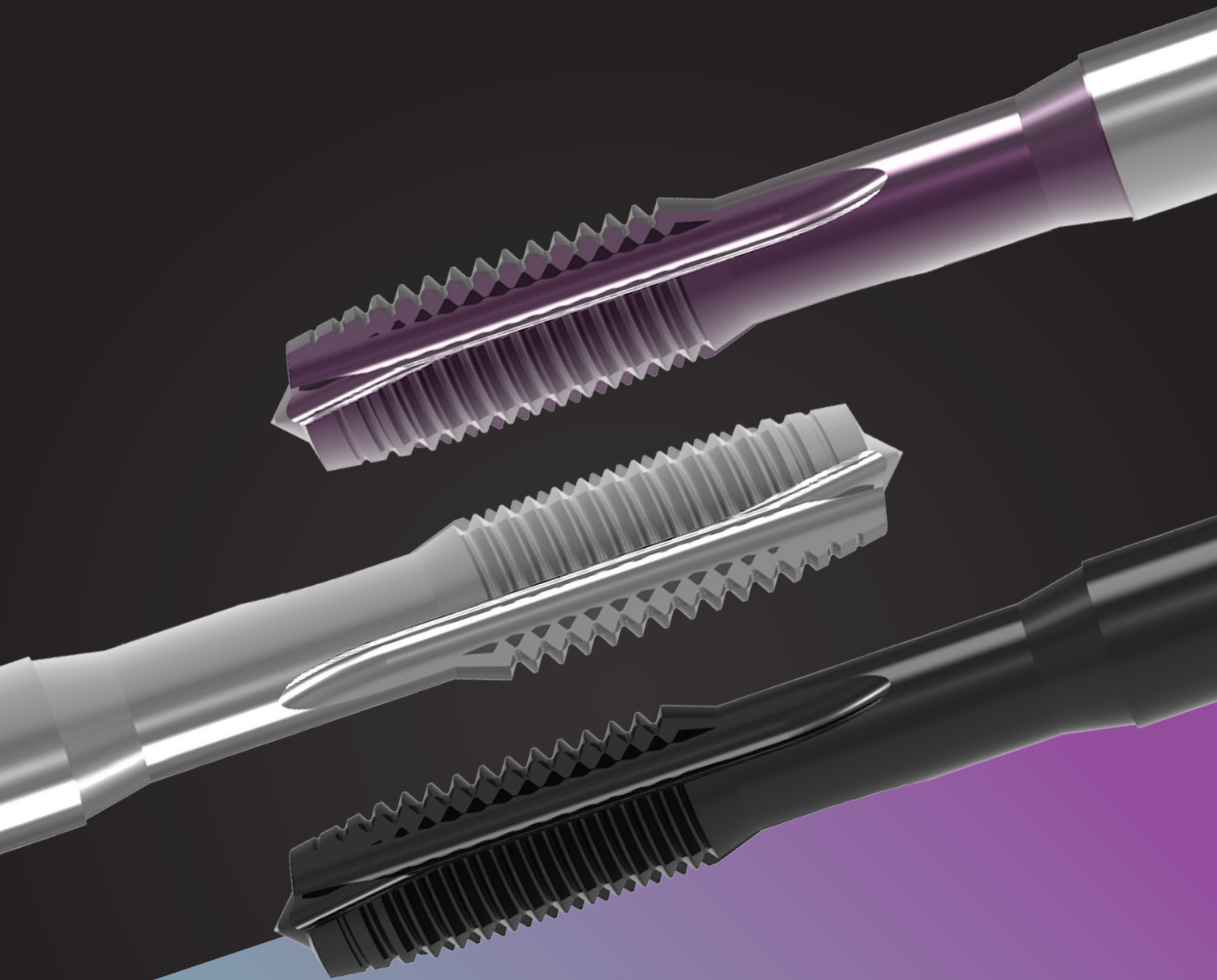




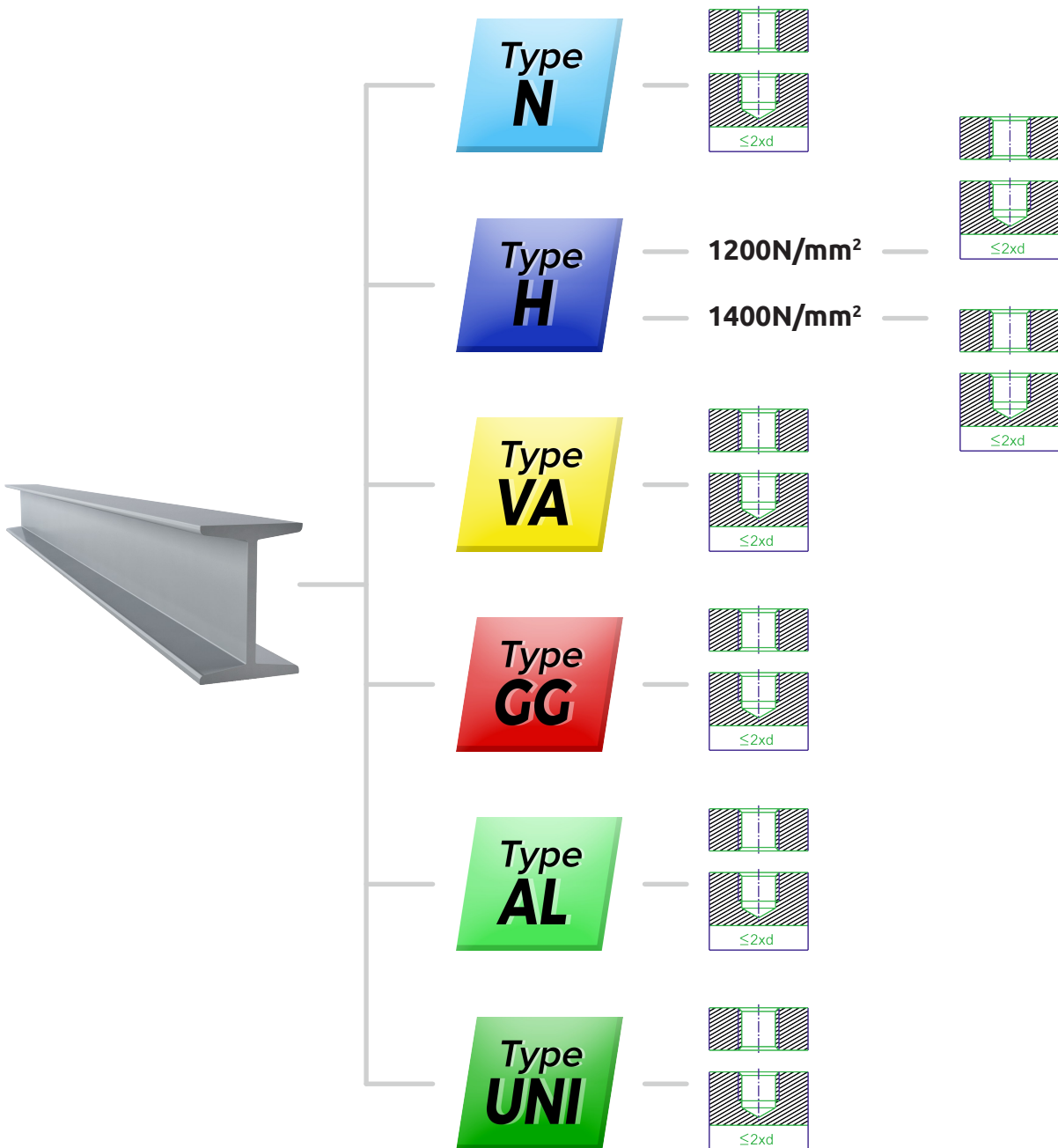
**JUNGMANN<sup>®</sup>  
WERKZEUGE**



## **MASCHINENGEWINDEBOHRER**

*Machine taps / Machos de máquina*

# JW SMART GUIDE



Type  
**N**








































# MASCHINENGEWINDEBOHRER

Machine taps / Machos de máquina



































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100-100		DIN 371	HSSE *	ISO 2 6H	Form B 3,5-6			M2-M10	8
100-100		DIN 371	HSSE *	ISO 3 6C	Form B 3,5-6			M3-M10	8
100-101		DIN 371	HSSE *	ISO 2 6H	Form B 3,5-6		OX	M3-M10	8
100-104		DIN 371	HSSE *	ISO 2 6H	Form B 3,5-6		TiAIN	M3-M10	8
100-400		DIN 371	HSSE *	ISO 2 6H	Form C 2-3			M3-M10	9
200-100		DIN 376	HSSE *	ISO 2 6H	Form B 3,5-6			M3-M36	10
200-100		DIN 376	HSSE *	ISO 3 6C	Form B 3,5-6			M12-M20	10
200-101		DIN 376	HSSE *	ISO 2 6H	Form B 3,5-6		OX	M3-M36	10
200-104		DIN 376	HSSE *	ISO 2 6H	Form B 3,5-6		TiAIN	M12-M20	10
200-400		DIN 376	HSSE *	ISO 2 6H	Form C 2-3			M3-M52	10
100-500		DIN 371	HSSE *	ISO 2 6H	Form C 2-3			M2-M10	11
100-500		DIN 371	HSSE *	ISO 3 6C	Form C 2-3			M3-M10	11
100-501		DIN 371	HSSE *	ISO 2 6H	Form C 2-3		OX	M3-M10	11
100-504		DIN 371	HSSE *	ISO 2 6H	Form C 2-3		TiAIN	M3-M10	11
200-500		DIN 376	HSSE *	ISO 2 6H	Form C 2-3			M3-M36	12
200-500		DIN 376	HSSE *	ISO 3 6C	Form C 2-3			M12-M20	12
200-501		DIN 376	HSSE *	ISO 2 6H	Form C 2-3		OX	M4-M36	12
200-504		DIN 376	HSSE *	ISO 2 6H	Form C 2-3		TiAIN	M12-M20	12
300-100		DIN 374	HSSE *	ISO 2 6H	Form B 3,5-6			M4-M36	13-14
300-400		DIN 374	HSSE *	ISO 2 6H	Form C 2-3			M4-M36	13-14
300-500		DIN 374	HSSE *	ISO 2 6H	Form C 2-3			M4-M36	15-16
203-400		DIN 5156	HSSE *		Form C 2-3			G1/8"-G2"	17

203-100		DIN 5156	HSSE *	Form B 3,5-6			G1/8"-G2" 17
203-102		DIN 5156	HSSE *	Form B 3,5-6		TiN	G1/8"-G2" 17
203-500		DIN 5156	HSSE *	Form C 2-3	 RSP 35°		G1/8"-G1 1/2" 18
203-502		DIN 5156	HSSE *	Form C 2-3	 RSP 35°		G1/8"-G1 1/2" 18
101-400		≅DIN 371	HSSE *	2B Form C 2-3			UNC5-3/8 19
101-100		≅DIN 371	HSSE *	2B Form B 3,5-6			UNC5-3/8 19
101-500		≅DIN 371	HSSE *	2B Form C 2-3	 RSP 35°		UNC5-3/8 19
201-400		≅DIN 376	HSSE *	2B Form C 2-3			UNC7/16-1 1/8 20
201-100		≅DIN 376	HSSE *	2B Form B 3,5-6			UNC7/16-1 1/8 20
201-500		≅DIN 376	HSSE *	2B Form C 2-3	 RSP 35°		UNC7/16-1 20
302-400		≅DIN 374	HSSE *	2B Form C 2-3			UNF5-1 21
302-100		≅DIN 374	HSSE *	2B Form B 3,5-6			UNF5-1 21
302-500		≅DIN 374	HSSE *	2B Form C 2-3	 RSP 35°		UNF5-1 21
704-400		FACTORY STANDARD	HSSE *	Form C 2-3			NPT1/8-2 22
705-400		DIN 40 433	HSSE *	Form C 2-3			PG7-PG29 22



100-121		DIN 371	HSSE *	ISO 2 6H	Form B 3,5-6		OX	M3-M10	23
100-123		DIN 371	HSSE *	ISO 2 6H	Form B 3,5-6		TiCN	M3-M10	23
200-121		DIN 376	HSSE *	ISO 2 6H	Form B 3,5-6		OX	M3-M30	24
200-123		DIN 376	HSSE *	ISO 2 6H	Form B 3,5-6		TiCN	M3-M30	24
100-521		DIN 371	HSSE *	ISO 2 6H	Form C 2-3 RSP 40°		OX	M3-M10	25
100-523		DIN 371	HSSE *	ISO 2 6H	Form C 2-3 RSP 40°		TiCN	M3-M10	25
200-521		DIN 376	HSSE *	ISO 2 6H	Form C 2-3 RSP 40°		OX	M3-M30	26
200-523		DIN 376	HSSE *	ISO 2 6H	Form C 2-3 RSP 40°		TiCN	M3-M30	26
100-144		DIN 371	HSSE PM ****	ISO 2 6H	Form B 3,5-6		FNT	M3-M10	27
100-564		DIN 371	HSSE PM ****	ISO 2 6H	Form C 2-3 RSP 40°		FNT	M3-M10	27
100-544		DIN 371	HSSE PM ****	ISO 2 6H	Form D 3,5-5 RSP 15°		FNT	M3-M10	27
200-144		DIN 376	HSSE *	ISO 2 6H	Form B 3,5-6		FNT	M12	27
200-564		DIN 376	HSSE *	ISO 2 6H	Form C 2-3 RSP 40°		FNT	M12	27
200-544		DIN 376	HSSE *	ISO 2 6H	Form D 3,5-5 RSP 15°		FNT	M12	27

100-255		DIN 371	HSSE PM ****	ISO 2 6H	Form B 3,5-6		HL	M3-M10	28
100-201		DIN 371	HSSE *	ISO 2 6H	Form B 3,5-6		OX	M3-M10	28
100-203		DIN 371	HSSE *	ISO 2 6H	Form B 3,5-6		TiCN	M3-M10	28
200-255		DIN 376	HSSE PM ****	ISO 2 6H	Form B 3,5-6		HL	M12-M20	29
200-201		DIN 376	HSSE *	ISO 2 6H	Form B 3,5-6		OX	M3-M30	29
200-203		DIN 376	HSSE *	ISO 2 6H	Form B 3,5-6		TiCN	M12-M30	29
100-655		DIN 371	HSSE PM ****	ISO 2 6H	Form C 2-3	RSP 40° 	HL	M3-M10	30
100-601		DIN 371	HSSE *	ISO 2 6H	Form C 2-3	RSP 40° 	OX	M3-M10	30
100-603		DIN 371	HSSE *	ISO 2 6H	Form C 2-3	RSP 40° 	TiCN	M3-M10	30
200-655		DIN 376	HSSE PM ****	ISO 2 6H	Form C 2-3	RSP 40° 	HL	M12-M20	31
200-601		DIN 376	HSSE *	ISO 2 6H	Form C 2-3	RSP 40° 	OX	M3-M30	31
200-603		DIN 376	HSSE *	ISO 2 6H	Form C 2-3	RSP 40° 	TiCN	M12-M30	31
203-201		DIN 5156	HSSE *		Form B 3,5-6		OX	G1/8"-G1 1/2"	32
203-202		DIN 5156	HSSE *		Form B 3,5-6		TiN	G1/8"-G1 1/2"	32
203-601		DIN 5156	HSSE *		Form C 2-3	RSP 35° 	OX	G1/8"-G1 1/2"	33
203-602		DIN 5156	HSSE *		Form C 2-3	RSP 35° 	TiN	G1/8"-G1 1/2"	33

100-423		DIN 371	HSSE *	ISO 2 6H	Form C 2-3			TiCN	M3-M10	34
200-423		DIN 376	HSSE *	ISO 2 6H	Form C 2-3			TiCN	M3-M30	35

100-126		DIN 371	HSSE *	ISO 2 6H	Form B 3.5-6			ALS	M3-M10	36
100-306		DIN 371	HSSE *	ISO 2 6H	Form B 3.5-6			ALS	M3-M10	36
200-126		DIN 376	HSSE *	ISO 2 6H	Form B 3.5-6			ALS	M12-M20	36
200-306		DIN 376	HSSE *	ISO 2 6H	Form B 3.5-6			ALS	M12-M20	36
100-526		DIN 371	HSSE *	ISO 2 6H	Form C 2-3		RSP 40° 	ALS	M3-M10	37
100-706		DIN 371	HSSE *	ISO 2 6H	Form C 2-3		RSP 45° 	ALS	M3-M10	37
200-526		DIN 376	HSSE *	ISO 2 6H	Form C 2-3		RSP 40° 	ALS	M12-M20	37
200-706		DIN 376	HSSE *	ISO 2 6H	Form C 2-3		RSP 45° 	ALS	M12-M20	37

100-272		DIN 371	HSSE *	ISO 2 6H	Form B 3,5-6		TiN	M3-M10	38
200-272		DIN 376	HSSE *	ISO 2 6H	Form B 3,5-6		TiN	M12-M20	38
100-295		DIN 371	HSSE PM ****	ISO 2 6HX	Form B 3,5-6		HL	M3-M10	39
100-295		DIN 371	HSSE PM ****	ISO 3 6CX	Form B 3,5-6		HL	M2-M10	39
200-295		DIN 376	HSSE PM ****	ISO 2 6HX	Form B 3,5-6		HL	M12-M20	39
200-295		DIN 376	HSSE PM ****	ISO 3 6CX	Form B 3,5-6		HL	M12-M30	39
100-672		DIN 371	HSSE *	ISO 2 6H	Form C 2-3	RSP 35° 	TiN	M3-M10	40
200-672		DIN 376	HSSE *	ISO 2 6H	Form C 2-3	RSP 35° 	TiN	M12-M20	40
100-695		DIN 371	HSSE PM ****	ISO 2 6HX	Form C 2-3	RSP 50° 	HL	M3-M10	41
100-695		DIN 371	HSSE PM ****	ISO 3 6CX	Form C 2-3	RSP 50° 	HL	M2-M10	41
200-695		DIN 376	HSSE PM ****	ISO 2 6HX	Form C 2-3	RSP 50° 	HL	M12-M20	41
200-695		DIN 376	HSSE PM ****	ISO 3 6CX	Form C 2-3	RSP 50° 	HL	M12-M30	41
300-272		DIN 374	HSSE *	ISO 2 6H	Form B 3,5-6		TiN	M6-M20	42
300-672		DIN 374	HSSE *	ISO 2 6H	Form C 2-3	RSP 35° 	TiN	M6-M20	42
300-295		DIN 374	HSSE PM ****	ISO 2 6HX	Form B 3,5-6		HL	M8-M20	43
300-695		DIN 374	HSSE PM ****	ISO 2 6HX	Form C 2-3	RSP 50° 	HL	M8-M20	43



Type  
**N**

## GEWINDEFORMER

Forming taps / Machos de Laminación



**JUNGMANN**  
WERKZEUGE

800-902		DIN 2174	HSSE *	ISO 2 6HX	Form C 2-3		TiN	M3-M12	44
800-902		DIN 2174	HSSE *	ISO 3 6GX	Form C 2-3		TiN	M3-M12	44
800-922		DIN 2174	HSSE *	ISO 2 6HX	Form C 2-3		TiN	M3-M12	44
800-922		DIN 2174	HSSE *	ISO 3 6GX	Form C 2-3		TiN	M3-M12	44

Type  
**N**

## HANDGEWINDEBOHRER

Hand taps / Machos de Mano

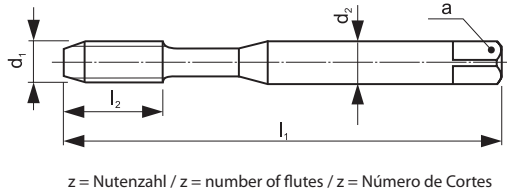
400-070		DIN 352	HSS	ISO 2 6H	Form C 2-3			M3-M52	45
400-091		DIN 352	HSSE *	ISO 2 6H	Form C 2-3		OX	M3-M20	46
400-080		DIN 2181	HSS	ISO 2 6H	Form C 2-3			M4,5-M52	47-49
403-080		DIN 5157	HSS		Form C 2-3			G1/8"-G2"	50
401-070		≅DIN 352	HSS	2B	Form C 2-3			UNC#5-UNC#1	51
402-080		≅DIN 2181	HSS	2B	Form C 2-3			UNC#5-UNC#1	52

Type  
**N**

## SCHNEIDEISEN

Circular screwing dies / Terrajas

090-010		DIN EN 22 568	HSS	ISO 6g	1,5			M2-M36	53-54
093-010		DIN EN 24 231	HSS	A	1,5			G1/8"-G1 1/2"	55



KATALOGNUMMER / Cat. No. / Referencia Producto

100-100

100-100

100-101

100-104

ISO 3  
6G

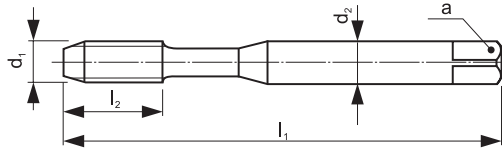
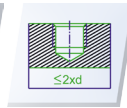
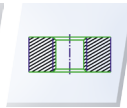
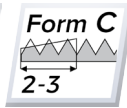
OX

TiAlN

d <sub>1</sub>	P	l <sub>1</sub>	l <sub>2</sub>	d <sub>2</sub>	a	z				
M2	0,4	45	8	2,8	2,1	3	■			
M2,5	0,45	50	9	2,8	2,1	3	■			
M3	0,5	56	11	3,5	2,7	3	■	■	■	■
M4	0,7	63	13	4,5	3,4	3	■	■	■	■
M5	0,8	70	16	6	4,9	3	■	■	■	■
M6	1	80	19	6	4,9	3	■	■	■	■
M8	1,25	90	22	8	6,2	3	■	■	■	■
M10	1,5	100	24	10	8	3	■	■	■	■

### Schnittgeschwindigkeiten / cutting speeds / Velocidad de Corte

V <sub>c</sub> m/min	steel 800 N/mm <sup>2</sup>	Al
100-100	8-15	10-15
100-101	12-20	12-20
100-104	10-15	



z = Nutenzahl / z = number of flutes / z = Número de Cortes



KATALOGNUMMER / Cat. No. / Referencia Producto

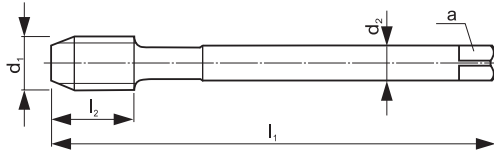
100-400

$d_1$	P	$l_1$	$l_2$	$d_2$	a	z	
M3	0,5	56	9	3,5	2,7	3	■
M3,5	0,6	56	11	4	3	3	■
M4	0,7	63	12	4,5	3,4	3	■
M5	0,8	70	13	6	4,9	3	■
M6	1	80	15	6	4,9	3	■
M8	1,25	90	18	8	6,2	3	■
M10	1,5	100	20	10	8	3	■

### Schnittgeschwindigkeiten / cutting speeds / Velocidad de Corte

$V_c$  m/min      steel 800 N/mm<sup>2</sup>      Al

100-400      6-10      8-10



z = Nutenzahl / z = number of flutes / z = Número de Cortes



KATALOGNUMMER / Cat. No. / Referencia Producto

200-100 200-100 200-101 200-104 200-400

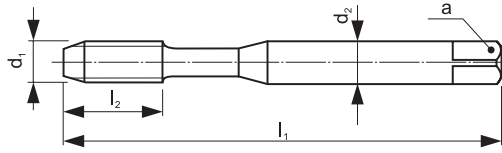


d <sub>1</sub>	P	l <sub>1</sub>	l <sub>2</sub>	d <sub>2</sub>	a	z	ISO 3 6G	OX	TiAlN	Form C 2-3	S2xd
M3	0,5	56	9	2,2	-	3	■		■		■
M4	0,7	63	12	2,8	2,1	3	■		■		■
M5	0,8	70	13	3,5	2,7	3	■		■		■
M6	1	80	15	4,5	3,4	3	■		■		■
M7	1	80	15	5,5	4,3	3	■		■		■
M8	1,25	90	18	6	4,9	3	■		■		■
M10	1,5	100	20	7	5,5	3	■		■		■
M12	1,75	110	28	9	7	3	■	■	■	■	■
M14	2	110	25	11	9	3	■	■	■	■	■
M16	2	110	25	12	9	3	■	■	■	■	■
M18	2,5	125	30	14	11	3	■		■	■	■
M20	2,5	140	30	16	12	3	■	■	■	■	■
M22	2,5	140	30	18	14,5	3	■		■		■
M24	3	160	36	18	14,5	4	■		■		■
M27	3	160	36	20	16	4	■		■		■
M30	3,5	180	40	22	18	4	■		■		■
M33	3,5	180	42	25	20	4	■		■		■
M36	4	200	50	28	22	4	■		■		■
M39	4	200	50	32	24	4					■
M42	4,5	200	56	32	24	4					■
M45	4,5	200	56	36	29	4					■
M48	5	250	63	36	29	4					■
M52	5	250	63	40	32	4					■

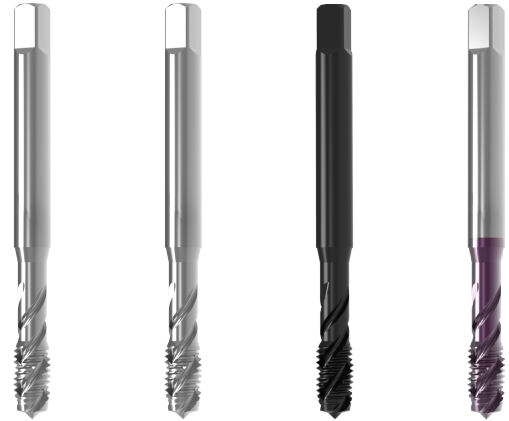
## Schnittgeschwindigkeiten / cutting speeds / Velocidad de Corte

V <sub>c</sub> m/min	steel 800 N/mm <sup>2</sup>	Al
200-100	8-15	10-15
200-101	10-15	12-20
200-104	12-20	
200-400	6-10	8-10





z = Nutenzahl / z = number of flutes / z = Número de Cortes



KATALOGNUMMER / Cat. No. / Referencia Producto

100-500

100-500

100-501

100-504

ISO 3  
6C

OX

TiAlN

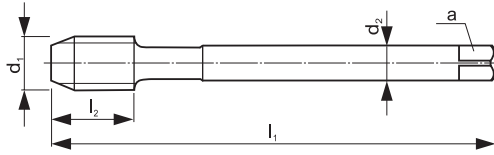
d <sub>1</sub>	P	l <sub>1</sub>	l <sub>2</sub>	d <sub>2</sub>	a	z	ISO 3 6C	OX	TiAlN
M2	0,4	45	6	2,8	2,1	3	■		
M2,5	0,45	50	7,5	2,8	2,1	3	■		
M3	0,5	56	5	3,5	2,7	3	■	■	■
M4	0,7	63	7	4,5	3,4	3	■	■	■
M5	0,8	70	8	6	4,9	3	■	■	■
M6	1	80	10	6	4,9	3	■	■	■
M8	1,25	90	13	8	6,2	3	■	■	■
M10	1,5	100	15	10	8	3	■	■	■

### Schnittgeschwindigkeiten / cutting speeds / Velocidad de Corte

V <sub>c</sub> m/min	steel 800 N/mm <sup>2</sup>	Al
100-500	8-10	8-10
100-501	10-12	10-15
100-504	10-15	

# MASCHINENGEWINDEBOHRER

Machine taps / Machos de máquina



z = Nutenzahl / z = number of flutes / z = Número de Cortes



KATALOGNUMMER / Cat. No. / Referencia Producto

200-500

200-500

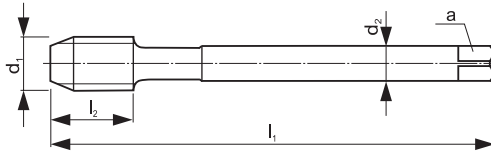
200-501

200-504

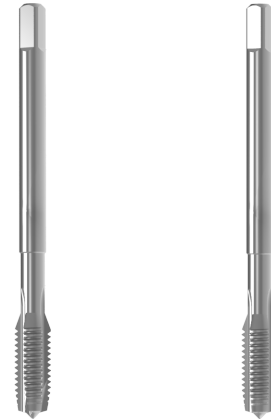
d <sub>1</sub>	P	l <sub>1</sub>	l <sub>2</sub>	d <sub>2</sub>	a	z				
							ISO 3 6G	OX	TiAlN	
M3	0,5	56	5	2,2	-	3	■			
M4	0,7	63	7	2,8	2,1	3	■		■	
M5	0,8	70	8	3,5	2,7	3	■		■	
M6	1	80	10	4,5	3,4	3	■		■	
M7	1	80	10	5,5	4,3	3	■		■	
M8	1,25	90	13	6	4,9	3	■		■	
M10	1,5	100	15	7	5,5	3	■		■	
M12	1,75	110	18	9	7	3	■	■	■	■
M14	2	110	20	11	9	3	■	■	■	■
M16	2	110	20	12	9	3	■	■	■	■
M18	2,5	125	25	14	11	4	■		■	■
M20	2,5	140	25	16	12	4	■	■	■	■
M22	2,5	140	25	18	14,5	4	■		■	
M24	3	160	30	18	14,5	4	■		■	
M27	3	160	30	20	16	4	■		■	
M30	3,5	180	35	22	18	4	■		■	
M33	3,5	180	35	25	20	4	■		■	
M36	4	200	40	28	22	4	■		■	

## Schnittgeschwindigkeiten / cutting speeds / Velocidad de Corte

V <sub>c</sub> m/min	steel 800 N/mm2	Al
200-500	8-10	8-10
200-501	10-12	10-15
200-504	10-15	



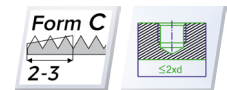
z = Nutenzahl / z = number of flutes / z = Número de Cortes



KATALOGNUMMER / Cat. No. / Referencia Producto

300-100

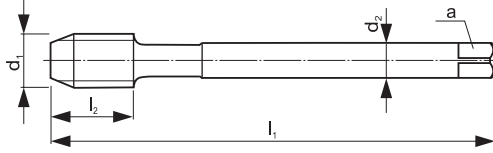
300-400



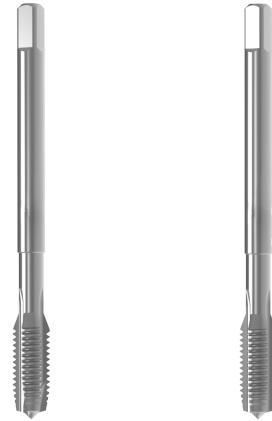
d <sub>1</sub>	P	l <sub>1</sub>	l <sub>2</sub>	d <sub>2</sub>	a	z	300-100	300-400
M4	0,5	63	12	2,8	2,1	3	■	■
M5	0,5	70	13	3,5	2,7	3	■	■
M6	0,5	80	15	4,5	3,4	3	■	■
M6	0,75	80	15	4,5	3,4	3	■	■
M7	0,75	80	15	5,5	4,3	3	■	■
M8	0,75	80	15	6	4,9	3	■	■
M8	1	90	18	6	4,9	3	■	■
M9	1	90	18	7	5,5	3	■	■
M10	0,75	90	20	7	5,5	3	■	■
M10	1	90	20	7	5,5	3	■	■
M10	1,25	100	20	7	5,5	3	■	■
M11	1	90	20	8	6,2	3	■	■
M12	1	100	21	9	7	3	■	■
M12	1,25	100	21	9	7	3	■	■
M12	1,5	100	21	9	7	3	■	■
M14	1	100	21	11	9	3	■	■
M14	1,25	100	21	11	9	3	■	■
M14	1,5	100	21	11	9	3	■	■
M15	1	100	21	12	9	3	■	■
M16	1	100	21	12	9	3	■	■
M16	1,5	100	21	12	9	3	■	■
M17	1	100	21	12	9	3	■	■
M18	1	110	24	14	11	3	■	■
M18	1,5	110	24	14	11	3	■	■
M18	2	125	24	14	11	3	■	■

### Schnittgeschwindigkeiten / cutting speeds / Velocidad de Corte

V <sub>c</sub> m/min	steel 800 N/mm2	Al
300-100	8-15	10-15
300-400	6-10	8-10



z = Nutenzahl / z = number of flutes / z = Número de Cortes

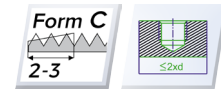


KATALOGNUMMER / Cat. No. / Referencia Producto

300-100

300-400

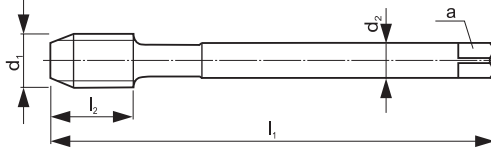
d <sub>1</sub>	P	l <sub>1</sub>	l <sub>2</sub>	d <sub>2</sub>	a	z		
M20	1	125	24	16	12	3	■	■
M20	1,5	125	24	16	12	3	■	■
M20	2	140	30	16	12	3	■	■
M22	1	125	24	18	14,5	3	■	■
M22	1,5	125	24	18	14,5	3	■	■
M22	2	140	30	18	14,5	3	■	■
M24	1	140	26	18	14,5	4	■	■
M24	1,5	140	26	18	14,5	4	■	■
M24	2	140	26	18	14,5	4	■	■
M25	1,5	140	26	18	14,5	4	■	■
M26	1,5	140	26	18	14,5	4	■	■
M27	1	140	26	20	16	4	■	■
M27	1,5	140	26	20	16	4	■	■
M27	2	140	26	20	16	4	■	■
M28	1,5	140	26	20	16	4	■	■
M28	2	140	26	20	16	4	■	■
M30	1	150	28	22	18	4	■	■
M30	1,5	150	28	22	18	4	■	■
M30	2	150	28	22	18	4	■	■
M32	1,5	150	28	22	18	4	■	■
M33	1,5	160	30	25	20	4	■	■
M33	2	160	30	25	20	4	■	■
M34	1,5	170	30	28	22	4		■
M35	1,5	170	30	28	22	4		■
M36	1,5	170	30	28	22	4	■	■
M36	2	170	30	28	22	4	■	■
M36	3	200	42	28	22	4	■	■



Schnittgeschwindigkeiten / cutting speeds / Velocidad de Corte

V <sub>c</sub> m/min	steel 800 N/mm <sup>2</sup>	Al
300-100	8-15	10-15
300-400	6-10	8-10





z = Nutenzahl / z = number of flutes / z = Número de Cortes



### KATALOGNUMMER / Cat. No. / Referencia Producto

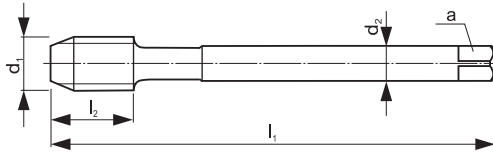
300-500

d <sub>1</sub>	P	l <sub>1</sub>	l <sub>2</sub>	d <sub>2</sub>	a	z	
M4	0,5	63	7	2,8	2,1	3	■
M5	0,5	70	8	3,5	2,7	3	■
M6	0,5	80	10	4,5	3,4	3	■
M6	0,75	80	10	4,5	3,4	3	■
M7	0,75	80	10	5,5	4,3	3	■
M8	0,75	80	10	6	4,9	3	■
M8	1	90	13	6	4,9	3	■
M9	1	90	13	7	5,5	3	■
M10	0,75	90	12	7	5,5	3	■
M10	1	90	12	7	5,5	3	■
M10	1,25	100	15	7	5,5	3	■
M11	1	90	12	8	6,2	3	■
M12	1	100	14	9	7	3	■
M12	1,25	100	14	9	7	3	■
M12	1,5	100	14	9	7	3	■
M14	1	100	16	11	9	3	■
M14	1,25	100	16	11	9	3	■
M14	1,5	100	16	11	9	3	■
M15	1	100	16	12	9	3	■
M16	1	100	16	12	9	4	■
M16	1,5	100	16	12	9	4	■
M18	1	110	20	14	11	4	■
M18	1,5	110	20	14	11	4	■
M18	2	125	20	14	11	4	■
M20	1	125	20	16	12	4	■
M20	1,5	125	20	16	12	4	■
M20	2	140	20	16	12	4	■

### Schnittgeschwindigkeiten / cutting speeds / Velocidad de Corte

V<sub>c</sub> m/min      steel 800 N/mm<sup>2</sup>      Al

300-500      8-10      8-10



z = Nutenzahl / z = number of flutes / z = Número de Cortes



KATALOGNUMMER / Cat. No. / Referencia Producto

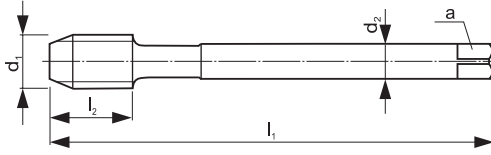
300-500

d <sub>1</sub>	P	l <sub>1</sub>	l <sub>2</sub>	d <sub>2</sub>	a	z	
M22	1	125	20	18	14,5	4	■
M22	1,5	125	20	18	14,5	4	■
M22	2	140	20	18	14,5	4	■
M24	1	140	22	18	14,5	4	■
M24	1,5	140	22	18	14,5	4	■
M24	2	140	22	18	14,5	4	■
M25	1,5	140	22	18	14,5	4	■
M26	1,5	140	22	18	14,5	4	■
M27	1	140	22	20	16	4	■
M27	1,5	140	22	20	16	4	■
M27	2	140	22	20	16	4	■
M28	1,5	140	22	20	16	4	■
M28	2	140	22	20	16	4	■
M30	1	150	26	22	18	4	■
M30	1,5	150	26	22	18	4	■
M30	2	150	26	22	18	4	■
M32	1,5	150	26	22	18	4	■
M33	1,5	160	28	25	20	4	■
M33	2	160	28	25	20	4	■
M35	1,5	170	30	28	22	4	■
M36	1,5	170	28	28	22	4	■
M36	2	170	28	28	22	4	■
M36	3	200	36	28	22	4	■

### Schnittgeschwindigkeiten / cutting speeds / Velocidad de Corte

V<sub>c</sub> m/min      steel 800 N/mm<sup>2</sup>      Al

300-500      8-10      8-10



z = Nutenzahl / z = number of flutes / z = Número de Cortes

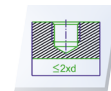
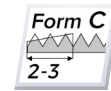


KATALOGNUMMER / Cat. No. / Referencia Producto

203-400

203-100

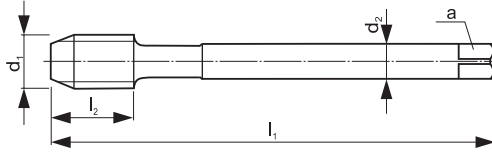
203-102



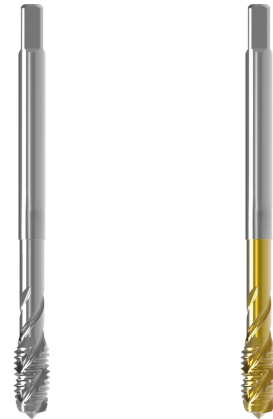
d <sub>1</sub>	P	l <sub>1</sub>	l <sub>2</sub>	d <sub>2</sub>	a	z	203-400	203-100	203-102
G1/8"	28	90	20	7	5,5	3	■	■	■
G1/4"	19	100	21	11	9	3	■	■	■
G3/8"	19	100	21	12	9	3	■	■	■
G1/2"	14	125	24	16	12	3	■	■	■
G5/8"	14	125	24	18	14,5	4	■	■	■
G3/4"	14	140	26	20	16	4	■	■	■
G7/8"	14	150	28	22	18	4	■	■	■
G1"	11	160	30	25	20	4	■	■	■
G1 1/8"	11	170	30	28	22	4	■	■	■
G1 1/4"	11	170	30	32	24	4	■	■	■
G1 3/8"	11	180	32	36	29	4	■	■	■
G1 1/2"	11	190	32	36	29	6	■	■	■
G1 3/4"	11	190	32	40	32	6	■	■	■
G2"	11	220	40	45	35	6	■	■	■

### Schnittgeschwindigkeiten / cutting speeds / Velocidad de Corte

V <sub>c</sub> m/min	steel 800 N/mm <sup>2</sup>	Al
203-400	6-10	6-10
203-100	8-15	10-15
203-102	10-15	10-15



z = Nutenzahl / z = number of flutes / z = Número de Cortes



KATALOGNUMMER / Cat. No. / Referencia Producto

203-500

203-502

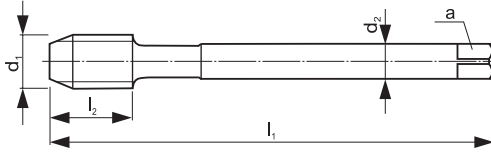


d <sub>1</sub>	P	l <sub>1</sub>	l <sub>2</sub>	d <sub>2</sub>	a	z		
G1/8"	28	90	20	7	5,5	3	■	■
G1/4"	19	100	21	11	9	3	■	■
G3/8"	19	100	21	12	9	3	■	■
G1/2"	14	125	24	16	12	3	■	■
G5/8"	14	125	24	18	14,5	4	■	■
G3/4"	14	140	26	20	16	4	■	■
G7/8"	14	150	28	22	18	4	■	■
G1"	11	160	30	25	20	4	■	■
G1 1/8"	11	170	30	28	22	4	■	■
G1 1/4"	11	170	30	32	24	4	■	■
G1 3/8"	11	180	32	36	29	4		
G1 1/2"	11	190	32	36	29	6	■	■
G1 3/4"	11	190	32	40	32	6		
G2"	11	220	40	45	35	6		

### Schnittgeschwindigkeiten / cutting speeds / Velocidad de Corte

V <sub>c</sub> m/min	steel 800 N/mm <sup>2</sup>	Al
203-500	8-15	10-15
203-502	10-15	10-15





z = Nutenzahl / z = number of flutes / z = Número de Cortes

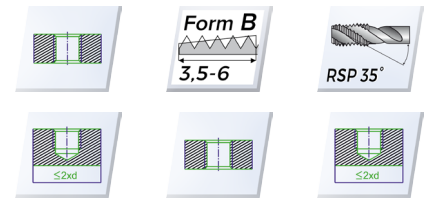


KATALOGNUMMER / Cat. No. / Referencia Producto

101-400

101-100

101-500



$d_1$	P	$l_1$	$l_2$	$l_{2,RSP35^\circ}$	$d_2$	a	z	Form B	RSP 35°	Chamfer
UNC5	40	56	9	5	3,5	2,7	3	■	■	■
UNC6	32	56	11	7	4	3	3	■	■	■
UNC8	32	63	12	7	4,5	3,4	3	■	■	■
UNC10	24	70	13	8	6	4,9	3	■	■	■
UNC12	24	80	15	10	6	4,9	3	■	■	■
UNC1/4	20	80	15	10	7	5,5	3	■	■	■
UNC5/16	18	90	18	13	8	6,2	3	■	■	■
UNC3/8	16	90	20	15	9	7	3	■	■	■

Schnittgeschwindigkeiten / cutting speeds / Velocidad de Corte

$V_c$ m/min	steel 800 N/mm2	Al
101-400	6-10	8-10
101-100	8-15	10-15
101-500	8-10	8-10

UNC

$60^\circ$

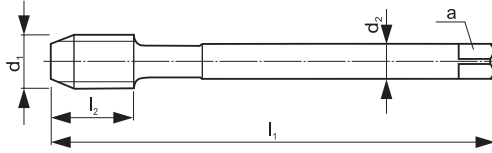
Type  
N

HSSE  
★

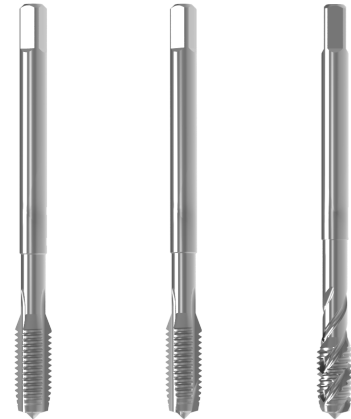
≈DIN  
376

2B

**Form C**



z = Nutenzahl / z = number of flutes / z = Número de Cortes



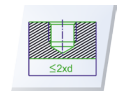
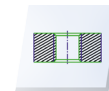
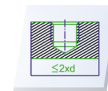
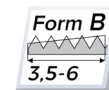
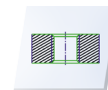
KATALOGNUMMER / Cat. No. / Referencia Producto

201-400

201-100

201-500

$d_1$	P	$l_1$	$l_2$	$d_2$	a	$\frac{z}{RSP35^\circ}$
UNC7/16	14	100	20	8	6,2	3/3
UNC1/2	13	110	23	9	7	3/3
UNC9/16	12	110	25	11	9	3/3
UNC5/8	11	110	25	12	9	3/3
UNC3/4	10	125	30	14	11	3/4
UNC7/8	9	140	30	18	14,5	3/4
UNC1	8	160	36	18	14,5	3/4
UNC1 1/8	7	180	40	22	18	4/-



■	■	■
■	■	■
■	■	■
■	■	■
■	■	■
■	■	■
■	■	■
■	■	■

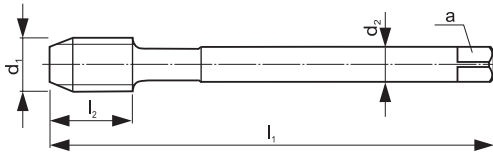
Schnittgeschwindigkeiten / cutting speeds / Velocidad de Corte

$V_c$ m/min	steel 800 N/mm <sup>2</sup>	Al
201-400	6-10	8-10
201-100	8-15	10-15
201-500	8-10	8-10

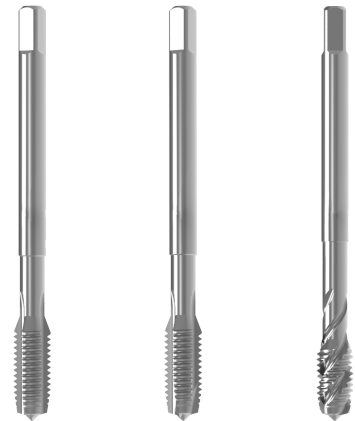
# MASCHINENGEWINDEBOHRER

Machine taps / Machos de máquina

UNF Type N  $\approx$ DIN 374 2B



z = Nutenzahl / z = number of flutes / z = Número de Cortes



KATALOGNUMMER / Cat. No. / Referencia Producto

302-400

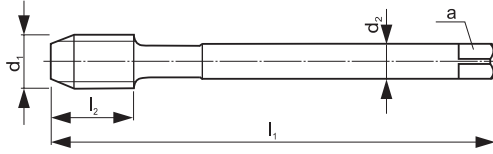
302-100

302-500

d <sub>1</sub>	P	l <sub>1</sub>	l <sub>2</sub>	d <sub>2</sub>	a	z /RSP35°	302-400	302-100	302-500
UNF5	44	56	9	2,2	-	3/3	■	■	■
UNF6	40	56	11	2,5	2,1	3/3	■	■	■
UNF8	36	63	12	2,8	2,1	3/3	■	■	■
UNF10	32	70	13	3,5	2,7	3/3	■	■	■
UNF12	28	80	15	4	3	3/3	■	■	■
UNF1/4	28	80	15	4,5	3,4	3/3	■	■	■
UNF5/16	24	90	18	6	4,9	3/3	■	■	■
UNF3/8	24	90	20	7	5,5	3/3	■	■	■
UNF7/16	20	100	20	8	6,2	3/3	■	■	■
UNF1/2	20	100	21	9	7	3/3	■	■	■
UNF9/16	18	100	21	11	9	3/3	■	■	■
UNF5/8	18	100	21	12	9	3/3	■	■	■
UNF3/4	16	110	24	14	11	3/4	■	■	■
UNF7/8	14	125	24	18	14,5	3/4	■	■	■
UNF1	12	140	26	18	14,5	3/4	■	■	■

### Schnittgeschwindigkeiten / cutting speeds / Velocidad de Corte

V <sub>c</sub> m/min	steel 800 N/mm <sup>2</sup>	Al
302-400	6-10	8-10
302-100	8-15	10-15
302-500	8-10	8-10



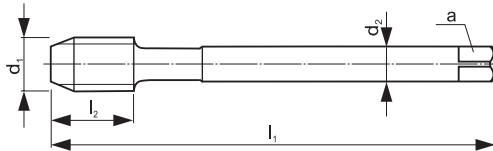
z = Nutenzahl / z = number of flutes / z = Número de Cortes



KATALOGNUMMER / Cat. No. / Referencia Producto

704-400

d <sub>1</sub>	P	l <sub>1</sub>	l <sub>2</sub>	d <sub>2</sub>	a	z	
NPT1/8	27	65	15	7	5,5	4	■
NPT1/4	18	70	22	11	9	4	■
NPT3/8	18	75	23	12	9	4	■
NPT1/2	14	80	30	16	12	4	■
NPT3/1	14	100	31	20	16	4	■
NPT1	11,5	110	36	25	20	4	■
NPT1 1/4	11,5	125	36	32	24	4	■
NPT1 1/2	11,5	140	36	36	29	6	■
NPT2	11,5	160	36,5	36	29	6	■



z = Nutenzahl / z = number of flutes / z = Número de Cortes



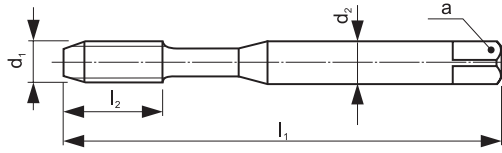
KATALOGNUMMER / Cat. No. / Referencia Producto

705-400

d <sub>1</sub>	P	l <sub>1</sub>	l <sub>2</sub>	d <sub>2</sub>	a	z /RSP35°	
PG7	20	70	22	9	7	4	■
PG9	18	70	22	12	9	4	■
PG11	18	80	22	14	11	4	■
PG13,5	18	80	22	16	12	4	■
PG16	18	80	22	18	14,5	4	■
PG21	16	90	22	22	18	4	■
PG29	16	100	25	28	22	4	■

### Schnittgeschwindigkeiten / cutting speeds / Velocidad de Corte

V <sub>c</sub> m/min	steel 800 N/mm <sup>2</sup>	Al
704-400	3-6	5-8
705-400	8-10	8-10



z = Nutenzahl / z = number of flutes / z = Número de Cortes



KATALOGNUMMER / Cat. No. / Referencia Producto

100-121

100-123

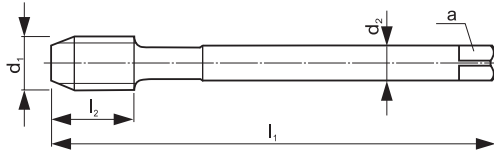
**OX**

**TiCN**

d <sub>1</sub>	P	l <sub>1</sub>	l <sub>2</sub>	d <sub>2</sub>	a	z	OX	TiCN
M3	0,5	56	9	3,5	2,7	3	■	■
M4	0,7	63	12	4,5	3,4	3	■	■
M5	0,8	70	13	6	4,9	3	■	■
M6	1	80	15	6	4,9	3	■	■
M8	1,25	90	18	8	6,2	3	■	■
M10	1,5	100	20	10	8	3	■	■

### Schnittgeschwindigkeiten / cutting speeds / Velocidad de Corte

V <sub>c</sub> m/min	steel 800 N/mm <sup>2</sup>	steel 1200 N/mm <sup>2</sup>	Al (Si > 8%)
100-121	12-15	4-8	8-12
100-123	10-15	8-12	8-20



z = Nutenzahl / z = number of flutes / z = Número de Cortes



KATALOGNUMMER / Cat. No. / Referencia Producto

200-121

200-123

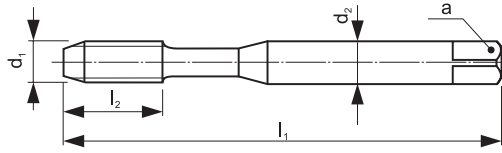
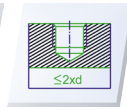
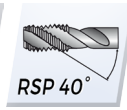
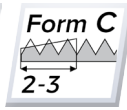
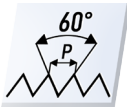
OX

TiCN

d <sub>1</sub>	P	l <sub>1</sub>	l <sub>2</sub>	d <sub>2</sub>	a	z	OX	TiCN
M3	0,5	56	9	2,2	-	3	■	■
M4	0,7	63	12	2,8	2,1	3	■	■
M5	0,8	70	13	3,5	2,7	3	■	■
M6	1	80	15	4,5	3,4	3	■	■
M8	1,25	90	18	6	4,9	3	■	■
M10	1,5	100	20	7	5,5	3	■	■
M12	1,75	110	23	9	7	3	■	■
M14	2	110	25	11	9	3	■	■
M16	2	110	25	12	9	3	■	■
M18	2,5	125	30	14	11	3	■	■
M20	2,5	140	30	16	12	3	■	■
M22	2,5	140	30	18	14,5	3	■	■
M24	3	160	36	18	14,5	4	■	■
M27	3	160	36	20	16	4	■	■
M30	3,5	180	40	22	18	4	■	■

### Schnittgeschwindigkeiten / cutting speeds / Velocidad de Corte

V <sub>c</sub> m/min	steel 800 N/mm2	steel 1200 N/mm2	Al (Si > 8%)
200-121	12-15	4-8	8-12
200-123	10-15	8-12	8-20



z = Nutenzahl / z = number of flutes / z = Número de Cortes



KATALOGNUMMER / Cat. No. / Referencia Producto

100-521

100-523

OX

TiCN

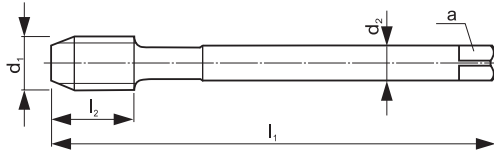
d <sub>1</sub>	P	l <sub>1</sub>	l <sub>2</sub>	d <sub>2</sub>	a	z	OX	TiCN
M3	0,5	56	5	3,5	2,7	3	■	■
M4	0,7	63	7	4,5	3,4	3	■	■
M5	0,8	70	8	6	4,9	3	■	■
M6	1	80	10	6	4,9	3	■	■
M8	1,25	90	13	8	6,2	3	■	■
M10	1,5	100	15	10	8	3	■	■

### Schnittgeschwindigkeiten / cutting speeds / Velocidad de Corte

V <sub>c</sub> m/min	steel 800 N/mm <sup>2</sup>	steel 1200 N/mm <sup>2</sup>	Al (Si > 8%)
100-521	10-12	4-8	10-15
100-523	10-15	6-10	8-20

# MASCHINENGEWINDEBOHRER

Machine taps / Machos de máquina



z = Nutenzahl / z = number of flutes / z = Número de Cortes



KATALOGNUMMER / Cat. No. / Referencia Producto

200-521

200-523

OX

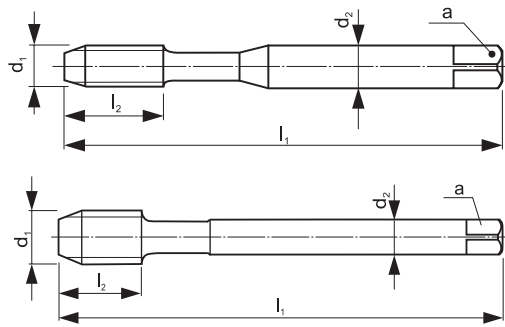
TiCN

d <sub>1</sub>	P	l <sub>1</sub>	l <sub>2</sub>	d <sub>2</sub>	a	z	OX	TiCN
M3	0,5	56	5	2,2	-	3	■	■
M4	0,7	63	7	2,8	2,1	3	■	■
M5	0,8	70	8	3,5	2,7	3	■	■
M6	1	80	10	4,5	3,4	3	■	■
M8	1,25	90	13	6	4,9	3	■	■
M10	1,5	100	15	7	5,5	3	■	■
M12	1,75	110	18	9	7	4	■	■
M14	2	110	20	11	9	4	■	■
M16	2	110	20	12	9	4	■	■
M18	2,5	125	25	14	11	4	■	■
M20	2,5	140	25	16	12	4	■	■
M22	2,5	140	25	18	14,5	4	■	■
M24	3	160	30	18	14,5	4	■	■
M27	3	160	30	20	16	4	■	■
M30	3,5	180	35	22	18	5	■	■

## Schnittgeschwindigkeiten / cutting speeds / Velocidad de Corte

V <sub>c</sub> m/min	steel 800 N/mm <sup>2</sup>	steel 1200 N/mm <sup>2</sup>	Al (Si > 8%)
200-521	10-12	4-8	10-15
200-523	10-15	6-10	8-20





z = Nutenzahl / z = number of flutes / z = Número de Cortes



## KATALOGNUMMER / Cat. No. / Referencia Producto

100-144

100-564

100-544

$d_1$	P	$l_1$	$l_2$	$l_{2RSP}$	$d_2$	a	z
M3	0,5	56	9	5	3,5	2,7	3
M4	0,7	63	12	7	4,5	3,4	3
M5	0,8	70	13	8	6	4,9	3
M6	1	80	15	10	6	4,9	3
M8	1,25	90	18	13	8	6,2	3
M10	1,5	100	20	15	10	8	3

DIN 371	Form B 3,5-6	DIN 371	Form C 2-3	DIN 371	Form D 3,5-5
	RSP 40°		≤2xd	RSP 15°	≤2xd
■		■		■	

## KATALOGNUMMER / Cat. No. / Referencia Producto

200-144

200-564

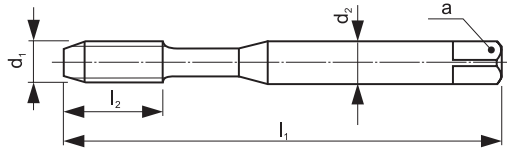
200-544

$d_1$	P	$l_1$	$l_2$	$l_{2RSP}$	$d_2$	a	z
M12	1,75	110	23	18	9	7	3

DIN 376	Form B 3,5-6	DIN 376	Form C 2-3	DIN 376	Form D 3,5-5
	RSP 40°		≤2xd	RSP 15°	≤2xd
■		■		■	

## Schnittgeschwindigkeiten / cutting speeds / Velocidad de Corte

$V_c$ m/min	steel 800 N/mm <sup>2</sup>	steel 1400 N/mm <sup>2</sup>
100-144, 200-144	4-8	4-8
100-564, 200-564	5-10	4-8
100-544, 200-544	5-10	4-8



z = Nutenzahl / z = number of flutes / z = Número de Cortes



KATALOGNUMMER / Cat. No. / Referencia Producto

100-255

100-201

100-203

HL

OX

TiCN

HSSE  
★

HSSE  
★

d <sub>1</sub>	P	l <sub>1</sub>	l <sub>2</sub>	d <sub>2</sub>	a	z	HL	OX	TiCN
M3	0,5	56	9	3,5	2,7	3	■	■	■
M4	0,7	63	12	4,5	3,4	3	■	■	■
M5	0,8	70	13	6	4,9	3	■	■	■
M6	1	80	15	6	4,9	3	■	■	■
M8	1,25	90	18	8	6,2	3	■	■	■
M10	1,5	100	20	10	8	3	■	■	■

### Schnittgeschwindigkeiten / cutting speeds / Velocidad de Corte

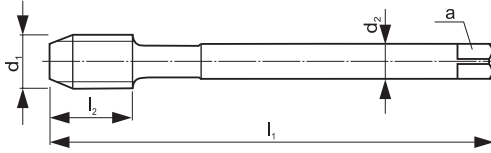
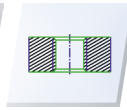
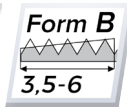
V <sub>c</sub> m/min	INOX
100-255	6-10
100-201	3-6
100-203	4-8

# MASCHINENGEWINDEBOHRER

Machine taps / Machos de máquina



**JUNGMANN®**  
**WERKZEUGE**



z = Nutenzahl / z = number of flutes / z = Número de Cortes



KATALOGNUMMER / Cat. No. / Referencia Producto

200-255

200-201

200-203



d <sub>1</sub>	P	l <sub>1</sub>	l <sub>2</sub>	d <sub>2</sub>	a	z	HL	OX	TiCN	HSSE *	HSSE *
M3	0,5	56	9	3,5	2,7	3					
M4	0,7	63	12	4,5	3,4	3					
M5	0,8	70	13	6	4,9	3					
M6	1	80	15	6	4,9	3					
M8	1,25	90	18	8	6,2	3					
M10	1,5	100	20	10	8	3					
M12	1,75	110	23	9	7	3	■			■	
M14	2	110	25	11	9	3	■			■	
M16	2	110	25	12	9	3	■			■	
M18	2,5	125	30	14	11	3				■	■
M20	2,5	140	30	16	12	3	■			■	■
M22	2,5	140	30	18	14,5	3				■	
M24	3	160	36	18	14,5	4				■	■
M27	3	160	36	20	16	4				■	■
M30	3,5	180	40	22	18	4				■	■

## Schnittgeschwindigkeiten / cutting speeds / Velocidad de Corte

V<sub>c</sub> m/min

INOX

200-255

6-10

200-201

3-6

200-203

4-8

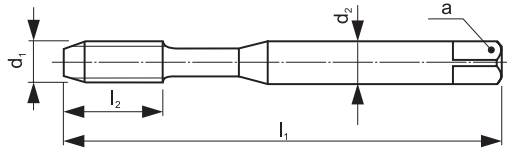
# MASCHINENGEWINDEBOHRER

Machine taps / Machos de máquina



**M**

**DIN 13**
**Type VA**
**HSSE PM**  
★★★★
**DIN 371**
**ISO 2 6H**
**Form C**  
2-3



z = Nutenzahl / z = number of flutes / z = Número de Cortes



KATALOGNUMMER / Cat. No. / Referencia Producto

100-655

100-601

100-603

**HL**

**OX**

**TiCN**

**HSSE**  
★

**HSSE**  
★

d <sub>1</sub>	P	l <sub>1</sub>	l <sub>2</sub>	d <sub>2</sub>	a	z	HL	OX	TiCN	HSSE ★	HSSE ★
M3	0,5	56	5	3,5	2,7	3	■	■	■	■	■
M4	0,7	63	7	4,5	3,4	3	■	■	■	■	■
M5	0,8	70	8	6	4,9	3	■	■	■	■	■
M6	1	80	10	6	4,9	3	■	■	■	■	■
M8	1,25	90	13	8	6,2	3	■	■	■	■	■
M10	1,5	100	15	10	8	3	■	■	■	■	■

## Schnittgeschwindigkeiten / cutting speeds / Velocidad de Corte

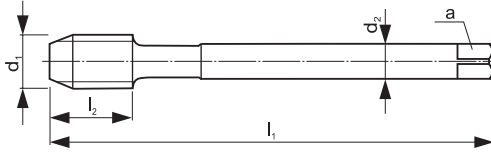
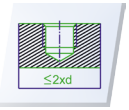
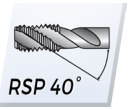
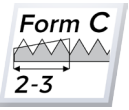
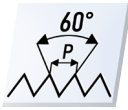
V <sub>c</sub> m/min	INOX
100-655	8-12
100-601	3-6
100-603	4-8

# MASCHINENGEWINDEBOHRER

Machine taps / Machos de máquina



**JUNGMANN**  
**WERKZEUGE**



z = Nutenzahl / z = number of flutes / z = Número de Cortes



KATALOGNUMMER / Cat. No. / Referencia Producto

200-655

200-601

200-603



d <sub>1</sub>	P	l <sub>1</sub>	l <sub>2</sub>	d <sub>2</sub>	a	z	HL	OX	TiCN	HSSE *	HSSE *
M3	0,5	56	5	2,2	-	3				■	
M4	0,7	63	7	2,8	2,1	3				■	
M5	0,8	70	8	3,5	2,7	3				■	
M6	1	80	10	4,5	3,4	3				■	
M8	1,25	90	13	6	4,9	3				■	
M10	1,5	100	15	7	5,5	3				■	
M12	1,75	110	18	9	7	3	■			■	■
M14	2	110	20	11	9	3	■			■	■
M16	2	110	20	12	9	4	■			■	■
M18	2,5	125	25	14	11	4				■	■
M20	2,5	140	25	16	12	4	■			■	■
M22	2,5	140	25	18	14,5	4				■	
M24	3	160	30	18	14,5	4				■	■
M27	3	160	30	20	16	4				■	■
M30	3,5	180	35	22	18	4				■	■

## Schnittgeschwindigkeiten / cutting speeds / Velocidad de Corte

V<sub>c</sub> m/min

INOX

200-655

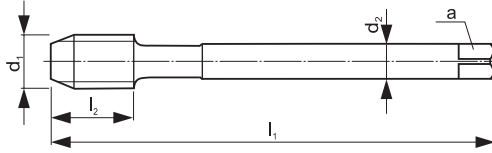
8-12

200-601

3-6

200-603

4-8



z = Nutenzahl / z = number of flutes / z = Número de Cortes



KATALOGNUMMER / Cat. No. / Referencia Producto

203-201

203-202

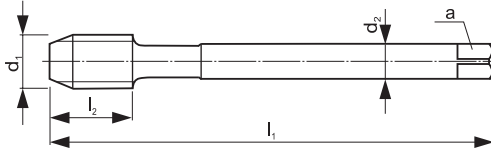
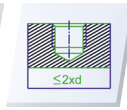
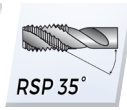
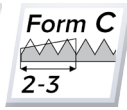
OX

TiN

d <sub>1</sub>	P	l <sub>1</sub>	l <sub>2</sub>	d <sub>2</sub>	a	z	OX	TiN
G1/8"	28	90	20	7	5,5	3	■	■
G1/4"	19	100	21	11	9	3	■	■
G3/8"	19	100	21	12	9	3	■	■
G1/2"	14	125	24	16	12	3	■	■
G5/8"	14	125	24	18	14,5	4	■	■
G3/4"	14	140	26	20	16	4	■	■
G7/8"	14	150	28	22	18	4	■	■
G1"	11	160	30	25	20	4	■	■
G1 1/8"	11	170	30	28	22	4	■	■
G1 1/4"	11	170	30	32	24	4	■	■
G1 1/2"	11	190	32	36	29	6	■	■

### Schnittgeschwindigkeiten / cutting speeds / Velocidad de Corte

V <sub>c</sub> m/min	INOX
203-201	3-6
203-202	4-8



z = Nutenzahl / z = number of flutes / z = Número de Cortes



KATALOGNUMMER / Cat. No. / Referencia Producto

203-601

203-602

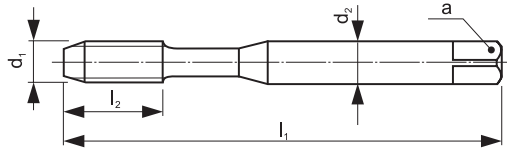
OX

TiN

d <sub>1</sub>	P	l <sub>1</sub>	l <sub>2</sub>	d <sub>2</sub>	a	z	OX	TiN
G1/8"	28	90	12	7	5,5	3	■	■
G1/4"	19	100	16	11	9	3	■	■
G3/8"	19	100	16	12	9	3	■	■
G1/2"	14	125	20	16	12	4	■	■
G5/8"	14	125	20	18	14,5	4	■	■
G3/4"	14	140	22	20	16	4	■	■
G7/8"	14	150	26	22	18	4	■	■
G1"	11	160	30	25	20	4	■	■
G1 1/8"	11	170	30	28	22	5	■	■
G1 1/4"	11	170	30	32	24	5	■	■
G1 1/2"	11	190	32	36	29	5	■	■

### Schnittgeschwindigkeiten / cutting speeds / Velocidad de Corte

V <sub>c</sub> m/min	INOX
203-601	3-6
203-602	4-8



z = Nutenzahl / z = number of flutes / z = Número de Cortes



KATALOGNUMMER / Cat. No. / Referencia Producto

100-423

TiCN

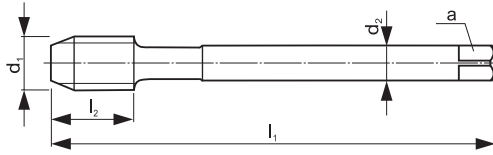
$d_1$	P	$l_1$	$l_2$	$d_2$	a	z	
M3	0,5	56	9	3,5	2,7	3	■
M4	0,7	63	12	4,5	3,4	3	■
M5	0,8	70	13	6	4,9	3	■
M6	1	80	15	6	4,9	3	■
M8	1,25	90	18	8	6,2	4	■
M10	1,5	100	20	10	8	4	■

Schnittgeschwindigkeiten / cutting speeds / Velocidad de Corte

$V_c$  m/min GG

100-423 10-20





z = Nutenzahl / z = number of flutes / z = Número de Cortes



KATALOGNUMMER / Cat. No. / Referencia Producto

200-423

**TiCN**

d <sub>1</sub>	P	l <sub>1</sub>	l <sub>2</sub>	d <sub>2</sub>	a	z	
M3	0,5	56	9	2,2	-	3	■
M4	0,7	63	12	2,8	2,1	3	■
M5	0,8	70	13	3,5	2,7	3	■
M6	1	80	15	4,5	3,4	3	■
M8	1,25	90	18	6	4,9	4	■
M10	1,5	100	20	7	5,5	4	■
M12	1,75	110	23	9	7	4	■
M14	2	110	25	11	9	4	■
M16	2	110	25	12	9	4	■
M18	2,5	125	30	14	11	4	■
M20	2,5	140	30	16	12	4	■
M22	2,5	140	30	18	14,5	4	■
M24	3	160	36	18	14,5	4	■
M27	3	160	36	20	16	4	■
M30	3,5	180	40	22	18	5	■

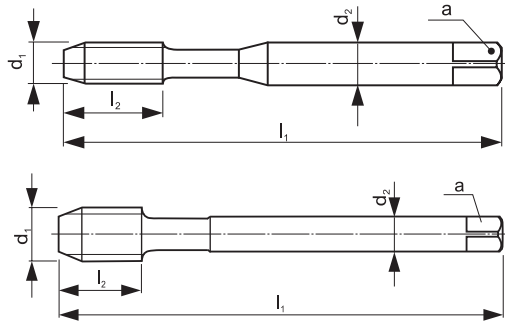
**Schnittgeschwindigkeiten / cutting speeds / Velocidad de Corte**

V<sub>c</sub> m/min

GG

200-423

10-20



z = Nutenzahl / z = number of flutes / z = Número de Cortes



KATALOGNUMMER / Cat. No. / Referencia Producto

100-126

100-306

DIN 371

DIN 371

d <sub>1</sub>	P	l <sub>1</sub>	l <sub>2</sub>	d <sub>2</sub>	a	z	DIN 371	DIN 371
M3	0,5	56	9	3,5	2,7	3	■	■
M4	0,7	63	12	4,5	3,4	3	■	■
M5	0,8	70	13	6	4,9	3	■	■
M6	1	80	15	6	4,9	3	■	■
M8	1,25	90	18	8	6,2	3	■	■
M10	1,5	100	20	10	8	3	■	■

KATALOGNUMMER / Cat. No. / Referencia Producto

200-126

200-306

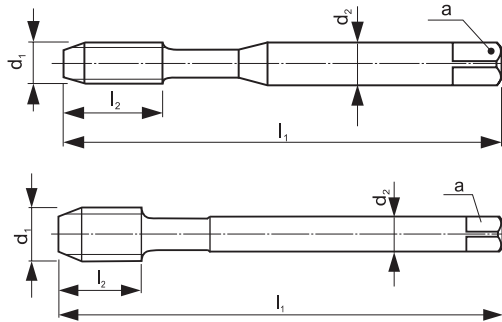
DIN 376

DIN 376

d <sub>1</sub>	P	l <sub>1</sub>	l <sub>2</sub>	d <sub>2</sub>	a	z	DIN 376	DIN 376
M12	1,75	110	23	9	7	3	■	■
M14	2	110	25	11	9	3	■	■
M16	2	110	25	12	9	3	■	■
M18	2,5	125	30	14	11	3	■	■
M20	2,5	140	30	16	12	3	■	■

Schnittgeschwindigkeiten / cutting speeds / Velocidad de Corte

V <sub>c</sub> m/min	ALU (Si<8%)	ALU (Si>8%)
100-126	10-30	
200-126	10-30	
100-306		15-35
200-306		15-35



z = Nutenzahl / z = number of flutes / z = Número de Cortes



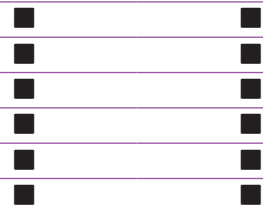
## KATALOGNUMMER / Cat. No. / Referencia Producto

100-526

100-706



d <sub>1</sub>	P	l <sub>1</sub>	l <sub>2</sub>	d <sub>2</sub>	a	z RSP40°	z RSP45°
M3	0,5	56	5	3,5	2,7	3	2
M4	0,7	63	7	4,5	3,4	3	2
M5	0,8	70	8	6	4,9	3	2
M6	1	80	10	6	4,9	3	2
M8	1,25	90	13	8	6,2	3	2
M10	1,5	100	15	10	8	3	2



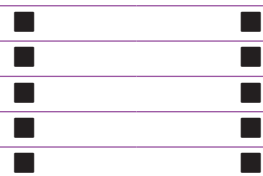
## KATALOGNUMMER / Cat. No. / Referencia Producto

200-526

200-706

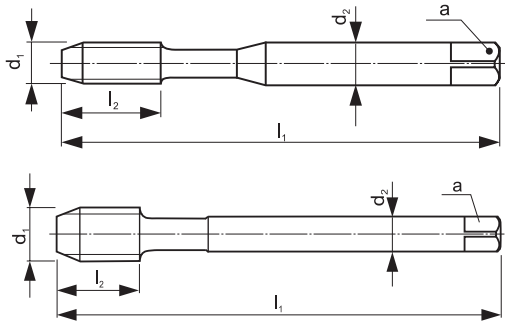


d <sub>1</sub>	P	l <sub>1</sub>	l <sub>2</sub> RSP40°	d <sub>2</sub>	a	z RSP40°	z RSP45°
M12	1,75	110	18	9	7	3	2
M14	2	110	20	11	9	3	2
M16	2	110	20	12	9	3	2
M18	2,5	125	25	14	11	3	3
M20	2,5	140	25	16	12	3	3



## Schnittgeschwindigkeiten / cutting speeds / Velocidad de Corte

V <sub>c</sub> m/min	ALU (Si<8%)	ALU (Si>8%)
100-526	10-25	
200-526	10-25	
100-706		10-30
200-706		10-30



z = Nutenzahl / z = number of flutes / z = Número de Cortes



KATALOGNUMMER / Cat. No. / Referencia Producto

100-272

DIN 371

d <sub>1</sub>	P	l <sub>1</sub>	l <sub>2</sub>	d <sub>2</sub>	a	z	
M3	0,5	56	9	3,5	2,7	7	■
M4	0,7	63	12	4,5	3,4	3	■
M5	0,8	70	13	6	4,9	3	■
M6	1	80	15	6	4,9	3	■
M8	1,25	90	18	8	6,2	3	■
M10	1,5	100	20	10	8	3	■

KATALOGNUMMER / Cat. No. / Referencia Producto

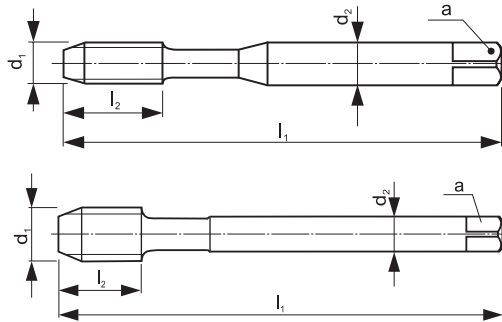
200-272

DIN 376

d <sub>1</sub>	P	l <sub>1</sub>	l <sub>2</sub>	d <sub>2</sub>	a	z	
M12	1,75	110	23	9	7	3	■
M14	2	110	25	11	9	3	■
M16	2	110	25	12	9	3	■
M18	2,5	125	30	14	11	3	■
M20	2,5	140	30	16	12	3	■

Schnittgeschwindigkeiten / cutting speeds / Velocidad de Corte

V <sub>c</sub> m/min	steel 800 N/mm2	steel 1200 N/mm2	INOX	Al (Si > 8%)
100-272	10-15	8-12	4-8	8-15
200-272	10-15	8-12	4-8	8-15



z = Nutenzahl / z = number of flutes / z = Número de Cortes



**KATALOGNUMMER / Cat. No. / Referencia Producto**

100-295

100-295

d <sub>1</sub>	P	l <sub>1</sub>	l <sub>2</sub>	d <sub>2</sub>	a	z
M2	0,4	45	8	2,8	2,1	3
M2,5	0,45	50	9	2,8	2,1	3
M3	0,5	56	11	3,5	2,7	3
M4	0,7	63	13	4,5	3,4	3
M5	0,8	70	16	6	4,9	3
M6	1	80	19	6	4,9	3
M8	1,25	90	22	8	6,2	3
M10	1,5	100	24	10	8	3

DIN 371  
ISO 2 6HX

DIN 371  
ISO 3 6CX

**KATALOGNUMMER / Cat. No. / Referencia Producto**

200-295

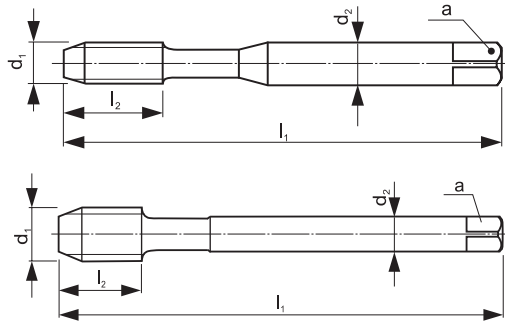
200-295

d <sub>1</sub>	P	l <sub>1</sub>	l <sub>2</sub>	d <sub>2</sub>	a	z
M12	1,75	110	28	9	7	3
M14	2	110	30	11	9	4
M16	2	110	32	12	9	4
M20	2,5	140	34	16	12	4
M20	3	160	38	18	14,5	3
M27	3	160	38	20	16	4
M30	3,5	180	45	22	18	4

DIN 376  
ISO 2 6HX

DIN 376  
ISO 3 6CX

Schnittgeschwindigkeiten / cutting speeds / Velocidad de Corte					
V <sub>c</sub> m/min	steel 800 N/mm2	steel 1200 N/mm2	steel 1400 N/mm2	INOX	Al (Si > 8%)
100-295	15-25	10-18	8-12	12-15	15-40
200-295	15-25	10-18	8-12	12-15	15-40



z = Nutenzahl / z = number of flutes / z = Número de Cortes



KATALOGNUMMER / Cat. No. / Referencia Producto

100-672

DIN 371

d <sub>1</sub>	P	l <sub>1</sub>	l <sub>2</sub>	d <sub>2</sub>	a	z	
M3	0,5	56	5	3,5	2,7	3	■
M4	0,7	63	7	4,5	3,4	3	■
M5	0,8	70	8	6	4,9	3	■
M6	1	80	10	6	4,9	3	■
M8	1,25	90	13	8	6,2	3	■
M10	1,5	100	15	10	8	3	■

KATALOGNUMMER / Cat. No. / Referencia Producto

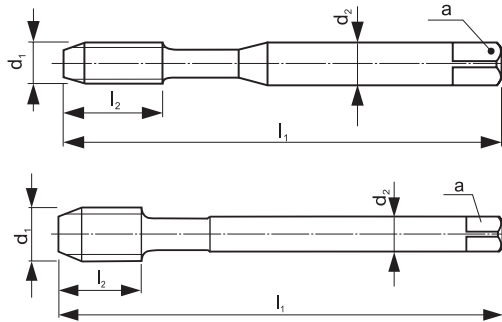
200-672

DIN 376

d <sub>1</sub>	P	l <sub>1</sub>	l <sub>2</sub>	d <sub>2</sub>	a	z	
M12	1,75	110	18	9	7	3	■
M14	2	110	20	11	9	3	■
M16	2	110	20	12	9	4	■
M18	2,5	125	25	14	11	4	■
M20	2,5	140	25	16	12	4	■

Schnittgeschwindigkeiten / cutting speeds / Velocidad de Corte

V <sub>c</sub> m/min	steel 800 N/mm2	steel 1200 N/mm2	INOX	Al (Si > 8%)
100-672	10-12	6-10	4-8	8-15
200-672	10-12	6-10	4-8	8-15



z = Nutenzahl / z = number of flutes / z = Número de Cortes



**KATALOGNUMMER / Cat. No. / Referencia Producto**

**100-695**

**100-695**

d <sub>1</sub>	P	l <sub>1</sub>	l <sub>2</sub>	d <sub>2</sub>	a	z
M2	0,4	45	8	2,8	2,1	3
M2,5	0,45	50	9	2,8	2,1	3
M3	0,5	56	5	3,5	2,7	3
M4	0,7	63	7	4,5	3,4	3
M5	0,8	70	8	6	4,9	3
M6	1	80	10	6	4,9	3
M8	1,25	90	13	8	6,2	3
M10	1,5	100	15	10	8	3

**DIN 371**  
**ISO 2 6HX**

**DIN 371**  
**ISO 3 6GX**

**KATALOGNUMMER / Cat. No. / Referencia Producto**

**200-695**

**200-695**

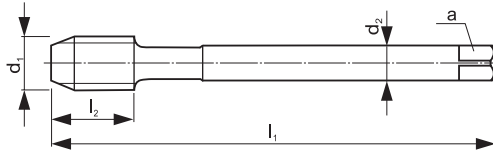
d <sub>1</sub>	P	l <sub>1</sub>	l <sub>2</sub>	d <sub>2</sub>	a	z
M12	1,75	110	18	9	7	3
M14	2	110	20	11	9	3
M16	2	110	20	12	9	3
M20	2,5	140	25	16	12	3
M24	3	160	30	28	14,5	4
M27	3	160	30	20	16	5
M30	3,5	180	35	22	18	5

**DIN 376**  
**ISO 2 6HX**

**DIN 376**  
**ISO 3 6GX**

**Schnittgeschwindigkeiten / cutting speeds / Velocidad de Corte**

V <sub>c</sub> m/min	steel 800 N/mm2	steel 1200 N/mm2	steel 1400 N/mm2	INOX	Al (Si > 8%)
<b>100-695</b>	10-25	10-12	6-10	10-12	15-30
<b>200-695</b>	10-25	10-12	6-10	10-12	15-30



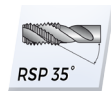
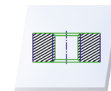
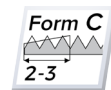
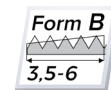
z = Nutenzahl / z = number of flutes / z = Número de Cortes



KATALOGNUMMER / Cat. No. / Referencia Producto

300-272

300-672

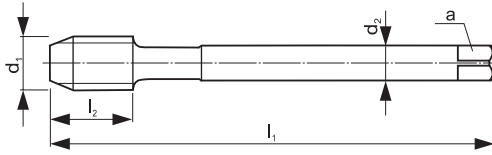


d <sub>1</sub>	P	l <sub>1</sub>	l <sub>2</sub>	l <sub>2</sub> RSP35°	d <sub>2</sub>	a	z	Form B	Form C
M6	0,75	80	15	10	4,5	3,4	3	■	■
M8	1	90	18	13	6	4,9	3	■	■
M8	0,75	80	15	10	6	4,9	3	■	■
M10	1	90	20	12	7	5,5	3	■	■
M12	1,5	100	21	14	9	7	3	■	■
M12	1	100	21	14	9	7	3	■	■
M14	1,5	100	21	16	11	9	3	■	■
M16	1,5	100	21	16	12	9	4	■	■
M18	1,5	110	24	20	14	11	4	■	■
M20	1,5	125	24	20	16	12	4	■	■

### Schnittgeschwindigkeiten / cutting speeds / Velocidad de Corte

V <sub>c</sub> m/min	steel 800 N/mm2	steel 1200 N/mm2	INOX	Al (Si > 8%)
300-272	10-15	8-12	4-8	8-15
300-672	10-12	6-10	4-8	8-15





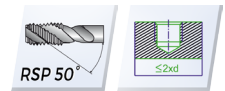
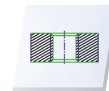
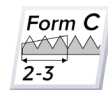
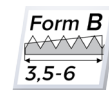
z = Nutenzahl / z = number of flutes / z = Número de Cortes



KATALOGNUMMER / Cat. No. / Referencia Producto

300-295

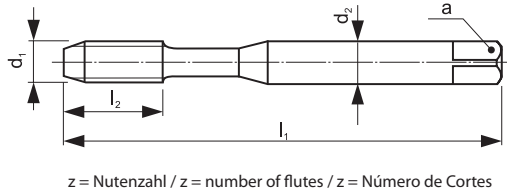
300-695



d <sub>1</sub>	P	l <sub>1</sub>	l <sub>2</sub>	l <sub>2</sub> RSP50°	d <sub>2</sub>	a	z	Form B	Form C
M8	1	90	22	10	6	4,9	3	■	■
M10	1,25	100	24	12	7	5,5	3	■	■
M10	1	90	20	12	7	5,5	3	■	■
M12	1,5	100	22	14	9	7	4	■	■
M12	1,25	100	22	14	9	7	4	■	■
M12	1	100	22	14	9	7	4	■	■
M14	1,5	100	22	16	11	9	4	■	■
M16	1,5	100	22	16	12	9	4	■	■
M18	1,5	110	25	20	14	11	4	■	■
M20	1,5	125	25	20	16	12	4	■	■

### Schnittgeschwindigkeiten / cutting speeds / Velocidad de Corte

V <sub>c</sub> m/min	steel 800 N/mm <sup>2</sup>	steel 1200 N/mm <sup>2</sup>	steel 1400 N/mm <sup>2</sup>	INOX	Al (Si > 8%)
300-295	15-25	10-18	8-12	12-15	15-40
300-695	10-25	10-12	6-10	10-12	15-30



KATALOGNUMMER / Cat. No. / Referencia Producto

800-902

800-902

800-922

800-922

ISO 2  
6HX

ISO 3  
6GX

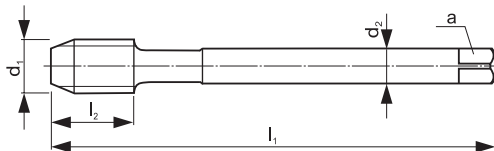
ISO 2  
6HX

ISO 3  
6GX

$d_1$	P	$l_1$	$l_2$	$d_2$	a	z	ISO 2 6HX	ISO 3 6GX	ISO 2 6HX	ISO 3 6GX
M3	0,5	56	11	3,5	2,7		■	■	■	■
M3,5	0,6	56	12	4	3		■	■	■	■
M4	0,7	63	13	4,5	3,4		■	■	■	■
M5	0,8	70	16	6	4,9		■	■	■	■
M6	1	80	19	6	4,9		■	■	■	■
M8	1,25	90	22	8	6,2		■	■	■	■
M10	1,5	100	24	10	8		■	■	■	■
M12	1,75	110	28	9	7		■		■	■

**Schnittgeschwindigkeiten / cutting speeds / Velocidad de Corte**

$V_c$ m/min	steel 800 N/mm2	Al
800-902	15-25	
800-922	15-25	15-30



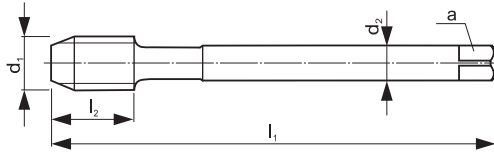
z = Nutenzahl / z = number of flutes / z = Número de Cortes



KATALOGNUMMER / Cat. No. / Referencia Producto

400-070

$d_1$	P	$l_1$	$l_2$	$d_2$	a	z	
M3	0,5	40	9	3,5	2,7	3	■
M3,5	0,6	45	11	4	3	3	■
M4	0,7	45	12	4,5	3,4	3	■
M4,5	0,75	50	13	6	4,9	3	■
M5	0,8	50	13	6	4,9	3	■
M6	1	56	15	6	4,9	3	■
M7	1	56	15	6	4,9	3	■
M8	1,25	63	18	6	4,9	3	■
M9	1,25	63	18	7	5,5	3	■
M10	1,5	70	20	7	5,5	3	■
M11	1,5	70	20	8	6,2	3	■
M12	1,75	75	23	9	7	3	■
M14	2	80	25	11	9	4	■
M16	2	80	25	12	9	4	■
M18	2,5	95	30	14	11	4	■
M20	2,5	95	30	16	12	4	■
M22	2,5	100	30	18	14,5	4	■
M24	3	110	34	18	14,5	4	■
M27	3	110	34	20	16	4	■
M30	3,5	125	40	22	18	4	■
M33	3,5	125	40	25	20	4	■
M36	4	150	50	28	22	4	■
M39	4	150	50	32	24	4	■
M42	4,5	150	56	32	24	4	■
M45	4,5	160	58	36	29	6	■
M48	5	180	65	36	29	6	■
M52	5	180	65	40	32	6	■



z = Nutenzahl / z = number of flutes / z = Número de Cortes

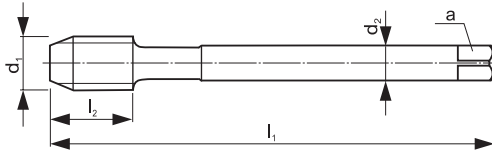
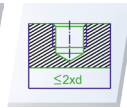
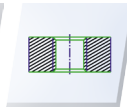
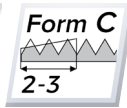
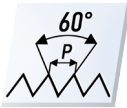


KATALOGNUMMER / Cat. No. / Referencia Producto

400-091



d <sub>1</sub>	P	l <sub>1</sub>	l <sub>2</sub>	d <sub>2</sub>	a	z	
M3	0,5	40	9	3,5	2,7	3	■
M4	0,7	45	12	4,5	3,4	3	■
M5	0,8	50	13	6	4,9	3	■
M6	1	56	15	6	4,9	3	■
M8	1,25	63	18	6	4,9	3	■
M10	1,5	70	20	7	5,5	3	■
M12	1,75	75	23	9	7	3	■
M14	2	80	25	11	9	4	■
M16	2	80	25	12	9	4	■
M18	2,5	95	30	14	11	4	■
M20	2,5	95	30	16	12	4	■



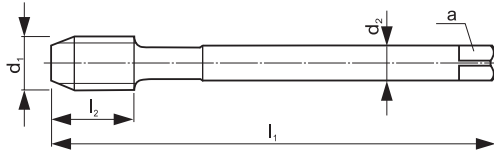
z = Nutenzahl / z = number of flutes / z = Número de Cortes



KATALOGNUMMER / Cat. No. / Referencia Producto

400-080

$d_1$	P	$l_1$	$l_2$	$d_2$	a	z	
M4,5	0,5	50	10	6	4,9	3	■
M5,5	0,5	56	11	6	4,9	3	■
M5	0,5	50	10	6	4,9	3	■
M6	0,75	56	11	6	4,9	3	■
M6	0,5	56	11	6	4,9	3	■
M7	0,75	56	11	6	4,9	3	■
M8	1	63	18	6	4,9	3	■
M8	0,75	56	14	6	4,9	3	■
M8	0,5	56	14	6	4,9	3	■
M9	1	63	18	7	5,5	3	■
M9	0,75	56	14	7	5,5	3	■
M10	1,25	70	20	7	5,5	3	■
M10	1	63	18	7	5,5	3	■
M10	0,75	63	18	7	5,5	3	■
M11	1	63	18	8	6,2	3	■
M12	1,5	70	20	9	7	3	■
M12	1,25	70	20	9	7	3	■
M12	1	70	18	9	7	3	■
M13	1	70	18	11	9	3	■
M14	1,5	70	20	11	9	4	■
M14	1,25	70	20	11	9	4	■
M14	1	70	18	11	9	4	■
M15	1,5	70	20	12	9	4	■
M15	1	70	18	12	9	4	■
M16	1,5	70	20	12	9	4	■
M16	1	70	18	12	9	4	■
M17	1	70	18	12	9	4	■



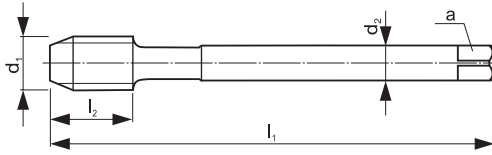
z = Nutenzahl / z = number of flutes / z = Número de Cortes



KATALOGNUMMER / Cat. No. / Referencia Producto

400-080

d <sub>1</sub>	P	l <sub>1</sub>	l <sub>2</sub>	d <sub>2</sub>	a	z	
M18	2	80	22	14	11	4	■
M18	1,5	80	22	14	11	4	■
M18	1	80	18	14	11	4	■
M20	2	80	22	16	12	4	■
M20	1,5	80	22	16	12	4	■
M20	1	80	18	16	12	4	■
M22	2	80	22	18	14,5	4	■
M22	1,5	80	22	18	14,5	4	■
M22	1	80	18	18	14,5	4	■
M24	2	90	22	18	14,5	4	■
M24	1,5	90	22	18	14,5	4	■
M24	1	90	18	18	14,5	4	■
M25	1,5	90	22	18	14,5	4	■
M26	1,5	90	22	18	14,5	4	■
M27	2	90	22	20	16	4	■
M27	1,5	90	22	20	16	4	■
M27	1	90	18	20	16	4	■
M28	2	90	22	20	16	4	■
M28	1,5	90	22	20	16	4	■
M30	2	90	22	22	18	4	■
M30	1,5	90	22	22	18	4	■
M30	1	90	18	22	18	4	■
M32	1,5	90	22	22	18	4	■
M33	2	100	25	25	20	4	■
M33	1,5	100	25	25	20	4	■
M34	1,5	100	25	28	22	4	■



z = Nutenzahl / z = number of flutes / z = Número de Cortes

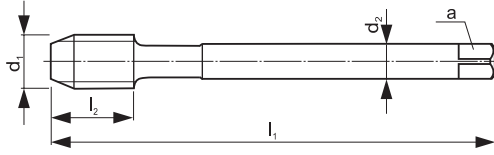


KATALOGNUMMER / Cat. No. / Referencia Producto

400-080

$d_1$	P	$l_1$	$l_2$	$d_2$	a	z	
M35	1,5	100	25	28	22	4	■
M36	3	125	36	28	22	4	■
M36	2	125	30	28	22	4	■
M36	1,5	100	25	28	22	4	■
M38	1,5	100	25	28	22	4	■
M39	3	125	36	32	24	4	■
M39	2	125	30	32	24	4	■
M39	1,5	110	25	32	24	4	■
M40	3	125	36	32	24	4	■
M40	2	125	30	32	24	4	■
M40	1,5	110	25	32	24	4	■
M42	3	125	36	32	24	4	■
M42	2	125	30	32	24	4	■
M42	1,5	110	25	32	24	4	■
M45	3	125	36	36	29	6	■
M45	2	125	30	36	29	6	■
M45	1,5	110	25	36	29	6	■
M48	3	140	36	36	29	6	■
M48	2	140	30	36	29	6	■
M48	1,5	140	25	36	29	6	■
M50	3	140	36	36	29	6	■
M50	2	140	30	36	29	6	■
M50	1,5	140	25	36	29	6	■
M52	3	140	40	40	32	6	■
M52	2	140	32	40	32	6	■
M52	1,5	140	25	40	32	6	■





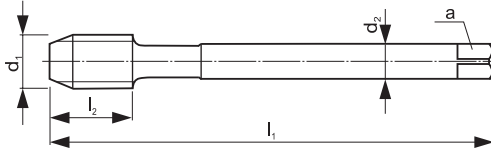
z = Nutenzahl / z = number of flutes / z = Número de Cortes



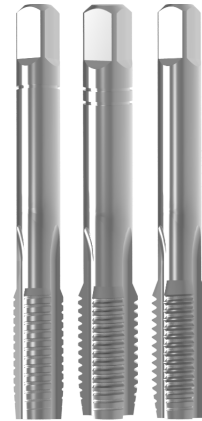
KATALOGNUMMER / Cat. No. / Referencia Producto

403-080

$d_1$	P	$l_1$	$l_2$	$d_2$	a	z	
G1/8"	28	63	18	7	5,5	3	■
G1/4"	19	70	20	11	9	3	■
G3/8"	19	70	20	12	9	3	■
G1/2"	14	80	22	16	12	3	■
G5/8"	14	80	22	18	14,5	4	■
G3/4"	14	90	22	20	16	4	■
G7/8"	14	90	22	22	18	4	■
G1"	11	100	25	25	20	4	■
G1 1/8"	11	125	30	28	22	4	■
G1 1/4"	11	125	30	32	24	4	■
G1 1/2"	11	140	30	36	29	6	■
G1 3/4"	11	140	32	40	32	6	■
G2"	11	160	36	45	35	6	■



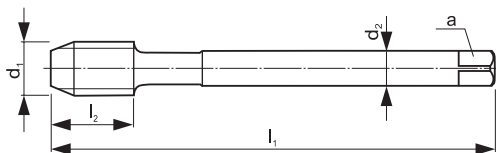
z = Nutenzahl / z = number of flutes / z = Número de Cortes



KATALOGNUMMER / Cat. No. / Referencia Producto

401-070

$d_1$	P	$l_1$	$l_2$	$d_2$	a	z	
UNC5	40	40	10	3,5	2,7	3	■
UNC6	32	45	11	4	3	3	■
UNC8	32	45	12	4,5	3,4	3	■
UNC10	24	50	14	6	4,9	3	■
UNC12	24	56	16	6	4,9	3	■
UNC1/4	20	56	16	6	4,9	3	■
UNC5/16	18	63	20	6	4,9	3	■
UNC3/8	16	70	22	7	5,5	3	■
UNC7/16	14	70	22	8	6,2	3	■
UNC1/2	13	75	25	9	7	3	■
UNC9/16	12	80	26	11	9	3	■
UNC5/8	11	80	27	12	9	3	■
UNC3/4	10	95	32	14	11	4	■
UNC7/8	9	100	32	18	14,5	4	■
UNC1	8	110	36	18	14,5	4	■



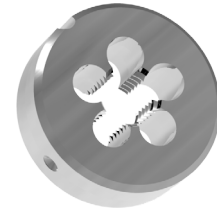
z = Nutenzahl / z = number of flutes / z = Número de Cortes



KATALOGNUMMER / Cat. No. / Referencia Producto

402-080

$d_1$	P	$l_1$	$l_2$	$d_2$	a	z	
UNF5	44	40	10	3,5	2,7	3	■
UNF6	40	45	11	4	3	3	■
UNF8	36	45	12	4,5	3,4	3	■
UNF10	32	50	14	6	4,9	3	■
UNF12	28	56	16	6	4,9	3	■
UNF1/4	28	56	16	6	4,9	3	■
UNF5/16	24	63	18	6	4,9	3	■
UNF3/8	24	63	18	7	5,5	3	■
UNF7/16	20	70	20	8	6,2	3	■
UNF1/2	20	70	20	9	7	3	■
UNF9/16	18	70	20	11	9	3	■
UNF5/8	18	70	20	12	9	3	■
UNF3/4	16	80	22	14	11	4	■
UNF7/8	14	80	22	18	14,5	4	■
UNF1	12	80	22	18	14,5	4	■



KATALOGNUMMER / Cat. No. / Referencia Producto

090-010

d <sub>1</sub>	P	d	e	
M2	0,4	16	5	■
M2,5	0,45	16	5	■
M3	0,5	20	5	■
M4	0,7	20	5	■
M5	0,8	20	7	■
M6	1	20	7	■
M6	0,75	20	7	■
M7	1	25	9	■
M8	1,25	25	9	■
M8	1	25	9	■
M8	0,75	25	9	■
M9	1,25	25	9	■
M10	1,5	30	11	■
M10	1,25	30	11	■
M10	1	30	11	■
M11	1,5	30	11	■
M12	1,75	38	14	■
M12	1,5	38	10	■
M12	1,25	38	10	■
M12	1	38	10	■
M14	2	38	14	■
M14	1,5	38	10	■
M14	1,25	38	10	■
M14	1	38	10	■

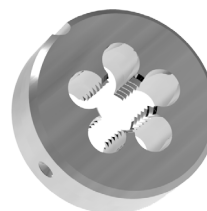
**Schnittgeschwindigkeiten / cutting speeds / Velocidad de Corte**

V<sub>c</sub> m/min

steel 800 N/mm<sup>2</sup>

090-010

2-4



KATALOGNUMMER / Cat. No. / Referencia Producto

090-010

$d_1$	P	d	e	
M16	2	45	18	■
M16	1,5	45	14	■
M16	1	45	14	■
M18	2,5	45	18	■
M18	2	45	14	■
M18	1,5	45	14	■
M20	2,5	45	18	■
M20	1,5	45	14	■
M20	1	45	14	■
M22	2,5	55	22	■
M22	2	55	16	■
M22	1,5	55	16	■
M22	1	55	16	■
M24	3	55	22	■
M24	2	55	16	■
M24	1,5	55	16	■
M24	1	55	16	■
M27	3	65	25	■
M30	3,5	65	25	■
M33	3,5	65	25	■
M36	4	65	25	■

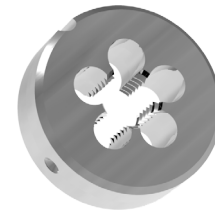
**Schnittgeschwindigkeiten / cutting speeds / Velocidad de Corte**

$V_c$  m/min

steel 800 N/mm<sup>2</sup>

090-010

2-4



KATALOGNUMMER / Cat. No. / Referencia Producto

093-010

$d_1$	P	d	e	
G1/8"	28	30	11	■
G1/4"	19	38	10	■
G3/8"	19	45	14	■
G1/2"	14	45	14	■
G5/8"	14	55	16	■
G3/4"	14	55	16	■
G1"	11	65	18	■
G1 1/8"	11	75	20	■
G1 1/4"	11	75	20	■
G1 1/2"	11	90	22	■

**Schnittgeschwindigkeiten / cutting speeds / Velocidad de Corte**

$V_c$  m/min steel 800 N/mm<sup>2</sup>

093-010 2-4

# SCHNITTGESCHWINDIGKEITEN

Hardness conversion / Conversion de Durezza



VICKERS	BRINELL	ROCKWELL		TENSILE STRNGTH R <sub>m</sub>	
HV 30	HB 30	HRB	HRC	N/mm <sup>2</sup>	kp/mm <sup>2</sup>
80	80	36,4	-	270	28
85	85	42,4	-	290	30
90	90	47,4	-	310	32
95	95	52,0	-	320	33
100	100	56,4	-	340	35
105	105	60,0	-	360	37
110	110	63,4	-	380	39
115	115	66,4	-	390	40
120	120	69,4	-	410	42
125	125	72,0	-	420	43
130	130	74,4	-	440	45
135	135	76,4	-	460	47
140	140	78,4	-	470	48
145	145	80,4	-	490	50
150	150	82,2	-	500	51
155	155	83,8	-	520	53
160	160	85,4	-	540	55
165	165	86,8	-	550	56
170	170	88,2	-	570	58
175	175	89,6	-	590	60
180	180	90,8	-	600	62
185	185	91,8	-	620	63
190	190	93,0	-	640	65
195	195	94,0	-	660	67
200	200	95,0	-	670	68
205	205	95,8	-	680	70
210	210	96,6	-	710	72
215	215	97,6	-	720	73
220	220	98,2	-	730	75
225	225	99,0	-	750	77
230	230	-	19,2	760	78
235	235	-	20,2	780	80
240	240	-	21,2	800	82
245	245	-	22,1	820	84
250	250	-	23,0	830	85
255	255	-	23,8	850	87
260	260	-	24,6	870	89
265	265	-	25,4	880	90
270	270	-	26,2	900	92
275	275	-	26,9	920	94
280	280	-	27,6	940	96
285	285	-	28,3	950	97
290	290	-	29,0	970	99
295	295	-	29,6	990	101
300	300	-	30,3	1010	103
310	310	-	31,5	1040	106
320	320	-	32,7	1080	110
330	330	-	33,8	1110	113
340	340	-	34,9	1140	117
350	350	-	36,0	1170	120
360	359	-	37,0	1200	123
370	368	-	38,0	1230	126
380	376	-	38,9	1260	129
390	385	-	39,8	1290	132
400	392	-	40,7	1320	135
410	400	-	41,5	1350	138
420	408	-	42,4	1380	144
440	423	-	44,0	1430	146
450	430	-	44,8	1460	149
460	-	-	45,6	-	-
470	-	-	46,3	-	-
480	-	-	47,0	-	-
490	-	-	47,7	-	-
500	-	-	48,3	-	-
510	-	-	49,1	-	-
520	-	-	49,7	-	-
530	-	-	50,4	-	-
540	-	-	51,0	-	-
550	-	-	51,6	-	-
560	-	-	52,2	-	-
570	-	-	52,8	-	-

VICKERS	BRINELL	ROCKWELL		TENSILE STRNGTH R <sub>m</sub>	
HV 30	HB 30	HRB	HRC	N/mm <sup>2</sup>	kp/mm <sup>2</sup>
580	-	-	53,3	-	-
590	-	-	53,9	-	-
600	-	-	54,4	-	-
610	-	-	55,0	-	-
620	-	-	55,5	-	-
630	-	-	56,0	-	-
640	-	-	56,5	-	-
650	-	-	57,0	-	-
660	-	-	57,5	-	-
670	-	-	58,0	-	-
680	-	-	58,5	-	-
690	-	-	59,0	-	-
700	-	-	59,5	-	-
720	-	-	60,4	-	-
740	-	-	61,2	-	-
760	-	-	62,0	-	-
780	-	-	62,8	-	-
800	-	-	63,6	-	-
820	-	-	64,3	-	-
840	-	-	65,0	-	-
860	-	-	65,7	-	-
880	-	-	66,3	-	-
900	-	-	66,9	-	-
920	-	-	67,5	-	-
940	-	-	68,0	-	-



**JUNGMANN<sup>®</sup>**  
**WERKZEUGE**

**Base Metalurgica S.L.**

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# Umrechnungstabelle

Conversion chart / Grafico Velocidad de Corte

Schnittgeschwindigkeit m/Min. | Cutting speed m/min. | Xxxx m/Min.

M	G	UN	1	2	3	4	5	6	7	8	9	10	12	14	15	16	18	20	22	24	25	26	28	30	32	34	35	40		
			Drehzahl/Min.   Revolutions per minute   Xxxxx/Min.																											
2			159	318	478	637	796	955	1115	1274	1433	1592	1911	2229	2389	2548	2866	3185	3503	3822	3981	4140	4459	4777	5096	5414	5573	6369		
2,5			127	255	382	510	637	764	892	1019	1146	1274	1529	1783	1911	2038	2293	2548	2803	3057	3185	3312	3567	3822	4076	4331	4459	5096		
3		No.5	106	212	318	425	531	637	743	849	955	1062	1274	1466	1592	1699	1911	2123	2335	2548	2654	2760	2972	3185	3397	3609	3715	4246		
4		No.8	80	159	239	318	398	478	557	637	717	796	955	1115	1194	1274	1433	1592	1752	1911	1990	2070	2229	2389	2548	2707	2787	3185		
5		No.10	64	127	191	255	318	382	446	510	573	637	764	892	955	1019	1146	1274	1401	1529	1592	1656	1783	1911	2038	2166	2229	2546		
6		1/4	53	106	159	212	265	318	372	425	478	531	637	743	796	849	955	1062	1168	1274	1327	1380	1486	1592	1699	1805	1858	2123		
7			45	91	136	182	227	273	318	364	409	455	546	637	682	728	819	910	1001	1092	1137	1183	1274	1365	1456	1547	1592	1820		
8		1/16"	40	80	119	159	199	239	279	318	358	398	478	557	597	637	717	796	876	955	995	1035	1115	1194	1274	1354	1393	1592		
9		3/8	35	71	106	142	177	212	248	283	318	354	425	495	531	566	637	708	778	849	885	920	991	1062	1132	1203	1238	1415		
10		1/8"	32	64	96	127	159	191	223	255	287	318	382	446	478	510	573	637	701	764	796	828	892	955	1019	1083	1115	1274		
12		1/4"	27	53	80	106	133	159	186	212	239	265	318	372	398	425	478	531	584	637	663	690	743	796	849	902	929	1062		
14		9/16	23	45	68	91	114	136	159	182	205	227	273	318	341	364	409	455	500	546	569	591	637	682	728	773	796	910		
16		3/8"	20	40	60	80	100	119	139	159	179	199	239	279	299	316	358	398	438	478	498	518	557	597	637	677	697	796		
18		3/4	18	35	53	71	99	106	124	142	159	177	212	248	265	283	318	354	389	425	442	460	495	531	566	602	619	708		
20		1/2"	16	32	48	64	80	96	111	127	143	159	191	223	239	255	287	318	350	382	398	414	446	478	510	541	557	637		
22		5/8"	14	29	43	58	72	87	101	116	130	145	174	203	217	232	261	290	318	347	362	376	405	434	463	492	507	579		
24		1	13	27	40	53	66	80	93	106	119	133	159	186	199	212	239	265	292	318	332	345	372	398	425	451	464	531		
27		3/4"	12	24	35	47	59	71	83	94	106	118	142	165	177	189	212	236	259	283	295	307	330	354	377	401	413	472		
30		7/8"	11	21	32	42	53	64	74	85	96	106	127	149	159	170	191	212	234	255	265	276	297	318	340	361	372	425		
33		1"	10	19	29	39	48	58	68	77	87	97	116	135	145	154	174	193	212	232	241	251	270	290	309	328	338	386		
36		1 3/8	9	18	27	35	44	53	62	71	80	88	106	124	133	142	159	177	195	212	221	230	248	265	283	301	310	354		
39		1 1/8"	8	16	24	33	41	49	57	65	73	82	98	114	122	131	147	163	180	196	204	212	229	245	261	278	286	327		
42		1 1/4"	8	15	23	30	38	45	53	61	68	76	91	106	114	121	136	152	167	182	190	197	212	227	243	258	265	303		
45		1 3/8"	7	14	21	28	35	42	50	57	64	71	85	99	106	113	127	142	156	170	177	184	198	212	226	241	248	283		
48		1 1/2"	7	13	20	27	33	40	46	53	60	66	80	93	100	106	119	133	146	159	166	173	186	199	212	226	232	265		
52		2	6	12	18	24	31	37	43	49	55	61	73	86	92	98	110	122	135	147	153	159	171	184	196	208	214	245		

Werkzeugabmessung / Diameter of tools