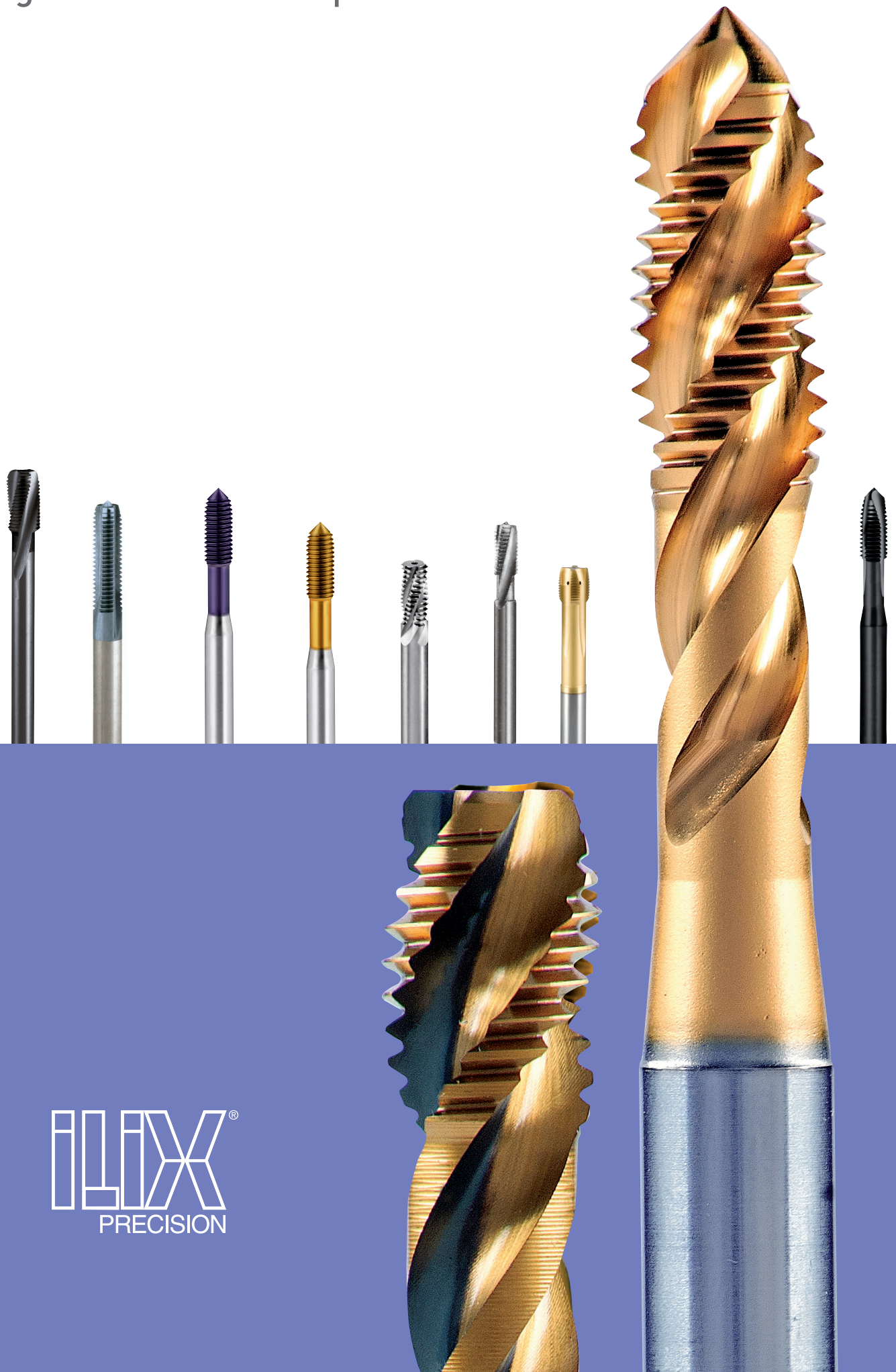
Hochleistungs-Gewindebohrer

High Performance Taps



ILIX® PRECISION

Hochleistungs-Gewindebohrer
High Performance Taps

▶ Zeichenerklärung
Key to symbols

SCHNEIDSTOFF / TOOL MATERIAL

HSS-Co

HSS-Co-8

HSS

K 20
VHM / Feinstkorn
Solid carbide / Micro grain

BESCHICHTUNG / COATING

Unbeschichtet
Blank

TN
TiN

TF
TiAlN
Futura

TC
TiCN

HL
Hard Lube

XB
TiCN Top

OBERFLÄCHENBEHANDLUNGEN / SURFACE TREATMENT

Nitriert
Nitrided

▶ Werkzeug-Auswahlhilfe
Tool selection guide

MASCHINEN-GEWINDEBOHRER / MACHINE TAPS

KAT.-NR. ITEM	SIMBOL SYMBOL	Ø mm	DIN	SACKLOCH / DURCHGANGSLOCH Blind hole/ Through hole	TOLERANZ TOLERANCE	DRALLWINKEL HELIX ANGLE	ANSCHNITT FORM CHAMFER FORM
Multi Rapid VA - Multi VA							
6773 	**M**	3 ÷ 10	**371**		6HX	0°	B
6774 	**M**	3 ÷ 10	**371**		6HX	50°	C
6778 	**M**	12 ÷ 20	**376**		6HX	0°	B
6779 	**M**	12 ÷ 20	**376**		6HX	50°	C
6984 NEW 	**MF**	8 ÷ 20	**374**		6HX	0°	B
6985 NEW 	**MF**	8 ÷ 20	**374**		6HX	50°	C
6986 NEW 	**UNC**	nr. 6 ÷ 3/8	**2184/1**		2BX	0°	B
6987 NEW 	**UNC**	nr. 6 ÷ 3/8	**2184/1**		2BX	50°	C
6988 NEW 	**UNF**	6 ÷ 3/8	**2184/1**		2BX	0°	B
6989 NEW 	**UNF**	6 ÷ 3/8	**2184/1**		2BX	50°	C
Multi Rapid HD - Multi HD							
6750 	**M**	3 ÷ 10	**371**		6H	0°	B
6755 	**M**	3 ÷ 10	**371**		6H	40°	C
6751 	**M**	12 ÷ 20	**376**		6H	0°	B
6756 	**M**	12 ÷ 20	**376**		6H	40°	C
6752 	**MF**	8 ÷ 20	**374**		6H	0°	B
6757 	**MF**	8 ÷ 20	**374**		6H	40°	C

MASCHINEN-GEWINDEBOHRER / MACHINE TAPS

BESCHICHTUNG COATING	KÜHLUNG INTERNAL COOLANT	SCHNEIDRICHTUNG CUTTING DIRECT.	SCHNEIDSTOFF TOOL MATERIAL	P	M	K	N	S	H	Seite Page
TC	-		HSS-Co-PM	●	●	-	❍	❍	-	313
TC	-		HSS-Co-PM	●	●	-	❍	❍	-	313
TC	-		HSS-Co-PM	●	●	-	❍	❍	-	314
TC	-		HSS-Co-PM	●	●	-	❍	❍	-	314
TC	-		HSS-Co-PM	●	●	-	❍	❍	-	315
TC	-		HSS-Co-PM	●	●	-	❍	❍	-	315
TC	-		HSS-Co-PM	●	●	-	❍	❍	-	316
TC	-		HSS-Co-PM	●	●	-	❍	❍	-	316
TC	-		HSS-Co-PM	●	●	-	❍	❍	-	317
TC	-		HSS-Co-PM	●	●	-	❍	❍	-	317
TN	-		HSS-Co-PM	●	❍	●	-	-	-	319
TN	-		HSS-Co-PM	●	❍	●	-	-	-	319
TN	-		HSS-Co-PM	●	❍	●	-	-	-	320
TN	-		HSS-Co-PM	●	❍	●	-	-	-	320
TN	-		HSS-Co-PM	●	❍	●	-	-	-	321
TN	-		HSS-Co-PM	●	❍	●	-	-	-	321

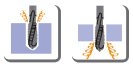
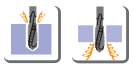
MASCHINEN-GEWINDEBOHRER MIT INNERER KÜHLMITTELZUFUHR
MACHINE TAPS WITH AXIAL INTERNAL COOLING

KAT.-NR. ITEM	SIMBOL SYMBOL	Ø mm	DIN	SACKLOCH / DURCHGANGSLOCH Blind hole/ Through hole	TOLERANZ TOLERANCE	DRALLWINKEL HELIX ANGLE	ANSCHNITT FORM CHAMFER FORM
Multi Rapid HD - Multi HD							
6993 NEW 	**UNC**	nr. 6 ÷ 3/8	**2184/1**		2B	0°	B
6994 NEW 	**UNC**	nr. 6 ÷ 3/8	**2184/1**		2B	40°	C
6995 NEW 	**UNF**	nr. 6 ÷ 3/8	**2184/1**		2B	0°	B
6996 NEW 	**UNF**	nr. 6 ÷ 3/8	**2184/1**		2B	40°	C
Multi Rapid HD i - Multi HD i							
6753 	**M**	6 ÷ 10	**371**		6H	0°	B
6772 	**M**	6 ÷ 10	**371**		6H	40°	C
6758 	**M**	12 ÷ 20	**376**		6H	0°	B
6777 	**M**	12 ÷ 20	**376**		6H	40°	C
Sincro Ilix i							
6975 	**M**	5 ÷ 10	**371**		6HX	0°	B
6971 	**M**	5 ÷ 10	**371**		6HX	15°	C
6973 	**M**	5 ÷ 10	**371**		6HX	40°	C
6972 	**M**	12 ÷ 20	**376**		6HX	15°	C
6974 	**M**	12 ÷ 20	**376**		6HX	40°	C
6978 	**MF**	8 ÷ 20	**374**		6HX	0°	B
6977 	**MF**	8 ÷ 20	**374**		6HX	40°	C

MASCHINEN-GEWINDEBOHRER MIT INNERER KÜHLMITTELZUFUHR
MACHINE TAPS WITH AXIAL INTERNAL COOLING

BESCHICHTUNG COATING	KÜHLUNG INTERNAL COOLANT	SCHNEIDRICHTUNG CUTTING DIRECT.	SCHNEIDSTOFF TOOL MATERIAL	P	M	K	N	S	H	Seite Page
TN	-		HSS-Co-PM	●	❍	●	-	-	-	322
TN	-		HSS-Co-PM	●	❍	●	-	-	-	322
TN	-		HSS-Co-PM	●	❍	●	-	-	-	323
TN	-		HSS-Co-PM	●	❍	●	-	-	-	323
TC TN			HSS-Co-PM	●	●	●	-	-	-	325
TC TN			HSS-Co-PM	●	●	●	-	-	-	326
TC TN			HSS-Co-PM	●	●	●	-	-	-	327
TC TN			HSS-Co-PM	●	●	●	-	-	-	328
TN			HSS-Co-PM	●	❍	●	●	❍	-	330
TN			HSS-Co-PM	●	❍	●	●	❍	-	330
TN			HSS-Co-PM	●	❍	●	●	❍	-	330
TN			HSS-Co-PM	●	❍	●	●	❍	-	331
TN			HSS-Co-PM	●	❍	●	●	❍	-	331
TN			HSS-Co-PM	●	❍	●	●	❍	-	332
TN			HSS-Co-PM	●	❍	●	●	❍	-	332

MASCHINEN-GEWINDEBOHRER / MACHINE TAPS

KAT.-NR. ITEM	SIMBOL SYMBOL	Ø mm	DIN	SACKLOCH / DURCHGANGSLOCH Blind hole/ Through hole	TOLERANZ TOLERANCE	DRALLWINKEL HELIX ANGLE	ANSCHNITT FORM CHAMFER FORM
Multi GG							
6964 	**M**	3 ÷ 10	**371**		6HX	0°	C
6965 	**M**	12 ÷ 30	**376**		6HX	0°	C
6966 	**MF**	8 ÷ 30	**374**		6HX	0°	C
Multi GG i ■ **Maschinen-Gewindebohrer mit radialem Kühlmittelaustritt /** Machine taps							
6967 	**M**	6 ÷ 10	**371**		6HX	0°	C
T-Black ■ **Mit Abschrägung TiCN TOP /** Back tapered TiCN TOP							
6668 	**M**	4 ÷ 10	**371**		6H	40°	C
6669 	**M**	12 ÷ 24	**376**		6H	40°	C
6830 	**MF**	6 ÷ 20	**374**		6H	40°	C
6831 	**UNC**	nr. 6 ÷ 3/8	**2184/1**		2B	40°	C
6832 	**UNC**	7/16 ÷ 2	**2184/1**		2B	40°	C
6833 	**UNF**	nr. 6 ÷ 3/8	**2184/1**		2B	40°	C
6834 	**UNF**	7/16 ÷ 1	**2184/1**		2B	40°	C
6835 	**BSP-G**	1/16 ÷ 1	**5156**		-	40°	C
VR i 15° ■ **Mit Innen Kühlung /** Internal Coolant							
6601 	**M**	6 ÷ 10	**371**		6HX	15°	C

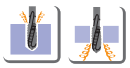
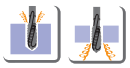
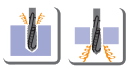
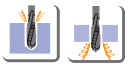
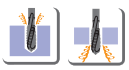
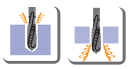
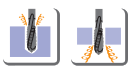
BESCHICHTUNG COATING	KÜHLUNG INTERNAL COOLANT	SCHNEIDRICHTUNG CUTTING DIRECT.	SCHNEIDSTOFF TOOL MATERIAL	P	M	K	N	S	H	Seite Page
-	-		HSS-Co-PM	-	-	●	❍	-	-	334
-	-		HSS-Co-PM	-	-	●	❍	-	-	335
-	-		HSS-Co-PM	-	-	●	❍	-	-	336
with radial coolant										
HL			HSS-Co-PM	-	-	●	❍	-	-	338
XB	-		HSS-Co-PM	●	●	●	●	❍	-	340
XB	-		HSS-Co-PM	●	●	●	●	❍	-	341
XB	-		HSS-Co-PM	●	●	●	●	❍	-	342
XB	-		HSS-Co-PM	●	●	●	●	❍	-	343
XB	-		HSS-Co-PM	●	●	●	●	❍	-	344
XB	-		HSS-Co-PM	●	●	●	●	❍	-	345
XB	-		HSS-Co-PM	●	●	●	●	❍	-	346
XB	-		HSS-Co-PM	●	●	●	●	❍	-	347
TN			HSS-Co-PM	●	●	●	●	❍	-	348

MASCHINEN-GEWINDEBOHRER / MACHINE TAPS

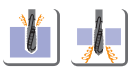
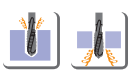
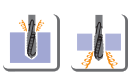
KAT.-NR. ITEM	SIMBOL SYMBOL	Ø mm	DIN	SACKLOCH / DURCHGANGSLOCH Blind hole/ Through hole	TOLERANZ TOLERANCE	DRALLWINKEL HELIX ANGLE	ANSCHNITT FORM CHAMFER FORM
Ti							
6683	**M**	3 ÷ 10	**371**		6HX	0°	B
6684	**M**	3 ÷ 10	**371**		6HX	15°	C
6825	**M**	12 ÷ 20	**376**		6HX	0°	B
6826	**M**	12 ÷ 20	**376**		6HX	15°	C
6828	**MF**	8 ÷ 20	**374**		6HX	0°	B
6829	**MF**	8 ÷ 20	**374**		6HX	15°	C
Ni							
6892	**M**	2 ÷ 10	**371**		6HX	0°	B
6894	**M**	3 ÷ 10	**371**		6HX	10°	C
6895	**M**	2 ÷ 10	**371**		6HX	22°	C
6893	**M**	12 ÷ 20	**376**		6HX	0°	B
6948 NEW	**M**	12	**376**		6HX	10°	C
6896	**M**	12 ÷ 20	**376**		6HX	22°	C
6906	**MJ**	3 ÷ 10	**371**		4HX	10°	C
6869	**UNC**	nr. 2 ÷ 3/8	**2184/1**		2BX	0°	B
6990 NEW	**UNC**	nr. 4 ÷ 3/8	**2184/1**		2BX	10°	C
6900	**UNC**	nr. 6 ÷ 3/8	**2184/1**		2BX	22°	C

BESCHICHTUNG COATING	KÜHLUNG INTERNAL COOLANT	SCHNEIDRICHTUNG CUTTING DIRECT.	SCHNEIDSTOFF TOOL MATERIAL	P	M	K	N	S	H	Seite Page
-	-		HSS-Co-PM	❍	-	-	-	●	-	350
-	-		HSS-Co-PM	❍	-	-	-	●	-	351
-	-		HSS-Co-PM	❍	-	-	-	●	-	352
-	-		HSS-Co-PM	❍	-	-	-	●	-	353
-	-		HSS-Co-PM	❍	-	-	-	●	-	354
-	-		HSS-Co-PM	❍	-	-	-	●	-	355
-	-		HSS-Co-PM	❍	-	-	-	●	-	357
-	-		HSS-Co-PM	❍	-	-	-	●	-	358
-	-		HSS-Co-PM	❍	-	-	-	●	-	359
-	-		HSS-Co-PM	❍	-	-	-	●	-	360
-	-		HSS-Co-PM	❍	-	-	-	●	-	361
-	-		HSS-Co-PM	❍	-	-	-	●	-	362
-	-		HSS-Co-PM	❍	-	-	-	●	-	363
-	-		HSS-Co-PM	❍	-	-	-	●	-	364
-	-		HSS-Co-PM	❍	-	-	-	●	-	365
-	-		HSS-Co-PM	❍	-	-	-	●	-	366

MASCHINEN-GEWINDEBOHRER / MACHINE TAPS

KAT.-NR. ITEM	SIMBOL SYMBOL	Ø mm	DIN	SACKLOCH / DURCHGANGSLOCH Blind hole/ Through hole	TOLERANZ TOLERANCE	DRALLWINKEL HELIX ANGLE	ANSCHNITT FORM CHAMFER FORM
Ni							
6897 	**UNC**	1/2 ÷ 3/4	**2184/1**		2BX	0°	B
6997 NEW 	**UNC**	7/16 ÷ 5/8	**2184/1**		2BX	10°	C
6998 NEW 	**UNJC**	nr. 6 ÷ 3/8	**2184/1**		3BX	10°	C
6844 	**UNF**	nr. 2 ÷ 3/8	**2184/1**		2BX	0°	B
6928 NEW 	**UNF**	nr. 6 ÷ 3/8	**2184/1**		2BX	10°	C
6846 	**UNF**	nr. 10 ÷ 3/8	**2184/1**		2BX	22°	C
6845 	**UNF**	7/16 ÷ 3/4	**2184/1**		2BX	0°	B
6929 NEW 	**UNF**	7/16 ÷ 5/8	**2184/1**		2BX	10°	C
6907 	**UNJF**	nr. 6 ÷ 3/8	**2184/1**		3BX	10°	C
Multi TP							
6770 	**M**	4 ÷ 12	**371**		6HX	0°	C

HSS-Co-PM
FORMER / COLD FORMING TAPS

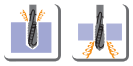
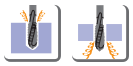
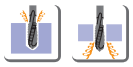
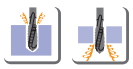
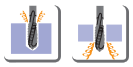
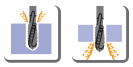
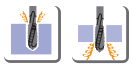
Former PM							
6800 	**M**	3 ÷ 10	**371**		6HX	-	C
6801 	**M**	6 ÷ 10	**371**		6HX	-	C
6969 	**M**	5 ÷ 10	**371**		6HX	-	C

MASCHINEN-GEWINDEBOHRER / MACHINE TAPS

BESCHICHTUNG COATING	KÜHLUNG INTERNAL COOLANT	SCHNEIDRICHTUNG CUTTING DIRECT.	SCHNEIDSTOFF TOOL MATERIAL	P	M	K	N	S	H	Seite Page
-	-		HSS-Co-PM	❍	-	-	-	●	-	367
-	-		HSS-Co-PM	❍	-	-	-	●	-	368
-	-		HSS-Co-PM	❍	-	-	-	●	-	369
-	-		HSS-Co-PM	❍	-	-	-	●	-	370
-	-		HSS-Co-PM	❍	-	-	-	●	-	371
-	-		HSS-Co-PM	❍	-	-	-	●	-	372
-	-		HSS-Co-PM	❍	-	-	-	●	-	373
-	-		HSS-Co-PM	❍	-	-	-	●	-	374
-	-		HSS-Co-PM	❍	-	-	-	●	-	375
TC	-		K10-K20	-	-	❍	-	-	●	377

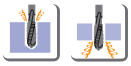
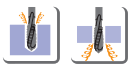
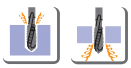
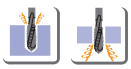
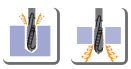
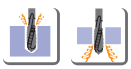
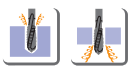
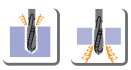
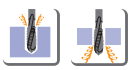
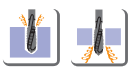
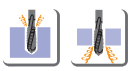
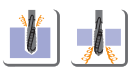
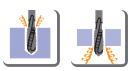
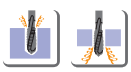
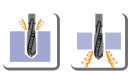
HSS-Co-PM
FORMER / COLD FORMING TAPS

TF	-		HSS-Co-PM	●	●	-	●	-	-	379
TN			HSS-Co-PM	●	●	-	●	-	-	380
TN			HSS-Co-PM	●	●	-	●	-	-	381

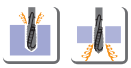
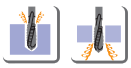
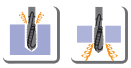
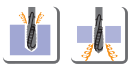
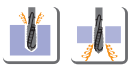
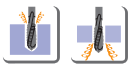
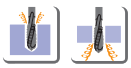
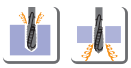
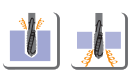
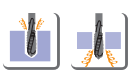
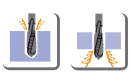
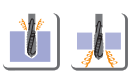
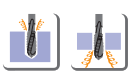
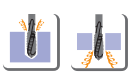
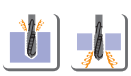
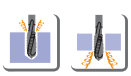
KAT.-NR. ITEM	SIMBOL SYMBOL	Ø mm	DIN	SACKLOCH / DURCHGANGSLOCH Blind hole/ Through hole	TOLERANZ TOLERANCE	DRALLWINKEL HELIX ANGLE	ANSCHNITT FORM CHAMFER FORM
Former ■ **Former /** Cold forming taps							
6788 	**M**	4 ÷ 10	**371**		6HX	-	C
N ■ **Gerade genutet /** Straight flutes							
6771 	**M**	3 ÷ 10	**371***		6HX	0°	C
6792 	**M**	12	**376***		6HX	0°	C
N ■ **15° rechtsdrall /** 15° Spiral flutes							
6736 	**M**	3 ÷ 10	**371***		6HX	15°	C
6759 	**M**	12	**376***		6HX	15°	C
6714 	**M**	12	**376***		6HX	15°	C
GG i ■ **Gerade genutet mit Kühlmittelaustritt Austritt axial /** Straight flutes with axial							
6760 	**M**	5 ÷ 10	**371***		6HX	0°	C
6763 	**M**	12	**376***		6HX	0°	C
6766 	**M**	8 ÷ 10	**374***		6HX	0°	C
6768 	**M**	12	**374***		6HX	0°	C
N i ■ **15° Rechtsdrall mit Kühlmittelaustritt Austritt axial /** 15° Spiral flutes with axial							
6762 	**M**	5 ÷ 10	**371***		6HX	15°	C
6765 	**M**	12	**376***		6HX	15°	C
6767 	**M**	8 ÷ 10	**374***		6HX	15°	C
6769 	**M**	12	**374***		6HX	15°	C

* Baumaße ähnlich DIN 371 - 374 (Innenkühlung ab M 6) / Dimensions similar to DIN 371/374/376 / Oil feed holes onwards from M 6)

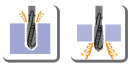
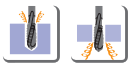
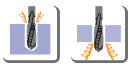
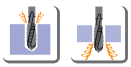
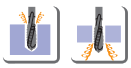
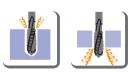
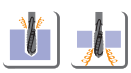
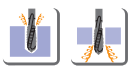
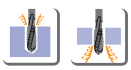
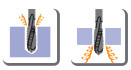
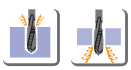
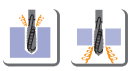
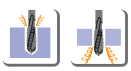
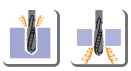
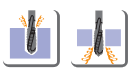
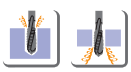
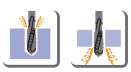
BESCHICHTUNG COATING	KÜHLUNG INTERNAL COOLANT	SCHNEIDRICHTUNG CUTTING DIRECT.	SCHNEIDSTOFF TOOL MATERIAL	P	M	K	N	S	H	Seite Page
-	-		K 20	●	●	-	●	-	-	382
-	-		K 20	-	-	●	●	-	-	384
-	-		K 20	-	-	●	●	-	-	385
-	-		K 20	-	-	●	-	-	-	384
-	-		K 20	-	-	●	-	-	-	385
-	-		K 20	-	-	●	-	-	-	385
internal coolant										
-			K 20	-	-	●	●	-	-	386
-			K 20	-	-	●	●	-	-	387
-			K 20	-	-	●	●	-	-	388
-			K 20	-	-	●	●	-	-	389
internal coolant										
-			K 20	-	-	●	●	-	-	386
-			K 20	-	-	●	●	-	-	387
-			K 20	-	-	●	●	-	-	388
-			K 20	-	-	●	●	-	-	389

KAT.-NR. ITEM	SIMBOL SYMBOL	Ø mm	DIN	SACKLOCH / DURCHGANGSLOCH Blind hole/ Through hole	TOLERANZ TOLERANCE	DRALLWINKEL HELIX ANGLE	ANSCHNITT FORM CHAMFER FORM
TP ■ **Gehärteter Stahl /** Hardened steels 54 - 63 HRC							
7015 	**M**	4 ÷ 12	-		4H-6H 6G-7G	0°	-
7016 	**M**	4 ÷ 12	-		4H-6H 6G-7G	0°	-
Micro ■ **Gewindefräser mit einer Reihe Gewindeprofil /** thread milling cutters with single							
7081 	**M**	1 ÷ 3,5	-		4H-6H 6G-7G	0°	-
7082 	**M**	1 ÷ 3,5	-		4H-6H 6G-7G	0°	-
7083 NEW 	**M**	1,2 ÷ 6	-		4H-6H 6G-7G	0°	-
Multi TM 27° ■ **Gewindefräser mit Innerer Kühlmittelzufuhr /** Thread milling with							
7000 	**M**	2 ÷ 10	-		6H 6G-7G	27°	-
7001 	**M**	6 ÷ 20	-		4H-6H 6G-7G	27°	-
7013 NEW 	**MJ**	4 ÷ 12	-		4H	27°	-
7002 	**MF**	4 ÷ 10	-		6H-6G	27°	-
7003 	**MF**	6 ÷ 12	-		6H-6G	27°	-
7007 	**UNC**	1/4 ÷ 1/2	-		2B-3B	27°	-
7009 	**UNF**	1/4 ÷ 1/2	-		2B-3B	27°	-
7014 NEW 	**UNJF**	10 ÷ 1/2	-		3B	27°	-
7005 	**BSP/G**	1/8 ÷ 3/8	-		-	27°	-
7010 	**NPT**	1/8 ÷ 1/2	-		-	27°	-
7012 	**NPTF**	1/8 ÷ 1/2	-		-	27°	-

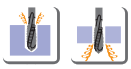
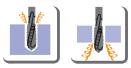
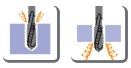
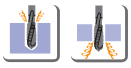
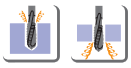
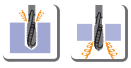
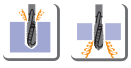
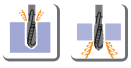
BESCHICHTUNG COATING	KÜHLUNG INTERNAL COOLANT	SCHNEIDRICHTUNG CUTTING DIRECT.	SCHNEIDSTOFF TOOL MATERIAL	P	M	K	N	S	H	Seite Page
TF	-		K 20	●	-	-	-	-	●	391
TF	-		K 20	●	-	-	-	-	●	392
ring of theeth										
TC	-		K 20	●	●	-	-	-	●	393
TC	-		K 20	●	●	-	-	-	●	394
TC	-		K 20	●	●	-	-	-	●	395
internal coolant										
-			K 20	●	●	●	●	●	●	396
TF			K 20	●	●	●	●	●	●	397
TF			K 20	●	●	●	●	●	●	398
TF			K 20	●	●	●	●	●	●	399
TF			K 20	●	●	●	●	●	●	400
TF			K 20	●	●	●	●	●	●	401
TF			K 20	●	●	●	●	●	●	402
TF			K 20	●	●	●	●	●	●	403
TF			K 20	●	●	●	●	●	●	404
TF			K 20	●	●	●	●	●	●	405
TF			K 20	●	●	●	●	●	●	406

KAT.-NR. ITEM	SIMBOL SYMBOL	Ø mm	DIN	SACKLOCH / DURCHGANGSLOCH Blind hole/ Through hole	TOLERANZ TOLERANCE	DRALLWINKEL HELIX ANGLE	ANSCHNITT FORM CHAMFER FORM
Multi TM 15° ■ Gewindefräser mit Innerer Kühlmittelzufuhr / Thread milling with							
7020 	**M**	M 8 ÷ M 20	-		4H-6H 6G-7G	15°	-
7027 	**UN**	1/2 ÷ 1	-		2B-3B	15°	-
7024 	**BPS/G**	1/4 ÷ 2"	-		-	15°	-
7030 	**NPT**	1/2 ÷ 2"	-		-	15°	-
7032 	**NPTF**	1/2 ÷ 2"	-		-	15°	-
Multi TM ■ Gewindefräser mit Innerer Kühlmittelzufuhr / Thread milling with							
6930 	**M**	16 ÷ 20	-		-	0°	-
6931 	**M**	12 ÷ 20	-		-	0°	-
6932 	**G**	1/2	-		-	0°	-
Multi CTM ■ Gewindefräser mit Senkfase und innerer Kühlmittelzufuhr / Thread							
7040 	**M**	2 ÷ 20	-		4H-6H 6G-7G	27°	-
7041 	**M**	2 ÷ 20	-		4H-6H 6G-7G	27°	-
7042 	**MF**	4 ÷ 16	-		6H-6G	27°	-
7043 	**MF**	4 ÷ 10	-		6H-6G	27°	-
7046 	**UNC**	nr. 8 ÷ 5/8	-		2B-3B	27°	-
7048 	**UNF**	nr. 10 ÷ 5/8	-		2B-3B	27°	-
7044 	**BSP/G**	1/8 ÷ 3/8	-		-	27°	-
7050 	**NPT**	1/8 ÷ 3/8	-		-	27°	-

BESCHICHTUNG COATING	KÜHLUNG INTERNAL COOLANT	SCHNEIDRICHTUNG CUTTING DIRECT.	SCHNEIDSTOFF TOOL MATERIAL	P	M	K	N	S	H	Seite Page
internal coolant										
TF			K 20	●	●	●	●	●	●	407
TF			K 20	●	●	●	●	●	●	408
TF			K 20	●	●	●	●	●	●	409
TF			K 20	●	●	●	●	●	●	410
TF			K 20	●	●	●	●	●	●	411
internal coolant										
TF			K 20	●	●	●	●	●	●	412
TF			K 20	●	●	●	●	●	●	413
TF			K 20	●	●	●	●	●	●	414
milling and countersinking with internal coolant										
TF			K 20	●	●	●	●	●	●	415
TF			K 20	●	●	●	●	●	●	416
TF			K 20	●	●	●	●	●	●	417
TF			K 20	●	●	●	●	●	●	418
TF			K 20	●	●	●	●	●	●	419
TF			K 20	●	●	●	●	●	●	420
TF			K 20	●	●	●	●	●	●	421
TF			K 20	●	●	●	●	●	●	422

KAT.-NR. ITEM	SIMBOL SYMBOL	Ø mm	DIN	SACKLOCH / DURCHGANGSLOCH Blind hole/ Through hole	TOLERANZ TOLERANCE	DRALLWINKEL HELIX ANGLE	ANSCHNITT FORM CHAMFER FORM
Multi CTM ■ Gewindefräser mit Senkfase und innerer Kühlmittelzufuhr / Thread							
7052 	**NPTF**	1/8 ÷ 3/8	-		-	27°	-
6933 	**M**	5 ÷ 16	-		-	27°	-
6935 	**M**	5 ÷ 16	-		-	27°	-
6934 	**MF**	6 ÷ 16	-		-	27°	-
6936 	**MF**	6 ÷ 16	-		-	27°	-
Multi DTM ■ 2 Schneiden zum Bohren Gewindefräsen und Senken mit innerer							
6940 	**M**	3 ÷ 16	-		4H-6H 6G	-	-
6942 	**M**	3 ÷ 16	-		4H-6H 6G	-	-
6947 	**M**	6 ÷ 16	-		4H-6H 6G	-	-
6944 	**MF**	5 ÷ 16	-		6H-6G	-	-
6946 	**MF**	5 ÷ 16	-		6H-6G	-	-
6943 	**MF**	8 ÷ 16	-		6H-6G	-	-
7068 	**UNC**	10 ÷ 5/8	-		2B-3B	-	-
7070 	**UNC**	10 ÷ 5/8	-		2B-3B	-	-
7064 	**UNF**	10 ÷ 5/8	-		2B-3B	-	-
7066 	**UNF**	10 ÷ 5/8	-		2B-3B	-	-
7060 	**BSP/G**	1/8 ÷ 3/8	-		-	-	-
7062 	**BSP/G**	1/8 ÷ 3/8	-		-	-	-

BESCHICHTUNG COATING	KÜHLUNG INTERNAL COOLANT	SCHNEIDRICHTUNG CUTTING DIRECT.	SCHNEIDSTOFF TOOL MATERIAL	P	M	K	N	S	H	Seite Page
milling and countersinking with internal coolant										
TF			K 20	●	●	●	●	●	●	423
TF			K 20	●	●	●	●	●	●	424
TF			K 20	●	●	●	●	●	●	425
TF			K 20	●	●	●	●	●	●	426
TF			K 20	●	●	●	●	●	●	427
Kühlmittelzufuhr / 2 flutes - Thread milling and countersinking with internal coolant										
TF			K 20	-	-	❍	●	-	-	428
TF			K 20	-	-	❍	●	-	-	429
TF			K 20	-	-	❍	●	-	-	430
TF			K 20	-	-	❍	●	-	-	431
TF			K 20	-	-	❍	●	-	-	432
TF			K 20	-	-	❍	●	-	-	433
TF			K 20	-	-	❍	●	-	-	434
TF			K 20	-	-	❍	●	-	-	435
TF			K 20	-	-	❍	●	-	-	436
TF			K 20	-	-	❍	●	-	-	437
TF			K 20	-	-	❍	●	-	-	438
TF			K 20	-	-	❍	●	-	-	439

KAT.-NR. ITEM	SIMBOL SYMBOL	Ø mm	DIN	SACKLOCH / DURCHGANGSLOCH Blind hole/ Through hole	TOLERANZ TOLERANCE	DRALLWINKEL HELIX ANGLE	ANSCHNITT FORM CHAMFER FORM
Multi DTM ■ 3 Schneiden zum Bohren Gewindefräsen und Senken mit innerer							
7071 	**M**	6 ÷ 16	-		4H-6H 6G	-	-
7073 	**M**	3 ÷ 16	-		4H-6H 6G	-	-
7075 	**M**	3 ÷ 16	-		4H-6H 6G	-	-
7077 	**M**	6 ÷ 16	-		4H-6H 6G	-	-
7072 	**MF**	10 ÷ 14	-		4H-6H 6G	-	-
7074 	**MF**	6 ÷ 16	-		6H-6G	-	-
7076 	**MF**	8 ÷ 16	-		6H-6G	-	-
7078 	**MF**	8 ÷ 16	-		6H-6G	-	-
Multi TMI ■ Stahlkörper für Gewindefräsplatten / Steel body for thread inserts							
6960 	**M-MF BSP-UN**	16 25	-	-	**A B**	1 2	0°
6961 	**M-MF BSP-UN**	16 20 25	-	-	**A A B**	1 1 2	0°
6963 	**M-MF BSP-UN**	22 27	-	-	**A B**	1 2	0°
6962 	**M-MF BSP-UN**	25	-	-	**A**	1	0°
6950 	**M-MF**	-	**0,50 - 3,50**	6H-6G 7G	-	-	-
6956 	**M-MF**	-	**1,0 - 4,0**	6H-6G 7G	-	-	-
6954 	**UN**	-	**12 - 16**	2B-3B	-	-	-
6952 	**BSF BSP/G**	-	**11 - 14**	-	-	-	-

BESCHICHTUNG COATING	KÜHLUNG INTERNAL COOLANT	SCHNEIDRICHTUNG CUTTING DIRECT.	SCHNEIDSTOFF TOOL MATERIAL	P	M	K	N	S	H	Seite Page
Kühlmittelzufuhr / 3 flutes - Thread milling and countersinking with internal coolant										
TF			K 20	-	-	❍	●	-	-	440
TF			K 20	-	-	❍	●	-	-	441
TF			K 20	-	-	❍	●	-	-	442
TF			K 20	-	-	❍	●	-	-	443
TF			K 20	-	-	❍	●	-	-	444
TF			K 20	-	-	❍	●	-	-	445
TF			K 20	-	-	❍	●	-	-	446
TF			K 20	-	-	❍	●	-	-	447
■ VHM Gewindefräsplatten / Solid carbide inserts										
-		-	-	-	-	-	-	-	-	448
-		-	-	-	-	-	-	-	-	448
-		-	-	-	-	-	-	-	-	448
-		-	-	-	-	-	-	-	-	448
TN	-	-	❍	❍	●	●	❍	-	-	449
TN	-	-	❍	❍	●	●	❍	-	-	450
TN	-	-	❍	❍	●	●	❍	-	-	451
TN	-	-	❍	❍	●	●	❍	-	-	452

KAT.-NR. ITEM		SIMBOL SYMBOL	Ø mm	STEIGUNG PITCH	TOLERANZ TOLERANCE	TYP TYPE	SCHNEIDEN CUTTING EDGE	DRALLWINKEL HELIX ANGLE
Multi TMI ■ **Stahlkörper für Gewindefräsplatten /** Steel bodyfor thread inserts								
6958		**BSF BSP/G**	-	**11 - 14**	-	**-**	-	-
Multi TMI EVOLUTION ■ **Stahlkörper für Gewindefräsplatten /** Steel body for								
6981	**NEW** 	**M-MF**	26		-	-	3	0°
6982	**NEW** 	**M-MF**	33		-	-	3	0°
6983	**NEW** 	**M-MF**	41		-	-	4	0°
6953	**NEW** 	**M-MF**	-	**1,0 - 4,0**	6H-6G 7G	-	-	-
6955	**NEW** 	**M-MF**	-	**1,0 - 5,0**	6H-6G 7G	-	-	-
6957	**NEW** 	**M-MF**	-	**2,0 - 6,0**	6H-6G 7G	-	-	-

BESCHICHTUNG COATING	KÜHLUNG INTERNAL COOLANT	SCHNEIDSTOFF TOOL MATERIAL	P	M	K	N	S	H	Seite Page
■ VHM Gewindefräsplatten / Solid carbide inserts									
TN	-	-	❍	❍	●	●	❍	-	**453**
thread inserts **■ VHM Gewindefräsplatten /** Solid carbide inserts									
-		-	-	-	-	-	-	-	**454**
-		-	-	-	-	-	-	-	**454**
-		-	-	-	-	-	-	-	**454**
TICN	-		●	●	●	●	●	-	**455**
TICN	-		●	●	●	●	●	-	**456**
TICN	-		●	●	●	●	●	-	**457**

Multi Rapid **VA** & Multi **VA**

Multi Rapid VA und Multi VA HSS Co-PM bieten eine bessere Stabilität und Zuverlässigkeit zur Bearbeitung von rostfreien Stählen.
Neue Geometrie sichert eine bessere Spankontrolle.

Multi Rapid VA and Multi VA HSS Co-PM taps offer better stability and reliability on stainless steel material.
New geometries ensure better chip control.

ANSCHNITT FORM B IST FÜR DUCHGANGSLOCH UND ANSCHNITT FORM C IST FÜR SACKLOCH GEWINDE
Form-B chamfer for through hole and Form-C chamfer for blind hole tapping

SPANWINKEL SPEZIELL KONSTRUIERT FÜR HOCHLEGIERTE CHROM STÄHLE
Rake angle specifically designed for high Chrome materials

SPANNUTENWINKEL 0 ° UND 50 ° FÜHRT ZU GERINGEREN SCHNITTKRÄFTEN, GERINGER SCHNITT TEMPERATUREN, SICHERE UND SCHNELLE SPANABFUHR.
Flute angle 0° and 50° results in lower cutting forces and reduced cutting temperatures and ensures a fast and efficient chip evacuation rate

QUALITÄT HSS CO-PM
Quality HSS Co-PM

TICN-BASIERTE PVD-BESCHICHTUNG MIT HOHER VERSCHLEISSFESTIGKEIT UND GERINGE HAFTUNG ZUR AUFSCHWEISSUNGEN DES ZU BEARBEITENDEN MATERIAL.
TiCN-based PVD coating with high wear resistance and low adhesion to abrasive steels

GEEIGNETE ZUM ARBEITEN MIT STARREN SPANNSYSTEMEN
Suitable for rigid tapping machining

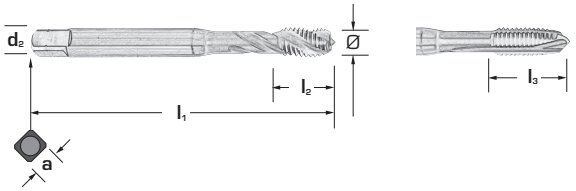
ILIX® PRECISION

DIN 371

Maschinen-Gewindebohrer mit verstärktem Schaft für Metrisches ISO-Regelgewinde nach DIN 13
Machine taps with reinforced shank for ISO metric coarse thread acc. to DIN 13 - New Geometry

Multi VA, Multi Rapid VA

M TICN



Typ / Type	Multi Rapid VA	Multi VA 50°
Toleranz Tolerance	6 HX	6 HX
Anschnittform / Anzahl der Gänge Chamfer form / No. of threads	B/4-5	C/2,5-3
Schneidrichtung Cutting direction		
Schneidstoff/ Material	HSS-Co-PM	HSS-Co-PM

Ø mm	Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	l_3 mm	d_2 mm h9	a mm h12	6773 TC	6774 TC
M 3	0,50	2,5	56	5	11	3,5	2,7	●	●
M 4	0,70	3,3	63	7	13	4,5	3,4	●	●
M 5	0,80	4,2	70	8	16	6,0	4,9	●	●
M 6	1,00	5,0	80	10	19	6,0	4,9	●	●
M 8	1,25	6,8	90	12	22	8,0	6,2	●	●
M 10	1,50	8,5	100	14	24	10,0	8,0	●	●

● Standardartikel / Items available ex stock

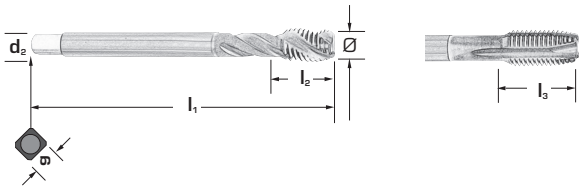
DIN 376

MULTI VA - MULTI RAPID VA

Maschinen-Gewindebohrer mit Überlaufschaft
für Metrisches ISO-Regelgewinde nach DIN 13
Machine taps with reduced shank
for ISO metric coarse thread acc. to DIN 13

Multi VA, Multi Rapid VA

M TICN



Typ / Type	Multi Rapid VA	Multi VA 50°
Toleranz Tolerance	6 HX	6 HX
Anschnittform / Anzahl der Gänge Chamfer form / No. of threads	B/4-5	C/2,5-3
Schneidrichtung Cutting direction		
Schneidstoff/ Material	HSS-Co-PM	HSS-Co-PM

Ø mm	Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	l_3 mm	d_2 mm h9	a mm h12	6778 TC	6779 TC
M 12	1,75	10,2	110	16	29	9,0	7,0	●	●
M 14	2,00	12,0	110	20	30	11,0	9,0	●	●
M 16	2,00	14,0	110	20	32	12,0	9,0	●	●
M 20	2,00	14,0	110	20	32	12,0	9,0	●	●

● Standardartikel / Items available ex stock

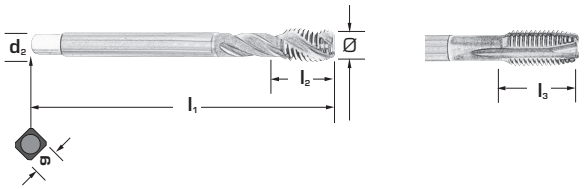
DIN 374

Maschinen-Gewindebohrer mit Überlaufschaft
für Metrisches ISO-Feingewinde nach DIN 13
Machine taps with reinforced shank
for ISO metric coarse thread acc. to DIN 13

Multi VA, Multi Rapid VA

MF TICN

NEW



Typ / Type	Multi Rapid VA	Multi VA 50°
Toleranz Tolerance	6 HX	6 HX
Anschnittform / Anzahl der Gänge Chamfer form / No. of threads	B/4-5	C/2,5-3
Schneidrichtung Cutting direction		
Schneidstoff/ Material	HSS-Co-PM	HSS-Co-PM

Ø mm	Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	l_3 mm	d_2 mm h9	a mm h12	6984 TC	6985 TC
MF 8	1,0	7,0	90	12	22	6	4,9	●	●
MF 10	1,0	9,0	90	14	20	7	5,5	●	●
MF 12	1,5	10,5	100	16	22	9	7,0	●	●
MF 16	1,5	14,5	100	20	22	12	9,0	●	●
MF 20	1,5	18,5	125	25	25	16	12,0	●	●

● Standardartikel / Items available ex stock

DIN 2184/1

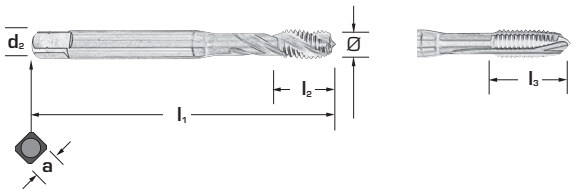
MULTI VA - MULTI RAPID VA

Maschinen-Gewindebohrer mit verstärktem Schaft
für unified-Gewinde (grob) UNC – ASME – B 1.1
Baumaße an DIN 371 angelehnt
Machine taps with reinforced shank
for unified coarse thread UNC - ASME – B 1.1
dimensions generally as per DIN 371

Multi VA, Multi Rapid VA

UNC TICN

NEW



	Multi Rapid VA	Multi VA 50°
Typ / Type		
Toleranz Tolerance	2 BX	2 BX
Anschnittform / Anzahl der Gänge Chamfer form / No. of threads	B/4-5	C/2,5-3
Schneidrichtung Cutting direction		
Schneidstoff/ Material	HSS-Co-PM	HSS-Co-PM

Ø mm			Gg/1" Tpi	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	l_3 mm	d_2 mm h9	a mm h12	6986 TC	6987 TC
UNC	nr. 6	-	32	2,85	56	6	13	4,0	3,0	●	●
UNC	nr. 8	-	32	3,50	63	7	13	4,5	3,4	●	●
UNC	nr. 10	-	24	3,90	70	8	16	6,0	4,9	●	●
UNC	1/4	-	20	5,10	80	10	17	7,0	5,5	●	●
UNC	5/16	-	18	6,60	90	12	20	8,0	6,2	●	●
UNC	3/8	-	16	8,00	90	12	20	10,0	8,0	●	●

● Standardartikel / Items available ex stock

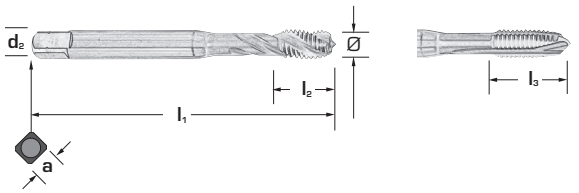
DIN 2184/1

Maschinen-Gewindebohrer mit verstärktem Schaft
für unified-Gewinde (fein) UNF – ASME – B 1.1
Baumaße an DIN 371 angelehnt
Machine taps with reinforced shank
for unified fine thread UNF – ASME – B 1.1
dimensions generally as per DIN 371

Multi VA, Multi Rapid VA

UNF TICN

NEW



Typ / Type	Multi Rapid VA	Multi VA 50°
Toleranz Tolerance	2 BX	2 BX
Anschnittform / Anzahl der Gänge Chamfer form / No. of threads	B/4-5	C/2,5-3
Schneidrichtung Cutting direction		
Schneidstoff / Material	HSS-Co-PM	HSS-Co-PM

Ø mm			Gg/1" Tpi	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	l_3 mm	d_2 mm h9	a mm h12	6988 TC	6989 TC
UNF	nr. 6	-	40	2,95	56	6	12	4,0	2,1	●	●
UNF	nr. 8	-	36	3,50	63	7	14	4,5	2,1	●	●
UNF	nr. 10	-	32	4,10	70	8	14	6,0	2,7	●	●
UNF	1/4	-	28	5,50	80	10	16	7,0	3,4	●	●
UNF	5/16	-	24	6,90	90	12	18	8,0	4,9	●	●
UNF	3/8	-	24	8,50	90	12	20	10,0	7,0	●	●

● Standardartikel / Items available ex stock

Multi Rapid **HD** & Multi **HD**

Multi Rapid und Multi HD HSS Co-PM bietet bessere Stabilität und Zuverlässigkeit zur Bearbeitung von Material bis zu 800 N/mm².

Multi Rapid HD and Multi HD HSS Co-PM taps offer better stability and reliability on materials with tensile strength up to 800 N/mm².

ANSCHNITT FORM B IST FÜR DUCHGANGSLOCH UND ANSCHNITT FORM C IST FÜR SACKLOCH GEWINDE
Form-B chamfer for through hole and Form-C chamfer for blind hole tapping

SPANWINKEL SPEZIELL KONSTRUIERT FÜR MATERIAL MIT NIEDRIGER BIS MITTLERER FESTIGKEIT.
Rake angle specifically designed for medium to high mechanical strength materials

SPANNUTENWINKEL 0 ° UND 40 ° FÜHRT ZU GERINGEREN SCHNITTKRÄFTEN UND SICHERE SCHNELLE UND LEISTUNGSFÄHIGE SPANABFUHR
Flute angle 0° and 40° results in lower cutting forces and ensures a fast and efficient chip evacuation rate

QUALITÄT HSS CO-PM
Quality HSS Co-PM

TIN-BASIS PVD-BESCHICHTUNG HAT EINE SEHR GUTE VERSCHLEISSFESTIGKEIT UND SPANABFUHR.
TiN-based PVD coating provides very good wear resistance and chip flow

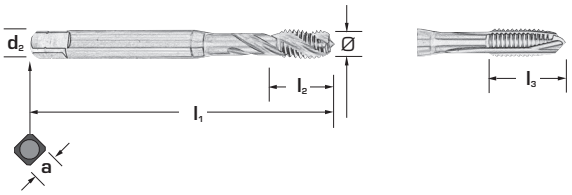
GEEIGNETE ZUM ARBEITEN MIT STARREN SPANNSYSTEMEN
Suitable for rigid tapping machining

ILIX® PRECISION

DIN 371

Maschinen-Gewindebohrer mit verstärktem Schaft
für Metrisches ISO-Regelgewinde nach DIN 13
Machine taps with reinforced shank
for ISO metric coarse thread acc. to DIN 13

Multi HD, Multi Rapid HD



Typ / Type	Multi Rapid HD	Multi HD 40°
Toleranz Tolerance	6 H	6 H
Anschnittform / Anzahl der Gänge Chamfer form / No. of threads	B/4-5	C/2,5-3
Schneidrichtung Cutting direction		
Schneidstoff/ Material	HSS-Co-PM	HSS-Co-PM

Ø mm	Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	l_3 mm	d_2 mm h9	a mm h12	6750 TN	6755 TN
M 3	0,5	2,5	56	5	11	3,5	2,7	●	●
M 4	0,7	3,3	63	7	13	4,5	3,4	●	●
M 5	0,8	4,2	70	8	16	6,0	4,9	●	●
M 6	1,0	5,0	80	10	19	6,0	4,9	●	●
M 8	1,3	6,8	90	12	22	8,0	6,2	●	●
M 10	1,5	8,5	100	14	24	10,0	8,0	●	●

● Standardartikel / Items available ex stock

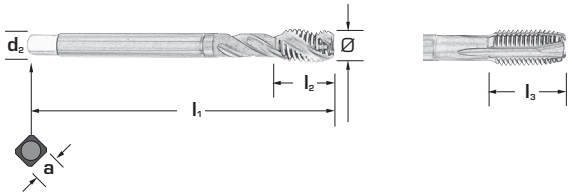
DIN 376

Maschinen-Gewindebohrer mit Überlaufschaft
für Metrisches ISO-Regelgewinde nach DIN 13
Machine taps with reduced shank
for ISO metric coarse thread acc. to DIN 13

MULTI HD - MULTI RAPID HD

Multi HD, Multi Rapid HD

M TiN



Typ / Type	Multi Rapid HD	Multi HD 40°
Toleranz Tolerance	6 H	6 H
Anschnittform / Anzahl der Gänge Chamfer form / No. of threads	B/4-5	C/2,5-3
Schneidrichtung Cutting direction		
Schneidstoff/ Material	HSS-Co-PM	HSS-Co-PM

Ø mm	Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	l_3 mm	d_2 mm h9	a mm h12	6751 TN	6756 TN
M 12	1,8	10,2	110	16	29	9	7	●	●
M 14	2,0	12,0	110	20	30	11	9	●	●
M 16	2,0	14,0	110	20	32	12	9	●	●
M 18	2,5	15,5	125	24	34	14	11	●	●
M 20	2,5	17,5	140	25	34	16	12	●	●

● Standardartikel / Items available ex stock

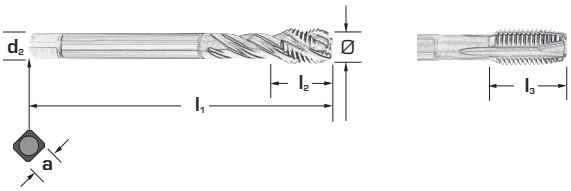
DIN 374

Maschinen-Gewindebohrer mit Überlaufschaft
für Metrisches ISO-Feingewinde nach DIN 13
Machine taps with reduced shank
for ISO metric coarse thread acc. to DIN 13

MULTI HD - MULTI RAPID HD

Multi HD, Multi Rapid HD

MF TiN



Typ / Type	Multi Rapid HD	Multi HD 40°
Toleranz Tolerance	6 H	6 H
Anschnittform / Anzahl der Gänge Chamfer form / No. of threads	B/4-5	C/2,5-3
Schneidrichtung Cutting direction		
Schneidstoff/ Material	HSS-Co-PM	HSS-Co-PM

Ø mm	Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	l_3 mm	d_2 mm h9	a mm h12	6752 TN	6757 TN
MF 8	1,0	7,0	90	12	22	6	4,9	●	●
MF 10	1,0	9,0	90	14	20	7	5,5	●	●
MF 12	1,5	10,5	100	16	22	9	7,0	●	●
MF 14	1,5	12,5	100	20	22	11	9,0	●	●
MF 16	1,5	14,5	100	20	22	12	9,0	●	●
MF 18	1,5	16,5	110	25	25	14	11,0	●	●
MF 20	1,5	18,5	125	25	25	16	12,0	●	●

● Standardartikel / Items available ex stock

DIN 2184/1

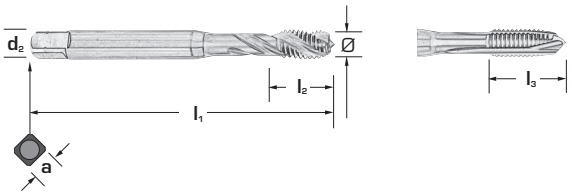
Maschinen-Gewindebohrer mit verstärktem Schaft
für unified-Gewinde (grob) UNC – ASME – B 1.1
Baumaße an DIN 371 angelehnt
Machine taps with reinforced shank
for unified coarse thread UNC - ASME – B 1.1
dimensions generally as per DIN 371

MULTI HD - MULTI RAPID HD

Multi HD, Multi Rapid HD

UNC TiN

NEW



	Multi Rapid HD	Multi HD 40°
Typ / Type		
Toleranz Tolerance	2 B	2 B
Anschnittform / Anzahl der Gänge Chamfer form / No. of threads	B/4-5	C/2,5-3
Schneidrichtung Cutting direction		
Schneidstoff/ Material	HSS-Co-PM	HSS-Co-PM

Ø mm	Gg/1" Tpi	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	l_3 mm	d_2 mm h9	a mm h12	6993 TN	6994 TN
UNC nr. 6	- 32	2,85	56	6	13	4,0	3,0	●	●
UNC nr. 8	- 32	3,50	63	7	13	4,5	3,4	●	●
UNC nr. 10	- 24	3,90	70	8	16	6,0	4,9	●	●
UNC 1/4	- 20	5,10	80	10	17	7,0	5,5	●	●
UNC 5/16	- 18	6,60	90	12	20	8,0	6,2	●	●
UNC 3/8	- 16	8,00	90	12	20	10,0	8,0	●	●

● Standardartikel / Items available ex stock

DIN 2184/1

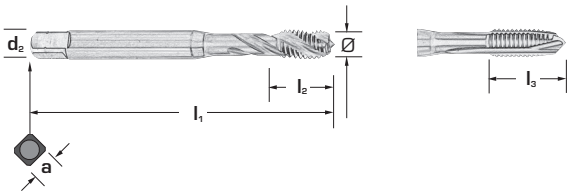
MULTI HD - MULTI RAPID HD

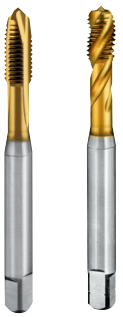
Maschinen-Gewindebohrer mit verstärktem Schaft
für unified-Gewinde (grob) UNF – ASME – B 1.1
Baumaße an DIN 371 fein
Machine taps with reinforced shank
for unified fine thread UNF – ASME – B 1.1
dimensions generally as per DIN 371

Multi HD, Multi Rapid HD

UNF TiN

NEW





Typ / Type	Multi Rapid HD	Multi HD 40°
Toleranz Tolerance	2 B	2 B
Anschnittform / Anzahl der Gänge Chamfer form / No. of threads	B/4-5	C/2,5-3
Schneidrichtung Cutting direction		
Schneidstoff / Material	HSS-Co-PM	HSS-Co-PM

Ø mm			Gg/1" Tpi	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a mm h12	6995 TN	6996 TN
UNF	nr. 6	-	40	2,95	56	6	4,0	2,1	●	●
UNF	nr. 8	-	36	3,50	63	7	4,5	2,1	●	●
UNF	nr. 10	-	32	4,10	70	8	6,0	2,7	●	●
UNF	1/4	-	28	5,50	80	10	7,0	3,4	●	●
UNF	5/16	-	24	6,90	90	12	8,0	4,9	●	●
UNF	3/8	-	24	8,50	90	12	10,0	7,0	●	●

● Standardartikel / Items available ex stock

Multi **RAPID HDi** & Multi **HDi**

HSS Co-PM Multi Rapid HDi und Multi HDi Gewindebohrer entwickelt für höhere Sicherheit bei höherer Schnittgeschwindigkeit, dank der Innenkühlung eine bessere Spanabfuhr und Temperaturkontrolle an der Schneide.

HSS Co-PM Multi Rapid HDi and Multi HDi taps are engineered for ensuring a better reliability when tapping at higher cutting speeds, thanks to coolant channels that ensure better chip evacuation and temperature control in the cutting zone.

ANSCHNITT FORM B IST FÜR DUCHGANGSLOCH UND ANSCHNITT FORM C IST FÜR SACKLOCH GEWINDE
Form-B chamfer for through hole and Form-C chamfer for blind hole tapping

SPANWINKEL SPEZIELL ENTWICKELT FÜR MATERIALIEN MIT MITTLERE UND HOHE MECHANISCHE FESTIGKEIT.
Rake angle specifically designed for medium high mechanical strength materials

DRALLWINKEL 0 ° UND 40 ° FÜHRT ZU GERINGEREN SCHNITTKRÄFTEN UND SICHERE SCHNELLE UND LEISTUNGSFÄHIGE SPANABFUHR
Flute angle 0° and 40° results in lower cutting forces and ensures a fast and efficient chip evacuation rate

METRISCHE GEWINDEABMESSUNGEN
Metric fine threading range

QUALITÄT HSS-CO-PM
Quality HSS Co-PM

TIN-AND TICN-BASIS PVD-BESCHICHTUNG HAT EINE SEHR GUTE VERSCHLEISSFESTIGKEIT UND SPANABFUHR.
TiN-and TiCN-based PVD coatings provide very good wear resistance and chip flow

IDEAL FÜR NIEDRIGE BIS HOHE FESTIGKEITEN IN MATERIALIEN WIE STAHL UND GRAU.- SPHÄROGUSS.
Ideal for medium to high resistance steel and grey and spheroidal cast iron materials

GEEIGNETE ZUM ARBEITEN MIT STARREN SPANNSYSTEMEN
Suitable for rigid tapping machining

ILIX® PRECISION

DIN 371

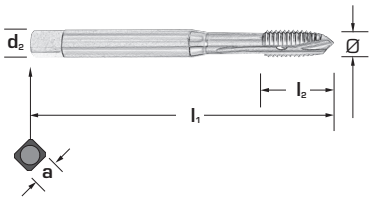
Maschinen-Gewindebohrer mit verstärktem Schaft und innenliegenden Kühlkanälen für Metrisches ISO-Regelgewinde nach DIN 13

Machine taps with reinforced shank and internal cooling for ISO metric coarse thread acc. to DIN 13

Multi Rapid HDi

M | TICN | TiN

Radialer Kühlmittelaustritt
radial cooling



Typ / Type	Multi Rapid HDi	Multi Rapid HDi
Toleranz Tolerance	6 H	6 H
Anschnittform / Anzahl der Gänge Chamfer form / No. of threads	B/4-5	B/4-5
Schneidrichtung Cutting direction		
Schneidstoff/ Material	HSS-Co-PM	HSS-Co-PM

Ø mm	Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a mm h12	6753 TN	6753 TC
M 6	1,00	5,0	80	19	6	4,9	●	●
M 8	1,25	6,8	90	22	8	6,2	●	●
M 10	1,50	8,5	100	24	10	8,0	●	●

● Standardartikel / Items available ex stock

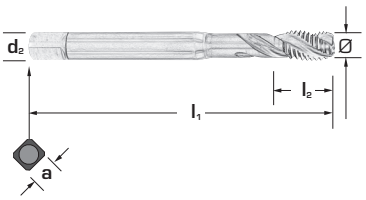
DIN 371

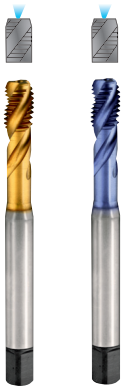
Maschinen-Gewindebohrer mit verstärktem Schaft und innenliegenden Kühlkanälen für Metrisches ISO-Regelgewinde nach DIN 13
Machine taps with reinforced shank and internal cooling for ISO metric coarse thread acc. to DIN 13

Multi HDi

M | TICN | TiN

Axialer Kühlmittelaustritt
Axial internal cooling





Typ / Type	Multi HDi 40°	Multi HDi 40°
Toleranz Tolerance	6 H	6 H
Anschnittform / Anzahl der Gänge Chamfer form / No. of threads	C/2,5-3	C/2,5-3
Schneidrichtung Cutting direction		
Schneidstoff/ Material	HSS-Co-PM	HSS-Co-PM

Ø mm	Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a mm h12	6772 TN	6772 TC
M 6	1,00	5,0	80	10	6	4,9	●	●
M 8	1,25	6,8	90	12	8	6,2	●	●
M 10	1,50	8,5	100	14	10	8,0	●	●

● Standardartikel / Items available ex stock

DIN 376

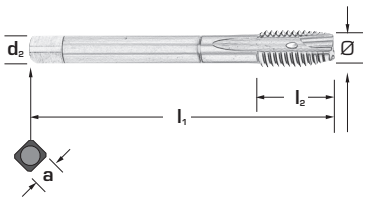
Maschinen-Gewindebohrer mit Überlaufschaft und innenliegenden Kühlkanälen für Metrisches ISO-Regelgewinde nach DIN 13

Machine taps with reduced shank and internal cooling for ISO metric coarse thread acc. to DIN 13

Multi Rapid HDi

M | TICN | TiN

Radialer Kühlmittelaustritt
radial cooling



Typ / Type	Multi Rapid HDi	Multi Rapid HDi
Toleranz Tolerance	6 H	6 H
Anschnittform / Anzahl der Gänge Chamfer form / No. of threads	B/4-5	B/4-5
Schneidrichtung Cutting direction		
Schneidstoff/ Material	HSS-Co-PM	HSS-Co-PM

Ø mm	Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a mm h12	6758 TN	6758 TC
M 12	1,75	10,2	110	29	9	7	●	●
M 14	2,00	12,0	110	30	11	9	●	●
M 16	2,00	14,0	110	32	12	9	●	●
M 18	2,50	15,5	125	34	14	11	●	●
M 20	2,50	17,5	140	34	16	12	●	●

● Standardartikel / Items available ex stock

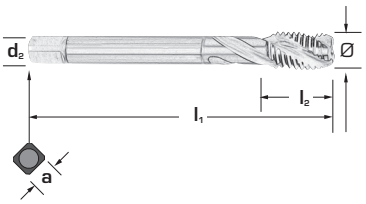
DIN 376

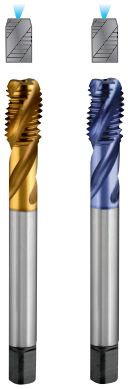
Maschinen-Gewindebohrer mit Überlaufschaft und innenliegenden Kühlkanälen für Metrisches ISO-Regelgewinde nach DIN 13
Machine taps with reduced shank and internal cooling for ISO metric coarse thread acc. to DIN 13

Multi HDi

M | TICN | TiN

Axialer Kühlmittelaustritt
Axial internal cooling





Typ / Type	Multi HDi 40°	Multi HDi 40°
Toleranz Tolerance	6 H	6 H
Anschnittform / Anzahl der Gänge Chamfer form / No. of threads	C/2,5-3	C/2,5-3
Schneidrichtung Cutting direction		
Schneidstoff/ Material	HSS-Co-PM	HSS-Co-PM

Ø mm	Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a mm h12	6777 TN	6777 TC
M 12	1,75	10,2	110	16	9	7	●	●
M 14	2,00	12,0	110	20	11	9	●	●
M 16	2,00	14,0	110	20	12	9	●	●
M 18	2,50	15,5	125	24	14	11	●	●
M 20	2,50	17,5	140	25	16	12	●	●

● Standardartikel / Items available ex stock

SINCRO ILIX i

Sincro Ilix HSS Co-PM Gewindebohrer wurden entwickelt mit einer Schafttoleranz h6 und Kühlkanälen mit axialen u. radialen Austritt.
Geeignet für Synchron Werkzeugspannsystem.

Sincro Ilix I HSS-Co-PM taps are engineered with shank tolerance h6, suitable for Sincro tool clamping system and are provided with both axial and radial internal coolant.

ANSCHNITT FORM B IST FÜR DUCHGANGSLOCH UND ANSCHNITT FORM C IST FÜR SACKLOCH GEWINDE.
Form-B chamfer for through hole and Form-C chamfer for blind hole tapping.

DRALLWINKEL 0 °, 15 ° UND 40 ° FÜR EINE OPTIMALE WAHL IN ABHÄNGIGKEIT VON DEN MATERIALEIGENSCHAFTEN.
Flute angle 0°, 15° and 40° for an optimal choice depending on the material features.

METRISCHE UND METRISCHFEIN - GEWINDEABMESSUNGEN.
Metric and Metric fine threading range.

QUALITÄT HSS-CO-PM
Quality HSS Co-PM

TIN-BASIS PVD-BESCHICHTUNG HAT EINE SEHR GUTE VERSCHLEISSFESTIGKEIT UND SPANABFUHR.
TiN-based PVD coatings provide very good wear resistance and chip flow.

IDEAL FÜR NIEDRIGE BIS HOHE FESTIGKEITEN IN MATERIALIEN WIE STAHL UND GRAU.- SPHÄROGUSS.
Ideal for low to high resistance steel and grey and spheroidal cast iron materials.

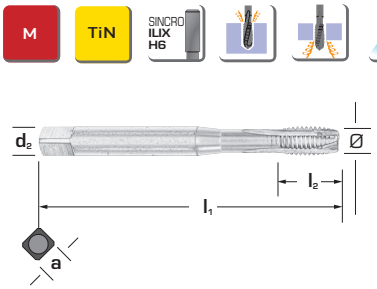
GEEIGNETE FÜR SYNCHRON SCHNEIDEN.
Suitable for synchronous tapping

ILIX® PRECISION

DIN 371

Maschinen-Gewindebohrer mit verstärktem Schaft
und innenliegenden Kühlkanälen
für Metrisches ISO-Regelgewinde nach DIN 13
Machine taps with reinforced shank
and internal cooling for ISO metric coarse thread acc. to DIN 13

Sincro Ilix i



Typ / Type	SINCRO	15° SINCRO	40° SINCRO
Toleranz Tolerance	6 HX	6 HX	6 HX
Anschnittform / Anzahl der Gänge Chamfer form / No. of threads	B/3,5-5	C/2-3	C/2-3
Schneidrichtung Cutting direction			
Schneidstoff/ Material	HSS-Co-PM	HSS-Co-PM	HSS-Co-PM

Ø mm	Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h6	a mm h12	6975 TN	6971 TN	6973 TN
M 5	0,80	4,2	70	10	6	4,9	●	●	●
M 6	1,00	5,0	80	11	6	4,9	●	●	●
M 8	1,25	6,8	90	13	8	6,2	●	●	●
M 10	1,50	8,5	100	15	10	8,0	●	●	●

● Standardartikel / Items available ex stock

DIN 376

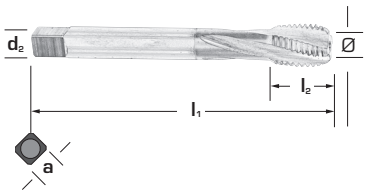
SINCRO ILIX i

Maschinen-Gewindebohrer mit Überlaufschaft
und innenliegenden Kühlkanälen
für Metrisches ISO-Regelgewinde nach DIN 13
Machine taps with reduced shank and internal cooling
for ISO metric coarse thread acc. to DIN 13

Sincro Ilix i

M | TiN | SINCRO ILIX H6

Axialer Kühlmittelaustritt
Axial internal cooling



Typ / Type	**15° SINCRO**	**40° SINCRO**
Toleranz Tolerance	**6 HX**	**6 HX**
Anschnittform / Anzahl der Gänge Chamfer form / No. of threads	**C/2-3**	**C/2-3**
Schneidrichtung Cutting direction		
Schneidstoff/ Material	**HSS-Co-PM**	**HSS-Co-PM**

Ø mm	Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h6	a mm h12	6972 TN	6974 TN
M 12	1,75	10,2	110	21	9	7	●	●
M 16	2,00	14,0	110	24	12	9	●	●
M 20	2,50	17,5	140	30	16	12	●	●

● Standardartikel / Items available ex stock

DIN 374

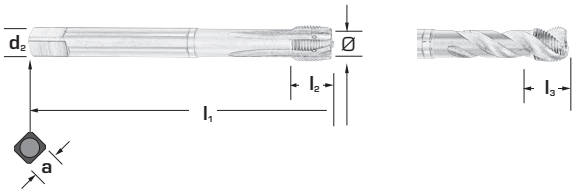
Maschinen-Gewindebohrer mit Überlaufschaft
und innenliegenden Kühlkanälen
für Metrisches ISO-Feingewinde nach DIN 13
Machine taps with reduced shank and internal cooling
for ISO metric fine thread as to DIN 13

Sincro Ilix i

MF TiN SINCRO ILIX H6

Radialer Kühlmittelaustritt
radial cooling

Axialer Kühlmittelaustritt
Axial internal cooling



Typ / Type	SINCRO	40° SINCRO
Toleranz Tolerance	6 HX	6 HX
Anschnittform / Anzahl der Gänge Chamfer form / No. of threads	B/3,5-5	C/2-3
Schneidrichtung Cutting direction		
Schneidstoff / Material	HSS-Co-PM	HSS-Co-PM

Ø mm	Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	l_3 mm	d_2 mm h6	a mm h12	6978 TN	6977 TN
MF 8	1,00	7,0	90	12	10	6	4,9	●	●
MF 10	1,00	9,0	90	12	10	8	6,2	●	●
MF 10	1,25	8,8	100	15	13	8	6,2	●	●
MF 12	1,00	10,8	100	12	10	10	8,0	●	●
MF 12	1,50	10,5	100	18	15	10	8,0	●	●
MF 14	1,00	13,0	100	12	10	12	9,0	●	●
MF 14	1,50	12,5	100	18	15	12	9,0	●	●
MF 16	1,00	15,0	100	12	10	12	9,0	●	●
MF 16	1,50	14,5	100	18	15	12	9,0	●	●
MF 18	1,50	16,5	110	18	15	14	11,0	●	●
MF 20	1,50	18,5	125	18	15	16	12,0	●	●

● Standardartikel / Items available ex stock

MULTI **GG**

HSS-Co-PM Gewindebohrer Multi GG Serie sind speziell für hohe Schnittgeschwindigkeit in allen Gusseisenwerkstoffe entwickelt.
Die geraden Nuten bieten ein besseren Drehwiderstand während des Schneidprozesses.

HSS-Co-PM taps Multi GG series are specifically engineered for high speed tapping on all cast iron types, the straight flutes offer a better torsional-resistance during the cutting process.

ANSCHNITT FORM C FÜR DURCHGANGS.- UND SACKLOCH GEWINDE
Form-C chamfer for both through and blind holes

METRISCHE UND METRISCHFEIN GEWINDEABMESSUNG
Metric and Metric fine threading range

QUALITÄT HSS-CO-PM
Quality HSS Co-PM

DIE NITRIERTE OBERFLÄCHENBEHANDLUNG BIETET AUSGEZEICHNETE VERSCHLEISSFESTIGKEIT IN DER TROCKENEN UND NASSEN ANWENDUNG
Nitriding surface treatment offers excellent wear resistance in dry and wet tapping

IDEAL FÜR GRAU.- UND KUGELGRAPHITGUSSEISENWERKSTOFFE
Ideal for grey and spheroidal cast iron materials

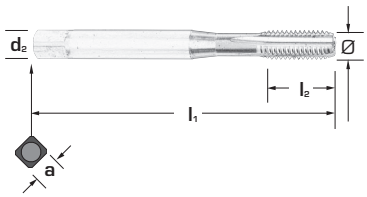
ILIX® PRECISION

DIN 371

MULTI GG

Maschinen-Gewindebohrer mit verstärktem Schaft
für Metrisches ISO-Regelgewinde nach DIN 13
Machine taps with reinforced shank
for ISO metric coarse thread as per DIN 13

Multi GG



Typ / Type	MULTI GG
Toleranz Tolerance	6 HX
Anschnittform / Anzahl der Gänge Chamfer form / No. of threads	C/2-3
Schneidrichtung Cutting direction	
Schneidstoff/ Material	HSS-Co-PM

Ø mm	Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a mm h12	6964
M 3,0	0,50	2,5	56	11	3,5	2,7	●
M 3,5	0,60	2,9	56	13	4,0	3,0	●
M 4,0	0,70	3,3	63	13	4,5	3,4	●
M 5,0	0,80	4,2	70	15	6,0	4,9	●
M 6,0	1,00	5,0	80	16	6,0	4,9	●
M 7,0	1,00	6,0	80	17	7,0	5,5	●
M 8,0	1,25	6,8	90	18	8,0	6,2	●
M 10,0	1,50	8,5	100	20	10,0	8,0	●

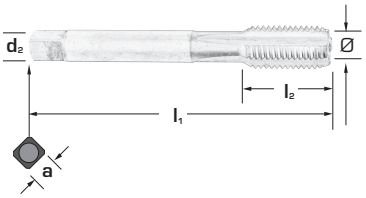
● Standardartikel / Items available ex stock

DIN 376

Maschinen-Gewindebohrer mit Überlaufschaft
für Metrisches ISO-Regelgewinde nach DIN 13
Machine taps with reduced shank
for ISO metric coarse thread as per DIN 13

MULTI GG

Multi GG



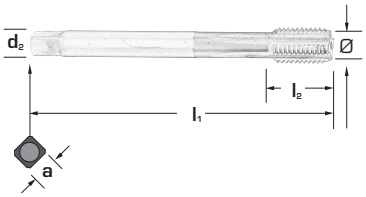
Typ / Type								MULTI GG
Toleranz Tolerance								6 HX
Anschnittform / Anzahl der Gänge Chamfer form / No. of threads								C/2-3
Schneidrichtung Cutting direction								
Schneidstoff/ Material								HSS-Co-PM
Ø mm		**Steigung** Pitch	**Kernloch Ø** Tap drill Ø	**l_1** mm	**l_2** mm	**d_2** mm h9	**a** mm h12	**6965**
M	12	1,75	10,2	110	24	9	7,0	●
M	14	2,00	12,0	110	26	11	9,0	●
M	16	2,00	14,0	110	28	12	9,0	●
M	18	2,50	15,5	125	34	14	11,0	●
M	20	2,50	17,5	140	32	16	12,0	●
M	22	2,50	19,5	140	34	18	14,5	●
M	24	3,00	21,0	160	38	18	14,5	●
M	27	3,00	24,0	160	38	20	16,0	●
M	30	3,50	26,5	180	45	22	18,0	●

● Standardartikel / Items available ex stock

DIN 374

Maschinen-Gewindebohrer mit Überlaufschaft
für Metrisches ISO-Feingewinde nach DIN 13
Machine taps with reduced shank
for ISO metric fine thread as to DIN 13

Multi GG



Typ / Type								MULTI GG
Toleranz Tolerance								6 HX
Anschnittform / Anzahl der Gänge Chamfer form / No. of threads								C/2-3
Schneidrichtung Cutting direction								
Schneidstoff/ Material								HSS-Co-PM
Ø mm		**Steigung** Pitch	**Kernloch Ø** Tap drill Ø	**l_1 mm**	**l_2 mm**	**d_2 mm h9**	**a mm h12**	**6966**
MF	**8**	1,00	7,0	90	18	6	4,9	●
MF	**9**	1,00	8,0	90	18	7	5,5	●
MF	**10**	1,00	9,0	90	15	7	5,5	●
MF	**10**	1,25	8,8	100	20	7	5,5	●
MF	**12**	1,50	10,5	100	18	9	7,0	●
MF	**14**	1,50	12,5	100	20	11	9,0	●
MF	**16**	1,50	14,5	100	20	12	9,0	●
MF	**18**	1,50	16,5	110	22	14	11,0	●
MF	**20**	1,50	18,5	125	22	16	12,0	●
MF	**22**	1,50	20,5	125	25	18	14,5	●
MF	**24**	1,50	22,5	140	25	18	14,5	●
MF	**30**	1,50	28,5	150	28	22	18,0	●

● Standardartikel / Items available ex stock

MULTI **GGi**

HSS Co-PM Gewindebohrer Multi GGi Serie sind speziell für hohe Schnittgeschwindigkeit in allen Gusseisenwerkstoffe, die geraden Nuten bieten ein besseren Drehwiderstand während des Schneidprozesses, ferner hilft die Innenkühlung den Span besser zu evakuieren und regelt Temperatur in der Schneidzone.

HSS Co-PM taps Multi GGi series are specifically engineered for high speed tapping on all cast iron types, the straight flutes offer a better torsional-resistance during the cutting process, furthermore the internal coolant helps along the chip evacuation and controls temperature in the cutting zone.

ANSCHNITT FORM C FÜR DURCHGANGS.- UND SACKLOCH GEWINDE
Form-C chamfer for both through and blind holes

METRISCHE GEWINDEABMESSUNG
Metric threading range

QUALITÄT HSS-CO-PM
Quality HSS Co-PM

HL BASIERTE PVD-BESCHICHTUNGEN BIETEN EINE SEHR GUTE VERSCHLEISSFESTIGKEIT BEI SEHR ABRASIVEN GUSSEISEN.
HL coating with pvd technology for a higher wear resistance on very abrasive cast iron

IDEAL FÜR GRAU.- UND KUGELGRAPHITGUSSEISENWERKSTOFFE
Ideal for grey and spheroidal cast iron materials

ILIX® PRECISION

DIN 371

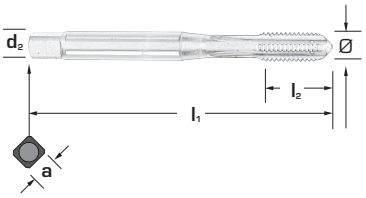
MULTI GGi

Maschinen-Gewindebohrer mit verstärktem Schaft und innenliegenden Kühlkanälen für Metrisches ISO-Regelgewinde nach DIN 13

Machine taps with reinforced shank and internal cooling for ISO metric coarse thread as per DIN 13

Multi GGi

Radialer Kühlmittelaustritt
radial cooling



Typ / Type								**MULTI GGi**
Toleranz Tolerance								**6 HX**
Anschnittform / Anzahl der Gänge Chamfer form / No. of threads								**C/2,5-3**
Schneidrichtung Cutting direction								
Schneidstoff/ Material								**HSS-Co-PM**
Ø mm		**Steigung** Pitch	**Kernloch Ø** Tap drill Ø	**l_1** mm	**l_2** mm	**d_2** mm h9	**a** mm h12	**6967 HL**
M	**6**	1,00	5,0	80	19	6	4,9	●
M	**8**	1,25	6,8	90	22	8	6,2	●
M	**10**	1,50	8,5	100	24	10	8,0	●

● Standardartikel / Items available ex stock

T-BLACK

T-Black HSS Co-PM Gewindebohrer sorgen für eine optimale Spankontrolle bei geringen Schnittkräften

T-Black HSS-Co-PM taps ensure an optimal chip control at low cutting forces.

ANSCHNITT FORM-C FÜR SACKLÖCHER BIS ZU 3 X D, MIT GEWINDEABSCHRÄGUNG
Form-C chamfer for blind holes up to 3xD back tapered

DRALLWINKEL 40 ° REDUZIERT DIE SCHNITTKRÄFTE UND BIETET EINE SCHNELLE UND EFFIZIENTE SPANABFUHR
Flute angle 40° reduces cutting forces and provides a fast and efficient chip evacuation

BREITE PALETTE VON GEWINDEARTEN
Wide range of threading types

QUALITÄT HSS-CO-PM
Quality HSS Co-PM

TIN-BASIERTE PVD BESCHICHTUNG BIETET EINE HOHE VERSCHLEISSFESTIGKEIT UND GUTEN SPANFLUSS
TiCN-based PVD offers a very gool wear resistance and chip flow

IDEAL FÜR NIEDRIG BIS MITTLERE ZUGFESTIGKEIT VON STAHL UND EDELSTAHL
Ideal for low to medium resistance steels and stainless steel materials

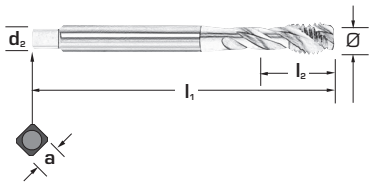
ILIX® PRECISION

DIN 371

T-BLACK

Maschinen-Gewindebohrer mit verstärktem Schaft
für Metrisches ISO-Regelgewinde nach DIN 13
Machine taps with reinforced shank
for ISO metric coarse thread as per DIN 13

T-BLACK



Typ / Type	TB 40°
Toleranz Tolerance	6H
Anschnittform / Anzahl der Gänge Chamfer form / No. of threads	C/2,5-3
Schneidrichtung Cutting direction	
Schneidstoff/ Material	HSS-Co-PM

Ø mm	Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a mm h12	6668 TB
M 4,0	0,70	3,3	63	7	4,5	3,4	●
M 5,0	0,80	4,2	70	8	6,0	4,9	●
M 6,0	1,00	5,0	80	10	6,0	4,9	●
M 8,0	1,25	6,8	90	12	8,0	6,2	●
M 10,0	1,50	8,5	100	14	10,0	8,0	●

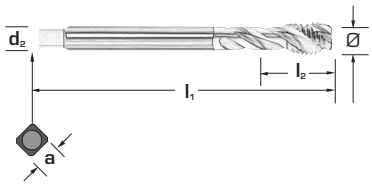
● Standardartikel / Items available ex stock

DIN 376

T-BLACK

Maschinen-Gewindebohrer mit Überlaufschaft
für Metrisches ISO-Regelgewinde nach DIN 13
Machine taps with reduced shank
for ISO metric coarse thread as per DIN 13

T-BLACK



Typ / Type	TB 40°
Toleranz Tolerance	6H
Anschnittform / Anzahl der Gänge Chamfer form / No. of threads	C/2,5-3
Schneidrichtung Cutting direction	
Schneidstoff/ Material	HSS-Co-PM

Ø mm	Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a mm h12	6669 TB
M 12	1,75	10,2	110	16	9	7,0	●
M 14	2,00	12,0	110	20	11	9,0	●
M 16	2,00	14,0	110	20	12	9,0	●
M 18	2,50	15,5	125	24	14	11,0	●
M 20	2,50	17,5	140	25	16	12,0	●
M 24	3,00	21,0	160	30	18	14,5	●

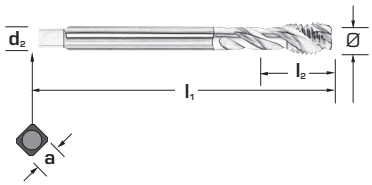
● Standardartikel / Items available ex stock

DIN 374

Maschinen-Gewindebohrer mit Überlaufschaft
für Metrisches ISO-Feingewinde nach DIN 13
Machine taps with reduced shank
for ISO metric fine thread as per DIN 13

T-BLACK

MF | TiCN Top



Typ / Type	TB 40°
Toleranz Tolerance	6H
Anschnittform / Anzahl der Gänge Chamfer form / No. of threads	C/2,5-3
Schneidrichtung Cutting direction	
Schneidstoff/ Material	HSS-Co-PM

Ø mm		Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a mm h12	6830 TB
MF	6	0,75	5,2	80	10	4,5	3,4	●
MF	8	1,00	7,0	90	12	6,0	4,9	●
MF	9	1,00	8,0	90	12	7,0	5,5	●
MF	10	1,00	9,0	90	14	7,0	5,5	●
MF	10	1,25	8,8	100	14	7,0	5,5	●
MF	11	1,00	10,0	90	14	8,0	6,2	●
MF	12	1,00	11,0	100	16	9,0	7,0	●
MF	12	1,25	10,8	100	16	9,0	7,0	●
MF	12	1,50	10,5	100	16	9,0	7,0	●
MF	14	1,50	12,5	100	20	11,0	9,0	●
MF	16	1,50	14,5	100	20	12,0	9,0	●
MF	18	1,50	16,5	110	25	14,0	11,0	●
MF	20	1,50	19,0	125	25	16,0	12,0	●

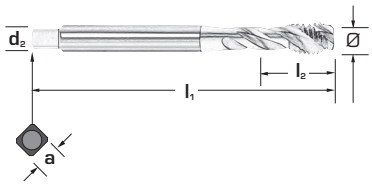
● Standardartikel / Items available ex stock

DIN 2184/1

Maschinen-Gewindebohrer mit verstärktem Schaft
für unified-Gewinde (grob) UNC – ASME – B 1.1
Baumaße an DIN 371 angelehnt
Machine taps with reinforced shank
for unified coarse thread UNC - ASME – B 1.1
dimensions generally as per DIN 371

T-BLACK

UNC | TiCN Top



Typ / Type	TB 40°
Toleranz Tolerance	2B
Anschnittform / Anzahl der Gänge Chamfer form / No. of threads	C/2,5-3
Schneidrichtung Cutting direction	
Schneidstoff / Material	HSS-Co-PM

Ø mm			Gg/1" Tpi	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a mm h12	6831 TB
UNC	nr. 6	-	32	2,85	56	6	4,0	3,0	●
UNC	nr. 8	-	32	3,50	63	7	4,5	3,4	●
UNC	nr. 10	-	24	3,90	70	8	6,0	4,9	●
UNC	nr. 12	-	24	4,50	80	10	6,0	4,9	●
UNC	1/4		20	5,10	80	10	7,0	5,5	●
UNC	5/16		18	6,60	90	12	8,0	6,2	●
UNC	3/8		16	8,00	90	12	10,0	8,0	●

● Standardartikel / Items available ex stock

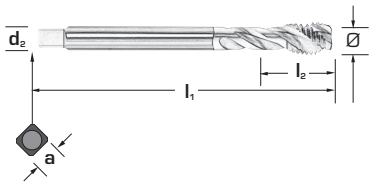
DIN 2184/1

T-BLACK

Maschinen-Gewindebohrer mit Überlaufschaft
für unified-Gewinde (grob) UNC – ASME – B 1.1
Baumaße an DIN 371 angelehnt
Machine taps with reduced shank
for unified coarse thread UNC - ASME – B 1.1
dimensions generally as per DIN 376

T-BLACK

UNC | TiCN Top



Typ / Type	TB 40°
Toleranz Tolerance	2B
Anschnittform / Anzahl der Gänge Chamfer form / No. of threads	C/2,5-3
Schneidrichtung Cutting direction	
Schneidstoff / Material	HSS-Co-PM

Ø mm		Gg/1" Tpi	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a mm h12	6832 TB
UNC 7/16	-	14	9,40	100	24	8	6,2	●
UNC 1/2	-	13	10,80	110	29	9	7,0	●
UNC 9/16	-	12	12,20	110	30	11	9,0	●
UNC 5/8	-	11	13,50	110	32	12	9,0	●
UNC 3/4	-	10	16,50	125	34	14	11,0	●
UNC 7/8	-	9	19,50	140	34	18	14,5	●
UNC 1	-	8	22,25	160	38	18	14,5	●
UNC 1 1/4	-	7	28,00	180	36	22	18,0	●
UNC 1 1/2	-	6	34,00	200	42	32	24,0	●
UNC 2	-	4 1/2	45,00	250	56	40	32,0	●

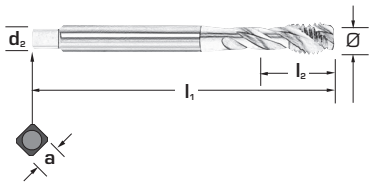
● Standardartikel / Items available ex stock

DIN 2184/1

Maschinen-Gewindebohrer mit verstärktem Schaft
für unified-Gewinde (fein) UNF – ASME – B 1.1
Baumaße an DIN 371 angelehnt
Machine taps with reinforced shank
for unified fine thread UNF – ASME – B 1.1
dimensions generally as per DIN 371

T-BLACK

UNF | TiCN Top



Typ / Type	TB 40°
Toleranz Tolerance	2B
Anschnittform / Anzahl der Gänge Chamfer form / No. of threads	C/2,5-3
Schneidrichtung Cutting direction	
Schneidstoff / Material	HSS-Co-PM

Ø mm			Gg/1" Tpi	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a mm h12	6833 TB
UNF	nr. 6	-	40	2,95	56	6	4,0	2,1	●
UNF	nr. 8	-	36	3,50	63	7	4,5	2,1	●
UNF	nr. 10	-	32	4,10	70	8	6,0	2,7	●
UNF	nr. 12	-	28	4,70	80	10	6,0	3,0	●
UNF	nr. 1/4	-	28	5,50	80	10	7,0	3,4	●
UNF	nr. 5/16	-	24	6,90	90	12	8,0	4,9	●
UNF	nr. 3/8	-	24	8,50	90	12	10,0	7,0	●

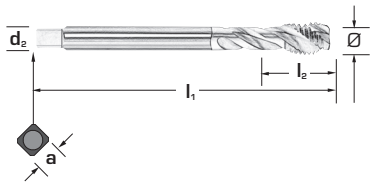
● Standardartikel / Items available ex stock

DIN 2184/1

Maschinen-Gewindebohrer mit Überlaufschaft
für unified-Gewinde (grob) UNF – ASME – B 1.1
Baumaße an DIN 371 fein
Machine taps with reduced shank
for unified fine thread UNF – ASME – B 1.1
dimensions generally as per DIN 376

T-BLACK

UNF | TiCN Top



Typ / Type	TB 40°
Toleranz Tolerance	2B
Anschnittform / Anzahl der Gänge Chamfer form / No. of threads	C/2,5-3
Schneidrichtung Cutting direction	
Schneidstoff/ Material	HSS-Co-PM

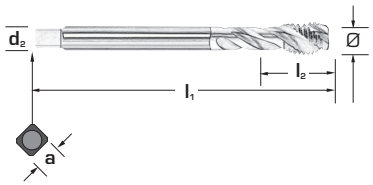
Ø mm			Gg/1" Tpi	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	$d_2$mm h9	a mm h12	6834 TB
UNF	7/16	-	20	9,90	90	14,0	8,0	6,2	●
UNF	1/2	-	20	11,50	100	16,0	9,0	7,0	●
UNF	9/16	-	18	12,90	100	20,0	11,0	9,0	●
UNF	5/8	-	18	14,50	100	20,0	12,0	9,0	●
UNF	3/4	-	16	17,50	110	25,0	14,0	11,0	●
UNF	7/8	-	14	20,40	125	25,0	18,0	14,5	●
UNF	1	-	12	23,25	140	25,0	18,0	14,5	●

● Standardartikel / Items available ex stock

DIN 5156

Maschinen-Gewindebohrer mit Überlaufschaft für Rohrgewinde nach DIN 259 und DIN-ISO 228
Machine taps with reduced shank for British standard Pipe thread as per DIN 259 and DIN-ISO 228

T-BLACK



Typ / Type	TB 40°
Toleranz Tolerance	-
Anschnittform / Anzahl der Gänge Chamfer form / No. of threads	C/2,5-3
Schneidrichtung Cutting direction	
Schneidstoff/ Material	HSS-Co-PM

Ø mm		Gg/1" Tpi	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	$d_2$mm h9	a mm h12	6835 TB
G 1/16	-	28	6,80	90	12	6	4,9	●
G 1/8	-	28	8,80	90	14	7	5,5	●
G 1/4	-	19	11,80	100	20	11	9,0	●
G 3/8	-	19	15,25	100	20	12	9,0	●
G 1/2	-	14	19,00	125	25	16	12,0	●
G 5/8	-	14	21,00	125	25	18	14,5	●
G 3/4	-	14	24,50	140	28	20	16,0	●
G 7/8	-	14	28,25	150	28	22	18,0	●
G 1	-	11	30,75	160	30	25	20,0	●

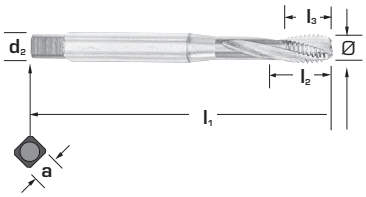
● Standardartikel / Items available ex stock

DIN 371

Maschinen-Gewindebohrer mit verstärktem Schaft und innenliegenden Kühlkanälen für Metrisches ISO-Regelgewinde nach DIN 13
Machine taps with reinforced shank for ISO metric coarse thread as per DIN 13

VR i

M TiN **Axialer Kühlmittelaustritt**
Axial internal cooling



Typ / Type									**VR i 15°**
Toleranz Tolerance									**6 HX**
Anschnittform / Anzahl der Gänge Chamfer form / No. of threads									**C/2,5-3**
Schneidrichtung Cutting direction									
Schneidstoff / Material									**HSS-Co-PM**
Ø mm		**Steigung** Pitch	**Kernloch Ø** Tap drill Ø	**l_1 mm**	**l_2 mm**	**l_3 mm**	**d_2 mm h6**	**a mm h12**	**6601 TN**
M	6	1,00	5,0	80	19	10	6	4,9	●
M	8	1,25	6,8	90	22	12	8	6,2	●
M	10	1,50	8,5	100	24	14	10	8,0	●

● Standardartikel / Items available ex stock

Ti

Ti HSS-Co-PM Gewindebohrer speziell für hitzebeständige Materialien in der Luftfahrt und der biomedizinischen Industrie entwickelt.

Ti HSS-Co-PM taps are specifically engineered for tapping heat resistance materials in aerospace and biomedical industry.

SPANWINKEL 15° FÜR LEICHTES SCHNEIDEN UND NIEDRIGER SCHNITTTEMPERATUR AN DEN SCHNEIDKANTEN
Rake angle 15° for a soft cut lows temperature at the cutting edge

TYPISCH FÜR DIE LUFTFAHRTINDUSTRIE SEHR GENAUE TOLERANZEN
Very precise tolerances typical of the aerospace industry

QUALITÄT HSS-CO-PM
Quality HSS-Co-PM

NITRID-OBERFLÄCHENBEHANDLUNG, UM DIE REIBUNG ZU REDUZIEREN
Nitrated surface treatment in order to reduce the friction rates

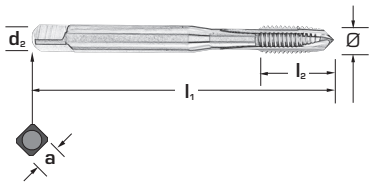
IDEAL FÜR TITAN UND TITANLEGIERUNGEN
Ideal for Titanium and Titanium alloys materials

ILIX® PRECISION

DIN 371

Maschinen-Gewindebohrer mit verstärktem Schaft
für Metrisches ISO-Regelgewinde nach DIN 13
Machine taps with reinforced shank
for ISO metric coarse thread as per DIN 13

Ti



Typ / Type	Ti
Toleranz Tolerance	6 HX
Anschnittform / Anzahl der Gänge Chamfer form / No. of threads	B/4-5
Schneidrichtung Cutting direction	
Schneidstoff/ Material	HSS-Co-PM

Ø mm	Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a mm h12	6683
M 3	0,50	2,50	56	11	3,50	2,70	●
M 3,5	0,60	2,90	56	13	4,00	3,00	●
M 4	0,70	3,30	63	13	4,50	3,40	●
M 5	0,80	4,20	70	16	6,00	4,90	●
M 6	1,00	5,00	80	19	6,00	4,90	●
M 7	1,00	6,00	80	19	7,00	5,50	●
M 8	1,25	6,80	90	22	8,00	6,20	●
M 10	1,50	8,50	100	24	10,00	8,00	●

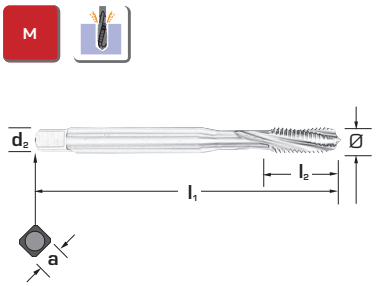
Ti:
für Titanlegierung
for Titanium alloys

● Standardartikel / Items available ex stock

DIN 371

Maschinen-Gewindebohrer mit verstärktem Schaft
für Metrisches ISO-Regelgewinde nach DIN 13
Machine taps with reinforced shank
for ISO metric coarse thread as per DIN 13

Ti



Typ / Type	Ti 15°
Toleranz Tolerance	6H
Anschnittform / Anzahl der Gänge Chamfer form / No. of threads	C/2,5-3
Schneidrichtung Cutting direction	
Schneidstoff/ Material	HSS-Co-PM

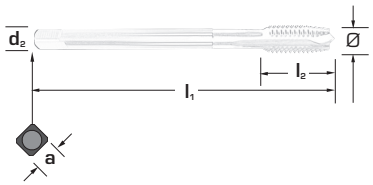
Ø mm	Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a mm h12	6684
M 3	0,50	2,50	56	5	3,5	2,7	●
M 3,5	0,60	2,90	56	6	4,0	3,0	●
M 4	0,70	3,30	63	7	4,5	3,4	●
M 5	0,80	4,20	70	8	6,0	4,9	●
M 6	1,00	5,00	80	10	6,0	4,9	●
M 7	1,00	6,00	80	10	7,0	5,5	●
M 8	1,25	6,80	90	12	8,0	6,2	●
M 10	1,50	8,50	100	14	10,0	8,0	●

● Standardartikel / Items available ex stock

DIN 376

Maschinen-Gewindebohrer mit Überlaufschaft
für Metrisches ISO-Regelgewinde nach DIN 13
Machine taps with reduced shank
for ISO metric coarse thread as per DIN 13

Ti



	Ti
Typ / Type	
Toleranz Tolerance	6 HX
Anschnittform / Anzahl der Gänge Chamfer form / No. of threads	B/4-5
Schneidrichtung Cutting direction	
Schneidstoff/ Material	HSS-Co-PM

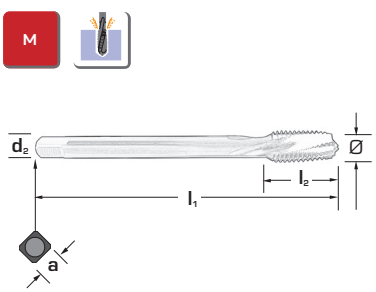
Ø mm		Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a mm h12	6825
M	12	1,75	10,2	110	29	9	7	●
M	16	2,00	14,0	110	32	12	9	●
M	20	2,50	17,5	140	34	16	12	●

● Standardartikel / Items available ex stock

DIN 376

Maschinen-Gewindebohrer mit Überlaufschaft
für Metrisches ISO-Regelgewinde nach DIN 13
Machine taps with reduced shank
for ISO metric coarse thread as per DIN 13

Ti



Typ / Type	Ti 15°
Toleranz Tolerance	6 HX
Anschnittform / Anzahl der Gänge Chamfer form / No. of threads	C 2,5-3
Schneidrichtung Cutting direction	
Schneidstoff/ Material	HSS-Co-PM

Ø mm	Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a mm h12	6826
M 12	1,75	10,2	110	29	9	7	●
M 16	2,00	14,0	110	32	12	9	●
M 20	2,50	17,5	140	34	16	12	●

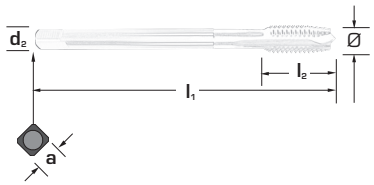
● Standardartikel / Items available ex stock

DIN 374

Maschinen-Gewindebohrer mit Überlaufschaft
für Metrisches ISO-Feingewinde nach DIN 13
Machine taps with reduced shank
for ISO metric fine thread as per DIN 13

Ti

MF



	Ti
Typ / Type	
Toleranz Tolerance	6 HX
Anschnittform / Anzahl der Gänge Chamfer form / No. of threads	B/4-5
Schneidrichtung Cutting direction	
Schneidstoff/ Material	HSS-Co-PM

Ø mm		Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a mm h12	6828
MF	8	1,00	7,0	90	22	6	4,9	●
MF	10	1,00	9,0	90	20	7	5,5	●
MF	12	1,00	11,0	100	22	9	7,0	●
MF	12	1,50	10,5	100	22	9	7,0	●
MF	14	1,50	12,5	100	22	11	9,0	●
MF	16	1,50	14,5	100	22	12	9,0	●
MF	18	1,50	16,5	110	25	14	11,0	●
MF	20	1,50	18,5	125	25	16	12,0	●

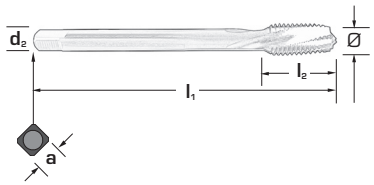
● Standardartikel / Items available ex stock

DIN 374

Maschinen-Gewindebohrer mit Überlaufschaft
für Metrisches ISO-Feingewinde nach DIN 13
Machine taps with reduced shank
for ISO metric fine thread as per DIN 13

Ti

MF



	Ti 15°
Typ / Type	
Toleranz Tolerance	6 HX
Anschnittform / Anzahl der Gänge Chamfer form / No. of threads	C/2,5-3
Schneidrichtung Cutting direction	
Schneidstoff/ Material	HSS-Co-PM

Ø mm	Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a mm h12	6829
MF 8	1,00	7,0	90	22	6	4,9	●
MF 10	1,00	9,0	90	20	7	5,5	●
MF 12	1,00	11,0	100	22	9	7,0	●
MF 12	1,50	10,5	100	22	9	7,0	●
MF 14	1,50	12,5	100	22	11	9,0	●
MF 16	1,50	14,5	100	22	12	9,0	●
MF 18	1,50	16,5	110	25	14	11,0	●
MF 20	1,50	18,5	125	25	16	12,0	●

● Standardartikel / Items available ex stock

Ni

Ni HSS-Co-PM Gewindebohrer speziell für hitzebeständige Materialien in der Luftfahrt Industrie entwickelt.
ILIX 10 Grad spiral getutet Gewindebohrer aus dieser Reihe sind mit Spanbrecher zur Verbesserung der Spankontrolle, dieses ermöglicht die Anwendung der Gewindebohrer in Sack.- u. Durchgangslöcher.

Ni HSS-Co-PM taps are specifically engineered for tapping heat resistance materials in aerospace and energy industry.
ILIX 10 degrees taps from our range are provided with chipbreaker for improving the chip control, this allows the use of these taps for both blind and through holes applications.

TYPISCH FÜR DIE LUFTFAHRTINDUSTRIE SEHR GENAUE TOLERANZEN.
Very precise tolerances typical of the aerospace industry.

QUALITÄT HSS-CO-PM
Quality HSS-Co-PM

GELÄPPTE OBERFLÄCHE REDUZIERT DIE REIBUNG.
Lapping surface treatment reduces the friction rates.

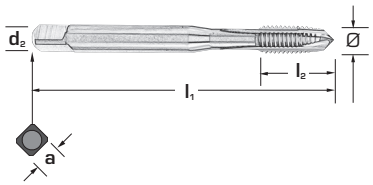
IDEAL FÜR NICKEL UND TITAN BASIS LEGIERUNGEN.
Ideal for Nichel.

ILIX® PRECISION

DIN 371

Maschinen-Gewindebohrer mit verstärktem Schaft
für Metrisches ISO-Regelgewinde nach DIN 13
Machine taps with reinforced shank
for ISO metric coarse thread as per DIN 13

Ni



	Ni
Typ / Type	
Toleranz Tolerance	6 HX
Anschnittform / Anzahl der Gänge Chamfer form / No. of threads	B/4-5
Schneidrichtung Cutting direction	
Schneidstoff/ Material	HSS-Co-PM

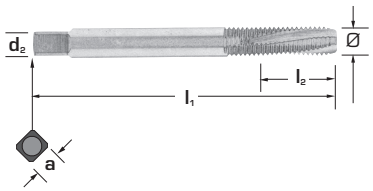
Ø mm	Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a mm h12	6892
M 2	0,40	1,60	45	8	2,8	2,1	●
M 2,5	0,45	2,05	50	9	2,8	2,1	●
M 3	0,50	2,50	56	11	3,5	2,7	●
M 4	0,70	3,30	63	13	4,5	3,4	●
M 5	0,80	4,20	70	16	6,0	4,9	●
M 6	1,00	5,00	80	19	6,0	4,9	●
M 8	1,25	6,80	90	22	8,0	6,2	●
M 10	1,50	8,50	100	24	10,0	8,0	●

● Standardartikel / Items available ex stock

DIN 371

Maschinen-Gewindebohrer mit verstärktem Schaft
für Metrisches ISO-Regelgewinde nach DIN 13
Machine taps with reinforced shank
for ISO metric coarse thread as per DIN 13

Ni



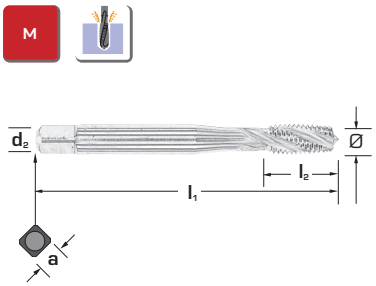
Typ / Type								Ni 10°
Toleranz Tolerance								6 HX
Anschnittform / Anzahl der Gänge Chamfer form / No. of threads								C/2,5-3
Schneidrichtung Cutting direction								
Schneidstoff/ Material								HSS-Co-PM
Ø mm		**Steigung** Pitch	**Kernloch Ø** Tap drill Ø	**l_1 mm**	**l_2 mm**	**d_2 mm h9**	**a mm h12**	**6894**
M	3	0,50	2,50	56	11	3,5	2,7	●
M	4	0,70	3,30	63	13	4,5	3,4	●
M	5	0,80	4,20	70	16	6,0	4,9	●
M	6	1,00	5,00	80	19	6,0	4,9	●
M	8	1,25	6,80	90	22	8,0	6,2	●
M	10	1,50	8,50	100	24	10,0	8,0	●

● Standardartikel / Items available ex stock

DIN 371

Maschinen-Gewindebohrer mit verstärktem Schaft
für Metrisches ISO-Regelgewinde nach DIN 13
Machine taps with reinforced shank
for ISO metric coarse thread as per DIN 13

Ni



Typ / Type	Ni 22°
Toleranz Tolerance	6 HX
Anschnittform / Anzahl der Gänge Chamfer form / No. of threads	C/2,5-3
Schneidrichtung Cutting direction	
Schneidstoff/ Material	HSS-Co-PM

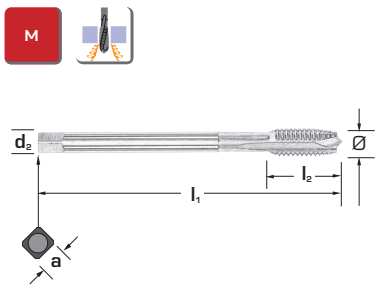
Ø mm	Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a mm h12	6895
M 2	0,40	1,60	45	8	2,8	2,1	●
M 3	0,50	2,50	56	11	3,5	2,7	●
M 3,5	0,60	2,90	56	13	4,0	3,0	●
M 4	0,70	3,30	63	13	4,5	3,4	●
M 5	0,80	4,20	70	16	6,0	4,9	●
M 6	1,00	5,00	80	19	6,0	4,9	●
M 8	1,25	6,80	90	22	8,0	6,2	●
M 10	1,50	8,50	100	24	10,0	8,0	●

● Standardartikel / Items available ex stock

DIN 376

Maschinen-Gewindebohrer mit Überlaufschaft
für Metrisches ISO-Regelgewinde nach DIN 13
Machine taps with reduced shank
for ISO metric coarse thread as per DIN 13

Ni



Typ / Type								Ni
Toleranz Tolerance								6 HX
Anschnittform / Anzahl der Gänge Chamfer form / No. of threads								B/4-5
Schneidrichtung Cutting direction								
Schneidstoff/ Material								HSS-Co-PM
Ø mm		**Steigung** Pitch	**Kernloch Ø** Tap drill Ø	**l_1** mm	**l_2** mm	**d_2** mm h9	**a** mm h12	**6893**
M	**12**	1,75	10,20	110	29	9,0	7,0	●
M	**16**	2,00	14,00	110	32	12,0	9,0	●
M	**20**	2,50	17,50	140	34	16,0	12,0	●

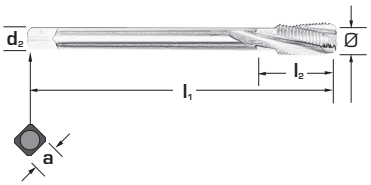
● Standardartikel / Items available ex stock

DIN 376

Maschinen-Gewindebohrer mit Überlaufschaft
für Metrisches ISO-Regelgewinde nach DIN 13
Machine taps with reduced shank
for ISO metric coarse thread as per DIN 13

Ni

NEW



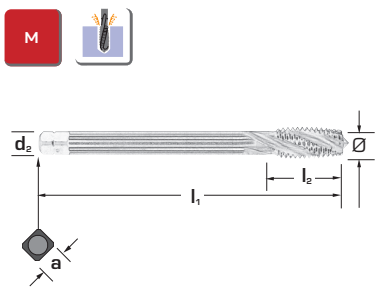
Typ / Type								Ni 10°
Toleranz Tolerance								6 HX
Anschnittform / Anzahl der Gänge Chamfer form / No. of threads								C/2,5-3
Schneidrichtung Cutting direction								
Schneidstoff/ Material								HSS-Co-PM
Ø mm		**Steigung** Pitch	**Kernloch Ø** Tap drill Ø	**l_1** mm	**l_2** mm	**d_2** mm h9	**a** mm h12	**6948**
M	**12**	1,75	10,20	110	29	9,0	7,0	●
M	**16**	2,00	14,00	110	32	12,0	9,0	●
M	**20**	4,50	17,50	140	34	16,0	12,0	●

● Standardartikel / Items available ex stock

DIN 376

Maschinen-Gewindebohrer mit Überlaufschaft
für Metrisches ISO-Regelgewinde nach DIN 13
Machine taps with reduced shank
for ISO-metric coarse thread as per DIN 13

Ni



Typ / Type	Ni 22°
Toleranz Tolerance	6 HX
Anschnittform / Anzahl der Gänge Chamfer form / No. of threads	C/2,5-3
Schneidrichtung Cutting direction	
Schneidstoff/ Material	HSS-Co-PM

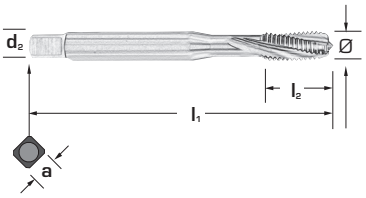
Ø mm	Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a mm h12	6896
M 12	1,75	10,20	110	29	9,0	7,0	●
M 16	2,00	14,00	110	32	12,0	9,0	●
M 20	2,50	17,50	140	34	16,0	12,0	●

● Standardartikel / Items available ex stock

DIN 371

Maschinen-Gewindebohrer mit verstärktem Schaft für MJ Gewinde
Machine taps with reinforced shank for MJ thread

Ni



Typ / Type	**Ni 10°**
Toleranz Tolerance	**4 HX**
Anschnittform / Anzahl der Gänge Chamfer form / No. of threads	**C/2,5-3**
Schneidrichtung Cutting direction	
Schneidstoff/ Material	**HSS-Co-PM**

Ø mm		Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a mm h12	6906
MJ	3	0,50	2,60	56	11	3,5	2,7	●
MJ	4	0,70	3,40	63	13	4,5	3,4	●
MJ	5	0,80	4,30	70	15	6,0	4,9	●
MJ	6	1,00	5,10	80	17	6,0	4,9	●
*MJ	8	1,00	7,10	90	17	8,0	6,2	●
MJ	8	1,25	6,90	90	20	8,0	6,2	●
*MJ	10	1,25	8,90	100	18	10,0	8,0	●
MJ	10	1,50	8,60	100	22	10,0	8,0	●

* Metrischfein / Metric Fine

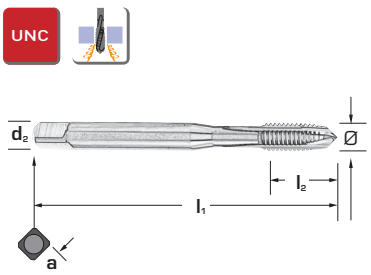
● Standardartikel / Items available ex stock

DIN 2184/1

Maschinen-Gewindebohrer mit verstärktem Schaft für Unified Grobgewinde UNC - ASME - B 1.1 Baumaße an DIN 371 angelehnt

Machine taps with reinforced shank
for unified coarse thread UNC - ASME – B 1.1
dimensions generally as per DIN 371

Ni



Typ / Type	Ni
Toleranz Tolerance	2 BX
Anschnittform / Anzahl der Gänge Chamfer form / No. of threads	B/4-5
Schneidrichtung Cutting direction	
Schneidstoff / Material	HSS-Co-PM

Ø mm		Gg/1" Tpi	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a mm h12	6869
UNC nr.	2	- 56	1,85	45	9	2,8	2,1	●
UNC nr.	3	- 48	2,10	50	9	2,8	2,1	●
UNC nr.	4	- 40	2,35	56	11	3,5	2,7	●
UNC nr.	5	- 40	2,65	56	11	3,5	2,7	●
UNC nr.	6	- 32	2,85	56	13	4,0	3,0	●
UNC nr.	8	- 32	3,50	63	13	4,5	3,4	●
UNC nr.	10	- 24	3,90	70	16	6,0	4,9	●
UNC nr.	12	- 24	4,50	80	17	6,0	4,9	●
UNC	1/4	- 20	5,10	80	17	7,0	5,5	●
UNC	5/16	- 18	6,60	90	20	8,0	6,2	●
UNC	3/8	16	8,00	100	20	10,0	8,0	●

DIN 2184/1

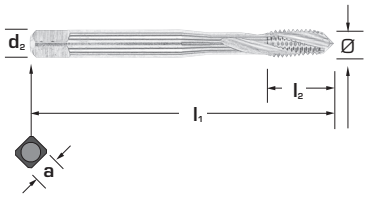
Maschinen-Gewindebohrer mit verstärktem Schaft für Unified Grobgewinde UNC - ASME - B 1.1 Baumaße an DIN 371 angelehnt

Machine taps with reinforced shank
for unified coarse thread UNC - ASME – B 1.1
dimensions generally as per DIN 371

Ni

UNC

NEW



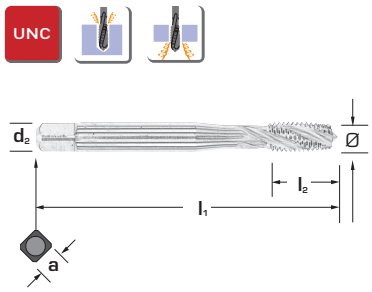
Typ / Type	Ni 10°
Toleranz Tolerance	2 BX
Anschnittform / Anzahl der Gänge Chamfer form / No. of threads	C/2,5/3
Schneidrichtung Cutting direction	
Schneidstoff / Material	HSS-Co-PM

Ø mm		Gg/1" Tpi	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a mm h12	6990
UNC nr.	4	- 40	2,35	56	11	3,5	2,7	●
UNC nr.	6	- 32	2,85	56	13	4,0	3,0	●
UNC nr.	8	- 32	3,50	63	13	4,5	3,4	●
UNC nr.	10	- 24	3,90	70	16	6,0	4,9	●
UNC nr.	12	- 24	4,50	80	17	6,0	4,9	●
UNC	1/4	- 20	5,10	80	17	7,0	5,5	●
UNC	5/16	- 18	6,60	90	20	8,0	6,2	●
UNC	3/8	- 16	8,00	100	20	10,0	8,0	●

ILIX NORM

Maschinen-Gewindebohrer mit verstärktem Schaft für Unified Grobgewinde UNC - ASME - B 1.1 Baumaße an DIN 371 angelehnt
Machine taps with reinforced shank
for unified coarse thread UNC - ASME – B 1.1
dimensions generally as per DIN 371

Ni



Typ / Type	Ni 22°
Toleranz Tolerance	2 BX
Anschnittform / Anzahl der Gänge Chamfer form / No. of threads	C/2,5/3
Schneidrichtung Cutting direction	
Schneidstoff/ Material	HSS-Co-PM

Ø mm			Gg/1" Tpi	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a mm h12	6900
UNC nr.	6	-	32	2,85	56	13	4,0	3,0	●
UNC nr.	8	-	32	3,50	63	13	4,5	3,4	●
UNC nr.	10	-	24	3,90	70	16	6,0	4,9	●
UNC nr.	12	-	24	4,50	80	17	6,0	4,9	●
UNC	1/4	-	20	5,10	80	17	7,0	5,5	●
UNC	5/16	-	18	6,60	90	20	8,0	6,2	●
UNC	3/8	-	16	8,00	100	20	10,0	8,0	●
		-							

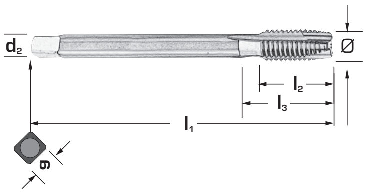
DIN 2184/1

Maschinengewindebohrer mit reduziertem Schaft für Unified Grobgewinde UNC - ASME - B 1.1 Baumaße an DIN 376 angelehnt

Machine taps with reduced shank
for unified coarse thread UNC - ASME – B 1.1
dimensions generally as per DIN 376

Ni

UNC



	Ni
Typ / Type	Ni
Toleranz Tolerance	2 BX
Anschnittform / Anzahl der Gänge Chamfer form / No. of threads	B/4-5
Schneidrichtung Cutting direction	
Schneidstoff/ Material	HSS-Co-PM

Ø mm			Gg/1" Tpi	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	l_3 mm	$d_2$mm h9	a h12	6897
UNC	1/2	-	13	10,80	110	16	29	9	7,0	●
UNC	5/8	-	11	13,50	110	20	32	12	9,0	●
UNC	3/4	-	10	16,50	125	25	34	14	11,0	●

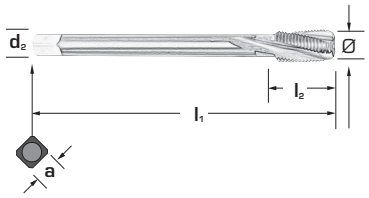
DIN 2184/1

Maschinengewindebohrer mit reduziertem Schaft für Unified Grobgewinde
UNC - ASME - B 1.1 Baumaße an DIN 376 angelehnt
Machine taps with reduced shank
for unified coarse thread UNC - ASME – B 1.1
dimensions generally as per DIN 376

Ni

UNC

NEW



Typ / Type	Ni 10°
Toleranz Tolerance	2 BX
Anschnittform / Anzahl der Gänge Chamfer form / No. of threads	C/2,5-3
Schneidrichtung Cutting direction	
Schneidstoff/ Material	HSS-Co-PM

Ø mm			Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a mm h12	6997
UNC	7/16	-	14	6,50	100	18	6	4,9	●
UNC	1/2	-	13	10,80	110	22	9	7,0	●
UNC	5/8	-	11	13,50	110	28	12	9,0	●

DIN 2184/1

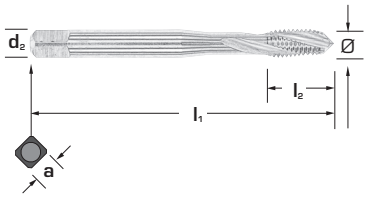
Maschinen-Gewindebohrer mit verstärktem Schaft für Unified Grobgewinde UNC - ASME - B 1.1 Baumaße an DIN 371 angelehnt

Machine taps with renforced shank
for unified coarse thread UNC - ASME – B 1.1
dimensions generally as per DIN 371

Ni

UNJC

NEW



Typ / Type	Ni 10°
Toleranz Tolerance	3 BX
Anschnittform / Anzahl der Gänge Chamfer form / No. of threads	C/2,5-3
Schneidrichtung Cutting direction	
Schneidstoff/ Material	HSS-Co-PM

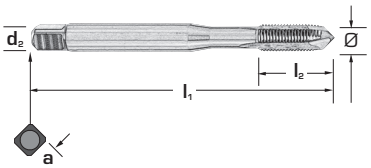
Ø mm	Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a mm h12	6998
UNJC nr. 4	- 40	2,3	56	10	3,5	2,7	●
UNJC nr. 6	- 32	2,75	56	11	4,0	3,0	●
UNJC nr. 8	- 32	3,50	63	12	4,5	3,4	●
UNJC nr. 10	- 24	3,80	70	14	6,0	4,9	●
UNJC nr. 12	- 24	3,80	70	14	6,0	4,9	●
UNJC 1/4	- 20	5,10	80	16	6,0	4,9	●
UNJC 5/16	- 18	6,50	90	18	8,0	6,2	●
UNJC 3/8	- 16	7,90	100	20	10,0	8,0	●

DIN 2184/1

Maschinengewindebohrer mit verstärktem Schaft für Unified-Feingewinde UNF Baumaße an DIN 371 angelehnt

Machine taps with reinforced shank for unified fine thread UNF - ASME – B 1.1 dimensions generally as per DIN 371

Ni



	Ni
Typ / Type	
Toleranz Tolerance	2 BX
Anschnittform / Anzahl der Gänge Chamfer form / No. of threads	B/4-5
Schneidrichtung Cutting direction	
Schneidstoff/ Material	HSS-Co-PM

Ø mm		Gg/1" Tpi	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a mm h12	6844
UNF	nr. 2	- 64	1,90	45	9	2,8	2,1	●
UNF	nr. 3	- 56	2,15	50	9	2,8	2,1	●
UNF	nr. 4	- 48	2,40	56	11	3,5	2,7	●
UNF	nr. 5	- 44	2,70	56	11	3,5	2,7	●
UNF	nr. 6	- 40	2,95	56	13	4,0	3,0	●
UNF	nr. 8	- 36	3,50	63	13	4,5	3,4	●
UNF	nr. 10	- 32	4,10	70	14	6,0	4,9	●
UNF	nr. 12	- 28	4,70	80	17	6,0	4,9	●
UNF	1/4	28	5,50	80	18	7,0	5,5	●
UNF	5/16	24	6,90	90	22	8,0	6,2	●
UNF	3/8	24	8,50	100	22	10,0	7,0	●

DIN 2184/1

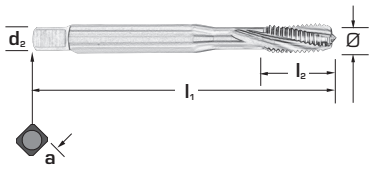
Maschinengewindebohrer mit verstärktem Schaft für Unified-Feingewinde UNF Baumaße an DIN 371 angelehnt

Machine taps with reinforced shank for unified fine thread UNF - ASME – B 1.1 dimensions generally as per DIN 371

Ni

UNF

NEW



Typ / Type	Ni 10°
Toleranz Tolerance	2 BX
Anschnittform / Anzahl der Gänge Chamfer form / No. of threads	C/2-3
Schneidrichtung Cutting direction	
Schneidstoff/ Material	HSS-Co-PM

Ø mm			Gg/1" Tpi	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a mm h12	6928
UNF	nr. 6	-	40	2,95	56	13	4,0	3,0	●
UNF	nr. 8	-	36	3,50	63	13	4,5	3,4	●
UNF	nr. 10	-	32	4,10	70	14	6,0	4,9	●
UNF	nr. 12	-	28	4,70	80	14	6,0	4,9	●
UNF	1/4	-	28	5,50	80	16	7,0	5,5	●
UNF	5/16	-	24	6,90	90	22	8,0	6,2	●
UNF	3/8	-	24	8,50	100	22	10,0	8,0	●

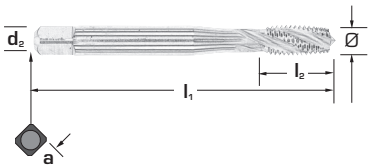
DIN 2184/1

Maschinengewindebohrer mit verstärktem Schaft für Unified-Feingewinde UNF Baumaße an DIN 371 angelehnt

Machine taps with reinforced shank for unified fine thread UNF - ASME – B 1.1 dimensions generally as per DIN 371

Ni

UNF



Typ / Type	Ni 22°
Toleranz Tolerance	2 BX
Anschnittform / Anzahl der Gänge Chamfer form / No. of threads	C/2,5-3
Schneidrichtung Cutting direction	
Schneidstoff/ Material	HSS-Co-PM

Ø mm			Gg/1" Tpi	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	$d_2$mm h9	a mm h12	6846
UNF	nr. 10	-	32	4,10	70	12	6,0	2,7	●
UNF	1/4	-	28	5,50	80	14	7,0	3,4	●
UNF	5/16	-	24	6,90	90	22	8,0	4,9	●
UNF	3/8	-	24	8,50	90	22	10,0	7,0	●

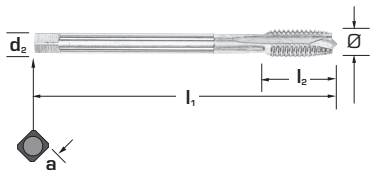
DIN 2184/1

Maschinengewindebohrer mit überlauf Schaft für Unified-Feingewinde UNF Baumaße an DIN 371 angelehnt

Machine taps with reduced shank
for unified fine thread UNF - ASME – B 1.1
dimensions generally as per DIN 374

Ni

UNF



Typ / Type									Ni
Toleranz Tolerance									2 BX
Anschnittform / Anzahl der Gänge Chamfer form / No. of threads									B/4-5
Schneidrichtung Cutting direction									
Schneidstoff/ Material									HSS-Co-PM
Ø mm			**Gg/1"** Tpi	**Kernloch Ø** Tap drill Ø	**l_1 mm**	**l_2 mm**	**$d_2$mm h9**	**a mm h12**	**6845**
UNF	**7/16**	-	20	9,90	90	20	8,0	6,2	●
UNF	**1/2**	-	20	11,50	100	22	9,0	7,0	●
UNF	**5/8**	-	18	14,50	100	22	12,0	9,0	●
UNF	**3/4**	-	16	17,50	110	25	14,0	11,0	●

DIN 2184/1

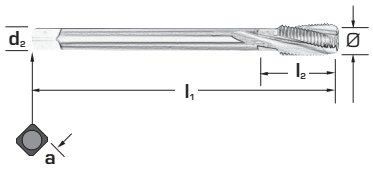
Maschinengewindebohrer mit überlauf Schaft für Unified-Feingewinde UNF Baumaße an DIN 371 angelehnt

Machine taps with reduced shank
for unified fine thread UNF - ASME – B 1.1
dimensions generally as per DIN 374

Ni

UNF

NEW



Typ / Type	Ni 10°
Toleranz Tolerance	2 BX
Anschnittform / Anzahl der Gänge Chamfer form / No. of threads	C/2,5-3
Schneidrichtung Cutting direction	
Schneidstoff/ Material	HSS-Co-PM

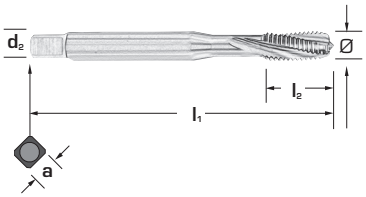
Ø mm		Gg/1" Tpi	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a mm h12	6929
UNF 7/16	- 20		9,90	100	14	8,0	6,2	●
UNF 1/2	- 20		11,50	110	18	9,0	7,0	●
UNF 5/8	- 18		14,50	110	20	12,0	9,0	●

DIN 2184/1

MULTI Aero

Maschinengewindebohrer mit verstärktem Schaft
für Unified-Feingewinde UNJF
Machine taps with reinforced shank
for Unified fine thread UNJF ASME B1.1

Multi Aero



Typ / Type	Ni 10°
Toleranz Tolerance	3 BX
Anschnittform / Anzahl der Gänge Chamfer form / No. of threads	C/2,5-3
Schneidrichtung Cutting direction	
Schneidstoff/ Material	HSS-Co-PM

Ø mm	Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a mm h12	6907
UNJF nr. 6	40	3,00	56	12	4,0	3,0	●
UNJF nr. 8	36	3,55	63	13	4,5	3,4	●
UNJF nr. 10	32	4,15	70	15	6,0	4,9	●
UNJF 1/4	28	5,55	80	17	7,0	5,5	●
UNJF 5/16	24	7,00	90	17	8,0	6,2	●
UNJF 3/8	24	8,60	90	18	10,0	8,0	●

● Standardartikel / Items available ex stock

MULTI **TP**

Multi TP VHM Gewindebohrer in besonders fester Ausführung zur Bearbeitung von Materialien mit einer Härte über 50 HRc.

Solid carbide taps for tapping in materials with a hardness over 50 HRC.

QUALITÄT VHM
Quality Solid Carbide

DIE NEUE GENERATION VON VHM SORTEN ULTA - FEINSTKORN VERLEIHEN DEM GEWINDEBOHRER EINE GUTE STABILITÄT UND LANGE STANDZEIT.
Latest generation SINTERED STEEL. Very good stability and longer tool life, thanks to the ultra-fine granulometry.

OBERFLÄCHEN BESCHICHTUNG:
DIE ANWENDUNG NEUER FERTIGUNGSTECHNOLOGIEN FÜHREN ZU BESCHLEUNIGTEN PRODUKTIONSPROZESSEN. DIE TICN BESCHICHTUNG GIBT DEM WERKZEUG EINE BESSERE FESTIGKEIT UND HÖHERE STANDZEITEN BEIM EINSATZ IN HOCHLEISTUNGSMASCHINEN.
Surface coating:
New production technologies have sped up production cycles. The TiCN coating gives higher tenacity and wear resistance to the tool when used in high performance machines.

ILIX® PRECISION

ILIX NORM

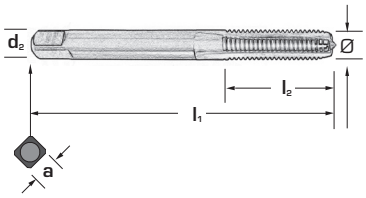
ÄHNLICH / SIMILAR DIN 371

MULTI TP

Maschinen-Gewindebohrer mit verstärktem Schaft* für Metrisches ISO-Regelgewinde nach DIN 13
Machine taps with reinforced shank* for ISO metric coarse thread as per DIN 13

Multi TP HRC 52-58

M TICN



Typ / Type								**MULTI TP**
Toleranz Tolerance								**6 HX**
Anschnittform / Anzahl der Gänge Chamfer form / No. of threads								**C/2,5-3**
Schneidrichtung Cutting direction								
Schneidstoff/ Material								**K10/K20**
Ø mm		**Steigung** Pitch	**Kernloch Ø** Tap drill Ø	**l_1 mm**	**l_2 mm**	**d_2 mm h9**	**a mm h12**	**6770 TC**
M	**4**	0,70	3,4	63	13	4,5	3,4	●
M	**5**	0,80	4,3	70	16	6,0	4,9	●
M	**6**	1,00	5,1	80	19	6,0	4,9	●
M	**8**	1,25	6,9	90	22	8,0	6,2	●
M	**10**	1,50	8,6	100	24	10,0	8,0	●
M	**12**	1,75	10,4	110	32	12,0	9,0	●

* Der Spiralbohrer 6014TF auf Seite 73 ist zum Bohren in genannten Materialien geeignet. / The twist drill 6014TF of page 73 is adequate for drilling in listed materials.

● Standardartikel / Items available ex stock

FORMER **PM - PM i**

Maschinen-Gewindeformer HSS Co-PM (gesintert) sind entwickelt für den Einsatz hoher Schnittgeschwindigkeit, eine hohe Produktivität und zuverlässige Qualität der Gewinde zu erzeugen. Haben eine hohe Beständigkeit gegen Verschleiß und Hitze. Die HSS-Co-PM Gewindeformer können auch auf CNC-Maschinen für das synchron Formen verwendet werden.

Machine thread former HSS co-PM (sintered) are developed for the use of high cutting speed, high productivity and reliable quality of thread to produce. Have a high resistance to wear and heat. The HSS-Co PM Thread formers can also be used on CNC machines for the synchronous forms.

GEWINDE HERSTELLUNG DURCH PLASTISCHE VERFORMUNG STATT MATERIALABTRAG. KEINE SPANBILDUNG.
Thread obtained by plastic deformation instead of material removal. No chip formation, therefore:

- SICHERE UND ZUVERLÄSSIGE GEWINDEPROZESS
- Secure and reliable tapping process
- DIE MÖGLICHKEIT, BEIDE GEWINDE SACK.- U. DURCHGAGSGEWINDE MIT DEM GLEICHEN FORMER ZU ERSTELLEN.
- Possibility to thread both blind and through holes with the same tap
- GROSSE AUSWAHL AN MATERIALIEN: STAHL <1000 N / MM2, ALUMINIUM, NICHT - EISEN METALLE-
Wide range of working materials: Steel <1000 N/mm2, Aluminium, Non Ferrous materials
- GROSSE GEWINDETIEFE AUCH FÜR SACHLÖCHER
- High tapping depth also on blind holes
- HOHE STANDZEIT
-High tool life

HÖHERE SCHNITTGESCHWINDIGKEIT IM VERGLEICH ZUM GEWINDESCHNEIDEN
Higher cutting speed compared to cutting taps

BESSERE OBERFLÄCHENQUALITÄT AM GEWINDE
Better surface quality on thread

DIE GEWINDEFORMER MIT TIN ODER TIALN BESCHICHTUNG HILFE DIE STANDZEIT ZU ERHÖHEN.
The forming taps TIN or TiAlN coated help to increase the tool life

GERINGE BRUCHGEFAHR DANK GRÖSSEREN KERNDURCHMESSER
Low risk of breakage , thanks to larger core diameter

ILIX® PRECISION

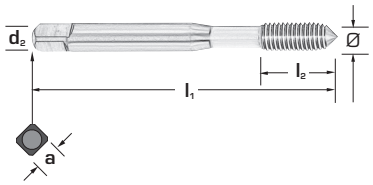
DIN 371

FORMER PM

Innengewinde-Former mit verstärktem Schaft
für Metrisches ISO-Regelgewinde nach DIN 13
Cold forming taps with reinforced shank
for ISO metric coarse thread as per DIN 13

FORMER PM

M TiAlN Futura



	Former
Typ / Type	
Toleranz Tolerance	6 HX
Anschnittform / Anzahl der Gänge Chamfer form / No. of threads	C/2,5-3
Schneidrichtung Cutting direction	
Schneidstoff/ Material	HSS-Co-PM

Ø mm	Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a mm h12	6800 TF
M 3,0	0,5	2,75	56	11	3,5	2,7	●
M 4,0	0,7	3,65	63	13	4,5	3,4	●
M 5,0	0,8	4,60	70	16	6,0	4,9	●
M 6,0	1,0	5,50	80	19	6,0	4,9	●
M 8,0	1,25	7,40	90	22	8,0	6,2	●
M 10,0	1,5	9,30	100	24	10,0	8,0	●

● Standardartikel / Items available ex stock

DIN 371

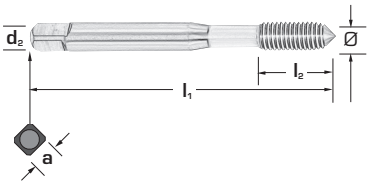
FORMER PM i

Innengewinde-Former mit verstärktem Schaft
für Metrisches ISO-Regelgewinde nach DIN 13
Cold forming taps with reinforced shank
for ISO metric coarse thread as per DIN 13

FORMER PM i

M TiN

Axialer Kühlmittelaustritt
Axial internal cooling



	Former i
Typ / Type	
Toleranz Tolerance	6 HX
Anschnittform / Anzahl der Gänge Chamfer form / No. of threads	C 2,5-3
Schneidrichtung Cutting direction	
Schneidstoff/ Material	HSS-Co-PM

Ø mm	Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a mm h12	6801 TN
M 6,0	1,0	5,50	80	19	6,0	4,9	●
M 8,0	1,25	7,40	90	22	8,0	6,2	●
M 10,0	1,5	9,30	100	24	10,0	8,0	●

● Standardartikel / Items available ex stock

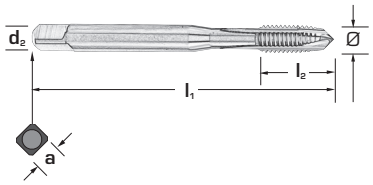
DIN 371

Innengewinde-Former mit verstärktem Schaft
für Metrisches ISO-Regelgewinde nach DIN 13
Cold forming taps with reinforced shank
for ISO metric coarse thread as per DIN 13

FORMER PM i

FORMER PM i

M TiN **Radialer Kühlmittelaustritt**
radial cooling



Typ / Type	Former i
Toleranz Tolerance	6 HX
Anschnittform / Anzahl der Gänge Chamfer form / No. of threads	C 2,5-3
Schneidrichtung Cutting direction	
Schneidstoff/ Material	HSS-Co-PM

Ø mm		Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	d_2 mm h9	a mm h12	6969 TN
M	5,0	0,80	4,60	70	16	6,0	4,9	●
M	6,0	1,00	5,50	80	19	6,0	4,9	●
M	8,0	1,25	7,40	90	22	8,0	6,2	●
M	10,0	1,50	9,30	100	24	10,0	8,0	●

● Standardartikel / Items available ex stock

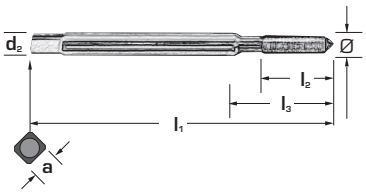
DIN 371

FORMER

Innengewinde-Former mit verstärktem Schaft aus Vollhartmetall
für Metrisches ISO-Regelgewinde nach DIN 13 Baumaße an DIN 371 angelehnt
Solid carbide forming taps with reinforced shank made of
for ISO metric coarse thread as per DIN 13 dimensions similar to DIN 371

FORMER

M



	FORMER
Typ / Type	
Toleranz Tolerance	6 HX
Anschnittform / Anzahl der Gänge Chamfer form / No. of threads	C/2-2,5
Schneidrichtung Cutting direction	
Schneidstoff/ Material	K20

Ø mm		Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	l_2 mm	d_2 mm h9	a mm h12	6788
M	4	0,70	3,65	63	13	-	4,5	3,4	●
M	5	0,80	4,60	70	16	-	6,0	4,9	●
M	6	1,00	5,50	80	19	-	6,0	4,9	●
M	8	1,25	7,40	90	18	30	8,0	6,2	●
M	10	1,50	9,30	100	20	32	10,0	8,0	●

● Standardartikel / Items available ex stock

GEWINDEBOHRER **VHM - SOLID CARBIDE** TAPS

Mit dem Ziel unter schnell wechselnder mechanischer und thermischer Beanspruchung Bearbeitungszeiten und Leistung zu optimieren, hat ILIX eine neue Generation von Gewindewerkzeugen aus fortschrittlichen Materialien entwickelt.
Die Eigenschaften sind auf Leistungssteigerung und somit auf Minimierung der Maschinenbelegungszeiten ausgerichtet.

To optimize all aspects of machining under rapidly changing mechanical and thermal stress.
ILIX has pioneered a new generation of threading tools from advanced materials.
Their characteristics aim towards higher performance and hereby reduction of machine assignment time.

DIE NEUEN HOCHLEISTUNGSGEWINDEBOHRER AUS VHM K20 ERMÖGLICHEN STABILE UND KONTROLLIERTE GEWINDEBEARBEITUNG IN PRÄZISIONSANWENDUNGEN.
The new high performance taps produced from ultrafine K20 allow stable and controlled threading processes in high precision applications.

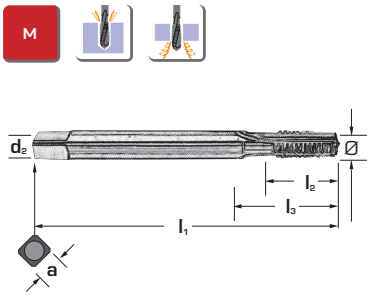
ILIX® PRECISION

ILIX NORM

Maschinen-Gewindebohrer mit verstärktem Schaft aus Vollhartmetall für Metrisches ISO-Regelgewinde nach DIN 13 Baumaße an DIN 371 angelehnt

Ground thread machine taps with reinforced shank made of solid carbide for ISO metric coarse thread as per DIN 13 dimensions similar to DIN 371

N



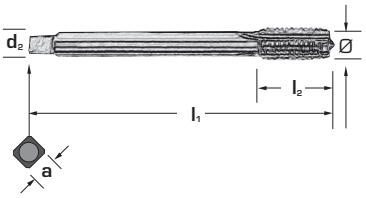
Typ / Type									**N**	**N R/15°**
Toleranz Tolerance									**6 HX**	**6 HX**
Anschnittform / Anzahl der Gänge Chamfer form / No. of threads									**C/2,5-3**	**C/2,5-3**
Schneidrichtung Cutting direction										
Schneidstoff / Material									**K20**	**K20**
Ø mm		**Steigung** Pitch	**Kernloch** Tap drill	**l_1 mm**	**l_2 mm**	**l_3 mm**	**d_2 mm h6**	**a mm h12**	**6771**	**6736**
M	3	0,50	2,50	56	10	-	3,5	2,7	●	●
M	4	0,70	3,30	63	13	-	4,5	3,4	●	●
M	5	0,80	4,20	70	16	-	6,0	4,9	●	●
M	6	1,00	5,00	80	19	-	6,0	4,9	●	●
M	8	1,25	6,80	90	22	30	8,0	6,2	●	●
M	10	1,50	8,50	100	24	32	10,0	8,0	●	●

● Standardartikel / Items available ex stock

ILIX NORM

Maschinen-Gewindebohrer mit überlauf Schaft aus Vollhartmetall
für Metrisches ISO-Regelgewinde nach DIN 13 Baumaße an DIN 376 angelehnt
Ground thread machine taps with reduced shank made of solid carbide
with internal cooling for ISO metric fine thread as per DIN 13 dimensions similar to DIN 376

N



								N	N R/15°	N L/15°
Typ / Type										
Toleranz Tolerance								6 HX	6 HX	6 HX
Anschnittform / Anzahl der Gänge Chamfer form / No. of threads								C/2,5-3	C/2,5-3	C/2,5-3
Schneidrichtung Cutting direction										
Schneidstoff/ Material								K20	K20	K20
Ø mm		**Steigung** Pitch	**Kernloch** Tap drill	**l_1 mm**	**l_2 mm**	**d_2 mm h9**	**a mm h12**	**6792**	**6759**	**6714**
M	**12**	1,75	10,2	110	23	9	7	●	●	●

● **Standardartikel** / Items available ex stock

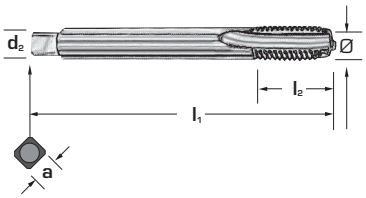
ILIX NORM

Maschinen-Gewindebohrer mit verstärktem Schaft aus Vollhartmetall
mit innenliegenden Kühlkanälen ab M 6
für Metrisches ISO-Regelgewinde nach DIN 13 Baumaße an DIN 371 angelehnt

Solid carbide machine taps with reinforced shank with internal cooling
from M 6 onwards for ISO metric coarse thread
as per DIN 13 dimensions similar to DIN 371

GG i - N i

Axialer Kühlmittelaustritt
Axial internal cooling



Typ / Type								**GG i**	**N 15° i**
Toleranz Tolerance								**6 HX**	**6 HX**
Anschnittform / Anzahl der Gänge Chamfer form / No. of threads								**C/2-3**	**C/2-3**
Schneidrichtung Cutting direction									
Schneidstoff / Material								**K20**	**K20**
Ø mm		**Steigung** Pitch	**Kernloch** Tap drill	**l_1 mm**	**l_2 mm**	**d_2 mm h6**	**a mm h12**	**6760**	**6762**
M	5	0,80	4,2	70	16	6	4,9	●	●
M	6	1,00	5,0	80	19	6	4,9	●	●
M	8	1,25	6,8	90	22	8	6,2	●	●
M	10	1,50	8,5	100	24	10	8,0	●	●

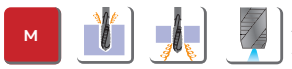
● Standardartikel / Items available ex stock

ILIX NORM

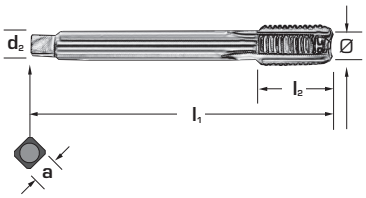
Maschinen-Gewindebohrer mit überlauf Schaft aus Vollhartmetall
mit innenliegenden Kühlkanälen
für Metrisches ISO-Regelgewinde nach DIN 13 Baumaße an DIN 376 angelehnt

Solid carbide machine taps with reinforced shank with internal cooling
for ISO metric coarse thread as per DIN 13
dimensions similar to DIN 376

GG i - N i



Axialer Kühlmittelaustritt
Axial internal cooling



Typ / Type									**GG i**	**N 15° i**
Toleranz Tolerance									**6 HX**	**6 HX**
Anschnittform / Anzahl der Gänge Chamfer form / No. of threads									**C/2-3**	**C/2-3**
Schneidrichtung Cutting direction										
Schneidstoff / Material									**K20**	**K20**
Ø mm		**Steigung** Pitch	**Kernloch** Tap drill	**l_1 mm**	**l_2 mm**	**d_2 mm h6**	**a mm h12**		**6763**	**6765**
M	**12**	1,75	10,2	110	29	9	7		●	●

● **Standardartikel** / Items available ex stock

ILIX NORM

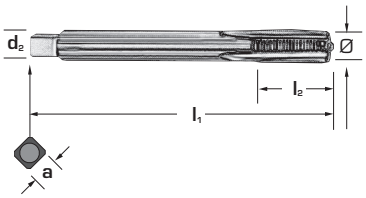
Maschinen-Gewindebohrer mit verstärktem Schaft aus Vollhartmetall
mit innenliegenden Kühlkanälen ab M6
für Metrisches ISO-Regelgewinde nach DIN 13 Baumaße an DIN 376 angelehnt

Solid carbide machine taps with reinforced shank with internal cooling
from M 6 onwards for ISO metric coarse thread
as per DIN 13 dimensions similar to DIN 374

GG i - N i

M

Axialer Kühlmittelaustritt
Axial internal cooling



	GG i	N 15° i
Typ / Type	GG i	N 15° i
Toleranz Tolerance	6 HX	6 HX
Anschnittform / Anzahl der Gänge Chamfer form / No. of threads	C/2-3	C/2-3
Schneidrichtung Cutting direction		
Schneidstoff / Material	K20	K20

Ø mm		Steigung Pitch	Kernloch Tap drill	l_1 mm	l_2 mm	d_2 mm h6	a mm h12	6766	6767
M	8	1	7	90	18	8	6,2	●	●
M	10	1	9	100	18	10	7,0	●	●

● Standardartikel / Items available ex stock

ILIX NORM

GG i - N

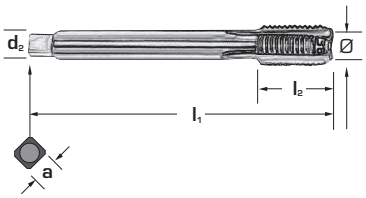
Maschinen-Gewindebohrer mit überlauf Schaft aus Vollhartmetall mit innenliegenden Kühlkanälen für Metrisches ISO-Regelgewinde nach DIN 13 Baumaße an DIN 374 angelehnt

Solid carbide machine taps with reinforced shank with internal cooling from M 6 onwards for ISO metric coarse thread as per DIN 13 dimensions similar to DIN 374

GG i - N i

M

Axialer Kühlmittelaustritt
Axial internal cooling



									GG i	N 15° i
Typ / Type										
Toleranz Tolerance									6 HX	6 HX
Anschnittform / Anzahl der Gänge Chamfer form / No. of threads									C/2-3	C/2-3
Schneidrichtung Cutting direction										
Schneidstoff / Material									K20	K20
Ø mm		**Steigung** Pitch	**Kernloch** Tap drill	**l_1 mm**	**l_2 mm**	**d_2 mm h6**	**a mm h12**		**6768**	**6769**
M	12	1,5	10,5	100	22	9	7		●	●

● Standardartikel / Items available ex stock

GEWINDEFRÄSER / THREAD MILLING CUTTERS

MULTI TM, TM AERO, CTM, DTM, TP e MICRO

VHM-Gewindefräser ausgelegt zur Herstellung guter Gewindequalität und präziser Toleranzen bei niedrigen Schnittgeschwindigkeiten. Gute Prozess Wiederholbarkeit und sehr hohe Zuverlässigkeit. Ideal für die Bearbeitung aller Materialien, aus Stahl, Gusseisen, speziell für hitzebeständige Legierungen und Aluminium.

Solid carbide thread milling cutters designed for reducing cutting speeds, producing short chips, obtaining very precise threading qualities and tolerances. These end mills are suitable in working conditions demanding reliability and process repeatability.
Ideal for machining all materials, from steel to cast iron and specifically for heat resistance alloys and aluminium.

ILIX® PRECISION

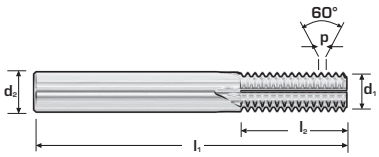
GEHÄRTETE STÄHLE / FOR HARDNED STEEL 54 - 63 HRC

Gewindefräser mit Zylinderschaft aus Vollhartmetall für Metrisches ISO-Regelgewinde nach DIN 13 (Einschraubtiefe von max. 1,5 x d1)
Solid carbide Thread milling cutters with straight shank for ISO metric coarse thread as per DIN 13 (depth max. 1,5 x d_1)

Für Innegewinde
For internal threads

M

TiAlN Futura



Typ / Type								TF
Schneidstoff/ Material								VHM
Ø mm	**Steigung** Pitch	**Kernloch Ø** Tap-drill Ø	**l_1 mm**	**l_2 mm**	**Ø d_1** (nominal)	**d_2 mm**	**Z**	**7015 TF**
M 4	0,70	3,3	48	7,3	3,1	6	4	●
M 5	0,80	4,2	54	9,2	4,0	6	4	●
M 6	1,00	5,0	64	10,5	4,5	8	4	●
M 8	1,25	6,8	64	14,3	6,4	8	5	●
M 10	1,50	8,5	80	17,2	8,1	12	5	●
M 12	1,75	10,2	80	21,8	9,6	12	5	●

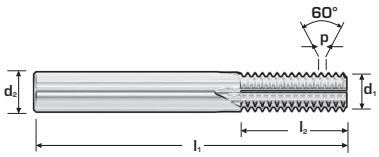
● Standardartikel / Items available ex stock

GEHÄRTETE STÄHLE / FOR HARDNED STEEL 54 - 63 HRC

Gewindefräser mit Zylinderschaft aus Vollhartmetall für Metrisches ISO-Regelgewinde nach DIN 13 (Einschraubtiefe von max. 2.0 x d_1)
Solid carbide thread milling cutters with straight shank for ISO metric coarse thread as per DIN 13 (depth max. 2,0 x d_1)

Für Innegewinde
For internal threads

M | TiAlN Futura




2,0 x d_1

Typ / Type	TF
Schneidstoff/ Material	VHM

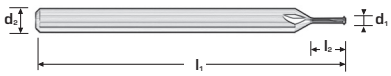
Ø mm	Steigung Pitch	Kernloch Ø Tap-drill Ø	l_1 mm	l_2 mm	Ø d_1 (nominal)	d_2 mm	Z	7016 TF
M 4	0,70	3,3	48	8,7	3,1	6	4	●
M 5	0,80	4,2	54	11,6	4,0	6	4	●
M 6	1,00	5,0	64	13,5	4,5	8	4	●
M 8	1,25	6,8	64	18,1	6,4	8	5	●
M 10	1,50	8,5	80	21,7	8,1	12	5	●
M 12	1,75	10,2	80	27,1	9,6	12	5	●

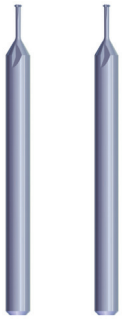
● Standardartikel / Items available ex stock

Gewindefräser mit Zylinderschaft aus Vollhartmetall für Metrisches ISO-Gewinde nach DIN 13 (Einschraubtiefe von max. 2,0 x d_1)
Solid carbide thread milling cutters with single ring of theeth for ISO metric coarse thread as per DIN 13 (depth of withdraw max. 2,0 x d_1)

Für Innegewinde
For internal threads

M TICN





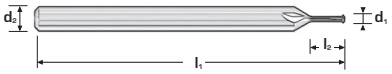
Typ / Type									MICRO	MICRO
Schneidstoff/ Material									VHM	VHM
Ø mm	**Bereich** Range	**Steigung** Pitch	**Kernloch Ø** Tap-drill Ø	**l_1 mm**	**l_2 mm**	**Ø d_1 (nominal)**	**d_2 mm**	**Z**	**7081**	**7081 TC**
M 1,0	M 1 - M 1,1	0,25	0,75	39	2,3	0,7	3	3	✓	✓
M 1,2		0,25	0,95	39	2,5	0,9	3	3	✓	✓
M 1,4		0,30	1,10	39	2,9	1,0	3	3	✓	✓
M 1,6	M 1,6 - M 1,7	0,35	1,25	39	3,5	1,2	3	3	✓	✓
M 1,8		0,35	1,45	39	3,7	1,4	3	3	✓	✓
M 2,0		0,40	1,60	39	4,1	1,5	3	4	✓	✓
M 2,2		0,45	1,75	39	4,5	1,7	3	4	✓	✓
M 2,3		0,40	1,90	39	4,7	1,8	3	4	✓	✓
M 2,5	M 2,5 - M 2,6	0,45	2,10	39	5,3	1,9	3	4	✓	✓
M 3,0		0,50	2,50	39	6,2	2,4	3	4	✓	✓
M 3,5		0,60	2,90	39	7,2	2,8	3	4	✓	✓

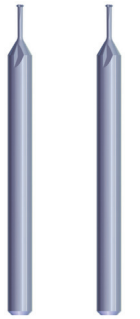
✓ Auf Anfrage / Upon request

Gewindefräser mit Zylinderschaft aus Vollhartmetall für Metrisches ISO-Gewinde nach DIN 13 (Einschraubtiefe von max. 3.0 x d_1)
Solid carbide thread milling cutters with single ring of theeth for ISO metric coarse thread as per DIN 13 (depth of withdraw max. 3,0 x d_1)

Für Innegewinde
For internal threads

M TICN





Typ / Type									MICRO	MICRO
Schneidstoff/ Material									VHM	VHM
Ø mm	**Bereich** Range	**Steigung** Pitch	**Kernloch Ø** Tap-drill Ø	**l_1 mm**	**l_2 mm**	**Ø d_1** (nominal)	**d_2 mm**	**Z**	**7082**	**7082 TC**
M 1,0	M 1 - M 1,1	0,25	0,75	39	3,4	0,7	3	3	✓	✓
M 1,2		0,25	0,95	39	3,7	0,9	3	3	✓	✓
M 1,4		0,30	1,10	39	4,3	1,0	3	3	✓	✓
M 1,6	M 1,6 - M 1,7	0,35	1,25	39	5,2	1,2	3	3	✓	✓
M 1,8		0,35	1,45	39	5,5	1,4	3	3	✓	✓
M 2,0		0,40	1,60	39	6,1	1,5	3	4	✓	✓
M 2,2		0,45	1,75	39	6,7	1,7	3	4	✓	✓
M 2,3		0,40	1,90	39	7,0	1,8	3	4	✓	✓
M 2,5	M 2,5 - M 2,6	0,45	2,10	39	7,9	1,9	3	4	✓	✓
M 3,0		0,50	2,50	39	9,2	2,4	3	4	✓	✓
M 3,5		0,60	2,90	39	10,7	2,8	3	4	✓	✓

✓ Auf Anfrage / Upon request

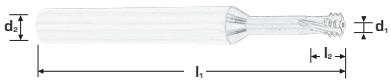
VHM-Gewindefräser mit drei Zahnringe für metrische ISO Regelgewinde nach DIN 13 (Einschraubtiefe max. 3 x d_1)

Solid carbide thread milling cutters with three rings of teeth for ISO metric coarse thread as per DIN 13 (depth of thread max. 3 x d_1)

Für Innegewinde

For internal threads

M TiAlN Futura **NEW**



3,0 x d_1 3,0 x d_1

Typ / Type									MICRO	MICRO
Schneidstoff / Material									VHM	VHM
Ø mm		Steigung Pitch	Kernloch Ø Tap-drill Ø	l_1 mm	l_2 mm	Ø d_1 (nominal)	d_2 mm	Z	7083	7083 TF
M	1,2	0,25	0,95	39	3,7	0,9	3	3	●	●
M	1,4	0,30	1,10	39	4,3	1,0	3	3	●	●
M	1,6	0,35	1,25	39	5,2	1,2	3	3	●	●
M	1,8	0,35	1,45	39	5,5	1,4	3	3	●	●
M	2,0	0,40	1,60	39	6,1	1,5	3	4	●	●
M	2,2	0,45	1,75	39	6,7	1,7	3	4	●	●
M	2,5	0,45	2,10	39	7,9	1,9	3	4	●	●
M	3,0	0,50	2,50	39	9,2	2,4	3	4	●	●
M	3,5	0,60	2,90	39	10,7	2,8	3	4	●	●
M	4,0	0,70	-	54	12,7	-	6	4	●	●
M	5,0	0,80	-	54	15,8	-	6	4	●	●
M	6,0	1,00	-	54	19,0	-	4	4	●	●

● Standardartikel / Items available ex stock

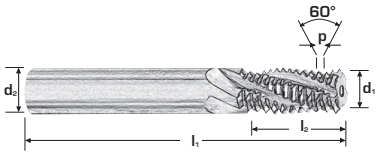
MULTI **TM**

27° RECHTSDRALL **/** RIGHT HAND HELIX 27°

Gewindefräser mit Zylinderschaft und innerer Kühlmittelzufuhr, aus Vollhartmetall für Metrisches ISO-Regelgewinde nach DIN 13(Einschraubtiefe max. 1,5 x d_1)
Solid carbide thread milling cutters with straight shank and internal cooling, for ISO metric coarse thread as per DIN 13 (depth of withdraw max. 1,5 x d_1)

Für Innegewinde
For internal threads

M | TiAlN Futura | **Axialer Kühlmittelaustritt** Axial internal cooling



Typ / Type									**Multi TM**
Schneidstoff / Material									VHM
Ø mm		**Steigung** Pitch	**Kernloch Ø** Tap drill Ø	**l_1 mm**	**l_2 mm**	**Ø d_1 (nominal)**	**d_2 mm**	**Z**	**7000**
M	2	0,40	1,6	48	4,00	1,50	6	2	■
M	6	1,00	5,0	54	11,00	4,50	6	3	■
M	8	1,25	6,8	54	14,00	5,95	6	3	■
M	10	1,50	8,5	64	17,00	7,95	8	4	■

● Standardartikel / Items available ex stock ■ Auslaufender Artikel / discontinued items

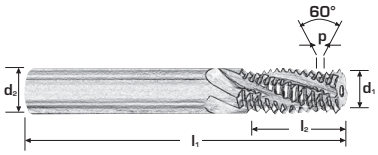
MULTI **TM**

27° RECHTSDRALL **/** RIGHT HAND HELIX 27°

Gewindefräser mit Zylinderschaft und innerer Kühlmittelzufuhr, aus Vollhartmetall für Metrisches ISO-Regelgewinde nach DIN 13 (Einschraubtiefe max. 2.0 x d_1)
Solid carbide thread milling cutters with straight shank and internal cooling, for ISO metric coarse thread as per DIN 13 (depth of withdraw max. 2,0 x d_1)

Für Innegewinde
For internal threads

M | TiAlN Futura | **Axialer Kühlmittelaustritt** Axial internal cooling



Typ / Type								Multi TM	Multi TM
Schneidstoff / Material								VHM	VHM
Ø mm	**Steigung** Pitch	**Kernloch Ø** Tap drill Ø	**l_1 mm**	**l_2 mm**	**Ø d_1 (nominal)**	**d_2 mm**	**Z**	**7001**	**7001 TF**
M 6	1,00	5,0	54	13,5	4,50	6	3	●	●
M 8	1,25	6,8	54	18,1	5,95	6	3	●	●
M 10	1,50	8,5	64	21,7	7,95	8	4	●	●
M 12	1,75	10,2	74	27,1	9,95	10	4	●	●
M 14	2,00	12,0	74	30,9	11,95	10	4	●	●
M 16	2,00	14,0	80	34,9	13,95	12	4	●	●
M 18	2,50	15,5	90	41,1	15,40	14	4	●	●
M 20	2,50	17,5	90	41,1	17,40	14	4	●	●

● **Standardartikel /** Items available ex stock

MULTI **TM-AERO**

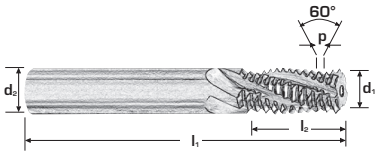
27° RECHTSDRALL **/** RIGHT HAND HELIX 27°

Gewindefräser mit Zylinderschaft und innerer Kühlmittelzufuhr, aus Vollhartmetall für Gewinde MJ (Einschraubtiefe max. 2 x d_1)
Solid carbide thread milling cutters with straight shank and internal coolant, for MJ thread (depth of thread max. 2 x d_1)

Für Innegewinde
For internal threads

MJ | TiAlN Futura | **Axialer Kühlmittelaustritt** Axial internal cooling

NEW



Typ / Type									Multi TM	Multi TM
Schneidstoff/ Material									VHM	VHM
Ø mm		**Steigung** Pitch	**Kernloch Ø** Tap drill Ø	**l_1 mm**	**l_2 mm**	**Ø d_1 (nominal)**	**d_2 mm**	**Z**	**7013**	**7013 TF**
MJ	**4**	0,70	3,3	48	8,75	3,10	6	3	●	●
MJ	**5**	0,80	4,2	54	10,75	3,90	6	3	●	●
MJ	**6**	1,00	5	54	13,50	4,80	6	3	●	●
MJ	**8**	1,25	6,8	54	18,10	5,95	6	3	●	●
MJ	**10**	1,50	8,5	64	21,70	7,95	8	4	●	●
MJ	**12**	1,75	10,3	74	27,10	9,95	10	4	●	●

● Standardartikel / Items available ex stock

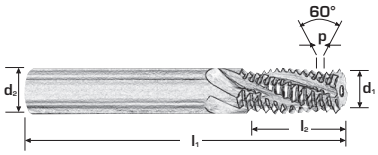
MULTI **TM**

27° RECHTSDRALL **/** RIGHT HAND HELIX 27°

Gewindefräser mit Zylinderschaft und innerer Kühlmittelzufuhr, aus Vollhartmetall für Metrisches ISO-Feingewinde nach DIN 13 (Einschraubtiefe max. 1,5 x d_1)
Solid carbide thread milling cutters with straight shank and internal cooling, for ISO metric fine thread as per DIN 13 (depth of withdraw max. 1,5 x d_1)

Für Innegewinde
For internal threads

MF | TiAlN Futura | **Axialer Kühlmittelaustritt** Axial internal cooling



Typ / Type									Multi TM	Multi TM
Schneidstoff / Material									VHM	VHM
Ø mm		**Steigung** Pitch	**Kernloch Ø** Tap drill Ø	**Ø d_1** (nominal)	**l_1** mm	**l_2** mm	**d_2** mm	**Z**	**7002**	**7002 TF**
MF	4	0,50	3,5	3,00	48	7,2	6	3	■	■
MF	8	0,75	7,2	5,95	54	13,1	6	3	■	-
MF	10	1,00	9,0	7,95	64	16,5	8	4	■	-

● Standardartikel / Items available ex stock ■ Auslaufender Artikel / discontinued items

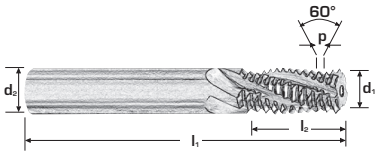
MULTI **TM**

27° RECHTSDRALL **/** RIGHT HAND HELIX 27°

Gewindefräser mit Zylinderschaft und innerer Kühlmittelzufuhr, aus Vollhartmetall für Metrisches ISO-Feingewinde nach DIN 13 (Einschraubtiefe max. 2,0 x d1)
Solid carbide thread milling cutters with straight shank and internal cooling, for ISO metric fine thread as per DIN 13 (depth of withdraw max. 2,0 x d_1)

Für Innegewinde
For internal threads

MF | TiAlN Futura | **Axialer Kühlmittelaustritt** Axial internal cooling



Typ / Type									Multi TM	Multi TM
Schneidstoff / Material									VHM	VHM
Ø mm		**Steigung** Pitch	**Kernloch Ø** Tap drill Ø	**l_1 mm**	**l_2 mm**	**Ø d_1 (nominal)**	**d_2 mm**	**Z**	**7003**	**7003 TF**
MF	**6**	0,50	5,5	54	12,7	4,50	6	3	●	●
MF	**6**	0,75	5,2	54	13,1	4,50	6	3	●	●
MF	**8**	0,50	7,5	54	17,7	5,95	6	3	●	●
MF	**8**	0,75	7,2	54	16,8	5,95	6	3	●	●
MF	**8**	1,00	7,0	54	17,5	5,95	6	3	●	●
MF	**10**	1,00	9,0	64	21,5	7,95	8	4	●	●
MF	**10**	1,25	8,7	64	21,8	7,95	8	4	●	●
MF	**12**	1,00	11,0	74	25,5	9,95	10	4	●	●
MF	**12**	1,50	10,4	74	26,2	9,95	10	4	●	●

● Standardartikel / Items available ex stock

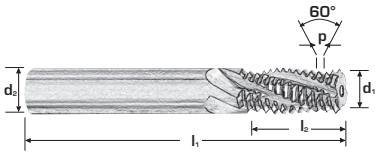
MULTI **TM**

27° RECHTSDRALL **/** RIGHT HAND HELIX 27°

Gewindefräser mit Zylinderschaft und innerer Kühlmittelzufuhr, aus Vollhartmetall für Unified Gewinde UNC ANSI B 1.1 (Einschraubtiefe max. 2 x d_1)
Solid carbide thread milling cutters with straight shank and internal cooling, for Unified thread UNC ANSI B 1.1 (depth of withdraw max. 2,0 x d_1)

Für Innegewinde
For internal threads

UNC | TiAlN Futura | **Axialer Kühlmittelaustritt** Axial internal cooling



Typ / Type										Multi TM	Multi TM
Schneidstoff / Material										VHM	VHM
Ø mm		**Gg/1"** Tpi	**Steigung** Pitch	**Kernloch Ø** Tap drill Ø	**l_1** mm	**l_2** mm	**Ø d_1** (nominal)	**d_2** mm	**Z**	**7007**	**7007 TF**
UNC	**1/4**	20	1,270	5,2	54	14,5	4,80	6	3	●	●
UNC	**5/16**	18	1,411	6,5	54	17,6	5,95	6	3	●	●
UNC	**3/8**	16	1,587	8,0	64	21,4	7,10	8	4	●	●
UNC	**7/16**	14	1,814	9,3	64	24,4	7,95	8	4	●	●
UNC	**1/2**	13	1,953	10,8	74	28,3	9,95	10	4	●	●

● Standardartikel / Items available ex stock

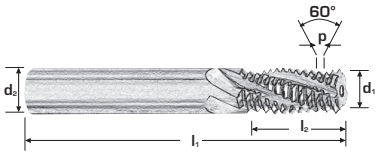
MULTI **TM**

27° RECHTSDRALL **/** RIGHT HAND HELIX 27°

Gewindefräser mit Zylinderschaft und innerer Kühlmittelzufuhr, aus Vollhartmetall für Unified Gewinde UNF ANSI B 1.1 (Einschraubtiefe max. 2 x d_1)
Solid carbide thread milling cutters with straight shank and internal cooling, for Unified thread UNF ANSI B 1.1 (depth of withdraw max. 2,0 x d_1)

Für Innegewinde
For internal threads

UNF | TiAlN Futura | **Axialer Kühlmittelaustritt** Axial internal cooling



Typ / Type									Multi TM	Multi TM
Schneidstoff / Material									VHM	VHM
Ø mm	**Gg/1"** Tpi	**Steigung** Pitch	**Kernloch Ø** Tap drill Ø	**l_1** mm	**l_2** mm	**Ø d_1** (nominal)	**d_2** mm	**Z**	**7009**	**7009 TF**
UNF 1/4	28	0,907	5,5	54	14,0	4,80	6	3	●	●
UNF 5/16	24	1,058	6,8	54	17,4	5,95	6	3	●	●
UNF 3/8	24	1,058	8,5	64	20,6	7,95	8	4	●	●
UNF 7/16	20	1,270	9,8	64	24,7	7,95	8	4	●	●
UNF 1/2	20	1,270	11,5	74	27,3	9,95	10	4	●	●

● Standardartikel / Items available ex stock

MULTI **TM-AERO**

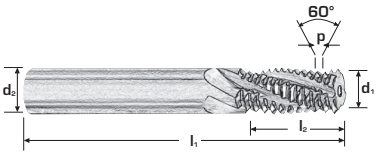
27° RECHTSDRALL **/** RIGHT HAND HELIX 27°

Gewindefräser mit Zylinderschaft und innerer Kühlmittelzufuhr, aus Vollhartmetall für UNJF Gewinde (Einschraubtiefe max. 2 x d_1)
Solid carbide thread milling cutters with straight shank and internal coolant, for UNJF thread (depth of thread max. 2,0 x d_1)

Für Innegewinde
For internal threads

UNJF | TiAlN Futura | **Axialer Kühlmittelaustritt** Axial internal cooling

NEW



Typ / Type								Multi TM	Multi TM
Schneidstoff/ Material								VHM	VHM
Ø mm	**Steigung** Pitch	**Kernloch Ø** Tap drill Ø	**l_1 mm**	**l_2 mm**	**Ø d_1** (nominal)	**d_2 mm**	**Z**	**7014**	**7014 TF**
UNJF nr. 10	32	4,83	54	11,5	3,90	6	3	●	●
UNJF 1/4	29	6,35	54	14,0	5,50	6	3	●	●
UNJF 5/16	24	7,94	54	17,4	5,95	6	3	●	●
UNJF 3/8	24	9,53	64	20,6	7,95	8	4	●	●
UNJF 7/16	20	11,11	64	24,7	7,95	8	4	●	●
UNJF 1/2	20	12,70	74	27,3	9,95	10	4	●	●

● Standardartikel / Items available ex stock

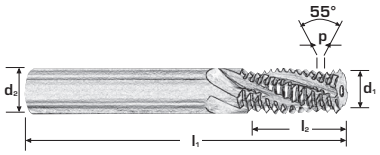
MULTI **TM**

27° RECHTSDRALL **/** RIGHT HAND HELIX 27°

Gewindefräser mit Zylinderschaft und innerer Kühlmittelzufuhr, aus Vollhartmetall für Whitworth-Rohrgewinde DIN – ISO 228 (Einschraubtiefe max. 2 x d_1)
Solid carbide thread milling cutters with straight shank and internal cooling, for British standard pipe thread DIN – ISO 228 (depth of withdraw max. 2,0 x d_1)

Für Innen- und Außengewinde
For internal and external threads

G | TiAlN Futura | **Axialer Kühlmittelaustritt** Axial internal cooling



Typ / Type									Multi TM	Multi TM
Schneidstoff/ Material									VHM	VHM
Ø mm	**Gg/1"** Tpi	**Steigung** Pitch	**Kernloch Ø** Tap drill Ø	**l_1** mm	**l_2** mm	**Ø d_1** (nominal)	**d_2** mm	**Z**	**7005**	**7005 TF**
G 1/8	28	0,907	8,7	64	21,3	7,95	8	4	●	●
G 1/4	19	1,336	11,8	74	28,7	9,95	10	4	●	●
G 3/8	19	1,336	15,2	90	35,5	13,60	14	4	●	●

● Standardartikel / Items available ex stock

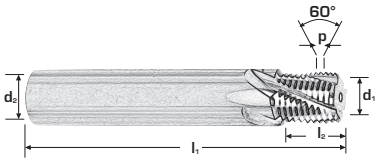
MULTI **TM**

27° RECHTSDRALL **/** RIGHT HAND HELIX 27°

Gewindefräser mit Zylinderschaft und innerer Kühlmittelzufuhr, aus Vollhartmetall, für NPT Gewinde ANSI B 1.20.1 - Kegel 1 : 16
Solid carbide thread milling cutters with straight shank and internal cooling, for American standard taper pipe thread ANSI B 1.20.1 - taper 1 : 16

Für Innegewinde
For internal threads

NPT | TiAlN Futura | **Axialer Kühlmittelaustritt** Axial internal cooling



Typ / Type										Multi TM	Multi TM
Schneidstoff / Material										VHM	VHM
Ø mm		**Gg/1"** Tpi	**Steigung** Pitch	**Kernloch Ø** Tap drill Ø	**l_1** mm	**l_2** mm	**Ø d_1** (nominal)	**d_2** mm	**Z**	**7010**	**7010 TF**
NPT	**1/8**	27	0,940	8,4	64	9,9	7,30	8	4	●	●
NPT	**1/4**	18	1,411	10,8	72	19,0	9,95	12	4	●	●
NPT	**3/8**	18	1,411	14,2	80	14,8	12,50	14	4	●	●
NPT	**1/2**	14	1,810	16,3	80	19,1	14,50	14	4	●	●

● Standardartikel / Items available ex stock

MULTI **TM**

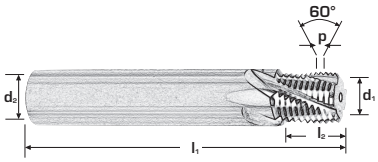
27° RECHTSDRALL **/** RIGHT HAND HELIX 15°

Gewindefräser mit Zylinderschaft und innerer Kühlmittelzufuhr, aus Vollhartmetall, für NPT Gewinde ANSI B 1.20.3 - Kegel 1 : 16
Solid carbide thread milling cutters with straight shank and internal cooling, for American standard taper pipe thread ANSI B 1.20.1 - taper 1 : 16

Für Innegewinde
For internal threads

NPTF | TiAlN Futura

Axialer Kühlmittelaustritt
Axial internal cooling



Typ / Type										Multi TM	Multi TM
Schneidstoff / Material										VHM	VHM
Ø mm		**Gg/1"** Tpi	**Steigung** Pitch	**Kernloch Ø** Tap drill Ø	**l_1** mm	**l_2** mm	**Ø d_1** (nominal)	**d_2** mm	**Z**	**7012**	**7012 TF**
NPT	**1/8**	27	0,940	8,4	64	9,9	7,30	8	4	●	●
NPT	**1/4**	18	1,411	10,8	72	19,0	9,95	12	4	●	●
NPT	**3/8**	18	1,411	14,2	80	14,8	12,50	14	4	●	●
NPT	**1/2**	14	1,810	16,3	80	19,1	14,50	14	4	●	●

● Standardartikel / Items available ex stock

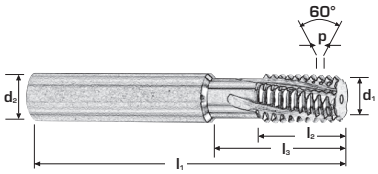
MULTI **TM**

15° RECHTSDRALL **/** RIGHT HAND HELIX 15°

Gewindefräser mit Zylinderschaft und innerer Kühlmittelzufuhr, aus Vollhartmetall für Metrisches ISO Gewinde nach DIN 13
Solid carbide thread milling cutters with straight shank and internal cooling, for ISO metric thread as per DIN 13

Für Innegewinde
For internal threads

M MF **Axialer Kühlmittelaustritt**
Axial internal cooling



Typ / Type							Multi TM	Multi TM
Schneidstoff / Material							VHM	VHM
Ø d_1 (nominal)	**Steigung** Pitch	**l_1** mm	**l_2** mm	**l_3** mm	**d_2** mm	**Z**	**7020**	**7020 TF**
8	0,50	64	16	16	8	4	●	●
8	0,75	64	16	16	8	4	●	●
10	0,75	70	16	25	10	4	●	●
10	1,00	70	16	25	10	4	●	●
10	1,25	70	16	25	10	4	●	●
10	1,50	70	16	25	10	4	●	●
12	0,50	80	20	31	12	4	●	●
12	1,00	80	20	31	12	4	●	●
12	1,25	80	20	31	12	4	●	●
12	1,50	80	20	31	12	4	●	●
12	2,00	80	20	31	12	4	●	●
16	1,00	90	25	40	16	5	●	●
16	1,50	90	25	40	16	5	●	●
16	2,00	90	25	40	16	5	●	●
16	2,50	90	25	40	16	5	●	●
20	1,00	105	33	50	20	5	●	●
20	1,50	105	33	50	20	5	●	●
20	2,00	105	33	50	20	5	●	●
20	2,50	105	33	50	20	5	●	●
20	3,00	105	33	50	20	5	●	●

Um größere Profilüberfräsungen zu vermeiden, darf der Fräser-Ø für Feingewinde nicht größer als 2/3 des zu fräsenden Gewinde-Ø sein.
To avoid too deeply milled profiles, the thread mill Ø must not exceed 2/3 of the Ø of thread to be milled.

● Standardartikel / Items available ex stock

MULTI **TM**

15° RECHTSDRALL **/** RIGHT HAND HELIX 15°

Gewindefräser mit Zylinderschaft und innerer Kühlmittelzufuhr, aus Vollhartmetall für Unified Gewinde UN ANSI B 1.1

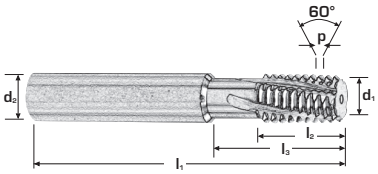
Solid carbide thread milling cutters with straight shank and internal cooling, for Unified national thread UN ANSI B 1.1

Für Innegewinde

For internal threads

UN | TiAlN Futura

Axialer Kühlmittelaustritt
Axial internal cooling



Typ / Type										Multi TM	Multi TM
Schneidstoff/ Material										VHM	VHM
Ø mm	**Ø d_1 (nominal)**	**Gg/1"** Tpi	**Steigung** Pitch	**Kernloch Ø** Tap drill Ø	**l_1 mm**	**l_2 mm**	**l_3 mm**	**d_2 mm**	**Z**	**7027**	**7027 TF**
UN 1/2	**10**	**24**	1,06	11,7	70	16	25	10	4	●	●
UN 5/8	**12**	**24**	1,06	18,1	80	20	31	12	4	●	●
UN 11/16	**12**	**20**	1,28	17,9	80	20	31	12	4	●	●
UN 5/8	**12**	**18**	1,42	17,7	80	20	31	12	4	●	●
UN 5/8	**12**	**16**	1,60	17,5	80	20	31	12	4	●	●
UN 13/16	**16**	**24**	1,06	24,5	90	25	40	16	4	●	●
UN 13/16	**16**	**20**	1,28	24,2	90	25	40	16	4	●	●
UN 7/8	**16**	**18**	1,42	24,1	90	25	40	16	4	●	●
UN 7/8	**16**	**16**	1,60	23,9	90	25	40	16	4	●	●
UN 7/8	**16**	**14**	1,82	23,7	90	25	40	16	4	●	●
UN 7/8	**16**	**12**	2,12	23,4	90	25	40	16	4	●	●
UN 1	**20**	**24**	1,06	30,8	105	33	50	20	5	●	●
UN 1	**20**	**20**	1,28	30,6	105	33	50	20	5	●	●
UN 1	**20**	**18**	1,42	30,5	105	33	50	20	5	●	●
UN 1	**20**	**16**	1,60	30,3	105	33	50	20	5	●	●
UN 1	**20**	**14**	1,82	30,1	105	33	50	20	5	●	●
UN 1	**20**	**12**	2,12	29,8	105	33	50	20	5	●	●
UN 1	**20**	**8**	3,19	28,7	105	33	50	20	5	●	●

Um größere Profilüberfräsungen zu vermeiden, darf der Fräser-Ø für Feingewinde nicht größer als 2/3 des zu fräsenden Gewinde-Ø sein.
To avoid too deeply milled profiles, the thread mill Ø must not exceed 2/3 of the Ø of thread to be milled.

● Standardartikel / Items available ex stock

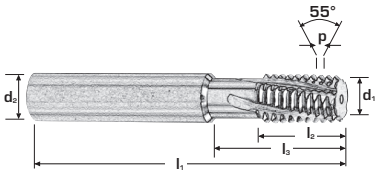
MULTI **TM**

15° RECHTSDRALL **/** RIGHT HAND HELIX 15°

Gewindefräser mit Zylinderschaft und innerer Kühlmittelzufuhr, aus Vollhartmetall für Whitworth-Rohrgewinde DIN – ISO 228
Solid carbide thread milling cutters with straight shank and internal cooling, for British standard pipe thread DIN – ISO 228

Für Innen- und Außengewinde
For internal and external threads

G TiAlN Futura **Axialer Kühlmittelaustritt**
Axial internal cooling



Typ / Type										Multi TM	Multi TM
Schneidstoff / Material										VHM	VHM
Ø mm	**Ø d_1 (nominal)**	**Gg/1"** Tpi	**Steigung** Pitch	**Kernloch Ø** Tap drill Ø	**l_1 mm**	**l_2 mm**	**l_3 mm**	**d_2 mm**	**Z**	**7024**	**7024 TF**
G 1/4 - 3/8	**10**	**19**	1,336	11,80	70	16	25	10	4	●	●
G 1/2 - 5/8 - 3/4 - 7/8	**16**	**14**	1,814	19,00	90	25	40	16	5	●	●
G 1-11/8 -11/4 -13/8 -11/2 -13/4 - 2	**20**	**11**	2,309	30,75	105	33	50	20	5	●	●

Um größere Profilüberfräsungen zu vermeiden, darf der Fräser-Ø für Feingewinde nicht größer als 2/3 des zu fräsenden Gewinde-Ø sein.
To avoid too deeply milled profiles, the thread mill Ø must not exceed 2/3 of the Ø of thread to be milled.

● Standardartikel / Items available ex stock

MULTI **TM**

15° RECHTSDRALL **/** RIGHT HAND HELIX 15°

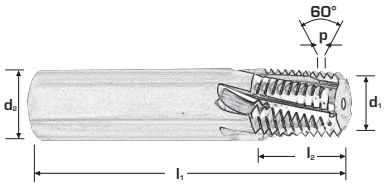
Gewindefräser mit Zylinderschaft und innerer Kühlmittelzufuhr, aus Vollhartmetall für NPT Gewinde ANSI B 1.20.1 Kegel 1 : 16

Solid carbide thread milling cutters with straight shank and internal cooling, for American standard taper pipe thread ANSI B 1.20.1 - taper 1 : 16

Für Innegewinde

For internal threads

NPT | TiAlN Futura | **Axialer Kühlmittelaustritt** Axial internal cooling



Typ / Type									Multi TM	Multi TM
Schneidstoff / Material									VHM	VHM
Ø mm	**Gg/1"** Tpi	**Steigung** Pitch	**Kernloch Ø** Tap drill Ø	**l_1** mm	**l_2** mm	**Ø d_1** (nominal)	**d_2** mm	**Z**	**7030**	**7030 TF**
NPT 1/2 ÷ 3/4	14,0	1,81	18 - 23	90	19,05	14,5	16	5	●	●
NPT 1" ÷ 2"	11,5	2,21	29 - 56	90	23,19	18,5	20	5	●	●

Um größere Profilüberfräsungen zu vermeiden, darf der Fräser-Ø für Feingewinde nicht größer als 2/3 des zu fräsenden Gewinde-Ø sein.
To avoid too deeply milled profiles, the thread mill Ø must not exceed 2/3 of the Ø of thread to be milled.

● Standardartikel / Items available ex stock

MULTI **TM**

15° RECHTSDRALL **/** RIGHT HAND HELIX 15°

Gewindefräser mit Zylinderschaft und innerer Kühlmittelzufuhr, aus Vollhartmetall für NPTF Gewinde ANSI B 1.20.3 Kegel 1 : 16

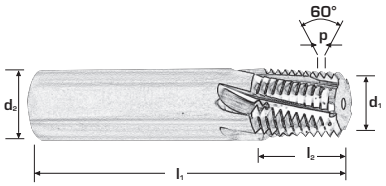
Solid carbide thread milling cutters with straight shank and internal cooling, for dryseal American standard taper pipe thread ANSI B 1.20.3 - taper 1 : 16

Für Innegewinde

For internal threads

NPTF TiAlN Futura

Axialer Kühlmittelaustritt
Axial internal cooling



Typ / Type									Multi TM	Multi TM
Schneidstoff / Material									VHM	VHM
Ø mm	**Gg/1"** Tpi	**Steigung** Pitch	**Kernloch Ø** Tap drill Ø	**l_1** mm	**l_2** mm	**Ø d_1** (nominal)	**d_2** mm	**Z**	**7032**	**7032 TF**
NPTF 1/2 ÷ 3/4	14,0	1,81	18 - 23	90	19,05	14,5	16	5	●	●
NPTF 1" ÷ 2"	11,5	2,21	29 - 56	90	23,19	18,5	20	5	●	●

Um größere Profilüberfräsungen zu vermeiden, darf der Fräser-Ø für Feingewinde nicht größer als 2/3 des zu fräsenden Gewinde-Ø sein.
To avoid too deeply milled profiles, the thread mill Ø must not exceed 2/3 of the Ø of thread to be milled.

● Standardartikel / Items available ex stock

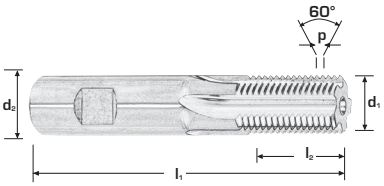
Gewindefräser mit Einheitsschaft nach DIN 6535 HB und innerer Kühlmittelzufuhr aus Vollhartmetall, für Metrisches ISO Gewinde nach DIN 13

Thread milling cutters with Unified shank acc. to DIN 6535 HB and internal coolingmade of solid carbide, for ISO metric thread as per DIN 13

Für Innegewinde

For internal threads

M TiAlN Futura **Axialer Kühlmittelaustritt**
Axial internal cooling



Typ / Type						Multi TM	Multi TM
Schneidstoff/ Material						VHM	VHM
Ø d_1 (nominal)	**Steigung** Pitch	**l_1 mm**	**l_2 mm**	**d_2 mm**	**Z**	**6930**	**6930 TF**
20	1,0	105	32	20	5	■	■
16	1,5	90	25	16	5	■	■
20	1,5	105	32	20	5	■	■
16	2,0	90	25	16	5	■	■
20	2,0	105	32	20	5	■	■
20	2,5	105	32	20	5	■	■
20	3,0	105	32	20	5	■	-

Um größere Profilüberfräsungen zu vermeiden, darf der Fräser-Ø für Feingewinde nicht größer als 2/3 des zu fräsenden Gewinde-Ø sein.
To avoid too deeply milled profiles, the thread mill Ø must not exceed 2/3 of the Ø of thread to be milled.

■ Auslaufender Artikel / discontinued items

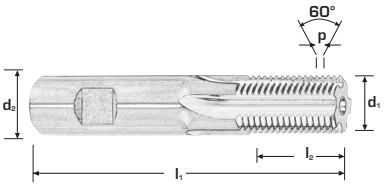
Gewindefräser mit Einheitsschaft nach DIN 6535 HB und innerer Kühlmittelzufuhr aus Vollhartmetall, für Metrisches ISO Gewinde nach DIN 13

Thread milling cutters with Unified shank acc. to DIN 6535 HB and internal coolingmade of solid carbide, for ISO metric thread as per DIN 13

Für Außengewinde

For external threads

M | TiAlN Futura | **Axialer Kühlmittelaustritt** Axial internal cooling



Typ / Type						Multi TM	Multi TM
Schneidstoff/ Material						VHM	VHM
Ø d_1 (nominal)	**Steigung** Pitch	**l_1 mm**	**l_2 mm**	**d_2 mm**	**Z**	**6931**	**6931 TF**
12	1,0	80	20	12	4	■	■
12	1,5	80	20	12	4	■	-
16	1,5	90	25	16	5	■	-
16	2,0	90	25	16	5	■	■
20	2,0	105	32	20	5	■	■
20	3,0	105	32	20	5	-	■

Um größere Profilüberfräsungen zu vermeiden, darf der Fräser-Ø für Feingewinde nicht größer als 2/3 des zu fräsenden Gewinde-Ø sein.
To avoid too deeply milled profiles, the thread mill Ø must not exceed 2/3 of the Ø of thread to be milled.

■ Auslaufender Artikel / discontinued items

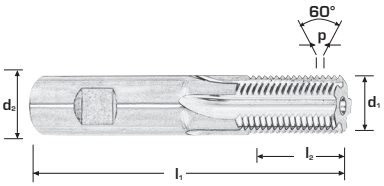
Gewindefräser mit Einheitsschaft nach DIN 6535 HB und innerer Kühlmittelzufuhr aus Vollhartmetall, für Whitworth-Rohrgewinde DIN – ISO 228

Thread milling cutters with unified shankacc. to DIN 6535 HB and internal cooling made of solid carbide, for British standard pipe thread DIN – ISO 228

Für Innen- und Außengewinde

For internal and external threads

G TiAlN Futura **Axialer Kühlmittelaustritt**
Axial internal cooling



Typ / Type									Multi TM	Multi TM
Schneidstoff/ Material									VHM	VHM
Ø mm	**Gg/1"** Tpi	**Steigung** Pitch	**Kernloch Ø** Tap drill Ø	**l_1** mm	**l_2** mm	**Ø d_1** (nominal)	**d_2** mm	**Z**	**6932**	**6932 TF**
G 1/2	14	1,814	30,75	105	32	20	20	5	■	■

■ Auslaufender Artikel / discontinued items

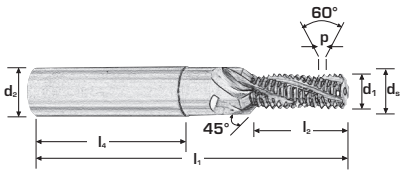
MULTI **CTM**

27° RECHTSDRALL **/** RIGHT HAND HELIX 27°

Gewindefräser mit Senkfase, mit Zylinderschaft und innerer Kühlmittelzufuhr, aus Vollhartmetall für Metrisches ISO – Regelgewinde nach DIN 13
Solid carbide thread milling cutters with chamfer, with straight shank and internal cooling, for ISO metric coarse thread as per DIN 13

Für Innegewinde
For internal threads

M | TiAlN Futura | **Axialer Kühlmittelaustritt** Axial internal cooling



Typ / Type											Multi CTM	Multi CTM
Schneidstoff/ Material											VHM	VHM
Ø mm		Steigung Pitch	Kernloch Ø Tap drill Ø	l_1 mm	l_2 mm	l_4 mm	Ø d_1 (nominal)	Ø d_{2mm} h6	Ø ds	Z	7040	7040 TF
M	2,0	0,40	1,60	48	3,40	36	1,5	6	2,1	2	●	●
M	2,5	0,45	2,05	48	4,25	36	1,9	6	2,6	3	●	●
M	3,0	0,50	2,50	48	5,25	36	2,3	6	3,2	3	●	●
M	3,5	0,60	2,75	48	6,30	36	2,7	6	3,7	3	●	●
M	4,0	0,70	3,30	48	7,35	36	3,0	6	4,2	3	●	●
M	5,0	0,80	4,20	54	9,15	36	3,8	6	5,3	3	●	●
M	6,0	1,00	5,00	62	10,50	36	4,5	8	6,3	3	●	●
M	8,0	1,25	6,80	74	13,10	40	6,0	10	8,4	3	●	●
M	10,0	1,50	8,50	80	17,20	45	8,0	12	10,5	4	●	●
M	12,0	1,75	10,20	90	20,05	45	10,0	14	12,6	4	●	●
M	14,0	2,00	12,00	102	25,00	48	10,8	16	14,7	4	●	●
M	16,0	2,00	14,00	102	27,00	48	12,8	18	16,8	4	●	●
M	18,0	2,50	15,50	125	33,70	50	13,9	20	21,0	4	●	●
M	20,0	2,50	17,50	125	33,70	50	13,9	20	21,0	4	●	●

● Standardartikel / Items available ex stock

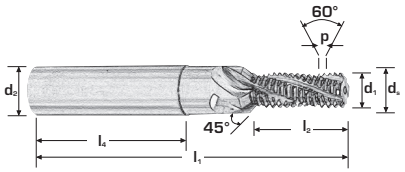
MULTI **CTM**

27° RECHTSDRALL **/** RIGHT HAND HELIX 27°

Gewindefräser mit Senkfase, mit Zylinderschaft und innerer Kühlmittelzufuhr, aus Vollhartmetall für Metrisches ISO – Regelgewinde nach DIN 13
Solid carbide thread milling cutters with chamfer, with straight shank and internal cooling, for ISO metric coarse thread as per DIN 13

Für Innegewinde
For internal threads

M | TiAlN Futura | **Axialer Kühlmittelaustritt** Axial internal cooling



Typ / Type											Multi CTM	Multi CTM
Schneidstoff / Material											VHM	VHM
Ø mm		**Steigung** Pitch	**Kernloch Ø** Tap drill Ø	**l_1 mm**	**l_2 mm**	**l_4 mm**	**Ø d_1** (nominal)	**Ø $d_2$mm** h6	**Ø ds**	**Z**	**7041**	**7041 TF**
M	2,0	0,40	1,60	48	4,6	36	1,50	6	2,1	2	●	●
M	2,5	0,45	2,05	48	6,1	36	1,90	6	2,6	3	●	●
M	3,0	0,50	2,50	48	6,7	36	2,30	6	3,2	3	●	●
M	3,5	0,60	2,75	48	8,1	36	2,70	6	3,7	3	●	●
M	4,0	0,70	3,30	48	8,7	36	3,00	6	4,2	3	●	●
M	5,0	0,80	4,20	54	10,8	36	3,80	6	5,3	3	●	●
M	6,0	1,00	5,00	62	13,5	36	4,50	8	6,3	3	●	●
M	8,0	1,25	6,80	74	18,1	40	5,95	10	8,4	3	●	●
M	10,0	1,50	8,50	80	21,7	45	7,95	12	10,5	4	●	●
M	12,0	1,75	10,20	90	25,3	45	9,95	14	12,6	4	●	●
M	14,0	2,00	12,00	102	31,0	48	10,80	16	14,7	4	●	●
M	16,0	2,00	14,00	102	35,0	48	12,80	18	16,8	4	●	●
M	18,0	2,50	15,50	125	41,2	50	13,90	20	21,5	4	●	●
M	20,0	2,50	17,50	125	41,2	50	13,90	20	21,5	4	●	●

● Standardartikel / Items available ex stock

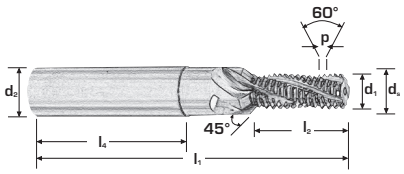
MULTI **CTM**

27° RECHTSDRALL **/** RIGHT HAND HELIX 27°

Gewindefräser mit Senkfase, mit Zylinderschaft und innerer Kühlmittelzufuhr, aus Vollhartmetall für Metrisches ISO – Feingewinde nach DIN 13
Solid carbide thread milling cutters with chamfer, with straight shank and internal cooling, for ISO metric coarse thread as per DIN 13

Für Innegewinde
For internal threads

MF | TiAlN Futura | **Axialer Kühlmittelaustritt** Axial internal cooling



Typ / Type											Multi CTM	Multi CTM
Schneidstoff / Material											VHM	VHM
Ø mm		**Steigung** Pitch	**Kernloch Ø** Tap drill Ø	**l_1 mm**	**l_2 mm**	**l_4 mm**	**Ø d_1** (nominal)	**Ø d_2 mm** h6	**Ø ds**	**Z**	**7042**	**7042 TF**
MF	**4**	0,50	3,3	48	7,25	36	3,00	6	4,2	3	●	●
MF	**5**	0,50	4,2	54	8,75	36	3,80	6	5,3	3	●	●
MF	**6**	0,50	5,0	62	9,75	36	4,50	8	6,3	3	●	●
MF	**6**	0,75	5,0	62	10,13	36	4,50	8	6,3	3	●	●
MF	**8**	0,50	6,8	74	12,75	40	5,95	10	8,4	3	●	●
MF	**8**	0,75	6,8	74	13,13	40	5,95	10	8,4	3	●	●
MF	**8**	1,00	6,8	74	13,50	40	5,95	10	8,4	3	●	●
MF	**10**	1,00	8,5	80	16,50	45	7,95	12	10,5	4	●	●
MF	**10**	1,25	8,5	80	16,90	45	7,95	12	10,5	4	●	●
MF	**12**	1,00	10,2	90	19,50	45	9,95	14	12,6	4	●	●
MF	**12**	1,50	10,2	90	20,25	45	9,95	14	12,6	4	●	●
MF	**14**	1,50	12,0	102	23,25	48	10,80	16	14,7	4	●	●
MF	**16**	1,50	14,0	102	26,25	48	12,80	18	16,8	4	●	●

● Standardartikel / Items available ex stock

MULTI **CTM**

27° RECHTSDRALL **/** RIGHT HAND HELIX 27°

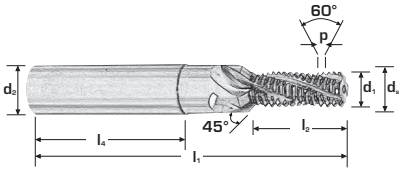
Gewindefräser mit Zylinderschaft und innerer Kühlmittelzufuhr, aus Vollhartmetall für Metrisches ISO-Feingewinde nach DIN 13 (Einschraubtiefe max. 2.0 x d1)

Solid carbide thread milling cutters with chamfer, with straight shank and internal cooling, for ISO metric coarse thread as per DIN 13

Für Innegewinde

For internal threads

MF | TiAlN Futura | **Axialer Kühlmittelaustritt** Axial internal cooling



Typ / Type											Multi CTM	Multi CTM
Schneidstoff / Material											VHM	VHM
Ø mm		**Steigung** Pitch	**Kernloch Ø** Tap drill Ø	**l_1 mm**	**l_2 mm**	**l_4 mm**	**Ø d_1** (nominal)	**Ø $d_2$mm** h6	**Ø ds**	**Z**	**7043**	**7043 TF**
MF	**4**	0,50	3,3	48	8,7	36	3,00	6	4,2	3	●	●
MF	**5**	0,50	4,2	54	10,7	36	3,80	6	5,3	3	●	●
MF	**6**	0,50	5,0	62	12,7	36	4,50	8	6,3	3	●	●
MF	**6**	0,75	5,0	62	13,1	36	4,50	8	6,3	3	●	●
MF	**8**	0,50	6,8	74	17,7	40	5,95	10	8,4	3	●	●
MF	**8**	0,75	6,8	74	16,9	40	5,95	10	8,4	3	●	●
MF	**8**	1,00	6,8	74	17,5	40	5,95	10	8,4	3	●	●
MF	**10**	1,00	8,5	80	21,5	45	7,95	12	10,5	4	●	●
MF	**10**	1,25	8,5	80	21,9	45	7,95	12	10,5	4	●	●
MF	**12**	1,00	10,2	90	25,5	45	9,95	14	12,6	4	●	●
MF	**12**	1,50	10,2	90	26,2	45	9,95	14	12,6	4	●	●
MF	**14**	1,50	12,0	102	30,8	48	10,80	16	14,7	4	●	●
MF	**16**	1,50	14,0	102	33,8	48	12,80	18	16,8	4	●	●

● Standardartikel / Items available ex stock

MULTI **CTM**

27° RECHTSDRALL **/** RIGHT HAND HELIX 27°

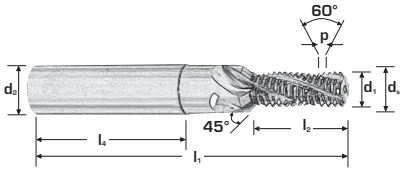
Gewindefräser mit Senkfase, mit Zylinderschaft und innerer Kühlmittelzufuhr, aus Vollhartmetall für Unified Gewinde UNC ANSI B 1.1

Solid carbide thread milling cutters with chamfer, with straight shank and internal cooling, for unified thread UNC ANSI B 1.1

Für Innegewinde

For internal threads

UNC | TiAlN Futura | **Axialer Kühlmittelaustritt** Axial internal cooling



Typ / Type												**Multi CTM**	**Multi CTM**
Schneidstoff/ Material												VHM	VHM
Ø mm		**Gg/1"** Tpi	**Steigung** Pitch	**Kernloch Ø** Tap drill Ø	**l_1** mm	**l_2** mm	**l_4** mm	**Ø d_1** (nominal)	**Ø d_2**mm h6	**Ø ds**	**Z**	**7046**	**7046 TF**
UNC	**nr. 8**	32	0,79	3,5	48	9,1	36	3,10	6	4,4	3	●	●
UNC	**nr. 10**	24	1,06	3,8	54	11,1	36	3,60	6	5,1	3	●	●
UNC	**nr. 12**	24	1,06	4,5	54	12,2	36	4,10	6	5,8	3	●	●
UNC	**1/4**	20	1,27	5,2	62	14,6	36	4,80	8	6,7	3	●	●
UNC	**5/16**	18	1,41	6,5	74	17,6	40	5,95	10	8,3	3	●	●
UNC	**3/8**	16	1,59	8,0	80	21,4	45	7,10	12	10,0	4	●	●
UNC	**7/16**	14	1,81	9,3	80	24,5	45	7,95	12	11,7	4	●	●
UNC	**1/2**	13	1,95	10,8	90	28,3	45	9,95	14	13,3	4	●	●
UNC	**9/16**	12	2,12	12,3	102	30,7	48	10,80	16	15,0	4	●	●
UNC	**5/8**	11	2,31	13,5	102	30,7	48	11,90	18	16,7	4	●	●

● Standardartikel / Items available ex stock

MULTI **CTM**

27° RECHTSDRALL **/** RIGHT HAND HELIX 27°

Gewindefräser mit Senkfase, mit Zylinderschaft und innerer Kühlmittelzufuhr, aus Vollhartmetall für Unified Gewinde UNF ANSI B 1.1

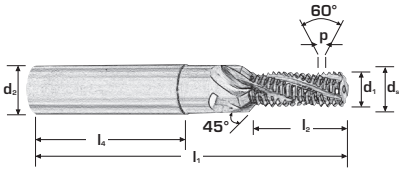
Solid carbide thread milling cutters with chamfer, with straight shank and internal cooling, for unified thread UNF ANSI B 1.1

Für Innegewinde

For internal threads

UNF | TiAlN Futura

Axialer Kühlmittelaustritt
Axial internal cooling



Typ / Type												Multi CTM	Multi CTM
Schneidstoff/ Material												VHM	VHM
Ø mm		**Gg/1"** Tpi	**Steigung** Pitch	**Kernloch Ø** Tap drill Ø	**l_1** mm	**l_2** mm	**l_4** mm	**Ø d_1** (nominal)	**Ø d_2** mm h6	**Ø ds**	**Z**	**7048**	**7048 TF**
UNF	**nr. 10**	32	0,79	4,0	54	11,5	36	3,6	6	5,1	3	●	●
UNF	**nr. 12**	28	0,91	4,6	54	12,2	36	4,1	6	5,8	3	●	●
UNF	**1/4**	28	0,91	5,5	62	14,1	36	4,8	8	6,3	3	●	●
UNF	**5/16**	24	1,06	6,8	74	17,4	40	5,95	10	8,3	3	●	●
UNF	**3/8**	24	1,06	8,5	80	20,7	45	7,95	12	10,0	4	●	●
UNF	**7/16**	20	1,27	9,8	80	24,7	45	7,95	12	11,7	4	●	●
UNF	**1/2**	20	1,27	11,5	90	27,3	45	9,95	14	13,3	4	●	●
UNF	**9/16**	18	1,41	12,8	102	30,3	48	10,8	16	15,0	4	●	●
UNF	**5/8**	18	1,41	14,5	102	33,1	48	11,9	18	16,7	4	●	●

● Standardartikel / Items available ex stock

MULTI **CTM**

27° RECHTSDRALL **/** RIGHT HAND HELIX 27°

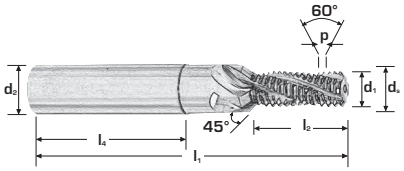
Gewindefräser mit Senkfase, mit Zylinderschaft und innerer Kühlmittelzufuhr, aus Vollhartmetall für Whitworth – Rohrgewinde DIN ISO 228

Solid carbide thread milling cutters with chamfer, with straight shank and internal cooling, for British standard pipe thread DIN – ISO 228

Für Innen- und Außengewinde

For internal and external threads

G | TiAlN Futura | **Axialer Kühlmittelaustritt** Axial internal cooling



Typ / Type											Multi CTM	Multi CTM
Schneidstoff/ Material											VHM	VHM
Ø mm	**Gg/1"** Tpi	**Steigung** Pitch	**Kernloch Ø** Tap drill Ø	**l_1** mm	**l_2** mm	**l_4** mm	**Ø d_1** (nominal)	**Ø d_2** mm h6	**Ø ds**	**Z**	**7044**	**7044 TF**
G 1/8	28	0,88	8,7	80	21,25	45	7,95	12	10,2	4	●	●
G 1/4	19	1,29	11,8	90	28,65	45	9,95	14	13,8	4	●	●
G 3/8	19	1,29	15,2	102	35,35	48	13,6	18	17,5	4	●	●

● Standardartikel / Items available ex stock

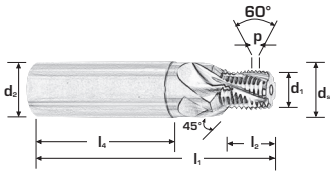
MULTI **CTM**

27° RECHTSDRALL **/** RIGHT HAND HELIX 27°

Gewindefräser mit Senkfase, mit Zylinderschaft und innerer Kühlmittelzufuhr aus Vollhartmetall, für NPT Gewinde ANSI B 1.20.1
Solid carbide thread milling cutters with chamfer, with straight shank and internal cooling, for American standard taper pipe thread ANSI B 1.20.1

Für Innegewinde
For internal threads

NPT | TiAlN Futura | **Axialer Kühlmittelaustritt** Axial internal cooling



Typ / Type											Multi CTM	Multi CTM
Schneidstoff/ Material											VHM	VHM
Ø mm		**Gg/1"** Tpi	**Steigung** Pitch	**Kernloch Ø** Tap drill Ø	**l_1** mm	**l_2** mm	**l_4** mm	**Ø d_1** (nominal)	**Ø d_{2mm}** h6	**Ø ds**	**Z**	**7050**	**7050 TF**
NPT	**1/8**	27	0,94	8,4	70	9,86	45	7,30	12	10,0	4	●	●
NPT	**1/4**	18	1,41	10,8	80	14,8	48	9,95	16	13,1	4	●	●
NPT	**3/8**	18	1,41	12,4	80	14,8	48	12,50	18	16,7	4	●	●

● Standardartikel / Items available ex stock

MULTI **CTM**

27° RECHTSDRALL **/** RIGHT HAND HELIX 27°

Gewindefräser mit Senkfase, mit Zylinderschaft und innerer Kühlmittelzufuhr aus Vollhartmetall, für NPT Gewinde ANSI B 1.20.3

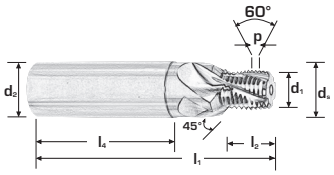
Solid carbide thread milling cutters with chamfer, with straight shank and internal cooling, for dryseal American standard taper pipe thread ANSI B 1.20.3

Für Innegewinde

For internal threads

NPTF TiAlN Futura

Axialer Kühlmittelaustritt
Axial internal cooling



Typ / Type												Multi CTM	Multi CTM
Schneidstoff / Material												VHM	VHM
Ø mm		**Gg/1"** Tpi	**Steigung** Pitch	**Kernloch Ø** Tap drill Ø	**l_1** mm	**l_2** mm	**l_4** mm	**Ø d_1** (nominal)	**Ø d_2** mm h6	**Ø ds**	**Z**	**7052**	**7052 TF**
NPTF	**1/8**	27	0,94	8,4	70	9,83	45	7,30	12	10,0	4	●	●
NPTF	**1/4**	18	1,41	10,8	80	14,77	48	9,95	16	13,1	4	●	●
NPTF	**3/8**	18	1,41	14,2	80	14,77	48	12,50	18	16,7	4	●	●

● Standardartikel / Items available ex stock

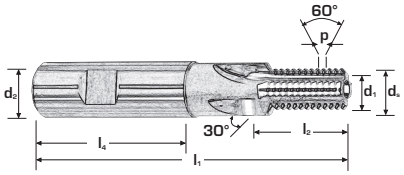
Gewindefräser mit Senkfase, mit Schaft nach DIN 6535 HB und innerer Kühlmittelzufuhr, aus Vollhartmetall für Metrisches ISO – Regelgewinde nach DIN 13

Thread milling cutters with chamfer, with shank acc. to DIN 6535 HB and internal cooling, made of solid carbide for ISO metric coarse thread as per DIN 13

Für Innegewinde

For internal threads

M | TiAlN Futura | **Axialer Kühlmittelaustritt** Axial internal cooling



Typ / Type												Multi CTM	Multi CTM
Schneidstoff/ Material												VHM	VHM
Ø mm		**Steigung** Pitch	**Kernloch Ø** Tap drill Ø	**l_1 mm**	**l_2 mm**	**l_4 mm**	**Ø d_1** (nominal)	**Ø d_1 mm**	**Ø d_2 mm** h6	**Ø ds**	**Z**	**6933**	**6933 TF**
M	5	0,80	4,2	55	7,6	36	4,00	6	4,0	5,3	3	-	■
M	6	1,00	5,0	62	9,5	36	4,80	8	4,8	6,3	3	■	■
M	8	1,25	6,8	74	13,1	40	6,50	10	6,5	8,3	3	■	■
M	10	1,50	8,5	80	15,8	45	8,20	12	8,2	10,3	3	■	■
M	12	1,75	10,2	90	17,9	45	9,95	14	9,9	12,3	4	■	■
M	14	2,00	12,0	100	23,0	48	11,60	16	11,6	14,3	4	■	■
M	16	2,00	14,0	102	25,0	48	13,60	18	13,6	16,3	4	■	■

■ Auslaufender Artikel / discontinued items

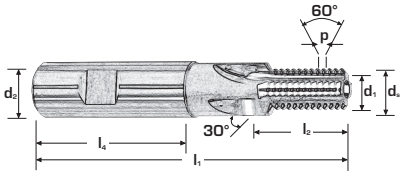
Gewindefräser mit Senkfase, mit Schaft nach DIN 6535 HB und innerer Kühlmittelzufuhr, aus Vollhartmetall für Metrisches ISO – Regelgewinde nach DIN 13

Thread milling cutters with chamfer, with shank acc. to DIN 6535 HB and internal cooling, made of solid carbide for ISO metric coarse thread as per DIN 13

Für Innegewinde

For internal threads

M | TiAlN Futura | **Axialer Kühlmittelaustritt** Axial internal cooling



Typ / Type												Multi CTM	Multi CTM
Schneidstoff/ Material												VHM	VHM
Ø mm		**Steigung** Pitch	**Kernloch Ø** Tap drill Ø	**l_1 mm**	**l_2 mm**	**l_4 mm**	**Ø d_1** (nominal)	**Ø d_1 mm**	**Ø d_2 mm** h6	**Ø ds**	**Z**	**6935**	**6935 TF**
M	5	0,80	4,2	55	10,8	32	4,00	6	4,0	5,3	3	■	-
M	6	1,00	5,0	62	12,5	36	4,80	8	4,8	6,3	3	■	■
M	12	1,75	10,2	90	25,4	45	9,95	14	9,9	12,3	4	■	■
M	16	2,00	14,0	102	33	48	13,60	18	13,6	16,3	4	■	■

■ Auslaufender Artikel / discontinued items

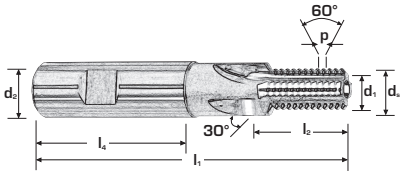
Gewindefräser mit Senkfase, mit Schaft nach DIN 6535 HB und innerer Kühlmittelzufuhr, aus Vollhartmetall für Metrisches ISO – Feingewinde nach DIN 13

Thread milling cutters with chamfer, with shank acc. to DIN 6535 HB and internal cooling made of solid carbide for ISO metric fine thread as per DIN 13

Für Innegewinde

For internal threads

MF | TiAlN Futura | **Axialer Kühlmittelaustritt** Axial internal cooling



Typ / Type												Multi CTM	Multi CTM
Schneidstoff/ Material												VHM	VHM
Ø mm		**Steigung** Pitch	**Kernloch Ø** Tap drill Ø	**l_1 mm**	**l_2 mm**	**l_4 mm**	**Ø d_1** (nominal)	**Ø d_1 mm**	**Ø d_2 mm** h6	**Ø ds**	**Z**	**6934**	**6934 TF**
M	6	0,75	5,0	62	9,40	36	4,50	5,0	8	6,3	3	■	■
M	8	1,00	6,8	74	12,50	40	5,95	6,7	10	8,3	3	■	■
M	10	1,00	8,5	80	15,50	45	7,95	8,7	12	10,3	3	■	■
M	12	1,00	10,2	90	18,50	45	9,95	10,6	14	12,3	4	■	■
M	12	1,50	10,2	90	18,75	45	9,95	10,1	14	12,3	4	■	■
M	14	1,50	12,0	100	21,75	48	11,60	12,1	16	14,3	4	■	■
M	16	1,50	14,0	102	24,80	48	13,60	14,0	18	16,3	4	-	■

■ Auslaufender Artikel / discontinued items

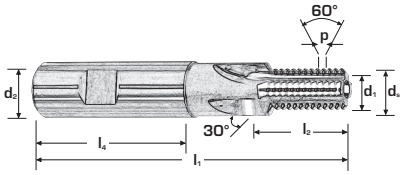
Gewindefräser mit Senkfase, mit Schaft nach DIN 6535 HB und innerer Kühlmittelzufuhr, aus Vollhartmetall für Metrisches ISO – Feingewinde nach DIN 13

Thread milling cutters with chamfer, with shank acc. to DIN 6535 HB and internal cooling made of solid carbide for ISO metric fine thread as per DIN 13

Für Innegewinde

For internal threads

MF | TiAlN Futura | **Axialer Kühlmittelaustritt** Axial internal cooling



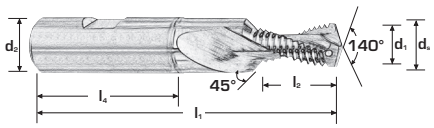
Typ / Type												Multi CTM	Multi CTM
Schneidstoff/ Material												VHM	VHM
Ø mm		**Steigung** Pitch	**Kernloch Ø** Tap drill Ø	**l_1 mm**	**l_2 mm**	**l_4 mm**	**Ø d_1** (nominal)	**Ø d_1 mm**	**Ø d_2 mm** h6	**Ø ds**	**Z**	**6936**	**6936 TF**
M	6	0,75	5,0	62	12,40	36	4,50	5,0	8	6,3	3	■	■
M	8	1,00	6,8	74	16,50	40	5,95	6,7	10	8,3	3	■	■
M	10	1,00	8,5	80	20,50	45	7,95	8,7	12	10,3	3	■	■
M	12	1,00	10,2	90	24,50	45	9,95	10,6	14	12,3	4	■	■
M	12	1,50	10,2	90	24,75	45	9,95	10,1	14	12,3	4	■	■
M	14	1,50	12,0	100	29,25	48	11,60	12,1	16	14,3	4	■	■
M	16	1,50	14,0	102	32,25	48	13,60	14,0	18	16,3	4	■	■

■ Auslaufender Artikel / discontinued items

Bohrgewindefräser mit Senkfase und 2 Nuten, mit Schaft nach DIN 6535 HB und innerer Kühlmittelzufuhr, aus Vollhartmetallfür Metrisches ISO – Regelgewinde nach DIN 13

Solid carbide thread milling cutters with chamfer and 2 flutes, with shank acc. to DIN 6535 HB and internal cooling for ISO metric coarse thread as per DIN 13

M | TiAlN Futura | **Kühlmittelaustritt** internal cooling



Typ / Type										Multi DTM	Multi DTM
Schneidstoff/ Material										VHM	VHM
Ø mm		**Steigung** Pitch	**l_1 mm**	**l_2 mm**	**l_4 mm**	**Ø d_1 (nominal)**	**Ø $d_2$mm h6**	**Ø ds mm**	**Z**	**6940**	**6940 TF**
***M**	**3**	0,50	48	5,40	36	2,40	6	3,2	2	●	●
***M**	**4**	0,70	48	6,85	36	3,20	6	4,2	2	●	●
***M**	**5**	0,80	54	8,70	36	4,00	6	5,3	2	●	●
M	**6**	1,00	62	10,85	36	4,75	8	6,3	2	●	●
M	**8**	1,25	74	13,65	40	6,35	10	8,4	2	●	●
M	**10**	1,50	80	17,95	45	7,95	12	10,5	2	●	●
M	**12**	1,75	90	20,75	45	9,95	14	12,6	2	●	●
M	**14**	2,00	102	23,55	48	11,20	16	14,7	2	●	●
M	**16**	2,00	102	25,90	48	13,20	18	16,8	2	●	●

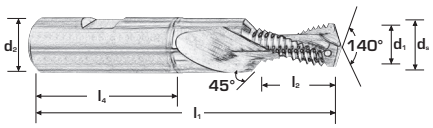
*Alle Abmessungen ← M 6 ohne Kühlkanäle / / All diameters < M 6 without internal cooling

● Standardartikel / Items available ex stock

Bohrgewindefräser mit Senkfase und 2 Nuten, mit Schaft nach DIN 6535 HB und innerer Kühlmittelzufuhr, aus Vollhartmetallfür Metrisches ISO – Regelgewinde nach DIN 13

Solid carbide thread milling cutters with chamfer and 2 flutes, with shank acc. to DIN 6535 HB and internal cooling for ISO metric coarse thread as per DIN 13

M | TiAlN Futura | **Kühlmittelaustritt** internal cooling



Typ / Type										Multi DTM	Multi DTM
Schneidstoff / Material										VHM	VHM
Ø mm		**Steigung** Pitch	**l_1 mm**	**l_2 mm**	**l_4 mm**	**Ø d_1 (nominal)**	**Ø $d_2$mm h6**	**Ø ds mm**	**Z**	**6942**	**6942 TF**
*M	3	0,50	48	6,90	36	2,40	6	3,2	2	●	●
*M	4	0,70	48	8,95	36	3,20	6	4,2	2	●	●
*M	5	0,80	54	11,10	36	4,00	6	5,3	2	●	●
M	6	1,00	62	13,85	36	4,75	8	6,3	2	●	●
M	8	1,25	74	18,65	40	6,35	10	8,4	2	●	●
M	10	1,50	80	22,45	45	7,95	12	10,5	2	●	●
M	12	1,75	90	26,00	45	9,95	14	12,6	2	●	●
M	14	2,00	102	31,55	48	11,20	16	14,7	2	●	●
M	16	2,00	102	35,90	48	13,20	18	16,8	2	●	●

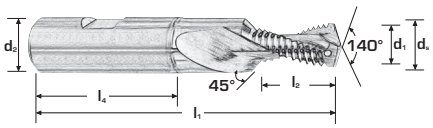
*Alle Abmessungen ← M 6 ohne Kühlkanäle / / All diameters < M 6 without internal cooling

● Standardartikel / Items available ex stock

Bohrgewindefräser mit Senkfase und 2 Nuten, mit Schaft nach DIN 6535 HB und innerer Kühlmittelzufuhr, aus Vollhartmetallfür Metrisches ISO – Regelgewinde nach DIN 13

Solid carbide thread milling cutters with chamfer and 2 flutes, with shank acc. to DIN 6535 HB and internal cooling for ISO metric coarse thread as per DIN 13

M | TiAlN Futura | **Kühlmittelaustritt** internal cooling



Typ / Type									Multi DTM	Multi DTM
Schneidstoff / Material									VHM	VHM
Ø mm	**Steigung** Pitch	**l_1 mm**	**l_2 mm**	**l_4 mm**	**Ø d_1 (nominal)**	**Ø d_2 mm h6**	**Ø ds mm**	**Z**	**6947**	**6947 TF**
M 6	1,00	62	16,85	36	4,75	8	6,3	2	●	●
M 8	1,25	74	22,40	40	6,35	10	8,4	2	●	●
M 10	1,50	80	26,95	45	7,95	12	10,5	2	●	●
M 12	1,75	90	31,25	45	9,95	14	12,6	2	●	●
M 14	2,00	102	39,55	48	11,20	16	14,7	2	●	●
M 16	2,00	102	45,90	48	13,20	18	16,8	2	●	●

● Standardartikel / Items available ex stock

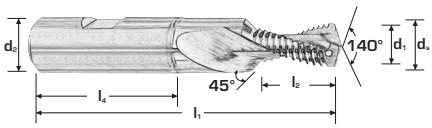
Bohrgewindefräser mit Senkfase und 2 Nuten, mit Schaft nach DIN 6535 HB und innerer Kühlmittelzufuhr aus Vollhartmetall, für Metrisches ISO – Regelgewinde nach DIN 13

Solid carbide thread milling cutters with chamfer and 2 flutes, with shank acc. to DIN 6535 HB and internal cooling for ISO metric fine coarse thread as per DIN 13

Für Innegewinde

For internal threads

MF | TiAlN Futura | **Kühlmittelaustritt** internal cooling



Typ / Type										**Multi DTM**	**Multi DTM**
Schneidstoff/ Material										VHM	VHM
Ø mm		**Steigung** Pitch	**l_1** mm	**l_2** mm	**l_4** mm	**Ø d_1** (nominal)	**Ø d_2** mm h6	**Ø ds** mm	**Z**	**6944**	**6944 TF**
*MF	5	0,50	54	8,30	36	4,00	6	5,3	2	●	●
MF	6	0,75	62	9,90	36	4,75	8	6,3	2	●	●
MF	8	1,00	74	14,20	40	6,35	10	8,4	2	●	●
MF	10	1,00	80	16,55	45	7,95	12	10,5	2	●	●
MF	10	1,25	80	16,55	45	7,95	12	10,5	2	●	●
MF	12	1,00	90	19,95	45	9,95	14	12,6	2	●	●
MF	12	1,50	90	21,30	45	9,95	14	12,6	2	●	●
MF	14	1,50	102	23,20	48	11,20	16	14,7	2	●	●
MF	16	1,50	102	26,55	48	13,20	18	16,8	2	●	●

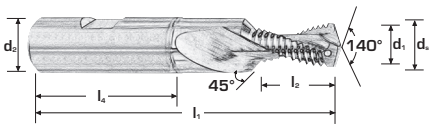
*Alle Abmessungen ← M 6 ohne Kühlkanäle / / All diameters < M 6 without internal cooling

● Standardartikel / Items available ex stock

Bohrgewindefräser mit Senkfase und 2 Nuten, mit Schaft nach DIN 6535 HB und innerer Kühlmittelzufuhr, aus Vollhartmetallfür Metrisches ISO – Feingewinde nach DIN 13

Solid carbide thread milling cutters with chamfer and 2 flutes, with shank acc. to DIN 6535 HB and internal cooling for ISO metric fine coarse thread as per DIN 13

MF | TiAlN Futura | **Kühlmittelaustritt** internal cooling



Typ / Type										Multi DTM	Multi DTM
Schneidstoff/ Material										VHM	VHM
Ø mm		Steigung Pitch	l_1 mm	l_2 mm	l_4 mm	Ø d_1 (nominal)	Ø $d_2$mm h6	Ø ds mm	Z	6946	6946 TF
*MF	5	0,50	54	10,80	36	4,00	6	5,3	2	●	●
MF	6	0,75	62	12,90	36	4,75	8	6,3	2	●	●
MF	8	1,00	74	17,20	40	6,35	10	8,4	2	●	●
MF	10	1,00	80	21,55	45	7,95	12	10,5	2	●	●
MF	10	1,25	80	21,55	45	7,95	12	10,5	2	●	●
MF	12	1,00	90	25,95	45	9,95	14	12,6	2	●	●
MF	12	1,50	90	27,30	45	9,95	14	12,6	2	●	●
MF	14	1,50	102	30,70	48	11,20	16	14,7	2	●	●
MF	16	1,50	102	34,05	48	13,20	18	16,8	2	●	●

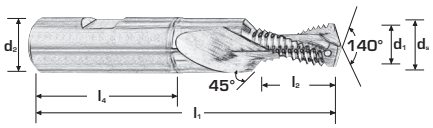
*Alle Abmessungen ← M 6 ohne Kühlkanäle / / All diameters < M 6 without internal cooling

● Standardartikel / Items available ex stock

Bohrgewindefräser mit Senkfase und 2 Nuten, mit Schaft nach DIN 6535 HB und innerer Kühlmittelzufuhr, aus Vollhartmetallfür Metrisches ISO – Feingewinde nach DIN 13

Solid carbide thread milling cutters with chamfer and 2 flutes, with shank acc. to DIN 6535 HB and internal cooling for ISO metric fine coarse thread as per DIN 13

MF | TiAlN Futura | **Kühlmittelaustritt** internal cooling



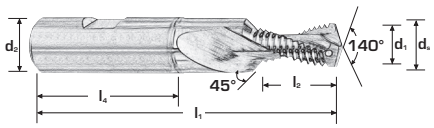
Typ / Type										Multi DTM	Multi DTM
Schneidstoff / Material										VHM	VHM
Ø mm		**Steigung** Pitch	**l_1 mm**	**l_2 mm**	**l_4 mm**	**Ø d_1** (nominal)	**Ø d_2 mm** h6	**Ø ds mm**	**Z**	**6943**	**6943 TF**
MF	**8**	1,00	74	21,20	40	6,35	10	8,4	2	●	●
MF	**10**	1,00	80	26,55	45	7,95	12	10,5	2	●	●
MF	**10**	1,25	80	26,55	45	7,95	12	10,5	2	●	●
MF	**12**	1,00	90	30,95	45	9,95	14	12,6	2	●	●
MF	**12**	1,50	90	31,80	45	9,95	14	12,6	2	●	●
MF	**14**	1,50	102	35,20	48	11,20	16	14,7	2	●	●
MF	**16**	1,50	102	45,55	48	13,20	18	16,8	2	●	●

● Standardartikel / Items available ex stock

Bohrgewindefräser mit Senkfase und 2 Nuten, mit Schaft nach DIN 6535 HB und innerer Kühlmittelzufuhr aus Vollhartmetall, für Unified Gewinde UNC ANSI B 1.1

Solid carbide thread milling cutters with chamfer and 2 flutes, with shank acc. to DIN 6535 HB and internal cooling for unified thread UNC ANSI B 1.1

UNC | TiAlN Futura | **Kühlmittelaustritt** internal cooling



Typ / Type											Multi DTM	Multi DTM
Schneidstoff / Material											VHM	VHM
Ø mm		**Gg/1"** Tpi	**Steigung** Pitch	**l_1** mm	**l_2** mm	**l_4** mm	**Ø d_1** (nominal)	**Ø d_2** mm h6	**Ø ds** mm	**Z**	**7068**	**7068 TF**
*UNC	nr.10	24	1,06	54	9,10	36	3,60	6	5,1	2	●	●
*UNC	nr.12	24	1,06	54	9,25	36	4,10	6	5,8	2	●	●
UNC	1/4	20	1,27	62	11,00	36	5,00	8	6,7	2	●	●
UNC	5/16	18	1,41	74	13,80	36	6,25	10	8,3	2	●	●
UNC	3/8	16	1,59	80	17,15	40	7,50	12	10,0	2	●	●
UNC	7/16	14	1,81	80	19,40	45	8,80	12	11,7	2	●	●
UNC	1/2	13	1,95	90	21,90	45	10,20	14	13,3	2	●	●
UNC	9/16	12	2,12	102	24,75	48	11,80	16	15,0	2	●	●
UNC	5/8	11	2,31	102	26,90	48	13,10	18	16,5	2	●	●

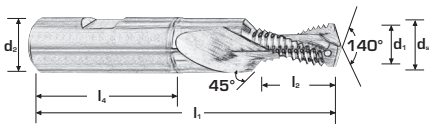
Nr. 10 und Nr. 12 ohne Kühlkanäle / No. 10 and No. 12 without internal cooling

● Standardartikel / Items available ex stock

Bohrgewindefräser mit Senkfase und 2 Nuten, mit Schaft nach DIN 6535 HB und innerer Kühlmittelzufuhr aus Vollhartmetall, für Unified Gewinde UNC ANSI B 1.1

Solid carbide thread milling cutters with chamfer and 2 flutes, with shank acc. to DIN 6535 HB and internal cooling for unified thread UNC ANSI B 1.1

UNC | TiAlN Futura | **Kühlmittelaustritt** internal cooling



Typ / Type — Multi DTM | Multi DTM

Schneidstoff / Material — VHM | VHM

Ø mm		Gg/1" Tpi	Steigung Pitch	l_1 mm	l_2 mm	l_4 mm	Ø d_1 (nominal)	Ø d_{2mm} h6	Ø ds mm	Z	7070	7070 TF
*UNC	nr.10	24	1,06	54	11,25	36	3,60	6	5,1	2	●	●
*UNC	nr.12	24	1,06	54	12,40	36	4,10	6	5,8	2	●	●
UNC	1/4	20	1,27	62	14,85	36	5,00	8	6,7	2	●	●
UNC	5/16	18	1,41	74	18,00	36	6,25	10	8,3	2	●	●
UNC	3/8	16	1,59	80	21,90	40	7,50	12	10,0	2	●	●
UNC	7/16	14	1,81	80	24,85	45	8,80	12	11,7	2	●	●
UNC	1/2	13	1,95	90	26,80	45	10,20	14	13,3	2	●	●
UNC	9/16	12	2,12	102	31,10	48	11,80	16	15,0	2	●	●
UNC	5/8	11	2,31	102	36,15	48	13,10	18	16,5	2	●	●

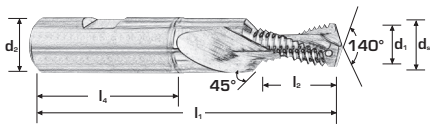
Nr. 10 und Nr. 12 ohne Kühlkanäle / No. 10 and No. 12 without internal cooling

● Standardartikel / Items available ex stock

Bohrgewindefräser mit Senkfase und 2 Nuten, mit Schaft nach DIN 6535 HB und innerer Kühlmittelzufuhr aus Vollhartmetall, für Unified Gewinde UNF ANSI B 1.1

Solid carbide thread milling cutters with chamfer and 2 flutes, with shank acc. to DIN 6535 HB and internal cooling for unified thread UNF ANSI B 1.1

UNF | TiAlN Futura | **Kühlmittelaustritt** internal cooling



Typ / Type											**Multi DTM**	**Multi DTM**
Schneidstoff / Material											VHM	VHM
Ø mm		**Gg/1"** Tpi	**Steigung** Pitch	**l_1** mm	**l_2** mm	**l_4** mm	**Ø d_1** (nominal)	**Ø d_2** mm h6	**Ø ds** mm	**Z**	**7064**	**7064 TF**
*UNF	nr.10	32	0,79	54	7,85	36	3,80	6	5,1	2	●	●
*UNF	nr.12	28	0,91	54	9,85	36	4,50	6	5,8	2	●	●
UNF	1/4	28	0,91	62	10,90	36	5,00	8	6,7	2	●	●
UNF	5/16	24	1,06	74	13,90	36	5,95	10	8,3	2	●	●
UNF	3/8	24	1,06	80	16,30	40	7,95	12	10,0	2	●	●
UNF	7/16	20	1,27	80	18,25	45	7,95	12	11,7	2	●	●
UNF	1/2	20	1,27	90	21,10	45	9,95	14	13,3	2	●	●
UNF	9/16	18	1,41	102	23,40	48	15,50	16	15,0	2	●	●
UNF	5/8	18	1,41	102	26,50	48	17,50	18	16,7	2	●	●

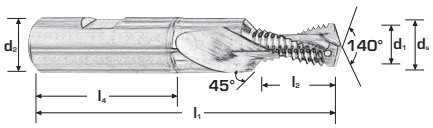
Nr. 10 und Nr. 12 ohne Kühlkanäle / No. 10 and No. 12 without internal cooling

● Standardartikel / Items available ex stock

Bohrgewindefräser mit Senkfase und 2 Nuten, mit Schaft nach DIN 6535 HB und innerer Kühlmittelzufuhr aus Vollhartmetall, für Unified Gewinde UNF ANSI B 1.1

Solid carbide thread milling cutters with chamfer and 2 flutes, with shank acc. to DIN 6535 HB and internal cooling for unified thread UNF ANSI B 1.1

UNF | TiAlN Futura | **Kühlmittelaustritt** internal cooling



Typ / Type										Multi DTM	Multi DTM
Schneidstoff / Material										VHM	VHM
Ø mm		**Gg/1"** Tpi	**Steigung** Pitch	**l_1** mm	**l_2** mm	**l_4** mm	**Ø d_1** (nominal)	**Ø d_2** mm h6	**Ø ds** mm	**Z**	**7066**	**7066 TF**
*UNF	nr.10	32	0,79	54	10,20	36	3,80	6	5,1	2	●	●
*UNF	nr.12	28	0,91	54	12,55	36	4,50	6	5,8	2	●	●
UNF	1/4	28	0,91	62	12,70	36	5,00	8	6,7	2	●	●
UNF	5/16	24	1,06	74	18,15	36	5,95	10	8,3	2	●	●
UNF	3/8	24	1,06	80	20,55	40	7,95	12	10,0	2	●	●
UNF	7/16	20	1,27	80	24,60	45	7,95	12	11,7	2	●	●
UNF	1/2	20	1,27	90	27,40	45	9,95	14	13,3	2	●	●
UNF	9/16	18	1,41	102	30,45	48	15,50	16	15,0	2	●	●
UNF	5/8	18	1,41	102	33,55	48	17,50	18	16,7	2	●	●

Nr. 10 und Nr. 12 ohne Kühlkanäle / No. 10 and No. 12 without internal cooling

● Standardartikel / Items available ex stock

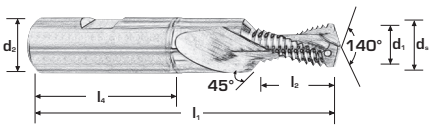
Bohrgewindefräser mit Senkfase und 2 Nuten, mit Schaft nach DIN 6535 HB und innerer Kühlmittelzufuhr aus Vollhartmetall, für Whitworth - Rohrgewinde DIN ISO 228

Solid carbide thread milling cutters with chamfer and 2 flutes, with shank acc. to DIN 6535 HB and internal cooling for British standard pipe thread DIN ISO 228

G

TiAlN Futura

Kühlmittelaustritt
internal cooling



Typ / Type										Multi DTM	Multi DTM
Schneidstoff/ Material										VHM	VHM
Ø mm	Gg/1" Tpi	Steigung Pitch	l_1 mm	l_2 mm	l_4 mm	Ø d_1 (nominal)	Ø d_2 mm h6	Ø ds mm	Z	7060	7060 TF
G 1/8	28	0,91	80	16	45	7,95	12	10,2	2	●	●
G 1/4	19	1,34	90	22	45	11,00	14	13,8	2	●	●
G 3/8	19	1,34	102	28	48	13,80	18	17,5	2	●	●

● Standardartikel / Items available ex stock

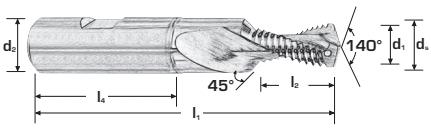
Bohrgewindefräser mit Senkfase und 2 Nuten, mit Schaft nach DIN 6535 HB und innerer Kühlmittelzufuhr aus Vollhartmetall, für Whitworth - Rohrgewinde DIN ISO 228

Solid carbide thread milling cutters with chamfer and 2 flutes, with shank acc. to DIN 6535 HB and internal cooling for British standard pipe thread DIN ISO 228

G

TiAlN Futura

Kühlmittelaustritt
internal cooling



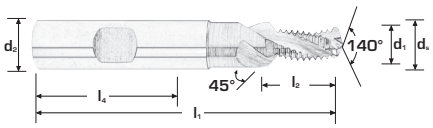
Typ / Type										Multi DTM	Multi DTM
Schneidstoff/ Material										VHM	VHM
Ø mm	Gg/1" Tpi	Steigung Pitch	l_1 mm	l_2 mm	l_4 mm	Ø d_1 (nominal)	Ø d_2 mm h6	Ø ds mm	Z	7062	7062 TF
G 1/8	28	0,91	80	21,45	45	7,95	12	10,2	2	●	●
G 1/4	19	1,34	90	28,70	45	11,00	14	13,8	2	●	●
G 3/8	19	1,34	102	36,00	48	13,80	18	17,5	2	●	●

● Standardartikel / Items available ex stock

Bohrgewindefräser mit Senkfase und 3 Nuten, mit Schaft nach DIN 6535 HB und innerer Kühlmittelzufuhr, aus Vollhartmetall für Metrisches ISO – Feingewinde nach DIN 13

Solid carbide thread milling cutters with chamfer and 3 flutes, with shank acc. to DIN 6535 HB and internal cooling for ISO metric coarse thread as per DIN 13

M | TiAlN Futura | **Kühlmittelaustritt** internal cooling



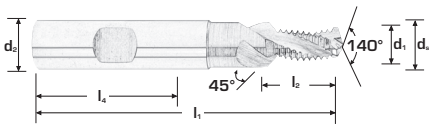
Typ / Type										**Multi DTM**	**Multi DTM**
Schneidstoff / Material										VHM	VHM
Ø mm		**Steigung** Pitch	**l_1** mm	**l_2** mm	**l_4** mm	**Ø d_1** (nominal)	**Ø d_2** mm h6	**Ø ds** mm	**Z**	**7071**	**7071 TF**
M	**6**	1,00	62	10,85	36	4,75	8	6,3	3	●	●
M	**8**	1,25	74	13,65	40	6,35	10	8,4	3	●	●
M	**10**	1,50	80	17,95	45	7,95	12	10,5	3	●	●
M	**12**	1,75	90	20,75	45	9,95	14	12,6	3	●	●
M	**14**	2,00	102	23,55	48	11,20	16	14,7	3	●	●
M	**16**	2,00	102	25,90	48	13,20	18	16,8	3	●	●

● Standardartikel / Items available ex stock

Bohrgewindefräser mit Senkfase und 3 Nuten, mit Schaft nach DIN 6535 HB und innerer Kühlmittelzufuhr, aus Vollhartmetall für Metrisches ISO – Regelgewinde nach DIN 13

Solid carbide thread milling cutters with chamfer and 3 flutes, with shank acc. to DIN 6535 HB and internal cooling for ISO metric coarse thread as per DIN 13

M | TiAlN Futura | **Kühlmittelaustritt** internal cooling



Typ / Type

Schneidstoff / Material

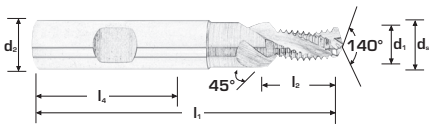
Ø mm		Steigung Pitch	l_1 mm	l_2 mm	l_4 mm	Ø d_1 (nominal)	Ø d_2 mm h6	Ø ds mm	Z	Multi DTM VHM 7073	Multi DTM VHM 7073 TF
M	3	0,50	48	6,90	36	2,40	6	3,2	3	●	●
M	4	0,70	48	8,95	36	3,20	6	4,2	3	●	●
M	5	0,80	54	11,10	36	4,00	6	5,3	3	●	●
M	6	1,00	62	13,85	36	4,75	8	6,3	3	●	●
M	8	1,25	74	18,65	40	6,35	10	8,4	3	●	●
M	10	1,50	80	22,45	45	7,95	12	10,5	3	●	●
M	12	1,75	90	26,00	45	9,95	14	12,6	3	●	●
M	14	2,00	102	31,55	48	11,20	16	14,7	3	●	●
M	16	2,00	102	35,90	48	13,20	18	16,8	3	●	●

● Standardartikel / Items available ex stock

Bohrgewindefräser mit Senkfase und 3 Nuten, mit Schaft nach DIN 6535 HB und innerer Kühlmittelzufuhr, aus Vollhartmetall für Metrisches ISO – Regelgewinde nach DIN 13

Solid carbide thread milling cutters with chamfer and 3 flutes, with shank acc. to DIN 6535 HB and internal cooling for ISO metric coarse thread as per DIN 13

M | TiAlN Futura | **Kühlmittelaustritt** internal cooling



Typ / Type										Multi DTM	Multi DTM
Schneidstoff / Material										VHM	VHM
Ø mm		**Steigung** Pitch	**l_1 mm**	**l_2 mm**	**l_4 mm**	**Ø d_1** (nominal)	**Ø d_2 mm** h6	**Ø ds mm**	**Z**	**7075**	**7075 TF**
*M	3	0,50	48	8,40	36	2,40	6	3,2	3	●	●
*M	4	0,70	48	11,05	36	3,20	6	4,2	3	●	●
*M	5	0,80	54	13,50	36	4,00	6	5,3	3	●	●
M	6	1,00	62	16,85	36	4,75	8	6,3	3	●	●
M	8	1,25	74	22,40	40	6,35	10	8,4	3	●	●
M	10	1,50	80	26,95	45	7,95	12	10,5	3	●	●
M	12	1,75	90	31,25	45	9,95	14	12,6	3	●	●
M	14	2,00	102	39,55	48	11,20	16	14,7	3	●	●
M	16	2,00	102	45,90	48	13,20	18	16,8	3	●	●

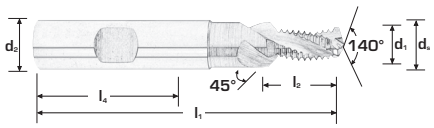
*Ohne Innenkühlung / Without internal cooling

● Standardartikel / Items available ex stock

Bohrgewindefräser mit Senkfase und 3 Nuten, mit Schaft nach DIN 6535 HB und innerer Kühlmittelzufuhr, aus Vollhartmetall für Metrisches ISO – Regelgewinde nach DIN 13

Solid carbide thread milling cutters with chamfer and 3 flutes, with shank acc. to DIN 6535 HB and internal cooling for ISO metric coarse thread as per DIN 13

M | TiAlN Futura | **Kühlmittelaustritt** internal cooling



Typ / Type — Multi DTM | Multi DTM

Schneidstoff / Material — VHM | VHM

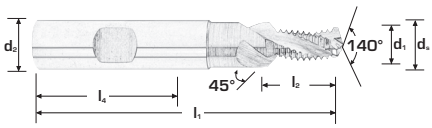
Ø mm	Steigung Pitch	l_1 mm	l_2 mm	l_4 mm	Ø d_1 (nominal)	Ø d_2 mm h6	Ø ds mm	Z	7077	7077 TF
M 6	1,0	62	18,90	36	4,75	8	6,3	3	●	●
M 8	1,25	74	25,00	40	6,35	10	8,4	3	●	●
M 10	1,5	80	31,50	45	7,95	12	10,5	3	●	●
M 12	1,75	90	38,30	45	9,95	14	12,6	3	●	●
M 14	2,0	102	43,70	48	11,20	16	14,7	3	●	●
M 16	2,0	102	50,00	48	13,20	18	16,8	3	●	●

● Standardartikel / Items available ex stock

Bohrgewindefräser mit Senkfase und 3 Nuten, mit Schaft nach DIN 6535 HB und innerer Kühlmittelzufuhr, aus Vollhartmetall für Metrisches ISO – Feingewinde nach DIN 13

Solid carbide thread milling cutters with chamfer and 3 flutes, with shank acc. to DIN 6535 HB and internal cooling for ISO metric fine thread as per DIN 13

MF | TiAlN Futura | **Kühlmittelaustritt** internal cooling



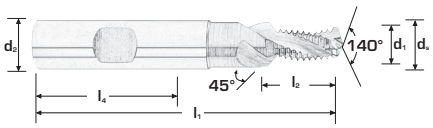
Typ / Type									**Multi DTM**
Schneidstoff/ Material									**VHM**
Ø mm	**Steigung** Pitch	**l_1 mm**	**l_2 mm**	**l_4 mm**	**Ø d_1 (nominal)**	**Ø $d_2$mm h6**	**Ø ds mm**	**Z**	**7072 TF**
MF 10	1,25	80	18,0	45	7,95	12	10,5	3	■
MF 14	1,50	102	23,0	48	11,20	16	14,7	3	■

■ Auslaufender Artikel / discontinued items

Bohrgewindefräser mit Senkfase und 3 Nuten, mit Schaft nach DIN 6535 HB und innerer Kühlmittelzufuhr, aus Vollhartmetall für Metrisches ISO – Feingewinde nach DIN 13

Solid carbide thread milling cutters with chamfer and 3 flutes, with shank acc. to DIN 6535 HB and internal cooling for ISO metric fine thread as per DIN 13

MF TiAlN Futura **Kühlmittelaustritt** internal cooling



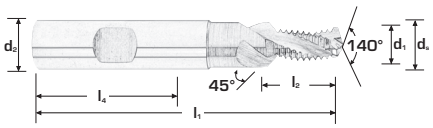
Typ / Type										Multi DTM	Multi DTM
Schneidstoff / Material										VHM	VHM
Ø mm		**Steigung** Pitch	**l_1 mm**	**l_2 mm**	**l_4 mm**	**Ø d_1** (nominal)	**Ø $d_2$mm** h6	**Ø ds mm**	**Z**	**7074**	**7074 TF**
MF	**6**	0,75	62	12,90	36	4,75	8	6,3	3	●	●
MF	**8**	1,00	74	17,20	40	6,35	10	8,4	3	●	●
MF	**10**	1,00	80	21,55	45	7,95	12	10,5	3	●	●
MF	**10**	1,25	80	21,55	45	7,95	12	10,5	3	●	●
MF	**12**	1,00	90	25,95	45	9,95	14	12,6	3	●	●
MF	**12**	1,50	90	27,30	45	9,95	14	12,6	3	●	●
MF	**14**	1,50	102	30,70	48	11,20	16	14,7	3	●	●
MF	**16**	1,50	102	34,05	48	13,20	18	16,8	3	●	●

● Standardartikel / Items available ex stock

Bohrgewindefräser mit Senkfase und 3 Nuten, mit Schaft nach DIN 6535 HB und innerer Kühlmittelzufuhr, aus Vollhartmetall für Metrisches ISO – Feingewinde nach DIN 13

Solid carbide thread milling cutters with chamfer and 3 flutes, with shank acc. to DIN 6535 HB and internal cooling for ISO metric fine thread as per DIN 13

MF | TiAlN Futura | **Kühlmittelaustritt** internal cooling



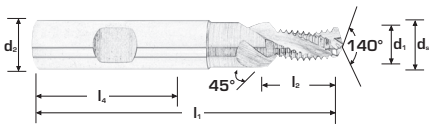
Typ / Type										Multi DTM	Multi DTM
Schneidstoff / Material										VHM	VHM
Ø mm		**Steigung** Pitch	**l_1 mm**	**l_2 mm**	**l_4 mm**	**Ø d_1** (nominal)	**Ø d_2 mm** h6	**Ø ds mm**	**Z**	**7076**	**7076 TF**
MF	**8**	1,00	74	21,20	40	6,35	10	8,4	3	●	●
MF	**10**	1,00	80	26,55	45	7,95	12	10,5	3	●	●
MF	**10**	1,25	80	26,55	45	7,95	12	10,5	3	●	●
MF	**12**	1,00	90	30,95	45	9,95	14	12,6	3	●	●
MF	**12**	1,50	90	31,80	45	9,95	14	12,6	3	●	●
MF	**14**	1,50	102	35,20	48	11,20	16	14,7	3	●	●
MF	**16**	1,50	102	41,55	48	13,20	18	16,8	3	●	●

● Standardartikel / Items available ex stock

Bohrgewindefräser mit Senkfase und 3 Nuten, mit Schaft nach DIN 6535 HB und innerer Kühlmittelzufuhr, aus Vollhartmetall für Metrisches ISO – Feingewinde nach DIN 13

Solid carbide thread milling cutters with chamfer and 3 flutes, with shank acc. to DIN 6535 HB and internal cooling for ISO metric fine thread as per DIN 13

MF | TiAlN Futura | **Kühlmittelaustritt** internal cooling



Typ / Type										Multi DTM	Multi DTM
Schneidstoff / Material										VHM	VHM
Ø mm		**Steigung** Pitch	**l_1 mm**	**l_2 mm**	**l_4 mm**	**Ø d_1** (nominal)	**Ø d_2 mm** h6	**Ø ds mm**	**Z**	**7078**	**7078 TF**
MF	**8**	1,00	74	25,10	40	6,35	10	8,4	3	●	●
MF	**10**	1,00	80	31,50	45	7,95	12	10,5	3	●	●
MF	**10**	1,25	80	31,50	45	7,95	12	10,5	3	●	●
MF	**12**	1,00	90	38,30	45	9,95	14	12,6	3	●	●
MF	**12**	1,50	90	38,30	45	9,95	14	12,6	3	●	●
MF	**14**	1,50	102	43,70	48	11,20	16	14,7	3	●	●
MF	**16**	1,50	102	50,00	48	13,20	18	16,8	3	●	●

● Standardartikel / Items available ex stock

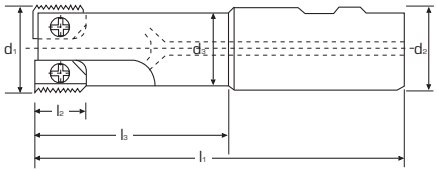
MULTI TMI

Gewindefräskörper mit auswechselbaren Gewindefräsplatten aus Hartmetall, Zylinderschaft mit WELDON – Fläche, mit innerer Kühlmittelzufuhr

Thread milling cutter bodies with inserts indexable weldon shank, with internal cooling

UNF UN G M-MF

Kühlmittelaustritt
internal cooling



Typ / Type A
(1 Gewindefräsplatten/insert)

Typ / Type B
(2 Gewindefräsplatten/insert)

Kat. Nr. Cat. No.	Typ Type	d_1 mm	Steigung Pitch	Ausführung Esecution	l_1 mm	l_2 mm	l_3 mm	Ø d2h6	Ø d3	Gesamtlänge Fräsplatte total length insert	
6960	A	16	0,5 - 2,5	kurz/short	78	15	30	16	13	15 mm	✓
	B	25	0,5 - 2,5	kurz/short	106	15	50	25	21	15 mm	✓
6961	A	16	0,5 - 2,5	lang/long	98	15	50	16	13	15 mm	✓
	A	20	0,5 - 2,5	lang/long	110	15	60	20	17	15 mm	✓
	B	25	0,5 - 2,5	lang/long	150	15	94	25	21	15 mm	✓
6963	A	22	3,0 - 3,5	lang/long	110	15	60	20	17	15 mm	✓
	B	27	3,0 - 3,5	kurz/short	106	15	50	25	21	15 mm	✓
6962	A	25	1,0 - 4,0	kurz/short	107	26	48	25	21	26 mm	✓

Anwendungsbereich:
für Feingewinde = Fräser-Ø d1 < 2/3 des Gewinde-Ø
für Feingewinde = Fräser-Ø d1 < 3/4 des Gewinde-Ø
Kat. Nr. 6970 - Schraube
Kat. Nr. 6980 - Torx-Schraubendreher
Bei Bestellung bitte Kat. Nr. des Werkzeughalters

Application area:
for metric coarse threads = cutter Ø d_1 2/3 of thread Ø
per filettatura fine = fresa Ø d_1 3/4 of thread Ø
Cat. No. 6970 - Screw
Cat. No. 6980 - Torx screw driver
When ordering please state Cat. No. of the tool holder

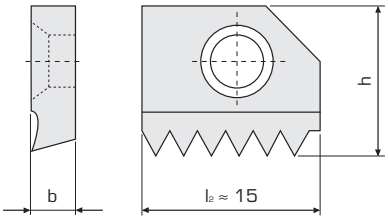
✓ Auf Anfrage / Upon request

MULTI TMI

Gewindefräsplatten aus Hartmetall für Metrisches ISO – Gewinde
Indexable inserts for ISO metric thread

Für Innegewinde
For internal threads

M MF TiN



Typ / Type					Multi TMI	Multi TMI
Schneidstoff / Material					VHM	VHM
l_2 mm	**Steigung** Pitch	**b mm**	**h mm**	**Standard Fräsplatte** Standard insert	**6950**	**6950 TN**
15	0,50	3,18	10	15 mm	●	●
15	0,75	3,18	10	15 mm	●	●
15	1,00	3,18	10	15 mm	●	●
15	1,25	3,18	10	15 mm	●	●
15	1,50	3,18	10	15 mm	●	●
15	1,75	3,18	10	15 mm	●	●
15	2,00	3,18	10	15 mm	●	●
15	2,50	3,18	10	15 mm	●	●
15	3,00	3,18	10	15 mm	●	●
15	3,50	3,18	10	15 mm	●	●

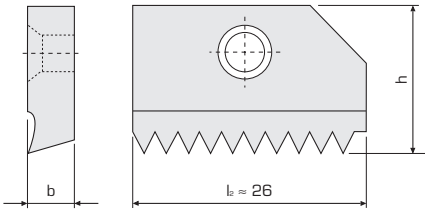
● Standardartikel / Items available ex stock

MULTI TMI

Gewindefräsplatten aus Hartmetall für Metrisches ISO – Gewinde
Indexable inserts for ISO metric thread

Für Innegewinde
For internal threads

MF F TiN



Typ / Type					**Multi TMI**	**Multi TMI**
Schneidstoff/ Material					**VHM**	**VHM**
l_2 mm	**Steigung** Pitch	**b mm**	**h mm**	**Standard Fräsplatte** Standard insert	**6956**	**6956 TN**
26	1,0	4,95	15	26 mm	●	●
26	1,5	4,95	15	26 mm	●	●
26	2,0	4,95	15	26 mm	●	●
26	2,5	4,95	15	26 mm	●	●
26	3,0	4,95	15	26 mm	●	●
26	3,5	4,95	15	26 mm	●	●
26	4,0	4,95	15	26 mm	●	●

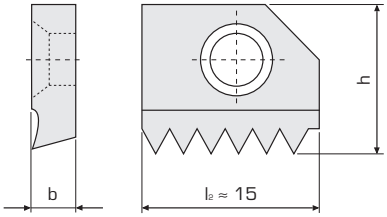
● Standardartikel / Items available ex stock

MULTI TMI

Gewindefräsplatten aus Hartmetall für Unified Gewinde ANSI B 1.1
Indexable inserts for unified thread UN ANSI B 1.1

Per filetti interni ed esterni / For internal and external threads

UN TiN



Typ / Type					Multi TMI	Multi TMI
Schneidstoff/ Material					VHM	VHM
l_2 **mm**	**Gg/1"** Tpi	**b mm**	**h mm**	**Standard Fräsplatte** Standard insert	**6954**	**6954 TN**
15	12	3,18	10	15 mm	●	●
15	14	3,18	10	15 mm	●	●
15	16	3,18	10	15 mm	●	●

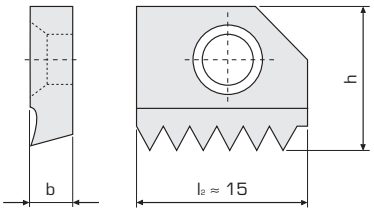
● **Standardartikel /** Items available ex stock

MULTI TMI

Gewindefräsplatten aus Hartmetall für Whitworth (BSF-BSP/G)
Indexable inserts for for Whitworth fine thread (BSF) and Whitworth pipe thread

Per filetti interni ed esterni / For internal and external threads

BSF BSP G TiN



Typ / Type					Multi TMI	Multi TMI
Schneidstoff/ Material					VHM	VHM
l_2 mm	**Gg/1"** Tpi	**b mm**	**h mm**	**Standard Fräsplatte** Standard insert	**6952**	**6952 TN**
15	11	3,18	10	15 mm	●	●
15	14	3,18	10	15 mm	●	●

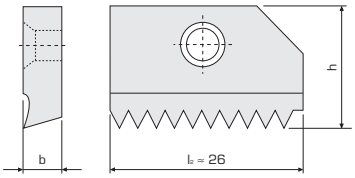
● Standardartikel / Items available ex stock

MULTI TMI

Gewindefräsplatten aus Hartmetall für Whitworth (BSF-BSP/G)
Indexable inserts for for Whitworth fine thread (BSF) and Whitworth pipe thread

Per filetti interni ed esterni / For internal and external threads

BSF BSP G TiN



Typ / Type					Multi TMI	Multi TMI
Schneidstoff/ Material					VHM	VHM
l_2 mm	**Gg/1"** Tpi	**b mm**	**h mm**	**Standard Fräsplatte** Standard insert	**6958**	**6958 TN**
26	11	4,95	15	26 mm	●	●

● Standardartikel / Items available ex stock

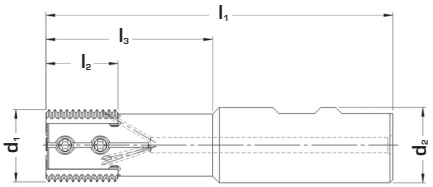
MULTI TMI

Gewindefräser mit unterschiedlichen Nuten, Wendeschneidplatten aus VHM, Weldon Schaft und Innenkühlung
Thread milling cutters multi flutes, indexable inserts, WELDON shank and internal coolant

M

Kühlmittelaustritt
internal cooling

NEW



Typ / Type

Schneidstoff/ Material

Kat. Nr. Cat. No.	d_1 mm	l_1 mm	l_2 mm	l_3 mm	Ø d2 h6	Z	Wendeplatte Standard	Schraube Screw	
6981	26	115	23	50	25	3	**6953**	**6991** M3,5	●
6982	33	115	40	85	32	3	**6955**	**6991** M3,5	●
6983	41	115	48	100	40	4	**6957**	**6991** M4	●

Kat. Nr./Cat.-No. **6991**	Schraube/Screw M3,5	Grundkörper/locking bodies **6981/6982**
Kat. Nr./Cat.-No. **6991**	Schraube/Screw M4	Grundkörper/locking body **6983**
Kat. Nr./Cat.-No. **KY T 15**		Torx Schraubendreher/Torx key

● Standardartikel / Items available ex stock

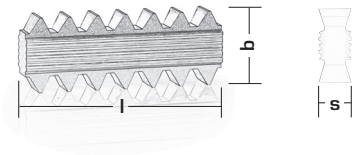
MULTI TMI

Vollhartmetallwendeplatte für ISO metrisches Gewinde
indexable inserts for ISO metric thread

Für Innegewinde
For internal threads

M TICN

NEW



Typ / Type						Multi TMI	Multi TMI
Schneidstoff / Material						VHM	VHM
Ø mm	**Steigung** Pitch	**Grundkörper** Bodies	**l mm**	**b mm**	**S mm**	**6953**	**6953 TC**
26	1,0	**6981**	24	9	4	●	●
26	1,5	**6981**	24	9	4	●	●
26	2,0	**6981**	24	9	4	●	●
26	3,0	**6981**	24	9	4	●	●
26	3,5	**6981**	24	9	4	●	●
26	4,0	**6981**	24	9	4	●	●

● Standardartikel / Items available ex stock

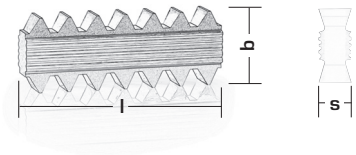
MULTI TMI

Vollhartmetallwendeplatte für ISO metrisches Gewinde
Indexable inserts for ISO metric thread

Für Innegewinde
For internal threads

M TICN

NEW



Typ / Type						Multi TMI	Multi TMI
Schneidstoff / Material						VHM	VHM
Ø mm	**Steigung** Pitch	**Grundkörper** Bodies	**l mm**	**b mm**	**S mm**	**6955**	**6955 TC**
33	1,0	**6982**	40	11	5	●	●
33	2,0	**6982**	40	11	5	●	●
33	3,0	**6982**	40	11	5	●	●
33	4,0	**6982**	40	11	5	●	●
33	4,5	**6982**	40	11	5	●	●
33	5,0	**6982**	40	11	5	●	●

● Standardartikel / Items available ex stock

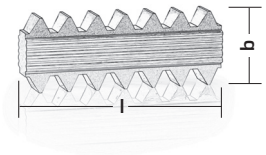
MULTI TMI

Vollhartmetallwendeplatte für ISO metrisches Gewinde
Indexable inserts for ISO metric thread

Für Innegewinde
For internal threads

M TICN

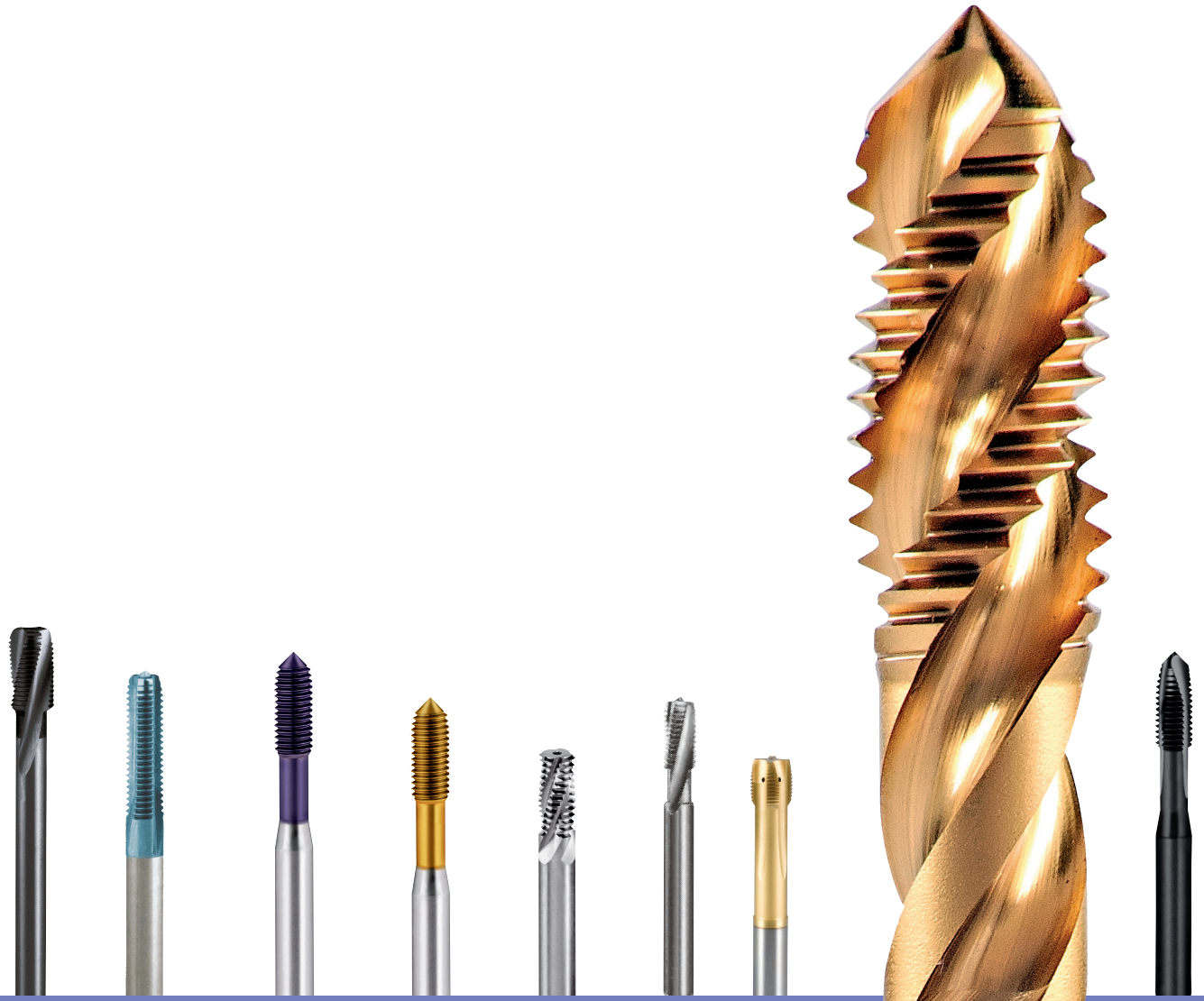
NEW



Typ / Type						Multi TMI	Multi TMI
Schneidstoff / Material						VHM	VHM
Ø mm	**Steigung** Pitch	**Grundkörper** Bodies	**l mm**	**b mm**	**S mm**	**6957**	**6957 TC**
41	2,0	**6983**	48	13	6	●	●
41	3,0	**6983**	48	13	6	●	●
41	4,0	**6983**	48	13	6	●	●
41	5,5	**6983**	48	13	6	●	●
41	6,0	**6983**	48	13	6	●	●

● Standardartikel / Items available ex stock

Hochleistungs-Gewindebohrer
High Performance Taps



▶ Technische Daten
Technical Guide

TECHNISCHE DATEN
TECHNICAL DATA




	Typ / Type	**MULTI RAPID VA / MULTI VA**		**MULTI RAPID HD / MULTI HD**	
	ILIX Typ-siehe Seite / ILIX type - see page	290		290	
	Werkstoff / Material	**HSS-Co-PM**		**HSS-Co-PM**	
	Anwendung / Application	Durchgangsloch Through Hole	Sackloch Blind Hole	Durchgangsloch Through Hole	Sackloch Blind Hole
	Anschnitt - Drallwinkel / Chamfer - Flute angle	B 0°	C 50°	B 0°	C 40°
	Gewindetiefe / Threding deep	3xD	3xD	3xD	3xD
	Beschichtung / Coating	TC	TC	TN	-
	Innenliegende Kühlkanäle / Internal Coolant	-	-	-	-
M	**4H**	-	-	-	-
	6H/6HX	6773/6778	6774/6779	6750/6751	6755/6756
	6G/6GX	-	-	-	-
	7G	-	-	-	-
	6H+0,1	-	-	-	-
MF	**6H/6HX**	6984	6985	6752	6757
	6G/6GX	-	-	-	-
	6H+0,1	-	-	-	-
UNC	**2B/2BX**	6986	6987	6993	6994
	3B/3BX	-	-	-	-
UNF	**2B/2BX**	6988	6989	6995	6996
	3B/3BX	-	-	-	-
8-UN	**2B**	-	-	-	-
BSP/G	**G**	-	-	-	-
RP (BSPP)	**Rp**	-	-	-	-
RC (BSPT)	**Rc**	-	-	-	-
BSW-W	**BSW**	-	-	-	-
NPT	**NPT**	-	-	-	-
NPTF	**NPTF**	-	-	-	-
		VC	**VC**	**VC**	**VC**
P	**< 800 N/mm²**	30	30	-	-
	700-1000 N/mm²	25	25	25	25
	1000-1300 N/mm²	-	-	15	15
M	**Austenitisch**	15	15	-	-
	Austenitisch / ferritisch	10	10	8	8
K	**GG**	-	-	30	30
	GGG	-	-	20	20
N	**Aluminium**	40	40	-	-
	NE-Metalle	-	-	-	-
S	**Titan**	3	3	-	-
	Sonderlegierungen	-	-	-	-
H	**Gehärteter Stahl 38 / 48 HRC**	-	-	-	-
	Gehärteter Stahl 48 / 58 HRC	-	-	-	-
	Gehärteter Stahl 58 / 68 HRC	-	-	-	-

Die in der Tabelle dargestellten Schnittdaten sind nur gültig für optimale Maschine / Werkstück Bedingungen.
The cutting parameters shown in the table have to be considered valid in optimal machine/workpiece conditions

TECHNISCHE DATEN
TECHNICAL DATA








	MULTI RAPID HD i / MULTI HD i		SINCRO ILIX i			MULTI GG	MULTI GG i	VR i 15°
	292		292			294	294	294
	HSS-Co-PM		HSS-Co-PM			HSS-Co-PM	HSS-Co-PM	HSS-Co-PM
	Durchgangsloch Through Hole	Sackloch Blind Hole	Durchgangsloch Through Hole	Sackloch Blind Hole		Sackloch / Blind Hole Durchgangsloch / Through Hole	Sackloch / Blind Hole Durchgangsloch / Through Hole	Sackloch Blind Hole
	B 0°	C 40°	B 0°	C 15°	C 40°	C 0°	C 0°	C 15°
	3XD	3XD	3XD	2xD	3xD	3xD	3xD	2xD
	TN/TC	TN/TC	TN	TN	TN	VP	VP	TN
						-		
	-	-	-	-	-	-	-	-
	6753/6758	6772/6777	6975	6971/6972	6973/6974	6964/6965	6967	6601
	-	-	-	-	-	-	-	-
	-	-	-	-	-	-	-	-
	-	-	-	-	-	-	-	-
	-	-	6978	-	6977	6966	-	-
	-	-	-	-	-	-	-	-
	-	-	-	-	-	-	-	-
	-	-	-	-	-	-	-	-
	-	-	-	-	-	-	-	-
	-	-	-	-	-	-	-	-
	-	-	-	-	-	-	-	-
	-	-	-	-	-	-	-	-
	-	-	-	-	-	-	-	-
	-	-	-	-	-	-	-	-
	-	-	-	-	-	-	-	-
	-	-	-	-	-	-	-	-
	-	-	-	-	-	-	-	-
	VC	VC	VC	VC	VC	VC	VC	VC
	-	-	40	40	40	-	-	40
	30	30	35	35	35	-	-	30
	25	25	25	25	25	-	-	25
	15	15	15	15	15	-	-	15
	10	10	10	10	10	-	-	10
	35	35	-	-	-	35	40	-
	35	35	40	40	40	25	30	-
	-	-	50	50	50	40	40	40
	-	-	35	35	35	-	-	25
	-	-	3	3	3	-	-	3
	-	-	2	2	2	-	-	2
	-	-	-	-	-	-	-	-
	-	-	-	-	-	-	-	-
	-	-	-	-	-	-	-	-

TECHNISCHE DATEN
TECHNICAL DATA




	Typ / Type	**T-BLACK**	**TI**		**NI**
	ILIX Typ-siehe Seite / ILIX type - see page	294	296		296
	Werkstoff / Material	**HSS-Co-PM**	**HSS-Co-PM**		**HSS-Co-PM**
	Anwendung / Application	Sackloch Blind Hole	Durchgangsloch Through Hole	Sackloch Blind Hole	Durchgangsloch Through Hole
	Anschnitt - Drallwinkel / Chamfer - Flute angle	C 40°	B 0°	C 15°	B 0°
	Gewindetiefe / Threding deep	3xD	2xD	2xD	2xD
	Beschichtung / Coating	TB	VP	VP	BL
	Innenliegende Kühlkanäle / Internal Coolant	-	-	-	-
M	**4H**	-	-	-	-
	6H/6HX	6668/6669	6683/6825	6684/6826	6892/6893
	6G/6GX	-	-	-	-
	7G	-	-	-	-
	6H+0,1	-	-	-	-
MF	**6H/6HX**	6830	6828	6829	-
	6G/6GX	-	-	-	-
	6H+0,1	-	-	-	-
UNC	**2B/2BX**	6831/6832	-	-	6869/6897
	3B/3BX	-	-	-	-
UNF	**2B/2BX**	6833/6834	-	-	6844/6845
	3B/3BX	-	-	-	-
8-UN	**2B**	-	-	-	-
BSP/G	**G**	6835	-	-	-
RP (BSPP)	**Rp**	-	-	-	-
RC (BSPT)	**Rc**	-	-	-	-
BSW-W	**BSW**	-	-	-	-
NPT	**NPT**	-	-	-	-
NPTF	**NPTF**	-	-	-	-
		VC	**VC**	**VC**	**VC**
P	**< 800 N/mm²**	35	-	-	-
	700-1000 N/mm²	30	-	-	-
	1000-1300 N/mm²	20	7	7	-
M	**Austenitisch**	10	-	-	-
	Austenitisch / ferritisch	7	6	6	6
K	**GG**	-	-	-	-
	GGG	30	-	-	-
N	**Aluminium**	30	-	-	-
	NE-Metalle	20	-	-	-
S	**Titan**	2	3	3	3
	Sonderlegierungen	2	-	-	2
H	**Gehärteter Stahl 38 / 48 HRC**	-	-	-	-
	Gehärteter Stahl 48 / 58 HRC	-	-	-	-
	Gehärteter Stahl 58 / 68 HRC	-	-	-	-

Die in der Tabelle dargestellten Schnittdaten sind nur gültig für optimale Maschine / Werkstück Bedingungen.
The cutting parameters shown in the table have to be considered valid in optimal machine/workpiece conditions

TECHNISCHE DATEN
TECHNICAL DATA







NI			MULTI TP	N	N 15°	GG i	N
296			298	300	300	300	300
HSS-Co-PM			VHM	VHM	VHM	VHM	VHM
Sackloch / Blind Hole			Sackloch / Blind Hole Durchgangsloch / Through Hole	Sackloch / Blind Hole	Sackloch / Blind Hole	Sackloch / Blind Hole Durchgangsloch / Through Hole	Sackloch / Blind Hole
C 10°	C 22°		C 0°	C 0°	C 15°	C 0°	C 15°
2XD	2XD		1,5xD	2xD	1,5xD	3xD	2xD
BL	BL		TC	BL	BL	VP	TN
-	-		-	-	-		
6906	-		-	-	-	-	-
6894/6948	6895/6896		6770	6771/6792	6736/6759	6760/6763	6762/6765
-	-		-	-	-	-	-
-	-		-	-	-	-	-
-	-		-	-	-	-	-
-	-		-	-	-	6766/6768	6767/6769
-	-		-	-	-	-	-
-	-		-	-	-	-	-
6990/6997	-		-	-	-	-	-
6998	-		-	-	-	-	-
6928/6929	-		-	-	-	-	-
6907	-		-	-	-	-	-
-	-		-	-	-	-	-
-	-		-	-	-	-	-
-	-		-	-	-	-	-
-	-		-	-	-	-	-
-	-		-	-	-	-	-
-	-		-	-	-	-	-
-	-		-	-	-	-	-
VC	VC		VC	VC	VC	VC	VC
-	-		-	-	-	-	-
-	-		-	-	-	-	-
-	-		-	-	-	-	-
-	-		-	-	-	-	-
6	6		-	-	-	-	-
-	-		35	35	35	40	40
-	-		-	-	-	-	-
-	-		-	40	40	50	50
-	-		-	40	40	50	50
3	3		-	-	-	-	-
2	2		-	-	-	-	-
-	-		6	6	6	6	6
-	-		4	-	-	-	-
-	-		2	-	-	-	-

TECHNISCHE DATEN
TECHNICAL DATA


	Typ / Type	**TP**		**MICRO**	
	ILIX Typ-siehe Seite / ILIX type - see page	302		302	
	Werkstoff / Material	**VHM**		**VHM**	
	Anwendung / Application	Sackloch / Blind Hole Durchgangsloch / Through Hole		Sackloch / Blind Hole Durchgangsloch / Through Hole	
	Anschnitt - Drallwinkel / Chamfer - Flute angle	-		-	
	Gewindetiefe / Threding deep	1,5/2xD		2/3xD	
	Beschichtung / Coating	TF		TC	
	Innenliegende Kühlkanäle / Internal Coolant	-		-	
M	**4H**	7015/7016		7081/7082/7083	
	6H/6HX	7015/7016		7081/7082/7083	
	6G/6GX	7015/7016		7081/7082/7083	
	7G	7015/7016		7081/7082/7083	
	6H+0,1	7015/7016		7081/7082/7083	
MF	**6H/6HX**	-		-	
	6G/6GX	-		-	
	6H+0,1	-		-	
UNC	**2B/2BX**	-		-	
	3B/3BX	-		-	
UNF	**2B/2BX**	-		-	
	3B/3BX	-		-	
8-UN	**2B**	-		-	
BSP/G	**G**	-		-	
RP (BSPP)	**Rp**	-		-	
RC (BSPT)	**Rc**	-		-	
BSW-W	**BSW**	-		-	
NPT	**NPT**	-		-	
NPTF	**NPTF**	-		-	
		Vc	**Fz**	**Vc**	**Fz**
P	**< 800 N/mm²**	-	-	120	0,005-0,02
	700-1000 N/mm²	-	-	100	0,005-0,02
	1000-1300 N/mm²	-	-	80	0,005-0,02
M	**Austenitisch**	-	-	40	0,005-0,02
	Austenitisch / ferritisch	-	-	35	0,005-0,02
K	**GG**	80	0,04-0,12	100	0,005-0,02
	GGG	-	-	80	0,005-0,02
N	**Aluminium**	-	-	250	0,01-0,06
	NE-Metalle	-	-	200	0,01-0,06
S	**Titan**	-	-	35	0,005-0,02
	Sonderlegierungen	-	-	30	0,005-0,02
H	**Gehärteter Stahl 38 / 48 HRC**	55	0,02-0,06	-	-
	Gehärteter Stahl 48 / 58 HRC	45	0,02-0,06	-	-
	Gehärteter Stahl 58 / 68 HRC	40	0,02-0,06	-	-

Die in der Tabelle dargestellten Schnittdaten sind nur gültig für optimale Maschine / Werkstück Bedingungen.
The cutting parameters shown in the table have to be considered valid in optimal machine/workpiece conditions

TECHNISCHE DATEN
TECHNICAL DATA

	MULTI TM 27°	MULTI TM 15°	MULTI TM 0°	MULTI CTM 27°
				
	302	304	304	304
	VHM	VHM	VHM	VHM
	Sackloch / Blind Hole Durchgangsloch / Through Hole	Sackloch / Blind Hole Durchgangsloch / Through Hole	Sackloch / Blind Hole Durchgangsloch / Through Hole	Sackloch / Blind Hole Durchgangsloch / Through Hole
	-	-	-	-
	2/3xD	2/3xD	2/3xD	2/3xD
	BL TF	BL TF	BL TF	BL TF
				
	7000/7001/7013	7020	6930/6931	7040/7041
	7000/7001/7013	7020	6930/6931	7040/7041
	7000/7001/7013	7020	6930/6931	7040/7041
	7000/7001/7013	7020	6930/6931	7040/7041
	7000/7001/7013	7020	6930/6931	7040/7041
	7002/7003	7020	-	7042/7043
	7002/7003	7020	-	7042/7043
	7002/7003	7020	-	7042/7043
	7007/7014	7027	-	7046
	7007/7014	7027	-	7046
	7009	7027	-	7048
	7009	7027	-	7048
	-	7027	-	-
	7004/7005	7024	6932	7044
	-	-	-	-
	-	-	-	-
	-	-	-	-
	7010	7030	-	7050
	7012	7032	-	7052
	Vc Fz	Vc Fz	Vc Fz	Vc Fz
	120 0,06-0,12	120 0,06-0,12	120 0,06-0,12	120 0,06-0,12
	100 0,05-0,1	100 0,05-0,1	100 0,05-0,1	100 0,05-0,1
	80 0,05-0,1	80 0,05-0,1	80 0,05-0,1	80 0,05-0,1
	40 0,06-0,12	40 0,06-0,12	40 0,06-0,12	40 0,06-0,12
	35 0,05-0,1	35 0,05-0,1	35 0,05-0,1	35 0,05-0,1
	100 0,07-0,14	100 0,07-0,14	100 0,07-0,14	100 0,07-0,14
	80 0,05-0,1	80 0,05-0,1	80 0,05-0,1	80 0,05-0,1
	250 0,07-0,15	250 0,07-0,15	250 0,07-0,15	250 0,07-0,15
	200 0,07-0,15	200 0,07-0,15	200 0,07-0,15	200 0,07-0,15
	35 0,02-0,08	35 0,02-0,08	35 0,02-0,08	35 0,02-0,08
	30 0,02-0,08	30 0,02-0,08	30 0,02-0,08	30 0,02-0,08
	- -	- -	- -	- -
	- -	- -	- -	- -
	- -	- -	- -	- -

TECHNISCHE DATEN
TECHNICAL DATA


	Typ / Type	**MULTI DTM 2tg**		**MULTI DTM 3tg**	
	ILIX Typ-siehe Seite / ILIX type - see page	306		308	
	Werkstoff / Material	**Wechselplatte VHM**		**Wechselplatte VHM**	
	Anwendung / Application	Sackloch / Blind Hole Durchgangsloch / Through Hole		Sackloch / Blind Hole Durchgangsloch / Through Hole	
	Anschnitt - Drallwinkel / Chamfer - Flute angle	-		-	
	Gewindetiefe / Threding deep	-		-	
	Beschichtung / Coating	BL	TF	BL	TF
	Innenliegende Kühlkanäle / Internal Coolant				
M	**4H**	6940/6942/6947		7071/7073//7075/7077	
	6H/6HX	6940/6942/6947		7071/7073//7075/7077	
	6G/6GX	6940/6942/6947		7071/7073//7075/7077	
	7G	6940/6942/6947		7071/7073//7075/7077	
	6H+0,1	6940/6942/6947		7071/7073//7075/7077	
MF	**6H/6HX**	6944/6946/6943		7072/7074/7076/7078	
	6G/6GX	6944/6946/6943		7072/7074/7076/7078	
	6H+0,1	6944/6946/6943		7072/7074/7076/7078	
UNC	**2B/2BX**	7068-7070		-	
	3B/3BX	7068-7070		-	
UNF	**2B/2BX**	7064-7066		-	
	3B/3BX	7064-7066		-	
8-UN	**2B**	-		-	
BSP/G	**G**	-		-	
RP (BSPP)	**Rp**	-		-	
RC (BSPT)	**Rc**	-		-	
BSW-W	**BSW**	-		-	
NPT	**NPT**	-		-	
NPTF	**NPTF**	-		-	
		Vc	**Fz**	**Vc**	**Fz**
P	**< 800 N/mm²**	-	-	-	-
	700-1000 N/mm²	-	-	-	-
	1000-1300 N/mm²	-	-	-	-
M	**Austenitisch**	-	-	-	-
	Austenitisch / ferritisch	-	-	-	-
K	**GG**	100	0,06-0,12	100	0,06-0,12
	GGG	-	-	-	-
N	**Aluminium**	250	0,07-0,15	250	0,07-0,15
	NE-Metalle	200	0,07-0,15	200	0,07-0,15
S	**Titan**	-	-	-	-
	Sonderlegierungen	-	-	-	-
H	**Gehärteter Stahl 38 / 48 HRC**	-	-	-	-
	Gehärteter Stahl 48 / 58 HRC	-	-	-	-
	Gehärteter Stahl 58 / 68 HRC	-	-	-	-

Die in der Tabelle dargestellten Schnittdaten sind nur gültig für optimale Maschine / Werkstück Bedingungen.
The cutting parameters shown in the table have to be considered valid in optimal machine/workpiece conditions

TECHNISCHE DATEN
TECHNICAL DATA

TMI		TMI EVO	
308		310	
Wechselplatte VHM		**Wechselplatte VHM**	
Sackloch / Blind Hole Durchgangsloch / Through Hole		Sackloch / Blind Hole Durchgangsloch / Through Hole	
-		-	
-		-	
BL	TN	BL	TC
-		-	
6950/6956		6953/6955/6957	
6950/6956		6953/6955/6957	
6950/6956		6953/6955/6957	
6950/6956		6953/6955/6957	
6950/6956		6953/6955/6957	
6950/6956		-	
6950/6956		-	
6950/6956		-	
6954		-	
6954		-	
6954		-	
6954		-	
6952		-	
-		-	
-		-	
-		-	
-		-	
-		-	
-		-	
Vc	**Fz**	**Vc**	**Fz**
120	0.05-0.30	120	0.05-0.30
100	0.05-0.25	100	0.05-0.25
80	0.05-0.15	80	0.05-0.15
80	0.05-0.15	80	0.05-0.20
70	0.05-0.10	70	0.05-0.15
100	0.05-0.30	90	0.05-0.30
80	0.05-0.20	80	0.05-0.20
250	0.05-0.35	250	0.10-0.40
150	0.05-0.25	150	0.10-0.35
35	0.02-0.08	35	0.04-0.15
25	0.02-0.08	30	0.04-0.15
-	-	-	-
-	-	-	-
-	-	-	-