS-Co	MF DIN 13	374 DIN		40°	6H	C 2,5-3	-	8 ÷ 20	-	-	-	-	-	<b>573</b>

► **VA**  
(Maschi a macchina | Machine taps)

<b>6646</b>		HSS-Co	M DIN 13	371 DIN		0°	6HX	B 4-5	-	2 ÷ 10	-	-	-	-	-	<b>540</b>
<b>NEW</b> <b>6646XP</b>		HSS-Co	M DIN 13	371 DIN		0°	6HX	B 4-5	AlCrN TOP	3 ÷ 10	-	-	-	-	-	<b>540</b>
<b>6646VP</b>		HSS-Co	M DIN 13	371 DIN		0°	6HX	B 4-5	VAP	2 ÷ 10	-	-	-	-	-	<b>540</b>
<b>6646TN</b>		HSS-Co	M DIN 13	371 DIN		0°	6HX	B 4-5	TIN	2 ÷ 10	-	-	-	-	-	<b>540</b>
<b>66466G</b>		HSS-Co	M DIN 13	371 DIN		0°	6GX	B 4-5	-	2 ÷ 10	-	-	-	-	-	<b>541</b>
<b>6647</b>		HSS-Co	M DIN 13	376 DIN		0°	6HX	B 4-5	-	12 ÷ 30	-	-	-	-	-	<b>558</b>
<b>6647VP</b>		HSS-Co	M DIN 13	376 DIN		0°	6HX	B 4-5	VAP	12 ÷ 30	-	-	-	-	-	<b>558</b>
<b>NEW</b> <b>6647XP</b>		HSS-Co	M DIN 13	376 DIN		0°	6HX	B 4-5	AlCrN TOP	12 ÷ 30	-	-	-	-	-	<b>558</b>
<b>66476G</b>		HSS-Co	M DIN 13	376 DIN		0°	6GX	B 4-5	-	12 ÷ 16	-	-	-	-	-	<b>559</b>

Codice Utensile   Tool code		Materiale utensile Tool material	Tipologia filetto Thread Type	DIN	Tipologia foro Hole type	Angolo elica Helix angle	Tolleranza Tolerance	Forma imbocco Chamfer Form	Rivestimento Coating	Gamma diametri Diameters range	P	M	K	N	S	H	Pagina utensile Tool page
<b>6663</b>		HSS-Co	MF	374		0°	6HX	B 4-5	-	8 ÷ 27							<b>581</b>
<b>6663VP</b>		HSS-Co	MF	374		0°	6HX	B 4-5	VAP	8 ÷ 30							<b>581</b>
<b>66636G</b>		HSS-Co	MF	374		0°	6GX	B 4-5	-	8 ÷ 24							<b>581</b>
<b>6663TN</b>		HSS-Co	MF	374		0°	6HX	B 4-5	TiN	8 ÷ 30							<b>581</b>
<b>NEW</b> <b>6663XP</b>		HSS-Co	MF	374		0°	6HX	B 4-5	AlCrN TOP	8 ÷ 24							<b>581</b>
<b>6739</b>		HSS-Co	UNC	2184 -1		0°	2BX	B 4-5	-	nr.2-56 ÷ 3/8							<b>589</b>
<b>6739VP</b>		HSS-Co	UNC	2184 -1		0°	2BX	B 4-5	VAP	nr.2-56 ÷ 3/8							<b>589</b>
<b>NEW</b> <b>6739XP</b>		HSS-Co	UNC	2184 -1		0°	2BX	B 4-5	AlCrN TOP	nr.2-56 ÷ 3/8							<b>589</b>
<b>6749</b>		HSS-Co	UNC	2184 -1		0°	2BX	B 4-5	-	1/2 ÷ 1"							<b>594</b>
<b>6749VP</b>		HSS-Co	UNC	2184 -1		0°	2BX	B 4-5	VAP	1/2 ÷ 1"							<b>594</b>
<b>6718</b>		HSS-Co	UNF	2184 -1		0°	2BX	B 4-5	-	nr.2-64 ÷ 3/8							<b>598</b>
<b>6718VP</b>		HSS-Co	UNF	2184 -1		0°	2BX	B 4-5	VAP	nr.2-64 ÷ 3/8							<b>598</b>
<b>6797</b>		HSS-Co	UNF	2184 -1		0°	2BX	B 4-5	-	7/16 ÷ 3/4							<b>602</b>



Codice Utensile   Tool code	Materiale utensile Tool material	Tipologia filetto Thread Type	DIN	Tipologia foro Hole type	Angolo elica Helix angle	Tolleranza Tolerance	Forma imbocco Chamfer Form	Rivestimento Coating	Gamma diametri Diameters range	P	M	K	N	S	H	Pagina utensile Tool page
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► **VA**  
(Maschi a macchina | Machine taps)

6700		HSS-Co	G (BSP) DIN EN ISO 228	5156 DIN	0°	-	B 4-5	-	1/16 ÷ 1"							616
6700VP		HSS-Co	G (BSP) DIN EN ISO 228	5156 DIN	0°	-	B 4-5	VAP	1/16 ÷ 1"							616
<b>NEW</b> 6700XP		HSS-Co	G (BSP) DIN EN ISO 228	5156 DIN	0°	2BX	B 4-5	AlCrN TOP	1/16 ÷ 1"							616

B  
02

► **VA 15°**  
(Maschi a macchina | Machine taps)

6654		HSS-Co	M DIN 13	371 DIN	15°	6HX	C 2,5-3	-	2 ÷ 10							532
6654VP		HSS-Co	M DIN 13	371 DIN	15°	6HX	C 2,5-3	VAP	2 ÷ 10							532
<b>NEW</b> 6654XP		HSS-Co	M DIN 13	371 DIN	15°	6HX	C 2,5-3	AlCrN TOP	2 ÷ 10							532
<b>NEW</b> 6634VP		HSS-Co	M DIN 13	376 DIN	15°	6HX	C 2,5-3	VAP	12 ÷ 24							550
6671		HSS-Co	MF DIN 13	374 DIN	15°	6H	D 3,5	-	8 ÷ 30							576
6716		HSS-Co	G (BSP) DIN EN ISO 228	5156 DIN	15°	-	C 2,5-3	-	1/16 ÷ 1"							614

► **VA i 15°**  
(Maschi a macchina con fori di lubrificazione assiale | Machine taps with axial internal coolant)

<b>NEW</b> 6620XP		HSS-Co	M DIN 13	371 DIN	15°	6HX	C 2,5-3	AlCrN TOP	6 ÷ 10							532
<b>NEW</b> 6605XP		HSS-Co	M DIN 13	376 DIN	15°	6HX	C 2,5-3	AlCrN TOP	12 ÷ 20							550



Codice Utensile   Tool code	Materiale utensile Tool material	Tipologia filetto Thread Type	DIN	Tipologia foro Hole type	Angolo elica Helix angle	Tolleranza Tolerance	Forma imbocco Chamfer Form	Rivestimento Coating	Gamma diametri Diameters range	P	M	K	N	S	H	Pagina utensile Tool page
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## ► VA i 15°

(Maschi a macchina con fori di lubrificazione assiale | Machine taps with axial internal coolant)

<b>NEW</b>		HSS-Co	MF DIN 13	374 DIN		15°	6HX	C 2,5-3	AlCrN TOP	8 ÷ 24							576
6626XP																	

## ► VA 35°

(Maschi a macchina | Machine taps)

6655		HSS-Co	MF DIN 13	374 DIN		35°	6HX	C 2,5-3	-	8 ÷ 30							576
6655VP		HSS-Co	MF DIN 13	374 DIN		35°	6HX	C 2,5-3	VAP	8 ÷ 30							576
<b>NEW</b>		HSS-Co	MF DIN 13	374 DIN		35°	6HX	C 2,5-3	AlCrN TOP	8 ÷ 30							576
6655XP																	
66556G		HSS-Co	MF DIN 13	374 DIN		35°	6GX	C 2,5-3	-	8 ÷ 20							577
6735		HSS-Co	UNC ASME B.1.1	2184 -1 DIN		35°	2BX	C 2,5-3	-	nr.6-32 ÷ 5/16							587
6735VP		HSS-Co	UNC ASME B.1.1	2184 -1 DIN		35°	2BX	C 2,5-3	VAP	nr.6-32 ÷ 5/16							587
<b>NEW</b>		HSS-Co	UNC ASME B.1.1	2184 -1 DIN		35°	2BX	C 2,5-3	AlCrN TOP	nr.6-32 ÷ 5/16							587
6735XP																	
6754		HSS-Co	UNC ASME B.1.1	2184 -1 DIN		35°	2BX	C 2,5-3	-	1/2 ÷ 1"							592
6754VP		HSS-Co	UNC ASME B.1.1	2184 -1 DIN		35°	2BX	C 2,5-3	VAP	1/2 ÷ 1"							593
6794		HSS-Co	UNF ASME B.1.1	2184 -1 DIN		35°	2BX	C 2,5-3	-	nr.10-32 ÷ 3/8							597
6794VP		HSS-Co	UNF ASME B.1.1	2184 -1 DIN		35°	2BX	C 2,5-3	VAP	nr.10-32 ÷ 3/8							597

B  
02

Codice Utensile   Tool code	Materiale utensile Tool material	Tipologia filetto Thread Type	DIN	Tipologia foro Hole type	Angolo elica Helix angle	Tolleranza Tolerance	Forma imbocco Chamfer Form	Rivestimento Coating	Gamma diametri Diameters range	P	M	K	N	S	H	Pagina utensile Tool page
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► **VA 35°**  
(Maschi a macchina | Machine taps)

6796		HSS-Co	UNF ASME B.1.1	2184 -1 DIN		35°	2B	C 2,5-3	-	7/16 ÷ 3/4		-	-	-	-	601
6945VP		HSS-Co	UN-8 ASME B.1.1	2184 -1 DIN		35°	2B	C 2,5-3	VAP	1 1/8 ÷ 1 1/2		-	-	-	-	604
6701		HSS-Co	G DIN EN ISO 228	5156 DIN		35°	-	C 2,5-3	-	1/8 ÷ 1"		-	-	-	-	614
6701VP		HSS-Co	G (BSP) DIN EN ISO 228	5156 DIN		35°	-	C 2,5-3	VAP	1/8 ÷ 1"		-	-	-	-	614
<b>NEW</b> 6701XP		HSS-Co	G (BSP) DIN EN ISO 228	5156 DIN		35°	-	C 2,5-3	AlCrN TOP	1/8 ÷ 1"		-	-	-	-	614

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02

► **VR 35°**  
(Maschi a macchina rastremati | Back tapered machine taps)

6661		HSS-Co	M DIN 13	371 DIN		35°	6HX	C 2,5-3	-	2 ÷ 10		-	-	-	-	532
6661VP		HSS-Co	M DIN 13	371 DIN		35°	6HX	C 2,5-3	VAP	2 ÷ 10		-	-	-	-	533
66616G		HSS-Co	M DIN 13	371 DIN		35°	6GX	C 2,5-3	-	2 ÷ 10		-	-	-	-	533
6661TN		HSS-Co	M DIN 13	371 DIN		35°	6HX	C 2,5-3	TiN	2 ÷ 10		-	-	-	-	533
<b>NEW</b> 6661XP		HSS-Co	M DIN 13	371 DIN		35°	6HX	C 2,5-3	AlCrN TOP	2 ÷ 10		-	-	-	-	533
6662		HSS-Co	M DIN 13	376 DIN		35°	6HX	C 2,5-3	-	12 ÷ 24		-	-	-	-	550
6662VP		HSS-Co	M DIN 13	376 DIN		35°	6HX	C 2,5-3	VAP	12 ÷ 24		-	-	-	-	550

Codice Utensile   Tool code	Materiale utensile Tool material	Tipologia filetto Thread Type	DIN	Tipologia foro Hole type	Angolo elica Helix angle	Tolleranza Tolerance	Forma imbocco Chamfer Form	Rivestimento Coating	Gamma diametri Diameters range	P	M	K	N	S	H	Pagina utensile Tool page
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## ► VR 35°

(Maschi a macchina rastremati | Back tapered machine taps)

<b>NEW</b> 6662XP		HSS-Co	M DIN 13	376 DIN		35°	6HX	C 2,5-3	AlCrN TOP	12 ÷ 24			-	-	-	551
66626G		HSS-Co	M DIN 13	376 DIN		35°	6GX	C 2,5-3	-	12 ÷ 16			-	-	-	551

## ► VR 50°

(Maschi a macchina rastremati | Back tapered machine taps)

6850VP		HSS-Co	M DIN 13	371 DIN		50°	6HX	C 2,5-3	VAP	2 ÷ 10			-	-	-	533
6850TN		HSS-Co	M DIN 13	371 DIN		50°	6HX	C 2,5-3	TiN	2 ÷ 10			-	-	-	533
6851VP		HSS-Co	M DIN 13	376 DIN		50°	6HX	C 2,5-3	VAP	12 ÷ 24			-	-	-	551
6851TN		HSS-Co	M DIN 13	376 DIN		50°	6HX	C 2,5-3	TiN	12 ÷ 24			-	-	-	551
6852VP		HSS-Co	UNC ASME B.1.1	2181 DIN		50°	2BX	C 2,5-3	VAP	nr.6-32 ÷ 3/8			-	-	-	587
6853VP		HSS-Co	UNC ASME B.1.1	2181 DIN		50°	2BX	C 2,5-3	VAP	1/2 ÷ 1"			-	-	-	593
6854VP		HSS-Co	UNF ASME B.1.1	2181 DIN		50°	2BX	C 2,5-3	VAP	nr.10-32 ÷ 3/8			-	-	-	597
6855VP		HSS-Co	UNF ASME B.1.1	2181 DIN		50°	2BX	C 2,5-3	VAP	7/16 ÷ 3/4			-	-	-	601
6856VP		HSS-Co	G (BSP) DIN EN ISO 228	5156 DIN		50°	-	C 2,5-3	VAP	1/8 ÷ 1"			-	-	-	615



Codice Utensile   Tool code		Materiale utensile Tool material	Tipologia filetto Thread Type	DIN	Tipologia foro Hole type	Angolo elica Helix angle	Tolleranza Tolerance	Forma imbocco Chamfer Form	Rivestimento Coating	Gamma diametri Diameters range	P	M	K	N	S	H	Pagina utensile Tool page
<b>6870</b>		HSS-Co	M	371		0°	6H	B 4-5	-	2 ÷ 10	-						541
<b>6870TF</b>		HSS-Co	M	371		0°	6H	B 4-5	TiAIN FUTURA	2 ÷ 10	-						541
<b>6871</b>		HSS-Co	M	376		0°	6H	B 4-5	-	12 ÷ 30	-						559
<b>6871TF</b>		HSS-Co	M	376		0°	6H	B 4-5	TiAIN FUTURA	12 ÷ 30	-						559
<b>6872</b>		HSS-Co	MF	374		0°	6H	B 4-5	-	6 ÷ 24	-						581
<b>NEW</b> <b>6872TF</b>		HSS-Co	MF	374		0°	6H	B 4-5	TiAIN FUTURA	6 ÷ 24	-						581
<b>6873</b>		HSS-Co	UNC	2184 -1		0°	2B	B 4-5	-	nr.2-56 ÷ 5/16	-						588
<b>6874</b>		HSS-Co	UNC	2184 -1		0°	2B	B 4-5	-	7/16 ÷ 1"	-						594
<b>6875</b>		HSS-Co	UNF	2184 -1		0°	2B	B 4-5	-	nr.2-64 ÷ 3/8	-						598
<b>6876</b>		HSS-Co	UNF	2184 -1		0°	2B	B 4-5	-	7/16 ÷ 1"	-						602
<b>6912</b>		HSS-Co	G (BSP)	5156		0°	-	C 2,5-3	-	1/8 ÷ 2"	-						612
<b>6912TN</b>		HSS-Co	G (BSP)	5156		0°	-	C 2,5-3	TiN	1/8 ÷ 2"	-						612
<b>6917</b>		HSS-Co	NPT	371		0°	-	C 2,5-3	-	1/16 ÷ 1/4	-						620

**B  
02**

Codice Utensile   Tool code	Materiale utensile Tool material	Tipologia filetto Thread Type	DIN	Tipologia foro Hole type	Angolo elica Helix angle	Tolleranza Tolerance	Forma imbocco Chamfer Form	Rivestimento Coating	Gamma diametri Diameters range	P	M	K	N	S	H	Pagina utensile Tool page
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## ► HD (Maschi a macchina | Machine taps)

6917TN		HSS-Co	NPT <small>ASME B1.20.1</small>	-371 <small>DIN</small>		0°	-	C 2,5-3	TiN	1/16 ÷ 1/4	-	-	-	-	-	620
6918		HSS-Co	NPT <small>ASME B1.20.1</small>	-374 <small>DIN</small>		0°	-	C 2,5-3	-	3/8 ÷ 1 1/2	-	-	-	-	-	621
6923		HSS-Co	NPTF <small>ANSI B1.20.3</small>	-371 <small>DIN</small>		0°	-	C 2,5-3	-	1/16 ÷ 1/4	-	-	-	-	-	620
6924		HSS-Co	NPTF <small>ANSI B1.20.3</small>	-374 <small>DIN</small>		0°	-	C 2,5-3	-	3/8 ÷ 1 1/2	-	-	-	-	-	621

## ► HD 15° (Maschi a macchina | Machine taps)

6878		HSS-Co	M <small>DIN 13</small>	371 <small>DIN</small>		15°	6H	C 2,5-3	-	3 ÷ 10	-	-	-	-	-	529
<b>NEW</b>	6878HL 	HSS-Co	M <small>DIN 13</small>	371 <small>DIN</small>		15°	6H	C 2,5-3	TiAIN HL EVO	3 ÷ 10	-	-	-	-	-	529
6879		HSS-Co	M <small>DIN 13</small>	376 <small>DIN</small>		15°	6H	C 2,5-3	-	12 ÷ 30	-	-	-	-	-	552
<b>NEW</b>	6879HL 	HSS-Co	M <small>DIN 13</small>	376 <small>DIN</small>		15°	6H	C 2,5-3	TiAIN HL EVO	12 ÷ 30	-	-	-	-	-	553
6880		HSS-Co	MF <small>DIN 13</small>	374 <small>DIN</small>		15°	6H	C 2,5-3	-	6 ÷ 24	-	-	-	-	-	577
<b>NEW</b>	6880HL 	HSS-Co	MF <small>DIN 13</small>	374 <small>DIN</small>		15°	6H	C 2,5-3	TiAIN HL EVO	6 ÷ 24	-	-	-	-	-	577
6866		HSS-Co	UNC <small>ASME B.1.1</small>	2184 -1 <small>DIN</small>		15°	2B	C 2,5-3	-	7/16 ÷ 1"	-	-	-	-	-	593
6848		HSS-Co	UNF <small>ASME B.1.1</small>	2184 -1 <small>DIN</small>		15°	2B	C 2,5-3	-	nr.5-44 ÷ 3/8	-	-	-	-	-	597

B  
02

Codice Utensile   Tool code	Materiale utensile Tool material	Tipologia filetto Thread Type	DIN	Tipologia foro Hole type	Angolo elica Helix angle	Tolleranza Tolerance	Forma imbocco Chamfer Form	Rivestimento Coating	Gamma diametri Diameters range	P	M	K	N	S	H	Pagina utensile Tool page
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► **HD 15°**  
(Maschi a macchina | Machine taps)

6849		HSS-Co	UNF <small>ASME B.1.1</small>	2184 -1 <small>DIN</small>		15°	2B	C 2,5-3	-	7/16 ÷ 1"	-	-	-	-	-	601
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► **HD 40°**  
(Maschi a macchina | Machine taps)

6666		HSS-Co	M <small>DIN 13</small>	371 <small>DIN</small>		40°	6H	C 2,5-3	-	3 ÷ 10	-	-	-	-	-	535
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66666G		HSS-Co	M <small>DIN 13</small>	371 <small>DIN</small>		40°	6G	C 2,5-3	-	3 ÷ 10	-	-	-	-	-	535
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66664H		HSS-Co	M <small>DIN 13</small>	371 <small>DIN</small>		40°	4H	C 2,5-3	-	3 ÷ 10	-	-	-	-	-	535
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6666TF		HSS-Co	M <small>DIN 13</small>	371 <small>DIN</small>		40°	6H	C 2,5-3	TiAIN FUTURA	3 ÷ 10	-	-	-	-	-	535
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6667		HSS-Co	M <small>DIN 13</small>	376 <small>DIN</small>		40°	6H	C 2,5-3	-	3 ÷ 20	-	-	-	-	-	553
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6667TN		HSS-Co	M <small>DIN 13</small>	376 <small>DIN</small>		40°	6H	C 2,5-3	TIN	3 ÷ 20	-	-	-	-	-	553
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6667TF		HSS-Co	M <small>DIN 13</small>	376 <small>DIN</small>		40°	6H	C 2,5-3	TiAIN FUTURA	3 ÷ 20	-	-	-	-	-	553
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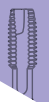
► **HR 40°**  
(Maschi a macchina rastremati | Back tapered machine taps)

6681		HSS-Co	M <small>DIN 13</small>	371 <small>DIN</small>		40°	6H	C 2,5-3	-	3 ÷ 10	-	-	-	-	-	535
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6681TF		HSS-Co	M <small>DIN 13</small>	371 <small>DIN</small>		40°	6H	C 2,5-3	TiAIN FUTURA	3 ÷ 10	-	-	-	-	-	535
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6689		HSS-Co	M <small>DIN 13</small>	376 <small>DIN</small>		40°	6H	C 2,5-3	-	12 ÷ 20	-	-	-	-	-	553
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B  
02



Codice Utensile   Tool code	Materiale utensile Tool material	Tipologia filetto Thread Type	DIN	Tipologia foro Hole type	Angolo elica Helix angle	Tolleranza Tolerance	Forma imbocco Chamfer Form	Rivestimento Coating	Gamma diametri Diameters range	P	M	K	N	S	H	Pagina utensile Tool page
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## ► HR 40°

(Maschi a macchina rastremati | Back tapered machine taps)

6689TF		HSS-Co	M <small>DIN 13</small>	376 <small>DIN</small>		40°	6H	C 2,5-3	TIAIN FUTURA	12 ÷ 20						553
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## ► GG

(Maschi a macchina | Machine taps)

6631		HSS-Co	M <small>DIN 13</small>	371 <small>DIN</small>		0°	6HX	C 2,5-3	NIT	3 ÷ 10						534
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6631TF		HSS-Co	M <small>DIN 13</small>	371 <small>DIN</small>		0°	6HX	C 2,5-3	TIAIN FUTURA	3 ÷ 10						534
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6632		HSS-Co	M <small>DIN 13</small>	376 <small>DIN</small>		0°	6HX	C 2,5-3	NIT	6 ÷ 30						552
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6632TF		HSS-Co	M <small>DIN 13</small>	376 <small>DIN</small>		0°	6HX	C 2,5-3	TIAIN FUTURA	6 ÷ 30						552
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6653		HSS-Co	MF <small>DIN 13</small>	374 <small>DIN</small>		0°	6HX	C 2,5-3	NIT	8 ÷ 24						577
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6708		HSS-Co	G <small>(BSP) DIN EN ISO 228</small>	5156 <small>DIN</small>		0°	-	C 2,5-3	NIT	1/16 ÷ 2"						615
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6708TF		HSS-Co	G <small>(BSP) DIN EN ISO 228</small>	5156 <small>DIN</small>		0°	-	C 2,5-3	TIAIN FUTURA	1/16 ÷ 2"						615
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6674		HSS-Co	Rp <small>(BSP) ISO 7-1</small>	5157 <small>DIN</small>		0°	-	C 2,5-3	NIT	1/8 ÷ 2"						608
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## ► MULTI GG i

(Maschi a macchina con fori di lubrificazione | Machine taps with internal coolant)

6629		HSS-Co	M <small>DIN 13</small>	371 <small>DIN</small>		0°	6HX	C 2,5-3	NIT	5 ÷ 10						534
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6629TC		HSS-Co	M <small>DIN 13</small>	371 <small>DIN</small>		0°	6HX	C 2,5-3	TiCN	5 ÷ 10						534
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02



Codice Utensile   Tool code	Materiale utensile Tool material	Tipologia filetto Thread Type	DIN	Tipologia foro Hole type	Angolo elica Helix angle	Tolleranza Tolerance	Forma imbocco Chamfer Form	Rivestimento Coating	Gamma diametri Diameters range	P	M	K	N	S	H	Pagina utensile Tool page
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**► MULTI GG i**

(Maschi a macchina con fori di lubrificazione | Machine taps with internal coolant)

6637		HSS-Co	M DIN 13	376 DIN		0°	6HX	C 2,5-3	NIT	12 ÷ 20	-	-	-	-	-	552
6637TC		HSS-Co	M DIN 13	376 DIN		0°	6HX	C 2,5-3	TiCN	12 ÷ 20	-	-	-	-	-	552

**► AZ**

(Maschi a macchina | Machine taps)

6820		HSS-Co	M DIN 13	371 DIN		0°	6H	C 2,5-3	-	2 ÷ 10	-	-	-	-	-	528
6616		HSS-Co	M DIN 13	371 DIN		0°	6H	B 4-5	-	2 ÷ 10	-	-	-	-	-	539
6821		HSS-Co	M DIN 13	376 DIN		0°	6H	C 2,5-3	-	6 ÷ 16	-	-	-	-	-	546
6617		HSS-Co	M DIN 13	376 DIN		0°	6H	B 4-5	-	12 ÷ 20	-	-	-	-	-	558
6916		HSS-Co	NPT ASME B1.20.1	-371 DIN		0°	-	C 2,5-3	-	1/16 ÷ 3/4	-	-	-	-	-	619
6919		HSS-Co	NPT ASME B1.20.1	-371 DIN		0°	-	C 2,5-3	-	1/16 ÷ 1/4	-	-	-	-	-	620
6920		HSS-Co	NPT ASME B1.20.1	-376 DIN		0°	-	C 2,5-3	-	3/8 ÷ 1 1/2	-	-	-	-	-	621

**► AZ 35°**

(Maschi a macchina | Machine taps)

6921		HSS-Co	NPT ASME B1.20.1	-371 DIN		35°	-	C 2,5-3	-	1/16 ÷ 1/4	-	-	-	-	-	620
6921TN		HSS-Co	NPT ASME B1.20.1	-371 DIN		35°	-	C 2,5-3	TiN	1/16 ÷ 1/4	-	-	-	-	-	620



Codice Utensile   Tool code	Materiale utensile Tool material	Tipologia filetto Thread Type	DIN	Tipologia foro Hole type	Angolo elica Helix angle	Tolleranza Tolerance	Forma imbocco Chamfer Form	Rivestimento Coating	Gamma diametri Diameters range	P	M	K	N	S	H	Pagina utensile Tool page
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## ► AZ 35° (Maschi a macchina | Machine taps)

6922		HSS-Co	NPT <small>ASME B1.20.1</small>	376 <small>DIN</small>		35°	-	C 2,5-3	-	3/8 ÷ 1 1/4							621
6925		HSS-Co	NPTF <small>ANSI B1.20.3</small>	374 <small>DIN</small>		35°	-	C 2,5-3	-	1/16 ÷ 1/4							621
6926		HSS-Co	NPTF <small>ANSI B1.20.3</small>	374 <small>DIN</small>		35°	-	C 2,5-3	-	3/8 ÷ 1 1/2							621

## ► ALU (Maschi a macchina | Machine taps)

6641		HSS-Co	M <small>DIN 13</small>	371 <small>DIN</small>		0°	6H	B 4-5	-	2 ÷ 10							541
6642		HSS-Co	M <small>DIN 13</small>	376 <small>DIN</small>		0°	6H	B 4-5	-	12 ÷ 20							559

## ► ALU 45° (Maschi a macchina | Machine taps)

6643		HSS-Co	M <small>DIN 13</small>	371 <small>DIN</small>		45°	6H	C 2,5-3	-	2 ÷ 10							534
6651		HSS-Co	M <small>DIN 13</small>	376 <small>DIN</small>		45°	6HX	C 2,5-3	-	8 ÷ 20							552
6731		HSS-Co	MF <small>DIN 13</small>	374 <small>DIN</small>		45°	6H	C 2,5-3	-	8 ÷ 20							577
6732		HSS-Co	UNC <small>ASME B.1.1</small>	2184 -1 <small>DIN</small>		45°	2B	C 2,5-3	-	nr.4-40 ÷ 3/8							587
6733		HSS-Co	UNC <small>ASME B.1.1</small>	2184 -1 <small>DIN</small>		45°	2B	C 2,5-3	-	1/2							593
6628		HSS-Co	UNF <small>ASME B.1.1</small>	2184 -1 <small>DIN</small>		45°	2B	C 2,5-3	-	nr.10-32 ÷ 3/8							597



Codice Utensile   Tool code	Materiale utensile Tool material	Tipologia filetto Thread Type	DIN	Tipologia foro Hole type	Angolo elica Helix angle	Tolleranza Tolerance	Forma imbocco Chamfer Form	Rivestimento Coating	Gamma diametri Diameters range	P	M	K	N	S	H	Pagina utensile Tool page
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## ▶ ALU 45° (Maschi a macchina | Machine taps)

6734		HSS-Co	UNF <small>ASME B.1.1</small>	2184 -1 <small>DIN</small>		45°	2B	C 2,5-3	-	nr.10-32 ÷ 3/8	-	-	-	-	-	601
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## ▶ BAK (Maschi a macchina | Machine taps)

6670		HSS-Co	M <small>DIN 13</small>	371 <small>DIN</small>		0°	6HX	E 1,5-2	NIT	2,3 ÷ 10	-	-	-	-	-	534
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02

## ▶ ULTRA (Maschi a macchina | Machine taps)

6606		HSS-Co	M <small>DIN 13</small>	371 <small>DIN</small>		0°	6HX	B 4-5	NIT	2 ÷ 10	-	-	-	-	-	538
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66066G		HSS-Co	M <small>DIN 13</small>	371 <small>DIN</small>		0°	6GX	B 4-5	NIT	2 ÷ 10	-	-	-	-	-	538
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6737		HSS-Co	UNC <small>ASME B.1.1</small>	2184 -1 <small>DIN</small>		0°	2B	B 4-5	NIT	nr.1-64 ÷ 3/8	-	-	-	-	-	589
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## ▶ ULTRA S (Maschi a macchina | Machine taps)

6649		HSS-Co	M <small>DIN 13</small>	371 <small>DIN</small>		0°	6HX	B 4-5	NIT	2 ÷ 10	-	-	-	-	-	538
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66496G		HSS-Co	M <small>DIN 13</small>	371 <small>DIN</small>		0°	6GX	B 4-5	NIT	2,2 ÷ 10	-	-	-	-	-	538
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6649TN		HSS-Co	M <small>DIN 13</small>	371 <small>DIN</small>		0°	6HX	B 4-5	TIN	2 ÷ 7	-	-	-	-	-	539
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## ▶ EG (M) (Maschi a macchina per filetti riportati [Helicoil] | Machine taps for wire thread inserts [Helicoil])

6908	Dimensioni similari a DIN 371 Similar dimensions to DIN 371 	HSS-Co	M <small>DIN 13</small>	8140 -2 <small>DIN</small>		0°	6H MOD.	B 4-5	-	3 ÷ 8	-	-	-	-	-	625
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Codice Utensile   Tool code	Materiale utensile Tool material	Tipologia filetto Thread Type	DIN	Tipologia foro Hole type	Angolo elica Helix angle	Tolleranza Tolerance	Forma imbocco Chamfer Form	Rivestimento Coating	Gamma diametri Diameters range	P	M	K	N	S	H	Pagina utensile Tool page
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## ► EG (M)

(Maschi a macchina per filetti riportati [Helicoil] | Machine taps for wire thread inserts [Helicoil])

6909	<p>Dimensioni simili a DIN 376 Similar dimensions to DIN 376</p>	HSS-Co	M DIN 13	8140 -2 DIN		0°	6H MOD.	B 4-5	-	10 ÷ 16		-	-	-	-	627
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## ► EG (M) 40°

(Maschi a macchina per filetti riportati [Helicoil] | Machine taps for wire thread inserts [Helicoil])

6910	<p>Dimensioni simili a DIN 371 Similar dimensions to DIN 371</p>	HSS-Co	M DIN 13	8140 -2 DIN		40°	6H MOD.	C 2,5-3	-	3 ÷ 8		-	-	-	-	624
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6911	<p>Dimensioni simili a DIN 376 Similar dimensions to DIN 376</p>	HSS-Co	M DIN 13	8140 -2 DIN		40°	6H MOD.	C 2,5-3	-	10 ÷ 16		-	-	-	-	626
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## ► N

(Maschi a macchina con gambo lungo | Machine taps with long shank)

6672		HSS-Co	M DIN 13	ILIX NORM DIN		0°	6H	B 4-5	-	3 ÷ 14		-	-	-	-	562
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## ► N

(Maschi a macchina con gambo extra lungo | Machine taps with extra long shank)

6692		HSS-Co	M DIN 13	ILIX NORM DIN		0°	6H	B 4-5	-	3 ÷ 8		-	-	-	-	564
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6695		HSS-Co	M DIN 13	ILIX NORM DIN		0°	6H	B 4-5	-	8 ÷ 20		-	-	-	-	565
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## ► N 30°

(Maschi a macchina con gambo extra lungo | Machine taps with extra long shank)

NEW Tech 6840		HSS-Co	M DIN 13	ILIX NORM DIN		30°	6H	C 2,5-3	-	3 ÷ 8		-	-	-	-	566
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NEW Tech 6841		HSS-Co	M DIN 13	ILIX NORM DIN		30°	6H	C 2,5-3	-	8 ÷ 20		-	-	-	-	567
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Codice Utensile   Tool code	Materiale utensile Tool material	Tipologia filetto Thread Type	DIN	Tipologia foro Hole type	Angolo elica Helix angle	Tolleranza Tolerance	Forma imbocco Chamfer Form	Rivestimento Coating	Gamma diametri Diameters range	P	M	K	N	S	H	Pagina utensile Tool page
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► **N**  
(Maschi a macchina per dadi | Machine nut taps)

6660		HSS-Co	M DIN 13	357 DIN 13		0°	6H	A 6-8	-	3 ÷ 30	-	-	-	-	-	563
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► **TR**  
(Maschi a macchina trapezoidali | Trapezoidal machine taps)

6938		HSS-Co	TR DIN	103 DIN		0°	7H	2/3 x 1/2	-	10 ÷ 36	-	-	-	-	-	629
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6939		HSS-Co	TR DIN	103 DIN		0°	7H	2/3 x 1/2	-	10 ÷ 36	-	-	-	-	-	629
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► **FORMER**  
(Maschi a rullare | Cold forming taps)

6722		HSS-Co	M DIN 13	2174 DIN		-	6HX	C 2,5-3	NIT	1 ÷ 10	-	-	-	-	-	543
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6722BL		HSS-Co	M DIN 13	2174 DIN		-	6HX	C 2,5-3	-	1 ÷ 10	-	-	-	-	-	543
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6722TN		HSS-Co	M DIN 13	2174 DIN		-	6HX	C 2,5-3	TIN	1 ÷ 10	-	-	-	-	-	543
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6722TF		HSS-Co	M DIN 13	2174 DIN		-	6HX	C 2,5-3	TiAIN FUTURA	1 ÷ 10	-	-	-	-	-	543
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6622		HSS-Co	M DIN 13	2174 DIN		-	6GX	C 2,5-3	NIT	2 ÷ 10	-	-	-	-	-	542
------	--	--------	-------------	-------------	--	---	-----	------------	-----	--------	---	---	---	---	---	-----

6622BL		HSS-Co	M DIN 13	2174 DIN		-	6GX	C 2,5-3	-	2 ÷ 10	-	-	-	-	-	542
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6622TN		HSS-Co	M DIN 13	2174 DIN		-	6GX	C 2,5-3	TIN	2 ÷ 10	-	-	-	-	-	542
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B  
02

Codice Utensile   Tool code	Materiale utensile Tool material	Tipologia filetto Thread Type	DIN	Tipologia foro Hole type	Angolo elica Helix angle	Tolleranza Tolerance	Forma imbocco Chamfer Form	Rivestimento Coating	Gamma diametri Diameters range	P	M	K	N	S	H	Pagina utensile Tool page
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## ► FORMER

(Maschi a rullare | Cold forming taps)

6723		HSS-Co	M DIN 13	2174 DIN		-	6HX	C 2,5-3	NIT	12 ÷ 16						560
6723TN		HSS-Co	M DIN 13	2174 DIN		-	6HX	C 2,5-3	TiN	12 ÷ 16						560
6623		HSS-Co	M DIN 13	2174 DIN		-	6HX	C 2,5-3	NIT	12 ÷ 16						560
6623TN		HSS-Co	M DIN 13	2174 DIN		-	6HX	C 2,5-3	TiN	12 ÷ 16						560
6721		HSS-Co	MF DIN 13	2174 DIN		-	6HX	C 2,5-3	NIT	8 ÷ 16						584
67216G		HSS-Co	MF DIN 13	2174 DIN		-	6GX	C 2,5-3	NIT	8 ÷ 16						584
6738		HSS-Co	UNC ASME B.1.1	2184 -1 DIN		-	2BX	C 2,5-3	NIT	nr.2-56 ÷ 3/8						590
6747		HSS-Co	UNF ASME B.1.1	2184 -1 DIN		-	2BX	C 2,5-3	NIT	nr.4-48 ÷ 3/8						599
6702		HSS-Co	G (BSP) DIN EN ISO 228	2189 DIN		-	2BX	B 4-5	NIT	1/16 ÷ 1/2						617

## ► FORMER S

(Maschi a rullare con canalini di lubrificazione esterni | Cold forming taps with coolant grooves)

6709		HSS-Co	M DIN 13	2174 DIN		-	6HX	C 2,5-3	NIT	3 ÷ 10						544
6709TN		HSS-Co	M DIN 13	2174 DIN		-	6HX	C 2,5-3	TiN	3 ÷ 10						544



Codice Utensile   Tool code	Materiale utensile Tool material	Tipologia filetto Thread Type	DIN	Tipologia foro Hole type	Angolo elica Helix angle	Tolleranza Tolerance	Forma imbocco Chamfer Form	Rivestimento Coating	Gamma diametri Diameters range	P	M	K	N	S	H	Pagina utensile Tool page
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## ► FORMER S

(Maschi a rullare con canali di lubrificazione esterni | Cold forming taps with coolant grooves)

6709TF		HSS-Co	M DIN 13	2174 DIN		-	6HX C 2,5-3	TiAIN FUTURA	3 ÷ 10							545
6808		HSS-Co	M DIN 13	2174 DIN		-	6GX C 2,5-3	NIT	3 ÷ 10							544
6808BL		HSS-Co	M DIN 13	2174 DIN		-	6GX C 2,5-3		3 ÷ 10							544
6808TN		HSS-Co	M DIN 13	2174 DIN		-	6GX C 2,5-3	TIN	3 ÷ 10							545
6819		HSS-Co	M DIN 13	2174 DIN		-	7GX C 2,5-3	NIT	8 ÷ 10							545
6725		HSS-Co	M DIN 13	2174 DIN		-	6HX C 2,5-3	NIT	12 ÷ 16							561
6725TN		HSS-Co	M DIN 13	2174 DIN		-	6HX C 2,5-3	TIN	12 ÷ 16							561
6809		HSS-Co	M DIN 13	2174 DIN		-	6GX C 2,5-3	NIT	12 ÷ 16							561
6809TN		HSS-Co	M DIN 13	2174 DIN		-	6GX C 2,5-3	TIN	12 ÷ 16							561
6720		HSS-Co	MF DIN 13	2174 DIN		-	6HX C 2,5-3	NIT	8 ÷ 16							584
67206G		HSS-Co	MF DIN 13	2174 DIN		-	6GX C 2,5-3	NIT	8 ÷ 16							584
6802		HSS-Co	UNC ASME B.1.1	2184 -1 DIN		-	2BX C 2,5-3	NIT	nr.5-40 ÷ 3/8							590
<b>NEW</b> 6811TN		HSS-Co	UNC ASME B.1.1	2184 -1 DIN		-	2BX C 2,5-3	TIN	1/2 ÷ 3/4							591

B  
02

Codice Utensile   Tool code	Materiale utensile Tool material	Tipologia filetto Thread Type	DIN	Tipologia foro Hole type	Angolo elica Helix angle	Tolleranza Tolerance	Forma imbocco Chamfer Form	Rivestimento Coating	Gamma diametri Diameters range	P	M	K	N	S	H	Pagina utensile Tool page
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## ► FORMER S

(Maschi a rullare con canali di lubrificazione esterni | Cold forming taps with coolant grooves)

6815		HSS-Co	UNF <small>ASME B.1.1</small>	2184 -1 DIN		-	2BX	C 2,5-3	NIT	nr.8-36 ÷ 5/16						599
<b>NEW</b> 6815TN		HSS-Co	UNF <small>ASME B.1.1</small>	2184 -1 DIN		-	2BX	C 2,5-3	TiN	nr.5-44 ÷ 3/8						599
6816		HSS-Co	UNF <small>ASME B.1.1</small>	2184 -1 DIN		-	2BX	C 2,5-3	NIT	1/2 ÷ 5/8						603
<b>NEW</b> 6816TN		HSS-Co	UNF <small>ASME B.1.1</small>	2184 -1 DIN		-	2BX	C 2,5-3	TiN	7/16 ÷ 5/8						603
6818		HSS-Co	G (BSP) <small>DIN EN ISO 228</small>	2184 -1 DIN		-	-	C 2,5-3	NIT	3/8						617
<b>NEW</b> 6818TN		HSS-Co	G (BSP) <small>DIN EN ISO 228</small>	2184 -1 DIN		-	-	C 2,5-3	TiN	1/16 ÷ 1/2						617

B  
02







**MASCHI TRADIZIONALI**  
**TAPS**

**B.02.02**

**Gamma prodotti**  
Products range

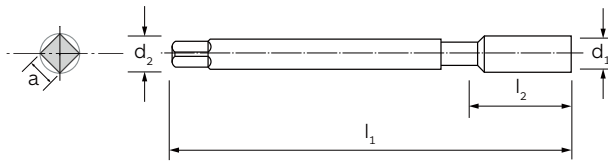
**B  
02**



Maschi a mano in serie di 3 pezzi composta da sbozzatore (P), intermedio (S), finitore (T)  
Hand taps, series in set of 3 pieces, consisting of taper (P), plug (S) and bottom (T)

**M**  
DIN 13

**352**  
DIN



MATERIALE | MATERIAL  
TIPO | TYPE  
RIVESTIMENTO/ TRATTAMENTO | COATING/ TREATMENT  
ANGOLO ELICA | HELIX ANGLE  
DIREZIONE TAGLIO | CUTTING DIRECTION  
LUBRIFICAZIONE INTERNA | INTERNAL COOLANT  
TOLLERANZA | TOLERANCE  
FORMA D'IMBOCCO/FILETTI | CHAMFER FORM/THREADS  
TIPO DI FORO | HOLE TYPE

- P** | Acciai | Steels  
**M** | Acciai Inossidabili | Stainless Steels  
**K** | Ghise | Cast Irons  
**N** | Metalli non ferrosi | Non-ferrous metals  
**S** | Leghe resistenti al calore e Titanio | HRSA and Titanium  
**H** | Acciai Temprati | Hardened Steels

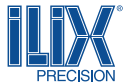
HSS	HSS	HSS	HSS	HSS	HSS
N	N	N	N	N	N
-	-	-	-	-	-
0°	0°	0°	0°	0°	0°
↻	↻	↻	↻	↻	↻
-	-	-	-	-	-
6H	6H	6H	6H	6H	6H
A/5-6	D/3-4	C/2,5-3	A/5-6	D/3-4	C/2,5-3
P	P	P	P	P	P
M	M	M	M	M	M
K	K	K	K	K	K
N	N	N	N	N	N
S	S	S	S	S	S
-	-	-	-	-	-

d <sub>1</sub>	P		l <sub>1</sub>	l <sub>2</sub>	d <sub>2</sub> (h9**)	a (h12)	6615P	6615S	6615T	6615	6618P	6618S	6618T	6618
							<b>6615</b> (Serie   Set)				<b>6618</b> (Serie   Set)			

d <sub>1</sub>	P		l <sub>1</sub>	l <sub>2</sub>	d <sub>2</sub> (h9**)	a (h12)	6615P	6615S	6615T	6615	6618P	6618S	6618T	6618
1,0	0,25	0,75	32	5,5	2,5	2,1	●	●	●	●	-	-	-	-
1,1	0,25	0,85	32	5,5	2,5	2,1	●	●	●	●	-	-	-	-
1,2	0,25	0,95	32	5,5	2,5	2,1	●	●	●	●	-	-	-	-
1,4	0,30	1,10	32	7,0	2,5	2,1	●	●	●	●	-	-	-	-
1,6	0,35	1,25	32	8,0	2,5	2,1	●	●	●	●	-	-	-	-
1,7*	0,35	1,30	32	8,0	2,5	2,1	●	●	●	●	-	-	-	-
1,8	0,35	1,45	32	8,0	2,5	2,1	●	●	●	●	-	-	-	-
2,0	0,40	1,60	36	8,0	2,8	2,1	●	●	●	●	-	-	-	-
2,2	0,45	1,75	36	9,0	2,8	2,1	●	●	●	●	-	-	-	-
2,3*	0,40	1,90	36	9,0	2,8	2,1	●	●	●	●	-	-	-	-
2,5	0,45	2,05	40	9,0	2,8	2,1	●	●	●	●	-	-	-	-
2,6*	0,45	2,10	40	9,0	2,8	2,1	●	●	●	●	-	-	-	-
3,0	0,50	2,50	40	11,0	3,5	2,7	●	●	●	●	●	●	●	●
3,0*	0,60	2,40	40	11,0	3,5	2,7	-	■	-	-	-	-	-	-
3,5	0,60	2,90	45	13,0	4,0	3,0	●	■	●	●	-	-	■	■
4,0	0,70	3,30	45	13,0	4,5	3,4	●	●	●	●	●	●	●	●
4*	0,75	3,25	45	13,0	4,5	3,4	■	-	■	■	-	-	-	-
4,5	0,75	3,70	50	16,0	6,0	4,9	●	●	●	●	-	-	-	-
5,0	0,80	4,20	50	16,0	6,0	4,9	●	●	●	●	●	●	●	●
5*	0,90	4,10	50	16,0	6,0	4,9	■	-	-	-	-	-	-	-
6,0	1,00	5,00	50	19,0	6,0	4,9	●	●	●	●	●	●	●	●
7,0	1,00	6,00	50	19,0	6,0	4,9	●	●	●	●	●	●	●	●
8,0	1,25	6,80	56	22,0	6,0	4,9	●	●	●	●	●	●	●	●
9,0	1,25	7,80	63	22,0	7,0	5,5	●	●	●	●	-	-	-	-

\* Misura non in standard ISO | These sizes are not ISO standard. ■ Fino ad esaurimento scorte | Till stocks last  
\*\* La tolleranza del gambo per il 1° e 2° maschio è h 12 | Shank tolerance of 1st and 2nd tap h 12

# M - DIN 352



Maschi a mano in serie di 3 pezzi composta da sbozzatore (P), intermedio (S), finitore (T)  
Hand taps, series in set of 3 pieces, consisting of taper (P), plug (S) and bottom (T)

HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co
VA	VA	VA	Ti	Ti	Ti
-	-	-	NIT	NIT	NIT
0°	0°	0°	0°	0°	0°
-	-	-	-	-	-
6HX	6HX	6HX	6HX	6HX	6HX
A/5-6	D/3-4	C/2,5-3	A/5-6	D/3-4	C/2,5-3
P	P	P	-	-	-
M	M	M	M	M	M
-	-	-	-	-	-
N	N	N	-	-	-
S	S	S	S	S	S
-	-	-	-	-	-

MATERIALE   MATERIAL
TIPO   TYPE
RIVESTIMENTO/ TRATTAMENTO   COATING/ TREATMENT
ANGOLO ELICA   HELIX ANGLE
DIREZIONE TAGLIO   CUTTING DIRECTION
LUBRIFICAZIONE INTERNA   INTERNAL COOLANT
TOLLERANZA   TOLERANCE
FORMA D'IMBOCCO/FILETTI   CHAMFER FORM/THREADS
TIPO DI FORO   HOLE TYPE
<b>P</b>   Acciai   Steels
<b>M</b>   Acciai Inossidabili   Stainless Steels
<b>K</b>   Ghise   Cast Irons
<b>N</b>   Metalli non ferrosi   Non-ferrous metals
<b>S</b>   Leghe resistenti al calore e Titanio   HRSA and Titanium
<b>H</b>   Acciai Temprati   Hardened Steels

GRUPPO MATERIALI MATERIAL GROUPS



<b>6614P</b>	<b>6614S</b>	<b>6614T</b>	<b>6625P</b>	<b>6625S</b>	<b>6625T</b>	$d_1$	P		$l_1$	$l_2$
<b>6614</b> (Serie   Set)			<b>6625</b> (Serie   Set)							

6614P	6614S	6614T	6614	6625P	6625S	6625T	6625	$d_1$	P	$l_1$	$l_2$	
-	-	-	-	-	-	-	-	1,0	0,25	0,75	32	5,5
-	-	-	-	-	-	-	-	1,1	0,25	0,85	32	5,5
-	-	-	-	-	-	-	-	1,2	0,25	0,95	32	5,5
-	-	-	-	-	-	-	-	1,4	0,30	1,10	32	7,0
-	-	-	-	-	-	-	-	1,6	0,35	1,25	32	8,0
-	-	-	-	-	-	-	-	1,7*	0,35	1,30	32	8,0
-	-	-	-	-	-	-	-	1,8	0,35	1,45	32	8,0
●	●	●	●	●	●	●	●	2,0	0,40	1,60	36	8,0
-	-	■	■	■	■	■	■	2,2	0,45	1,75	36	9,0
■	■	■	■	-	-	■	■	2,3*	0,40	1,90	36	9,0
●	●	●	●	●	●	●	●	2,5	0,45	2,05	40	9,0
-	-	■	■	■	-	■	-	2,6*	0,45	2,10	40	9,0
●	●	●	●	●	●	●	●	3,0	0,50	2,50	40	11,0
-	-	-	■	-	-	-	-	3,0*	0,60	2,40	40	11,0
-	■	■	-	■	■	■	■	3,5	0,60	2,90	45	13,0
●	●	●	●	●	●	●	●	4,0	0,70	3,30	45	13,0
-	-	-	-	-	-	-	-	4*	0,75	3,25	45	13,0
-	-	-	-	-	-	-	-	4,5	0,75	3,70	50	16,0
●	●	●	●	●	●	●	●	5,0	0,80	4,20	50	16,0
■	-	-	-	-	-	-	-	5*	0,90	4,10	50	16,0
●	●	●	●	●	●	●	●	6,0	1,00	5,00	50	19,0
●	●	●	●	-	-	■	-	7,0	1,00	6,00	50	19,0
●	●	●	●	●	●	●	●	8,0	1,25	6,80	56	22,0
-	-	-	-	-	-	-	-	9,0	1,25	7,80	63	22,0

■ Fino ad esaurimento scorte | Till stocks last

01/02

Maschi a mano in serie di 3 pezzi composta da sbozzatore (P), intermedio (S), finitore (T)  
Hand taps, series in set of 3 pieces, consisting of taper (P), plug (S) and bottom (T)

d <sub>1</sub>	P		l <sub>1</sub>	l <sub>2</sub>	d <sub>2</sub> (h9**)	a (h12)	6615P	6615S	6615T	6618P	6618S	6618T		
							6615 (Serie   Set)				6618 (Serie   Set)			
							6615P	6615S	6615T	6615	6618P	6618S	6618T	6618
<b>10,0</b>	1,50	8,50	70	24,0	7,0	6,2	●	●	●	●	●	●	●	●
<b>11,0</b>	1,50	9,50	70	24,0	8,0	5,5	●	●	●	●	-	-	-	-
<b>12,0</b>	1,75	10,20	75	29,0	9,0	7,0	●	●	●	●	●	●	●	●
<b>14,0</b>	2,00	12,00	80	30,0	11,0	9,0	●	●	●	●	●	●	●	●
<b>16,0</b>	2,00	14,00	80	32,0	12,0	9,0	●	●	●	●	●	●	●	●
<b>18,0</b>	2,50	15,50	95	40,0	14,0	11,0	●	●	●	●	-	■	■	-
<b>20,0</b>	2,50	17,50	95	40,0	16,0	12,0	●	●	●	●	●	●	●	●
<b>22,0</b>	2,50	19,50	100	40,0	18,0	14,5	●	●	●	●	-	-	-	-
<b>24,0</b>	3,00	21,00	110	50,0	18,0	14,5	●	●	●	●	-	-	-	-
<b>27,0</b>	3,00	24,00	110	50,0	20,0	16,0	●	●	●	●	-	-	-	-
<b>30,0</b>	3,50	26,50	125	56,0	22,0	18,0	●	●	●	●	-	-	-	-
<b>33,0</b>	3,50	29,50	125	56,0	25,0	20,0	●	●	●	●	-	-	-	-
<b>36,0</b>	4,00	32,00	150	63,0	28,0	22,0	●	●	●	●	-	-	-	-
<b>39,0</b>	4,00	35,00	150	63,0	32,0	24,0	●	●	●	●	-	-	-	-
<b>42,0</b>	4,50	37,50	150	63,0	32,0	24,0	●	●	●	●	-	-	-	-
<b>45,0</b>	4,50	40,50	160	70,0	36,0	29,0	●	●	●	●	-	-	-	-
<b>48,0</b>	5,00	43,00	180	75,0	36,0	29,0	●	●	●	●	-	-	-	-
<b>52,0</b>	5,00	47,00	180	75,0	40,0	32,0	●	●	●	●	-	-	-	-
<b>56,0</b>	5,50	50,50	200	85,0	45,0	35,0	●	●	●	●	-	-	-	-
<b>60,0</b>	5,50	54,50	200	85,0	45,0	35,0	●	●	●	●	-	-	-	-
<b>64,0</b>	6,00	58,00	220	90,0	50,0	39,0	●	●	●	●	-	-	-	-
<b>68,0</b>	6,00	62,00	220	90,0	50,0	29,0	●	●	●	●	-	-	-	-

02/02

\*\* La tolleranza del gambo per il 1° e 2° maschio è h 12 | Shank tolerance of 1st and 2nd tap h 12


■ Fino ad esaurimento scorte | Till stocks last

B  
02



# M - DIN 352

Maschi a mano in serie di 3 pezzi composta da sbozzatore (P), intermedio (S), finitore (T)  
 Hand taps, series in set of 3 pieces, consisting of taper (P), plug (S) and bottom (T)

6614P	6614S	6614T	6625P	6625S	6625T		d <sub>1</sub>	P		l <sub>1</sub>	l <sub>2</sub>	
6614 (Serie   Set)				6625 (Serie   Set)								
●	●	●	●	●	●	●	●	<b>10,0</b>	1,50	8,50	70	24,0
-	-	-	-	-	-	-	-	<b>11,0</b>	1,50	9,50	70	24,0
●	●	●	●	●	●	●	●	<b>12,0</b>	1,75	10,20	75	29,0
●	●	●	●	●	●	●	●	<b>14,0</b>	2,00	12,00	80	30,0
●	●	●	●	●	●	●	●	<b>16,0</b>	2,00	14,00	80	32,0
●	●	●	●	●	●	●	●	<b>18,0</b>	2,50	15,50	95	40,0
●	●	●	●	●	●	●	●	<b>20,0</b>	2,50	17,50	95	40,0
-	-	-	-	-	-	-	-	<b>22,0</b>	2,50	19,50	100	40,0
-	-	-	-	-	-	-	-	<b>24,0</b>	3,00	21,00	110	50,0
-	-	-	-	-	-	-	-	<b>27,0</b>	3,00	24,00	110	50,0
-	-	-	-	-	-	-	-	<b>30,0</b>	3,50	26,50	125	56,0
-	-	-	-	-	-	-	-	<b>33,0</b>	3,50	29,50	125	56,0
-	-	-	-	-	-	-	-	<b>36,0</b>	4,00	32,00	150	63,0
-	-	-	-	-	-	-	-	<b>39,0</b>	4,00	35,00	150	63,0
-	-	-	-	-	-	-	-	<b>42,0</b>	4,50	37,50	150	63,0
-	-	-	-	-	-	-	-	<b>45,0</b>	4,50	40,50	160	70,0
-	-	-	-	-	-	-	-	<b>48,0</b>	5,00	43,00	180	75,0
-	-	-	-	-	-	-	-	<b>52,0</b>	5,00	47,00	180	75,0
-	-	-	-	-	-	-	-	<b>56,0</b>	5,50	50,50	200	85,0
-	-	-	-	-	-	-	-	<b>60,0</b>	5,50	54,50	200	85,0
-	-	-	-	-	-	-	-	<b>64,0</b>	6,00	58,00	220	90,0
-	-	-	-	-	-	-	-	<b>68,0</b>	6,00	62,00	220	90,0

02/02



SET Maschi a mano in serie di 3 pezzi in cassetta metallica  
Hand taps SET, series in set of 3 pieces in metal cases

<b>M</b>	<b>352</b>
DIN 13	DIN

HSS	HSS	HSS
N	N	N
-	-	-
0°	0°	0°
-	-	-
6H	6H	6H
A/5-6	D/3-4	C/2,5-3
P	P	P
M	M	M
K	K	K
N	N	N
S	S	S
-	-	-

MATERIALE | MATERIAL

TIPO | TYPE

RIVESTIMENTO/ TRATTAMENTO | COATING/ TREATMENT

ANGOLO ELICA | HELIX ANGLE

DIREZIONE TAGLIO | CUTTING DIRECTION

LUBRIFICAZIONE INTERNA | INTERNAL COOLANT

TOLLERANZA | TOLERANCE

FORMA D'IMBOCCO/FILETTI | CHAMFER FORM/THREADS

TIPO DI FORO | HOLE TYPE

**P** | Acciai | Steels

**M** | Acciai Inossidabili | Stainless Steels

**K** | Ghise | Cast Irons

**N** | Metalli non ferrosi | Non-ferrous metals

**S** | Leghe resistenti al calore e Titanio | HRSA and Titanium

**H** | Acciai Temprati | Hardened Steels

B  
02

GRUPPO MATERIALI  
MATERIAL GROUPS

## SET MASCHI A MANO Hand Taps SET

6615P

6615S

6615T



**6608-3/12**

Codice d'ordine **SET**  
SET Order Code

Cassetta metallica | Metal Case

**M 3**

Sbozzatore (P) - Intermedio (S) - Finitore (T)  
Taper (P) - Plug (S) - Bottom (T)

●

●

●

**M 4**

Sbozzatore (P) - Intermedio (S) - Finitore (T)  
Taper (P) - Plug (S) - Bottom (T)

●

●

●

**M 5**

Sbozzatore (P) - Intermedio (S) - Finitore (T)  
Taper (P) - Plug (S) - Bottom (T)

●

●

●

**M 6**

Sbozzatore (P) - Intermedio (S) - Finitore (T)  
Taper (P) - Plug (S) - Bottom (T)

●

●

●

**M 8**

Sbozzatore (P) - Intermedio (S) - Finitore (T)  
Taper (P) - Plug (S) - Bottom (T)

●

●

●

**M 10**

Sbozzatore (P) - Intermedio (S) - Finitore (T)  
Taper (P) - Plug (S) - Bottom (T)

●

●

●

**M 12**

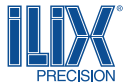
Sbozzatore (P) - Intermedio (S) - Finitore (T)  
Taper (P) - Plug (S) - Bottom (T)

●

●

●

# M - DIN 352



SET Maschi a mano in serie di 3 pezzi e relative misure di punte (DIN 338) per preforatura  
Hand taps SET, series in set of 3 pieces and twist drills for tap drill hole according to DIN 338

<b>M</b>	<b>352</b>
DIN 13	DIN

HSS	HSS	HSS
N	N	N
-	-	-
0°	0°	0°
-	-	-
6H	6H	6H
A/5-6	D/3-4	C/2,5-3
P	P	P
M	M	M
K	K	K
N	N	N
S	S	S
-	-	-

MATERIALE | MATERIAL

TIPO | TYPE

RIVESTIMENTO/ TRATTAMENTO | COATING/ TREATMENT

ANGOLO ELICA | HELIX ANGLE

DIREZIONE TAGLIO | CUTTING DIRECTION

LUBRIFICAZIONE INTERNA | INTERNAL COOLANT

TOLLERANZA | TOLERANCE

FORMA D'IMBOCCO/FILETTI | CHAMFER FORM/THREADS

TIPO DI FORO | HOLE TYPE

GRUPPO MATERIALI  
MATERIAL GROUPS

**P** | Acciai | Steels

**M** | Acciai Inossidabili | Stainless Steels

**K** | Ghise | Cast Irons

**N** | Metalli non ferrosi | Non-ferrous metals

**S** | Leghe resistenti al calore e Titanio | HRSA and Titanium

**H** | Acciai Temprati | Hardened Steels

## SET MASCHI A MANO E RELATIVE PUNTE PER PREFORO

Hand Taps SET and twist drills for tap drill hole

6615P

6615S

6615T



**6609-3/12**

Codice d'ordine SET  
SET Order Code

Cassetta metallica | Metal Case

<b>M 3</b>	Sbozzatore (P) - Intermedio (S) - Finitore (T) Taper (P) - Plug (S) - Bottom (T)	●	●	●
∅ 2,5	<b>Punta 6151 - DIN 338 per preforatura</b>   Twist drills 6151 - DIN 338 for tap drill			
<b>M 4</b>	Sbozzatore (P) - Intermedio (S) - Finitore (T) Taper (P) - Plug (S) - Bottom (T)	●	●	●
∅ 3,3	<b>Punta 6151 - DIN 338 per preforatura</b>   Twist drills 6151 - DIN 338 for tap drill			
<b>M 5</b>	Sbozzatore (P) - Intermedio (S) - Finitore (T) Taper (P) - Plug (S) - Bottom (T)	●	●	●
∅ 4,2	<b>Punta 6151 - DIN 338 per preforatura</b>   Twist drills 6151 - DIN 338 for tap drill			
<b>M 6</b>	Sbozzatore (P) - Intermedio (S) - Finitore (T) Taper (P) - Plug (S) - Bottom (T)	●	●	●
∅ 5,0	<b>Punta 6151 - DIN 338 per preforatura</b>   Twist drills 6151 - DIN 338 for tap drill			
<b>M 8</b>	Sbozzatore (P) - Intermedio (S) - Finitore (T) Taper (P) - Plug (S) - Bottom (T)	●	●	●
∅ 6,8	<b>Punta 6151 - DIN 338 per preforatura</b>   Twist drills 6151 - DIN 338 for tap drill			
<b>M 10</b>	Sbozzatore (P) - Intermedio (S) - Finitore (T) Taper (P) - Plug (S) - Bottom (T)	●	●	●
∅ 8,5	<b>Punta 6151 - DIN 338 per preforatura</b>   Twist drills 6151 - DIN 338 for tap drill			
<b>M 12</b>	Sbozzatore (P) - Intermedio (S) - Finitore (T) Taper (P) - Plug (S) - Bottom (T)	●	●	●
∅ 10,2	<b>Punta 6151 - DIN 338 per preforatura</b>   Twist drills 6151 - DIN 338 for tap drill			

B  
02

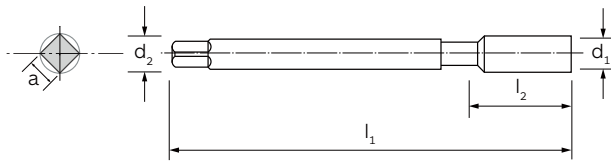
**M**

**352**

DIN 13

DIN

P. 632 →



MATERIALE   MATERIAL
TIPO   TYPE
RIVESTIMENTO/ TRATTAMENTO   COATING/ TREATMENT
ANGOLO ELICA   HELIX ANGLE
DIREZIONE TAGLIO   CUTTING DIRECTION
LUBRIFICAZIONE INTERNA   INTERNAL COOLANT
TOLLERANZA   TOLERANCE
FORMA D'IMBOCCO/FILETTI   CHAMFER FORM/THREADS
TIPO DI FORO   HOLE TYPE

- P** | Acciai | Steels
- M** | Acciai Inossidabili | Stainless Steels
- K** | Ghise | Cast Irons
- N** | Metalli non ferrosi | Non-ferrous metals
- S** | Leghe resistenti al calore e Titanio | HRSA and Titanium
- H** | Acciai Temprati | Hardened Steels

HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co
N	N 15°	N 40°	N 40°	N 40°	Rapid
-	-	-	-	-	-
0°	15°	40°	40°	40°	0°
↻	↻	↻	↻	↻	↻
-	-	-	-	-	-
6H	6H	6H	6H	6G	6H
C/2,5-3	C/2,5-3	C/2,5-3	E/1,5-2	E/1,5-2	B/4-5
P	P	P	P	P	P
-	-	-	-	-	M
K	K	K	K	K	K
N	N	N	N	N	N
-	-	-	-	-	-
-	-	-	-	-	-

d <sub>1</sub>	P		l <sub>1</sub>	l <sub>2</sub>	l <sub>2</sub> (N 40°)	d <sub>2</sub> (h9)	a (h12)	6678	6659	6639	6604	66046G	6679
----------------	---	--	----------------	----------------	---------------------------	------------------------	------------	------	------	------	------	--------	------

2,0	0,40	1,60	36	8	-	2,8	2,1	●	-	-	-	-	●
2,2	0,45	1,75	36	9	-	2,8	2,1	●	-	-	-	-	●
2,3*	0,40	1,90	36	9	-	2,8	2,1	●	-	-	-	-	●
2,5	0,45	2,05	40	9	-	2,8	2,1	●	-	-	-	-	●
2,6*	0,45	2,10	40	9	-	2,8	2,1	●	-	-	-	-	●
3,0	0,50	2,50	40	11	5	3,5	2,7	●	●	●	●	●	●
3,5	0,60	2,90	45	13	6	4,0	3,0	●	●	●	-	-	■
4,0	0,70	3,30	45	13	7	4,5	3,4	●	●	●	●	●	●
5,0	0,80	4,20	50	16	8	6,0	4,9	●	●	●	●	●	●
6,0	1,00	5,00	50	19	10	6,0	4,9	●	●	●	●	●	●
7,0	1,00	6,00	50	19	10	6,0	4,9	-	●	●	-	-	■
8,0	1,25	6,80	56	22	12	6,0	4,9	●	●	●	●	●	●
10,0	1,50	8,50	70	24	14	7,0	5,5	●	●	●	●	●	●
12,0	1,75	10,20	75	29	16	9,0	7,0	●	●	●	●	●	●
14,0	2,00	12,00	80	30	20	11,0	9,0	●	●	●	-	-	●
16,0	2,00	14,00	80	32	20	12,0	9,0	●	●	●	●	-	●
18,0	2,50	15,50	95	40	25	14,0	11,0	●	●	●	-	-	●
20,0	2,50	17,50	95	40	25	16,0	12,0	●	●	●	●	-	●
24,0	3,00	21,00	110	38	30	18,0	14,5	-	-	-	●	-	-

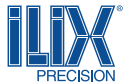
\* Misura non in standard ISO | These sizes are not ISO standard. ■ Fino ad esaurimento scorte | Till stocks last

B  
02



# M - DIN 352

Maschi a macchina corti | Short machine taps



HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co
AZ	AZ	VA 15°	VA 15°	MS
-	-	-	-	-
0°	0°	15°	15°	0°
↻	↻	↻	↻	↻
-	-	-	-	-
6H	6H	6HX	6HX	6H
B/4-5	C/2,5-3	C/2,5-3	E/1,5-2	E/1,5-2
P	P	P	P	-
M	M	M	M	-
-	-	-	-	-
N	N	N	N	N
-	-	S	S	-
-	-	-	-	-

MATERIALE   MATERIAL
TIPO   TYPE
RIVESTIMENTO/ TRATTAMENTO   COATING/ TREATMENT
ANGOLO ELICA   HELIX ANGLE
DIREZIONE TAGLIO   CUTTING DIRECTION
LUBRIFICAZIONE INTERNA   INTERNAL COOLANT
TOLLERANZA   TOLERANCE
FORMA D'IMBOCCO/FILETTI   CHAMFER FORM/THREADS
TIPO DI FORO   HOLE TYPE
<b>P</b>   Acciai   Steels
<b>M</b>   Acciai Inossidabili   Stainless Steels
<b>K</b>   Ghise   Cast Irons
<b>N</b>   Metalli non ferrosi   Non-ferrous metals
<b>S</b>   Leghe resistenti al calore e Titanio   HRSA and Titanium
<b>H</b>   Acciai Temprati   Hardened Steels

6613	6621	6648	6612	6624		d <sub>1</sub>	P		l <sub>1</sub>	l <sub>2</sub>
-	-	-	-	●		2,0	0,40	1,60	36	8
-	-	-	-	●		2,2	0,45	1,75	36	9
-	-	-	-	●		2,3*	0,40	1,90	36	9
-	-	-	-	●		2,5	0,45	2,05	40	9
-	-	-	-	●		2,6*	0,45	2,10	40	9
●	●	●	●	●		3,0	0,50	2,50	40	11
-	-	●	-	●		3,5	0,60	2,90	45	13
●	●	●	●	●		4,0	0,70	3,30	45	13
●	●	●	●	●		5,0	0,80	4,20	50	16
●	●	●	●	●		6,0	1,00	5,00	50	19
-	-	-	-	●		7,0	1,00	6,00	50	19
●	●	●	●	●		8,0	1,25	6,80	56	22
●	●	●	●	●		10,0	1,50	8,50	70	24
●	●	●	●	●		12,0	1,75	10,20	75	29
-	-	●	-	-		14,0	2,00	12,00	80	30
●	●	●	●	-		16,0	2,00	14,00	80	32
-	-	-	-	-		18,0	2,50	15,50	95	40
-	-	-	-	-		20,0	2,50	17,50	95	40
-	-	-	-	-		24,0	3,00	21,00	110	38

**B 02**  
GRUPPO MATERIALI  
MATERIAL GROUPS

**NEW**  
C

**M**

**371**

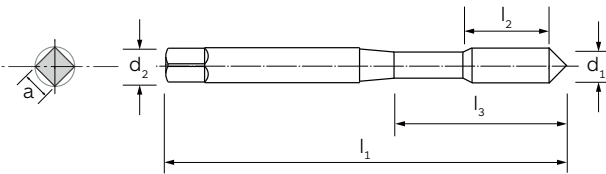


6878HL

DIN 13

DIN

P. 632 →



MATERIALE | MATERIAL

TIPO | TYPE

RIVESTIMENTO/ TRATTAMENTO | COATING/ TREATMENT

ANGOLO ELICA | HELIX ANGLE

DIREZIONE TAGLIO | CUTTING DIRECTION

LUBRIFICAZIONE INTERNA | INTERNAL COOLANT

TOLLERANZA | TOLERANCE

FORMA D'IMBOCCO/FILETTI | CHAMFER FORM/THREADS

TIPO DI FORO | HOLE TYPE

**P** | Acciai | Steels

**M** | Acciai Inossidabili | Stainless Steels

**K** | Ghise | Cast Irons

**N** | Metalli non ferrosi | Non-ferrous metals

**S** | Leghe resistenti al calore e Titanio | HRSA and Titanium

**H** | Acciai Temprati | Hardened Steels

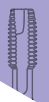
GRUPPO MATERIALI  
MATERIAL GROUPS

HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co
N	N	N	AZ	N 15°	N 15°
-	TiN	-	-	-	-
0°	0°	0°	0°	15°	15°
↻	↻	↻	↻	↻	↻
-	-	-	-	-	-
6H	6H	6H	6H	6H	6G
C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3
P	P	P	P	P	P
-	-	-	M	-	-
K	K	K	-	K	K
N	N	N	N	N	N
-	-	-	-	-	-
-	-	-	-	-	-

d <sub>1</sub>	P		l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub> (h9)	a (h12)	6706	6706TN	6712	6820	6657	66576G
1,0	0,25	0,75	40	-	5,5	2,5	2,1	●	●	-	-	-	-
1,1	0,25	0,85	40	-	5,5	2,5	2,1	●	●	-	-	-	-
1,2	0,25	0,95	40	-	5,5	2,5	2,1	●	●	-	-	-	-
1,4	0,30	1,10	40	-	7	2,5	2,1	●	●	-	-	-	-
1,6	0,35	1,25	40	-	8	2,5	2,1	●	●	-	-	-	-
1,7*	0,35	1,30	40	-	8	2,5	2,1	●	●	-	-	-	-
1,8	0,35	1,45	40	-	8	2,5	2,1	●	●	-	-	-	-
2,0	0,40	1,60	45	4	8	2,8	2,1	●	●	-	●	●	●
2,2	0,45	1,75	45	4	9	2,8	2,1	●	-	-	-	-	-
2,3*	0,40	1,90	45	4	9	2,8	2,1	●	●	-	-	■	-
2,5	0,45	2,05	50	4	9	2,8	2,1	●	●	-	-	●	●
2,6*	0,45	2,10	50	4	9	2,8	2,1	●	●	-	-	●	-
3,0	0,50	2,50	56	5	11	3,5	2,7	●	●	●	●	●	●
3*	0,60	2,40	56	5	11	3,5	2,7	●	-	-	-	-	-
3,5	0,60	2,90	56	6	13	4,0	3,0	●	●	-	-	●	●
4,0	0,70	3,30	63	7	13	4,5	3,4	●	●	●	●	●	●
4*	0,75	3,25	63	7	13	4,5	3,4	●	-	-	-	-	-
5,0	0,80	4,20	70	8	16	6,0	4,9	●	●	●	●	●	●
5*	0,90	4,10	70	8	16	6,0	4,9	■	-	-	-	-	-
6,0	1,00	5,00	80	10	19	6,0	4,9	●	●	●	●	●	●
7,0	1,00	6,00	80	10	19	7,0	5,5	●	●	-	-	●	-
8,0	1,25	6,80	90	12	22	8,0	6,2	●	●	●	●	●	●
9,0	1,25	7,80	90	12	22	9,0	7,0	●	●	-	-	-	-
10,0	1,50	8,50	100	14	24	10,0	8,0	●	●	●	●	●	●

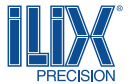
\* Misura non in standard ISO | These sizes are not ISO standard. ■ Fino ad esaurimento scorte | Till stocks last

B  
02



# M - DIN 371

Maschi a macchina con gambo rinforzato | Machine taps with reinforced shank



HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co
N 15°	N 15°	N 15°	HD 15°	HD 15°
TiN	TiCN	-	-	TiAlN HL EVO
15°	15°	15°	15°	15°
↻	↻	↻	↻	↻
-	-	-	-	-
6H	6H	6H+0,1	6H	6H
C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3
P	P	P	P	P
M	M	-	-	-
K	K	K	K	K
N	N	N	-	-
-	-	-	-	-
-	-	-	-	-

MATERIALE   MATERIAL
TIPO   TYPE
RIVESTIMENTO/ TRATTAMENTO   COATING/ TREATMENT
ANGOLO ELICA   HELIX ANGLE
DIREZIONE TAGLIO   CUTTING DIRECTION
LUBRIFICAZIONE INTERNA   INTERNAL COOLANT
TOLLERANZA   TOLERANCE
FORMA D'IMBOCCO/FILETTI   CHAMFER FORM/THREADS
TIPO DI FORO   HOLE TYPE
<b>P</b>   Acciai   Steels
<b>M</b>   Acciai Inossidabili   Stainless Steels
<b>K</b>   Ghise   Cast Irons
<b>N</b>   Metalli non ferrosi   Non-ferrous metals
<b>S</b>   Leghe resistenti al calore e Titanio   HRSA and Titanium
<b>H</b>   Acciai Temprati   Hardened Steels

GRUPPO MATERIALI  
MATERIAL GROUPS

**B  
02**



6657TN	6657TC	6902	6878	6878HL		d <sub>1</sub>	P		l <sub>1</sub>	l <sub>2</sub>
-	-	-	-	-		1,0	0,25	0,75	40	-
-	-	-	-	-		1,1	0,25	0,85	40	-
-	-	-	-	-		1,2	0,25	0,95	40	-
-	-	-	-	-		1,4	0,30	1,10	40	-
-	-	-	-	-		1,6	0,35	1,25	40	-
-	-	-	-	-		1,7*	0,35	1,30	40	-
-	-	-	-	-		1,8	0,35	1,45	40	-
-	-	-	-	-		2,0	0,40	1,60	45	4
-	-	-	-	-		2,2	0,45	1,75	45	4
■	-	-	-	-		2,3*	0,40	1,90	45	4
-	■	-	-	-		2,5	0,45	2,05	50	4
-	■	-	-	-		2,6*	0,45	2,10	50	4
●	●	●	■	■		3,0	0,50	2,50	56	5
-	-	-	-	-		3*	0,60	2,40	56	5
-	-	-	-	-		3,5	0,60	2,90	56	6
●	●	●	●	●		4,0	0,70	3,30	63	7
-	-	-	-	-		4*	0,75	3,25	63	7
●	●	●	●	●		5,0	0,80	4,20	70	8
-	-	-	-	-		5*	0,90	4,10	70	8
●	●	●	●	●		6,0	1,00	5,00	80	10
-	-	-	-	-		7,0	1,00	6,00	80	10
●	●	●	●	●		8,0	1,25	6,80	90	12
-	-	-	-	-		9,0	1,25	7,80	90	12
●	●	●	●	●		10,0	1,50	8,50	100	14

\* Misura non in standard ISO | These sizes are not ISO standard. ■ Fino ad esaurimento scorte | Till stocks last

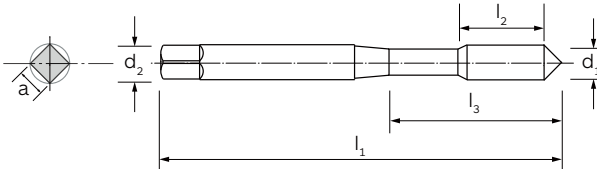
**M**

**371**

DIN 13

DIN

P. 632 →



MATERIALE   MATERIAL
TIPO   TYPE
RIVESTIMENTO/ TRATTAMENTO   COATING/ TREATMENT
ANGOLO ELICA   HELIX ANGLE
DIREZIONE TAGLIO   CUTTING DIRECTION
LUBRIFICAZIONE INTERNA   INTERNAL COOLANT
TOLLERANZA   TOLERANCE
FORMA D'IMBOCCO/FILETTI   CHAMFER FORM/THREADS
TIPO DI FORO   HOLE TYPE

**P** | Acciai | Steels

**M** | Acciai Inossidabili | Stainless Steels

**K** | Ghise | Cast Irons

**N** | Metalli non ferrosi | Non-ferrous metals

**S** | Leghe resistenti al calore e Titanio | HRSA and Titanium

**H** | Acciai Temprati | Hardened Steels

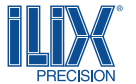
HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co
N 40°	N 40°	N 40°	N 40°	N 40°
-	VAP	-	TiN	-
40°	40°	40°	40°	40°
↻	↻	↻	↻	↻
-	-	-	-	-
6H	6H	6G	6G	7G
C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3
P	P	P	P	P
-	-	-	M	-
K	K	K	K	K
N	N	N	N	N
-	-	-	-	-
-	-	-	-	-

d <sub>1</sub>	P		l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub> (h9)	a (h12)	6644	6644VP	66446G	6644TN (6G)**	66447G
1,0	0,25	0,75	40	-	5,5	2,5	2,1	-	-	-	-	-
1,1	0,25	0,85	40	-	5,5	2,5	2,1	-	-	-	-	-
1,2	0,25	0,95	40	-	5,5	2,5	2,1	-	-	-	-	-
1,4	0,30	1,10	40	-	7	2,5	2,1	-	-	-	-	-
1,6	0,35	1,25	40	-	8	2,5	2,1	-	-	-	-	-
1,7*	0,35	1,30	40	-	8	2,5	2,1	-	-	-	-	-
1,8	0,35	1,45	40	-	8	2,5	2,1	-	-	-	-	-
2,0	0,40	1,60	45	4,0	8	2,8	2,1	●	●	●	●	●
2,2	0,45	1,75	45	4,0	9	2,8	2,1	●	●	-	-	-
2,3*	0,40	1,90	45	4,0	9	2,8	2,1	●	●	-	-	-
2,5	0,45	2,05	50	4,0	9	2,8	2,1	●	●	●	●	●
2,6*	0,45	2,10	50	4,0	9	2,8	2,1	●	●	-	-	-
3,0	0,50	2,50	56	5,0	11	3,5	2,7	●	●	●	●	●
3*	0,60	2,40	56	5,0	11	3,5	2,7	-	-	-	-	-
3,5	0,60	2,90	56	6,0	13	4,0	3,0	●	●	●	●	-
4,0	0,70	3,30	63	7,0	13	4,5	3,4	●	●	●	●	●
4*	0,75	3,25	63	7,0	13	4,5	3,4	-	-	-	-	-
5,0	0,80	4,20	70	8,0	16	6,0	4,9	●	●	●	●	●
5*	0,90	4,10	70	8,0	16	6,0	4,9	-	-	-	-	-
6,0	1,00	5,00	80	10,0	19	6,0	4,9	●	●	●	●	●
7,0	1,00	6,00	80	10,0	19	7,0	5,5	●	●	●	●	-
8,0	1,25	6,80	90	12,0	22	8,0	6,2	●	●	●	●	●
9,0	1,25	7,80	90	12,0	22	9,0	7,0	●	-	-	-	-
10,0	1,50	8,50	100	14,0	24	10,0	8,0	●	●	●	●	●

\* Misura non in standard ISO | These sizes are not ISO standard.    \*\* Per tolleranza 6G codice d'ordine 6644TN (6G) | For 6G tolerance, order code 6644TN (6G)

# M - DIN 371

Maschi a macchina con gambo rinforzato | Machine taps with reinforced shank



HSS-Co	HSS-Co	HSS-Co	HSS-Co
N 40°	N 40°	N 40°	N SX 40°
TiN	TiCN	-	-
40°	40°	40°	40°
↻	↻	↻	↻
-	-	-	-
6H	6H	6H	6H
C/2,5-3	C/2,5-3	E/1,5-2	C/2,5-3
P	P	P	P
M	M	-	-
K	K	K	K
N	N	N	N
-	-	-	-
-	-	-	-

MATERIALE   MATERIAL
TIPO   TYPE
RIVESTIMENTO/ TRATTAMENTO   COATING/ TREATMENT
ANGOLO ELICA   HELIX ANGLE
DIREZIONE TAGLIO   CUTTING DIRECTION
LUBRIFICAZIONE INTERNA   INTERNAL COOLANT
TOLLERANZA   TOLERANCE
FORMA D'IMBOCCO/FILETTI   CHAMFER FORM/THREADS
TIPO DI FORO   HOLE TYPE
<b>P</b>   Acciai   Steels
<b>M</b>   Acciai Inossidabili   Stainless Steels
<b>K</b>   Ghise   Cast Irons
<b>N</b>   Metalli non ferrosi   Non-ferrous metals
<b>S</b>   Leghe resistenti al calore e Titanio   HRSA and Titanium
<b>H</b>   Acciai Temprati   Hardened Steels

6644TN	6644TC	6867	6861		d <sub>1</sub>	P		l <sub>1</sub>	l <sub>2</sub>
-	-	-	-		1,0	0,25	0,75	40	-
-	-	-	-		1,1	0,25	0,85	40	-
-	-	-	-		1,2	0,25	0,95	40	-
-	-	-	-		1,4	0,30	1,10	40	-
-	-	-	-		1,6	0,35	1,25	40	-
-	-	-	-		1,7*	0,35	1,30	40	-
-	-	-	-		1,8	0,35	1,45	40	-
●	●	-	-		2,0	0,40	1,60	45	4,0
-	-	-	-		2,2	0,45	1,75	45	4,0
-	-	-	-		2,3*	0,40	1,90	45	4,0
●	●	-	-		2,5	0,45	2,05	50	4,0
-	-	-	-		2,6*	0,45	2,10	50	4,0
●	●	●	●		3,0	0,50	2,50	56	5,0
-	-	-	-		3*	0,60	2,40	56	5,0
●	●	-	-		3,5	0,60	2,90	56	6,0
●	●	●	●		4,0	0,70	3,30	63	7,0
-	-	-	-		4*	0,75	3,25	63	7,0
●	●	●	●		5,0	0,80	4,20	70	8,0
-	-	-	-		5*	0,90	4,10	70	8,0
●	●	●	●		6,0	1,00	5,00	80	10,0
●	-	-	-		7,0	1,00	6,00	80	10,0
●	●	●	●		8,0	1,25	6,80	90	12,0
-	-	-	-		9,0	1,25	7,80	90	12,0
●	●	●	●		10,0	1,50	8,50	100	14,0

**B 02**  
GRUPPO MATERIALI  
MATERIAL GROUPS

**NEW**  
C

**M**

**371**

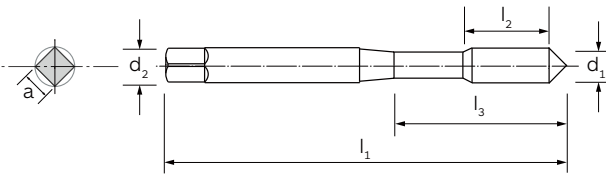


....XP

DIN 13

DIN

P. 632 →



MATERIALE | MATERIAL

TIPO | TYPE

RIVESTIMENTO/ TRATTAMENTO | COATING/ TREATMENT

ANGOLO ELICA | HELIX ANGLE

DIREZIONE TAGLIO | CUTTING DIRECTION

LUBRIFICAZIONE INTERNA | INTERNAL COOLANT

TOLLERANZA | TOLERANCE

FORMA D'IMBOCCO/FILETTI | CHAMFER FORM/THREADS

TIPO DI FORO | HOLE TYPE

**P** | Acciai | Steels

**M** | Acciai inossidabili | Stainless Steels

**K** | Ghise | Cast Irons

**N** | Metalli non ferrosi | Non-ferrous metals

**S** | Leghe resistenti al calore e Titanio | HRSA and Titanium

**H** | Acciai Temprati | Hardened Steels



HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co
VA 15°	VA 15°	VA 15°	VA i 15°	VR 35°
-	VAP	AlCrN TOP	AlCrN TOP	-
15°	15°	15°	15°	35°
↻	↻	↻	↻	↻
-	-	-	A	-
6HX	6HX	6HX	6HX	6HX
C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3
P	P	P	P	P
M	M	M	M	M
-	-	-	-	-
N	N	N	N	-
S	S	S	S	-
-	-	-	-	-

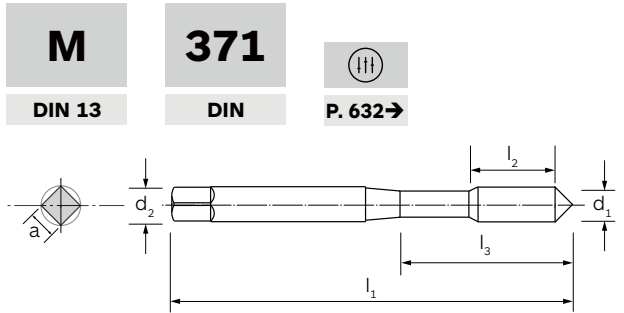
B  
02

GRUPPO MATERIALI  
MATERIAL GROUPS

d <sub>1</sub>	P		l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub> (h9)	a (h12)	6654	6654VP	6654XP	6620XP	6661
2,0	0,40	1,60	45	4	8	2,8	2,1	●	●	●	-	●
2,2	0,45	1,75	45	4	9	2,8	2,1	●	●	-	-	●
2,3*	0,40	1,90	45	4	9	2,8	2,1	●	●	-	-	●
2,5	0,45	2,05	50	4	9	2,8	2,1	●	●	-	-	●
2,6*	0,45	2,10	50	4	9	2,8	2,1	●	●	-	-	●
3,0	0,50	2,50	56	5	11	3,5	2,7	●	●	●	-	●
3,5	0,60	2,90	56	6	13	4,0	3,0	●	●	-	-	■
4,0	0,70	3,30	63	7	13	4,5	3,4	●	●	●	-	●
5,0	0,80	4,20	70	8	16	6,0	4,9	●	●	●	-	●
6,0	1,00	5,00	80	10	19	6,0	4,9	●	●	●	●	●
7,0	1,00	6,00	80	10	19	7,0	5,5	●	●	■	-	●
8,0	1,25	6,80	90	12	22	8,0	6,2	●	●	●	●	●
10,0	1,50	8,50	100	14	24	10,0	8,0	●	●	●	●	●

\* Misura non in standard ISO | These sizes are not ISO standard. ■ Fino ad esaurimento scorte | Till stocks last  
I maschi 6661 sono rastremati a partire dal Ø3 mm. ad eccezione del Ø7 mm | Cat.-No. 6661 with back tapered from M 3 onwards, except M 7





<b>M</b>	<b>371</b>		<b>P. 632</b> →
<b>DIN 13</b>	<b>DIN</b>		
<b>MATERIALE   MATERIAL</b>			
<b>TIPO   TYPE</b>			
<b>RIVESTIMENTO/ TRATTAMENTO   COATING/ TREATMENT</b>			
<b>ANGOLO ELICA   HELIX ANGLE</b>			
<b>DIREZIONE TAGLIO   CUTTING DIRECTION</b>			
<b>LUBRIFICAZIONE INTERNA   INTERNAL COOLANT</b>			
<b>TOLLERANZA   TOLERANCE</b>			
<b>FORMA D'IMBOCCO/FILETTI   CHAMFER FORM/THREADS</b>			
<b>TIPO DI FORO   HOLE TYPE</b>			
<b>P   Acciai   Steels</b>			
<b>M   Acciai inossidabili   Stainless Steels</b>			
<b>K   Ghise   Cast Irons</b>			
<b>N   Metalli non ferrosi   Non-ferrous metals</b>			
<b>S   Leghe resistenti al calore e Titanio   HRSA and Titanium</b>			
<b>H   Acciai Temprati   Hardened Steels</b>			

HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co
GG	GG	MULTI GG i	MULTI GG i	ALU 45°	BAK
NIT	TiAlN Futura	NIT	TiCN	-	NIT
0°	0°	0°	0°	45°	0°
-	-	A	A	-	-
6HX	6HX	6HX	6HX	6H	6HX
C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	E/1,5-2
-	-	-	-	-	-
-	-	-	-	-	-
K	K	K	K	-	-
N	N	N	N	N	N
-	-	-	-	-	-
-	-	-	-	-	-

d <sub>1</sub>	P		l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	d <sub>2</sub> (h9)	a (h12)	6631	6631TF	6629	6629TC	6643	6670
2,0	0,40	1,60	45	4	8	2,8	2,1	-	-	-	-	●	-
2,2	0,45	1,75	45	4	9	2,8	2,1	-	-	-	-	■	-
2,3*	0,40	1,90	45	4	9	2,8	2,1	-	-	-	-	-	■
2,5	0,45	2,05	50	4	9	2,8	2,1	-	-	-	-	●	-
2,6*	0,45	2,10	50	4	9	2,8	2,1	-	-	-	-	●	-
3,0	0,50	2,50	56	5	11	3,5	2,7	●	●	-	-	●	●
3,5	0,60	2,90	56	6	13	4,0	3,0	■	■	-	-	●	●
4,0	0,70	3,30	63	7	13	4,5	3,4	●	●	-	-	●	●
5,0	0,80	4,20	70	8	16	6,0	4,9	●	●	●	●	●	●
6,0	1,00	5,00	80	10	19	6,0	4,9	●	●	●	●	●	●
7,0	1,00	6,00	80	10	19	7,0	5,5	●	●	-	-	-	■
8,0	1,25	6,80	90	12	22	8,0	6,2	●	●	●	●	●	●
10,0	1,50	8,50	100	14	24	10,0	8,0	●	●	●	●	●	●

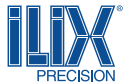
\* Misura non in standard ISO | These sizes are not ISO standard. ■ Fino ad esaurimento scorte | Till stocks last





# M - DIN 371

Maschi a macchina con gambo rinforzato | Machine taps with reinforced shank



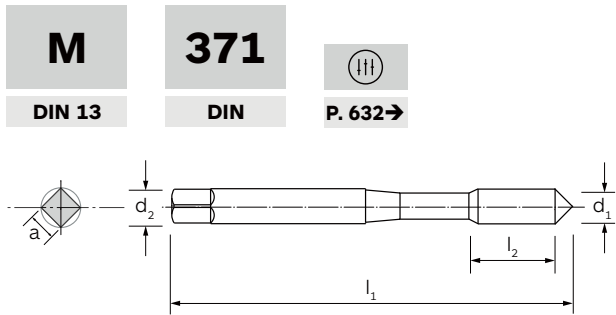
HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co
HD 40°	HD 40°	HD 40°	HD 40°	HR 40°	HR 40°
-	-	-	TiAIN Futura	-	TiAIN Futura
40°	40°	40°	40°	40°	40°
↻	↻	↻	↻	↻	↻
-	-	-	-	-	-
6H	6G	4H	6H	6H	6H
C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3
P	P	P	P	P	P
-	-	-	-	-	-
K	K	K	K	-	-
-	-	-	-	-	-
-	-	-	-	-	-
-	-	-	-	-	-

MATERIALE   MATERIAL
TIPO   TYPE
RIVESTIMENTO/ TRATTAMENTO   COATING/ TREATMENT
ANGOLO ELICA   HELIX ANGLE
DIREZIONE TAGLIO   CUTTING DIRECTION
LUBRIFICAZIONE INTERNA   INTERNAL COOLANT
TOLLERANZA   TOLERANCE
FORMA D'IMBOCCO/FILETTI   CHAMFER FORM/THREADS
TIPO DI FORO   HOLE TYPE
P   Acciai   Steels
M   Acciai Inossidabili   Stainless Steels
K   Ghise   Cast Irons
N   Metalli non ferrosi   Non-ferrous metals
S   Leghe resistenti al calore e Titanio   HRSA and Titanium
H   Acciai Temprati   Hardened Steels

6666	66666G	66664H	6666TF	6681	6681TF		d <sub>1</sub>	P		l <sub>1</sub>	l <sub>2</sub>
-	-	-	-	-	-		2,0	0,40	1,60	45	4
-	-	-	-	-	-		2,2	0,45	1,75	45	4
-	-	-	-	-	-		2,3*	0,40	1,90	45	4
-	-	-	-	-	-		2,5	0,45	2,05	50	4
-	-	-	-	-	-		2,6*	0,45	2,10	50	4
●	●	●	●	●	●		3,0	0,50	2,50	56	5
●	●	●	●	-	-		3,5	0,60	2,90	56	6
●	●	●	●	●	●		4,0	0,70	3,30	63	7
●	●	●	●	●	●		5,0	0,80	4,20	70	8
●	●	●	●	●	●		6,0	1,00	5,00	80	10
●	■	■	-	-	-		7,0	1,00	6,00	80	10
●	●	●	●	●	●		8,0	1,25	6,80	90	12
●	●	●	●	●	●		10,0	1,50	8,50	100	14

\* Misura non in standard ISO | These sizes are not ISO standard. ■ Fino ad esaurimento scorte | Till stocks last





MATERIALE   MATERIAL
TIPO   TYPE
RIVESTIMENTO/ TRATTAMENTO   COATING/ TREATMENT
ANGOLO ELICA   HELIX ANGLE
DIREZIONE TAGLIO   CUTTING DIRECTION
LUBRIFICAZIONE INTERNA   INTERNAL COOLANT
TOLLERANZA   TOLERANCE
FORMA D'IMBOCCO/FILETTI   CHAMFER FORM/THREADS
TIPO DI FORO   HOLE TYPE

HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co
Rapid	Rapid	Rapid	Rapid	Rapid	Rapid
-	VAP	-	TiN	-	-
0°	0°	0°	0°	0°	0°
↻	↻	↻	↻	↻	↻
-	-	-	-	-	-
6H	6H	6G	6G	4H	7G
B/4-5	B/4-5	B/4-5	B/4-5	B/4-5	B/4-5
P	P	P	P	P	P
M	M	M	M	M	M
K	K	K	K	K	K
N	N	N	N	N	N
-	-	-	-	-	-
-	-	-	-	-	-

- P** | Acciai | Steels
- M** | Acciai Inossidabili | Stainless Steels
- K** | Ghise | Cast Irons
- N** | Metalli non ferrosi | Non-ferrous metals
- S** | Leghe resistenti al calore e Titanio | HRSA and Titanium
- H** | Acciai Temprati | Hardened Steels

**B 02**

d <sub>1</sub>	P		l <sub>1</sub>	l <sub>2</sub>	d <sub>2</sub> (h9)	a (h12)	6707	6707VP	67076G	6707TN (6G)**	67074H	67077G
2,0	0,40	1,60	45	8	2,8	2,1	●	●	●	●	●	●
2,2	0,45	1,75	45	9	2,8	2,1	●	●	●	●	■	●
2,3*	0,40	1,90	45	9	2,8	2,1	●	●	-	-	-	-
2,5	0,45	2,05	50	9	2,8	2,1	●	●	●	●	●	●
2,6*	0,45	2,10	50	9	2,8	2,1	●	●	-	-	-	-
3,0	0,50	2,50	56	11	3,5	2,7	●	●	●	●	●	●
3*	0,60	2,40	56	11	3,5	2,7	■	-	■	-	-	-
3,5	0,60	2,90	56	13	4,0	3,0	●	●	●	●	●	-
4,0	0,70	3,30	63	13	4,5	3,4	●	●	●	●	●	●
4*	0,75	3,25	63	13	4,5	3,4	■	-	-	-	-	-
5,0	0,80	4,20	70	16	6,0	4,9	●	●	●	●	●	●
6,0	1,00	5,00	80	19	6,0	4,9	●	●	●	●	●	●
7,0	1,00	6,00	80	19	7,0	5,5	●	●	●	●	●	-
8,0	1,25	6,80	90	22	8,0	6,2	●	●	●	●	●	●
9,0	1,25	7,80	90	22	9,0	7,0	●	●	-	-	-	-
10,0	1,50	8,50	100	24	10,0	8,0	●	●	●	●	●	●

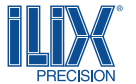
\* Misura non in standard ISO | These sizes are not ISO standard. \*\* Per tolleranza 6G codice d'ordine 6707TN (6G) | For 6G tolerance, order code 6707TN (6G)  
 ■ Fino ad esaurimento scorte | Till stocks last





# M - DIN 371

Maschi a macchina con gambo rinforzato | Machine taps with reinforced shank



HSS-Co	HSS-Co	HSS-Co
Ultra-S	AZ	NL 15°
TiN	-	-
0°	0°	15°
-	-	-
6HX	6H	6H
B/4-5	B/4-5	D/4-5
P	P	P
M	M	-
-	-	K
N	N	-
-	-	-
-	-	-

MATERIALE   MATERIAL
TIPO   TYPE
RIVESTIMENTO/ TRATTAMENTO   COATING/ TREATMENT
ANGOLO ELICA   HELIX ANGLE
DIREZIONE TAGLIO   CUTTING DIRECTION
LUBRIFICAZIONE INTERNA   INTERNAL COOLANT
TOLLERANZA   TOLERANCE
FORMA D'IMBOCCO/FILETTI   CHAMFER FORM/THREADS
TIPO DI FORO   HOLE TYPE
P   Acciai   Steels
M   Acciai Inossidabili   Stainless Steels
K   Ghise   Cast Irons
N   Metalli non ferrosi   Non-ferrous metals
S   Leghe resistenti al calore e Titanio   HRSA and Titanium
H   Acciai Temprati   Hardened Steels

6649TN	6616	6727		d <sub>1</sub>	P		l <sub>1</sub>	l <sub>2</sub>
■	●	-		2,0	0,40	1,60	45	8
-	●	-		2,2	0,45	1,75	45	9
-	●	-		2,3*	0,40	1,90	45	9
-	●	-		2,5	0,45	2,05	50	9
-	●	-		2,6*	0,45	2,10	50	9
■	●	●		3,0	0,50	2,50	56	11
-	●	■		3,5	0,60	2,90	56	13
■	●	●		4,0	0,70	3,30	63	13
-	-	-		4*	0,75	3,25	63	13
■	●	●		5,0	0,80	4,20	70	16
■	●	●		6,0	1,00	5,00	80	19
■	●	-		7,0	1,00	6,00	80	19
-	●	●		8,0	1,25	6,80	90	22
-	-	-		9,0	1,25	7,80	90	22
-	●	●		10,0	1,50	8,50	100	24

\* Misura non in standard ISO | These sizes are not ISO standard. ■ Fino ad esaurimento scorte | Till stocks last







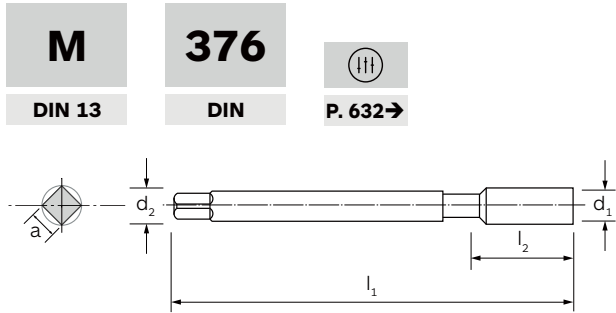












MATERIALE   MATERIAL
TIPO   TYPE
RIVESTIMENTO/ TRATTAMENTO   COATING/ TREATMENT
ANGOLO ELICA   HELIX ANGLE
DIREZIONE TAGLIO   CUTTING DIRECTION
LUBRIFICAZIONE INTERNA   INTERNAL COOLANT
TOLLERANZA   TOLERANCE
FORMA D'IMBOCCO/FILETTI   CHAMFER FORM/THREADS
TIPO DI FORO   HOLE TYPE

HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co
N	N	N SX	AZ	N 15°	N 15°
-	TiN	-	-	-	TiCN
0°	0°	0°	0°	15°	15°
↻	↻	↻	↻	↻	↻
-	-	-	-	-	-
6H	6H	6H	6H	6H	6H
C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3
P	P	P	P	P	P
-	-	-	M	-	M
K	K	K	-	K	K
N	N	N	N	N	N
-	-	-	-	-	-
-	-	-	-	-	-

P   Acciai   Steels
M   Acciai Inossidabili   Stainless Steels
K   Ghise   Cast Irons
N   Metalli non ferrosi   Non-ferrous metals
S   Leghe resistenti al calore e Titanio   HRSA and Titanium
H   Acciai Temprati   Hardened Steels

B  
02

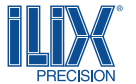
GRUPPO MATERIALI  
MATERIAL GROUPS

d <sub>1</sub>	P		l <sub>1</sub>	l <sub>2</sub>	l <sub>2</sub> (N 40°)	d <sub>2</sub> (h9)	a (h12)	6705	6705TN	6715	6821	6658	6658TC
2,0	0,40	1,60	45	8	-	1,4	-	●	●	-	-	-	-
2,2	0,45	1,75	45	9	-	1,6	-	■	-	-	-	-	-
2,3*	0,40	1,90	45	9	-	1,6	-	■	-	-	-	-	-
2,5	0,45	2,05	50	9	-	1,8	-	●	●	-	-	-	-
2,6*	0,45	2,10	50	9	4	1,8	-	●	●	-	-	-	-
3,0	0,50	2,50	56	11	5	2,2	-	●	●	-	-	-	-
3,5	0,60	2,90	56	13	6	2,5	2,1	●	●	-	-	-	-
4,0	0,70	3,30	63	13	7	2,8	2,1	●	●	-	-	-	-
5,0	0,80	4,20	70	16	8	3,5	2,7	●	●	-	-	-	-
6,0	1,00	5,00	80	19	10	4,5	3,4	●	●	-	●	-	-
7,0	1,00	6,00	80	19	10	5,5	4,3	●	●	-	-	-	-
8,0	1,25	6,80	90	22	12	6,0	4,9	●	●	-	●	●	-
9,0	1,25	7,80	90	22	19	7,0	5,5	●	●	-	-	-	-
10,0	1,50	8,50	100	24	14	7,0	5,5	●	●	-	●	●	-
12,0	1,75	10,20	110	29	16	9,0	7,0	●	●	●	●	●	●
14,0	2,00	12,00	110	30	20	11,0	9,0	●	●	●	-	●	●
16,0	2,00	14,00	110	32	20	12,0	9,0	●	●	●	●	●	●
18,0	2,50	15,50	125	34	24	14,0	11,0	●	●	●	-	●	●
20,0	2,50	17,50	140	34	25	16,0	12,0	●	●	●	-	●	●
22,0	2,50	19,50	140	34	25	18,0	14,5	●	●	●	-	●	■
24,0	3,00	21,00	160	38	30	18,0	14,5	●	●	●	-	●	-
27,0	3,00	24,00	160	38	30	20,0	16,0	●	●	-	-	●	■
30,0	3,50	26,50	180	45	35	22,0	18,0	●	●	-	-	●	■
33,0	3,50	29,50	180	50	-	25,0	20,0	●	■	-	-	-	-
36,0	4,00	32,00	200	56	-	28,0	22,0	●	-	-	-	-	-

\* Misura non in standard ISO | These sizes are not ISO standard. ■ Fino ad esaurimento scorte | Till stocks last

# M - DIN 376

Maschi a macchina con gambo passante | Machine taps with reduced shank




HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co
N 40°	N 40°	N 40°	N 40°	N 40°	N 40°	N 40°	N SX 40°
-	VAP	-	-	TiN	TiCN	-	-
40°	40°	40°	40°	40°	40°	40°	40°
-	-	-	-	-	-	-	-
6H	6H	6G	7G	6H	6H	6H	6H
C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	E/1,5-2	C/2,5-3
P	P	P	P	P	P	P	P
-	-	-	-	M	M	-	-
K	K	K	K	K	K	K	K
N	N	N	N	N	N	N	N
-	-	-	-	-	-	-	-
-	-	-	-	-	-	-	-

MATERIALE   MATERIAL
TIPO   TYPE
RIV./ TRAT.   COATING/ TREAT.
ANGOLO ELICA   HELIX ANGLE
DIR. TAGLIO   CUTTING DIRECTION
LUB. INT.   INTERNAL COOLANT
TOLLERANZA   TOLERANCE
F./FIL. D'IMB.   CHAM. FORM/THRE.
TIPO DI FORO   HOLE TYPE
P   Acciai   Steels
M   Acciaio Inoss.   Stainless Steel
K   Ghise   Cast Irons
N   Metalli n.f.   Non ferrous metals
S   HRSA e Titanio   HRSA and Tit.
H   Acciai Temp.   Hardened Steels

6638	6638VP	66386G	66387G	6638TN	6638TC	6868	6862	d <sub>1</sub>	P		I <sub>1</sub>	I <sub>2</sub> (N 40°)
-	-	-	-	-	-	-	-	2,0	0,40	1,60	45	-
-	-	-	-	-	-	-	-	2,2	0,45	1,75	45	-
-	-	-	-	-	-	-	-	2,3*	0,40	1,90	45	-
-	-	-	-	-	-	-	-	2,5	0,45	2,05	50	-
-	-	-	-	-	-	-	-	2,6*	0,45	2,10	50	4
●	●	●	-	-	-	-	-	3,0	0,50	2,50	56	5
■	■	-	-	-	-	-	-	3,5	0,60	2,90	56	6
●	●	●	-	-	-	-	-	4,0	0,70	3,30	63	7
●	●	●	-	-	-	-	-	5,0	0,80	4,20	70	8
●	●	●	-	-	-	-	-	6,0	1,00	5,00	80	10
●	-	-	-	-	-	-	-	7,0	1,00	6,00	80	10
●	●	●	●	-	-	-	-	8,0	1,25	6,80	90	12
●	■	-	-	-	-	-	-	9,0	1,25	7,80	90	19
●	●	●	●	-	-	-	-	10,0	1,50	8,50	100	14
●	●	●	●	●	●	●	●	12,0	1,75	10,20	110	16
●	●	●	-	●	●	●	●	14,0	2,00	12,00	110	20
●	●	●	●	●	●	●	●	16,0	2,00	14,00	110	20
●	●	●	-	●	●	●	-	18,0	2,50	15,50	125	24
●	●	●	●	●	●	●	●	20,0	2,50	17,50	140	25
●	●	●	-	-	-	-	-	22,0	2,50	19,50	140	25
●	●	●	●	-	-	-	-	24,0	3,00	21,00	160	30
●	●	-	-	-	-	-	-	27,0	3,00	24,00	160	30
●	●	■	-	-	-	-	-	30,0	3,50	26,50	180	35
●	-	-	-	-	-	-	-	33,0	3,50	29,50	180	-
●	-	-	-	-	-	-	-	36,0	4,00	32,00	200	-

\* Misura non in standard ISO | These sizes are not ISO standard. ■ Fino ad esaurimento scorte | Till stocks last



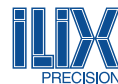
$d_1$	P		$l_1$	$l_2$	$l_2$ (N 40°)	$d_2$ (h9)	a (h12)	6705	6705TN	6715	6821	6658	6658TC
39,0	4,00	35,00	200	60	-	32,0	24,0	●	-	-	-	-	-
42,0	4,50	37,50	200	60	-	32,0	24,0	●	-	-	-	-	-
45,0	4,50	40,50	220	65	-	36,0	29,0	●	-	-	-	-	-
48,0	5,00	43,00	250	70	-	36,0	29,0	●	-	-	-	-	-
52,0	5,00	47,00	250	70	-	40,0	32,0	●	-	-	-	-	-


02/02



# M - DIN 376

Maschi a macchina con gambo passante | Machine taps with reduced shank



6638	6638VP	66386G	66387G	6638TN	6638TC	6868	6862	$d_1$	P		$l_1$	$l_2$ (N 40°)
-	-	-	-	-	-	-	-	<b>39,0</b>	4,00	35,00	200	-
-	-	-	-	-	-	-	-	<b>42,0</b>	4,50	37,50	200	-
-	-	-	-	-	-	-	-	<b>45,0</b>	4,50	40,50	220	-
-	-	-	-	-	-	-	-	<b>48,0</b>	5,00	43,00	250	-
-	-	-	-	-	-	-	-	<b>52,0</b>	5,00	47,00	250	-

02/02

B  
02







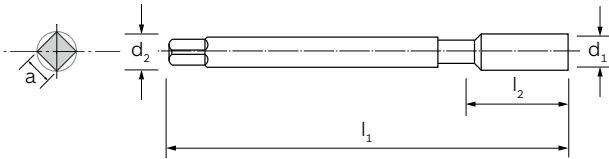


**NEW**  
6879HL

**M**  
DIN 13

**376**  
DIN

III  
P. 632 →



MATERIALE   MATERIAL
TIPO   TYPE
RIVESTIMENTO/ TRATTAMENTO   COATING/ TREATMENT
ANGOLO ELICA   HELIX ANGLE
DIREZIONE TAGLIO   CUTTING DIRECTION
LUBRIFICAZIONE INTERNA   INTERNAL COOLANT
TOLLERANZA   TOLERANCE
FORMA D'IMBOCCO/FILETTI   CHAMFER FORM/THREADS
TIPO DI FORO   HOLE TYPE

- P** | Acciai | Steels
- M** | Acciai Inossidabili | Stainless Steels
- K** | Ghise | Cast Irons
- N** | Metalli non ferrosi | Non-ferrous metals
- S** | Leghe resistenti al calore e Titanio | HRSA and Titanium
- H** | Acciai Temprati | Hardened Steels

HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co
GG	GG	MULTI GG i	MULTI GG i	ALU 45°	HD 15°
NIT	TiAlN Futura	NIT	TiCN	-	-
0°	0°	0°	0°	45°	15°
↻	↻	↻	↻	↻	↻
-	-	A	A	-	-
6HX	6HX	6HX	6HX	6HX	6H
C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3
-	-	-	-	-	P
-	-	-	-	-	-
K	K	K	K	-	K
N	N	N	N	N	-
-	-	-	-	-	-
-	-	-	-	-	-

**B 02**

GRUPPO MATERIALI  
MATERIAL GROUPS

d <sub>1</sub>	P		l <sub>1</sub>	l <sub>2</sub>	l <sub>2</sub> (40/45°)	d <sub>2</sub> (h9)	a (h12)	6632	6632TF	6637	6637TC	6651	6879
3,0	0,50	2,5	56	11	5	2,2	-	-	-	-	-	-	-
3,5	0,60	2,9	56	13	6	2,5	2,1	-	-	-	-	-	-
4,0	0,70	3,3	63	13	7	2,8	2,1	-	-	-	-	-	-
5,0	0,80	4,2	70	16	8	3,5	2,7	-	-	-	-	-	-
6,0	1,00	5,0	80	19	10	4,5	3,4	●	●	-	-	-	-
7,0	1,00	6,0	80	19	10	5,5	4,3	●	●	-	-	-	-
8,0	1,25	6,8	90	22	12	6,0	4,9	●	●	-	-	●	-
10,0	1,50	8,5	100	24	14	7,0	5,5	●	●	-	-	●	-
12,0	1,75	10,2	110	29	16	9,0	7,0	●	●	●	●	●	●
14,0	2,00	12,0	110	30	20	11,0	9,0	●	●	-	-	●	●
16,0	2,00	14,0	110	32	20	12,0	9,0	●	●	●	●	●	●
18,0	2,50	15,5	125	34	24	14,0	11,0	●	●	●	●	■	●
20,0	2,50	17,5	140	34	25	16,0	12,0	●	●	●	●	●	●
22,0	2,50	19,5	140	34	25	18,0	14,5	■	-	-	-	-	●
24,0	3,00	21,0	160	38	30	18,0	14,5	●	●	-	-	-	●
27,0	3,00	24,0	160	38	30	20,0	16,0	●	●	-	-	-	■
30,0	3,50	26,5	180	45	35	22,0	18,0	●	●	-	-	-	■

■ Fino ad esaurimento scorte | Till stocks last



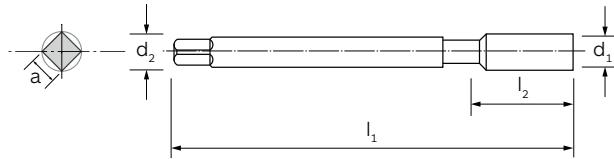
**M**

**376**

**DIN 13**

**DIN**

**P. 632** →



MATERIALE   MATERIAL
TIPO   TYPE
RIVESTIMENTO/ TRATTAMENTO   COATING/ TREATMENT
ANGOLO ELICA   HELIX ANGLE
DIREZIONE TAGLIO   CUTTING DIRECTION
LUBRIFICAZIONE INTERNA   INTERNAL COOLANT
TOLLERANZA   TOLERANCE
FORMA D'IMBOCCO/FILETTI   CHAMFER FORM/THREADS
TIPO DI FORO   HOLE TYPE
<b>P</b>   Acciai   Steels
<b>M</b>   Acciai Inossidabili   Stainless Steels
<b>K</b>   Ghise   Cast Irons
<b>N</b>   Metalli non ferrosi   Non-ferrous metals
<b>S</b>   Leghe resistenti al calore e Titanio   HRSA and Titanium
<b>H</b>   Acciai Temprati   Hardened Steels

HSS-Co	HSS-Co	HSS-Co	HSS-Co
Rapid	Rapid	Rapid	Rapid
-	VAP	-	TiN
0°	0°	0°	0°
↻	↻	↻	↻
-	-	-	-
6H	6H	6G	6H
B/4-5	B/4-5	B/4-5	B/4-5
P	P	P	P
M	M	M	M
K	K	K	K
N	N	N	N
-	-	-	-
-	-	-	-

B  
02

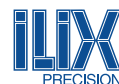
GRUPPO MATERIALI  
MATERIAL GROUPS

d <sub>1</sub>	P		l <sub>1</sub>	l <sub>2</sub>	d <sub>2</sub> (h9)	a (h12)		6711	6711VP	67116G	6711TN
2,0	0,40	1,60	45	8	1,4	-		●	●	●	-
2,2	0,45	1,75	45	9	1,6	-		●	■	-	-
2,3*	0,40	1,90	45	9	1,6	-		●	■	-	-
2,5	0,45	2,05	50	9	1,8	-		●	●	●	-
2,6*	0,45	2,10	50	9	1,8	-		●	-	-	-
3,0	0,50	2,50	56	11	2,2	-		●	●	●	-
3,5	0,60	2,90	56	13	2,5	2,1		●	●	●	-
4,0	0,70	3,30	63	13	2,8	2,1		●	●	●	-
5,0	0,80	4,20	70	16	3,5	2,7		●	●	●	-
6,0	1,00	5,00	80	19	4,5	3,4		●	●	●	●
7,0	1,00	6,00	80	19	5,5	4,3		●	●	-	-
8,0	1,25	6,80	90	22	6,0	4,9		●	●	●	●
9,0	1,25	7,80	90	22	7,0	5,5		●	●	-	-
10,0	1,50	8,50	100	24	7,0	5,5		●	●	●	●
12,0	1,75	10,20	110	29	9,0	7,0		●	●	●	●
14,0	2,00	12,00	110	30	11,0	9,0		●	●	●	●
16,0	2,00	14,00	110	32	12,0	9,0		●	●	●	●
18,0	2,50	15,50	125	34	14,0	11,0		●	●	●	●
20,0	2,50	17,50	140	34	16,0	12,0		●	●	●	●
22,0	2,50	19,50	140	34	18,0	14,5		●	●	●	-
24,0	3,00	21,00	160	38	18,0	14,5		●	●	●	●
27,0	3,00	24,00	160	38	20,0	16,0		●	●	■	-
30,0	3,50	26,50	180	45	22,0	18,0		●	●	-	●
33,0	3,50	29,50	180	50	25,0	20,0		●	●	-	-
36,0	4,00	32,00	200	56	28,0	22,0		●	●	■	-

\* Misura non in standard ISO | These sizes are not ISO standard. ■ Fino ad esaurimento scorte | Till stocks last

# M - DIN 376

Maschi a macchina con gambo passante | Machine taps with reduced shank



HSS-Co	HSS-Co	HSS-Co
Rapid	Rapid	N SX
TiCN	-	-
0°	0°	0°
-	-	-
6H	7G	6H
B/4-5	B/4-5	B/4-5
P	P	P
M	M	-
K	K	K
N	N	N
-	-	-
-	-	-

MATERIALE   MATERIAL
TIPO   TYPE
RIVESTIMENTO/ TRATTAMENTO   COATING/ TREATMENT
ANGOLO ELICA   HELIX ANGLE
DIREZIONE TAGLIO   CUTTING DIRECTION
LUBRIFICAZIONE INTERNA   INTERNAL COOLANT
TOLLERANZA   TOLERANCE
FORMA D'IMBOCCO/FILETTI   CHAMFER FORM/THREADS
TIPO DI FORO   HOLE TYPE
P   Acciai   Steels
M   Acciai Inossidabili   Stainless Steels
K   Ghise   Cast Irons
N   Metalli non ferrosi   Non-ferrous metals
S   Leghe resistenti al calore e Titanio   HRSA and Titanium
H   Acciai Temprati   Hardened Steels


GRUPPO MATERIALI MATERIAL GROUPS



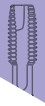
6711TC	67117G	6860	d <sub>1</sub>	P		l <sub>1</sub>	l <sub>2</sub>
-	-	-	2,0	0,40	1,60	45	8
-	-	-	2,2	0,45	1,75	45	9
-	-	-	2,3*	0,40	1,90	45	9
-	-	-	2,5	0,45	2,05	50	9
-	-	-	2,6*	0,45	2,10	50	9
-	-	-	3,0	0,50	2,50	56	11
-	-	-	3,5	0,60	2,90	56	13
-	-	-	4,0	0,70	3,30	63	13
-	-	-	5,0	0,80	4,20	70	16
●	-	-	6,0	1,00	5,00	80	19
-	-	-	7,0	1,00	6,00	80	19
●	-	-	8,0	1,25	6,80	90	22
-	-	-	9,0	1,25	7,80	90	22
●	-	-	10,0	1,50	8,50	100	24
●	●	●	12,0	1,75	10,20	110	29
●	-	●	14,0	2,00	12,00	110	30
●	●	●	16,0	2,00	14,00	110	32
●	-	●	18,0	2,50	15,50	125	34
●	●	●	20,0	2,50	17,50	140	34
-	-	-	22,0	2,50	19,50	140	34
●	●	-	24,0	3,00	21,00	160	38
-	-	-	27,0	3,00	24,00	160	38
●	-	-	30,0	3,50	26,50	180	45
-	-	-	33,0	3,50	29,50	180	50
-	-	-	36,0	4,00	32,00	200	56

01/02

\* Misura non in standard ISO | These sizes are not ISO standard. ■ Fino ad esaurimento scorte | Till stocks last

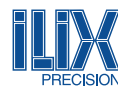
$d_1$	P		$l_1$	$l_2$	$d_2$ (h9)	a (h12)		6711	6711VP	67116G	6711TN
39,0	4,00	35,00	200	60	32,0	24,0		●	-	-	-
42,0	4,50	37,50	200	60	32,0	24,0		●	-	-	-
45,0	4,50	40,50	220	65	36,0	29,0		●	■	-	-
48,0	5,00	43,00	250	70	36,0	29,0		●	-	-	-
52,0	5,00	47,00	250	70	40,0	32,0		●	■	-	-


02/02

**B  
02**


# M - DIN 376

Maschi a macchina con gambo passante | Machine taps with reduced shank



6711TC	67117G	6860		d <sub>1</sub>	P		l <sub>1</sub>	l <sub>2</sub>
-	-	-		<b>39,0</b>	4,00	35,00	200	60
-	-	-		<b>42,0</b>	4,50	37,50	200	60
-	-	-		<b>45,0</b>	4,50	40,50	220	65
-	-	-		<b>48,0</b>	5,00	43,00	250	70
-	-	-		<b>52,0</b>	5,00	47,00	250	70

02/02









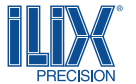




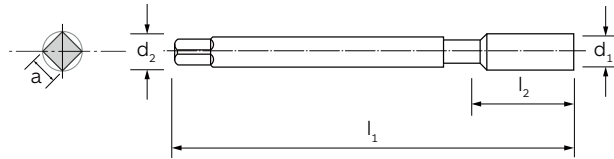


# M - DIN 357

Maschi a macchina per dadi con gambo diritto e imbocco extra lungo  
Machine nut taps with extra long chamfer, straight shank



<b>M</b>	<b>357</b>	
<b>DIN 13</b>	<b>DIN 13</b>	<b>P. 648</b>



MATERIALE | MATERIAL

TIPO | TYPE

RIVESTIMENTO/ TRATTAMENTO | COATING/ TREATMENT

ANGOLO ELICA | HELIX ANGLE

DIREZIONE TAGLIO | CUTTING DIRECTION

LUBRIFICAZIONE INTERNA | INTERNAL COOLANT

TOLLERANZA | TOLERANCE

FORMA D'IMBOCCO/FILETTI | CHAMFER FORM/THREADS

TIPO DI FORO | HOLE TYPE

GRUPPO MATERIALI  
MATERIAL GROUPS

**P** | Acciai | Steels

**M** | Acciai Inossidabili | Stainless Steels

**K** | Ghise | Cast Irons

**N** | Metalli non ferrosi | Non-ferrous metals

**S** | Leghe resistenti al calore e Titanio | HRSA and Titanium

**H** | Acciai Temprati | Hardened Steels

HSS-Co

N

-

0°

↻

-

6H

A/6-8



P

-

K

N

-

-

B  
02



d <sub>1</sub>	P		l <sub>1</sub>	l <sub>2</sub>	d <sub>2</sub> (h9)	a (h12)	6660
----------------	---	--	----------------	----------------	------------------------	------------	------

3,0	0,50	2,5	70	22	2,2	-	●
3,5	0,60	2,9	80	25	2,5	2,1	■
4,0	0,70	3,3	90	25	2,8	2,1	●
5,0	0,80	4,2	100	28	3,5	2,7	●
6,0	1,00	5,0	110	32	4,5	3,4	●
8,0	1,25	6,8	125	40	6,0	4,9	●
10,0	1,50	8,5	140	45	7,0	5,5	●
12,0	1,75	10,2	180	50	9,0	7,0	●
16,0	2,00	14,0	200	63	12,0	9,0	●
27,0	3,00	24,0	315	90	20,0	16,0	■
30,0	3,50	26,5	315	100	22,0	18,0	■

■ Fino ad esaurimento scorte | Till stocks last



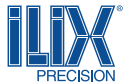




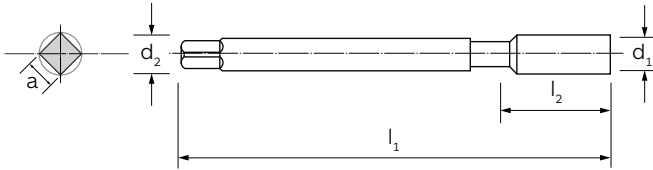


# M - ILIX NORM

Maschi a macchina con gambo extra lungo | Machine taps with extra long shank



**NEW TECH** **M** **ILIX NORM** **P. 648**  
**DIN 13** **DIN**



MATERIALE | MATERIAL

TIPO | TYPE

RIVESTIMENTO/ TRATTAMENTO | COATING/ TREATMENT

ANGOLO ELICA | HELIX ANGLE

DIREZIONE TAGLIO | CUTTING DIRECTION

LUBRIFICAZIONE INTERNA | INTERNAL COOLANT

TOLLERANZA | TOLERANCE

FORMA D'IMBOCCO/FILETTI | CHAMFER FORM/THREADS

TIPO DI FORO | HOLE TYPE

HSS-Co

N 30°

-

30°

↻

-

6H

C/2,5-3



P

-

K

N

-

-

GRUPPO MATERIALI  
MATERIAL GROUPS

**P** | Acciai | Steels

**M** | Acciai Inossidabili | Stainless Steels

**K** | Ghise | Cast Irons

**N** | Metalli non ferrosi | Non-ferrous metals

**S** | Leghe resistenti al calore e Titanio | HRSA and Titanium

**H** | Acciai Temprati | Hardened Steels

d <sub>1</sub>	P		l <sub>1</sub>	l <sub>2</sub>	d <sub>2</sub> (h9)	a (h12)	6841
----------------	---	--	----------------	----------------	------------------------	------------	------

8	1,25	6,8	180	20	6	4,9	●
10	1,50	8,5	200	22	7	4,9	●
12	1,75	10,2	224	24	9	7,0	●
14	2,00	12,0	224	26	11	9,0	●
16	2,00	14,0	224	27	12	9,0	●
18	2,50	15,5	250	30	14	11,0	●
20	2,50	17,5	280	32	16	12,0	●

**B  
02**

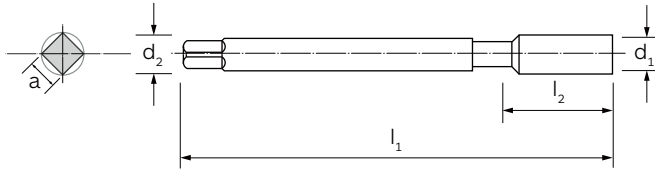
Maschi a mano in serie di 2 pezzi composta da sbozzatore (P) e finitore (T)  
Hand taps, series in set of 2 pieces, consisting of taper (P) and bottom (T)

## MF

## 2181

DIN 13

DIN



HSS	HSS
N	N
-	-
0°	0°
↻	↻
-	-
6H	6H
A/5-6	C/2,5-3
P	P
M	M
K	K
N	N
S	S
-	-

MATERIALE | MATERIAL

TIPO | TYPE

RIVESTIMENTO/ TRATTAMENTO | COATING/ TREATMENT

ANGOLO ELICA | HELIX ANGLE

DIREZIONE TAGLIO | CUTTING DIRECTION

LUBRIFICAZIONE INTERNA | INTERNAL COOLANT

TOLLERANZA | TOLERANCE

FORMA D'IMBOCCO/FILETTI | CHAMFER FORM/THREADS

TIPO DI FORO | HOLE TYPE

**P** | Acciai | Steels

**M** | Acciai Inossidabili | Stainless Steels

**K** | Ghise | Cast Irons

**N** | Metalli non ferrosi | Non-ferrous metals

**S** | Leghe resistenti al calore e Titanio | HRSA and Titanium

**H** | Acciai Temprati | Hardened Steels

GRUPPO MATERIALI  
MATERIAL GROUPS

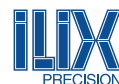
B  
02

d <sub>1</sub>	P		l <sub>1</sub>	l <sub>2</sub>	d <sub>2</sub> (h9)	a (h12)	6633P	6633T
							<b>6633</b> (Serie   Set)	


d <sub>1</sub>	P		l <sub>1</sub>	l <sub>2</sub>	d <sub>2</sub> (h9)	a (h12)	6633P	6633T	6633
2,0	0,25	1,8	36	8	2,8	2,1	●	●	●
2,2	0,25	2,0	36	9	2,8	2,1	●	●	●
2,3*	0,25	2,1	36	9	2,8	2,1	●	●	●
2,5	0,35	2,2	40	9	2,8	2,1	●	●	●
2,6	0,35	2,3	40	9	2,8	2,1	●	●	●
3,0	0,35	2,7	40	9	3,5	2,7	●	●	●
3,5	0,35	3,2	45	10	4,0	3,0	●	●	●
4,0	0,50	3,5	45	10	4,5	3,4	●	●	●
5,0	0,50	4,5	50	12	6,0	4,9	●	●	●
6,0	0,50	5,5	50	14	6,0	4,9	●	●	●
6,0	0,75	5,2	50	14	6,0	4,9	●	●	●
7,0	0,75	6,2	50	14	6,0	4,9	●	●	●
8,0	0,50	7,5	50	19	6,0	4,9	●	●	●
8,0	0,75	7,2	50	19	6,0	4,9	●	●	●
8,0	1,00	7,0	56	22	6,0	4,9	●	●	●
9,0	1,00	8,0	63	22	7,0	5,5	●	●	●
10,0	0,75	9,2	63	20	7,0	5,5	●	●	●
10,0	1,00	9,0	63	20	7,0	5,5	●	●	●
10,0	1,25	8,8	70	24	7,0	5,5	●	●	●
11,0	1,00	10,0	63	20	8,0	6,2	●	●	●
12,0	1,00	11,0	70	22	9,0	7,0	●	●	●
12,0	1,25	10,8	70	22	9,0	7,0	●	●	●
12,0	1,50	10,5	70	22	9,0	7,0	●	●	●
14,0	1,00	13,0	70	22	11,0	9,0	●	●	●

\* Misura non in standard ISO | These sizes are not ISO standard.  
In fase di ordinazione specificare sempre il Ø (d<sub>1</sub>) e il passo (P) | When ordering, please state Ø (d<sub>1</sub>) and pitch (P)

# MF - DIN 2181



Maschi a mano in serie di 2 pezzi composta da sbozzatore (P) e finitore (T)  
Hand taps, series in set of 2 pieces, consisting of taper (P) and bottom (T)

d <sub>1</sub>	P		l <sub>1</sub>	l <sub>2</sub>	d <sub>2</sub> (h9)	a (h12)	6633P		6633T	
							6633 (Serie   Set)			
14,0	1,25*	12,8	70	22	11,0	9,0	●	●	●	
14,0	1,50	12,5	70	22	11,0	9,0	●	●	●	
15,0	1,00	14,0	70	22	12,0	9,0	●	●	●	
15,0	1,50	13,5	70	22	12,0	9,0	●	●	●	
16,0	1,00	15,0	70	22	12,0	9,0	●	●	●	
16,0	1,50	14,5	70	22	12,0	9,0	●	●	●	
18,0	1,00	17,0	80	22	14,0	11,0	●	●	●	
18,0	1,50	16,5	80	22	14,0	11,0	●	●	●	
18,0	2,00	16,0	80	22	14,0	11,0	●	●	●	
20,0	1,00	19,0	80	22	16,0	12,0	●	●	●	
20,0	1,50	18,5	80	22	16,0	12,0	●	●	●	
20,0	2,00	18,0	80	22	16,0	12,0	●	●	●	
22,0	1,00	21,0	80	22	18,0	14,5	●	●	●	
22,0	1,50	20,5	80	22	18,0	14,5	●	●	●	
22,0	2,00	20,0	80	22	18,0	14,5	●	●	●	
24,0	1,00	23,0	90	22	18,0	14,5	●	●	●	
24,0	1,50	22,5	90	22	18,0	14,5	●	●	●	
24,0	2,00	22,0	90	22	18,0	14,5	●	●	●	
26,0	1,50	24,5	90	22	18,0	14,5	●	●	●	
27,0	1,50	25,5	90	22	20,0	16,0	●	●	●	
27,0	2,00	25,0	90	22	20,0	16,0	●	●	●	
28,0	1,50	26,5	90	22	20,0	16,0	●	●	●	
30,0	1,00	29,0	90	22	22,0	18,0	●	●	●	
30,0	1,50	28,5	90	22	22,0	18,0	●	●	●	
30,0	2,00	28,0	90	22	22,0	18,0	●	●	●	
32,0	1,50	30,5	90	22	22,0	18,0	●	●	●	
33,0	1,50	31,5	100	25	25,0	20,0	●	●	●	
34,0	1,50	32,5	100	25	28,0	22,0	●	●	●	
35,0	1,50	33,5	100	25	25,0	20,0	●	●	●	
36,0	1,50	34,5	100	25	28,0	22,0	●	●	●	
36,0	3,00	33,0	125	40	28,0	22,0	●	●	●	
38,0	1,50	36,5	100	25	28,0	22,0	●	●	●	
40,0	1,50	38,5	110	25	32,0	24,0	●	●	●	
42,0	1,50	40,5	110	25	32,0	24,0	●	●	●	
45,0	1,50	43,5	110	25	36,0	29,0	●	●	●	
48,0	1,50	46,5	140	40	36,0	29,0	●	●	●	
48,0	2,00	46,0	140	40	36,0	29,0	●	●	●	
48,0	3,00	45,0	140	40	36,0	29,0	●	●	●	
50,0	1,50	48,5	140	40	36,0	29,0	●	●	●	
52,0	1,50	50,5	140	40	40,0	32,0	●	●	●	



\* Misura non in standard ISO | These sizes are not ISO standard.  
In fase di ordinazione specificare sempre il Ø (d<sub>1</sub>) e il passo (P) | When ordering, please state Ø (d1) and pitch (P)

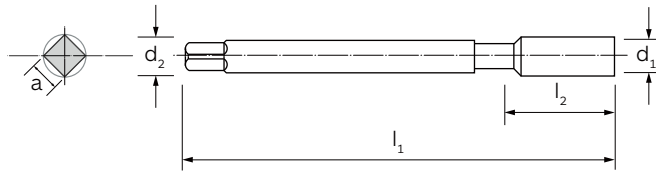
**MF**

DIN 13

**2181**

DIN

P. 632 →



HSS-Co	HSS-Co	HSS-Co
N	N 15°	MS
-	-	-
0°	15°	0°
↻	↻	↻
-	-	-
6H	6H	6H
C/2,5-3	C/2,5-3	C/2,5-3
P	P	-
-	-	-
K	K	-
N	N	N
-	-	-
-	-	-

MATERIALE | MATERIAL

TIPO | TYPE

RIVESTIMENTO/ TRATTAMENTO | COATING/ TREATMENT

ANGOLO ELICA | HELIX ANGLE

DIREZIONE TAGLIO | CUTTING DIRECTION

LUBRIFICAZIONE INTERNA | INTERNAL COOLANT

TOLLERANZA | TOLERANCE

FORMA D'IMBOCCO/FILETTI | CHAMFER FORM/THREADS

TIPO DI FORO | HOLE TYPE

**P** | Acciai | Steels

**M** | Acciai Inossidabili | Stainless Steels

**K** | Ghise | Cast Irons

**N** | Metalli non ferrosi | Non-ferrous metals

**S** | Leghe resistenti al calore e Titanio | HRSA and Titanium

**H** | Acciai Temprati | Hardened Steels

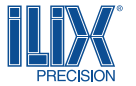
B  
02


GRUPPO MATERIALI  
MATERIAL GROUPS

d <sub>1</sub>	P		l <sub>1</sub>	l <sub>2</sub>	d <sub>2</sub> (h9)	a (h12)	6899	6656	6724
4	0,50	3,5	45	10	4,5	3,4	-	-	●
5	0,50	4,5	50	12	6,0	4,9	-	●	●
6	0,50	5,5	56	14	6,0	4,9	●	●	●
6	0,75	5,2	56	14	6,0	4,9	●	-	●
7	0,75	6,2	56	14	6,0	4,9	-	-	●
8	0,50	7,5	56	18	6,0	4,9	●	●	●
8	0,75	7,2	56	18	6,0	4,9	●	●	●
8	1,00	7,0	63	22	6,0	4,9	●	-	●
9	1,00	8,0	63	22	6,0	4,9	●	-	●
10	0,75	9,2	63	20	7,0	5,5	●	-	●
10	1,00	9,0	63	20	7,0	5,5	●	●	●
10	1,25	8,8	70	24	7,0	5,5	●	-	●
11	1,00	10,0	63	20	8,0	6,2	-	-	●
12	1,00	11,0	70	22	9,0	7,0	●	●	●
12	1,25	10,8	70	22	9,0	7,0	●	-	●
12	1,50	10,5	70	22	9,0	7,0	●	●	●
14	1,00	10,5	70	22	11,0	9,0	●	-	-
14	1,25	10,5	70	22	11,0	9,0	●	-	-
14	1,50	12,5	70	22	11,0	9,0	●	●	-
16	1,00	12,5	70	22	11,0	9,0	●	-	-
16	1,50	14,5	70	22	11,0	9,0	●	●	-
18	1,00	14,5	80	22	14,0	11,0	●	-	-
18	1,50	16,5	80	22	14,0	11,0	●	●	-
18	2,00	16,5	80	22	14,0	11,0	●	-	-
20	1,00	16,5	80	22	16,0	12,0	●	-	-

# DIN 2181

Maschi a macchina corti | Short machine taps



$d_1$	P		$l_1$	$l_2$	$d_2$ (h9)	a (h12)		6899	6656	6724
-------	---	---	-------	-------	---------------	------------	--	------	------	------

20	1,50	18,5	80	22	16,0	12,0		●	-	-
20	2,00	18,5	80	22	16,0	12,0		●	-	-

02/02

In fase di ordinazione specificare sempre il  $\varnothing$  ( $d_1$ ) e il passo (P) | When ordering, please state  $\varnothing$  (d1) and pitch (P)

B  
02



**MF**

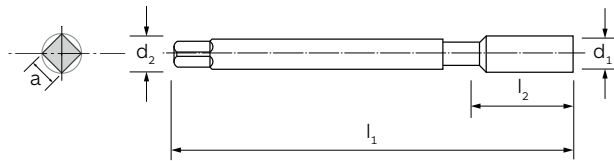
DIN 13

**374**

DIN

III

P. 632 →



MATERIALE   MATERIAL
TIPO   TYPE
RIVESTIMENTO   COATING
ANGOLO ELICA   HELIX ANGLE
DIREZIONE TAGLIO   CUTTING DIRECTION
LUBRIFICAZIONE INTERNA   INTERNAL COOLANT
TOLLERANZA   TOLERANCE
FORMA D'IMBOCCO/FILETTI   CHAMFER FORM/THREADS
TIPO DI FORO   HOLE TYPE

- P** | Acciai | Steels
- M** | Acciai Inossidabili | Stainless Steels
- K** | Ghise | Cast Irons
- N** | Metalli non ferrosi | Non-ferrous metals
- S** | Leghe resistenti al calore e Titanio | HRSA and Titanium
- H** | Acciai Temprati | Hardened Steels

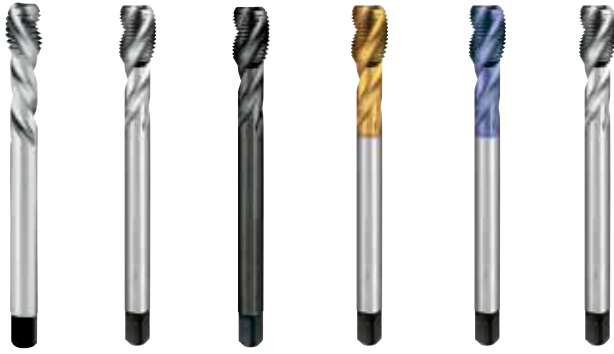
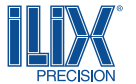
HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co
N	N	N	N 15°	N 15°	N 15°
-	TiN	TiCN	-	TiN	-
0°	0°	0°	15°	15°	15°
↻	↻	↻	↻	↻	↻
-	-	-	-	-	-
6H	6H	6H	6H	6H	6H+0,1
C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	E/1-2
P	P	P	P	P	P
-	-	-	-	M	-
K	K	K	K	K	K
N	N	N	N	N	N
-	-	-	-	-	-
-	-	-	-	-	-

d <sub>1</sub>	P		l <sub>1</sub>	l <sub>2</sub>	l <sub>2</sub> (40°)	d <sub>2</sub> (h9)	a (h12)	6726	6726TN	6726TC	6664	6664TN	6904
3,0	0,35	2,65	56	9	5	2,2	-	●	●	●	-	-	-
3,5	0,35	3,15	56	10	6	2,5	2,1	●	●	●	-	-	-
4,0	0,50	3,50	63	10	7	2,8	2,1	●	●	●	-	-	-
5,0	0,50	4,50	70	12	8	3,5	2,7	●	●	●	-	-	-
6,0	0,50	5,50	80	14	10	4,5	3,4	●	●	●	-	-	-
6,0	0,75	5,20	80	14	10	4,5	3,4	●	●	●	-	-	-
7,0	0,75	6,20	80	14	10	5,5	4,3	●	●	●	-	-	-
8,0	0,50	7,50	80	19	12	6,0	4,9	●	●	●	-	-	-
8,0	0,75	7,20	80	19	12	6,0	4,9	●	●	●	●	●	-
8,0	1,00	7,00	90	22	12	6,0	4,9	●	●	●	●	●	-
9,0	1,00	8,00	90	22	12	7,0	5,5	●	●	●	-	-	-
10,0	0,75	9,20	90	20	14	7,0	5,5	●	●	●	-	-	-
10,0	1,00	9,00	90	20	14	7,0	5,5	●	●	●	●	●	-
10,0	1,25	8,80	100	24	14	7,0	5,5	●	●	●	●	●	-
11,0	1,00	10,00	90	20	14	8,0	6,2	●	●	●	-	-	-
12,0	1,00	11,00	100	22	16	9,0	7,0	●	●	●	●	●	-
12,0	1,25	10,80	100	22	16	9,0	7,0	●	●	●	-	-	-
12,0	1,50	10,50	100	22	16	9,0	7,0	●	●	●	-	-	-
14,0	1,00	13,00	100	22	20	11,0	9,0	●	●	●	-	-	-
14,0*	1,25	12,80	100	22	20	11,0	9,0	●	●	●	-	-	-
14,0	1,50	12,50	100	22	20	11,0	9,0	●	●	●	●	●	-
15,0	1,00	14,00	100	22	20	12,0	9,0	●	●	●	-	-	-
15,0	1,50	13,50	100	22	20	12,0	9,0	●	●	●	-	-	-
16,0	1,00	15,00	100	22	20	12,0	9,0	●	●	●	-	-	-
16,0	1,50	14,50	100	22	20	12,0	9,0	●	●	●	●	●	-

\* Misura non in standard ISO | These sizes are not ISO standard.  
In fase di ordinazione specificare sempre il Ø (D) e il passo (P) | When ordering, please state Ø (D) and pitch (P)

# MF - DIN 374

Maschi a macchina con gambo passante | Machine taps with reduced shank



HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co
N SX 40°	N 40°	N 40°	N 40°	N 40°	N 40°
-	-	VAP	TiN	TiCN	-
40°	40°	40°	40°	40°	40°
↻	↻	↻	↻	↻	↻
-	-	-	-	-	-
6H	6H	6H	6H	6H	6H
C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	E/1-2
P	P	P	P	P	P
-	-	-	M	M	-
K	K	K	K	K	K
N	N	N	N	N	N
-	-	-	-	-	-
-	-	-	-	-	-

MATERIALE   MATERIAL
TIPO   TYPE
RIVESTIMENTO   COATING
ANGOLO ELICA   HELIX ANGLE
DIREZIONE TAGLIO   CUTTING DIRECTION
LUBRIFICAZIONE INTERNA   INTERNAL COOLANT
TOLLERANZA   TOLERANCE
FORMA D'IMBOCCO/FILETTI   CHAMFER FORM/THREADS
TIPO DI FORO   HOLE TYPE
<b>P</b>   Acciai   Steels
<b>M</b>   Acciai Inossidabili   Stainless Steels
<b>K</b>   Ghise   Cast Irons
<b>N</b>   Metalli non ferrosi   Non-ferrous metals
<b>S</b>   Leghe resistenti al calore e Titanio   HRSA and Titanium
<b>H</b>   Acciai Temprati   Hardened Steels

6864	6652	6652VP	6652TN	6652TC	6877		d <sub>1</sub>	P		l <sub>1</sub>	l <sub>2</sub> (40°)
-	●	●	●	●	-		3,0	0,35	2,65	56	5
-	●	●	●	●	-		3,5	0,35	3,15	56	6
-	●	●	●	●	-		4,0	0,50	3,50	63	7
-	●	●	●	●	-		5,0	0,50	4,50	70	8
-	●	●	●	●	-		6,0	0,50	5,50	80	10
-	●	●	●	●	●		6,0	0,75	5,20	80	10
-	-	-	-	-	-		7,0	0,75	6,20	80	10
-	-	-	-	-	-		8,0	0,50	7,50	80	12
-	●	●	●	●	●		8,0	0,75	7,20	80	12
●	●	●	●	●	●		8,0	1,00	7,00	90	12
-	-	-	-	-	-		9,0	1,00	8,00	90	12
-	-	-	-	-	-		10,0	0,75	9,20	90	14
●	●	●	●	●	●		10,0	1,00	9,00	90	14
-	●	●	●	●	-		10,0	1,25	8,80	100	14
-	-	-	-	-	-		11,0	1,00	10,00	90	14
●	●	●	●	●	●		12,0	1,00	11,00	100	16
-	-	-	-	-	-		12,0	1,25	10,80	100	16
●	●	●	●	●	●		12,0	1,50	10,50	100	16
-	-	-	-	-	-		14,0	1,00	13,00	100	20
-	-	-	-	-	-		14,0	1,25*	12,80	100	20
●	●	●	●	●	●		14,0	1,50	12,50	100	20
-	-	-	-	-	-		15,0	1,00	14,00	100	20
-	-	-	-	-	-		15,0	1,50	13,50	100	20
-	-	-	-	-	-		16,0	1,00	15,00	100	20
●	●	●	●	●	●		16,0	1,50	14,50	100	20

01/02

B  
02

GRUPPO MATERIALI  
MATERIAL GROUPS

$d_1$	P		$l_1$	$l_2$	$l_2$ (40°)	$d_2$ (h9)	a (h12)	6726	6726TN	6726TC	6664	6664TN	6904
18,0	1,00	17,00	110	25	25	14,0	11,0	●	●	●	-	-	-
18,0	1,50	16,50	110	25	25	14,0	11,0	●	●	●	●	●	-
18,0	2,00	16,00	125	34	25	14,0	11,0	●	●	●	-	-	-
20,0	1,00	19,00	125	25	25	16,0	12,0	●	●	●	-	-	●
20,0	1,50	18,50	125	25	25	16,0	12,0	●	●	●	●	●	-
20,0	2,00	18,00	140	34	25	16,0	12,0	●	●	●	-	-	-
22,0	1,00	21,00	125	25	25	18,0	14,5	●	●	●	-	-	-
22,0	1,50	20,50	125	25	25	18,0	14,5	●	●	●	●	●	-
22,0	2,00	20,00	140	34	25	18,0	14,5	●	●	●	-	-	-
24,0	1,00	23,00	140	28	28	18,0	14,5	●	●	●	-	-	●
24,0	1,50	22,50	140	28	28	18,0	14,5	●	●	●	●	●	-
24,0	2,00	22,00	140	28	28	18,0	14,5	●	●	●	-	-	-
26,0	1,50	24,50	140	28	28	18,0	14,5	●	●	●	●	●	-
27,0	1,50	25,50	140	28	28	20,0	16,0	●	●	●	-	-	-
27,0	2,00	25,00	140	28	28	20,0	16,0	●	●	●	-	-	-
28,0	1,50	26,50	140	28	28	20,0	16,0	●	●	●	-	-	-
30,0	1,00	29,00	150	28	28	22,0	18,0	●	●	●	-	-	-
30,0	1,50	28,50	150	28	28	22,0	18,0	●	●	●	●	●	-
30,0	2,00	28,00	150	28	28	22,0	18,0	●	●	●	-	■	-
32,0	1,50	30,50	150	28	-	22,0	18,0	●	●	●	-	-	-
33,0	1,50	31,50	160	30	-	25,0	20,0	●	●	●	-	-	-
34,0	1,50	32,50	170	30	-	28,0	22,0	●	●	●	-	-	-
35,0	1,50	33,50	170	30	-	28,0	22,0	●	●	●	-	-	-
36,0	1,50	34,50	170	30	-	28,0	22,0	●	●	●	-	-	-
38,0	1,50	36,50	170	30	-	28,0	22,0	●	●	●	-	-	-
40,0	1,50	38,50	170	30	-	32,0	24,0	●	●	●	-	-	-
42,0	1,50	40,50	170	30	-	32,0	24,0	●	●	●	-	-	-
45,0	1,50	43,50	180	32	-	36,0	29,0	●	●	●	-	-	-
48,0	1,50	46,50	190	32	-	36,0	29,0	●	●	●	-	-	-
50,0	1,50	48,50	190	32	-	36,0	29,0	●	●	●	-	-	-
52,0	1,50	50,50	190	32	-	40,0	32,0	●	●	●	-	-	-

**B  
02**

**02/02**

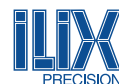
■ Fino ad esaurimento scorte | Till stocks last


 In fase di ordinazione specificare sempre il  $\varnothing$  (D) e il passo (P) | When ordering, please state  $\varnothing$  (D) and pitch (P)



# MF - DIN 374

Maschi a macchina con gambo passante | Machine taps with reduced shank



6864	6652	6652VP	6652TN	6652TC	6877		d <sub>1</sub>	P		l <sub>1</sub>	l <sub>2</sub> (40°)	
-	-	-	-	-	-		18,0	1,00		17,00	110	25
●	●	●	●	●	●		18,0	1,50		16,50	110	25
-	-	-	-	-	-		18,0	2,00		16,00	125	25
-	-	-	-	-	-		20,0	1,00		19,00	125	25
●	●	●	●	●	●		20,0	1,50		18,50	125	25
-	-	-	-	-	-		20,0	2,00		18,00	140	25
-	-	-	-	-	-		22,0	1,00		21,00	125	25
-	●	●	●	●	-		22,0	1,50		20,50	125	25
-	-	-	-	-	-		22,0	2,00		20,00	140	25
-	-	-	-	-	-		24,0	1,00		23,00	140	28
-	●	●	●	●	-		24,0	1,50		22,50	140	28
-	-	-	-	-	-		24,0	2,00		22,00	140	28
-	●	●	●	●	-		26,0	1,50		24,50	140	28
-	●	●	●	●	-		27,0	1,50		25,50	140	28
-	●	-	●	●	-		27,0	2,00		25,00	140	28
-	●	●	●	●	-		28,0	1,50		26,50	140	28
-	-	-	-	-	-		30,0	1,00		29,00	150	28
-	●	●	●	●	-		30,0	1,50		28,50	150	28
-	●	-	●	●	-		30,0	2,00		28,00	150	28
-	-	-	-	-	-		32,0	1,50		30,50	150	-
-	-	-	-	-	-		33,0	1,50		31,50	160	-
-	-	-	-	-	-		34,0	1,50		32,50	170	-
-	-	-	-	-	-		35,0	1,50		33,50	170	-
-	-	-	-	-	-		36,0	1,50		34,50	170	-
-	-	-	-	-	-		38,0	1,50		36,50	170	-
-	-	-	-	-	-		40,0	1,50		38,50	170	-
-	-	-	-	-	-		42,0	1,50		40,50	170	-
-	-	-	-	-	-		45,0	1,50		43,50	180	-
-	-	-	-	-	-		48,0	1,50		46,50	190	-
-	-	-	-	-	-		50,0	1,50		48,50	190	-
-	-	-	-	-	-		52,0	1,50		50,50	190	-

02/02



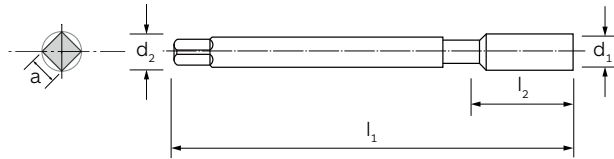
**NEW**  
....XP

**NEW**  
6880HL

**MF**  
DIN 13

**374**  
DIN

P. 632 →



MATERIALE   MATERIAL
TIPO   TYPE
RIVESTIMENTO   COATING
ANGOLO ELICA   HELIX ANGLE
DIREZIONE TAGLIO   CUTTING DIRECTION
LUBRIFICAZIONE INTERNA   INTERNAL COOLANT
TOLLERANZA   TOLERANCE
FORMA D'IMBOCCO/FILETTI   CHAMFER FORM/THREADS
TIPO DI FORO   HOLE TYPE

<b>P</b>   Acciai   Steels
<b>M</b>   Acciai inossidabili   Stainless Steels
<b>K</b>   Ghise   Cast Irons
<b>N</b>   Metalli non ferrosi   Non-ferrous metals
<b>S</b>   Leghe resistenti al calore e Titanio   HRSA and Titanium
<b>H</b>   Acciai Temprati   Hardened Steels

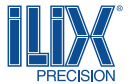
HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co
VA 15°	VA i 15°	VA 35°	VA 35°	VA 35°
-	AlCrN TOP	-	VAP	AlCrN TOP
15°	15°	35°	35°	35°
-	A	-	-	-
6H	6H	6HX	6HX	6HX
D/3,5	C/2-3	C/2,5-3	C/2,5-3	C/2,5-3
P	P	P	P	P
M	M	M	M	M
-	-	-	-	-
N	N	N	N	N
S	S	S	S	S
-	-	-	-	-

d <sub>1</sub>	P		l <sub>1</sub>	l <sub>2</sub>	l <sub>2</sub> (35-45°)	d <sub>2</sub> (h9)	a (h12)	6671	6626XP	6655	6655VP	6655XP
3,0	0,35	2,65	56	9	5	2,2	-	-	-	-	-	-
3,5	0,35	3,15	56	10	6	2,5	2,1	-	-	-	-	-
4,0	0,50	3,50	63	10	7	2,8	2,1	-	-	-	-	-
5,0	0,50	4,50	70	12	8	3,5	2,7	-	-	-	-	-
6,0	0,50	5,50	80	14	10	4,5	3,4	-	-	-	-	-
6,0	0,75	5,20	80	14	10	4,5	3,4	-	-	-	-	-
7,0	0,75	6,20	80	14	10	5,5	4,3	-	-	-	-	-
8,0	0,50	7,50	80	19	12	6,0	4,9	-	-	-	-	-
8,0	0,75	7,20	80	19	12	6,0	4,9	-	-	-	-	-
8,0	1,00	7,00	90	22	12	6,0	4,9	●	●	●	●	●
9,0	1,00	8,00	90	22	12	7,0	5,5	-	-	-	-	-
10,0	0,75	9,20	90	20	14	7,0	5,5	-	-	-	-	-
10,0	1,00	9,00	90	20	14	7,0	5,5	●	●	●	●	●
10,0	1,25	8,80	100	24	14	7,0	5,5	●	●	●	-	●
11,0	1,00	10,00	90	20	14	8,0	6,2	-	-	-	-	-
12,0	1,00	11,00	100	22	16	9,0	7,0	●	●	●	●	●
12,0	1,25	10,80	100	22	16	9,0	7,0	●	●	-	-	-
12,0	1,50	10,50	100	22	16	9,0	7,0	●	●	●	●	●
14,0	1,00	13,00	100	22	20	11,0	9,0	-	-	-	-	-
14,0*	1,25	12,80	100	22	20	11,0	9,0	-	-	-	-	-
14,0	1,50	12,50	100	22	20	11,0	9,0	●	●	●	●	-
15,0	1,00	14,00	100	22	20	12,0	9,0	-	-	-	-	-
15,0	1,50	13,50	100	22	20	12,0	9,0	-	-	-	-	-
16,0	1,00	15,00	100	22	20	12,0	9,0	-	-	-	-	-
16,0	1,50	14,50	100	22	20	12,0	9,0	●	●	●	●	●

\* Misura non in standard ISO | These sizes are not ISO standard.  
In fase di ordinazione specificare sempre il Ø (D) e il passo (P) | When ordering, please state Ø (D) and pitch (P)

# MF - DIN 374

Maschi a macchina con gambo passante | Machine taps with reduced shank



HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co
VA 35°	GG	HD 15°	HD 15°	ALU 45°
-	NIT	-	TiAlN HL EVO	-
35°	0°	15°	15°	45°
↻	↻	↻	↻	↻
-	-	-	-	-
6GX	6HX	6H	6H	6H
C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3
P	-	P	P	-
M	-	-	-	-
-	K	K	K	-
N	N	-	-	N
S	-	-	-	-
-	-	-	-	-

MATERIALE   MATERIAL
TIPO   TYPE
RIVESTIMENTO/ TRATTAMENTO   COATING/ TREATMENT
ANGOLO ELICA   HELIX ANGLE
DIREZIONE TAGLIO   CUTTING DIRECTION
LUBRIFICAZIONE INTERNA   INTERNAL COOLANT
TOLLERANZA   TOLERANCE
FORMA D'IMBOCCO/FILETTI   CHAMFER FORM/THREADS
TIPO DI FORO   HOLE TYPE
<b>P</b>   Acciai   Steels
<b>M</b>   Acciai Inossidabili   Stainless Steels
<b>K</b>   Ghise   Cast Irons
<b>N</b>   Metalli non ferrosi   Non-ferrous metals
<b>S</b>   Leghe resistenti al calore e Titanio   HRSA and Titanium
<b>H</b>   Acciai Temprati   Hardened Steels

66556G	6653	6880	6880HL	6731		d <sub>1</sub>	P		I <sub>1</sub>	I <sub>2</sub> (35-45°)
-	-	-	-	-		3,0	0,35	2,65	56	5
-	-	-	-	-		3,5	0,35	3,15	56	6
-	-	-	-	-		4,0	0,50	3,50	63	7
-	-	-	-	-		5,0	0,50	4,50	70	8
-	-	-	-	-		6,0	0,50	5,50	80	10
-	-	●	●	-		6,0	0,75	5,20	80	10
-	-	-	-	-		7,0	0,75	6,20	80	10
-	-	-	-	-		8,0	0,50	7,50	80	12
-	-	-	-	-		8,0	0,75	7,20	80	12
●	●	●	●	●		8,0	1,00	7,00	90	12
-	■	-	-	-		9,0	1,00	8,00	90	12
-	-	-	-	-		10,0	0,75	9,20	90	14
●	●	●	●	●		10,0	1,00	9,00	90	14
-	-	-	-	■		10,0	1,25	8,80	100	14
-	-	-	-	-		11,0	1,00	10,00	90	14
-	-	●	●	●		12,0	1,00	11,00	100	16
-	-	-	-	-		12,0	1,25	10,80	100	16
●	●	●	●	●		12,0	1,50	10,50	100	16
-	-	-	-	-		14,0	1,00	13,00	100	20
-	-	-	-	-		14,0	1,25*	12,80	100	20
●	●	●	●	●		14,0	1,50	12,50	100	20
-	-	-	-	-		15,0	1,00	14,00	100	20
-	-	-	-	-		15,0	1,50	13,50	100	20
-	-	-	-	-		16,0	1,00	15,00	100	20
●	●	●	●	●		16,0	1,50	14,50	100	20

■ Fino ad esaurimento scorte | Till stocks last

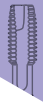
01/02

B  
02  
GRUPPO MATERIALI  
MATERIAL GROUPS

$d_1$	P		$l_1$	$l_2$	$l_2$ (35-45°)	$d_2$ (h9)	a (h12)		6671	6626XP	6655	6655VP	6655XP
18,0	1,00	17,00	110	25	25	14,0	11,0	-	-	-	-	-	-
18,0	1,50	16,50	110	25	25	14,0	11,0	●	●	●	●	●	-
20,0	1,50	18,50	125	25	25	16,0	12,0	●	●	●	●	●	●
20,0	2,00	18,00	140	34	25	16,0	12,0	-	-	-	-	-	-
22,0	1,00	21,00	125	25	25	18,0	14,5	-	-	-	-	-	-
22,0	1,50	20,50	125	25	25	18,0	14,5	●	●	●	●	●	-
22,0	2,00	20,00	140	34	25	18,0	14,5	-	-	-	-	-	-
24,0	1,00	23,00	140	28	28	18,0	14,5	-	-	-	-	-	-
24,0	1,50	22,50	140	28	28	18,0	14,5	●	●	●	●	●	●
24,0	2,00	22,00	140	28	28	18,0	14,5	-	-	-	-	-	-
26,0	1,50	24,50	140	28	28	18,0	14,5	■	-	-	-	-	-
27,0	1,50	25,50	140	28	28	20,0	16,0	■	-	●	■	■	●
27,0	2,00	25,00	140	28	28	20,0	16,0	-	-	●	-	-	-
28,0	1,50	26,50	140	28	28	20,0	16,0	■	-	●	■	■	●
30,0	1,00	29,00	150	28	28	22,0	18,0	-	-	-	-	-	-
30,0	1,50	28,50	150	28	28	22,0	18,0	■	-	●	■	■	●
30,0	2,00	28,00	150	28	28	22,0	18,0	-	-	●	■	■	-

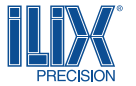
02/02


■ Fino ad esaurimento scorte | Till stocks last

**B  
02**


# MF - DIN 374

Maschi a macchina con gambo passante | Machine taps with reduced shank



66556G	6653	6880	6880HL	6731		d <sub>1</sub>	P		l <sub>1</sub>	l <sub>2</sub> (35-45°)
-	-	-	-	-		<b>18,0</b>	<b>1,00</b>	17,00	110	25
●	●	●	●	●		<b>18,0</b>	<b>1,50</b>	16,50	110	25
●	●	●	●	●		<b>20,0</b>	<b>1,50</b>	18,50	125	25
-	-	-	-	-		<b>20,0</b>	<b>2,00</b>	18,00	140	25
-	-	-	-	-		<b>22,0</b>	<b>1,00</b>	21,00	125	25
-	●	●	●	-		<b>22,0</b>	<b>1,50</b>	20,50	125	25
-	-	-	-	-		<b>22,0</b>	<b>2,00</b>	20,00	140	25
-	-	-	-	-		<b>24,0</b>	<b>1,00</b>	23,00	140	28
-	●	●	●	-		<b>24,0</b>	<b>1,50</b>	22,50	140	28
-	-	-	-	-		<b>24,0</b>	<b>2,00</b>	22,00	140	28
-	-	-	-	-		<b>26,0</b>	<b>1,50</b>	24,50	140	28
-	-	-	-	-		<b>27,0</b>	<b>1,50</b>	25,50	140	28
-	-	-	-	-		<b>27,0</b>	<b>2,00</b>	25,00	140	28
-	-	-	-	-		<b>28,0</b>	<b>1,50</b>	26,50	140	28
-	-	-	-	-		<b>30,0</b>	<b>1,00</b>	29,00	150	28
-	-	-	-	-		<b>30,0</b>	<b>1,50</b>	28,50	150	28
-	-	-	-	-		<b>30,0</b>	<b>2,00</b>	28,00	150	28

02/02

B  
02



**NEW**

6663XP

**NEW**

6872TF

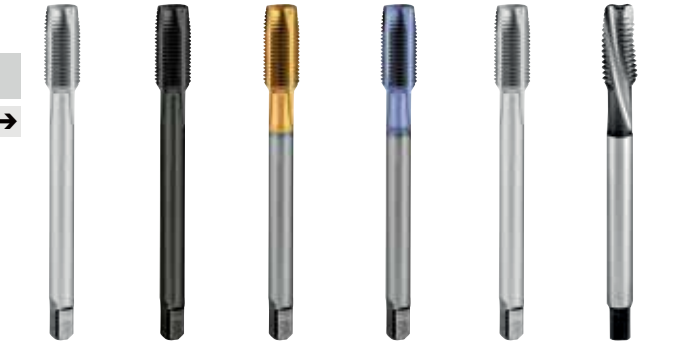
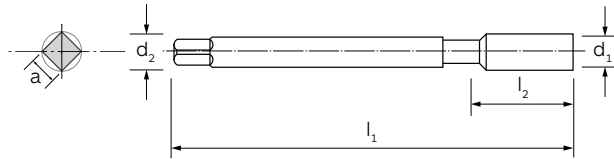
**MF**

DIN 13

**374**

DIN

P. 632 →



- MATERIALE | MATERIAL
- TIPO | TYPE
- RIVESTIMENTO | COATING
- ANGOLO ELICA | HELIX ANGLE
- DIREZIONE TAGLIO | CUTTING DIRECTION
- LUBRIFICAZIONE INTERNA | INTERNAL COOLANT
- TOLLERANZA | TOLERANCE
- FORMA D'IMBOCCO/FILETTI | CHAMFER FORM/THREADS
- TIPO DI FORO | HOLE TYPE

HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co
Rapid	Rapid	Rapid	Rapid	N SX	NL 15°
-	VAP	TiN	TiCN	-	-
0°	0°	0°	0°	0°	15°
↻	↻	↻	↻	↻	↻
-	-	-	-	-	-
6H	6H	6H	6H	6H	6H
B/4-5	B/4-5	B/4-5	B/4-5	B/4-5	B/4-5
P	P	P	P	P	P
M	M	M	M	-	-
K	K	K	K	K	K
N	N	N	N	N	-
-	-	-	-	-	-
-	-	-	-	-	-

- P** | Acciai | Steels
- M** | Acciai Inossidabili | Stainless Steels
- K** | Ghise | Cast Irons
- N** | Metalli non ferrosi | Non-ferrous metals
- S** | Leghe resistenti al calore e Titanio | HRSA and Titanium
- H** | Acciai Temprati | Hardened Steels

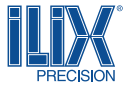
**B 02**

d <sub>1</sub>	P		l <sub>1</sub>	l <sub>2</sub>	d <sub>2</sub> (h9)	a (h12)	6730	6730VP	6730TN	6730TC	6863	6741
3,0	0,35	2,65	56	9	2,2	-	●	●	●	●	-	-
3,5	0,35	3,15	56	10	2,5	2,1	●	●	●	●	-	-
4,0	0,50	3,50	63	10	2,8	2,1	●	●	●	●	-	-
5,0	0,50	4,50	70	12	3,5	2,7	●	●	●	●	-	-
6,0	0,50	5,50	80	14	4,5	3,4	●	●	●	●	-	-
6,0	0,75	5,20	80	14	4,5	3,4	●	●	●	●	-	-
7,0	0,75	6,20	80	14	5,5	4,3	●	●	●	●	-	-
8,0	0,50	7,50	80	19	6,0	4,9	●	●	●	●	-	-
8,0	0,75	7,20	80	19	6,0	4,9	●	●	●	●	-	●
8,0	1,00	7,00	90	22	6,0	4,9	●	●	●	●	●	●
9,0	1,00	8,00	90	22	7,0	5,5	●	●	●	●	-	-
10,0	0,75	9,20	90	20	7,0	5,5	●	●	●	●	-	-
10,0	1,00	9,00	90	20	7,0	5,5	●	●	●	●	●	●
10,0	1,25	8,80	100	24	7,0	5,5	●	●	●	●	-	-
11,0	1,00	10,00	90	20	8,0	6,2	●	●	●	●	-	-
12,0	1,00	11,00	100	22	9,0	7,0	●	●	●	●	●	●
12,0	1,25	10,80	100	22	9,0	7,0	●	●	●	●	-	-
12,0	1,50	10,50	100	22	9,0	7,0	●	●	●	●	●	●
14,0	1,00	13,00	100	22	11,0	9,0	●	●	●	●	-	-
14,0	1,25*	12,80	100	22	11,0	9,0	●	●	●	●	-	-
14,0	1,50	12,50	100	22	11,0	9,0	●	●	●	●	●	●
15,0	1,00	14,00	100	22	12,0	9,0	●	●	●	●	-	-
15,0	1,50	13,50	100	22	12,0	9,0	●	●	●	●	-	-
16,0	1,00	15,00	100	22	12,0	9,0	●	●	●	●	-	-
16,0	1,50	14,50	100	22	12,0	9,0	●	●	●	●	●	●

\* Misura non in standard ISO | These sizes are not ISO standard.

# MF - DIN 374

Maschi a macchina con gambo passante | Machine taps with reduced shank



HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co
VA	VA	VA	VA	VA	HD	HD
-	VAP	-	TiN	AlCrN TOP	-	TiAlN Futura
0°	0°	0°	0°	0°	0°	0°
-	-	-	-	-	-	-
6HX	6HX	6GX	6HX	6HX	6H	6H
B/4-5	B/4-5	B/4-5	B/4-5	B/4-5	B/4-5	B/4-5
P	P	P	P	P	P	P
M	M	M	M	M	-	-
-	-	-	-	-	K	K
N	N	N	N	N	-	-
S	S	S	S	S	-	-
-	-	-	-	-	-	-

MATERIALE   MATERIAL
TIPO   TYPE
RIVESTIMENTO   COATING
ANGOLO ELICA   HELIX ANGLE
DIREZIONE TAGLIO   CUTTING DIRECTION
LUBRIFICAZIONE INTERNA   INTERNAL COOLANT
TOLLERANZA   TOLERANCE
FORMA/FILETTI D'IMB.   CHAMFER FORM/THRE.
TIPO DI FORO   HOLE TYPE
<b>P</b>   Acciai   Steels
<b>M</b>   Acciai Inossidabili   Stainless Steels
<b>K</b>   Ghise   Cast Irons
<b>N</b>   Metalli non ferrosi   Non-ferrous metals
<b>S</b>   Leghe res. al calore e Tit.   HRSA and Titanium
<b>H</b>   Acciai Temprati   Hardened Steels

**B 02**  
GRUPPO MATERIALI  
MATERIAL GROUPS

6663	6663VP	66636G	6663TN	6663XP	6872	6872TF	d <sub>1</sub>	P		l <sub>1</sub>	l <sub>2</sub>
-	-	-	-	-	-	-	3,0	0,35	2,65	56	9
-	-	-	-	-	-	-	3,5	0,35	3,15	56	10
-	-	-	-	-	-	-	4,0	0,50	3,50	63	10
-	-	-	-	-	-	-	5,0	0,50	4,50	70	12
-	-	-	-	-	-	-	6,0	0,50	5,50	80	14
-	-	-	-	-	●	●	6,0	0,75	5,20	80	14
-	-	-	-	-	-	-	7,0	0,75	6,20	80	14
-	-	-	-	-	-	-	8,0	0,50	7,50	80	19
-	-	-	-	-	●	●	8,0	0,75	7,20	80	19
●	●	●	●	●	●	●	8,0	1,00	7,00	90	22
-	-	-	-	-	-	-	9,0	1,00	8,00	90	22
-	-	-	-	-	-	-	10,0	0,75	9,20	90	20
●	●	●	●	●	●	●	10,0	1,00	9,00	90	20
●	●	-	●	●	-	-	10,0	1,25	8,80	100	24
-	-	-	-	-	-	-	11,0	1,00	10,00	90	20
●	●	●	●	●	●	●	12,0	1,00	11,00	100	22
-	-	-	-	-	-	-	12,0	1,25	10,80	100	22
●	●	●	●	●	●	●	12,0	1,50	10,50	100	22
-	-	-	-	-	-	-	14,0	1,00	13,00	100	22
-	-	-	-	-	-	-	14,0	1,25*	12,80	100	22
●	●	●	●	●	●	●	14,0	1,50	12,50	100	22
-	-	-	-	-	-	-	15,0	1,00	14,00	100	22
-	-	-	-	-	-	-	15,0	1,50	13,50	100	22
-	-	-	-	-	-	-	16,0	1,00	15,00	100	22
●	●	●	●	●	●	●	16,0	1,50	14,50	100	22

01/02

\* Misura non in standard ISO | These sizes are not ISO standard.

$d_1$	P		$l_1$	$l_2$	$d_2$ (h9)	a (h12)		6730	6730VP	6730TN	6730TC	6863	6741
18,0	1,00	16,50	110	25	14,0	11,0		●	●	●	●	-	-
18,0	1,50	16,50	110	25	14,0	11,0		●	●	●	●	●	●
18,0	2,00	16,00	125	34	14,0	11,0		●	●	●	●	-	-
20,0	1,00	19,00	125	25	16,0	12,0		●	●	●	●	-	-
20,0	1,50	18,50	125	25	16,0	12,0		●	●	●	●	●	●
20,0	2,00	18,00	140	34	16,0	12,0		●	●	●	●	-	-
22,0	1,00	21,00	125	25	18,0	14,5		●	●	●	●	-	-
22,0	1,50	20,50	125	25	18,0	14,5		●	●	●	●	-	-
22,0	2,00	20,00	140	34	18,0	14,5		●	●	●	●	-	-
24,0	1,00	23,00	140	28	18,0	14,5		●	●	●	●	-	-
24,0	1,50	22,50	140	28	18,0	14,5		●	●	●	●	-	-
24,0	2,00	22,00	140	28	18,0	14,5		●	●	●	●	-	-
26,0	1,50	24,50	140	28	18,0	14,5		●	●	●	●	-	-
27,0	1,50	25,50	140	28	20,0	16,0		●	●	●	●	-	-
27,0	2,00	25,00	140	28	20,0	16,0		●	●	●	●	-	-
28,0	1,50	26,50	140	28	20,0	16,0		●	●	●	●	-	-
30,0	1,00	29,00	150	28	22,0	18,0		●	●	●	●	-	-
30,0	1,50	28,50	150	28	22,0	18,0		●	●	●	●	-	-
30,0	2,00	28,00	150	28	22,0	18,0		●	●	●	●	-	-
32,0	1,50	30,50	150	28	22,0	18,0		●	●	●	●	-	-
33,0	1,50	31,50	160	30	25,0	20,0		●	●	●	●	-	-
34,0	1,50	32,50	170	30	28,0	22,0		●	●	●	●	-	-
35,0	1,50	33,50	170	30	28,0	22,0		●	●	●	●	-	-
36,0	1,50	34,50	170	30	28,0	22,0		●	●	●	●	-	-
38,0	1,50	36,50	170	30	28,0	22,0		●	●	●	●	-	-
40,0	1,50	38,50	170	30	32,0	24,0		●	●	●	●	-	-
42,0	1,50	40,50	170	30	32,0	24,0		●	●	●	●	-	-
45,0	1,50	43,50	180	32	36,0	29,0		●	●	●	●	-	-
48,0	1,50	46,50	190	32	36,0	29,0		●	●	●	●	-	-
50,0	1,50	48,50	190	32	36,0	29,0		●	●	●	●	-	-
52,0	1,50	50,50	190	32	40,0	32,0		●	●	●	●	-	-



6663	6663VP	66636G	6663TN	6663XP	6872	6872TF		d <sub>1</sub>	P		l <sub>1</sub>	l <sub>2</sub>
-	-	-	-	-	-	-		18,0	1,00	16,50	110	25
●	●	-	●	●	●	●		18,0	1,50	16,50	110	25
-	-	-	-	-	-	-		18,0	2,00	16,00	125	34
-	-	-	-	-	-	-		20,0	1,00	19,00	125	25
●	●	●	●	●	●	●		20,0	1,50	18,50	125	25
●	●	-	●	-	-	-		20,0	2,00	18,00	140	34
-	-	-	-	-	-	-		22,0	1,00	21,00	125	25
●	●	-	●	-	●	●		22,0	1,50	20,50	125	25
●	●	-	●	-	-	-		22,0	2,00	20,00	140	34
-	-	-	-	-	-	-		24,0	1,00	23,00	140	28
●	●	●	●	●	●	●		24,0	1,50	22,50	140	28
●	●	-	●	-	-	-		24,0	2,00	22,00	140	28
●	●	-	-	-	-	-		26,0	1,50	24,50	140	28
●	●	-	■	-	-	-		27,0	1,50	25,50	140	28
●	●	-	■	-	-	-		27,0	2,00	25,00	140	28
-	-	-	-	-	-	-		28,0	1,50	26,50	140	28
-	-	-	-	-	-	-		30,0	1,00	29,00	150	28
-	●	-	-	-	-	-		30,0	1,50	28,50	150	28
-	●	-	■	-	-	-		30,0	2,00	28,00	150	28
-	-	-	-	-	-	-		32,0	1,50	30,50	150	28
-	-	-	-	-	-	-		33,0	1,50	31,50	160	30
-	-	-	-	-	-	-		34,0	1,50	32,50	170	30
-	-	-	-	-	-	-		35,0	1,50	33,50	170	30
-	-	-	-	-	-	-		36,0	1,50	34,50	170	30
-	-	-	-	-	-	-		38,0	1,50	36,50	170	30
-	-	-	-	-	-	-		40,0	1,50	38,50	170	30
-	-	-	-	-	-	-		42,0	1,50	40,50	170	30
-	-	-	-	-	-	-		45,0	1,50	43,50	180	32
-	-	-	-	-	-	-		48,0	1,50	46,50	190	32
-	-	-	-	-	-	-		50,0	1,50	48,50	190	32
-	-	-	-	-	-	-		52,0	1,50	50,50	190	32

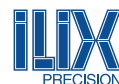
■ Fino ad esaurimento scorte | Till stocks last

02/02





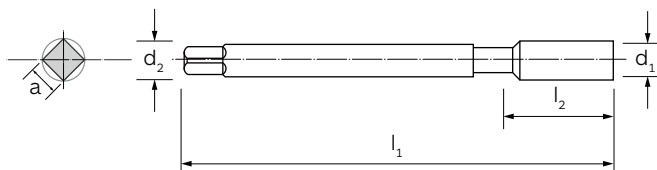
# UNC - DIN 2184-2



Maschi a mano in serie di 3 pezzi composta da sbozzatore (P), intermedio (S), finitore (T)  
Hand taps, series in set of 3 pieces, consisting of taper (P), plug (S) and bottom (T)

**UNC**  
ASME B.1.1

**2184  
2**  
DIN



HSS	HSS	HSS
N	N	N
-	-	-
0°	0°	0°
↻	↻	↻
-	-	-
2B	2B	2B
A/5-6	D/3-4	C/2,5-3
P	P	P
M	M	M
K	K	K
N	N	N
S	S	S
-	-	-

MATERIALE | MATERIAL

TIPO | TYPE

RIVESTIMENTO | COATING

ANGOLO ELICA | HELIX ANGLE

DIREZIONE TAGLIO | CUTTING DIRECTION

LUBRIFICAZIONE INTERNA | INTERNAL COOLANT

TOLLERANZA | TOLERANCE

FORMA D'IMBOCCO/FILETTI | CHAMFER FORM/THREADS

TIPO DI FORO | HOLE TYPE

GRUPPO MATERIALI  
MATERIAL GROUPS

**P** | Acciai | Steels

**M** | Acciai Inossidabili | Stainless Steels

**K** | Ghise | Cast Irons

**N** | Metalli non ferrosi | Non-ferrous metals

**S** | Leghe resistenti al calore e Titanio | HRSA and Titanium

**H** | Acciai Temprati | Hardened Steels

d <sub>1</sub>	Filetti/1" Tpi		l <sub>1</sub>	l <sub>2</sub>	d <sub>2</sub> (h9*)	a (h12)	6775P	6775S	6775T	
							6775 (Serie   Set)			
							6775P	6775S	6775T	6775
nr. 1	64	1,55	36	8	2,8	2,1	●	●	●	●
nr. 2	56	1,85	36	9	2,8	2,1	●	●	●	●
nr. 3	48	2,10	40	9	2,8	2,1	●	●	●	●
nr. 4	40	2,35	40	11	3,5	2,7	●	●	●	●
nr. 5	40	2,65	40	11	3,5	2,7	●	●	●	●
nr. 6	32	2,85	45	13	4,0	3,0	●	●	●	●
nr. 8	32	3,50	45	13	4,5	3,4	●	●	●	●
nr. 10	24	3,90	50	16	6,0	4,9	●	●	●	●
nr. 12	24	4,50	50	17	6,0	4,9	●	●	●	●
1/4	20	5,10	50	19	6,0	4,9	●	●	●	●
5/16	18	6,60	56	22	6,0	4,9	●	●	●	●
3/8	16	8,00	63	22	7,0	5,5	●	●	●	●
7/16	14	9,40	70	24	8,0	6,2	●	●	●	●
1/2	13	10,80	75	29	9,0	7,0	●	●	●	●
9/16	12	12,20	80	30	11,0	9,0	●	●	●	●
5/8	11	13,50	80	32	12,0	9,0	●	●	●	●
3/4	10	16,50	95	40	14,0	11,0	●	●	●	●
7/8	9	19,50	100	40	18,0	14,5	●	●	●	●
1"	8	22,25	110	50	18,0	14,5	●	●	●	●
1 1/8	7	25,00	125	56	22,0	18,0	●	●	●	●
1 1/4	7	28,00	125	56	22,0	18,0	●	●	●	●
1 3/8	6	30,75	150	63	28,0	22,0	●	●	●	●
1 1/2	6	34,00	150	63	32,0	24,0	●	●	●	●
1 3/4	5	39,50	160	70	36,0	29,0	●	●	●	●
2"	4 1/2	45,00	180	75	40,0	32,0	●	●	●	●

\* La tolleranza del gambo per il 1° e 2° maschio è h 12 | Shank tolerance of 1st and 2nd tap h 12







Maschi a macchina con gambo rinforzato, simile DIN 371  
Machine taps with reinforced shank, similar to DIN 371

**NEW**

**6739XP**

**UNC**

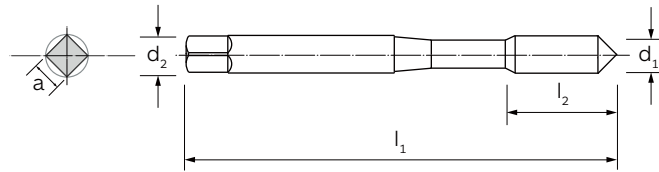
ASME B.1.1

**2184**

**-1**

DIN

**P. 632** →



HSS-Co	HSS-Co	HSS-Co	HSS-Co
HD	Rapid	Rapid	Rapid
-	-	-	TiN
0°	0°	0°	0°
↻	↻	↻	↻
-	-	-	-
2B	2B	3B	2B
B/4-5	B/4-5	B/4-5	B/4-5
P	P	P	P
-	M	M	M
K	K	K	K
-	N	N	N
-	-	-	-
-	-	-	-

MATERIALE   MATERIAL
TIPO   TYPE
RIVESTIMENTO   COATING
ANGOLO ELICA   HELIX ANGLE
DIREZIONE TAGLIO   CUTTING DIRECTION
LUBRIFICAZIONE INTERNA   INTERNAL COOLANT
TOLLERANZA   TOLERANCE
FORMA D'IMBOCCO/FILETTI   CHAMFER FORM/THREADS
TIPO DI FORO   HOLE TYPE
<b>P</b>   Acciai   Steels
<b>M</b>   Acciai inossidabili   Stainless Steels
<b>K</b>   Ghise   Cast Irons
<b>N</b>   Metalli non ferrosi   Non-ferrous metals
<b>S</b>   Leghe resistenti al calore e Titanio   HRSA and Titanium
<b>H</b>   Acciai Temprati   Hardened Steels

B  
02

GRUPPO MATERIALI  
MATERIAL GROUPS

$d_1$	Filetti/1" Tpi		$l_1$	$l_2$	$d_2$ (h9)	$a$ (h12)	6873	6690	66903B	6690TN
nr. 1	64	1,55	45	8	2,8	2,1	-	●	-	●
nr. 2	56	1,85	45	9	2,8	2,1	●	●	-	●
nr. 3	48	2,10	50	9	2,8	2,1	●	●	-	●
nr. 4	40	2,35	56	11	3,5	2,7	●	●	●	●
nr. 5	40	2,65	56	11	3,5	2,7	●	●	-	●
nr. 6	32	2,85	56	13	4,0	3,0	●	●	●	●
nr. 8	32	3,50	63	13	4,5	3,4	●	●	●	●
nr. 10	24	3,90	70	16	6,0	4,9	●	●	●	●
nr. 12	24	4,50	80	17	6,0	4,9	●	●	-	●
1/4	20	5,10	80	17	6,0	4,9	●	●	●	●
5/16	18	6,60	90	20	8,0	6,2	●	●	-	●
3/8	16	8,00	90	20	10,0	8,0	-	●	●	●

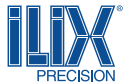






# UNC - DIN 2184/1

Maschi a macchina a rullare con gambo passante  
Cold forming machine taps with reduced shank

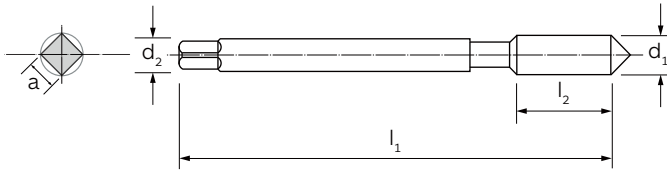


NEW

**UNC**  
ASME B.1.1

**2184  
-1**  
DIN

P. 650



con canali di lubrificazione  
with coolant grooves

MATERIALE | MATERIAL

TIPO | TYPE

RIVESTIMENTO | COATING

ANGOLO ELICA | HELIX ANGLE

DIREZIONE TAGLIO | CUTTING DIRECTION

LUBRIFICAZIONE INTERNA | INTERNAL COOLANT

TOLLERANZA | TOLERANCE

FORMA D'IMBOCCO/FILETTI | CHAMFER FORM/THREADS

TIPO DI FORO | HOLE TYPE

GRUPPO MATERIALI  
MATERIAL GROUPS

**P** | Acciai | Steels

**M** | Acciai Inossidabili | Stainless Steels

**K** | Ghise | Cast Irons

**N** | Metalli non ferrosi | Non-ferrous metals

**S** | Leghe resistenti al calore e Titanio | HRSA and Titanium

**H** | Acciai Temprati | Hardened Steels

HSS-Co

FORMER S

TiN

-



-

2BX

C/2,5-3



P

M

-

N

-

-

B  
02



d <sub>1</sub>	Filetti/1" Tpi		l <sub>1</sub>	l <sub>2</sub>	d <sub>2</sub> (h9)	a (h12)	6811TN
----------------	-------------------	--	----------------	----------------	------------------------	------------	--------

<b>1/2</b>	13	11,80	110	25	9	7,0	●
<b>9/16</b>	12	13,30	110	28	11	9,0	●
<b>5/8</b>	11	14,85	110	30	12	9,0	●
<b>3/4</b>	10	17,90	125	33	14	11,0	●





Maschi a macchina con gambo passante, simile DIN 376  
Machine taps with reduced shank, similar to DIN 376

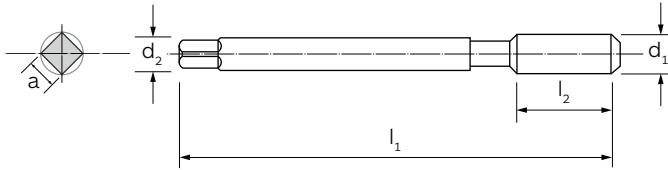
**UNC**

ASME B.1.1

**2184  
-1**

DIN

**P. 632** →



MATERIALE | MATERIAL

TIPO | TYPE

RIVESTIMENTO | COATING

ANGOLO ELICA | HELIX ANGLE

DIREZIONE TAGLIO | CUTTING DIRECTION

LUBRIFICAZIONE INTERNA | INTERNAL COOLANT

TOLLERANZA | TOLERANCE

FORMA D'IMBOCCO/FILETTI | CHAMFER FORM/THREADS

TIPO DI FORO | HOLE TYPE

**P** | Acciai | Steels

**M** | Acciai inossidabili | Stainless Steels

**K** | Ghise | Cast Irons

**N** | Metalli non ferrosi | Non-ferrous metals

**S** | Leghe resistenti al calore e Titanio | HRSA and Titanium

**H** | Acciai Temprati | Hardened Steels



HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co
HD	Rapid	Rapid	VA	VA
-	-	-	-	VAP
0°	0°	0°	0°	0°
-	-	-	-	-
2B	2B	3B	2BX	2BX
B/4-5	B/4-5	B/4-5	B/4-5	B/4-5
P	P	P	P	P
-	M	M	M	M
K	K	K	-	-
-	N	N	N	N
-	-	-	S	S
-	-	-	-	-

B  
02

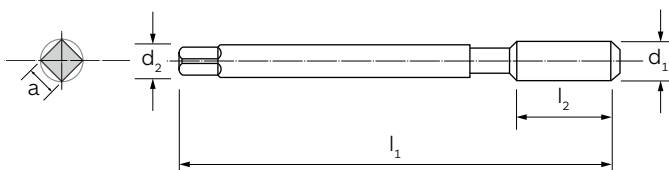
GRUPPO MATERIALI  
MATERIAL GROUPS

d <sub>1</sub>	Filetti/1" Tpi		l <sub>1</sub>	l <sub>2</sub>	d <sub>2</sub> (h9)	a (h12)	6874	6693	66933B	6749	6749VP
7/16	14	9,40	100	14	8	6,2	●	●	●	-	-
1/2	13	10,80	110	16	9	7,0	●	●	●	●	●
9/16	12	12,20	110	20	11	9,0	●	●	●	-	-
5/8	11	13,50	110	20	12	9,0	●	●	●	●	●
3/4	10	16,50	125	25	14	11,0	●	●	●	●	●
7/8	9	19,50	140	25	18	14,5	●	●	●	●	●
1"	8	22,25	160	30	18	14,5	●	●	●	●	●
1 1/8	7	25,00	180	-	22	18,0	-	●	●	-	-
1 1/4	7	28,00	180	-	22	18,0	-	●	●	-	-
1 3/8	6	30,75	200	-	28	22,0	-	●	●	-	-
1 1/2	6	34,00	200	-	32	24,0	-	●	●	-	-
1 3/4	5	39,50	220	-	36	29,0	-	●	●	-	-
2"	5	45,00	250	-	40	32,0	-	●	●	-	-

# UNF - DIN 2184/2

Maschi a mano in serie di 2 pezzi composta da sbozzatore (P) e finitore (T)  
Hand taps, series in set of 2 pieces, consisting of taper (P) and bottom (T)

**UNF** **2184**  
**2**  
**DIN** **P. 632** →



HSS	HSS
N	N
-	-
0°	0°
↻	↻
-	-
2B	2B
A/5-6	C/2,5-3
P	P
M	M
K	K
N	N
S	S
-	-

MATERIALE   MATERIAL
TIPO   TYPE
RIVESTIMENTO   COATING
ANGOLO ELICA   HELIX ANGLE
DIREZIONE TAGLIO   CUTTING DIRECTION
LUBRIFICAZIONE INTERNA   INTERNAL COOLANT
TOLLERANZA   TOLERANCE
FORMA D'IMBOCCO/FILETTI   CHAMFER FORM/THREADS
TIPO DI FORO   HOLE TYPE
<b>P</b>   Acciai   Steels
<b>M</b>   Acciai Inossidabili   Stainless Steels
<b>K</b>   Ghise   Cast Irons
<b>N</b>   Metalli non ferrosi   Non-ferrous metals
<b>S</b>   Leghe resistenti al calore e Titanio   HRSA and Titanium
<b>H</b>   Acciai Temprati   Hardened Steels

GRUPPO MATERIALI  
MATERIAL GROUPS

d <sub>1</sub>	Filetti/1" Tpi		l <sub>1</sub>	l <sub>2</sub>	d <sub>2</sub> (h9*)	a (h12)	6776P	6776T
							<b>6776</b> (Serie   Set)	

							6776P	6776T	6776
nr. 1	72	1,55	45	8	2,8	2,1	●	●	●
nr. 2	64	1,85	45	9	2,8	2,1	●	●	●
nr. 3	56	2,15	40	9	2,8	2,1	●	●	●
nr. 4	48	2,40	40	11	3,5	2,7	●	●	●
nr. 5	44	2,70	40	11	3,5	2,7	●	●	●
nr. 6	40	2,95	45	13	4,0	3,0	●	●	●
nr. 8	36	3,50	45	13	4,5	3,4	●	●	●
nr. 10	32	4,10	50	12	6,0	4,9	●	●	●
nr. 12	28	4,70	50	17	6,0	4,9	●	●	●
1/4	28	5,50	50	14	6,0	4,9	●	●	●
5/16	24	6,90	56	22	6,0	4,9	●	●	●
3/8	24	8,50	63	22	7,0	5,5	●	●	●
7/16	20	9,90	63	20	8,0	6,2	●	●	●
1/2	20	11,50	70	22	9,0	7,0	●	●	●
9/16	18	12,90	70	22	11,0	9,0	●	●	●
5/8	18	14,50	70	22	12,0	9,0	●	●	●
3/4	16	17,50	80	22	14,0	11,0	●	●	●
7/8	14	20,40	80	22	18,0	14,5	●	●	●
1	12	23,25	90	22	18,0	14,5	●	●	●
1 1/8	12	26,50	90	22	22,0	18,0	●	●	●
1 1/4	12	29,50	90	22	22,0	18,0	●	●	●
1 3/8	12	32,75	125	40	28,0	22,0	●	●	●
1 1/2	12	36,00	125	40	32,0	24,0	●	●	●

\* La tolleranza del gambo per il 1° e 2° maschio è h 12 | Shank tolerance of 1st and 2nd tap h 12

B  
02

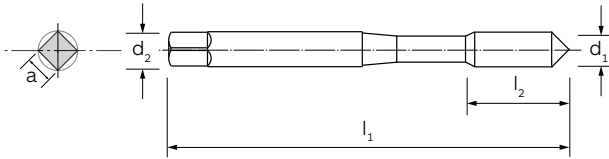
Maschi a macchina con gambo rinforzato, simile DIN 371  
Machine taps with reinforced shank, similar to DIN 371

**UNF**

**2184  
-1**

DIN

III  
P. 632 →



MATERIALE | MATERIAL

TIPO | TYPE

RIVESTIMENTO | COATING

ANGOLO ELICA | HELIX ANGLE

DIREZIONE TAGLIO | CUTTING DIRECTION

LUBRIFICAZIONE INTERNA | INTERNAL COOLANT

TOLLERANZA | TOLERANCE

FORMA D'IMBOCCO/FILETTI | CHAMFER FORM/THREADS

TIPO DI FORO | HOLE TYPE

**P** | Acciai | Steels

**M** | Acciai inossidabili | Stainless Steels

**K** | Ghise | Cast Irons

**N** | Metalli non ferrosi | Non-ferrous metals

**S** | Leghe resistenti al calore e Titanio | HRSA and Titanium

**H** | Acciai Temprati | Hardened Steels



HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co
N	N 15°	N 40°	N 40°	N 40°
-	-	-	-	TiN
0°	15°	40°	40°	40°
↻	↻	↻	↻	↻
-	-	-	-	-
2B	2B	2B	3B	2B
C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3
<b>P</b>	<b>P</b>	<b>P</b>	<b>P</b>	<b>P</b>
-	-	-	-	<b>M</b>
<b>K</b>	<b>K</b>	<b>K</b>	<b>K</b>	<b>K</b>
<b>N</b>	<b>N</b>	<b>N</b>	<b>N</b>	<b>N</b>
-	-	-	-	-
-	-	-	-	-

B  
02

GRUPPO MATERIALI  
MATERIAL GROUPS

d <sub>1</sub>	Filetti/1" Tpi		l <sub>1</sub>	l <sub>2</sub>	l <sub>2</sub> (35-40 50°)	d <sub>2</sub> (h9)	a (h12)	6838	6719	6680	66803B	6680TN
nr. 1	<b>72</b>	1,55	45	8	-	3	2,1	●	-	-	-	-
nr. 2	<b>64</b>	1,85	45	9	-	3	2,1	●	-	-	-	-
nr. 3	<b>56</b>	2,15	50	9	-	3	2,1	●	-	-	-	-
nr. 4	<b>48</b>	2,40	56	11	-	4	2,7	●	-	-	-	-
nr. 5	<b>44</b>	2,70	56	11	5	4	2,7	●	●	●	●	●
nr. 6	<b>40</b>	2,95	56	13	6	4	2,1	●	●	●	●	●
nr. 8	<b>36</b>	3,50	63	13	7	5	2,1	●	●	●	●	●
nr. 10	<b>32</b>	4,10	70	12	8	6	2,7	●	●	●	●	●
nr. 12	<b>28</b>	4,70	80	17	10	6	3,0	●	●	●	●	●
<b>1/4</b>	28	5,50	80	14	10	7	3,4	●	●	●	●	●
<b>5/16</b>	24	6,90	90	22	12	8	4,9	●	●	●	●	●
<b>3/8</b>	24	8,50	90	22	12	10	7,0	●	●	-	●	-



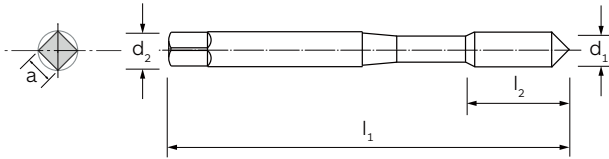
Maschi a macchina con gambo rinforzato, simile DIN 371  
Machine taps with reinforced shank, similar to DIN 371

**UNF**

**2184  
-1**

DIN

Ⓜ  
P. 632 →



MATERIALE | MATERIAL

TIPO | TYPE

RIVESTIMENTO | COATING

ANGOLO ELICA | HELIX ANGLE

DIREZIONE TAGLIO | CUTTING DIRECTION

LUBRIFICAZIONE INTERNA | INTERNAL COOLANT

TOLLERANZA | TOLERANCE

FORMA D'IMBOCCO/FILETTI | CHAMFER FORM/THREADS

TIPO DI FORO | HOLE TYPE

**P** | Acciai | Steels

**M** | Acciai inossidabili | Stainless Steels

**K** | Ghise | Cast Irons

**N** | Metalli non ferrosi | Non-ferrous metals

**S** | Leghe resistenti al calore e Titanio | HRSA and Titanium

**H** | Acciai Temprati | Hardened Steels



HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co
Rapid	Rapid	Rapid	VA	VA	HD
-	-	TiN	-	VAP	-
0°	0°	0°	0°	0°	0°
↻	↻	↻	↻	↻	↻
-	-	-	-	-	-
2B	3B	2B	2BX	2BX	2B
B/4-5	B/4-5	B/4-5	B/4-5	B/4-5	B/4-5
P	P	P	P	P	P
M	M	M	M	M	-
K	K	K	-	-	K
N	N	N	N	N	-
-	-	-	S	S	-
-	-	-	-	-	-

B  
02

GRUPPO MATERIALI  
MATERIAL GROUPS

d <sub>1</sub>	Filetti/1" Tpi		l <sub>1</sub>	l <sub>2</sub>	d <sub>2</sub> (h9)	a (h12)	6607	66073B	6607TN	6718	6718VP	6875
nr. 2	64	1,85	45	9	2,8	2,1	●	-	●	●	●	●
nr. 3	56	2,15	50	9	2,8	2,1	●	-	●	●	●	-
nr. 4	48	2,40	56	11	3,5	2,7	●	-	●	●	●	●
nr. 5	44	2,70	56	11	3,5	2,7	●	-	●	●	●	●
nr. 6	40	2,95	56	13	4,0	3,0	●	-	●	●	●	●
nr. 8	36	3,50	63	13	4,5	3,4	●	■	●	●	●	●
nr. 10	32	4,10	70	12	6,0	4,9	●	■	●	●	●	●
nr. 12	28	4,70	80	17	6,0	4,9	●	-	●	●	●	-
1/4	28	5,50	80	14	7,0	5,5	●	■	●	●	●	●
5/16	24	6,90	90	22	8,0	6,2	●	■	●	●	●	●
3/8	24	8,50	90	22	10,0	7,0	●	■	●	●	●	●



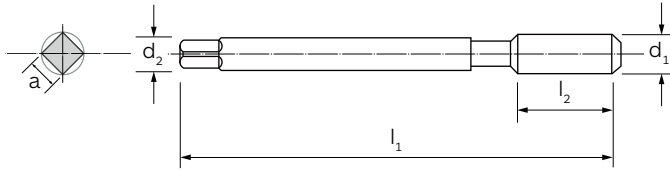


**UNF**

**2184  
-1**

DIN

Ⓜ  
P. 632 →



MATERIALE | MATERIAL

TIPO | TYPE

RIVESTIMENTO | COATING

ANGOLO ELICA | HELIX ANGLE

DIREZIONE TAGLIO | CUTTING DIRECTION

LUBRIFICAZIONE INTERNA | INTERNAL COOLANT

TOLLERANZA | TOLERANCE

FORMA D'IMBOCCO/FILETTI | CHAMFER FORM/THREADS

TIPO DI FORO | HOLE TYPE

**P** | Acciai | Steels

**M** | Acciai inossidabili | Stainless Steels

**K** | Ghise | Cast Irons

**N** | Metalli non ferrosi | Non-ferrous metals

**S** | Leghe resistenti al calore e Titanio | HRSA and Titanium

**H** | Acciai Temprati | Hardened Steels



HSS-Co	HSS-Co	HSS-Co	HSS-Co
N	N 15°	N 40°	N 40°
-	-	-	-
0°	15°	40°	40°
↻	↻	↻	↻
-	-	-	-
2B	2B	2B	3B
C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3
<b>P</b>	<b>P</b>	<b>P</b>	<b>P</b>
-	-	-	-
<b>K</b>	<b>K</b>	<b>K</b>	<b>K</b>
<b>N</b>	<b>N</b>	<b>N</b>	<b>N</b>
-	-	-	-
-	-	-	-

**B  
02**

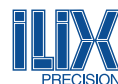
GRUPPO MATERIALI  
MATERIAL GROUPS

d <sub>1</sub>	Filetti/1" Tpi		l <sub>1</sub>	l <sub>2</sub>	l <sub>2</sub> (35-40 50°)	d <sub>2</sub> (h9)	a (h12)	6839	6729	6688	66883B
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nr. 10	32	4,45	70	16	-	6,0	4,9	-	-	-	-
5/16	24	7,40	90	22	-	8,0	6,2	-	-	-	-
3/8	24	9,00	90	22	-	10,0	7,0	-	-	-	-
7/16	20	9,90	90	20	14	8,0	6,2	●	●	●	●
1/2	20	11,50	100	22	16	9,0	7,0	●	●	●	●
9/16	18	12,90	100	22	20	11,0	9,0	●	●	●	●
5/8	18	14,50	100	22	20	12,0	9,0	●	-	●	●
3/4	16	17,50	110	25	25	14,0	11,0	●	●	●	●
7/8	14	20,40	125	25	25	18,0	14,5	●	-	●	●
1"	12	23,25	140	28	25	18,0	14,5	●	●	●	●
1 1/8	12	26,50	150	28	26	22,0	15,0	●	-	-	-
1 1/4	12	29,50	150	28	27	22,0	15,5	●	-	-	-
1 1/2	12	30,60	170	30	28	28,0	16,5	●	-	-	-

# UNF - DIN 2184/1

Maschi a macchina con gambo passante, simile DIN 374  
Machine taps with reduced shank, similar to DIN 374



HSS-Co	HSS-Co	HSS-Co	HSS-Co
VA 35°	VR 50°	HD 15°	ALU 45°
-	VAP	-	-
35°	50°	15°	45°
↻	↻	↻	↻
-	-	-	-
2B	2BX	2B	2B
C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3
P	P	P	-
M	M	-	-
-	-	K	-
N	-	-	N
S	-	-	-
-	-	-	-

MATERIALE   MATERIAL
TIPO   TYPE
RIVESTIMENTO/ TRATTAMENTO   COATING/ TREATMENT
ANGOLO ELICA   HELIX ANGLE
DIREZIONE TAGLIO   CUTTING DIRECTION
LUBRIFICAZIONE INTERNA   INTERNAL COOLANT
TOLLERANZA   TOLERANCE
FORMA D'IMBOCCO/FILETTI   CHAMFER FORM/THREADS
TIPO DI FORO   HOLE TYPE
P   Acciai   Steels
M   Acciai Inossidabili   Stainless Steels
K   Ghise   Cast Irons
N   Metalli non ferrosi   Non-ferrous metals
S   Leghe resistenti al calore e Titanio   HRSA and Titanium
H   Acciai Temprati   Hardened Steels

B  
02  
GRUPPO MATERIALI  
MATERIAL GROUPS

6796	6855VP	6849	6734	d <sub>1</sub>	Filetti/1" Tpi		l <sub>1</sub>	l <sub>2</sub> (35-40 50°)
------	--------	------	------	----------------	-------------------	--	----------------	----------------------------------

-	-	-	■	nr. 10	32	4,45	70	-
-	-	-	■	5/16	24	7,40	90	-
-	-	-	■	3/8	24	9,00	90	-
●	●	●	-	7/16	20	9,90	90	14
●	●	●	-	1/2	20	11,50	100	16
●	●	●	-	9/16	18	12,90	100	20
●	●	-	-	5/8	18	14,50	100	20
●	●	●	-	3/4	16	17,50	110	25
-	-	-	-	7/8	14	20,40	125	25
-	-	●	-	1"	12	23,25	140	25
-	-	-	-	1 1/8	12	26,50	150	26
-	-	-	-	1 1/4	12	29,50	150	27
-	-	-	-	1 1/2	12	30,60	170	28

■ Fino ad esaurimento scorte | Till stocks last

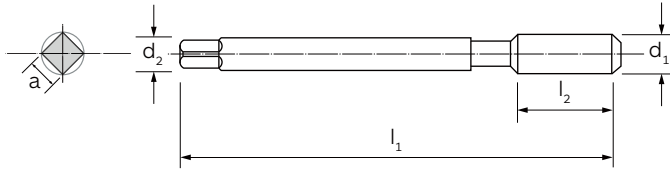
Maschi a macchina con gambo passante, simile DIN 374  
Machine taps with reduced shank, similar to DIN 374

**UNF**

**2184  
-1**

DIN

P. 632 →



MATERIALE | MATERIAL

TIPO | TYPE

RIVESTIMENTO | COATING

ANGOLO ELICA | HELIX ANGLE

DIREZIONE TAGLIO | CUTTING DIRECTION

LUBRIFICAZIONE INTERNA | INTERNAL COOLANT

TOLLERANZA | TOLERANCE

FORMA D'IMBOCCO/FILETTI | CHAMFER FORM/THREADS

TIPO DI FORO | HOLE TYPE

**P** | Acciai | Steels

**M** | Acciai inossidabili | Stainless Steels

**K** | Ghise | Cast Irons

**N** | Metalli non ferrosi | Non-ferrous metals

**S** | Leghe resistenti al calore e Titanio | HRSA and Titanium

**H** | Acciai Temprati | Hardened Steels



HSS-Co	HSS-Co	HSS-Co	HSS-Co
Rapid	Rapid	VA	HD
-	-	-	-
0°	0°	0°	0°
-	-	-	-
2B	3B	2BX	2B
B/4-5	B/4-5	B/4-5	B/4-5
<b>P</b>	<b>P</b>	<b>P</b>	<b>P</b>
<b>M</b>	<b>M</b>	<b>M</b>	-
<b>K</b>	<b>K</b>	-	<b>K</b>
<b>N</b>	<b>N</b>	<b>N</b>	-
-	-	<b>S</b>	-
-	-	-	-

**B  
02**

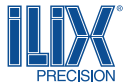
GRUPPO MATERIALI  
MATERIAL GROUPS

d <sub>1</sub>	Filetti/1" Tpi		l <sub>1</sub>	l <sub>2</sub>	d <sub>2</sub> (h9)	a (h12)	6687	66873B	6797	6876
<b>7/16</b>	20	9,90	90	20	8	6,2	●	●	●	●
<b>1/2</b>	20	11,50	100	22	9	7,0	●	●	●	●
<b>9/16</b>	18	12,90	100	22	11	9,0	●	●	-	●
<b>5/8</b>	18	14,50	100	22	12	9,0	●	●	●	●
<b>3/4</b>	16	17,50	110	25	14	11,0	●	●	●	●
<b>7/8</b>	14	20,40	125	25	18	14,5	●	●	-	●
<b>1"</b>	12	23,25	140	28	18	14,5	●	●	-	●
<b>1 1/8</b>	12	26,50	150	28	22	18,0	●	●	-	-
<b>1 1/4</b>	12	29,50	150	28	22	18,0	●	●	-	-
<b>1 3/8</b>	12	32,75	170	30	28	22,0	●	●	-	-
<b>1 1/2</b>	12	36,00	170	30	32	24,0	●	●	-	-





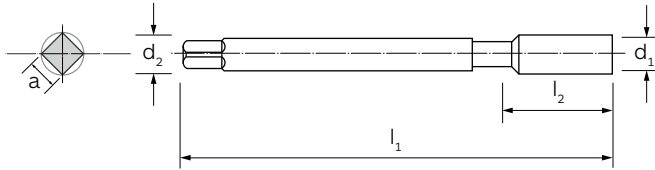
# BSW - DIN 2184-2



Maschi a mano in serie di 3 pezzi composta da sbozzatore (P), intermedio (S), finitore (T)  
Hand taps, series in set of 3 pieces, consisting of taper (P), plug (S) and bottom (T)

**BSW**  
DIN 11

**2184**  
**2**  
DIN



MATERIALE | MATERIAL

TIPO | TYPE

RIVESTIMENTO | COATING

ANGOLO ELICA | HELIX ANGLE

DIREZIONE TAGLIO | CUTTING DIRECTION

LUBRIFICAZIONE INTERNA | INTERNAL COOLANT

TOLLERANZA | TOLERANCE

FORMA D'IMBOCCO/FILETTI | CHAMFER FORM/THREADS

TIPO DI FORO | HOLE TYPE

HSS	HSS	HSS
N	N	N
-	-	-
0°	0°	0°
↻	↻	↻
-	-	-
-	-	-
A/5-6	D/3-4	C/2,5-3
P	P	P
M	M	M
K	K	K
N	N	N
S	S	S
-	-	-

GRUPPO MATERIALI  
MATERIAL GROUPS

**P** | Acciai | Steels

**M** | Acciai Inossidabili | Stainless Steels

**K** | Ghise | Cast Irons

**N** | Metalli non ferrosi | Non-ferrous metals

**S** | Leghe resistenti al calore e Titanio | HRSA and Titanium

**H** | Acciai Temprati | Hardened Steels

d <sub>1</sub>	Filetti/1" Tpi		l <sub>1</sub>	l <sub>2</sub>	d <sub>2</sub> (h9*)	a (h12)	6603P	6603S	6603T
							<b>6603</b> (Serie   Set)		

							6603P	6603S	6603T	6603
1/16	60	1,20	32	8	2,5	2,1	●	●	●	●
3/32	48	1,90	40	9	2,8	2,1	●	●	●	●
1/8	40	2,50	40	11	3,5	2,7	●	●	●	●
5/32	32	3,20	45	13	4,5	3,4	●	●	●	●
3/16	24	3,60	50	16	6,0	4,9	●	●	●	●
7/32	24	4,50	50	17	6,0	4,9	●	●	●	●
1/4	20	5,10	50	19	6,0	4,9	●	●	●	●
5/16	18	6,50	56	22	6,0	4,9	●	●	●	●
3/8	16	7,90	63	22	7,0	5,5	●	●	●	●
7/16	14	9,30	70	24	8,0	6,2	●	●	●	●
1/2	12	10,50	75	29	9,0	7,0	●	●	●	●
9/16	12	12,00	80	30	11,0	9,0	●	●	●	●
5/8	11	13,50	80	32	12,0	9,0	●	●	●	●
3/4	10	16,50	95	40	14,0	11,0	●	●	●	●
7/8	9	19,25	100	40	18,0	14,5	●	●	●	●
1"	8	22,00	110	50	18,0	14,5	●	●	●	●
1 1/8	7	24,75	125	56	22,0	18,0	●	●	●	●
1 1/4	7	28,00	125	56	22,0	18,0	●	●	●	●
1 3/8	6	30,50	150	63	28,0	22,0	●	●	●	●
1 1/2	6	33,50	150	63	32,0	24,0	●	●	●	●
1 5/8	5	35,50	150	63	32,0	24,0	●	●	●	●
1 3/4	5	39,00	160	70	36,0	29,0	●	●	●	●
2"	4,5	44,50	180	75	40,0	32,0	●	●	●	●

\* La tolleranza del gambo per il 1° e 2° maschio è h 12 | Shank tolerance of 1st and 2nd tap h 12

B  
02











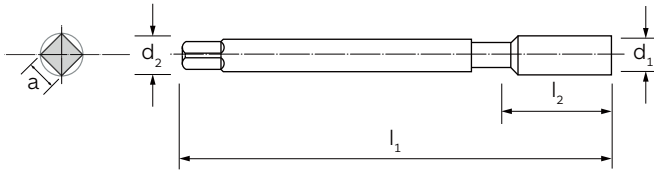
Maschi a macchina corti con gambo passante, secondo DIN 259 e DIN-ISO 228  
Short machine taps with reduced shank, as per DIN 259 e DIN-ISO 228

**G**  
(BSP)

**5157**  
DIN

P. 632 →

DIN EN ISO 228



HSS-Co	HSS-Co	HSS-Co	HSS-Co
N	N 15°	MS	VA 15°
-	-	-	-
0°	15°	0°	15°
-	-	-	-
-	-	ISO 228+0,1	-
C/2,5-3	E/1-2	E/1,5-2	E/1-2
P	P	-	P
-	-	-	M
K	K	-	-
N	N	N	N
-	-	-	S
-	-	-	-

- MATERIALE | MATERIAL
- TIPO | TYPE
- RIVESTIMENTO | COATING
- ANGOLO ELICA | HELIX ANGLE
- DIREZIONE TAGLIO | CUTTING DIRECTION
- LUBRIFICAZIONE INTERNA | INTERNAL COOLANT
- TOLLERANZA | TOLERANCE
- FORMA D'IMBOCCO/FILETTI | CHAMFER FORM/THREADS

TIPO DI FORO | HOLE TYPE

- P | Acciai | Steels
- M | Acciai inossidabili | Stainless Steels
- K | Ghise | Cast Irons
- N | Metalli non ferrosi | Non-ferrous metals
- S | Leghe resistenti al calore e Titanio | HRSA and Titanium
- H | Acciai Temprati | Hardened Steels

GRUPPO MATERIALI  
MATERIAL GROUPS

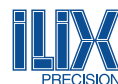
B  
02

d <sub>1</sub>	Filetti/1" Tpi		l <sub>1</sub>	l <sub>2</sub>	d <sub>2</sub> (h9)	a (h12)	6858	6905	6913	6951
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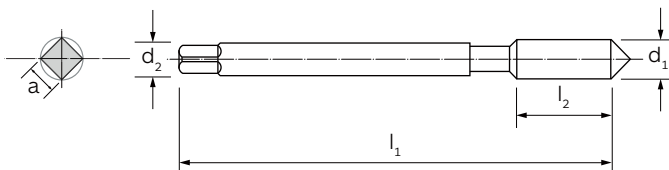
1/16	28	6,80	56	22	6	4,9	●	-	●	●
1/8	28	8,80	63	20	7	5,5	●	-	●	●
1/4	19	11,80	70	22	11	9,0	●	●	●	●
3/8	19	15,25	70	22	12	9,0	●	●	●	●
1/2	14	19,00	80	22	16	12,0	●	●	●	●
5/8	14	21,00	80	22	18	14,5	●	-	●	●
3/4	14	24,50	90	22	20	16,0	●	●	●	●
7/8	14	28,25	90	22	22	18,0	●	-	●	●
1"	11	30,75	100	25	25	20,0	●	-	●	●
1 1/8	11	35,50	125	40	28	22,0	-	-	●	-
1 1/4	11	39,50	125	40	32	24,0	●	-	●	-
1 3/8	11	42,00	125	40	36	29,0	-	-	●	-
1 1/2	11	45,00	140	40	36	29,0	-	-	●	-

# G (BSP) - DIN 5157

Maschi a macchina corti con gambo passante, secondo DIN 259 e DIN-ISO 228  
Short machine taps with reduced shank, as per DIN 259 e DIN-ISO 228



<b>G</b> (BSP)	<b>5157</b>	
DIN EN ISO 228	DIN	P. 632



MATERIALE | MATERIAL

TIPO | TYPE

RIVESTIMENTO | COATING

ANGOLO ELICA | HELIX ANGLE

DIREZIONE TAGLIO | CUTTING DIRECTION

LUBRIFICAZIONE INTERNA | INTERNAL COOLANT

TOLLERANZA | TOLERANCE

FORMA D'IMBOCCO/FILETTI | CHAMFER FORM/THREADS

TIPO DI FORO | HOLE TYPE

HSS-Co

VA

-

0°

↻

-

-

B/4-5



P

M

-

N

S

-

GRUPPO MATERIALI  
MATERIAL GROUPS

**P** | Acciai | Steels

**M** | Acciai inossidabili | Stainless Steels

**K** | Ghise | Cast Irons

**N** | Metalli non ferrosi | Non-ferrous metals

**S** | Leghe resistenti al calore e Titanio | HRSA and Titanium

**H** | Acciai Temprati | Hardened Steels

d <sub>1</sub>	Filetti/1" Tpi		l <sub>1</sub>	l <sub>2</sub>	d <sub>2</sub> (h9)	a (h12)	6857
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<b>1/16</b>	28	6,80	56	22	6	4,9	●
<b>1/8</b>	28	8,80	63	20	7	5,5	●
<b>1/4</b>	19	11,80	70	22	11	9,0	●
<b>3/8</b>	19	15,25	70	22	12	9,0	●
<b>1/2</b>	14	19,00	80	22	16	12,0	●
<b>3/4</b>	14	24,50	90	22	20	16,0	●
<b>1"</b>	11	30,75	100	25	25	20,0	●
<b>1 1/4</b>	11	39,50	125	40	32	24,0	●
<b>1 1/2</b>	11	45,00	140	40	36	29,0	●

**B  
02**



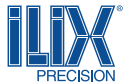






# G (BSP) - DIN 5156

Maschi a macchina con gambo passante, secondo DIN 259 e DIN-ISO 228  
Machine taps with reduced shank, as per DIN 259 e DIN-ISO 228



HSS-Co	HSS-Co	HSS-Co
VR 50°	GG	GG
VAP	NIT	TiAlN Futura
50°	0°	0°
↻	↻	↻
-	-	-
-	-	-
C/2,5-3	C/2,5-3	C/2,5-3
P	-	-
M	K	K
-	-	-
-	N	N
-	-	-
-	-	-

MATERIALE   MATERIAL
TIPO   TYPE
RIVESTIMENTO/ TRATTAMENTO   COATING/ TREATMENT
ANGOLO ELICA   HELIX ANGLE
DIREZIONE TAGLIO   CUTTING DIRECTION
LUBRIFICAZIONE INTERNA   INTERNAL COOLANT
TOLLERANZA   TOLERANCE
FORMA D'IMBOCCO/FILETTI   CHAMFER FORM/THREADS
TIPO DI FORO   HOLE TYPE
P   Acciai   Steels
M   Acciai Inossidabili   Stainless Steels
K   Ghise   Cast Irons
N   Metalli non ferrosi   Non-ferrous metals
S   Leghe resistenti al calore e Titanio   HRSA and Titanium
H   Acciai Temprati   Hardened Steels

6856VP	6708	6708TF	d <sub>1</sub>	Filetti/1" Tpi		l <sub>1</sub>	l <sub>2</sub> (35-40 50°)
-	●	●		1/16	28	6,80	12
●	●	●		1/8	28	8,80	14
●	●	●		1/4	19	11,80	20
●	●	●		3/8	19	15,25	20
●	●	●		1/2	14	19,00	25
-	●	●		5/8	14	21,00	25
●	●	●		3/4	14	24,50	28
-	●	●		7/8	14	28,25	28
●	●	●		1"	11	30,75	30
-	●	●		1 1/8	11	35,50	30
-	●	●		1 1/4	11	39,50	30
-	●	●		1 3/8	11	42,00	32
-	●	●		1 1/2	11	45,00	32
-	●	●		1 3/4	11	51,00	32
-	●	●		2"	11	57,00	36



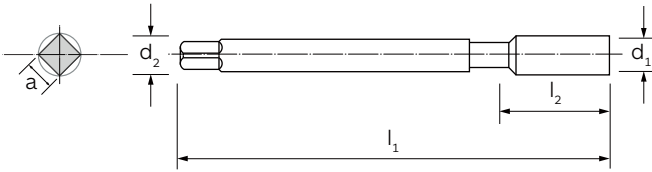
Maschi a macchina con gambo passante, secondo DIN 259 e DIN-ISO 228  
Machine taps with reduced shank, as per DIN 259 e DIN-ISO 228

**NEW**  
  
**6700XP**

**G**  
**(BSP)**  
**DIN EN ISO 228**

**5156**  
**DIN**

**P. 632 →**



<b>MATERIALE   MATERIAL</b>
<b>TIPO   TYPE</b>
<b>RIVESTIMENTO   COATING</b>
<b>ANGOLO ELICA   HELIX ANGLE</b>
<b>DIREZIONE TAGLIO   CUTTING DIRECTION</b>
<b>LUBRIFICAZIONE INTERNA   INTERNAL COOLANT</b>
<b>TOLLERANZA   TOLERANCE</b>
<b>FORMA D'IMBOCCO/FILETTI   CHAMFER FORM/THREADS</b>
<b>TIPO DI FORO   HOLE TYPE</b>
<b>P   Acciai   Steels</b>
<b>M   Acciai Inossidabili   Stainless Steels</b>
<b>K   Ghise   Cast Irons</b>
<b>N   Metalli non ferrosi   Non-ferrous metals</b>
<b>S   Leghe resistenti al calore e Titanio   HRSA and Titanium</b>
<b>H   Acciai Temprati   Hardened Steels</b>

HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co
Rapid	Rapid	Rapid	VA	VA	VA
-	VAP	TiN	-	VAP	AlCrN TOP
0°	0°	0°	0°	0°	0°
↻	↻	↻	↻	↻	↻
-	-	-	-	-	-
-	-	-	-	-	-
B/4-5	B/4-5	B/4-5	B/4-5	B/4-5	B/4-5
P	P	P	P	P	P
M	M	M	M	M	M
K	K	K	-	-	-
N	N	N	N	N	N
-	-	-	S	S	S
-	-	-	-	-	-

**B  
02**

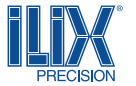
GRUPPO MATERIALI  
MATERIAL GROUPS

d <sub>1</sub>	Filetti/1" Tpi		l <sub>1</sub>	l <sub>2</sub>	d <sub>2</sub> (h9)	a (h12)	6704	6704VP	6704TN	6700	6700VP	6700XP
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1/16	28	6,80	90	22	6	4,9	-	-	-	●	●	●
1/8	28	8,80	90	20	7	5,5	●	●	●	●	●	●
1/4	19	11,80	100	22	11	9,0	●	●	●	●	●	●
3/8	19	15,25	100	22	12	9,0	●	●	●	●	●	●
1/2	14	20,10	125	25	16	12,0	●	●	●	●	●	●
5/8	14	21,00	125	25	18	14,5	●	●	●	●	●	●
3/4	14	24,50	140	28	20	16,0	●	●	●	●	●	●
7/8	14	28,25	150	28	22	18,0	●	●	●	●	●	●
1"	11	30,75	160	30	25	20,0	●	●	●	●	●	●
1 1/8	11	35,50	170	30	28	22,0	●	●	●	-	-	-
1 1/4	11	39,50	170	30	32	24,0	●	●	●	-	-	-
1 1/2	11	45,00	190	32	36	29,0	●	●	●	-	-	-
1 3/4	11	51,00	190	32	40	32,0	●	●	●	-	-	-
2"	11	57,00	220	40	45	35,0	●	●	●	-	-	-

# G (BSP) - DIN 2189

Maschi a macchina a rullare con gambo passante  
Cold forming machine taps with reduced shank

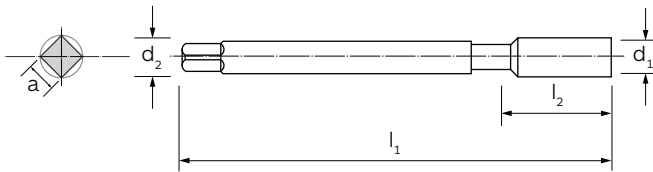


**NEW**  
**6818TN**

**G (BSP)**  
DIN EN ISO 228

**2189**  
DIN

  
**P. 650**



MATERIALE | MATERIAL

TIPO | TYPE

RIVESTIMENTO | COATING

ANGOLO ELICA | HELIX ANGLE

DIREZIONE TAGLIO | CUTTING DIRECTION

LUBRIFICAZIONE INTERNA | INTERNAL COOLANT

TOLLERANZA | TOLERANCE

FORMA D'IMBOCCO/FILETTI | CHAMFER FORM/THREADS

TIPO DI FORO | HOLE TYPE

GRUPPO MATERIALI  
MATERIAL GROUPS

**P** | Acciai | Steels

**M** | Acciai inossidabili | Stainless Steels

**K** | Ghise | Cast Irons


**N** | Metalli non ferrosi | Non-ferrous metals

**S** | Leghe resistenti al calore e Titanio | HRSA and Titanium

**H** | Acciai Temprati | Hardened Steels



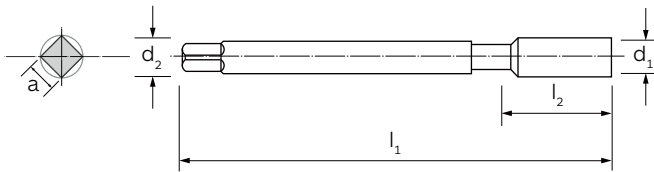
HSS-Co	HSS-Co	HSS-Co
FORMER	FORMER S	FORMER S
NIT	NIT	TiN
0°	0°	0°
-	-	-
-	-	-
B/4-5	C/2,5-3	C/2,5-3
P	P	P
M	M	M
-	-	-
N	N	N
-	-	-
-	-	-

d <sub>1</sub>	Filetti/1" Tpi		l <sub>1</sub>	l <sub>2</sub>	d <sub>2</sub> (h9)	a (h12)	6702	6818	6818TN
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<b>1/16</b>	28	6,80	90	22	6	4,9	●	-	●
<b>1/8</b>	28	8,80	90	20	7	5,5	●	-	●
<b>1/4</b>	19	11,80	100	22	11	9,0	●	-	●
<b>3/8</b>	19	15,25	100	22	12	9,0	●	■	●
<b>1/2</b>	14	20,10	125	25	16	12,0	●	-	●

■ Fino ad esaurimento scorte | Till stocks last

<b>RC</b>	<b>5156</b>	
<b>BSPT</b>	<b>DIN</b>	<b>P. 636</b>



- HSS-Co**
- N
- 
- 0°
- 
- 
- 
- C/2,5-3
- 
- P**
- 
- K**
- N**
- 
- 

- MATERIALE | MATERIAL
- TIPO | TYPE
- RIVESTIMENTO | COATING
- ANGOLO ELICA | HELIX ANGLE
- DIREZIONE TAGLIO | CUTTING DIRECTION
- LUBRIFICAZIONE INTERNA | INTERNAL COOLANT
- TOLLERANZA | TOLERANCE
- FORMA D'IMBOCCO/FILETTI | CHAMFER FORM/THREADS
- TIPO DI FORO | HOLE TYPE

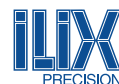
- GRUPPO MATERIALI**  
MATERIAL GROUPS
- P** | Acciai | Steels
  - M** | Acciai Inossidabili | Stainless Steels
  - K** | Ghise | Cast Irons
  - N** | Metalli non ferrosi | Non-ferrous metals
  - S** | Leghe resistenti al calore e Titanio | HRSA and Titanium
  - H** | Acciai Temprati | Hardened Steels

d <sub>1</sub>	Filetti/1" Tpi		l <sub>1</sub>	l <sub>2</sub>	d <sub>2</sub> (h9)	a (h12)	6790
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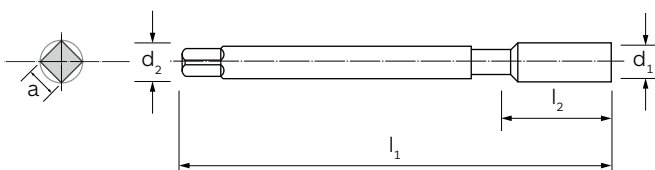
1/8	28	8,2	90	13	10	8	●
1/4	19	11,0	100	20	14	11	●
3/8	19	14,0	110	20	14	11	●
1/2	14	18,0	140	25	16	12	●
3/4	14	23,5	150	26	20	16	●
1"	11	29,5	170	32	25	20	●

# NPT/NPTF - ILIX NORM

Maschi a macchina, conicità 1:16, angolo di filettatura 60° simile DIN 2181  
Machine taps, taper 1:16, included angle 60° similar to DIN 2181



<b>NPT</b>	<b>NPTF</b>	<b>ILIX NORM</b>	
ASME B1.20.1	ANSI B1.20.3	DIN	P. 632→



HSS-Co	HSS-Co	HSS-Co
N	N	AZ/VA
-	-	-
0°	0°	0°
-	-	-
-	-	-
C/2,5-3	C/2,5-3	C/2,5-3
P	P	P
-	-	M
K	K	-
N	N	N
-	-	S
-	-	-

MATERIALE   MATERIAL
TIPO   TYPE
RIVESTIMENTO   COATING
ANGOLO ELICA   HELIX ANGLE
DIREZIONE TAGLIO   CUTTING DIRECTION
LUBRIFICAZIONE INTERNA   INTERNAL COOLANT
TOLLERANZA   TOLERANCE
FORMA D'IMBOCCO/FILETTI   CHAMFER FORM/THREADS
TIPO DI FORO   HOLE TYPE
<b>P</b>   Acciai   Steels
<b>M</b>   Acciai inossidabili   Stainless Steels
<b>K</b>   Ghise   Cast Irons
<b>N</b>   Metalli non ferrosi   Non-ferrous metals
<b>S</b>   Leghe resistenti al calore e Titanio   HRSA and Titanium
<b>H</b>   Acciai Temprati   Hardened Steels

GRUPPO MATERIALI  
MATERIAL GROUPS

d <sub>1</sub>	Filetti/1" Tpi		l <sub>1</sub>	l <sub>2</sub>	d <sub>2</sub> (h9)	a (h12)		6610	6611	6916
1/16	27	6,20	56	14	6	4,9		●	●	●
1/8	27	8,50	63	15	7	5,5		●	●	●
1/4	18	11,10	70	21	11	9,0		●	●	●
3/8	18	14,50	70	21	12	9,0		●	●	●
1/2	14	17,75	80	27	16	12,0		●	●	●
3/4	14	23,00	100	27	20	16,0		●	●	●
1"	11,5	29,00	110	32	25	20,0		●	●	-
1 1/4	11,5	38,00	125	33	32	24,0		●	●	-
1 1/2	11,5	44,00	140	33	36	29,0		●	●	-
2"	11,5	56,00	160	33	45	35,0		●	-	-

Alesatore conico per preforo NPT/NPTF vedi pag. 835 | Taper pin reamer for NPT/NPTF thread on the page 835

Maschi a macchina, conicità 1:16, angolo di filettatura 60° simile DIN 371  
Machine taps, taper 1:16, included angle 60° similar to DIN 371

**NPT**

ASME B1.20.1

**NPTF**

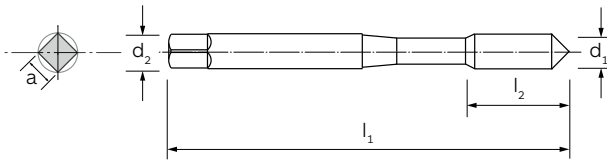
ANSI B1.20.3

**ILIX  
NORM**

DIN



P. 632 →



MATERIALE | MATERIAL

TIPO | TYPE

RIVESTIMENTO | COATING

ANGOLO ELICA | HELIX ANGLE

DIREZIONE TAGLIO | CUTTING DIRECTION

LUBRIFICAZIONE INTERNA | INTERNAL COOLANT

TOLLERANZA | TOLERANCE

FORMA D'IMBOCCO/FILETTI | CHAMFER FORM/THREADS

TIPO DI FORO | HOLE TYPE

**P** | Acciai | Steels

**M** | Acciai Inossidabili | Stainless Steels

**K** | Ghise | Cast Irons

**N** | Metalli non ferrosi | Non-ferrous metals

**S** | Leghe resistenti al calore e Titanio | HRSA and Titanium

**H** | Acciai Temprati | Hardened Steels



NPT	NPT	NPTF	NPT	NPT	NPT
HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co
HD	HD	HD	AZ	AZ 35°	AZ 35°
-	TiN	-	-	-	TiN
0°	0°	0°	0°	35°	35°
↻	↻	↻	↻	↻	↻
-	-	-	-	-	-
-	-	-	-	-	-
C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3
P	P	P	P	P	P
-	-	-	M	M	M
K	K	K	-	-	-
-	-	-	N	N	N
-	-	-	-	-	-
-	-	-	-	-	-

**B  
02**

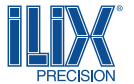
GRUPPO MATERIALI  
MATERIAL GROUPS

d <sub>1</sub>	Filetti/1" Tpi		l <sub>1</sub>	l <sub>2</sub>	d <sub>2</sub> (h9)	a (h12)	6917	6917TN	6923	6919	6921	6921TN
1/16	27	6,3	90	13	8	6,2	●	●	●	●	●	●
1/8	27	8,5	90	13	10	8,0	●	●	●	●	●	●
1/4	18	11,1	100	20	14	11,0	●	●	●	●	●	●
3/8	18	15,0	110	20	14	11,0	-	-	-	-	-	-
1/2	14	18,0	140	25	16	12,0	-	-	-	-	-	-
3/4	14	23,0	150	26	20	16,0	-	-	-	-	-	-
1"	11,5	29,0	170	32	25	20,0	-	-	-	-	-	-
1 1/4	11,5	38,0	190	34	32	24,0	-	-	-	-	-	-
1 1/2	11,5	44,0	200	34	36	29,0	-	-	-	-	-	-

Alesatore conico per preforo NPT/NPTF vedi pag. 835 | Taper pin reamer for NPT/NPTF thread on the page 835

# NPT/NPTF - ILIX NORM

Maschi a macchina, conicità 1:16, angolo di filettatura 60° simile DIN 371  
 Machine taps, taper 1:16, included angle 60° similar to DIN 371



HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co
AZ 35°	HD	HD	AZ	AZ 35°	AZ 35°
-	-	-	-	-	-
35°	0°	0°	0°	35°	35°
↻	↻	↻	↻	↻	↻
-	-	-	-	-	-
-	-	-	-	-	-
C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3	C/2,5-3
P	P	P	P	P	P
M	-	-	M	M	M
-	K	K	-	-	-
N	-	-	N	N	N
-	-	-	-	-	-
-	-	-	-	-	-

MATERIALE   MATERIAL
TIPO   TYPE
RIVESTIMENTO   COATING
ANGOLO ELICA   HELIX ANGLE
DIREZIONE TAGLIO   CUTTING DIRECTION
LUBRIFICAZIONE INTERNA   INTERNAL COOLANT
TOLLERANZA   TOLERANCE
FORMA D'IMBOCCO/FILETTI   CHAMFER FORM/THREADS
TIPO DI FORO   HOLE TYPE
<b>P</b>   Acciai   Steels
<b>M</b>   Acciai Inossidabili   Stainless Steels
<b>K</b>   Ghise   Cast Irons
<b>N</b>   Metalli non ferrosi   Non-ferrous metals
<b>S</b>   Leghe resistenti al calore e Titanio   HRSA and Titanium
<b>H</b>   Acciai Temprati   Hardened Steels

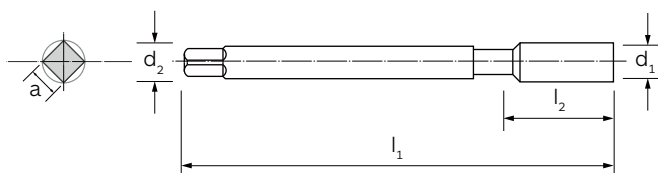
6925	6918	6924	6920	6922	6926	d <sub>1</sub>	Filetti/1" Tpi		l <sub>1</sub>	l <sub>2</sub>
●	-	-	-	-	-	<b>1/16</b>	27	6,3	90	13
●	-	-	-	-	-	<b>1/8</b>	27	8,5	90	13
●	-	-	-	-	-	<b>1/4</b>	18	11,1	100	20
-	●	●	●	●	●	<b>3/8</b>	18	15,0	110	20
-	●	●	●	●	●	<b>1/2</b>	14	18,0	140	25
-	●	●	●	●	●	<b>3/4</b>	14	23,0	150	26
-	●	●	●	●	●	<b>1"</b>	11,5	29,0	170	32
-	●	●	●	●	●	<b>1 1/4</b>	11,5	38,0	190	34
-	●	●	●	-	●	<b>1 1/2</b>	11,5	44,0	200	34

Alesatore conico per preforo NPT/NPTF vedi pag. 835 | Taper pin reamer for NPT/NPTF thread on the page 835

**B  
02**  
GRUPPO MATERIALI  
MATERIAL GROUPS

Maschi per tubi di protezione di conduttori elettrici, angolo di filettatura 80° su macchine e utensili elettrici  
Machine taps for steel conduit pipe thread, included angle 80° on machine and power tools

**PG** **40432** **P. 632** →  
DIN



HSS-Co	HSS-Co
N	Rapid
-	-
0°	0°
-	-
-	-
C/2,5-3	B/4-5
P	P
-	M
K	K
N	N
-	-
-	-

MATERIALE | MATERIAL

TIPO | TYPE

RIVESTIMENTO | COATING

ANGOLO ELICA | HELIX ANGLE

DIREZIONE TAGLIO | CUTTING DIRECTION

LUBRIFICAZIONE INTERNA | INTERNAL COOLANT

TOLLERANZA | TOLERANCE

FORMA D'IMBOCCO/FILETTI | CHAMFER FORM/THREADS

TIPO DI FORO | HOLE TYPE

P | Acciai | Steels

M | Acciai inossidabili | Stainless Steels

K | Ghise | Cast Irons

N | Metalli non ferrosi | Non-ferrous metals

S | Leghe resistenti al calore e Titanio | HRSA and Titanium

H | Acciai Temprati | Hardened Steels

GRUPPO MATERIALI  
MATERIAL GROUPS

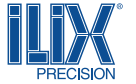
B  
02

Misura Size	d <sub>1</sub>	Filetti/1" Tpi		l <sub>1</sub>	l <sub>2</sub>	d <sub>2</sub> (h9)	a (h12)	6915	6710
7,0	12,5	20	11,50	70	22	9	7,0	●	●
9,0	15,2	18	14,00	70	22	12	9,0	●	●
11,0	18,6	18	17,25	80	22	14	11,0	●	●
13,5	20,4	18	19,00	80	22	16	12,0	●	●
16,0	22,5	18	21,25	80	22	18	14,5	●	●
21,0	28,3	16	27,00	90	22	22	18,0	●	●
29,0	37,0	16	35,50	100	25	28	22,0	●	●
36,0	47,0	16	45,50	140	40	36	29,0	●	●
42,0	54,0	16	52,50	140	40	40	32,0	●	●
48,0	59,3	16	58,00	160	40	45	35,0	●	●



# PG - DIN 40433

Maschi per tubi di protezione di conduttori elettrici, angolo di filettatura 80° su macchine e utensili elettrici  
Machine taps for steel conduit pipe thread, included angle 80° on machine and power tools



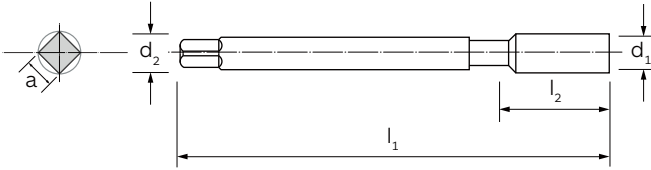
PG

40433

Ⓜ  
P. 636

DIN

P. 636

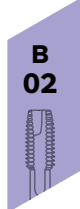


HSS-Co
N
-
0°
↻
-
-
D/4-5
P
-
K
N
-
-

MATERIALE   MATERIAL
TIPO   TYPE
RIVESTIMENTO   COATING
ANGOLO ELICA   HELIX ANGLE
DIREZIONE TAGLIO   CUTTING DIRECTION
LUBRIFICAZIONE INTERNA   INTERNAL COOLANT
TOLLERANZA   TOLERANCE
FORMA D'IMBOCCO/FILETTI   CHAMFER FORM/THREADS
TIPO DI FORO   HOLE TYPE
<b>P</b>   Acciai   Steels
<b>M</b>   Acciai Inossidabili   Stainless Steels
<b>K</b>   Ghise   Cast Irons
<b>N</b>   Metalli non ferrosi   Non-ferrous metals
<b>S</b>   Leghe resistenti al calore e Titanio   HRSA and Titanium
<b>H</b>   Acciai Temprati   Hardened Steels

GRUPPO MATERIALI  
MATERIAL GROUPS

Misura Size	d <sub>1</sub>	Filetti/1" Tpi		l <sub>1</sub>	l <sub>2</sub>	d <sub>2</sub> (h9)	a (h12)	6914
<b>7,0</b>	12,5	20	11,50	100	20	9	7,0	●
<b>9,0</b>	15,2	18	14,00	100	20	12	9,0	●
<b>11,0</b>	18,6	18	17,25	110	22	14	11,0	●
<b>13,5</b>	20,4	18	19,00	125	22	16	12,0	●
<b>16,0</b>	22,5	18	21,25	125	25	18	14,5	●
<b>21,0</b>	28,3	16	27,00	150	28	22	18,0	●
<b>29,0</b>	37,0	16	35,50	170	28	28	22,0	●
<b>36,0</b>	47,0	16	45,50	190	32	36	29,0	●

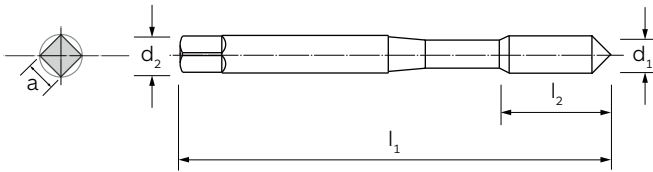


**EG (M)**

**8140**

**P. 648**

DIN



MATERIALE | MATERIAL

TIPO | TYPE

RIVESTIMENTO | COATING

ANGOLO ELICA | HELIX ANGLE

DIREZIONE TAGLIO | CUTTING DIRECTION

LUBRIFICAZIONE INTERNA | INTERNAL COOLANT

TOLLERANZA | TOLERANCE

FORMA D'IMBOCCO/FILETTI | CHAMFER FORM/THREADS

TIPO DI FORO | HOLE TYPE

**P** | Acciai | Steels

**M** | Acciai Inossidabili | Stainless Steels

**K** | Ghise | Cast Irons

**N** | Metalli non ferrosi | Non-ferrous metals

**S** | Leghe resistenti al calore e Titanio | HRSA and Titanium

**H** | Acciai Temprati | Hardened Steels

HSS-Co

N 40°

-

40°

↻

-

6H MOD.

C/2,5-3



**P**

-

**K**

**N**

-

-

GRUPPO MATERIALI  
MATERIAL GROUPS

**B  
02**

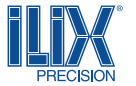


d <sub>1</sub>	P		l <sub>1</sub>	l <sub>2</sub>	d <sub>2</sub> (h9)	a (h12)	6910
----------------	---	--	----------------	----------------	------------------------	------------	------

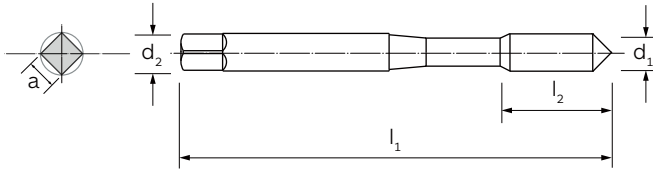
3	0,50	3,2	63	5	4,5	3,4	●
4	0,70	4,2	70	7	6,0	4,9	●
5	0,80	5,2	80	8	6,0	4,9	●
6	1,00	6,3	90	10	8,0	6,2	●
8	1,25	8,4	100	12	10,0	8,0	●

# EG (M) - DIN 8140 - Helicoil

Maschi a macchina per filetti riportati [Helicoil], simile DIN 371  
Machine taps for wire thread inserts [Helicoil], similar to DIN 371



<b>EG (M)</b>	<b>8140</b>	
	<b>DIN</b>	<b>P. 648</b>



MATERIALE | MATERIAL

TIPO | TYPE

RIVESTIMENTO | COATING

ANGOLO ELICA | HELIX ANGLE

DIREZIONE TAGLIO | CUTTING DIRECTION

LUBRIFICAZIONE INTERNA | INTERNAL COOLANT

TOLLERANZA | TOLERANCE

FORMA D'IMBOCCO/FILETTI | CHAMFER FORM/THREADS

TIPO DI FORO | HOLE TYPE

HSS-Co

N

-

0°

↻

-

6H MOD.

B/4-5



P

-

K

N

-

-

GRUPPO MATERIALI  
MATERIAL GROUPS

**P** | Acciai | Steels

**M** | Acciai Inossidabili | Stainless Steels

**K** | Ghise | Cast Irons

**N** | Metalli non ferrosi | Non-ferrous metals

**S** | Leghe resistenti al calore e Titanio | HRSA and Titanium

**H** | Acciai Temprati | Hardened Steels

d <sub>1</sub>	P		l <sub>1</sub>	l <sub>2</sub>	d <sub>2</sub> (h9)	a (h12)	6908
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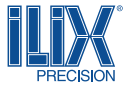
3	0,50	3,2	63	10	4,5	3,4	●
4	0,70	4,2	70	12	6,0	4,9	●
5	0,80	5,2	80	13	6,0	4,9	●
6	1,00	6,3	90	17	8,0	6,2	●
8	1,25	8,4	100	18	10,0	8,0	●

**B  
02**

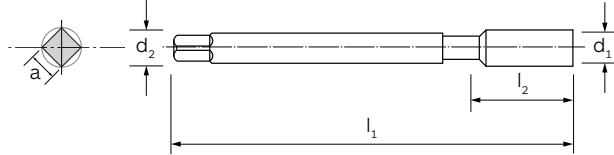


# EG (M) - DIN 8140 - Helicoil

Maschi a macchina per filetti riportati [Helicoil], simile DIN 376  
Machine taps for wire thread inserts [Helicoil], similar to DIN 376



<b>EG (M)</b>	<b>8140</b>	
	<b>DIN</b>	<b>P. 648</b>



- HSS-Co
- N
- 
- 0°
- ↻
- 
- 6H MOD.
- B/4-5
- 
- P
- 
- K
- N
- 
- 

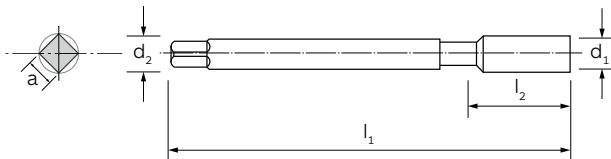
<b>GRUPPO MATERIALI</b> MATERIAL GROUPS	<b>P</b>   Acciai   Steels
	<b>M</b>   Acciai Inossidabili   Stainless Steels
	<b>K</b>   Ghise   Cast Irons
	<b>N</b>   Metalli non ferrosi   Non-ferrous metals
	<b>S</b>   Leghe resistenti al calore e Titanio   HRSA and Titanium
	<b>H</b>   Acciai Temprati   Hardened Steels

$d_1$	P		$l_1$	$l_2$	$d_2$ (h9)	a (h12)	6909
10	1,50	10,5	100	22	9	7	●
12	1,75	12,5	110	26	11	9	●
16	2,00	16,5	125	20	14	11	●

**B 02**

Maschi a mano trapezoidali in serie di 3 pezzi composta da sbozzatore (P), intermedio (S), finitore (T)  
Trapezoidal Hand taps, series in set of 3 pieces, consisting of taper (P), plug (S) and bottom (T)

**TR** **103**  
**DIN**



HSS-Co	HSS-Co	HSS-Co
N	N	N
-	-	-
0°	0°	0°
↻	↻	↻
-	-	-
7H	7H	7H
A/5-6	D/3-4	C/2,5-3
P	P	P
-	-	-
K	K	K
N	N	N
-	-	-
-	-	-

MATERIALE   MATERIAL
TIPO   TYPE
RIVESTIMENTO   COATING
ANGOLO ELICA   HELIX ANGLE
DIREZIONE TAGLIO   CUTTING DIRECTION
LUBRIFICAZIONE INTERNA   INTERNAL COOLANT
TOLLERANZA   TOLERANCE
FORMA D'IMBOCCO/FILETTI   CHAMFER FORM/THREADS
TIPO DI FORO   HOLE TYPE

<b>P</b>   Acciai   Steels
<b>M</b>   Acciai Inossidabili   Stainless Steels
<b>K</b>   Ghise   Cast Irons
<b>N</b>   Metalli non ferrosi   Non-ferrous metals
<b>S</b>   Leghe resistenti al calore e Titanio   HRSA and Titanium
<b>H</b>   Acciai Temprati   Hardened Steels

B  
02

GRUPPO MATERIALI  
MATERIAL GROUPS

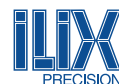
d <sub>1</sub>	P		l <sub>1</sub>	l <sub>2</sub>	d <sub>2</sub> (h9)	a (h12)	6937P	6937S	6937T
							<b>6937</b> (Serie   Set)		

d <sub>1</sub>	P		l <sub>1</sub>	l <sub>2</sub>	d <sub>2</sub> (h9)	a (h12)	6937P	6937S	6937T	6937
10	2	8,20	110	70	7,1	5,6	●	-	●	●
12	3	9,25	160	102	8,0	6,3	●	-	●	●
14	3	11,25	160	102	9,0	7,1	●	-	●	●
16	4	12,25	220	136	11,2	9,0	●	-	●	●
18	4	14,25	220	136	12,5	10,0	●	-	●	●
20	4	16,25	220	136	14,0	11,2	●	■	●	●
22	5	17,25	275	166	16,0	12,5	●	-	●	●
24	5	19,25	275	166	16,0	12,5	●	-	●	●
26	5	21,25	290	170	18,0	14,0	●	-	●	●
28	5	23,25	290	170	18,0	14,0	●	-	●	●
30	6	24,25	345	200	22,4	18,0	●	-	●	●

■ Fino ad esaurimento scorte | Till stocks last

# TR - DIN 103

Maschi a macchina trapezoidali | Trapezoidal machine taps



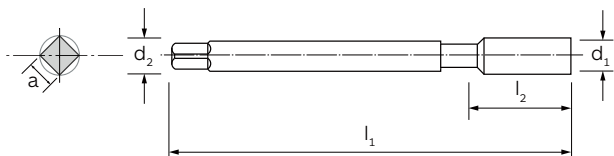
TR

103

III

P. 632 →

DIN



MATERIALE | MATERIAL

TIPO | TYPE

RIVESTIMENTO | COATING

ANGOLO ELICA | HELIX ANGLE

DIREZIONE TAGLIO | CUTTING DIRECTION

LUBRIFICAZIONE INTERNA | INTERNAL COOLANT

TOLLERANZA | TOLERANCE

FORMA D'IMBOCCO/FILETTI | CHAMFER FORM/THREADS

TIPO DI FORO | HOLE TYPE

GRUPPO MATERIALI  
MATERIAL GROUPS

**P** | Acciai | Steels

**M** | Acciai inossidabili | Stainless Steels

**K** | Ghise | Cast Irons

**N** | Metalli non ferrosi | Non-ferrous metals

**S** | Leghe resistenti al calore e Titanio | HRSA and Titanium

**H** | Acciai Temprati | Hardened Steels

HSS-Co	HSS-Co
N	N SX
-	-
0°	0°
↻	↻
-	-
7H	7H
2/3 x l <sub>2</sub>	2/3 x l <sub>2</sub>
P	P
-	-
K	K
N	N
-	-
-	-

**B  
02**

d <sub>1</sub>	P		l <sub>1</sub>	l <sub>2</sub>	d <sub>2</sub> (h9)	a (h12)		6938	6939
10	2	8,20	116	76	7,1	5,6		●	●
12	2	10,20	126	76	8,0	6,3		●	●
12	3	9,25	175	115	8,0	6,3		●	●
14	2	12,20	126	76	9,0	7,1		●	●
14	3	11,25	175	115	9,0	7,1		●	●
16	4	12,25	235	150	11,2	9,0		●	●
18	4	14,25	235	150	12,5	10,0		●	●
20	4	16,25	235	150	14,0	11,2		●	●
22	5	17,25	290	180	16,0	12,5		●	●
24	5	19,25	290	180	16,0	12,5		●	●
26	5	21,25	300	180	18,0	14,0		●	●
28	5	23,25	300	180	18,0	14,0		●	●
30	6	24,25	380	235	22,4	18,0		●	●
32	6	26,25	380	235	22,4	18,0		●	●
34	6	28,25	390	240	25,0	20,0		●	●
36	6	30,25	390	240	25,0	20,0		●	●

In fase di ordinazione specificare sempre il Ø (d<sub>1</sub>) e il passo (P) | When ordering, please state Ø (d1) and pitch (P)



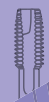


**MASCHI TRADIZIONALI**  
**TAPS**

**B.02.03**

**Parametri di taglio**  
Cutting data

**B  
02**



Profondità di filettatura Threading depth	Profili di filettatura   Threading profiles												
	M	MF	UNC	UNF	Pg 8-UN	G (BSP)	Rp (BSPP)	Rc (BSPT)	BSW	NPT	NPTF		

► **RAPID (Maschi a macchina corti | Short machine taps)**

≤1.5 xD		6679	-	-	-	-	-	-	-	-	-	-
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► **N (Maschi a macchina corti | Short machine taps)**

≤1.5 xD		6678	6899	-	-	-	6858	-	-	-	-	-
		6659	6656	-	-	-	-	-	-	-	-	-
		6639	-	-	-	-	-	-	-	-	-	-
		6604	-	-	-	-	-	-	-	-	-	-
		66046G	-	-	-	-	-	-	-	-	-	-
		-	-	-	-	-	6905	-	-	-	-	-

► **VA (Maschi a macchina corti | Short machine taps)**

≤1.5 xD		-	-	-	-	-	6857	-	-	-	-	-
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► **VA 15° (Maschi a macchina corti | Short machine taps)**

≤1.5 xD		6648	-	-	-	-	-	-	-	-	-	-
		6612	-	-	-	-	6951	-	-	-	-	-

► **MS (Maschi a macchina corti | Short machine taps)**

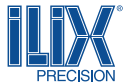
≤1.5 xD		6624	-	-	-	-	6913	-	-	-	-	-
		6724	-	-	-	-	-	-	-	-	-	-

► **AZ (Maschi a macchina corti | Short machine taps)**

≤1.5 xD		6621	-	-	-	-	-	-	-	-	-	-
		6613	-	-	-	-	-	-	-	-	-	-

B  
02

# PARAMETRI DI TAGLIO | CUTTING DATA



Maschi Tradizionali | Taps

Acciaio debole/mente legato Low-Alloyed Steel <800 N/mm <sup>2</sup>	Acciaio mediamente legato Medium-Alloyed Steel 700/1000 N/mm <sup>2</sup>	Acciaio fortemente legato High-Alloyed Steel 1000/1300 N/mm <sup>2</sup>	Acciaio inossidabile Martensitico/Ferritico Stainless steel Martensitic/Ferritic	Acciaio inossidabile Austenitico Stainless steel Austenitic	Ghisa grigia Grey cast iron	Ghisa sferoidale Nodular cast iron	Alluminio e leghe di Alluminio Aluminum and Aluminum alloys	Materiali non ferrosi Non ferrous materials	Titanio e leghe di Titanio Titanium and Titanium alloys	HPSA Leghe resistenti al calore Heat resistant alloys	Acciai temprati Hardened steels 38/48 HRC	Acciai temprati Hardened steels 48/58 HRC	Acciai temprati Hardened steels 58/68 HRC
P1	P2	P3	M1	M2	K1	K2	N1	N2	S1	S2	H1	H2	H3

V<sub>c</sub>: velocità di taglio (m/min) | cutting speed (m/min)

13	8	5	5	-	8	4	13	8	-	-	-	-	-
-	9	5	-	-	9	-	13	9	-	-	-	-	-
-	9	5	-	-	9	-	13	9	-	-	-	-	-
-	9	5	-	-	9	-	13	9	-	-	-	-	-
-	9	5	-	-	9	-	13	9	-	-	-	-	-
-	9	5	-	-	9	-	13	9	-	-	-	-	-
13	-	-	5	4	-	-	-	9	2	1	-	-	-
13	-	-	5	4	-	-	-	9	2	1	-	-	-
13	-	-	5	4	-	-	-	9	2	1	-	-	-
-	-	-	-	-	-	-	-	9	-	-	-	-	-
-	-	-	-	-	-	-	-	9	-	-	-	-	-
13	-	-	5	-	-	-	13	9	-	-	-	-	-
13	-	-	5	-	-	-	13	9	-	-	-	-	-

► I parametri di taglio indicati in tabella sono da considerarsi validi in condizioni macchina/pezzo ottimali  
The cutting parameters shown in the table have to be considered valid in optimal machine/workpiece conditions



Profondità di filettatura Threading depth	Profili di filettatura   Threading profiles											
	M	MF	UNC	UNF	Pg 8-UN	G (BSP)	Rp (BSPP)	Rc (BSPT)	BSW	NPT	NPTF	

► **RAPID** (Maschi a macchina | Machine taps)

≤2.0 xD		6707 67076G 67074H 67077G	-	6690 66903B	6607 66073B	-	-	-	-	6697	-	-
		6707TN	-	6690TN	6607TN	-	-	-	-	-	-	-
		6707TC	-	-	-	-	-	-	-	-	-	-
		6707VP	-	-	-	-	-	-	-	-	-	-
		6711 67116G 67117G	6730	6693 66933B	6687 66873B	-	6704	6673	-	6636	-	-
		6711TN	6730TN	-	-	-	6704TN	-	-	-	-	-
		6711TC	6730TC	-	-	-	-	-	-	-	-	-
		6711VP	6730VP	-	-	-	6704VP	-	-	-	-	-
		-	-	-	-	6710	-	-	-	-	-	-

► **RAPID 2** (Maschi a macchina | Machine taps)

≤2.0 xD		6640 66406G	-	-	-	-	-	-	-	-	-	-
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► **N** (Maschi a macchina | Machine taps)

≤2.0 xD		6706	-	6823	6838	-	-	-	-	6699	-	-
		6706TN	-	-	-	-	-	-	-	-	-	-
		6706TC	-	-	-	-	-	-	-	-	-	-
		6705	6726	6824	6839	-	-	-	-	-	-	-
		6705TN	6726TN	-	-	-	-	-	-	-	-	-

# PARAMETRI DI TAGLIO | CUTTING DATA

Maschi Tradizionali | Taps

Acciaio debole/mente legato Low-Alloyed Steel <800 N/mm <sup>2</sup>	Acciaio mediamente legato Medium-Alloyed Steel 700/1000 N/mm <sup>2</sup>	Acciaio fortemente legato High-Alloyed Steel 1000/1300 N/mm <sup>2</sup>	Acciaio inossidabile Martensitico/Ferritico Stainless steel Martensitic/Ferritic	Acciaio inossidabile Austenitico Stainless steel Austenitic	Ghisa grigia Grey cast iron	Ghisa sferoidale Nodular cast iron	Alluminio e leghe di Alluminio Aluminum and Aluminum alloys	Materiali non ferrosi Non ferrous materials	Titanio e leghe di Titanio Titanium and Titanium alloys	HPSA Leghe resistenti al calore Heat resistant alloys	Acciai temprati Hardened steels 38/48 HRC	Acciai temprati Hardened steels 48/58 HRC	Acciai temprati Hardened steels 58/68 HRC
P1	P2	P3	M1	M2	K1	K2	N1	N2	S1	S2	H1	H2	H3

V<sub>c</sub>: velocità di taglio (m/min) | cutting speed (m/min)

15	10	6	6	-	10	5	15	10	-	-	-	-	-
18	13	8	10	7	13	8	20	15	-	-	-	-	-
18	13	8	10	7	13	8	20	15	-	-	-	-	-
15	10	6	6	-	10	5	15	10	-	-	-	-	-
15	10	6	6	-	10	5	15	10	-	-	-	-	-
18	13	8	10	7	13	8	20	15	-	-	-	-	-
18	13	8	10	7	13	8	20	15	-	-	-	-	-
15	10	6	6	-	10	5	15	10	-	-	-	-	-
15	10	6	6	-	10	5	15	10	-	-	-	-	-
-	-	-	-	-	-	-	15	13	-	-	-	-	-
15	10	6	-	-	10	-	15	10	-	-	-	-	-
18	13	8	-	-	13	-	20	15	-	-	-	-	-
18	13	8	-	-	13	-	20	15	-	-	-	-	-
15	10	6	-	-	10	-	15	10	-	-	-	-	-
18	13	8	-	-	13	-	20	15	-	-	-	-	-



► I parametri di taglio indicati in tabella sono da considerarsi validi in condizioni macchina/pezzo ottimali  
The cutting parameters shown in the table have to be considered valid in optimal machine/workpiece conditions

Profondità di filettatura Threading depth	Profili di filettatura   Threading profiles												
	M	MF	UNC	UNF	Pg 8-UN	G (BSP)	Rp (BSPP)	Rc (BSPT)	BSW	NPT	NPTF		

► **N (Maschi a macchina | Machine taps)**

≤2.0 xD		6705TC	6726TC	-	-	-	-	-	-	-	-	-	-
		-	-	-	-	-	-	-	-	-	6610	6611	-
		-	-	-	-	-	-	6790	-	-	-	-	-
		-	-	-	-	6915	-	-	-	-	-	-	-
		-	-	-	-	6914	-	-	-	-	-	-	-

► **N SX (Maschi a macchina | Machine taps)**

≤2.0 xD		6712	-	-	-	-	-	-	-	-	-	-	-
		6859	-	-	-	-	-	-	-	-	-	-	-
		6715	-	-	-	-	-	-	-	-	-	-	-
		6860	6863	-	-	-	-	-	-	-	-	-	-

► **NL 15° (Maschi a macchina | Machine taps)**

≤1.5 xD		6727	-	-	-	-	-	-	-	-	-	-	-
		6740	6741	-	-	-	-	-	-	-	-	-	-

► **N 15° (Maschi a macchina | Machine taps)**

≤1.5 xD		6657	-	6696	6719	-	-	-	-	-	-	-	-
		66576G	-	-	-	-	-	-	-	-	-	-	-
		6902	-	-	-	-	-	-	-	-	-	-	-
		6657TN	-	-	-	-	-	-	-	-	-	-	-
		6657TC	-	-	-	-	-	-	-	-	-	-	-
		6658	6664	6728	6729	-	6665	6675	-	-	-	-	-
		6658TN	6664TN	-	-	-	-	-	-	-	-	-	-
	6658TC	6664TC	-	-	-	-	-	-	-	-	-	-	
	-	6904	-	-	-	-	-	-	-	-	-	-	

# PARAMETRI DI TAGLIO | CUTTING DATA

Maschi Tradizionali | Taps

Acciaio debole/mente legato Low-Alloyed Steel <800 N/mm <sup>2</sup>	Acciaio mediamente legato Medium-Alloyed Steel 700/1000 N/mm <sup>2</sup>	Acciaio fortemente legato High-Alloyed Steel 1000/1300 N/mm <sup>2</sup>	Acciaio inossidabile Martensitico/Ferritico Stainless steel Martensitic/Ferritic	Acciaio inossidabile Austenitico Stainless steel Austenitic	Ghisa grigia Grey cast iron	Ghisa sferoidale Nodular cast iron	Alluminio e leghe di Alluminio Aluminum and Aluminum alloys	Materiali non ferrosi Non ferrous materials	Titanio e leghe di Titanio Titanium and Titanium alloys	HPSA Leghe resistenti al calore Heat resistant alloys	Acciai temprati Hardened steels 38/48 HRC	Acciai temprati Hardened steels 48/58 HRC	Acciai temprati Hardened steels 58/68 HRC
P1	P2	P3	M1	M2	K1	K2	N1	N2	S1	S2	H1	H2	H3

V<sub>c</sub>: velocità di taglio (m/min) | cutting speed (m/min)

18	13	8	-	-	13	-	20	15	-	-	-	-	-
15	10	6	-	-	10	-	15	10	-	-	-	-	-
15	10	6	-	-	10	-	15	10	-	-	-	-	-
15	10	6	-	-	10	-	15	10	-	-	-	-	-
15	10	6	-	-	10	-	15	10	-	-	-	-	-
15	10	6	-	-	10	-	15	10	-	-	-	-	-
15	10	6	-	-	10	-	15	10	-	-	-	-	-
15	10	6	-	-	10	-	15	10	-	-	-	-	-
15	10	6	-	-	10	5	15	10	-	-	-	-	-
18	13	8	8	5	13	8	20	15	-	-	-	-	-
18	13	8	8	5	13	8	20	15	-	-	-	-	-
15	10	6	-	-	10	5	15	10	-	-	-	-	-
18	13	8	8	5	13	8	20	15	-	-	-	-	-
18	13	8	8	5	13	8	20	15	-	-	-	-	-
15	10	6	-	-	10	5	15	10	-	-	-	-	-

B  
02

► I parametri di taglio indicati in tabella sono da considerarsi validi in condizioni macchina/pezzo ottimali  
The cutting parameters shown in the table have to be considered valid in optimal machine/workpiece conditions

Profondità di filettatura Threading depth	Profili di filettatura   Threading profiles											
	M	MF	UNC	UNF	Pg 8-UN	G (BSP)	Rp (BSPP)	Rc (BSPT)	BSW	NPT	NPTF	

► **N 15° (Maschi a macchina | Machine taps)**

≤1.5 xD		6658TC	6664TC	-	-	-	-	-	-	-	-	-
		-	6904	-	-	-	-	-	-	-	-	-

► **N 40° (Maschi a macchina | Machine taps)**

≤2.5 xD		6644 66446G 66447G	-	6691 66913B	6680 66803B	-	-	-	-	6836	-	-
		6644TN	-	6691TN	6680TN	-	-	-	-	-	-	-
		6644TC	-	-	-	-	-	-	-	-	-	-
		6644VP	-	-	-	-	-	-	-	-	-	-
≤2.5 xD		6638 66386G 66387G	6652	6694 66943B	6688 66883B	-	6703	-	-	6837	-	-
		6638TN	6652TN	-	-	-	6703TN	-	-	-	-	-
		6638TC	6652TC	-	-	-	6703VP	-	-	-	-	-
		6638VP	6652VP	-	-	-	-	-	-	-	-	-
		6867	-	-	-	-	-	-	-	-	-	-
		6868	6877	-	-	-	-	-	-	-	-	-

► **N SX 40° (Maschi a macchina | Machine taps)**

≤2.5 xD		6861	-	-	-	-	-	-	-	-	-	-
		6862	6864	-	-	-	-	-	-	-	-	-

► **VA (Maschi a macchina | Machine taps)**

≤2.0 xD		6646 66466G	-	6739	6718	-	-	-	-	-	-	-
		6647 66476G	6663 66636G	6749	6797	-	6700	-	-	-	-	-



# PARAMETRI DI TAGLIO | CUTTING DATA

Maschi Tradizionali | Taps

Acciaio debolmente legato Low-Alloyed Steel <800 N/mm <sup>2</sup>	Acciaio mediamente legato Medium-Alloyed Steel 700/1000 N/mm <sup>2</sup>	Acciaio fortemente legato High-Alloyed Steel 1000/1300 N/mm <sup>2</sup>	Acciaio inossidabile Martensitico/Ferritico Stainless steel Martensitic/Ferritic	Acciaio inossidabile Austenitico Stainless steel Austenitic	Ghisa grigia Grey cast iron	Ghisa sferoidale Nodular cast iron	Alluminio e leghe di Alluminio Aluminum and Aluminum alloys	Materiali non ferrosi Non ferrous materials	Titanio e leghe di Titanio Titanium and Titanium alloys	HPSA Leghe resistenti al calore Heat resistant alloys	Acciai temprati Hardened steels 38/48 HRC	Acciai temprati Hardened steels 48/58 HRC	Acciai temprati Hardened steels 58/68 HRC
P1	P2	P3	M1	M2	K1	K2	N1	N2	S1	S2	H1	H2	H3

V<sub>c</sub>: velocità di taglio (m/min) | cutting speed (m/min)

18	13	8	8	5	13	8	20	15	-	-	-	-	-
15	10	6	-	-	10	5	15	10	-	-	-	-	-
15	10	6	-	-	10	5	15	10	-	-	-	-	-
18	13	8	8	5	13	8	20	15	-	-	-	-	-
18	13	8	8	5	13	8	20	15	-	-	-	-	-
15	10	6	-	-	10	5	15	10	-	-	-	-	-
15	10	6	-	-	10	5	15	10	-	-	-	-	-
18	13	8	8	5	13	8	20	15	-	-	-	-	-
18	13	8	8	5	13	8	20	15	-	-	-	-	-
15	10	6	-	-	10	5	15	10	-	-	-	-	-
15	10	6	-	-	10	5	15	10	-	-	-	-	-
15	10	6	-	-	10	5	15	10	-	-	-	-	-
15	10	6	-	-	10	5	15	10	-	-	-	-	-
15	10	6	-	-	10	5	15	10	-	-	-	-	-
15	-	-	6	5	-	-	-	10	3	2	-	-	-
15	-	-	6	5	-	-	-	10	3	2	-	-	-

► I parametri di taglio indicati in tabella sono da considerarsi validi in condizioni macchina/pezzo ottimali  
The cutting parameters shown in the table have to be considered valid in optimal machine/workpiece conditions



Profondità di filettatura Threading depth	Profili di filettatura   Threading profiles											
	M	MF	UNC	UNF	Pg 8-UN	G (BSP)	Rp (BSPP)	Rc (BSPT)	BSW	NPT	NPTF	

► **VA (Maschi a macchina | Machine taps)**

≤2.0 xD		6646TN	-	-	-	-	-	-	-	-	-	-
		-	6663TN	-	-	-	-	-	-	-	-	-
		6646XP	-	6739XP	-	-	-	-	-	-	-	-
		6647XP	6663XP	-	-	-	6700XP	-	-	-	-	-
		6646VP	-	6739VP	6718VP	-	-	-	-	-	-	-
		6647VP	6663VP	6749VP	-	-	6700VP	-	-	-	-	-

► **VA 15° (Maschi a macchina | Machine taps)**

≤1.5 xD		6654	-	-	-	-	-	-	-	-	-	-
		-	6671	-	-	-	6716	-	-	-	-	-
		6654XP	-	-	-	-	-	-	-	-	-	-
		6654VP	-	-	-	-	-	-	-	-	-	-
		6634VP	-	-	-	-	-	-	-	-	-	-

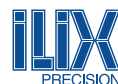
► **VA i 15° (Maschi a macchina | Machine taps)**

≤2.5 xD		6620XP	-	-	-	-	-	-	-	-	-	-
		6605XP	6626XP	-	-	-	-	-	-	-	-	-

► **VA 35° (Maschi a macchina | Machine taps)**

≤2.0 xD		-	6655	6754	6796	-	6701	-	-	-	-	-
		-	66556G	-	-	-	-	-	-	-	-	-
		-	-	6735	6794	-	-	-	-	-	-	-
		-	6655XP	-	-	-	6701XP	-	-	-	-	-
		-	6655VP	6754VP	-	6945VP	6701VP	-	-	-	-	-
		-	-	6735VP	6794VP	-	-	-	-	-	-	-

# PARAMETRI DI TAGLIO | CUTTING DATA



Maschi Tradizionali | Taps

Acciaio debole/mente legato Low-Alloyed Steel <800 N/mm <sup>2</sup>	Acciaio mediamente legato Medium-Alloyed Steel 700/1000 N/mm <sup>2</sup>	Acciaio fortemente legato High-Alloyed Steel 1000/1300 N/mm <sup>2</sup>	Acciaio inossidabile Martensitico/Ferritico Stainless steel Martensitic/Ferritic	Acciaio inossidabile Austenitico Stainless steel Austenitic	Ghisa grigia Grey cast iron	Ghisa sferoidale Nodular cast iron	Alluminio e leghe di Alluminio Aluminum and Aluminum alloys	Materiali non ferrosi Non ferrous materials	Titanio e leghe di Titanio Titanium and Titanium alloys	HPSA Leghe resistenti al calore Heat resistant alloys	Acciai temprati Hardened steels 38/48 HRC	Acciai temprati Hardened steels 48/58 HRC	Acciai temprati Hardened steels 58/68 HRC
P1	P2	P3	M1	M2	K1	K2	N1	N2	S1	S2	H1	H2	H3

V<sub>c</sub>: velocità di taglio (m/min) | cutting speed (m/min)

18	-	-	10	7	-	-	-	15	5	4	-	-	-
18	-	-	10	7	-	-	-	15	5	4	-	-	-
18	-	-	10	7	-	-	-	15	5	4	-	-	-
18	-	-	10	7	-	-	-	15	5	4	-	-	-
15	-	-	6	5	-	-	-	10	3	2	-	-	-
15	-	-	6	5	-	-	-	10	3	2	-	-	-

13	-	-	10	8	-	-	-	11	3	2	-	-	-
13	-	-	10	8	-	-	-	11	3	2	-	-	-
15	-	-	12	10	-	-	-	13	5	4	-	-	-
13	-	-	10	8	-	-	-	11	3	2	-	-	-
15	-	-	12	10	-	-	-	13	5	4	-	-	-

17	15	-	15	10	-	-	-	15	6	5	-	-	-
17	15	-	15	10	-	-	-	15	6	5	-	-	-

13	-	-	10	8	-	-	-	11	3	2	-	-	-
13	-	-	10	8	-	-	-	11	3	2	-	-	-
15	-	-	12	8	-	-	-	13	5	4	-	-	-
13	-	-	10	8	-	-	-	11	3	2	-	-	-
13	-	-	10	8	-	-	-	11	3	2	-	-	-
13	-	-	10	8	-	-	-	11	3	2	-	-	-

► I parametri di taglio indicati in tabella sono da considerarsi validi in condizioni macchina/pezzo ottimali  
The cutting parameters shown in the table have to be considered valid in optimal machine/workpiece conditions



Profondità di filettatura Threading depth	Profili di filettatura   Threading profiles											
	M	MF	UNC	UNF	Pg 8-UN	G (BSP)	Rp (BSPP)	Rc (BSPT)	BSW	NPT	NPTF	

► **VR 35° (Maschi a macchina | Machine taps)**

≤2.0 xD	VR 35° (Maschi a macchina   Machine taps)											
	6661 66616G	6662 66626G	6661TN	6661XP	6662XP	6662VP	6661VP					
								-	-	-	-	-

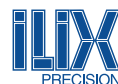
► **VR 50° (Maschi a macchina | Machine taps)**

≤3.0 xD	VR 50° (Maschi a macchina   Machine taps)											
	6850TN	6851TN	6850VP	6851VP	6852VP	6854VP	6853VP	6855VP	6856VP			
										-	-	-

► **HD (Maschi a macchina | Machine taps)**

≤2.0 xD	HD (Maschi a macchina   Machine taps)											
	6870	6871	6870TF	6871TF	6872TF	6873	6874	6875	6876	6912TN	6917TN	6923

# PARAMETRI DI TAGLIO | CUTTING DATA



Maschi Tradizionali | Taps

Acciaio debole/mente legato Low-Alloyed Steel <800 N/mm <sup>2</sup>	Acciaio mediamente legato Medium-Alloyed Steel 700/1000 N/mm <sup>2</sup>	Acciaio fortemente legato High-Alloyed Steel 1000/1300 N/mm <sup>2</sup>	Acciaio inossidabile Martensitico/Ferritico Stainless steel Martensitic/Ferritic	Acciaio inossidabile Austenitico Stainless steel Austenitic	Ghisa grigia Grey cast iron	Ghisa sferoidale Nodular cast iron	Alluminio e leghe di Alluminio Aluminum and Aluminum alloys	Materiali non ferrosi Non ferrous materials	Titanio e leghe di Titanio Titanium and Titanium alloys	HPSA Leghe resistenti al calore Heat resistant alloys	Acciai temprati Hardened steels 38/48 HRC	Acciai temprati Hardened steels 48/58 HRC	Acciai temprati Hardened steels 58/68 HRC
P1	P2	P3	M1	M2	K1	K2	N1	N2	S1	S2	H1	H2	H3

V<sub>c</sub>: velocità di taglio (m/min) | cutting speed (m/min)

13	-	-	10	8	-	-	-	-	-	-	-	-	-
13	-	-	10	8	-	-	-	-	-	-	-	-	-
15	-	-	12	8	-	-	-	-	-	-	-	-	-
15	-	-	12	8	-	-	-	-	-	-	-	-	-
15	-	-	12	8	-	-	-	-	-	-	-	-	-
13	-	-	10	8	-	-	-	-	-	-	-	-	-
13	-	-	10	8	-	-	-	-	-	-	-	-	-
13	-	-	10	8	-	-	-	-	-	-	-	-	-
13	-	-	10	8	-	-	-	-	-	-	-	-	-
15	-	-	12	10	-	-	-	-	-	-	-	-	-
15	-	-	12	10	-	-	-	-	-	-	-	-	-
15	10	6	-	-	-	10	-	-	-	-	-	-	-
15	10	6	-	-	-	10	-	-	-	-	-	-	-
15	10	6	-	-	-	10	-	-	-	-	-	-	-
15	10	6	-	-	-	10	-	-	-	-	-	-	-
18	13	8	-	-	-	10	-	-	-	-	-	-	-
18	13	8	-	-	-	10	-	-	-	-	-	-	-
18	13	8	-	-	-	10	-	-	-	-	-	-	-
18	13	8	-	-	-	10	-	-	-	-	-	-	-



► I parametri di taglio indicati in tabella sono da considerarsi validi in condizioni macchina/pezzo ottimali  
The cutting parameters shown in the table have to be considered valid in optimal machine/workpiece conditions

Profondità di filettatura Threading depth	Profili di filettatura   Threading profiles											
	M	MF	UNC	UNF	Pg 8-UN	G (BSP)	Rp (BSPP)	Rc (BSPT)	BSW	NPT	NPTF	

► **HD 15° (Maschi a macchina | Machine taps)**

≤1.5 xD		6878	-	6865	6848	-	-	-	-	-	-	-
		6879	6880	6866	6849	-	-	-	-	-	-	-
		6878HL	-	-	-	-	-	-	-	-	-	-
		6879HL	6880HL	-	-	-	-	-	-	-	-	-

► **HD 40° (Maschi a macchina | Machine taps)**

≤2.5 xD		6666 6666G 66664H	-	-	-	-	-	-	-	-	-	-
		6667	-	-	-	-	-	-	-	-	-	-
		6666TF	-	-	-	-	-	-	-	-	-	-
		6667TF	-	-	-	-	-	-	-	-	-	-
		6667TN	-	-	-	-	-	-	-	-	-	-

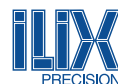
► **HR 40° (Maschi a macchina | Machine taps)**

≤2.5 xD		6681	-	-	-	-	-	-	-	-	-	-
		6689	-	-	-	-	-	-	-	-	-	-
		6681TF	-	-	-	-	-	-	-	-	-	-
		6689TF	-	-	-	-	-	-	-	-	-	-

► **GG (Maschi a macchina | Machine taps)**

≤2.5 xD		6631TF	-	-	-	-	-	-	-	-	-	-
		6632TF	-	-	-	-	6708TF	-	-	-	-	-
		6631	-	-	-	-	-	-	-	-	-	-
		6632	6653	-	-	-	6708	6674	-	-	-	-

# PARAMETRI DI TAGLIO | CUTTING DATA

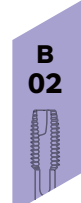


Maschi Tradizionali | Taps

Acciaio debolmente legato Low-Alloyed Steel <800 N/mm <sup>2</sup>	Acciaio mediamente legato Medium-Alloyed Steel 700/1000 N/mm <sup>2</sup>	Acciaio fortemente legato High-Alloyed Steel 1000/1300 N/mm <sup>2</sup>	Acciaio inossidabile Martensitico/Ferritico Stainless steel Martensitic/Ferritic	Acciaio inossidabile Austenitico Stainless steel Austenitic	Ghisa grigia Grey cast iron	Ghisa sferoidale Nodular cast iron	Alluminio e leghe di Alluminio Aluminum and Aluminum alloys	Materiali non ferrosi Non ferrous materials	Titanio e leghe di Titanio Titanium and Titanium alloys	HPSA Leghe resistenti al calore Heat resistant alloys	Acciai temprati Hardened steels 38/48 HRC	Acciai temprati Hardened steels 48/58 HRC	Acciai temprati Hardened steels 58/68 HRC
P1	P2	P3	M1	M2	K1	K2	N1	N2	S1	S2	H1	H2	H3

V<sub>c</sub>: velocità di taglio (m/min) | cutting speed (m/min)

13	10	6	-	-	-	10	-	-	-	-	-	-	-
13	10	6	-	-	-	10	-	-	-	-	-	-	-
15	12	8	-	-	-	10	-	-	-	-	-	-	-
15	12	8	-	-	-	10	-	-	-	-	-	-	-
13	10	6	-	-	-	10	-	-	-	-	-	-	-
13	10	6	-	-	-	10	-	-	-	-	-	-	-
15	12	8	-	-	-	10	-	-	-	-	-	-	-
15	12	8	-	-	-	10	-	-	-	-	-	-	-
15	12	8	-	-	-	10	-	-	-	-	-	-	-
13	10	8	-	-	-	-	-	-	-	-	-	-	-
13	10	8	-	-	-	-	-	-	-	-	-	-	-
15	12	10	-	-	-	-	-	-	-	-	-	-	-
15	12	10	-	-	-	-	-	-	-	-	-	-	-
-	-	-	-	-	30	25	25	-	-	-	-	-	-
-	-	-	-	-	30	25	25	-	-	-	-	-	-
-	-	-	-	-	25	20	25	-	-	-	-	-	-
-	-	-	-	-	25	20	25	-	-	-	-	-	-



► I parametri di taglio indicati in tabella sono da considerarsi validi in condizioni macchina/pezzo ottimali  
The cutting parameters shown in the table have to be considered valid in optimal machine/workpiece conditions

Profondità di filettatura Threading depth	Profili di filettatura   Threading profiles												
	M	MF	UNC	UNF	Pg 8-UN	G (BSP)	Rp (BSPP)	Rc (BSPT)	BSW	NPT	NPTF		

► **MULTI GG I (Maschi a macchina | Machine taps)**

≤2.5 xD		6629TC	-	-	-	-	-	-	-	-	-	-
		6637TC	-	-	-	-	-	-	-	-	-	-
		6637	-	-	-	-	-	-	-	-	-	-
		6629	-	-	-	-	-	-	-	-	-	-

► **AZ (Maschi a macchina | Machine taps)**

≤2.5 xD		6820	-	-	-	-	-	-	-	-	-	-
		6616	-	-	-	-	-	-	-	-	-	-
		6821	-	-	-	-	-	-	-	6919	6920	-
		6617	-	-	-	-	-	-	-	-	-	-
		-	-	-	-	-	-	-	-	6916	-	-

► **AZ 35° (Maschi a macchina | Machine taps)**

≤2.5 xD		-	-	-	-	-	-	-	-	6921	6925	-
		-	-	-	-	-	-	-	-	6922	6926	-
		-	-	-	-	-	-	-	-	6921TN	-	-

► **ALU (Maschi a macchina | Machine taps)**

≤2.5 xD		6641	-	-	-	-	-	-	-	-	-	-
		6642	-	-	-	-	-	-	-	-	-	-

► **ALU 45° (Maschi a macchina | Machine taps)**

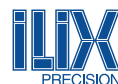
≤2.5 xD		6643	-	6732	6628	-	-	-	-	-	-	-
		6651	6731	6733	6734	-	-	-	-	-	-	-

► **BAK (Maschi a macchina | Machine taps)**

≤2.5 xD		6670	-	-	-	-	-	-	-	-	-	-
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# PARAMETRI DI TAGLIO | CUTTING DATA



Maschi Tradizionali | Taps

<b>Acciaio debolmente legato</b> Low-Alloyed Steel <b>&lt;800 N/mm²</b>	<b>Acciaio mediamente legato</b> Medium-Alloyed Steel <b>700/1000 N/mm²</b>	<b>Acciaio fortemente legato</b> High-Alloyed Steel <b>1000/1300 N/mm²</b>	<b>Acciaio inossidabile</b> Martensitico/Ferritico Stainless steel Martensitic/Ferritic	<b>Acciaio inossidabile</b> Austenitico Stainless steel Austenitic	<b>Ghisa grigia</b> Grey cast iron	<b>Ghisa sferoidale</b> Nodular cast iron	<b>Alluminio e leghe di Alluminio</b> Aluminum and Aluminum alloys	<b>Materiali non ferrosi</b> Non ferrous materials	<b>Titanio e leghe di Titanio</b> Titanium and Titanium alloys	<b>HPSA</b> Leghe resistenti al calore Heat resistant alloys	<b>Acciai temprati</b> Hardened steels <b>38/48 HRC</b>	<b>Acciai temprati</b> Hardened steels <b>48/58 HRC</b>	<b>Acciai temprati</b> Hardened steels <b>58/68 HRC</b>
<b>P1</b>	<b>P2</b>	<b>P3</b>	<b>M1</b>	<b>M2</b>	<b>K1</b>	<b>K2</b>	<b>N1</b>	<b>N2</b>	<b>S1</b>	<b>S2</b>	<b>H1</b>	<b>H2</b>	<b>H3</b>

**V<sub>c</sub>: velocità di taglio (m/min) | cutting speed (m/min)**

-	-	-	-	-	<b>35</b>	<b>30</b>	30	-	-	-	-	-	-
-	-	-	-	-	<b>35</b>	<b>30</b>	30	-	-	-	-	-	-
-	-	-	-	-	<b>32</b>	<b>27</b>	30	-	-	-	-	-	-
-	-	-	-	-	<b>32</b>	<b>27</b>	30	-	-	-	-	-	-
15	-	-	6	-	-	-	<b>15</b>	<b>10</b>	-	-	-	-	-
15	-	-	6	-	-	-	<b>15</b>	<b>10</b>	-	-	-	-	-
15	-	-	6	-	-	-	<b>15</b>	<b>10</b>	-	-	-	-	-
15	-	-	6	-	-	-	<b>15</b>	<b>10</b>	-	-	-	-	-
15	-	-	6	-	-	-	<b>15</b>	<b>10</b>	-	-	-	-	-
15	-	-	6	-	-	-	<b>15</b>	<b>10</b>	-	-	-	-	-
15	-	-	6	-	-	-	<b>15</b>	<b>10</b>	-	-	-	-	-
15	-	-	6	-	-	-	<b>15</b>	<b>10</b>	-	-	-	-	-
18	-	-	10	-	-	-	<b>20</b>	<b>15</b>	-	-	-	-	-
-	-	-	-	-	-	-	<b>25</b>	<b>15</b>	-	-	-	-	-
-	-	-	-	-	-	-	<b>25</b>	<b>15</b>	-	-	-	-	-
-	-	-	-	-	-	-	<b>25</b>	<b>15</b>	-	-	-	-	-
-	-	-	-	-	-	-	<b>25</b>	<b>15</b>	-	-	-	-	-
-	-	-	-	-	-	-	-	<b>15</b>	-	-	-	-	-



► I parametri di taglio indicati in tabella sono da considerarsi validi in condizioni macchina/pezzo ottimali  
The cutting parameters shown in the table have to be considered valid in optimal machine/workpiece conditions

Profondità di filettatura Threading depth	Profili di filettatura   Threading profiles												
	M	MF	UNC	UNF	Pg 8-UN	G (BSP)	Rp (BSPP)	Rc (BSPT)	BSW	NPT	NPTF		

▶ **ULTRA (Maschi a macchina | Machine taps)**

≤1.0 xD		6606 66066G	-	-	-	-	-	-	-	-	-	-
		-	-	6737	-	-	-	-	-	-	-	-

▶ **ULTRA S (Maschi a macchina | Machine taps)**

≤1.5 xD		6649 66496G	-	-	-	-	-	-	-	-	-	-
		6649TN	-	-	-	-	-	-	-	-	-	-

▶ **EG (M) (Maschi a macchina per filetti riportati [Helicoil] | Machine taps for wire thread inserts [Helicoil])**

≤2.0 xD		6908	-	-	-	-	-	-	-	-	-	-
		6909	-	-	-	-	-	-	-	-	-	-

▶ **EG (M) 40° (Maschi a macchina per filetti riportati [Helicoil] | Machine taps for wire thread inserts [Helicoil])**

≤2.0 xD		6910	-	-	-	-	-	-	-	-	-	-
		6911	-	-	-	-	-	-	-	-	-	-

▶ **N (Maschi a macchina con gambo lungo | Machine taps with long shank)**

≤3.0 xD		6672	-	-	-	-	-	-	-	-	-	-
------------	--	------	---	---	---	---	---	---	---	---	---	---

▶ **N (Maschi a macchina con gambo extra lungo | Machine taps with extra long shank)**

≤3.0 xD		6692	-	-	-	-	-	-	-	-	-	-
		6695	-	-	-	-	-	-	-	-	-	-

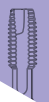
▶ **N 30° (Maschi a macchina con gambo extra lungo | Machine taps with extra long shank)**

≤3.0 xD		6840	-	-	-	-	-	-	-	-	-	-
		6841	-	-	-	-	-	-	-	-	-	-

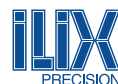
▶ **N 40° (Maschi a macchina per dadi | Machine nut taps)**

≤3.0 xD		6660	-	-	-	-	-	-	-	-	-	-
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B  
02



# PARAMETRI DI TAGLIO | CUTTING DATA

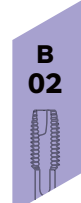


Maschi Tradizionali | Taps

Acciaio debolmente legato Low-Alloyed Steel <800 N/mm <sup>2</sup>	Acciaio mediamente legato Medium-Alloyed Steel 700/1000 N/mm <sup>2</sup>	Acciaio fortemente legato High-Alloyed Steel 1000/1300 N/mm <sup>2</sup>	Acciaio inossidabile Martensitico/Ferritico Stainless steel Martensitic/Ferritic	Acciaio inossidabile Austenitico Stainless steel Austenitic	Ghisa grigia Grey cast iron	Ghisa sferoidale Nodular cast iron	Alluminio e leghe di Alluminio Aluminum and Aluminum alloys	Materiali non ferrosi Non ferrous materials	Titanio e leghe di Titanio Titanium and Titanium alloys	HPSA Leghe resistenti al calore Heat resistant alloys	Acciai temprati Hardened steels 38/48 HRC	Acciai temprati Hardened steels 48/58 HRC	Acciai temprati Hardened steels 58/68 HRC
P1	P2	P3	M1	M2	K1	K2	N1	N2	S1	S2	H1	H2	H3

V<sub>c</sub>: velocità di taglio (m/min) | cutting speed (m/min)

15	-	-	12	-	-	-	20	-	-	-	-	-	-
15	-	-	12	-	-	-	20	-	-	-	-	-	-
15	-	-	12	-	-	-	20	-	-	-	-	-	-
18	-	-	15	-	-	-	25	-	-	-	-	-	-
15	8	5	-	-	-	-	18	12	-	-	-	-	-
15	8	5	-	-	-	-	18	12	-	-	-	-	-
15	8	5	-	-	-	-	18	12	-	-	-	-	-
15	8	5	-	-	-	-	18	12	-	-	-	-	-
-	7	4	-	-	7	-	10	7	-	-	-	-	-
-	7	4	-	-	7	-	10	7	-	-	-	-	-
-	7	4	-	-	7	-	10	7	-	-	-	-	-
10	7	4	-	-	7	5	10	7	-	-	-	-	-
10	7	4	-	-	7	5	10	7	-	-	-	-	-
10	7	4	-	-	7	5	10	7	-	-	-	-	-



► I parametri di taglio indicati in tabella sono da considerarsi validi in condizioni macchina/pezzo ottimali  
The cutting parameters shown in the table have to be considered valid in optimal machine/workpiece conditions

Profondità di filettatura Threading depth	Profili di filettatura   Threading profiles											
	M	MF	UNC	UNF	TR	G (BSP)	Rp (BSPP)	Rc (BSPT)	BSW	NPT	NPTF	

► **TR (Maschi a macchina trapezoidali | Trapezoidal machine taps)**

≤1.5 xD		-	-	-	-	6938	-	-	-	-	-	-
		-	-	-	-	6939	-	-	-	-	-	-

► **FORMER (Maschi a macchina a rullare | Cold forming machine taps)**

≤2.0 xD		6722BL 6622BL	-	-	-	-	-	-	-	-	-	-
		6722TF	-	-	-	-	-	-	-	-	-	-
		6722TN 6622TN	-	-	-	-	-	-	-	-	-	-
		6722 6622	-	6738	6747	-	-	-	-	-	-	-
≤2.0 xD		6723TN 6623TN	-	-	-	-	-	-	-	-	-	-
		6723 6623	6721 67216G	-	-	-	6702	-	-	-	-	-

► **FORMER S (Maschi a macchina a rullare con canali di lubrificazione | Cold forming machine taps with coolant groove)**

≤2.0 xD		6808BL	-	-	-	-	-	-	-	-	-	-
		6709TF	-	-	-	-	-	-	-	-	-	-
		6709TN 6808TN 6815TN	-	-	-	-	-	-	-	-	-	-
≤2.0 xD		6709 6808 6819	-	6802	6815	-	-	-	-	-	-	-
		6725 6809	6720 67206G	-	6816	-	6818	-	-	-	-	-
		6725TN 6809TN 6811TN	-	-	6816TN	-	6818TN	-	-	-	-	-

# PARAMETRI DI TAGLIO | CUTTING DATA

Maschi Tradizionali | Taps

<b>Acciaio debole/mente legato</b> Low-Alloyed Steel <800 N/mm <sup>2</sup>	<b>Acciaio mediamente legato</b> Medium-Alloyed Steel 700/1000 N/mm <sup>2</sup>	<b>Acciaio fortemente legato</b> High-Alloyed Steel 1000/1300 N/mm <sup>2</sup>	<b>Acciaio inossidabile</b> Martensitico/Ferritico Stainless steel Martensitic/Ferritic	<b>Acciaio inossidabile</b> Austenitico Stainless steel Austenitic	<b>Ghisa grigia</b> Grey cast iron	<b>Ghisa sferoidale</b> Nodular cast iron	<b>Alluminio e leghe di Alluminio</b> Aluminum and Aluminum alloys	<b>Materiali non ferrosi</b> Non ferrous materials	<b>Titanio e leghe di Titanio</b> Titanium and Titanium alloys	<b>HPSA</b> Leghe resistenti al calore Heat resistant alloys	<b>Acciai temprati</b> Hardened steels 38/48 HRC	<b>Acciai temprati</b> Hardened steels 48/58 HRC	<b>Acciai temprati</b> Hardened steels 58/68 HRC
<b>P1</b>	<b>P2</b>	<b>P3</b>	<b>M1</b>	<b>M2</b>	<b>K1</b>	<b>K2</b>	<b>N1</b>	<b>N2</b>	<b>S1</b>	<b>S2</b>	<b>H1</b>	<b>H2</b>	<b>H3</b>

**V<sub>c</sub>: velocità di taglio (m/min) | cutting speed (m/min)**

<b>15</b>	<b>10</b>	<b>6</b>	-	-	10	5	<b>15</b>	<b>10</b>	-	-	-	-	-
<b>15</b>	<b>10</b>	<b>6</b>	-	-	10	5	<b>15</b>	<b>10</b>	-	-	-	-	-
<b>13</b>	<b>11</b>	-	<b>8</b>	-	-	-	<b>20</b>	<b>18</b>	-	-	-	-	-
<b>15</b>	<b>13</b>	-	<b>10</b>	-	-	-	<b>25</b>	<b>22</b>	-	-	-	-	-
<b>15</b>	<b>13</b>	-	<b>10</b>	-	-	-	<b>25</b>	<b>22</b>	-	-	-	-	-
<b>13</b>	<b>11</b>	-	<b>8</b>	-	-	-	<b>20</b>	<b>18</b>	-	-	-	-	-
<b>15</b>	<b>13</b>	-	<b>10</b>	-	-	-	<b>25</b>	<b>22</b>	-	-	-	-	-
<b>13</b>	<b>11</b>	-	<b>8</b>	-	-	-	<b>20</b>	<b>18</b>	-	-	-	-	-
<b>15</b>	<b>13</b>	-	<b>10</b>	-	-	-	<b>25</b>	<b>22</b>	-	-	-	-	-
<b>17</b>	<b>15</b>	-	<b>12</b>	-	-	-	<b>30</b>	<b>25</b>	-	-	-	-	-
<b>17</b>	<b>15</b>	-	<b>12</b>	-	-	-	<b>30</b>	<b>25</b>	-	-	-	-	-
<b>15</b>	<b>13</b>	-	<b>10</b>	-	-	-	<b>25</b>	<b>22</b>	-	-	-	-	-
<b>15</b>	<b>13</b>	-	<b>10</b>	-	-	-	<b>25</b>	<b>22</b>	-	-	-	-	-
<b>17</b>	<b>15</b>	-	<b>12</b>	-	-	-	<b>30</b>	<b>25</b>	-	-	-	-	-



► I parametri di taglio indicati in tabella sono da considerarsi validi in condizioni macchina/pezzo ottimali  
The cutting parameters shown in the table have to be considered valid in optimal machine/workpiece conditions