

Gewindewerkzeuge *Threading Tools* **6**



Drehen
Turning

Fräswerkzeuge
Milling Tools

HDS-/VHM- Fräser
HDS-/Solid Carbide
Endmills



Stech- und
Abstechwerkzeuge
Grooving and
Parting off Tools

Mini/ Micro
Schneidwerkzeuge
Mini/ Micro Tools

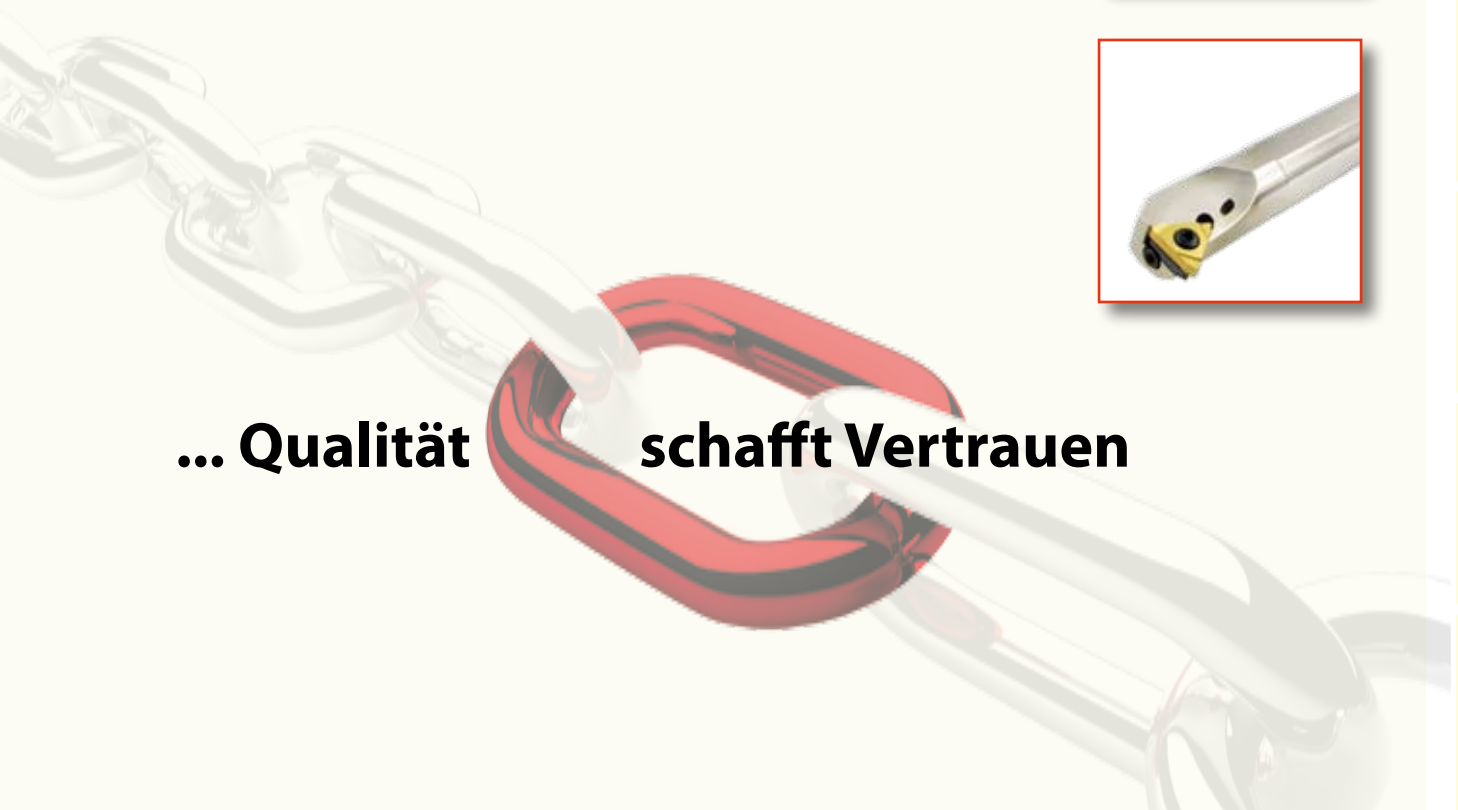


Gewinde-
werkzeuge
Threading tools



Wendepplattenbohrer
VHM-Bohrer
Indexable Drills
Solid Carbide Drills

... Qualität schafft Vertrauen



Drehen
Turning

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Milling Tools

HDS-/VHM-Fräser
HDS-/Solid Carbide
Endmills

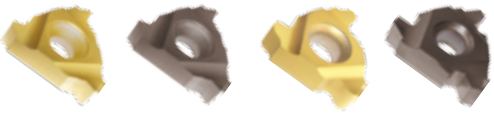

Stechdreh-
werkzeuge
Grooving Tools

Mini/Micro
Schneidwerkzeuge
Mini/Micro Tools

Gewinde-
werkzeuge
Threading Tools

Wendepplattenbohrer
VHM-Bohrer
Indexable Drills
Solid Carbide Drills

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Stech- und
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Grooving and
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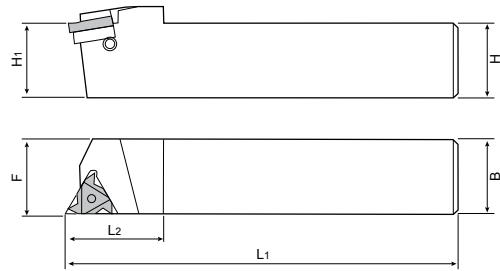
Mini/ Micro
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Gewinde-
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Wendepplattenbohrer
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Indexable Drills
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AL NL

zum Außen-Gewindedrehen *for External Threading*



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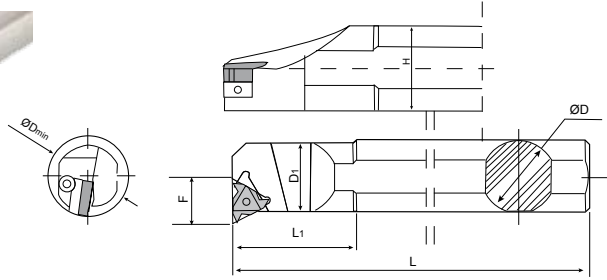
Stechedreh-
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Wendepplattenbohrer
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Bezeichnung Part Number	Lager Stock	Bezeichnung Part Number	Lager Stock	Maße [mm] Dimensions					Ersatzteile Spare Parts				
				H ₁ = H=B	F	L ₁	L ₂						
NL 08 - 2	●	NL 08 - 2 LH	●	8	11	100	17	11 ER/EL	-	75.20.118	56.33.612	-	
NL 10 - 2	●	NL 10 - 2 LH	●	10	11	100	17		-	75.20.119	-	-	
NL 12 - 3	●	NL 12 - 3 LH	●	12	16	100	22	16 ER/EL	16 ER: 75.10.201 +1,5°(Standard) 16 EL: 75.20.201 +1,5°(Standard)	+4,5° +3,5° +2,5° Standard +0,5° -0,5° -1,5°	75.20.120	75.20.618	75.20.130
AL 16 - 3	●	AL 16 - 3 LH	●	16	16	100	22						
AL 20 - 3	●	AL 20 - 3 LH	●	20	20	125	30						
AL 25 - 3	●	AL 25 - 3 LH	●	25	25	150	30						
AL 32 - 3	●	AL 32 - 3 LH	●	32	32	170	30	22 ER/EL	22 ER: 75.10.203 +1,5°(Standard) 22 EL: 75.20.202 +1,5°(Standard)	+4,5° +3,5° +2,5° Standard +0,5° -0,5° -1,5°	75.20.122	56.33.614	75.20.129
AL 25 - 4	●	AL 25 - 4 LH	●	25	25	150	36						
AL 32 - 4	○	AL 32 - 4 LH	●	32	32	170	36						
AL 40 - 4	●	AL 40 - 4 LH	○	40	40	200	36	27 ER/EL	27 ER: 75.10.204 +1,5°(Standard) 27 EL: 75.20.203 +1,5°(Standard)	+4,5° +3,5° +2,5° Standard +0,5° -0,5° -1,5°	75.20.124	56.33.613	75.20.127
AL 25 - 5	○	AL 25 - 5 LH	○	25	25	150	36						
AL 32 - 5	○	AL 32 - 5 LH	○	32	32	170	40						
AL 40 - 5	○	AL 40 - 5 LH	○	40	40	200	40						

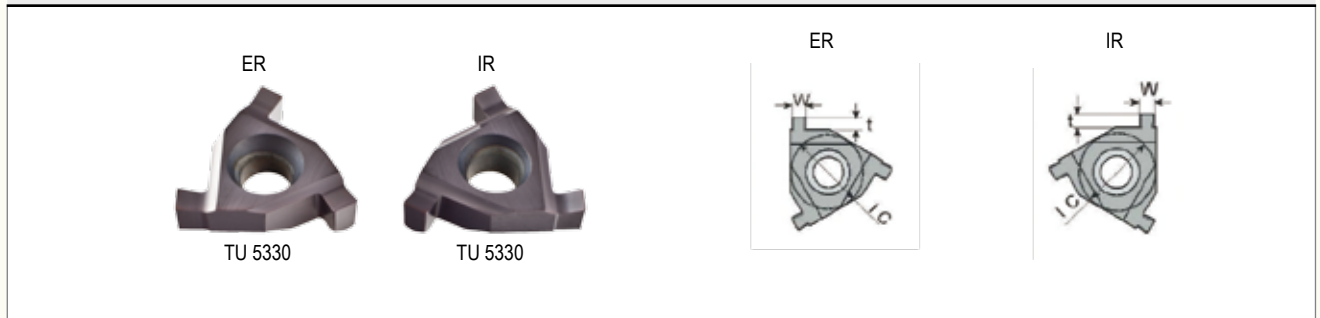
AVR NVR
zum Innen-Gewindedrehen for Internal Threading


Bezeichnung Part Number	Lager Stock	Bezeichnung Part Number	Lager Stock	Maße [mm] Dimensions								Ersatzteile Spare Parts				
				D	D ₁	L	L ₁	F	D _{min}	H						
Rechter Halter RH-Holder		Linke Halter LH-Holder														
NVR 05 - 0	●	NVR 05 - 0 LH	○	12	5,1	100	12	4,3	6,0	11	06 IR/IL	-	75.20.102	75.20.621	-	
NVR 07 - 1	●	NVR 07 - 1 LH	●	16	6,6	125	18	5,3	7,8	14	08 IR/IL	-	75.20.101			
NVR 10 - 2 IK	●	NVR 10 - 2 IK LH	○	16	10	125	25	7,4	12	14	11 IR/IL	-	75.20.118	56.33.612	-	
NVR 10 D - 2	●	NVR 10 D - 2 LH	○	10	9,6	100	25	7,4	12	9						
NVR 12 - 2 E	○	NVR 12 - 2 E LH		12	12	170	-	8,4	15	11						
NVR 13 - 2 IK	●	NVR 13 - 2 IK LH	●	16	13	150	32	8,9	15	14	16 IR/IL	-	75.20.119	75.20.618	75.20.130	
NVR 13 - 3 IK	●	NVR 13 - 3 IK LH	○	16	13	150	32	10,2	16	14						
NVR 16 - 3 IK	●	NVR 16 - 3 IK LH	●	20	16	170	40	11,7	19	18						
NVR 16 - 3 E	○	NVR 16 - 3 E LH		16	16	200	-	11,7	19	14	16 IR: 75.20.201 +1,5°(Standard)	+4,5° +3,5° +2,5° Standard	75.20.120	75.20.618	75.20.130	
AVR 20 - 3 IK	●	AVR 20 - 3 IK LH	●	20	20	170	-	13,7	24	18						
AVR 20 - 3 E	○	AVR 20 - 3 E LH		20	20	250	-	13,7	23	18						
AVR 25 D - 3 IK	●	AVR 25 D - 3 IK LH	●	25	25	200	-	16,2	29	22,5	22 IR/IL	-	75.20.122	56.33.614	75.20.129	
AVR 32 - 3 IK	●	AVR 32 - 3 IK LH	●	32	32	250	-	19,7	36	29						
AVR 40 - 3	●	AVR 40 - 3 LH	●	40	40	300	-	23,7	44	36						
NVR 20 - 4	●	NVR 20 - 4 LH	●	20	20	170	-	15,6	24	18	22 IR: 75.20.202 +1,5°(Standard)	+4,5° +3,5° +2,5° Standard	75.20.122	56.33.614	75.20.129	
AVR 25 - 4 IK	●	AVR 25 - 4 IK LH	●	25	25	200	-	18,1	29	22,5						
AVR 32 - 4 IK	●	AVR 32 - 4 IK LH	●	32	32	250	-	21,5	39	29						
AVR 40 - 4	●	AVR 40 - 4 LH	○	40	40	300	-	25,6	46	36	27 IR/IL	22 IL: 75.10.203 +1,5°(Standard)	75.20.124	75.20.622	75.20.127	
AVR 32 - 5	○	AVR 32 - 5 LH	○	32	32	250	-	22,6	40	29						
AVR 40 - 5	○	AVR 40 - 5 LH	○	40	40	300	-	26,6	48	36						
AVR 50 - 5	○	AVR 50 - 5 LH	○	50	50	350	-	31,6	58	45	27 IL: 75.10.204 +1,5°(Standard)	75.20.124	75.20.622	75.20.127		
AVR 60 - 5	○	AVR 60 - 5 LH	○	60	60	400	-	36,6	68	54						

"E" = HM-Schaft mit Innenkühlung
Carbide Shank with Inner Coolant

"IK" = Innenkühlung
Inner Coolant

Präzisions-Einstecken Außen/Innen *Grooving External/Internal*



Bezeichnung Part Number	Lager Stock	Bezeichnung Part Number	Lager Stock	IC	L	X	Y
Rechte WSP RH Inserts	TU 5330	Linke WSP LH Inserts	TU 5330	mm	mm	mm	mm
60° außen / external		60° außen / external					
16 ER -1.10- T 1.30	●	16 EL -1.10- T 1.30	○			1.10	1.30
16 ER -1.30- T 1.50	●	16 EL -1.30- T 1.30	○			1.30	1.50
16 ER -1.60- T 1.85	●	16 EL -1.60- T 1.85	○	9.525 (3/8")	16	1.60	1.85
16 ER -1.85- T 2.00	●	16 EL -1.85- T 2.00	○			1.85	2.00
16 ER -2.15- T 2.50	●	16 EL -2.15- T 2.50	○			2.15	2.25
60° außen / external		60° außen / external					
16 IR -1.10- T 1.30	●	16 EL -1.10- T 1.30	○			1.10	1.30
16 IR -1.30- T 1.30	●	16 EL -1.30- T 1.30	○			1.30	1.50
16 IR -1.60- T 1.85	●	16 EL -1.60- T 1.85	○	9.525 (3/8")	16	1.60	1.85
16 IR -1.85- T 2.00	●	16 EL -1.85- T 2.00	○			1.85	2.00
16 IR -2.15- T 2.50	●	16 EL -2.15- T 2.50	○			2.15	2.25

Set Präzisions - Einstecken Grooving



16ER 1.10-2.15/TU 5330
oder or
16IR 1.10-2.15/TU 5330

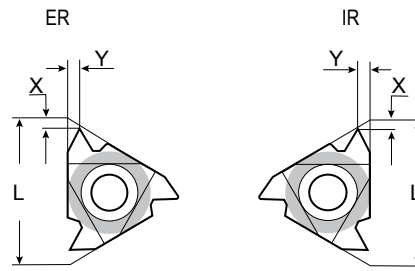
bestehend aus:

consisting of:

je 2 Stechplatten in den Breiten
each 2 grooving inserts in size
1.10, 1.30, 1.60, 1.85, 2.15 mm

Außen- / Innengewinde / External/Internal Thread

60° Teilprofil / Partial Profile



Bezeichnung Part Number	Lager Stock		Bezeichnung Part Number	Lager Stock		Steigung Pitch mm	L mm	X mm	Y mm
	TP 5130	TU 5330		TP 5130	TU 5330				
60° außen / external			60° außen / external						
11 ER -T- A 60	●		11 EL -T- A 60			0.5 - 1.5	11	0.8	0.9
16 ER -T- A 60	●	●	16 EL -T- A 60	●		0.5 - 1.5	16	0.8	0.9
16 ER -T- G 60	●	●	16 EL -T- G 60	●		1.75 - 3.0	16	1.2	1.7
16 ER -T- AG 60	●	●	16 EL -T- AG 60	●		0.5 - 3.0	16	1.2	1.7
22 ER -T- N 60	●		22 EL -T- N 60			3.5 - 5.0	22	1.7	2.5
27 ER -T- Q 60	●		27 EL -T- Q 60			5.5 - 6.0	27	2.1	3.1
60° innen / internal			60° innen / internal						
06 IR -T- A 60	○		06 IL -T- A 60			0.5 - 1.25	6	0.6	0.6
08 IR -T- A 60	○		08 IL -T- A 60			0.5 - 1.5	8	0.6	0.7
11 IR -T- A 60	●	○	11 IL -T- A 60	●		0.5 - 1.5	11	0.8	0.9
16 IR -T- A 60	●	●	16 IL -T- A 60	●		0.5 - 1.5	16	0.8	0.9
16 IR -T- G 60	●	●	16 IL -T- G 60	●		1.75 - 3.0	16	1.2	1.7
16 IR -T- AG 60	●	●	16 IL -T- AG 60	●		0.5 - 3.0	16	1.2	1.7
22 IR -T- N 60	●		22 IL -T- N 60			3.5 - 5.0	22	1.7	2.5
27 IR -T- Q 60	○		27 IL -T- Q 60			5.5 - 6.0	27	1.8	2.7

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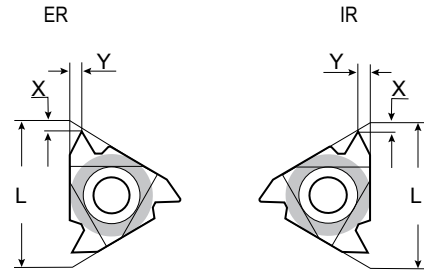
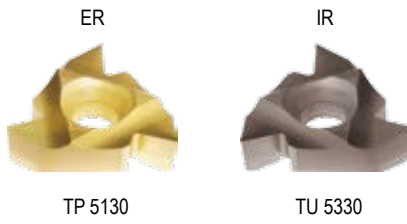
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Außen- /Innengewinde / External/Internal Thread

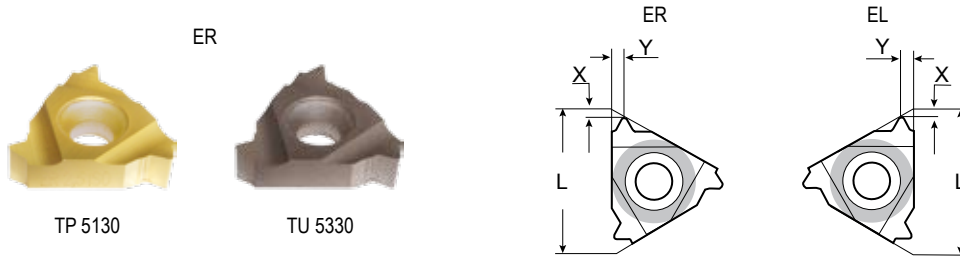
55° Teilprofil / Partial Profile



Bezeichnung Part Number	Lager Stock		Bezeichnung Part Number	Lager Stock		Steigung Pitch mm	L mm	X mm	Y mm
	TP 5130	TU 5330		TP 5130	TU 5330				
55° außen / external			55° außen / external						
11 ER -T- A 55	○		11 EL -T- A 55			48-16	11	0.8	0.9
16 ER -T- A 55	●	●	16 EL -T- A 55	●		48-16	16	0.8	0.9
16 ER -T- G 55	●	●	16 EL -T- G 55	●		14-8	16	1.2	1.7
16 ER -T- AG 55	●	●	16 EL -T- AG 55	●		48-168	16	1.2	1.7
22 ER -T- N 55	●		22 EL -T- N 55			7-5	22	1.7	2.5
27 ER -T- Q 55	●		27 EL -T- Q 55			4.5-4	27	2.0	2.9
55° innen / internal			55° innen / internal						
06 IR -T- A 55	○		06 IL -T- A 55			48-20	6	0.6	0.6
08 IR -T- A 55	○		08 IL -T- A 55			48-16	8	0.6	0.7
11 IR -T- A 55	●	○	11 IL -T- A 55			48-16	11	0.8	0.9
16 IR -T- A 55	●	●	16 IL -T- A 55	●		48-16	16	0.8	0.9
16 IR -T- G 55	●	●	16 IL -T- G 55	●		14-8	16	1.2	1.7
16 IR -T- AG 55	●	●	16 IL -T- AG 55	●		48-8	16	1.2	1.7
22 IR -T- N 55	●		22 IL -T- N 55			7-5	22	1.7	2.5
27 IR -T- Q 55	●		27 IL -T- Q 55			4.5-4	27	2.0	2.9

Außengewinde / External Thread

Vollprofil ISO 60° Full Profile ISO 60°



Bezeichnung Part Number	Lager Stock		Bezeichnung Part Number	Lager Stock		Steigung Pitch	L	X	Y
	TP 5130	TU 5330		Linke WSP LH Inserts	TP 5130				
11 ER - V - ISO 0.35			11 EL - V - ISO 0.35			0.35		0.8	0.4
11 ER - V - ISO 0.4			11 EL - V - ISO 0.4			0.4		0.7	0.4
11 ER - V - ISO 0.45			11 EL - V - ISO 0.45			0.45		0.7	0.4
11 ER - V - ISO 0.5	○		11 EL - V - ISO 0.5			0.5		0.6	0.6
11 ER - V - ISO 0.6	○		11 EL - V - ISO 0.6			0.6		0.6	0.6
11 ER - V - ISO 0.7	○		11 EL - V - ISO 0.7			0.7		0.6	0.6
11 ER - V - ISO 0.75	○		11 EL - V - ISO 0.75			0.75	11	0.6	0.6
11 ER - V - ISO 0.8	○		11 EL - V - ISO 0.8			0.8		0.6	0.6
11 ER - V - ISO 1.0	●		11 EL - V - ISO 1.0			1.0		0.7	0.7
11 ER - V - ISO 1.25	○		11 EL - V - ISO 1.25			1.25		0.8	0.9
11 ER - V - ISO 1.5	●		11 EL - V - ISO 1.5			1.5		0.8	1.0
11 ER - V - ISO 1.75	○		11 EL - V - ISO 1.75			1.75		0.8	1.1
16 ER - V - ISO 0.35			16 EL - V - ISO 0.35			0.35		0.8	0.4
16 ER - V - ISO 0.4			16 EL - V - ISO 0.4			0.4		0.7	0.4
16 ER - V - ISO 0.45			16 EL - V - ISO 0.45			0.45		0.7	0.4
16 ER - V - ISO 0.5	●	●	16 EL - V - ISO 0.5	●		0.5		0.6	0.6
16 ER - V - ISO 0.6	○		16 EL - V - ISO 0.6			0.6		0.6	0.6
16 ER - V - ISO 0.7	●	●	16 EL - V - ISO 0.7			0.7		0.6	0.6
16 ER - V - ISO 0.75	●	●	16 EL - V - ISO 0.75	●		0.75		0.6	0.6
16 ER - V - ISO 0.8	●	●	16 EL - V - ISO 0.8			0.8	16	0.6	0.6
16 ER - V - ISO 1.0	●	●	16 EL - V - ISO 1.0	●		1.0		0.7	0.7
16 ER - V - ISO 1.25	●	●	16 EL - V - ISO 1.25	●		1.25		0.8	0.9
16 ER - V - ISO 1.5	●	●	16 EL - V - ISO 1.5	●		1.5		0.8	1.0
16 ER - V - ISO 1.75	●	●	16 EL - V - ISO 1.75	●		1.75		0.9	1.2
16 ER - V - ISO 2.0	●	●	16 EL - V - ISO 2.0	●		2.0		1.0	1.3
16 ER - V - ISO 2.5	●	●	16 EL - V - ISO 2.5	●		2.5		1.1	1.5
16 ER - V - ISO 3.0	●	●	16 EL - V - ISO 3.0	●		3.0		1.2	1.6
16 ER - V - ISO 3.5	●		16 EL - V - ISO 3.5			3.5		1.2	1.7
22 ER - V - ISO 3.5	●	●	22 EL - V - ISO 3.5			3.5		1.6	2.3
22 ER - V - ISO 4.0	●	●	22 EL - V - ISO 4.0			4.0		1.6	2.3
22 ER - V - ISO 4.5	●	●	22 EL - V - ISO 4.5			4.5		1.7	2.4
22 ER - V - ISO 5.0	●	●	22 EL - V - ISO 5.0			5.0	22	1.7	2.5
22 ER - V - ISO 5.5	●	●	22 EL - V - ISO 5.5			5.5		1.7	2.6
22 ER - V - ISO 6.0	●	●	22 EL - V - ISO 6.0			6.0		1.9	2.7
27 ER - V - ISO 5.5	●		27 EL - V - ISO 5.5			5.5	27	1.9	2.7
27 ER - V - ISO 6.0	●		27 EL - V - ISO 6.0			6.0		2.0	2.9

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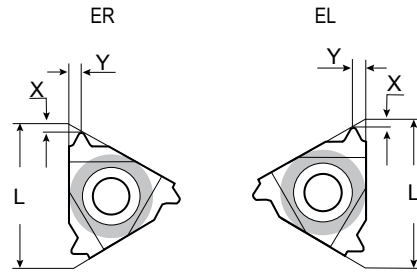
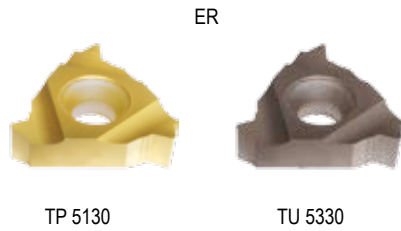
Mini/ Micro
Schneidwerkzeuge
Mini/ Micro Tools

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werkzeuge
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Solid Carbide Drills

Außengewinde / External Thread

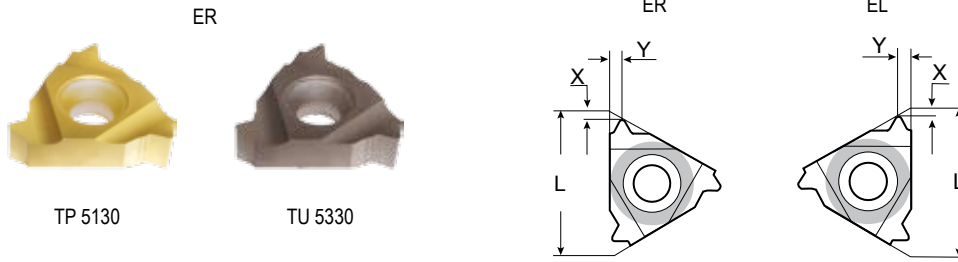
Vollprofil BSW 55° Full Profile BSW 55°



Bezeichnung Part Number	Lager Stock		Bezeichnung Part Number	Lager Stock		Steigung Pitch	L	X	Y
	TP 5130	TU 5330		TP 5130	TU 5330				
11 ER - V - BSW 40			11 EL - V - BSW 40			40		0.6	0.6
11 ER - V - BSW 36			11 EL - V - BSW 36			36		0.6	0.6
11 ER - V - BSW 32	○		11 EL - V - BSW 32			32		0.6	0.6
11 ER - V - BSW 28	○		11 EL - V - BSW 28			28		0.6	0.7
11 ER - V - BSW 26	○		11 EL - V - BSW 26			26		0.7	0.8
11 ER - V - BSW 24	○		11 EL - V - BSW 24			24	11	0.7	0.8
11 ER - V - BSW 22	○		11 EL - V - BSW 22			22		0.8	0.9
11 ER - V - BSW 20	○		11 EL - V - BSW 20			20		0.8	0.9
11 ER - V - BSW 19	○		11 EL - V - BSW 19			19		0.8	1.0
11 ER - V - BSW 18	○		11 EL - V - BSW 18			18		0.8	1.0
11 ER - V - BSW 16	○		11 EL - V - BSW 16			16		0.9	1.1
11 ER - V - BSW 14	○		11 EL - V - BSW 14			14		1.0	1.2
16 ER - V - BSW 40			16 EL - V - BSW 40			40		0.6	0.6
16 ER - V - BSW 36			16 EL - V - BSW 36			36		0.6	0.6
16 ER - V - BSW 32	○		16 EL - V - BSW 32			32		0.6	0.6
16 ER - V - BSW 28	●		16 EL - V - BSW 28			28		0.6	0.7
16 ER - V - BSW 26	●		16 EL - V - BSW 26			26		0.7	0.8
16 ER - V - BSW 24	●		16 EL - V - BSW 24			24		0.7	0.8
16 ER - V - BSW 22	○		16 EL - V - BSW 22			22		0.8	0.9
16 ER - V - BSW 20	○		16 EL - V - BSW 20			20		0.8	0.9
16 ER - V - BSW 19	●	●	16 EL - V - BSW 19	●		19	16	0.8	1.0
16 ER - V - BSW 18	●		16 EL - V - BSW 18			18		0.8	1.0
16 ER - V - BSW 16	●		16 EL - V - BSW 16			16		0.9	1.1
16 ER - V - BSW 14	●	●	16 EL - V - BSW 14	●		14		1.0	1.2
16 ER - V - BSW 12	●		16 EL - V - BSW 12			12		1.1	1.4
16 ER - V - BSW 11	●	●	16 EL - V - BSW 11	●		11		1.1	1.5
16 ER - V - BSW 10	●	○	16 EL - V - BSW 10			10		1.1	1.5
16 ER - V - BSW 9	●		16 EL - V - BSW 9			9		1.2	1.7
16 ER - V - BSW 8	●		16 EL - V - BSW 8			8		1.2	1.5
22 ER - V - BSW 7	○	●	22 EL - V - BSW 7			7		1.6	2.3
22 ER - V - BSW 6	●	●	22 EL - V - BSW 6			6	22	1.6	2.3
22 ER - V - BSW 5	○	●	22 EL - V - BSW 5			5		1.7	2.4
27 ER - V - BSW 4.5	○	●	27 EL - V - BSW 4.5			4.5	27	1.8	2.6
27 ER - V - BSW 4	○	●	27 EL - V - BSW 4			4		2.0	2.9

Außengewinde / External Thread

Vollprofil UN 60° Full Profile UN 60°



Bezeichnung Part Number	Lager Stock		Bezeichnung Part Number	Lager Stock		Steigung Pitch	L	X	Y
	TP 5130	TU 5330		TP 5130	TU 5330				
11 ER - V - UN 40			11 EL - V - UN 40			40		0.6	0.6
11 ER - V - UN 36			11 EL - V - UN 36			36		0.6	0.6
11 ER - V - UN 32	○		11 EL - V - UN 32			32		0.6	0.6
11 ER - V - UN 28	○		11 EL - V - UN 28			28		0.6	0.7
11 ER - V - UN 27	○		11 EL - V - UN 27			27		0.7	0.8
11 ER - V - UN 24	●		11 EL - V - UN 24			24	11	0.7	0.8
11 ER - V - UN 20	○		11 EL - V - UN 20			20		0.8	0.9
11 ER - V - UN 18	○		11 EL - V - UN 18			18		0.8	1.0
11 ER - V - UN 16	○		11 EL - V - UN 16			16		0.9	1.1
11 ER - V - UN 14	○		11 EL - V - UN 14			14		0.9	1.1
16 ER - V - UN 40	○		16 EL - V - UN 40			40		0.6	0.6
16 ER - V - UN 36	○		16 EL - V - UN 36			36		0.6	0.6
16 ER - V - UN 32	●	○	16 EL - V - UN 32			32		0.6	0.6
16 ER - V - UN 28	●		16 EL - V - UN 28			28		0.6	0.7
16 ER - V - UN 27	○		16 EL - V - UN 27			27		0.7	0.8
16 ER - V - UN 24	●		16 EL - V - UN 24			24		0.7	0.8
16 ER - V - UN 20	●		16 EL - V - UN 20			20		0.8	0.9
16 ER - V - UN 18	●		16 EL - V - UN 18			18		0.8	1.0
16 ER - V - UN 16	●		16 EL - V - UN 16			16	16	0.9	1.1
16 ER - V - UN 14	●		16 EL - V - UN 14			14		1.0	1.2
16 ER - V - UN 13	●		16 EL - V - UN 13			13		1.0	1.3
16 ER - V - UN 12	●		16 EL - V - UN 12			12		1.1	1.4
16 ER - V - UN 11	●		16 EL - V - UN 11			11		1.1	1.5
16 ER - V - UN 10	●		16 EL - V - UN 10			10		1.1	1.5
16 ER - V - UN 9	●		16 EL - V - UN 9			9		1.2	1.7
16 ER - V - UN 8	○		16 EL - V - UN 8			8		1.2	1.6
22 ER - V - UN 7	○		22 EL - V - UN 7			7		1.6	2.3
22 ER - V - UN 6	●		22 EL - V - UN 6			6	22	1.6	2.3
22 ER - V - UN 5	○		22 EL - V - UN 5			5		1.7	2.5
27 ER - V - UN 4.5	○		27 EL - V - UN 4.5			4.5		1.9	2.7
27 ER - V - UN 4	○		27 EL - V - UN 4			4	27	2.1	3.0

Drehen
Turning

Fräswerkzeuge
Milling Tools

HDS-/VHM-Fräser
HDS-/Solid Carbide
Endmills

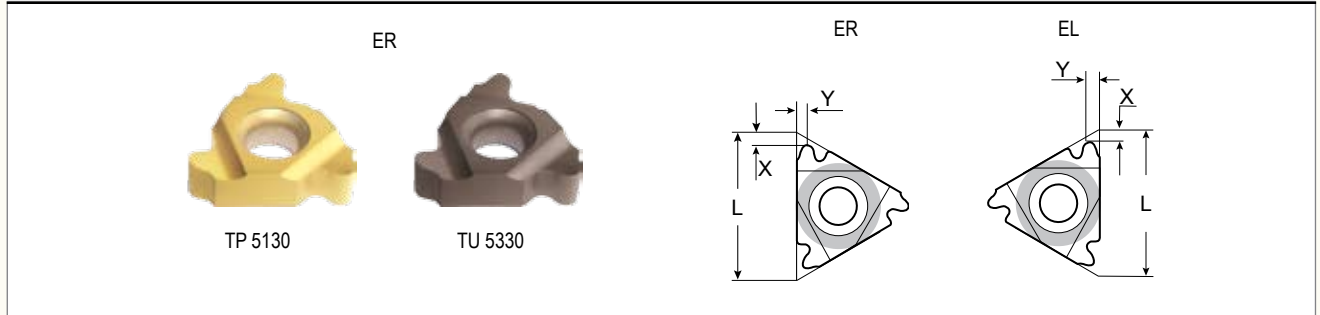
Stech- und
Abstechwerkzeuge
Grooving and
Parting off Tools

Mini/ Micro
Schneidwerkzeuge
Mini/ Micro Tools

Gewinde-
werkzeuge
Threading Tools

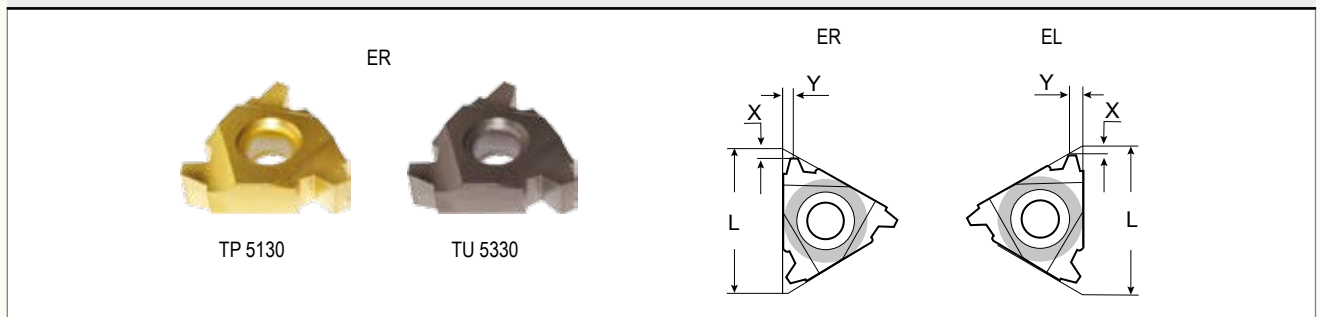
Wendepplattenbohrer
VHM-Bohrer
Indexable Drills
Solid Carbide Drills

Außengewinde / External Thread

Vollprofil RD DIN 405 Full Profile RD DIN 405


Bezeichnung Part Number	Lager Stock		Bezeichnung Part Number	Lager Stock		Steigung Pitch	L	X	Y
	TP 5130	TU 5330		TP 5130	TU 5330				
Rechte WSP RH Inserts			Linke WSP LH Inserts			TPI	mm	mm	mm
16 ER - V - RD 405 / 10	●		16 EL - V - RD 405 / 10			10		1.1	1.2
16 ER - V - RD 405 / 8	●		16 EL - V - RD 405 / 8			8	16	1.4	1.3
16 ER - V - RD 405 / 6	●		16 EL - V - RD 405 / 6			6		1.5	1.7
22 ER - V - RD 405 / 6	●		22 EL - V - RD 405 / 6			6	22	1.5	1.7
22 ER - V - RD 405 / 4	●		22 EL - V - RD 405 / 4			4		2.2	2.3
27 ER - V - RD 405 / 4	○		27 EL - V - RD 405 / 4			4	27	2.3	2.3

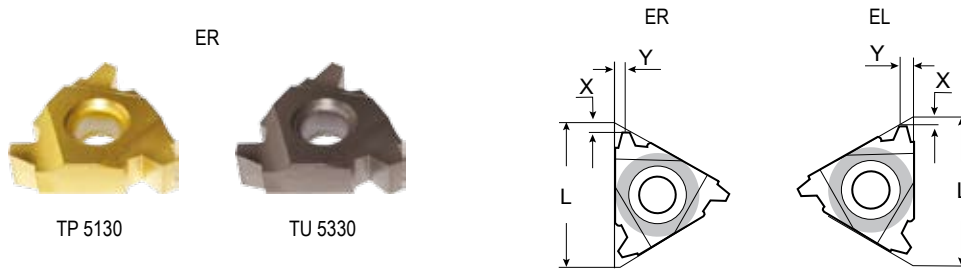
Außengewinde / External Thread

Vollprofil TR DIN 103 Full Profile TR DIN 103


Bezeichnung Part Number	Lager Stock		Bezeichnung Part Number	Lager Stock		Steigung Pitch	L	X	Y
	TP 5130	TU 5330		TP 5130	TU 5330				
Rechte WSP RH Inserts			Linke WSP LH Inserts			mm	mm	mm	mm
11 ER - V - TR 103 / 1.5			11 EL - V - TR 103 / 1.5			1.5	11	0.8	0.9
16 ER - V - TR 103 / 1.5	○		16 EL - V - TR 103 / 1.5			1.5		1.0	1.1
16 ER - V - TR 103 / 2	●		16 EL - V - TR 103 / 2			2	16	1.0	1.3
16 ER - V - TR 103 / 3	●		16 EL - V - TR 103 / 3			3		1.3	1.5
22 ER - V - TR 103 / 4	●		22 EL - V - TR 103 / 4			4	22	1.7	1.9
22 ER - V - TR 103 / 5	●		22 EL - V - TR 103 / 5			5		2.1	2.5
27 ER - V - TR 103 / 6	●		27 EL - V - TR 103 / 6			6	27	2.3	2.7

Außengewinde / External Thread

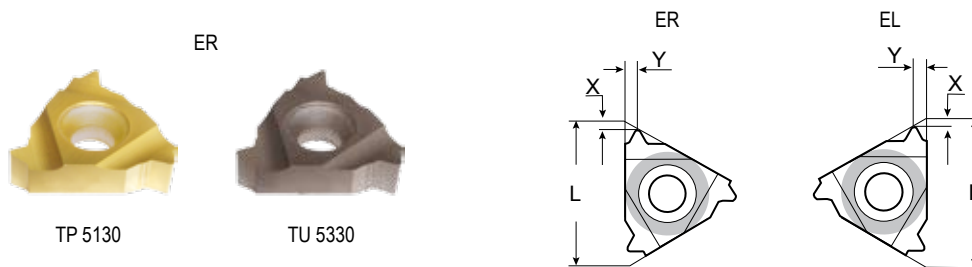
Vollprofil ACME Full Profile ACME



Bezeichnung Part Number	Lager Stock		Bezeichnung Part Number	Lager Stock		Steigung Pitch	L	X	Y
	TP 5130	TU 5330		TP 5130	TU 5330				
Rechte WSP RH Inserts			Linke WSP LH Inserts			TPI	mm	mm	mm
11 ER -V- ACME 16	○		11 EL -V- ACME 16			16	11	0.9	1.0
16 ER -V- ACME 16	○		16 EL -V- ACME 16			16		1.0	1.1
16 ER -V- ACME 14	○		16 EL -V- ACME 14			14		1.0	1.2
16 ER -V- ACME 12	○		16 EL -V- ACME 12			12	16	1.1	1.2
16 ER -V- ACME 10	●		16 EL -V- ACME 10			10		1.3	1.3
16 ER -V- ACME 8	○		16 EL -V- ACME 8			8		1.5	1.5
22 ER -V- ACME 6	●		22 EL -V- ACME 6			6		1.8	2.1
22 ER -V- ACME 5	●		22 EL -V- ACME 5			5	22	2.0	2.3
27 ER -V- ACME 4	○		27 EL -V- ACME 4			4	27	2.7	2.7

Außengewinde / External Thread

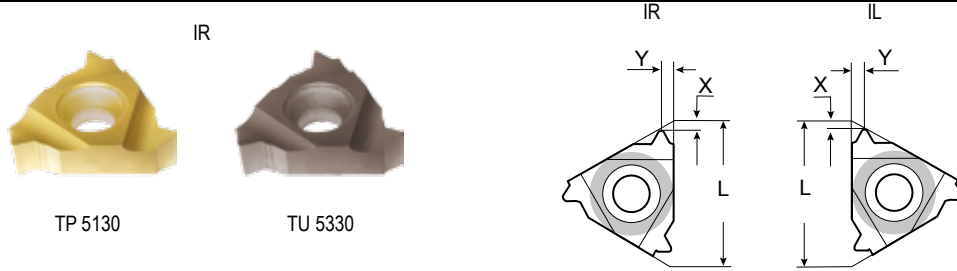
Vollprofil NPT 60° Full Profile NPT 60°



Bezeichnung Part Number	Lager Stock		Bezeichnung Part Number	Lager Stock		Steigung Pitch	L	X	Y
	TP 5130	TU 5330		TP 5130	TU 5330				
Rechte WSP RH Inserts			Linke WSP LH Inserts			TPI	mm	mm	mm
11 ER -V- NPT 27	○		11 EL -V- NPT 27			27		0.7	0.8
11 ER -V- NPT 18	○		11 EL -V- NPT 18			18	11	0.8	1.0
11 ER -V- NPT 14	○		11 EL -V- NPT 14			14		0.8	1.0
16 ER -V- NPT 27	○		16 EL -V- NPT 27			27		0.7	0.8
16 ER -V- NPT 18	●		16 EL -V- NPT 18			18		0.8	1.0
16 ER -V- NPT 14	●		16 EL -V- NPT 14			14	16	0.9	1.2
16 ER -V- NPT 11.5	●		16 EL -V- NPT 11.5			11.5		1.1	1.5
16 ER -V- NPT 8	●		16 EL -V- NPT 8			8		1.3	1.8

Innengewinde / Internal Thread

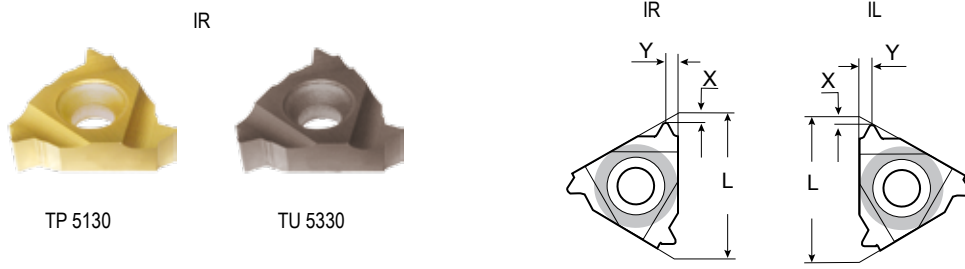
Vollprofil ISO 60° Full Profile ISO 60°



Bezeichnung Part Number	Lager Stock		Bezeichnung Part Number	Lager Stock		Steigung Pitch	L mm	X mm	Y mm
	Rechte WSP RH Inserts	TP 5130 TU 5330		Linke WSP LH Inserts	TP 5130 TU 5330				
06 IR - V - ISO 0.5	○		06 IL - V - ISO 0.5			0.5		0.9	0.5
06 IR - V - ISO 0.75	○		06 IL - V - ISO 0.75			0.75		0.8	0.5
06 IR - V - ISO 1.0	○		06 IL - V - ISO 1.0			1.0	6	0.7	0.6
06 IR - V - ISO 1.25	○		06 IL - V - ISO 1.25			1.25		0.6	0.6
06 IR - V - ISO 1.5	○		06 IL - V - ISO 1.5			1.5		0.5	0.6
08 IR - V - ISO 0.5	○		08 IL - V - ISO 0.5			0.5		0.6	0.5
08 IR - V - ISO 0.75	●		08 IL - V - ISO 0.75			0.75		0.6	0.5
08 IR - V - ISO 1.0	●		08 IL - V - ISO 1.0			1.0	8	0.6	0.6
08 IR - V - ISO 1.25	○		08 IL - V - ISO 1.25			1.25		0.6	0.7
08 IR - V - ISO 1.5	○		08 IL - V - ISO 1.5			1.5		0.6	0.7
08 IR - V - ISO 1.75	○		08 IL - V - ISO 1.75			1.75		0.6	0.8
11 IR - V - ISO 0.35			11 IL - V - ISO 0.35			0.35		0.8	0.3
11 IR - V - ISO 0.4			11 IL - V - ISO 0.4			0.4		0.8	0.4
11 IR - V - ISO 0.45			11 IL - V - ISO 0.45			0.45		0.8	0.4
11 IR - V - ISO 0.5	○		11 IL - V - ISO 0.5			0.5		0.6	0.6
11 IR - V - ISO 0.6	○		11 IL - V - ISO 0.6			0.6		0.6	0.6
11 IR - V - ISO 0.7	○		11 IL - V - ISO 0.7			0.7		0.6	0.6
11 IR - V - ISO 0.75	●		11 IL - V - ISO 0.75			0.75	11	0.6	0.6
11 IR - V - ISO 0.8	○		11 IL - V - ISO 0.8			0.8		0.6	0.6
11 IR - V - ISO 1.0	●		11 IL - V - ISO 1.0			1.0		0.6	0.7
11 IR - V - ISO 1.25	●		11 IL - V - ISO 1.25			1.25		0.8	0.9
11 IR - V - ISO 1.5	●	●	11 IL - V - ISO 1.5			1.5		0.8	1.0
11 IR - V - ISO 1.75	●		11 IL - V - ISO 1.75			1.75		0.9	1.1
11 IR - V - ISO 2.0	●	○	11 IL - V - ISO 2.0			2.0		0.8	0.9
11 IR - V - ISO 2.5	●		11 IL - V - ISO 2.5			2.5		0.8	1.2

Innengewinde / Internal Thread

Vollprofil ISO 60° Full Profile ISO 60°



Bezeichnung Part Number	Lager Stock		Bezeichnung Part Number	Lager Stock		Steigung Pitch	L	X	Y
	TP 5130	TU 5330		TP 5130	TU 5330				
16 IR - V - ISO 0.35			16 IL - V - ISO 0.35			0.35		0.8	0.3
16 IR - V - ISO 0.4			16 IL - V - ISO 0.4			0.4		0.8	0.4
16 IR - V - ISO 0.45			16 IL - V - ISO 0.45			0.45		0.8	0.4
16 IR - V - ISO 0.5	●	●	16 IL - V - ISO 0.5	○		0.5		0.6	0.6
16 IR - V - ISO 0.6	○		16 IL - V - ISO 0.6			0.6		0.6	0.6
16 IR - V - ISO 0.7	●	●	16 IL - V - ISO 0.7			0.7		0.6	0.6
16 IR - V - ISO 0.75	●	●	16 IL - V - ISO 0.75	○		0.75		0.6	0.6
16 IR - V - ISO 0.8	●	●	16 IL - V - ISO 0.8			0.8	16	0.6	0.6
16 IR - V - ISO 1.0	●	●	16 IL - V - ISO 1.0	●		1.0		0.6	0.7
16 IR - V - ISO 1.25	●	●	16 IL - V - ISO 1.25	●		1.25		0.8	0.9
16 IR - V - ISO 1.5	●	●	16 IL - V - ISO 1.5	●		1.5		0.8	1.0
16 IR - V - ISO 1.75	●	●	16 IL - V - ISO 1.75	●		1.75		0.9	1.2
16 IR - V - ISO 2.0	●	●	16 IL - V - ISO 2.0	●	○	2.0		1.0	1.3
16 IR - V - ISO 2.5	●	●	16 IL - V - ISO 2.5	●		2.5		1.1	1.5
16 IR - V - ISO 3.0	●	●	16 IL - V - ISO 3.0	●		3.0		1.1	1.5
16 IR - V - ISO 3.5	●		16 IL - V - ISO 3.5			3.5		1.2	1.7
22 IR - V - ISO 3.5	●	●	22 IL - V - ISO 3.5			3.5		1.6	2.3
22 IR - V - ISO 4.0	●	●	22 IL - V - ISO 4.0			4.0		1.6	2.3
22 IR - V - ISO 4.5	●	●	22 IL - V - ISO 4.5			4.5		1.6	2.4
22 IR - V - ISO 5.0	●	●	22 IL - V - ISO 5.0			5.0	22	1.6	2.3
22 IR - V - ISO 5.5	●	●	22 IL - V - ISO 5.5			5.5		1.6	2.3
22 IR - V - ISO 6.0	●	●	22 IL - V - ISO 6.0			6.0		1.6	2.4
27 IR - V - ISO 5.5	●		27 IL - V - ISO 5.5			5.5		1.6	2.3
27 IR - V - ISO 6.0	●		27 IL - V - ISO 6.0			6.0	27	1.8	2.5

Drehen
Turning

Fräswerkzeuge
Milling Tools

HDS-/VHM-Fräser
HDS-/Solid Carbide
Endmills

Stech- und
Abstechwerkzeuge
Grooving and
Parting off Tools

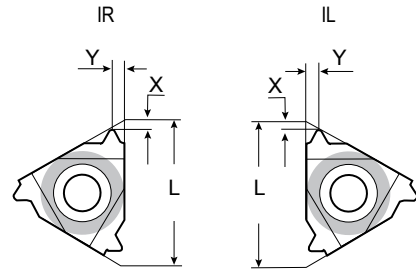
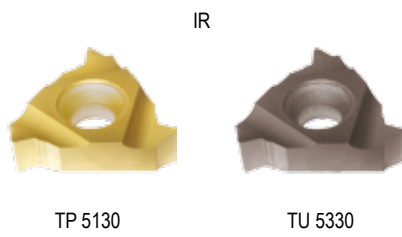
Mini/ Micro
Schneidwerkzeuge
Mini/ Micro Tools

Gewinde-
werkzeuge
Threading Tools

Wendepplattenbohrer
VHM-Bohrer
Indexable Drills
Solid Carbide Drills

Innengewinde / Internal Thread

Vollprofil BSW 55° Full Profile BSW 55°



Bezeichnung Part Number	Lager Stock		Bezeichnung Part Number	Lager Stock		Steigung Pitch TPI	L mm	X mm	Y mm
	TP 5130	TU 5330		Linke WSP LH Inserts	TP 5130				
11 IR - V - BSW 40			11 IL - V - BSW 40			40		0.6	0.6
11 IR - V - BSW 36			11 IL - V - BSW 36			36		0.6	0.6
11 IR - V - BSW 32			11 IL - V - BSW 32			32		0.6	0.6
11 IR - V - BSW 28	○		11 IL - V - BSW 28			28		0.6	0.7
11 IR - V - BSW 26	○		11 IL - V - BSW 26			26		0.7	0.7
11 IR - V - BSW 24	○		11 IL - V - BSW 24			24	11	0.7	0.8
11 IR - V - BSW 22	○		11 IL - V - BSW 22			22		0.8	0.9
11 IR - V - BSW 20	○		11 IL - V - BSW 20			20		0.8	0.9
11 IR - V - BSW 19	●	○	11 IL - V - BSW 19	●		19		0.8	1.0
11 IR - V - BSW 18	○	○	11 IL - V - BSW 18			18		0.8	1.0
11 IR - V - BSW 16	○		11 IL - V - BSW 16			16		0.9	1.1
11 IR - V - BSW 14	●	○	11 IL - V - BSW 14	●		14		0.9	1.1
16 IR - V - BSW 40			16 IL - V - BSW 40			40		0.6	0.6
16 IR - V - BSW 36			16 IL - V - BSW 36			36		0.6	0.6
16 IR - V - BSW 32			16 IL - V - BSW 32			32		0.6	0.6
16 IR - V - BSW 28	○		16 IL - V - BSW 28			28		0.6	0.7
16 IR - V - BSW 26	●		16 IL - V - BSW 26			26		0.7	0.8
16 IR - V - BSW 24	○		16 IL - V - BSW 24			24		0.7	0.8
16 IR - V - BSW 22	○		16 IL - V - BSW 22			22		0.8	0.9
16 IR - V - BSW 20	●		16 IL - V - BSW 20			20		0.8	0.9
16 IR - V - BSW 19	●	●	16 IL - V - BSW 19	●		19	16	0.8	1.0
16 IR - V - BSW 18	●		16 IL - V - BSW 18			18		0.8	1.0
16 IR - V - BSW 16	●		16 IL - V - BSW 16			16		0.9	1.1
16 IR - V - BSW 14	●	●	16 IL - V - BSW 14	●		14		1.0	1.2
16 IR - V - BSW 12	●	○	16 IL - V - BSW 12			12		1.1	1.4
16 IR - V - BSW 11	●	●	16 IL - V - BSW 11	●		11		1.1	1.5
16 IR - V - BSW 10	●		16 IL - V - BSW 10			10		1.1	1.5
16 IR - V - BSW 9	●	●	16 IL - V - BSW 9	●		9		1.2	1.7
16 IR - V - BSW 8	●		16 IL - V - BSW 8			8		1.2	1.5
22 IR - V - BSW 7	○		22 IL - V - BSW 7			7		1.6	2.3
22 IR - V - BSW 6	○		22 IL - V - BSW 6			6	22	1.6	2.3
22 IR - V - BSW 5	○		22 IL - V - BSW 5			5		1.7	2.4
27 IR - V - BSW 4.5	●		27 IL - V - BSW 4.5			4.5	27	1.8	2.6
27 IR - V - BSW 4	●		27 IL - V - BSW 4			4		2.0	2.9

Innengewinde / Internal Thread

Vollprofil UN 60° Full Profile UN 60°



Bezeichnung Part Number	Lager Stock		Bezeichnung Part Number	Lager Stock		Steigung Pitch	L	X	Y
	TP 5130	TU 5330		TP 5130	TU 5330				
Rechte WSP RH Inserts			Linke WSP LH Inserts			TPI	mm	mm	mm
11 IR - V - UN 40			11 IL - V - UN 40			40		0.6	0.6
11 IR - V - UN 36			11 IL - V - UN 36			36		0.6	0.6
11 IR - V - UN 32	○		11 IL - V - UN 32			32		0.6	0.6
11 IR - V - UN 28	○		11 IL - V - UN 28			28		0.6	0.7
11 IR - V - UN 27	○		11 IL - V - UN 27			27		0.7	0.8
11 IR - V - UN 24	○		11 IL - V - UN 24			24	11	0.7	0.8
11 IR - V - UN 20	○		11 IL - V - UN 20			20		0.8	0.9
11 IR - V - UN 18	●		11 IL - V - UN 18			18		0.8	1.0
11 IR - V - UN 16	●		11 IL - V - UN 16			16		0.9	1.1
11 IR - V - UN 14	●		11 IL - V - UN 14			14		0.9	1.1
16 IR - V - UN 40			16 IL - V - UN 40			40		0.6	0.6
16 IR - V - UN 36			16 IL - V - UN 36			36		0.6	0.6
16 IR - V - UN 32	○		16 IL - V - UN 32			32		0.6	0.6
16 IR - V - UN 28	●		16 IL - V - UN 28			28		0.6	0.7
16 IR - V - UN 27	○		16 IL - V - UN 27			27		0.7	0.8
16 IR - V - UN 24	●		16 IL - V - UN 24			24		0.7	0.8
16 IR - V - UN 20	●		16 IL - V - UN 20			20		0.8	0.9
16 IR - V - UN 18	●		16 IL - V - UN 18			18	16	0.8	1.0
16 IR - V - UN 16	●		16 IL - V - UN 16			16		0.9	1.1
16 IR - V - UN 14	●		16 IL - V - UN 14			14		0.9	1.2
16 IR - V - UN 13	○		16 IL - V - UN 13			13		1.0	1.3
16 IR - V - UN 12	●		16 IL - V - UN 12			12		1.1	1.4
16 IR - V - UN 11	●		16 IL - V - UN 11			11		1.1	1.5
16 IR - V - UN 10	○		16 IL - V - UN 10			10		1.1	1.5
16 IR - V - UN 9	●		16 IL - V - UN 9			9		1.2	1.7
16 IR - V - UN 8	●		16 IL - V - UN 8			8		1.1	1.5
22 IR - V - UN 7	○		22 IL - V - UN 7			7		1.6	2.3
22 IR - V - UN 6	○		22 IL - V - UN 6			6	22	1.6	2.3
22 IR - V - UN 5	○		22 IL - V - UN 5			5		1.6	2.3
27 IR - V - UN 4.5	○		27 IL - V - UN 4.5			4.5		1.7	2.4
27 IR - V - UN 4	○		27 IL - V - UN 4			4	27	1.8	2.7

Drehen
Turning

Fräswerkzeuge
Milling Tools

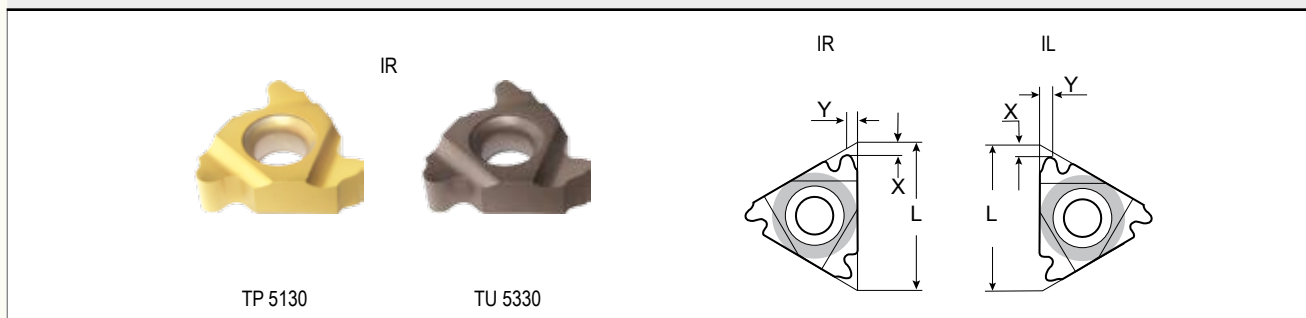
HDS-/VHM-Fräser
HDS-/Solid Carbide
Endmills

Stech- und
Abstechwerkzeuge
Grooving and
Parting off Tools

Mini/ Micro
Schneidwerkzeuge
Mini/ Micro Tools

Gewinde-
werkzeuge
Threading Tools

Wendepplattenbohrer
VHM-Bohrer
Indexable Drills
Solid Carbide Drills

Innengewinde / Internal Thread
Vollprofil RD DIN 405 Full Profile RD DIN 405


Bezeichnung Part Number	Lager Stock		Bezeichnung Part Number	Lager Stock		Steigung Pitch	L	X	Y
	TP 5130	TU 5330		TP 5130	TU 5330				
Rechte WSP RH Inserts	TP 5130	TU 5330	Linke WSP LH Inserts	TP 5130	TU 5330	TPI	mm	mm	mm
16 IR - V - RD 405 / 10	○		16 IL - V - RD 405 / 10			10		1.1	1.2
16 IR - V - RD 405 / 8	●		16 IL - V - RD 405 / 8			8	16	1.4	1.4
16 IR - V - RD 405 / 6	○		16 IL - V - RD 405 / 6			6		1.4	1.5
22 IR - V - RD 405 / 6	○		22 IL - V - RD 405 / 6			6	22	1.5	1.7
22 IR - V - RD 405 / 4	○		22 IL - V - RD 405 / 4			4		2.2	2.3
27 IR - V - RD 405 / 4	○		27 IL - V - RD 405 / 4			4	27	2.2	2.3

Innengewinde / Internal Thread
Vollprofil TR DIN 103 Full Profile TR DIN 103


Bezeichnung Part Number	Lager Stock		Bezeichnung Part Number	Lager Stock		Steigung Pitch	L	X	Y
	TP 5130	TU 5330		TP 5130	TU 5330				
Rechte WSP RH Inserts	TP 5130	TU 5330	Linke WSP LH Inserts	TP 5130	TU 5330	TPI	mm	mm	mm
11 IR - V - TR 103 / 1.5			11 IL - V - TR 103 / 1.5			1.5	11	0.8	0.9
16 IR - V - TR 103 / 1.5	○		16 IL - V - TR 103 / 1.5			1.5		1.0	1.1
16 IR - V - TR 103 / 2	●		16 IL - V - TR 103 / 2			2	16	1.0	1.3
16 IR - V - TR 103 / 3	●		16 IL - V - TR 103 / 3			3		1.3	1.5
22 IR - V - TR 103 / 4	●		22 IL - V - TR 103 / 4			4	22	1.7	1.9
22 IR - V - TR 103 / 5	●		22 IL - V - TR 103 / 5	○		5		2.1	2.5
27 IR - V - TR 103 / 6	●		27 IL - V - TR 103 / 6			6	27	2.3	2,7

Innengewinde / Internal Thread

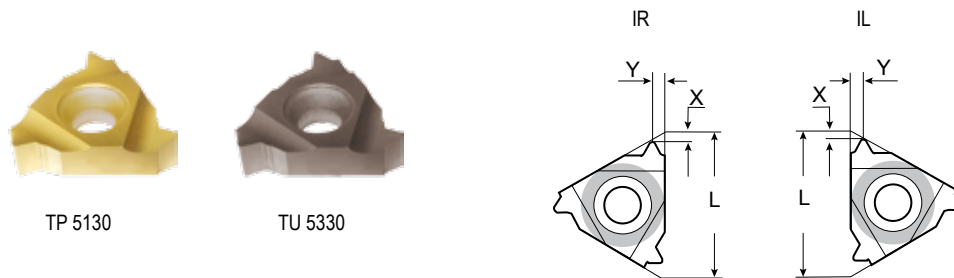
Vollprofil ACME Full Profile ACME



Bezeichnung Part Number	Lager Stock		Bezeichnung Part Number	Lager Stock		Steigung Pitch	L	X	Y
	TP 5130	TU 5330		TP 5130	TU 5330				
Rechte WSP RH Inserts			Linke WSP LH Inserts			TPI	mm	mm	mm
11 IR - V - ACME16	○		11 IL - V - ACME16			16	11	0.9	1.0
16 IR - V - ACME16	○		16 IL - V - ACME16			16		0.9	1.0
16 IR - V - ACME14	○		16 IL - V - ACME14			14		1.0	1.2
16 IR - V - ACME12	○		16 IL - V - ACME12			12	16	1.1	1.2
16 IR - V - ACME10	●		16 IL - V - ACME10			10		1.3	1.3
16 IR - V - ACME8	○		16 IL - V - ACME8			8		1.5	1.5
22 IR - V - ACME6	○		22 IL - V - ACME6			6		1.8	2.1
22 IR - V - ACME5	●		22 IL - V - ACME5			5	22	2.0	2.3
27 IR - V - ACME 4	○		27 IL - V - ACME 4			4	27	2.3	2.6

Innengewinde / Internal Thread

Vollprofil NPT 60° Full Profile NPT 60°

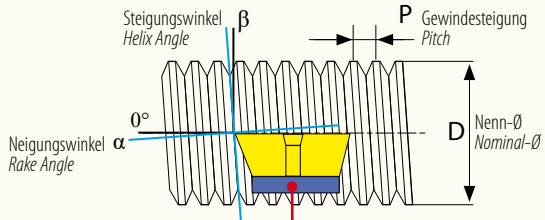


Bezeichnung Part Number	Lager Stock		Bezeichnung Part Number	Lager Stock		Steigung Pitch	L	X	Y
	TP 5130	TU 5330		TP 5130	TU 5330				
Rechte WSP RH Inserts			Linke WSP LH Inserts			TPI	mm	mm	mm
11 IR - V - NPT 27	●		11 IL - V - NPT 27			27		0.7	0.8
11 IR - V - NPT 18	●		11 IL - V - NPT 18			18	11	0.8	1.0
11 IR - V - NPT 14	●		11 IL - V - NPT 14			14		0.8	1.0
16 IR - V - NPT 27	○		16 IL - V - NPT 27			27		0.7	0.8
16 IR - V - NPT 18	●	○	16 IL - V - NPT 18			18		0.8	1.0
16 IR - V - NPT 14	●		16 IL - V - NPT 14			14	16	0.9	1.2
16 IR - V - NPT 11.5	●		16 IL - V - NPT 11.5			11.5		1.1	1.5
16 IR - V - NPT 8	●	○	16 IL - V - NPT 8			8		1.3	1.8

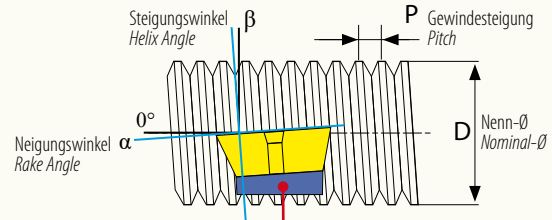
Gewindedrehen - Technische Information Threading - Technical Information

Zugunsten einer größtmöglichen Profildgenauigkeit, bester Oberflächengüte sowie einem gleichmäßigen Verschleiß und der damit verbundenen längeren Standzeit der Wendeschneidplatte, muss der **Wendepplatten-Neigungswinkel "α"** mit dem **Gewinde-Steigungswinkel "β"** möglichst exakt übereinstimmen.

In favor of high level on accuracy of the profile, best surface finish as well as simultaneously wear and longer tool life of the insert, the rake angle "α" of the insert and the helix angle "β" of the thread have to agree.



Unterlegplatte mit falschem Neigungswinkel
Shim with incorrect rake angle

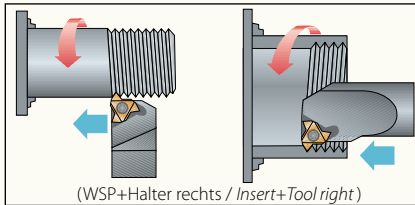


Unterlegplatte mit richtigem Neigungswinkel
Shim with correct rake angle

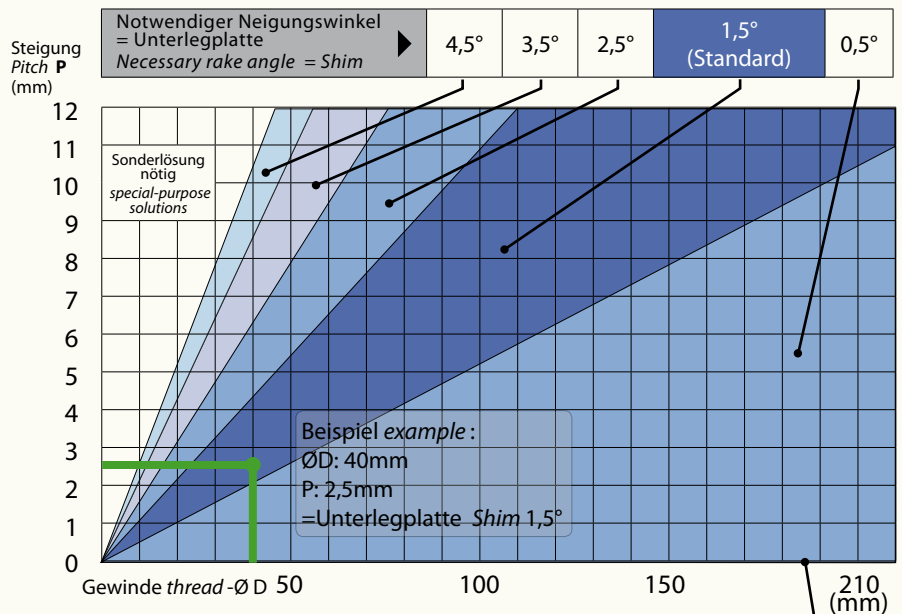
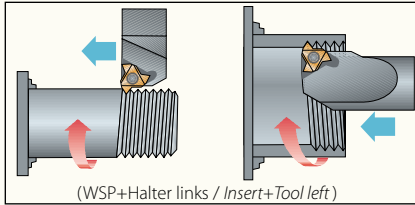
Steigungswinkeldiagramm zum Austausch der Unterlegplatten für metrisches Gewinde

Vorschub in Richtung Futter Movement to Chuck

Rechtsgewinde Right Thread:

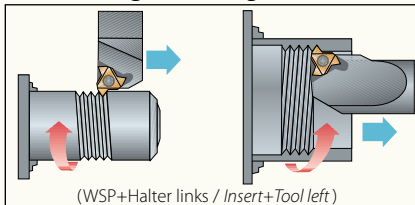


Linksgewinde Left Thread:

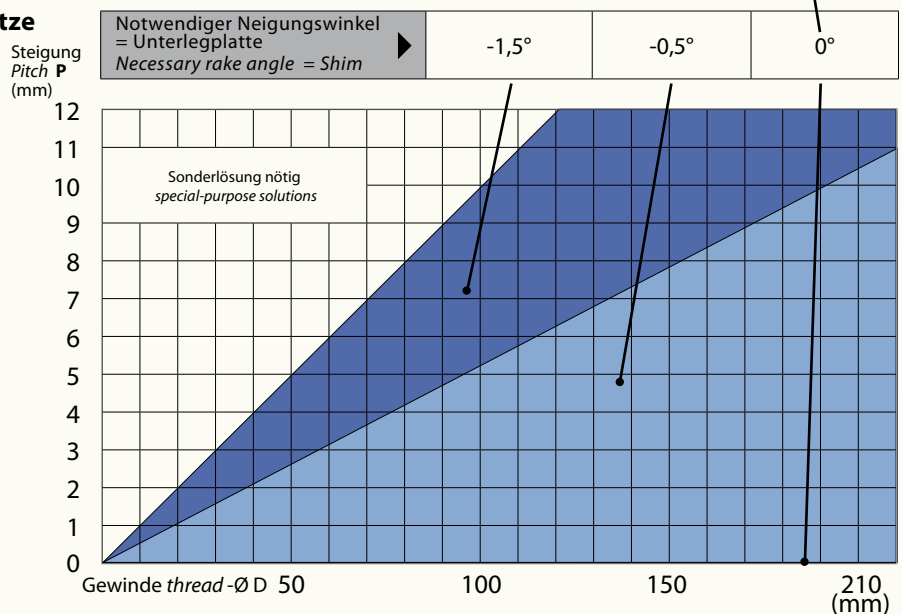
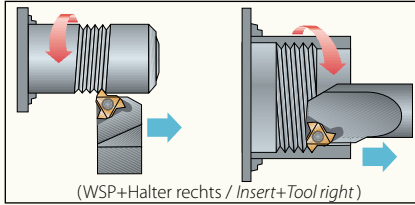


Vorschub in Richtung Drehbankspitze Movement to Center

Rechtsgewinde Right Thread:



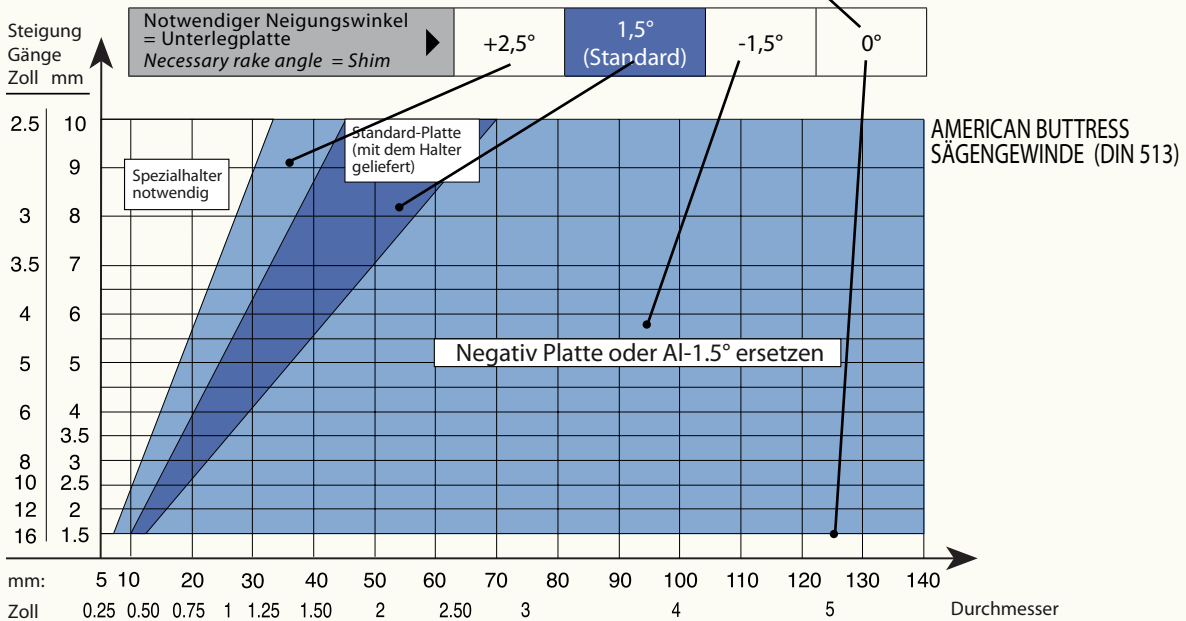
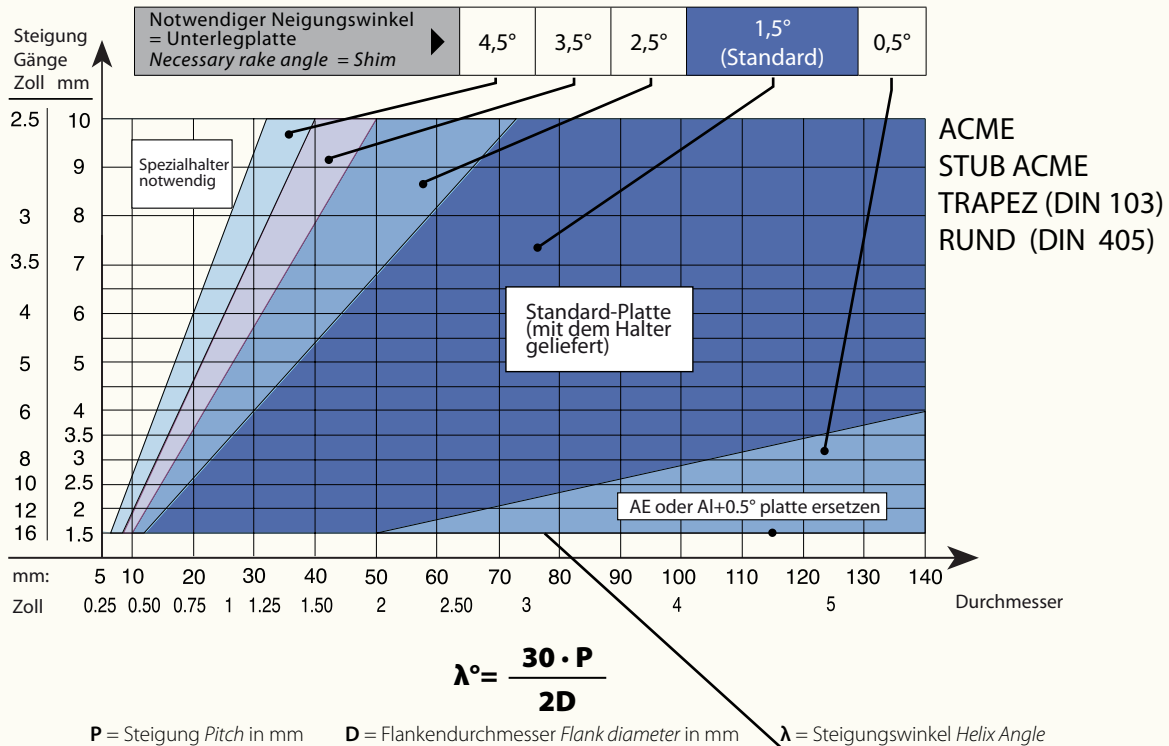
Linksgewinde Left Thread:



$$\lambda^\circ = \frac{20 \cdot P}{D} \quad \text{tg } \lambda = \frac{P}{3,14 \cdot D}$$

Gewindedrehen - Technische Information Threading - Technical Information

Steigungswinkeldiagramm zum Austausch der Unterlegplatten



Richtwerte für die Anzahl der Gewindedurchgänge * Guide Lines for the Number of Threading Passes *

Steigung Pitch	mm	0.5	0.75	1.0	1.25	1.5	1.75	2.0	2.5	3.0	4.0	5.0	6.0
	G/1" TPI	48	32	24	20	16	14	12	10	8	6	5	4
Zahl der Durchgänge No. of passes		4-6	4-7	4-8	5-9	6-10	7-12	7-12	8-14	10-16	11-18	12-20	12-20

*abhängig von Werkstoff und Schnittbedingungen depends on material and cutting conditions

Drehen
Turning

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HDS-/Solid Carbide
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Schneidwerkzeuge
Mini/ Micro Tools

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werkzeuge
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VHM-Bohrer
Indexable Drills
Solid Carbide Drills

Unterschiede zwischen Voll- und Teilprofil-Gewindeschneidplatten Differences between Full and Partial Profile Threading Inserts

Vollprofil - Gewindeschneidplatte



Full Profile - Threading Insert

Vorteile / Advantages

Das gesamte Gewindeprofil einschließlich Gewindespitze wird normhaltig bearbeitet - für Serienfertigung geeignet.

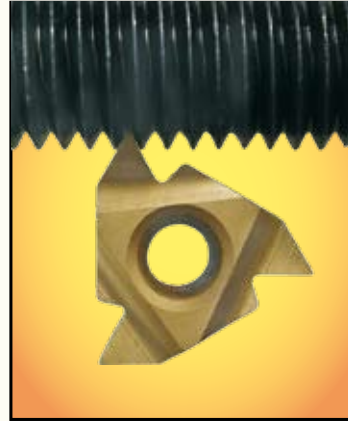
The complete thread profile including tip of thread is machined complying with the norm - suitable for series production.

Die Gewindespitzen sind gratfrei.
The tips of thread are burr-free.

Nachteile / Disadvantages

Für jede Steigung wird eine andere Wendeschneidplatte benötigt.
For every pitch a different insert is required.

Teilprofil - Gewindeschneidplatte



Partial Profile - Threading Insert

Vorteile / Advantages

Mit wenigen Wendeschneidplatten können die meisten Steigungen gefertigt werden.

With only a few inserts it is possible to machine most of the different pitches.

Nachteile / Disadvantages

Das Gewindeprofil weicht geringfügig von der Norm ab.

The profile of thread differs slightly from the norm.

Die Gewindespitzen müssen häufig nachträglich entgratet werden.
The tips of thread often have to be de-burred.

Schnittdaten-Empfehlungen zum Gewindedrehen Cutting Data Recommendations for Threading

	Werkstückwerkstoff Material	Festigkeit Tensile strength	Schnittgeschwindigkeiten / Cutting speeds v_c [m/min]	
			TP 5130 (P/M30/K20C)	TU 5330 (P30C)
A (P)	unlegierter Stahl mild steel	< 650 N/mm ²	70 - 200	70 - 220
		650 - 850 N/mm ²	70 - 160	70 - 160
R (M)	rostfreier Stahl stainless steel	700 - 1000 N/mm ²	90 - 160	90 - 180
		1000 - 1300 N/mm ²	70 - 120	70 - 120
F (K)	Grauguss grey cast iron	500 - 700 N/mm ² (austenitisch /austenitic)	80 - 160	50 - 240
		500 - 900 N/mm ² (ferritisch / ferritic)	100 - 160	50 - 200
N	Aluminium und Kupferlegierungen aluminium and copper alloys	110 - 150 HB	150 - 220	60 - 230
		> 150 HB	100 - 160	60 - 160
		50 - 160 HB	80 - 360	100 - 500


Symbolerklärung Explanation of Symbols

M Metrisches ISO-Regelgewinde DIN 13
ISO Metric Coarse Thread DIN 13

**Typ
Type
N** Für universellen Einsatz
For universal use

SL
 Sackloch
Blind Hole

vapor. Vaporisiert
Steam treatment

DL
 Durchgangsloch
Through Hole

Schnittdaten-Richtwerte (bei Verwendung von Emulsion / Schneidöl) Cutting Data Recommendations (when using emulsion / cutting oil)

	Werkstückwerkstoff Material	Festigkeit Tensile strength	Schnittgeschwindigkeiten / Cutting feeds v_c [m/min]			
			JD 4126	JD 4226		
A	Unlegierter Stahl Mild steel	< 650 N/mm ²	08 - 12	10 - 15		
			650 - 850 N/mm ²	08 - 10	10 - 12	
		Legierter Stahl Alloyed steel		700 - 1000 N/mm ²	06 - 08	08 - 10
			1000 - 1300 N/mm ²			
	R	Rostfreier Stahl Stainless steel	500 - 700 N/mm ² (austenitisch /austenitic)	05 - 06	06 - 08	
				500 - 900 N/mm ² (ferritisch / ferritic)	05 - 06	06 - 08
F			Grauguss Grey cast iron		110 - 150 HB	10 - 12
				> 150 HB		08 - 10
	N	Aluminium Aluminium				12 - 15
				Kupferlegierungen Copper alloys		

Drehen
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HDS-/Solid Carbide
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Mini/ Micro
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Mini/ Micro Tools

Gewinde-
werkzeuge
Threading tools

Wendepplattenbohrer
VHM-Bohrer
Indexable Drills
Solid Carbide Drills

Maschinengewindebohrer / Machine Taps

 Typ
Type
UNI

 DIN
371
376

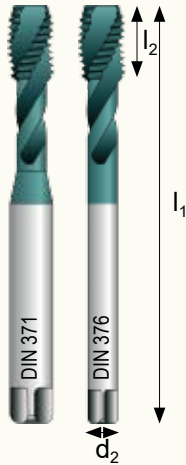
M


 Form C
2-3

 Tol.
6 H

HSS-E

vapor.



Bezeichnung Part Number	DIN	Nennmaß Size	Lager Stock	Maße [mm] Dimensions					Z
				Steigung Pitch	l_1	l_2	d_2	a	
JD 4126 M3	371	M3	●	0.50	56	5	3.50	2.7	3
JD 4126 M4		M4	●	0.70	63	7	4.50	3.4	
JD 4126 M5		M5	●	0.80	70	8	6.00	4.9	
JD 4126 M6		M6	●	1.00	80	10	6.00	4.9	
JD 4126 M8		M8	●	1.25	90	13	8.00	6.2	
JD 4126 M10		M10	●	1.50	100	15	10.00	8.0	
JD 4126 M12	376	M12	●	1.75	110	18	9.00	7.0	4
JD 4126 M14		M14	○	2.00	110	20	11.00	9.0	
JD 4126 M16		M16	○	2.00	110	20	12.00	9.0	

Maschinengewindebohrer / Machine Taps

 Typ
Type
VA

 DIN
371
376

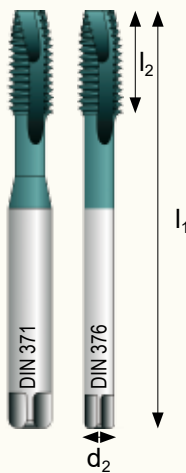
M


 Form C
3-5

 Tol.
6 H

HSS-E

vapor.



Bezeichnung Part Number	DIN	Nennmaß Size	Lager Stock	Maße [mm] Dimensions					Z
				Steigung Pitch	l_1	l_2	d_2	a	
JD 4226 M3	371	M3	●	0.50	56	9	3.50	2.7	3
JD 4226 M4		M4	●	0.70	63	12	4.50	3.4	
JD 4226 M5		M5	●	0.80	70	13	6.00	4.9	
JD 4226 M6		M6	●	1.00	80	15	6.00	4.9	
JD 4226 M8		M8	●	1.25	90	18	8.00	6.2	
JD 4226 M10		M10	●	1.50	100	20	10.00	8.0	
JD 4226 M12	376	M12	●	1.75	110	23	9.00	7.0	4
JD 4226 M14		M14	○	2.00	110	25	11.00	9.0	
JD 4226 M16		M16	●	2.00	110	25	12.00	9.0	