MACHINE TAPS WITH COLOURED RING
MASCHI A MACCHINA CON COLLARINI COLORATI

		Form B/A/C	39°RSP	TwinBox
●	for general use per uso universale	138	139	153
PM	for general use per uso universale	140	141	
●	for wear resistant steel Acciaio resistente all'abrasione	142	143	154
○	for stainless steel Acciaio inossidabile	144	146	155
●	for cast iron Ghisa grigia	148		
●	Material from 1200 N/mm2 tensile strength Materiali con resistenza alla trazione da 1.200 N/mm²	151		
●	for aluminium alloys Alluminio	149		
●	for brass Ottone	150		

VÖLKEL THREADING SOLUTIONS

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

Material **Materiali**	Cutting Speed Velocita di taglio V= m/min	coolants and lubrications Refrigerazione e lubrificante
Unalloyed steels, tensile strength < 800 N/mm² Acciai non legati, resistenza alla trazione < 800 N/mm²	10 - 18	drilling oil emulsion, cutting oil also with lubricity-increasing additives Emulsione, Olio da taglio con additivi che aumentano la lubrificazione
Machining steels, case hardening steels, tempered steels Acciai automatici, acciai da cementazione, acciai bonificati	10 - 18	
Unalloyed steels, tensile strength < 1000 N/mm² Acciai non legati, resistenza alla trazione < 1000 N/mm²	6 - 10	
Unalloyed and alloyed steels, tensile strength < 1200 N/mm² Acciai legati e non legati, resistenza alla trazione < 1200 N/mm²	3 - 5	thread cutting oil, cutting oil highly activated with special additives, solid lubricants Olio da taglio per maschiatura, Olio da taglio con additivi lubrificanti solidi
Unalloyed and alloyed steels, tensile strength > 1200 N/mm² Acciai legati e non legati, resistenza alla trazione > 1200 N/mm²	2 - 4	
Stainless and acid-resistant steels; VA-steels < 850 N/mm² Acciai inossidabili <850 N / mm²	2 - 4	
Rust- and acid-resistant steels with high chromium-nickel content, V4A steels Acciai inossidabili con alto contenuto in Cromo-Nickel, Acciai V4A	2 - 4	
Gray cast iron Ghisa grigia	8 - 16	thread cutting oil, special thread cutting oil and emulsion Olio da taglio per maschiatura ed emulsione
Graphite cast iron, malleable cast iron Ghisa sferoidale etemprata	8 - 16	
Copper alloys short chipping Leghe di rame, ottone a truciolo corto	18 - 24	thread cutting oil, emulsion Olio da taglio maschiatura, emulsione
Long-chipping brass Ottone a truciolo lungo	12 - 18	
Aluminium, magnesium, unalloyed Alluminio, Magnesio, non legato	20 - 30	thread cutting oil for non-ferrous metals, emulsion, petroleum Olio da taglio per maschiatura per metalli non ferrosi Emulsione, Petrolio
Aluminium alloys, Si < 0,5% Leghe di alluminio, Si < 0,5%	18 - 24	
Aluminium alloys, Si 0,5 - 10% Leghe di alluminio, Si 0,5 - 10%	14 - 18	
Aluminium alloys, Si > 10% Leghe di alluminio, Si > 10%	8 - 10	
Titanium alloys Leghe di titanio	2 - 4	oil, special thread cutting oil Olio, o da taglio speciale per maschiatura
Thermoplastics Termoplastiche	18 - 24	mold release oil, dry, oil mist, compressed air, emulsion Olio di distacco dallo stampo, secco, Olio nebulizzato, secco, aria compressa, emulsione
Thermosetting and fibre-reinforced plastics Duroplaste e plastica rinforzata con fibre	8 - 12	

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

Material **Materiali**	Green Ring collarino verde	Green Ring PM collarino verde PM	Blue Ring collarino blu	White Ring collarino bianco	Black Ring collarino nero	Yellow Ring collarino giallo	Orange Ring collarino arancion	Red Ring collarino rosso
Unalloyed steels, tensile strength < 800 N/mm² Acciai non legati, resistenza alla trazione < 800 N/mm²	●	PM						
Machining steels, case hardening steels, tempered steels Acciai automatici, acciai da cementazione, acciai bonificati	●	PM	●	○				
Unalloyed steels, tensile strength < 1000 N/mm² Acciai non legati, resistenza alla trazione < 1000 N/mm²	●	PM	●					
Unalloyed and alloyed steels, tensile strength < 1200 N/mm² Acciai legati e non legati, resistenza alla trazione < 1200 N/mm²		PM	●					○
Unalloyed and alloyed steels, tensile strength > 1200 N/mm² Acciai legati e non legati, resistenza alla trazione > 1200 N/mm²								●
Stainless and acid-resistant steels; VA-steels < 850 N/mm² Acciai inossidabili <850 N / mm²		PM	○	○				
Rust- and acid-resistant steels with high chromium-nickel content, V4A steels Acciai inossidabili con alto contenuto in Cromo-Nickel, Acciai V4A			●	○				
Gray cast iron Ghisa grigia					●			
Graphite cast iron, malleable cast iron Ghisa sferoidale etemprata	●	PM	●					
Copper alloys short chipping Leghe di rame, ottone a truciolo corto					○		●	
Long-chipping brass Ottone a truciolo lungo	○	PM						
Aluminium, magnesium, unalloyed Alluminio, Magnesio, non legato						●		
Aluminium alloys, Si < 0,5% Leghe di alluminio, Si < 0,5%			○			●		
Aluminium alloys, Si 0,5 - 10% Leghe di alluminio, Si 0,5 - 10%	○	PM	●			○		
Aluminium alloys, Si > 10% Leghe di alluminio, Si > 10%			●					
Titanium alloys Leghe di titanio			○	○				
Thermoplastics Termoplastiche	●	PM						
Thermosetting and fibre-reinforced plastics Duroplaste e plastica rinforzata con fibre			○		●			●

● = appropiate / idoneitá ottimale ○ = conditionally suitable / idoneitá limitata

Material No.	DIN	AISI	AFNOR	JIS	tensile strength N/mm² min.	tensile strength N/mm² max.	recommendation 1	recommendation 2
1.0044	St 44-2	A 570:Gr.40	E-28-2	SM 41 B	410	560	Standard Form A-C-B-RSP	Green Ring
1.0060	St 60-2			SM 570	600	720	Standard Form A-C-B-RSP	Green Ring
1.0070	St 70-2				670	830	Standard Form A-C-B-RSP	Green Ring
1.0116	St 37-3	A 573;Gr.58	E 24-3;E 24-4		370	450	Standard Form A-C-B-RSP	Green Ring
1.0570	St 52-3		E 36-3;E 36-4	SM 50 YA	450	680	Standard Form A-C-B-RSP	Green Ring
1.0301	C 10	1010	AF 34 C 10	S 10 C	490	780	Standard Form A-C-B-RSP	Green Ring
1.0402	C 22	1020	AF 42 C 20		470	650	Standard Form A-C-B-RSP	Green Ring
1.0501	C 35	1035	AF 55 C 35		550	780	Standard Form A-C-B-RSP	Green Ring
1.0511	C 40	1040	AF 60 C 40		600	800	Standard Form A-C-B-RSP	Green Ring
1.0711	9S 20	1112		SUM 21	370	450	Green Ring	Standard Form B-RSP
1.0715	9SMn 28	1213	S 250	SUM 22	390	580	Green Ring	Standard Form B-RSP
1.0718	9SMnPb 28	12L13	S 250 Pb	SUM 22 L	380	810	Green Ring	Standard Form B-RSP
1.0726	35S 20	1140	35 MF 6		510	880	Green Ring	Standard Form B-RSP
1.0736	9SMn 36	1215	S 300		390	800	Green Ring	Standard Form B-RSP
1.0737	9SMnPb 36	12L14	S 300 Pb		390	800	Green Ring	Standard Form B-RSP
1.0712	13Cr 3				500	800	Green Ring	Standard Form B-RSP
1.1121	Ck 10	1010	XC 10	S 10 C	450	630	Green Ring	Standard Form B-RSP
1.1141	Ck 15	1015	XC 15;XC 18	S 15C;S 15 CK	450	630	Green Ring	Standard Form B-RSP
1.7131	16MnCr 5	5115	16 MC 5	SCR 415	500	700	Green Ring	Standard Form B-RSP
1.1151	Ck 22	1023	XC 25;XC 18	S 20 C; S 20 CK	470	650	Green Ring	Standard Form B-RSP
1.1158	Ck 25	1025	XC 25	S 25 C	500	700	Green Ring	Standard Form B-RSP
1.1183	Cf 35				540	780	Green Ring	Standard Form B-RSP
1.1191	Ck 45	1045	XC 42	S 45 C	650	850	Green Ring PM	Green Ring
1.1203	Ck 55	1055	XC 55	S 55 C	700	950	Green Ring PM	Green Ring
1.1213	Cf 53		XC 48 TS		650	800	Green Ring PM	Green Ring
1.1221	Ck 60	1060	XC 60	S 58 C	750	1000	Green Ring PM	Green Ring
1.5752	14NiCr 14 (ECN 35)	3310;9314	12 NC 15	SNC 815 (H)	880	1000	Green Ring PM	Green Ring
1.0401	C 15	1015	AF 34 C 12		600	900	Green Ring PM	Green Ring
1.0503	C 45	1045	AF 65 C 45	S 45 C	650	850	Green Ring PM	Green Ring
1.0535	C 55	1055			700	950	Green Ring PM	Green Ring
1.0601	C 60	1060	CC 55		750	1000	Green Ring PM	Green Ring
1.1157	40Mn 4	1039	35 M 5		800	1000	Green Ring PM	Green Ring
1.1181	Ck 35	1035	XC 38 H1;XC 32	S 35 C	550	780	Green Ring PM	Green Ring
1.6582	35CrNiMo 6	4340	35 NCD 6	SNCM 447	800	1000	Green Ring PM	Green Ring
1.7015	15Cr 3	5015	12 C 3	SCR 415 (H)	690	1000	Green Ring PM	Green Ring
1.7033	34Cr 4	5132	32 C 4	SCr 430 (H)	700	1000	Green Ring PM	Green Ring
1.7035	41Cr 4	5140	32 C 4	SCr 440 (H)	800	1000	Green Ring PM	Green Ring
1.7218	25CrMo 4	4130	25 CD 4 S	SCM 420;SCM 430	800	1000	Green Ring PM	Green Ring
1.7223	41CrMo 4	4142;4140	42 CD 4 TS	SCM 440	800	1000	Green Ring PM	Green Ring
1.7225	42CrMo 4	4142;4140	42 CD 4 TS	SCM 440	800	1000	Green Ring PM	Green Ring
1.7361	32CrMo 12		30 CD 12		690	1000	Green Ring PM	Green Ring
1.6582	35CrNiMo 6	4340	35 NCD 6	SNCM 447	1000	1200	Blue Ring	
1.8515	31 CrMo 12		30 CD 12		1000	1200	Blue Ring	
1.8519	31CrMo V 9				1000	1250	Blue Ring	
1.8523	39CrMoV 13 9				1000	1200	Blue Ring	
1.1157	40Mn 4	1039	35 M 5		1000	1100	Blue Ring	
1.6580	30CrNiMo 8		30 CND 8	SNCM 431	1000	1200	Blue Ring	
1.7218	25CrMo 4	4130	25 CD 4 S	SCM 420;SCM 430	1000	1100	Blue Ring	
1.7223	41CrMo 4	4142;4140	42 CD 4 TS	SCM 440	1000	1200	Blue Ring	
1.7225	42CrMo 4 V	4142;4140	42 CD 4 TS	SCM 440	1000	1200	Blue Ring	
1.2080	X210Cr 12	D 3	Z 200 C 12	SKD 1	830	830	Blue Ring	
1.2210	115CrV 3	L 2	100 C 3		730	730	Blue Ring	
1.2363	X100CrMoV 5 1	A 2	Z 100 CDV 5	SKD 12	760	760	Blue Ring	
1.2436	X210CRW 12			SKD 2	760	760	Blue Ring	
1.2510	100MnCrW 4	O 1	90 MWCV 5		720	720	Blue Ring	
1.2601	X165CrMoV 12		Z 160 CDV 12		760	760	Blue Ring	
1.2631	X50CrMoW 9 11				860	860	Blue Ring	
1.2842	90MnCrV 8	O2	90 M V 8		740	740	Blue Ring	
1.3207	S10-4-3-10		Z 130 WKCDV 10-10-04-040		1000	1200	Blue Ring	
1.8151	50CrV 4						Blue Ring	
1.8161	58CrV 4				1000	1200	Blue Ring	
1.2083	X42Cr 13		Z 40 C 14	SUS 420 J 2		770	Blue Ring	
1.2311	40CrMnMo 7					770	Blue Ring	
1.2316	X36CrMo 17					840	Blue Ring	
1.2343	X38CrMoV 5 1	H 11	Z 38 CDV 5	SKD 6		800	Blue Ring	
1.2344	X40CrMoV 5 1	H 13	Z 40 CDV 5	SKD 61		800	Blue Ring	
1.2365	X32CrMoV 3 3	H 10	Z 32 DCV 28	SKD 7		800	Blue Ring	
1.2542	45WCrV 7	S 1					Blue Ring	
1.2581	X30WCrV 9 3	H 21	Z 30 WCV 9			800	Blue Ring	
1.2713	55NiCrMoV 6	L 6	55 NCDV 7	SKT 4		800	Blue Ring	
1.2743	60NiCrMoV 12 4						Blue Ring	
1.2766	35NiCrMo 16						Blue Ring	
1.4973	NiCr19CoMo				1200	1320	Red Ring	
1.4980	X5NiCrTi26 15				930	1180	Red Ring	
1.6582	35CrNiMo 6	4340	35 NCD 6	SNCM 447	1200	1400	Red Ring	
1.2379	X155CrVMo 12 1	D 2	Z 160 CDV 12	SKD 11	1200	1400	Red Ring	
1.2714	56NiCrMoV 7				1200	1400	Red Ring	
1.8159	50CrV 4	6150	50 CV 4	SUP 10	1200	1300	Red Ring	
1.4006	X10Cr 13	410;CA-15	Z 12 C 13	SUS 410	450	650	Blue Ring	Blue Ring
1.4008	GX8CrNi 13				590	790	White Ring	Blue Ring
1.4021	X20Cr 13	420	Z 20 C 13	SUS 420 J 1	650	950	White Ring	Blue Ring
1.4027	GX20Cr 14		Z 20 C 13 M		590	700	White Ring	Blue Ring
1.4028	X30Cr 13	420	Z 30 C 13	SUS 420 J 2	600	780	White Ring	Blue Ring
1.4031	X39Cr 13	420	Z 40 C 14	SUS 420 J 2	560	800	White Ring	Blue Ring

VÖLKEL
THREADING SOLUTIONS

Material No.	DIN	AISI	AFNOR	JIS	tensile strength N/mm² min./max.		recommendation 1	recommendation 2
1.4057	X17CrNi 162	431	Z 15 CN 16.02	SUS 431	650	850	Blue Ring	White Ring
1.4104	X14CrMoS 17	430 F	Z 13 CF 17	SUS 430 F	540	840	White Ring	Blue Ring
1.4125	X105CrMo 17	440 C	Z 100 CD 17	SUS 440 C	900	900	Blue Ring	White Ring
1.4301	X5CrNi18 10	304 (V2A)	Z 6 CN 18.09	SUS 304	500	700	White Ring	Blue Ring
1.4305	X8CrNiS 18 9	303	Z 10 CNF 18.09	SUS 303	500	750	White Ring	Blue Ring
1.4306	X2CrNi 19 11	304L (V2A)	Z 2 CN 18.10	SCS 19	460	850	White Ring	Blue Ring
1.4308	GX5CrNi 19 10		Z 6 CN 18.10 M		460	640	White Ring	Blue Ring
1.4310	X10CrNi 18 8	301	Z 11 CN 17-08	SUS 301	700	950	White Ring	Blue Ring
1.4311	X2CrNiN 18 10	304 LN	Z c2 CN 18.10	SUS 304 LN	550	760	White Ring	Blue Ring
1.4541	X10CrNiTi 18 9	321 (V2A)	Z 6 CNT 18.10	SUS 321	500	700	White Ring	Blue Ring
1.4401	X5CrNiMo 17 12 1	316 (V4A)	Z 6 CND 17.11	SUS 316	510	710	White Ring	Blue Ring
1.4404	X2CrNiMo 17 12 2	316L (V4A)	Z 2 CND 17.12	SUS 316 L	490	850	White Ring	Blue Ring
1.4406	X2CrNiMoN 17 12 2	316 LN	Z 2 CND 17.12 AZ	SUS 316 LN	580	800	White Ring	Blue Ring
1.4429	X2CrNiMoN 17 13 3	316 LN	Z 2 CND 17.13 AZ	SUS 316 LN	580	800	White Ring	Blue Ring
1.4435	X2CrNiMo 18 14 3	316 L	Z 2 CND 17.13	SCS 16;SUS 316 L	490	690	White Ring	Blue Ring
1.4436	X5CrNiM0 17 13 3	316	Z 2 CND 17.12	SUS 316	510	710	White Ring	Blue Ring
1.4438	X2CrNiMo 18 16	317 L	Z 2 CND 19.15	SUS 317 L	490	690	White Ring	Blue Ring
1.4449	X5CrNiMo 17 13	317					White Ring	Blue Ring
1.4460	X4CrNiMoN 27 5 2	329	Z 5 CDN 27-05	SUS 329 J 1	600	800	White Ring	Blue Ring
1.4462	X2CrNiMoN 22 5 3	2205	Z 3 CND 22-05 Az	SUS 329J3L	680	880	White Ring	Blue Ring
1.4503	X3NiCrCuMoTi 27 23				500	700	White Ring	Blue Ring
1.4505	X5NiCrMoCuNb 20 18				490	740	White Ring	Blue Ring
1.4510	X6CrTi 17	XM 8;430 TI	Z 8 CT 17	SUS 430 LX	450	600	White Ring	Blue Ring
1.4511	X6CrNb 17				450	600	White Ring	Blue Ring
1.4512	X6CrTi 12	409	Z 6 CT 12	SUH 409	330	560	Blue Ring	Blue Ring
1.4521	X2CrMoTi 18 2	444	Z 3 CDT 18-02	SUS 444	450	650	White Ring	Blue Ring
1.4542	X5CrNiCuPb 16 4	630	Z 7 CNU 15-05	SCS 630			White Ring	Blue Ring
1.4546	X5CrNiNb 18 10	348	Z 6 CNNb 18.10	SUS 347	410	610	White Ring	Blue Ring
1.4550	X6CrNiNb 18 10	347	Z 6 CN Nb 18.10	SUS 347	550	750	White Ring	Blue Ring
1.4552	GX5CrNiNb 19 10		Z 4 CN Nb 19.10 M		440	640	White Ring	Blue Ring
0.6015	GG15	A48-25 B	Ft 15 D	FC 15	110	150	Black Ring	
0.6020	GG20	A48-30 B	Ft 20 D	FC 20	150	200	Black Ring	
0.6025	GG25	A48-40 B	Ft 25 D	FC 25	200	250	Black Ring	
0.6030	GG30	A48-45 B	Ft 30 D	FC 30	240	270	Black Ring	
0.6035	GG35	A48-50 B	Ft 35 D	FC 35	280	320	Black Ring	
0.6040	GG40	A48-60 B	FT 40 D		350	450	Black Ring	
0.7040	GGG40	60-40-18	FGS 400-12	FCD 40	400	400	Standard Form A-C-B	Green Ring Form B
0.7050	GGG50	65-45-12	FGS 500-7	FCD 50	500	500	Standard Form A-C-B	Green Ring Form B
0.7060	GGG60	80-55-06	FGS 600-3	FCD 60	600	600	Standard Form A-C-B	Green Ring Form B
0.7070	GGG70	100-70-03	FGS 700-2	FCD 70	700	700	Standard Form A-C-B	Green Ring Form B
0.8035	GTW35-04	MB 350-4	MB35-7	FCMW 330	350	350	Standard Form A-C-B	Green Ring Form B
0.8055	GTS55-05				550	550	Standard Form A-C-B	Green Ring Form B
2.0401	CuZn39Pb 3 (MS58)	C 38500	MS58		630	630	Orange Ring	
2.0410	CuZn44Pb 2				630	630	Orange Ring	
2.0580	CuZn40MnPb				400	400	Orange Ring	
2.0250	CuZn 20						Standard Form C-B-B/ AZ-RSP	
2.0265	CuZn 30	C 26000	CuZn 30	C 2600			Standard Form C-B-B/ AZ-RSP	
2.0321	CuZn 37	C 27200	CuZn 37	C 2700			Standard Form C-B-B/ AZ-RSP	
2.0335	CuZn 36 (MS63)		Ms63	C 2700			Standard Form C-B-B/ AZ-RSP	
3.0250	AL 99.5 H		A 5	A1x1		350	Yellow Ring	Standard Form B-AZ
3.0280	AL 99.8 H						Yellow Ring	Standard Form B-AZ
3.0305	AL 99.9		A 9				Yellow Ring	Standard Form B-AZ
3.3308	AL 99.9 Mg 0,5						Yellow Ring	Standard Form B-AZ
3.0515	ALMn 1			144054			Yellow Ring	Standard Form B-AZ
3.0525	AlMn 1 Mg 05		A-M1G0,5				Yellow Ring	Standard Form B-AZ
3.0615	AlMgSi-Pb						Yellow Ring	Standard Form B-AZ
3.1325	AlCuMg 1		A-U4G				Yellow Ring	Standard Form B-AZ
3.1355	AlCuMg 2		A-U4G1	A3x4			Yellow Ring	Standard Form B-AZ
3.3315	AlMg 1		A-G0,5	A2x8			Yellow Ring	Standard Form B-AZ
3.4365	AlZnMgCu 1.5	7175	AZ 4 GU/9050 C				Yellow Ring	Standard Form B-AZ
3.2381	G-AlSi 10 Mg		A-S1OG				Blue Ring	
3.2383	G-AlSi 10 Mg (CU)	A 360.2	A-S1OGU				Blue Ring	
3.2581	G-AlSi 12	A 413.2	A-S13	AC3			Blue Ring	
3.2583	G-AlSi (CU)	A 413.1	A-S12U				Blue Ring	
3.2982	GD-AlSi 12 (CU)						Blue Ring	
3.5912	G-MgAl 9 Zn 1						Blue Ring	
3.2134	G-AlSi 5 Cu 1 Mg						Standard Form C-B-RSP	Blue Ring
3.2152	G-AlSi 6 Cu 4						Standard Form C-B-RSP	Blue Ring
3.2162	G-AlSi 8 Cu 3						Standard Form C-B-RSP	Blue Ring
3.2373	G-AlSi 9 Mg		A-S9G	AC4A			Standard Form C-B-RSP	Blue Ring
3.7115	TiAl 5 Sn 2				790	980	White Ring	
3.7165	TiAl 6 V 4	R56400	T-A6V		980	1140	Blue Ring	
3.7185	TiAl4Mo4Sn2				1000		Blue Ring	
	Polyamid						Standard Form B-RSP	Green Ring
	Polystyrol						Standard Form B-RSP	Green Ring
	Polyvinylchlorid						Standard Form B-RSP	Green Ring
	Ultramid						Standard Form B-RSP	Green Ring
CFK	Faserverstärkte				190	210	Black Ring	Red Ring
GFK	Kunsttoffe						Black Ring	Red Ring
	Bakelit						Black Ring	Red Ring
	Ferrozell						Black Ring	Red Ring
	Pertinax						Black Ring	Red Ring

GREEN RING-Machine Taps
metric ISO-thread DIN 13

Maschi a macchina con collarino verde
filettatura metrica ISO DIN 13

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

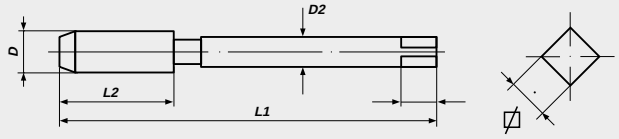
Nominal Diameter D	L 1	L 2	D 2	⌀	Art.-No.	€
DIN 371						
M 3 x 0.5	56	11	3.5	2.7	35326	8,90
M 4 x 0.7	63	13	4.5	3.4	35330	8,90
M 5 x 0.8	70	16	6.0	4.9	35334	9,70
M 6 x 1.0	80	19	6.0	4.9	35338	9,70
M 8 x 1.25	90	22	8.0	6.2	35342	11,20
M 10 x 1.5	100	24	10.0	8.0	35346	17,80
DIN 376						
M 12 x 1.75	110	29	9.0	7.0	35350	22,50
M 14 x 2.0	110	30	11.0	9.0	35354	23,00
M 16 x 2.0	110	32	12.0	9.0	35358	25,00
M 18 x 2.5	125	34	14.0	11.0	35362	37,00
M 20 x 2.5	140	34	16.0	12.0	35366	52,00
SET						
M 3 - 12	M 3-4-5-6-8-10 (DIN 371), M 12 (DIN 376)				47853	87,00

Application:

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

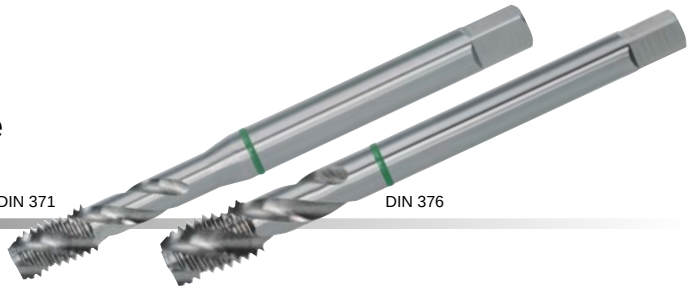
Applicazione:

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



GREEN RING-Machine Taps
metric ISO-thread DIN 13

Maschi a macchina con collarino verde
filettatura metrica ISO DIN 13



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

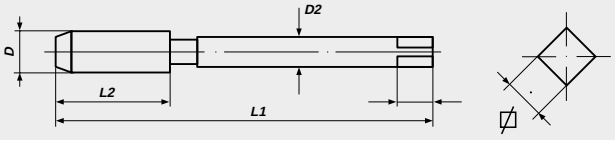
Nominal Diameter D	L 1	L 2	D 2	☐	Art.-No.	€
DIN 371						
M 3 x 0.5	56	6	3.5	2.7	36326	10,70
M 4 x 0.7	63	7	4.5	3.4	36330	10,70
M 5 x 0.8	70	8	6.0	4.9	36334	11,70
M 6 x 1.0	80	10	6.0	4.9	36338	11,70
M 8 x 1.25	90	14	8.0	6.2	36342	13,50
M 10 x 1.5	100	16	10.0	8.0	36346	20,00
DIN 376						
M 12 x 1.75	110	18	9.0	7.0	36350	25,00
M 14 x 2.0	110	20	11.0	9.0	36354	28,00
M 16 x 2.0	110	22	12.0	9.0	36358	33,00
M 18 x 2.5	125	25	14.0	11.0	36362	44,40
M 20 x 2.5	140	25	16.0	12.0	36366	60,00
SET						
M 3 - 12	M 3-4-5-6-8-10 (DIN 371), M 12 (DIN 376)				47863	103,00

Application:

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

Applicazione:

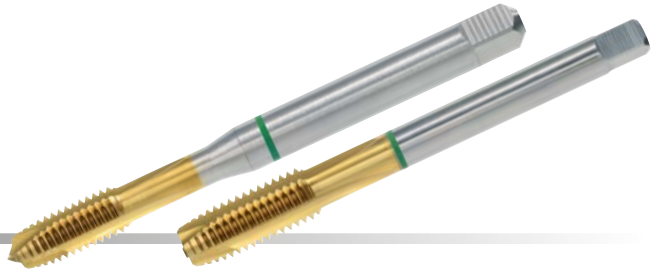
per uso universale
- Materiali con buona truciodibilità fino a 1.000 N/mm²
- Acciaio non legati e scarsamente legati
- Materiali truciolo lungo
- per fori ciechi



VÖLKEL
THREADING SOLUTIONS

GREEN RING-Machine Taps
metric ISO-thread DIN 13

Maschi a macchina con collarino verde
filettatura metrica ISO DIN 13



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

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

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

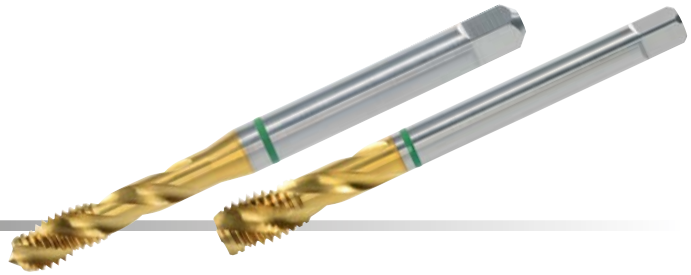
Advantages HSSE-PM-TIN
- increased wear resistance and toughness
- TiN-coating improves anti-friction properties, thereby improved wear-resistance and reduced tendency of build-up edge

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

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

GREEN RING-Machine Taps
metric ISO-thread DIN 13

Maschi a macchina con collarino verde
filettatura metrica ISO DIN 13



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

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

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

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

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

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

VÖLKEL
THREADING SOLUTIONS

BLUE RING-Machine Taps
metric ISO-thread DIN 13

Maschi a macchina con collarino blu
filettatura metrica ISO DIN 13

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

Nominal Diameter D	L 1	L 2	D 2	☐	Art.-No.	€
DIN 371						
M 3 x 0.5	56	11	3.5	2.7	35426	8,90
M 4 x 0.7	63	13	4.5	3.4	35430	8,90
M 5 x 0.8	70	16	6.0	4.9	35434	9,70
M 6 x 1.0	80	19	6.0	4.9	35438	9,70
M 8 x 1.25	90	22	8.0	6.2	35442	11,20
M 10 x 1.5	100	24	10.0	8.0	35446	17,80
DIN 376						
M 12 x 1.75	110	29	9.0	7.0	35450	22,50
M 14 x 2.0	110	30	11.0	9.0	35454	25,50
M 16 x 2.0	110	32	12.0	9.0	35458	27,50
M 18 x 2.5	125	34	14.0	11.0	35462	37,00
M 20 x 2.5	140	34	16.0	12.0	35466	52,00
SET						
M 3 - 12	M 3-4-5-6-8-10 (DIN 371), M 12 (DIN 376)				47854	87,00
TiCN						
DIN 371						
M 3 x 0.5	56	11	3.5	2.7	35427	12,00
M 4 x 0.7	63	13	4.5	3.4	35431	12,00
M 5 x 0.8	70	16	6.0	4.9	35435	12,80
M 6 x 1.0	80	19	6.0	4.9	35439	13,40
M 8 x 1.25	90	22	8.0	6.2	35443	15,90
M 10 x 1.5	100	24	10.0	8.0	35447	24,30
DIN 376						
M 12 x 1.75	110	29	9.0	7.0	35451	32,40
M 14 x 2.0	110	30	11.0	9.0	35455	36,50
M 16 x 2.0	110	32	12.0	9.0	35459	39,50
M 18 x 2.5	125	34	14.0	11.0	35463	52,90
M 20 x 2.5	140	34	16.0	12.0	35467	67,90

Application:

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

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

Applicazione:

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

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

BLUE RING-Machine Taps
metric ISO-thread DIN 13

Maschi a macchina con collarino blu
filettatura metrica ISO DIN 13

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

Nominal Diameter D	L 1	L 2	D 2	☐	Art.-No.	€
DIN 371						
M 3 x 0.5	56	6	3.5	2.7	36426	10,70
M 4 x 0.7	63	7	4.5	3.4	36430	10,70
M 5 x 0.8	70	8	6.0	4.9	36434	11,70
M 6 x 1.0	80	10	6.0	4.9	36438	11,70
M 8 x 1.25	90	14	8.0	6.2	36442	13,50
M 10 x 1.5	100	16	10.0	8.0	36446	20,00
DIN 376						
M 12 x 1.75	110	18	9.0	7.0	36450	26,00
M 14 x 2.0	110	20	11.0	9.0	36454	28,00
M 16 x 2.0	110	22	12.0	9.0	36458	31,00
M 18 x 2.5	125	25	14.0	11.0	36462	43,00
M 20 x 2.5	140	25	16.0	12.0	36466	62,40
SET						
M 3 - 12	M 3-4-5-6-8-10 (DIN 371). M 12 (DIN 376)				47864	103,00
TiCN						
DIN 371						
M 3 x 0.5	56	6	3.5	2.7	36427	13,80
M 4 x 0.7	63	7	4.5	3.4	36431	13,80
M 5 x 0.8	70	8	6.0	4.9	36435	14,80
M 6 x 1.0	80	10	6.0	4.9	36439	15,40
M 8 x 1.25	90	14	8.0	6.2	36443	18,20
M 10 x 1.5	100	16	10.0	8.0	36447	26,50
DIN 376						
M 12 x 1.75	110	18	9.0	7.0	36451	35,90
M 14 x 2.0	110	20	11.0	9.0	36455	39,00
M 16 x 2.0	110	22	12.0	9.0	36459	43,00
M 18 x 2.5	125	25	14.0	11.0	36463	58,90
M 20 x 2.5	140	25	16.0	12.0	36467	78,30

Application:

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

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

Applicazione:

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

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

VÖLKEL
THREADING SOLUTIONS

WHITE RING-Machine Taps
metric ISO-thread DIN 13

Maschi a macchina con collarino bianco
filettatura metrica ISO DIN 13

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

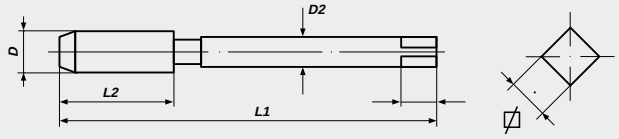
Nominal Diameter D	L 1	L 2	D 2	☐	Art.-No.	€
DIN 371						
M 3 x 0.5	56	11	3.5	2.7	35226	9,70
M 4 x 0.7	63	13	4.5	3.4	35230	9,70
M 5 x 0.8	70	16	6.0	4.9	35234	10,60
M 6 x 1.0	80	19	6.0	4.9	35238	10,60
M 8 x 1.25	90	22	8.0	6.2	35242	12,60
M 10 x 1.5	100	24	10.0	8.0	35246	17,80
DIN 376						
M 12 x 1.75	110	29	9.0	7.0	35250	22,50
M 14 x 2.0	110	30	11.0	9.0	35254	25,50
M 16 x 2.0	110	32	12.0	9.0	35258	27,50
M 18 x 2.5	125	34	14.0	11.0	35262	37,00
M 20 x 2.5	140	34	16.0	12.0	35266	52,00
SET						
M 3 - 12	M 3-4-5-6-8-10 (DIN 371), M 12 (DIN 376)				47852	94,00

Application:

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

Applicazione:

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



WHITE RING-Machine Taps

Maschi a macchina con collarino bianco

Form B HSS-E

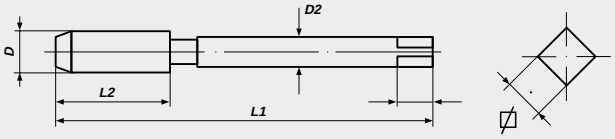
Nominal Diameter D	L 1	L 2	D 2	☐	Art.-No.	€
MF Tol. ISO2/6H DIN 374						
M 5 x 0.5	70	12	3.5	2.7	35903	16,50
M 6 x 0.75	80	14	4.5	3.4	35904	16,50
M 8 x 0.75	80	19	6.0	4.9	35906	16,50
M 8 x 1.0	90	22	6.0	4.9	35907	16,50
M 10 x 1.0	90	20	7.0	5.5	35909	19,30
M 10 x 1.25	100	24	7.0	5.5	35910	19,30
M 12 x 1.25	100	22	9.0	7.0	35913	26,40
M 12 x 1.5	100	22	9.0	7.0	35914	26,40
M 14 x 1.5	100	22	11.0	9.0	35917	33,00
M 16 x 1.5	100	22	12.0	9.0	35921	38,00
M 18 x 1.5	110	25	14.0	11.0	35925	46,20
M 20 x 1.5	125	25	16.0	12.0	35929	51,20
UNC Tol. 2B DIN 371						
UNC 1/4 x 20	80	17	7.0	5.5	35945	12,10
UNC 5/16 x 18	90	20	8.0	6.2	35946	15,40
UNC 3/8 x 16	100	22	9.0	7.0	35947	17,60
DIN 376						
UNC 7/16 x 14	100	22	8.0	6.2	35948	20,90
UNC 1/2 x 13	110	25	9.0	7.0	35949	20,90
UNF Tol. 2B DIN 371						
UNF 1/4 x 28	80	17	7.0	5.5	35965	12,10
UNF 5/16 x 24	90	17	8.0	6.2	35966	15,40
UNF 3/8 x 24	100	18	9.0	7.0	35967	17,60
DIN 376						
UNF 7/16 x 20	100	22	8.0	6.2	35968	20,90
UNF 1/2 x 20	100	22	9.0	7.0	35969	20,90
G (BSP) DIN 5156						
G 1/8 x 28	90	20	7.0	5.5	35992	19,80
G 1/4 x 19	100	22	11.0	9.0	35993	24,20
G 3/8 x 19	100	22	12.0	9.0	35994	28,60
G 1/2 x 14	125	25	16.0	12.0	35995	41,80

Application:

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

Applicazione:

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



VÖLKEL
THREADING SOLUTIONS

WHITE RING-Machine Taps
metric ISO-thread DIN 13

Maschi a macchina con collarino bianco
filettatura metrica ISO DIN 13

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

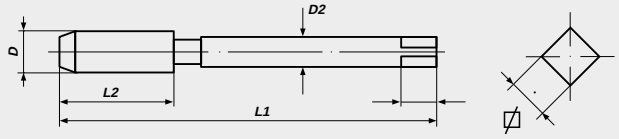
Nominal Diameter D	L 1	L 2	D 2	☐	Art.-No.	€
DIN 371						
M 3 x 0.5	56	6	3.5	2.7	36226	11,60
M 4 x 0.7	63	7	4.5	3.4	36230	11,60
M 5 x 0.8	70	8	6.0	4.9	36234	12,70
M 6 x 1.0	80	10	6.0	4.9	36238	12,70
M 8 x 1.25	90	14	8.0	6.2	36242	15,10
M 10 x 1.5	100	16	10.0	8.0	36246	21,40
DIN 376						
M 12 x 1.75	110	18	9.0	7.0	36250	27,00
M 14 x 2.0	110	20	11.0	9.0	36254	30,60
M 16 x 2.0	110	22	12.0	9.0	36258	33,00
M 18 x 2.5	125	25	14.0	11.0	36262	44,40
M 20 x 2.5	140	25	16.0	12.0	36266	62,40
SET						
M 3 - 12	M 3-4-5-6-8-10 (DIN 371), M 12 (DIN 376)				47862	113,00

Application:

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

Applicazione:

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



WHITE RING-Machine Taps

Maschi a macchina con collarino bianco

Form C/39° RSP HSS-E

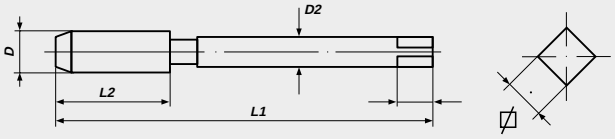
Nominal Diameter D	L 1	L 2	D 2	☐	Art.-No.	€
MF Tol. ISO2/6H DIN 374						
M 5 x 0.5	70	5	3.5	2.7	36903	18,70
M 6 x 0.75	80	8	4.5	3.4	36904	18,70
M 8 x 0.75	80	8	6.0	4.9	36906	18,70
M 8 x 1.0	90	10	6.0	4.9	36907	18,70
M 10 x 1.0	90	10	7.0	5.5	36909	22,50
M 10 x 1.25	100	16	7.0	5.5	36910	22,20
M 12 x 1.25	100	15	9.0	7.0	36913	28,60
M 12 x 1.5	100	15	9.0	7.0	36914	28,60
M 14 x 1.5	100	15	11.0	9.0	36917	35,20
M 16 x 1.5	100	15	12.0	9.0	36921	40,70
M 18 x 1.5	110	17	14.0	11.0	36925	50,60
M 20 x 1.5	125	17	16.0	12.0	36929	56,10
UNC Tol. 2B DIN 371						
UNC 1/4 x 20	80	13	7.0	5.5	36945	15,10
UNC 5/16 x 18	90	14	8.0	6.2	36946	18,20
UNC 3/8 x 16	100	16	9.0	7.0	36947	20,00
DIN 376						
UNC 7/16 x 14	100	17	8.0	6.2	36948	25,30
UNC 1/2 x 13	110	20	9.0	7.0	36949	25,30
UNF Tol. 2B DIN 371						
UNF 1/4 x 28	80	10	7.0	5.5	36965	15,10
UNF 5/16 x 24	90	10	8.0	6.2	36966	18,20
UNF 3/8 x 24	100	10	9.0	7.0	36967	20,00
DIN 376						
UNF 7/16 x 20	100	13	8.0	6.2	36968	25,30
UNF 1/2 x 20	100	13	9.0	7.0	36969	25,30
G (BSP) DIN 5156						
G 1/8 x 28	90	20	7.0	5.5	36992	22,00
G 1/4 x 19	100	22	11.0	9.0	36993	27,50
G 3/8 x 19	100	22	12.0	9.0	36994	37,70
G 1/2 x 14	125	25	16.0	12.0	36995	48,40

Application:

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

Applicazione:

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



VÖLKEL
THREADING SOLUTIONS

BLACK RING-Machine Taps
metric ISO-thread DIN 13

Maschi a macchina con collarino nero
filettatura metrica ISO DIN 13

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

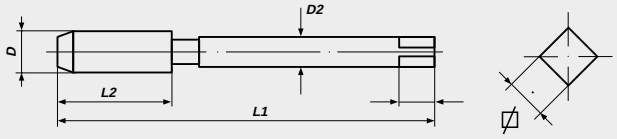
Nominal Diameter D	L 1	L 2	D 2	☐	Art.-No.	€
DIN 371						
M 3 x 0.5	56	11	3.5	2.7	35126	9,70
M 4 x 0.7	63	13	4.5	3.4	35130	9,70
M 5 x 0.8	70	16	6.0	4.9	35134	10,60
M 6 x 1.0	80	19	6.0	4.9	35138	10,60
M 8 x 1.25	90	22	8.0	6.2	35142	12,40
M 10 x 1.5	100	24	10.0	8.0	35146	17,00
DIN 376						
M 12 x 1.75	110	29	9.0	7.0	35150	22,00
M 14 x 2.0	110	30	11.0	9.0	35154	25,00
M 16 x 2.0	110	32	12.0	9.0	35158	27,00
M 18 x 2.5	125	34	14.0	11.0	35162	36,50
M 20 x 2.5	140	34	16.0	12.0	35166	51,00
SET						
M 3 - 12	M 3-4-5-6-8-10 (DIN 371), M 12 (DIN 376)				47851	94,00

Application:

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

Applicazione:

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



YELLOW RING-Machine Taps
metric ISO-thread DIN 13

Maschi a macchina con collarino giallo
filettatura metrica ISO DIN 13

DIN 371/376 Form C/40° RSP HSS-E

Nominal Diameter D		L 1	L 2	D 2	☐	Art.-No.	€
M	Tol. ISO2/6H DIN 371						
M	3 x 0.5	56	6	3.5	2.7	36526	10,70
M	4 x 0.7	63	7	4.5	3.4	36530	10,70
M	5 x 0.8	70	8	6.0	4.9	36534	11,70
M	6 x 1.0	80	10	6.0	4.9	36538	11,70
M	8 x 1.25	90	14	8.0	6.2	36542	13,50
M	10 x 1.5	100	16	10.0	8.0	36546	20,00
		DIN 376					
M	12 x 1.75	110	18	9.0	7.0	36550	26,00
M	14 x 2.0	110	20	11.0	9.0	36554	28,00
M	16 x 2.0	110	22	12.0	9.0	36558	31,00
SET							
M	3 - 12	M 3-4-5-6-8-10 (DIN 371), M 12 (DIN 376)				47860	103,00
UNC	Tol. 2B DIN 371						
UNC	1/4 x 20	80	13	7,0	5,5	36580	13,80
UNC	5/16 x 18	90	14	8,0	6,2	36581	16,60
UNC	3/8 x 16	100	16	9,0	7,0	36582	18,20
UNC	7/16 x 14	100	17	8,0	6,2	36583	23,00
		DIN 376					
UNC	1/2 x 13	100	20	9,0	7,0	36584	23,00

Application:

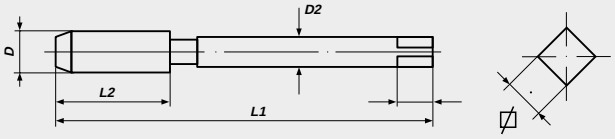
Aluminium-alloys, long chipping

- for blind holes
- with 2 flutes

Applicazione:

Alluminio, truciolo lungo

- per fori ciechi
- A 2 scanalature



VÖLKEL
THREADING SOLUTIONS

ORANGE RING-Machine Taps
metric ISO-thread DIN 13

Maschi a macchina con collarino arancione
filettatura metrica ISO DIN 13

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

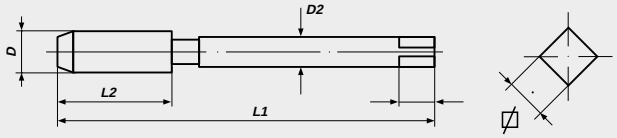
Nominal Diameter D	L 1	L 2	D 2	☐	Art.-No.	€
DIN 371						
M 3 x 0.5	56	11	3.5	2.7	35726	9,70
M 4 x 0.7	63	13	4.5	3.4	35730	9,70
M 5 x 0.8	70	16	6.0	4.9	35734	10,60
M 6 x 1.0	80	19	6.0	4.9	35738	10,60
M 8 x 1.25	90	22	8.0	6.2	35742	12,40
M 10 x 1.5	100	24	10.0	8.0	35746	17,00
DIN 376						
M 12 x 1.75	110	29	9.0	7.0	35750	22,00
M 14 x 2.0	110	30	11.0	9.0	35754	25,00
M 16 x 2.0	110	32	12.0	9.0	35758	27,00
SET						
M 3 - 12	M 3-4-5-6-8-10 (DIN 371), M 12 (DIN 376)				47850	94,00

Application:

Ms
Brass, short chipping
- for through and blind holes

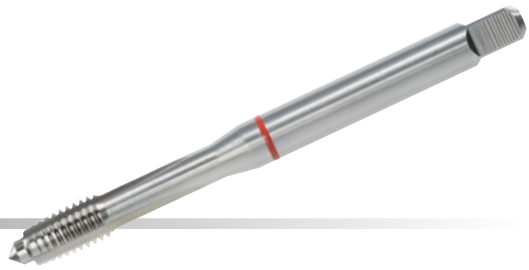
Applicazione:

Ms
Ottone, truciolo corto
- per fori passanti e ciechi



RED RING-Machine Taps
metric ISO-thread DIN 13

Maschi a macchina con collarino rosso
filettatura metrica ISO DIN 13



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

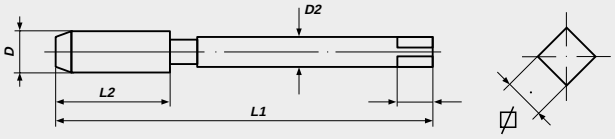
Nominal Diameter D	L 1	L 2	D 2	☐	Art.-No.	€
DIN 371						
M 4 x 0.7	63	9	4.5	3.4	36130	11,20
M 5 x 0.8	70	11	6.0	4.9	36134	12,40
M 6 x 1.0	80	13	6.0	4.9	36138	12,40
M 8 x 1.25	90	15	8.0	6.2	36142	14,20
M 10 x 1.5	100	16	10.0	8.0	36146	17,80

Application:

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

Applicazione:

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



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

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

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

77 + 153 - 155

GREEN RING TwinBox

Machine Tap + Twist Drill
metric ISO-thread DIN 13

TwinBox verde

Maschi a macchina + punte
filettatura metrica ISO DIN 13

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

Nominal Diameter D			Art.-No.	€
Form B, Spiral Point / punta en espiral (pasante)				
M 3 x 0.5	DIN 371	2.5 mm	35390	10,90
M 4 x 0.7	DIN 371	3.3 mm	35391	11,00
M 5 x 0.8	DIN 371	4.2 mm	35392	12,20
M 6 x 1.0	DIN 371	5.0 mm	35393	12,50
M 8 x 1.25	DIN 371	6.8 mm	35394	15,50
M 10 x 1.5	DIN 371	8.5 mm	35395	25,00
M 12 x 1.75	DIN 376	10.2 mm	35396	33,00
M 14 x 2.0	DIN 376	12.0 mm	35397	35,00
M 16 x 2.0	DIN 376	14.0 mm	35398	43,00
Form C, Spiral Flute / Helicoidal 39° (ciego)				
M 3 x 0.5	DIN 371	2.5 mm	36390	12,10
M 4 x 0.7	DIN 371	3.3 mm	36391	12,30
M 5 x 0.8	DIN 371	4.2 mm	36392	13,50
M 6 x 1.0	DIN 371	5.0 mm	36393	13,80
M 8 x 1.25	DIN 371	6.8 mm	36394	17,00
M 10 x 1.5	DIN 371	8.5 mm	36395	26,50
M 12 x 1.75	DIN 376	10.2 mm	36396	34,50
M 14 x 2.0	DIN 376	12.0 mm	36397	38,50
M 16 x 2.0	DIN 376	14.0 mm	36398	46,50

Application:

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

Spiral Point for through holes
Spiral Flute for blind holes

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

Applicazione:

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

Forma B per fori passanti
39° RSP per fori ciechi

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

VÖLKEL
THREADING SOLUTIONS

BLUE RING TwinBox

Machine Tap + Twist Drill
metric ISO-thread DIN 13

TwinBox blu

Maschi a macchina + punte
filettatura metrica ISO DIN 13

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

Nominal Diameter D			Art.-No.	€
Form B, Spiral Point / con imbocco corretto				
M 3 x 0.5	DIN 371	2.5 mm	35490	10,60
M 4 x 0.7	DIN 371	3.3 mm	35491	10,90
M 5 x 0.8	DIN 371	4.2 mm	35492	12,00
M 6 x 1.0	DIN 371	5.0 mm	35493	12,50
M 8 x 1.25	DIN 371	6.8 mm	35494	15,80
M 10 x 1.5	DIN 371	8.5 mm	35495	24,00
M 12 x 1.75	DIN 376	10.2 mm	35496	32,00
M 14 x 2.0	DIN 376	12.0 mm	35497	36,00
M 16 x 2.0	DIN 376	14.0 mm	35498	41,00
Form C, Spiral Flute / spirale destra a 39°,				
M 3 x 0.5	DIN 371	2.5 mm	36490	12,30
M 4 x 0.7	DIN 371	3.3 mm	36491	12,60
M 5 x 0.8	DIN 371	4.2 mm	36492	13,70
M 6 x 1.0	DIN 371	5.0 mm	36493	14,10
M 8 x 1.25	DIN 371	6.8 mm	36494	17,50
M 10 x 1.5	DIN 371	8.5 mm	36495	25,00
M 12 x 1.75	DIN 376	10.2 mm	36496	33,00
M 14 x 2.0	DIN 376	12.0 mm	36497	39,00
M 16 x 2.0	DIN 376	14.0 mm	36498	45,60

Application:

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

Spiral Point for through holes
Spiral Flute for blind holes

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

Applicazione:

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

Forma B per fori passanti
39° RSP per fori ciechi

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

WHITE RING TwinBox

Machine Tap + Twist Drill
metric ISO-thread DIN 13

TwinBox bianco

Maschi a macchina + punte
filettatura metrica ISO DIN 13

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

Nominal Diameter D				Art.-No.	€
Form B, Spiral Point / con imbocco corretto					
M	3 x 0.5	DIN 371	2.5 mm	35290	11,40
M	4 x 0.7	DIN 371	3.3 mm	35291	11,80
M	5 x 0.8	DIN 371	4.2 mm	35292	13,00
M	6 x 1.0	DIN 371	5.0 mm	35293	13,50
M	8 x 1.25	DIN 371	6.8 mm	35294	16,50
M	10 x 1.5	DIN 371	8.5 mm	35295	24,00
M	12 x 1.75	DIN 376	10.2 mm	35296	31,50
M	14 x 2.0	DIN 376	12.0 mm	35297	37,00
M	16 x 2.0	DIN 376	14.0 mm	35298	44,00
Form C, Spiral Flute / spirale destra a 39°					
M	3 x 0.5	DIN 371	2.5 mm	36290	13,30
M	4 x 0.7	DIN 371	3.3 mm	36291	13,60
M	5 x 0.8	DIN 371	4.2 mm	36292	14,80
M	6 x 1.0	DIN 371	5.0 mm	36293	15,30
M	8 x 1.25	DIN 371	6.8 mm	36294	18,50
M	10 x 1.5	DIN 371	8.5 mm	36295	25,50
M	12 x 1.75	DIN 376	10.2 mm	36296	34,00
M	14 x 2.0	DIN 376	12.0 mm	36297	40,50
M	16 x 2.0	DIN 376	14.0 mm	36298	48,60

Application:

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

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

Applicazione:

Acciaio inossidabile truciolo lungo a 1000 N/mm²
- Acciaio resistente al calore truciolo lungo
- Materiali difficile da tagliare
Forma B per fori passanti
39° RSP per fori ciechi
Superficie: vaporizzato

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