Le alte cime

The high peaks

Tra le cime più alte in Piemonte c'è il Gran Paradiso. Il toponimo deriva dal patois valdostano Granta Parei, che vuol dire grande parete.
Il Parco Nazionale Gran Paradiso, un'eccellenza della regione a pochi chilometri dagli stabilimenti UFS, si estende su 70.000 ettari di territorio d'alta montagna, tra gli 800 metri di fondovalle e i 4.061 metri della vetta.
La sua storia è legata alla protezione dello stambecco. Nel 1856, infatti, il re Vittorio Emanuele II dichiarò queste montagne riserva reale di caccia e salvò così lo stambecco dall'estinzione. Il re creò anche un corpo di guardie specializzate e fece costruire una rete viaria per la protezione della fauna e per le escursioni. Nel 1920, Vittorio Emanuele III donò la riserva allo Stato italiano perché ne facesse un parco che fu effettivamente istituito nel 1922.

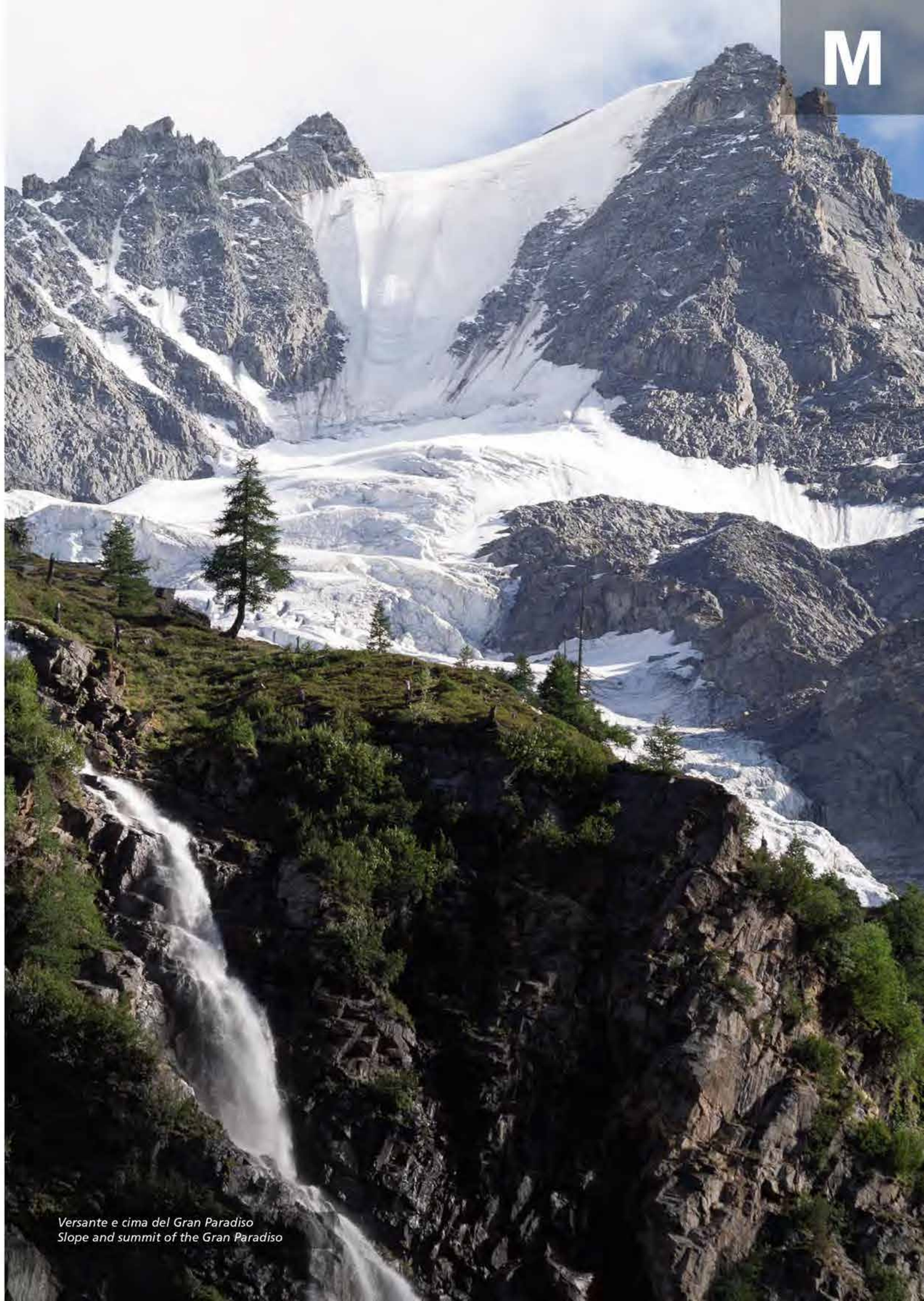
La montagna piemontese costituisce un'importante risorsa per il sistema economico e sociale regionale. I beni naturali e paesaggistici fruibili attraverso un turismo ambientalmente sostenibile, le produzioni agricole, le tipicità agroalimentari e artigianali concorrono, attraverso il contributo delle piccole imprese presenti, delle associazioni dei professionisti della montagna e degli amministratori locali, a formare un patrimonio per la crescita sostenibile.
La Regione Piemonte sta investendo per valorizzarne le peculiarità, promuoverne lo sviluppo sociale ed economico.
Centrali sono gli ambiti energetico e ambientale, con progetti che puntano a investire su impianti di energia rinnovabile così da portare il Piemonte ad essere una delle Regioni più green d'Italia e d'Europa. Le linee guida sono chiare: con la legge regionale dell'aprile 2019 sono state riconosciute le specificità delle aree montane, dove si stanno portando avanti progetti di efficienza energetica.

Moltissimi piccoli borghi della montagna piemontese sono tornati alla vita. Non tantissimi anni fa, nonostante la bellezza della natura circostante, molti erano solo una manciata di case di pietra disabitate. Oggi, grazie a interventi di riqualificazione, gli edifici diroccati sono stati rimessi a nuovo per ospitare imprese, turisti, ma anche persone che hanno fatto di queste baite la loro casa.
Per ripopolare i borghi in montagna, e in generale le aree a rischio spopolamento servono anzitutto servizi, dalla viabilità ai servizi per i cittadini; che facciano da incentivo per chi vuole andarci ad abitare e questo genera un circolo virtuoso.

One of Piedmont's highest mountains is Gran Paradiso. The name derives from the Val d'Aosta dialect term *Granta Parei*, meaning great wall.
The Gran Paradiso National Park, a regional treasure just a few kilometres from our UFS headquarters, covers 70,000 hectares of high mountains, ranging from 800 metres in the valley to 4,061 metres at the summit.
The story of the park is linked to the conservation of the Alpine ibex. In 1856, King Victor Emmanuel II declared these mountains a royal hunting reserve, and thus saved the Alpine ibex from extinction. The king also created a specialist guard corps and ordered the construction of a network of roads, to protect the area's fauna and facilitate excursions. In 1920, Victor Emmanuel donated the reserve to the Italian state to create a national park, which was established in 1922.

The Piedmont mountains are an important resource for the region's economy and society. Natural spaces and landscapes enjoyed through environmentally sustainable tourism, agriculture, food products and handicrafts combine to form a legacy for sustainable growth, thanks to the contribution of small businesses, associations of mountain professionals and local administrations.
The Piedmont Region is investing to promote these special qualities and encourage social and economic development.
Energy and the environment are key, with projects focusing investment on renewable energy production, making Piedmont one of the greenest regions in Italy and Europe. The guidelines are clear: the regional law of April 2019 recognised the special nature of the mountain areas, where energy efficiency projects are ongoing.

A large number of small villages in the mountains of Piedmont have returned to life. Not so many years ago, despite their stunning natural surroundings, many of these were reduced to a handful of abandoned stone houses. Today, thanks to redevelopment schemes, derelict buildings have been rebuilt to house businesses and tourists, but also local people who have made these hamlets their homes.
To repopulate mountain villages - and places at risk of abandonment in general - the first thing needed is services, from roads to amenities for residents; these can be an incentive for those seeking to live here, creating a virtuous circle.

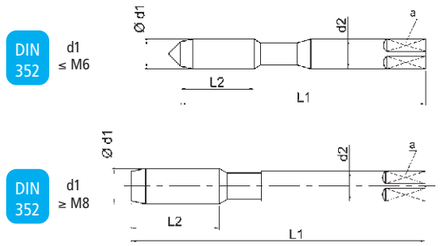


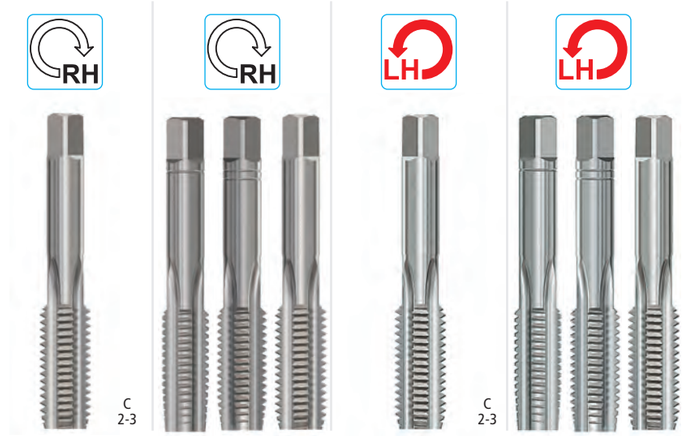
Versante e cima del Gran Paradiso
Slope and summit of the Gran Paradiso

M

MASCHI A MANO - Per fori ciechi e passanti in serie di tre pezzi
HAND TAPS - For blind and through holes in sets of three pieces
TARAUDS À MAIN - Pour trous borgnes et débouchant en jeux de trois pièces

DIN13 | USO GENERALE - GENERAL PURPOSE - USAGE GÉNÉRAL





Profondità di filettatura - Thread depth - Prof. de filetage	**2xD**	**2xD**	**2xD**	**2xD**
Materiale - Tool Material - Substrat	**HSS**	**HSS**	**HSS**	**HSS**
Tolleranza - Thread tolerance - Tolérance du filetage	**ISO2/6H**	**ISO2/6H**	**ISO2/6H**	**ISO2/6H**
Trattamento superficiale - Surface treatment - Revêtement				

DIN 352	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		Finitore Bottoming - Finisseur	Serie Set - Jeu	Finitore Bottoming - Finisseur	Serie Set - Jeu
◀	**2**	**0,4**	36	8	2,8	2,1	3	1,6	03M2	00M2	-	-
◀	**2,5**	**0,45**	40	9	2,8	2,1	3	2,05	03M2,5	00M2,5	-	-
◀	**3**	**0,5**	40	9	3,5	2,7	3	2,5	03M3	00M3	03M3LH	00M3LH
◀	**4**	**0,7**	45	11	4,5	3,4	3	3,3	03M4	00M4	03M4LH	00M4LH
◀	**5**	**0,8**	50	13	6	4,9	3	4,2	03M5	00M5	03M5LH	00M5LH
◀	**6**	**1**	56	15	6	4,9	3	5	03M6	00M6	03M6LH	00M6LH
	8	**1,25**	63	19	6	4,9	3	6,8	03M8	00M8	03M8LH	00M8LH
	10	**1,5**	70	22	7	5,5	3	8,5	03M10	00M10	03M10LH	00M10LH
	12	**1,75**	75	28	9	7	4	10,3	03M12	00M12	03M12LH	00M12LH
	14	**2**	80	30	11	9	4	12	03M14	00M14	03M14LH	00M14LH
	16	**2**	80	30	12	9	4	14	03M16	00M16	03M16LH	00M16LH
	18	**2,5**	95	34	14	11	4	15,5	03M18	00M18	-	-
	20	**2,5**	95	34	16	12	4	17,5	03M20	00M20	-	-
	22	**2,5**	100	34	18	14,5	4	19,5	03M22	00M22	-	-
	24	**3**	110	38	18	14,5	4	21	03M24	00M24	-	-
	27	**3**	110	38	20	16	4	24	03M27	00M27	-	-
	30	**3,5**	125	45	22	18	4	26,5	03M30	00M30	-	-
	36	**4**	150	55	28	22	4	32	03M36	00M36	-	-

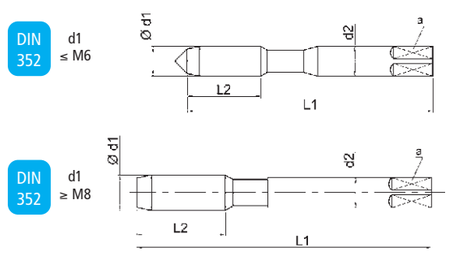
ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali Material groups Groupes de matières				
P	Acciaio - Steel - Acier - Rm ≤ 850 N/mm²	•1.1	•1.2	•1.3	•1.4	
M	Acciaio INOX – Stainless steel - Acier inoxydable	◦2.1	◦2.2	◦2.3		
K	Ghisa - Cast iron - Fonte	◦3.1	◦3.4			
N	Leghe di Allumino – Al alloys - Alliage Al	•4.1	•4.2	•4.3	◦4.4	
N	Leghe di Rame - Copper alloys - Alliages de cuivre	•5.1	•5.2	◦5.3		

• Raccomandato - Optimal - Recommandé ◦ Adatto - Suitable - Adaptè

M

MASCHI A MANO - Per fori ciechi e passanti in serie di tre pezzi
HAND TAPS - For blind and through holes in sets of three pieces
TARAUDS À MAIN - Pour trous borgnes et débouchant en jeux de 3 pièces

DIN13 | INOX | ACCIAIO INOSSIDABILE - STAINLESS STEEL - ACIER INOXYDABLE



Profondità di filettatura - Thread depth - Prof. de filetage	**2xD**	**2xD**
Materiale - Tool Material - Substrat	**HSSE**	**HSSE**
Tolleranza - Thread tolerance - Tolérance du filetage	**6HX**	**6HX**
Trattamento superficiale - Surface treatment - Revêtement	**VS**	**VS**

DIN 352	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		Finitore Bottoming - Finisseur	Serie Set - Jeu
◀	**3**	**0,5**	40	9	3,5	2,7	3	2,5	03M3X-VS	00M3X-VS
◀	**4**	**0,7**	45	11	4,5	3,4	3	3,3	03M4X-VS	00M4X-VS
◀	**5**	**0,8**	50	13	6	4,9	3	4,2	03M5X-VS	00M5X-VS
◀	**6**	**1**	56	15	6	4,9	3	5	03M6X-VS	00M6X-VS
	8	**1,25**	63	19	6	4,9	3	6,8	03M8X-VS	00M8X-VS
	10	**1,5**	70	22	7	5,5	3	8,5	03M10X-VS	00M10X-VS
	12	**1,75**	75	28	9	7	4	10,3	03M12X-VS	00M12X-VS
	14	**2**	80	30	11	9	4	12	03M14X-VS	00M14X-VS
	16	**2**	80	30	12	9	4	14	03M16X-VS	00M16X-VS

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali Material groups Groupes de matières				
P	Acciaio - Steel - Acier - Rm ≤ 1000 N/mm²	•1.1	•1.2	•1.3	•1.4	◦1.5
M	Acciaio INOX – Stainless steel - Acier inoxydable	•2.1	•2.2	•2.3		
K	Ghisa - Cast iron - Fonte	•3.1	◦3.2	◦3.3	•3.4	
N	Leghe di Allumino – Al alloys - Alliage Al	•4.1	•4.2	•4.3	•4.4	
N	Leghe di Rame - Copper alloys - Alliages de cuivre	•5.1	•5.2	•5.3		

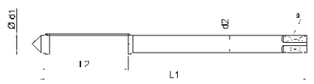
• Raccomandato - Optimal - Recommandé ◦ Adatto - Suitable - Adaptè

M

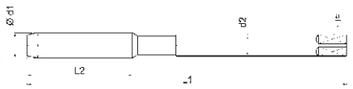
MASCHI A MACCHINA PER DADI - Scanalature diritte
MACHINE NUT TAPS - Straight flutes
TARAUDS MACHINE POUR ÉCROUS - Goujures droites

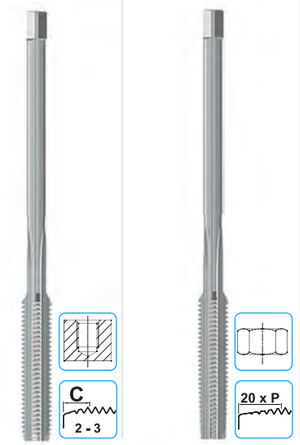
DIN13 | USO GENERALE - GENERAL PURPOSE - USAGE GÉNÉRAL

DIN 357 d1 ≤ M6



DIN 357 d1 ≥ M8





Profondità di filettatura - Thread depth - Prof. de filetage	**1,5xD**	**1,5xD**		
Materiale - Tool Material - Substrat	**HSSE**	**HSSE**		
Tolleranza - Thread tolerance - Tolérance du filetage	**ISO2/6H**	**ISO2/6H**		
Trattamento superficiale - Surface treatment - Revêtement				

DIN 357	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE	
◀	**3**	**0,5**	70	22	2,2	1,75	3	2,5	10FCM3	10FPM3
◀	**4**	**0,7**	90	25	2,8	2,1	3	3,3	10FCM4	10FPM4
◀	**5**	**0,8**	100	28	3,5	2,7	3	4,2	10FCM5	10FPM5
◀	**6**	**1**	110	32	4,5	3,4	3	5	10FCM6	10FPM6
	8	**1,25**	125	40	6	4,9	3	6,8	10FCM8	10FPM8
	10	**1,5**	140	45	7	5,5	3	8,5	10FCM10	10FPM10
	12	**1,75**	180	50	9	7	3	10,3	10FCM12	10FPM12
	14	**2**	200	56	11	9	3	12	10FCM14	10FPM14
	16	**2**	200	63	12	9	3	14	10FCM16	10FPM16

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min							
P	Acciaio - Steel - Acier - Rm ≤ 850 N/mm²	•1.1 10-15	•1.2 10-15	•1.3 10-12	◑1.4 8-10	•1.1 18-20	•1.2 15-18	•1.3 12-15	◑1.4 10-12

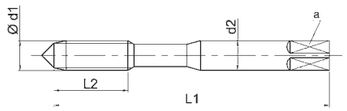
• Raccomandato - Optimal - Recommandé ◑ Adatto - Suitable - Adaptè

M

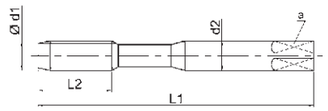
MASCHI A MACCHINA - Scanalature diritte per fori ciechi e passanti
MACHINE TAPS - Straight flutes for blind and through holes
TARAUDS MACHINE - Goujures droites pour trous borgnes et débouchant

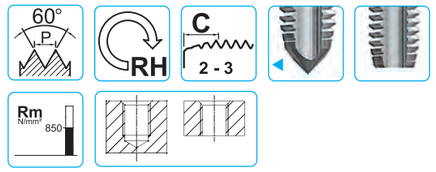
DIN13 | OT | OTTONE - BRASS - LAITON

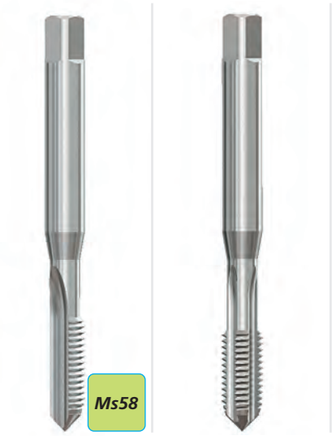
DIN 371 d1 ≤ M6



DIN 371 d1 ≥ M8







Profondità di filettatura - Thread depth - Prof. de filetage	**3xD**	**3xD**		
Materiale - Tool Material - Substrat	**HSSE**	**HSSE**		
Tolleranza - Thread tolerance - Tolérance du filetage	**ISO2/6H**	**ISO2/6H**		
Trattamento superficiale - Surface treatment - Revêtement				

DIN 371	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE	
◀	**3**	**0,5**	56	10	3,5	2,7	2	2,5	LANCIAM3	-
◀	**4**	**0,7**	63	13	4,5	3,4	2	3,3	LANCIAM4	-
◀	**5**	**0,8**	70	13	6	4,9	2	4,2	LANCIAM5	-
◀	**6**	**1**	80	16	6	4,9	2	5	LANCIAM6	-
	8	**1,25**	90	18	8	6,2	2	6,8	LANCIAM8	-
	10	**1,5**	100	20	10	8	2	8,5	LANCIAM10	-
◀	**3**	**0,5**	56	10	3,5	2,7	3	2,5		E20M3-OT
◀	**4**	**0,7**	63	13	4,5	3,4	3	3,3		E20M4-OT
◀	**5**	**0,8**	70	13	6	4,9	3	4,2		E20M5-OT
◀	**6**	**1**	80	16	6	4,9	3	5		E20M6-OT
	8	**1,25**	90	18	8	6,2	3	6,8		E20M8-OT
	10	**1,5**	100	20	10	8	3	8,5		E20M10-OT

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min							
N	Leghe di Rame - Copper alloys - Alliages de cuivre	•5.3 15-20				•5.3 15-20			
N	Materiali termoindurenti Duroplastic - Thermodurcissables	◑8.2 8-10	◑8.3 3-50			◑8.2 8-10	◑8.3 3-50		

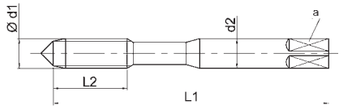
• Raccomandato - Optimal - Recommandé ◑ Adatto - Suitable - Adaptè

M

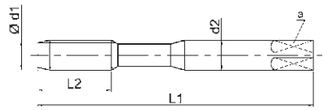
MASCHI A MACCHINA - Scanalature diritte per fori ciechi e passanti
MACHINE TAPS - Straight flutes for blind and through holes
TARAUDS MACHINE - Goujures droites pour trous borgnes et débouchant

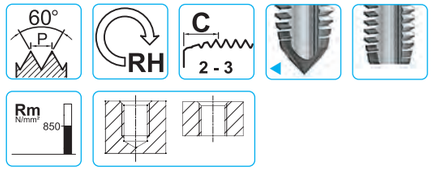
DIN13 | USO GENERALE - GENERAL PURPOSE - USAGE GÉNÉRAL

DIN 371 d1 ≤ M7



DIN 371 d1 ≥ M8





Profondità di filettatura - Thread depth - Prof. de filetage	**1,5xD**	**1,5xD**	
Materiale - Tool Material - Substrat	**HSSE**	**HSSE**	
Tolleranza - Thread tolerance - Tolérance du filetage	**ISO2/6H**	**ISO2/6H**	
Trattamento superficiale - Surface treatment - Revêtement		**TiN**	

DIN 371	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z	
◀	**1**	**0,25**	40	5	2,5	2,1	-	0,75
◀	**1,2**	**0,25**	40	5	2,5	2,1	-	0,95
◀	**1,4**	**0,3**	40	7	2,5	2,1	-	1,1
◀	**1,6**	**0,35**	40	8	2,5	2,1	-	1,25
◀	**1,7**	**0,35**	40	8	2,5	2,1	-	1,35
◀	**1,8**	**0,35**	40	8	2,5	2,1	-	1,45
◀	**2**	**0,4**	45	10	2,8	2,1	3	1,6
◀	**2,2**	**0,45**	45	10	2,8	2,1	3	1,75
◀	**2,5**	**0,45**	50	13	2,8	2,1	3	2,05
◀	**2,6**	**0,45**	50	13	2,8	2,1	3	2,15
◀	**3**	**0,5**	56	10	3,5	2,7	3	2,5
◀	**3,5**	**0,6**	56	11	4	3	3	2,9
◀	**4**	**0,7**	63	13	4,5	3,4	3	3,3
◀	**4,5**	**0,75**	70	13	6	4,9	3	3,7
◀	**5**	**0,8**	70	13	6	4,9	3	4,2
◀	**6**	**1**	80	16	6	4,9	3	5
◀	**7**	**1**	80	16	7	5,5	3	6
	8	**1,25**	90	18	8	6,2	3	6,8
	9	**1,25**	90	18	9	7	3	7,8
	10	**1,5**	100	20	10	8	3	8,5

CODE	
E20M1	-
E20M1,2	-
E20M1,6	-
E20M1,7	-
E20M1,8	-
E20M2	-
E20M2,2	-
E20M2,5	-
E20M2,6	-
E20M3	E20M3T
E20M3,5	E20M3,5T
E20M4	E20M4T
E20M4,5	E20M4,5T
E20M5	E20M5T
E20M6	E20M6T
E20M7	E20M7T
E20M8SP	E20M8SP-T
E20M9	E20M9T
E20M10SP	E20M10SP-T

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min							
P	Acciaio - Steel - Acier - Rm ≤ 850 N/mm²	❍1.1 10-15	•1.2 10-15	•1.3 10-12	❍1.4 8-10	•1.1 20-30	•1.2 20-30	•1.3 20-25	•1.4 15-20
K	Ghisa - Cast iron - Fonte	❍3.4 8-10				❍3.4 15-20			
N	Leghe di Allumino - Al alloys - Alliage Al	❍4.2 15-20	❍4.3 10-15			❍4.2 25-30	❍4.3 20-25		
N	Leghe di Rame - Copper alloys - Alliages de cuivre	❍5.2 10-15	❍5.3 15-20			❍5.2 20-25	❍5.3 25-30		
N	Materiali termoindurenti Duroplastic - Thermodurcissables	❍8.2 8-10				❍8.2 10-15			

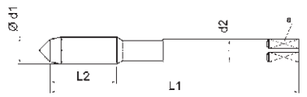
• Raccomandato - Optimal - Recommandé ❍ Adatto - Suitable - Adaptè

M

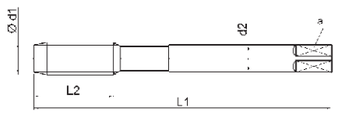
MASCHI A MACCHINA - Scanalature diritte per fori ciechi e passanti
MACHINE TAPS - Straight flutes for blind and through holes
TARAUDS MACHINE - Goujures droites pour trous borgnes et débouchant

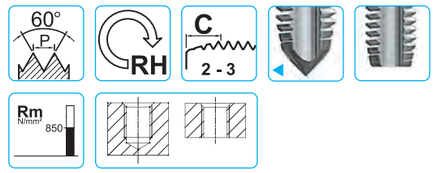
DIN13 | USO GENERALE - GENERAL PURPOSE - USAGE GÉNÉRAL

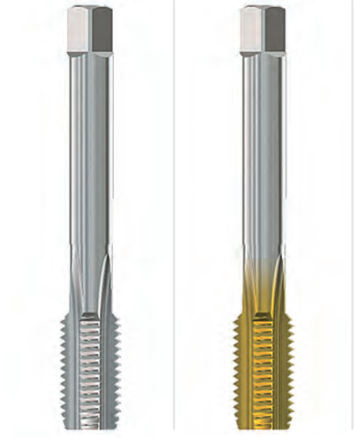
DIN 376 d1 ≤ M6



DIN 376 d1 ≥ M8







Profondità di filettatura - Thread depth - Prof. de filetage	**1,5xD**	**1,5xD**	
Materiale - Tool Material - Substrat	**HSSE**	**HSSE**	
Tolleranza - Thread tolerance - Tolérance du filetage	**ISO2/6H**	**ISO2/6H**	
Trattamento superficiale - Surface treatment - Revêtement		**TiN**	

DIN 376	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z	
◀	**4**	**0,7**	63	13	2,8	2,1	3	3,3
◀	**5**	**0,8**	70	13	3,5	2,7	3	4,2
◀	**6**	**1**	80	16	4,5	3,4	3	5
	8	**1,25**	90	18	6	4,9	3	6,8
	10	**1,5**	100	20	7	5,5	3	8,5
	11	**1,5**	100	20	8	6,2	3	9,5
	12	**1,75**	110	25	9	7	3	10,3
	14	**2**	110	28	11	9	3	12
	16	**2**	110	28	12	9	3	14
	18	**2,5**	125	33	14	11	4	15,5
	20	**2,5**	140	33	16	12	4	17,5
	22	**2,5**	140	33	18	14,5	4	19,5
	24	**3**	160	39	18	14,5	4	21
	27	**3**	160	39	20	16	4	24
	30	**3,5**	180	46	22	18	4	26,5
	33	**3,5**	180	46	25	20	4	29,5
	36	**4**	200	50	28	22	4	32
	39	**4**	200	50	32	24	4	35
	42	**4,5**	200	55	32	24	5	37,5
■	**45**	**4,5**	220	60	36	29	5	40,5
■	**48**	**5**	250	65	36	29	6	43
■	**52**	**5**	250	65	40	32	6	47

■ = HSS

CODE	
E21M4	E21M4T
E21M5	E21M5T
E21M6	E21M6T
E21M8SP	E21M8SP-T
E21M10SP	E21M10SP-T
E21M11	E21M11T
E21M12	E21M12T
E21M14	E21M14T
E21M16	E21M16T
E21M18	E21M18T
E21M20	E21M20T
E21M22	E21M22T
E21M24	E21M24T
E21M27	E21M27T
E21M30	E21M30T
E21M33	E21M33T
E21M36	E21M36T
E21M39	E21M39T
E21M42	E21M42T
E21M45	E21M45T
E21M48	E21M48T
E21M52	E21M52T

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min							
P	Acciaio - Steel - Acier - Rm ≤ 850 N/mm²	❍1.1 10-15	•1.2 10-15	•1.3 10-12	❍1.4 8-10	•1.1 20-30	•1.2 20-30	•1.3 20-25	•1.4 15-20
K	Ghisa - Cast iron - Fonte	❍3.4 8-10				❍3.4 15-20			
N	Leghe di Allumino - Al alloys - Alliage Al	❍4.2 15-20	❍4.3 10-15			❍4.2 25-30	❍4.3 20-25		
N	Leghe di Rame - Copper alloys - Alliages de cuivre	❍5.2 10-15	❍5.3 15-20			❍5.2 20-25	❍5.3 25-30		
N	Materiali termoindurenti Duroplastic - Thermodurcissables	❍8.2 8-10				❍8.2 10-15			

• Raccomandato - Optimal - Recommandé ❍ Adatto - Suitable - Adaptè

M

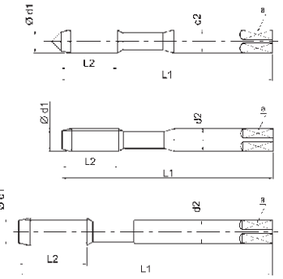
MASCHI A MACCHINA - Scanalature diritte filettatura sinistra
MACHINE TAPS - Straight flutes left thread
TARAUDS MACHINE - Goujures droites filetage à gauche

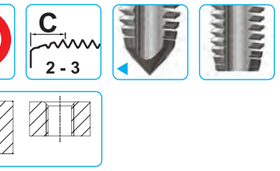
DIN13 | USO GENERALE - GENERAL PURPOSE - USAGE GÉNÉRAL

DIN 371 d1 ≤ M6

DIN 371 d1 =M8, M10

DIN 376 d1 ≥ M12





Profondità di filettatura - Thread depth - Prof. de filetage	**1,5xD**				
Materiale - Tool Material - Substrat	**HSSE**				
Tolleranza - Thread tolerance - Tolérance du filetage	**ISO2/6H**				
Trattamento superficiale - Surface treatment - Revêtement					

DIN 371	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE
◀	**3**	**0,5**	56	10	3,5	2,7	3	2,5	E20M3LH
◀	**4**	**0,7**	63	13	4,5	3,4	3	3,3	E20M4LH
◀	**5**	**0,8**	70	13	6	4,9	3	4,2	E20M5LH
◀	**6**	**1**	80	16	6	4,9	3	5	E20M6LH
	8	**1,25**	90	18	8	6,2	3	6,8	E20M8LH-SP
	10	**1,5**	100	20	10	8	3	8,5	E20M10LH-SP

DIN 376	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE
	12	**1,75**	110	25	9	7	3	10,3	E21M12LH
	14	**2**	110	28	11	9	3	12	E21M14LH
	16	**2**	110	28	12	9	3	14	E21M16LH
	18	**2,5**	125	33	14	11	4	15,5	E21M18LH
	20	**2,5**	140	33	16	12	4	17,5	E21M20LH
	22	**2,5**	140	33	18	14,5	4	19,5	E21M22LH
	24	**3**	160	39	18	14,5	4	21	E21M24LH
	27	**3**	160	39	20	16	4	24	E21M27LH
	30	**3,5**	180	46	22	18	4	26,5	E21M30LH

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min				
P	Acciaio - Steel - Acier - Rm ≤ 850 N/mm²	◑1.1 10-15	•1.2 10-15	•1.3 10-12	◑1.4 8-10	
K	Ghisa - Cast iron - Fonte	◑3.4 8-10				
N	Leghe di Allumino - Al alloys - Alliage Al	◑4.2 15-20	◑4.3 10-15			
N	Leghe di Rame - Copper alloys - Alliages de cuivre	◑5.2 10-15	◑5.3 15-20			
N	Materiali termoindurenti Duroplastic - Thermodurcissables	◑8.2 8-10				

• Raccomandato - Optimal - Recommandé ◑ Adatto - Suitable - Adaptè

M

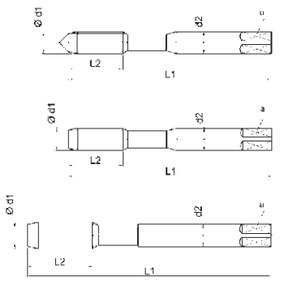
MASCHI A MACCHINA - Scanalature diritte filetti alternati
MACHINE TAPS - Straight flutes interrupted threads
TARAUDS MACHINE - Goujures droites filets alternés

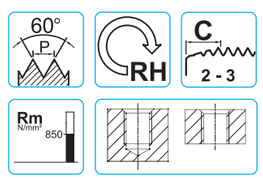
DIN13 | AL-CU-FE | ALLUMINIO, RAME, FERRO - ALUMINIUM, COPPER, IRON - ALUMINIUM, CUIVRE, FER

DIN 371 d1 ≤ M7

DIN 371 d1 =M8, M10

DIN 376 d1 ≥ M12





Profondità di filettatura - Thread depth - Prof. de filetage	**1,5xD**	**1,5xD**	
Materiale - Tool Material - Substrat	**HSSE**	**HSSE**	
Tolleranza - Thread tolerance - Tolérance du filetage	**ISO2/6H**	**ISO2/6H**	
Trattamento superficiale - Surface treatment - Revêtement		**V**	

DIN 371	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE	
◀	**3**	**0,5**	56	10	3,5	2,7	3	2,5	E20M3AZ	E20M3AZ-V
◀	**4**	**0,7**	63	13	4,5	3,4	3	3,3	E20M4AZ	E20M4AZ-V
◀	**5**	**0,8**	70	13	6	4,9	3	4,2	E20M5AZ	E20M5AZ-V
◀	**6**	**1**	80	16	6	4,9	3	5	E20M6AZ	E20M6AZ-V
◀	**7**	**1**	80	16	7	5,5	3	6	E20M7AZ	E20M7AZ-V
	8	**1,25**	90	18	8	6,2	3	6,8	E20M8AZ-SP	E20M8AZ-SP-V
	10	**1,5**	100	20	10	8	3	8,5	E20M10AZ-SP	E20M10AZ-SP-V

DIN 376	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE	
	12	**1,75**	110	25	9	7	3	10,3	E21M12AZ	E21M12AZ-V
	14	**2**	110	28	11	9	3	12	E21M14AZ	E21M14AZ-V
	16	**2**	110	28	12	9	3	14	E21M16AZ	E21M16AZ-V

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min			
P	Acciaio - Steel - Acier - Rm ≤ 400 N/mm²	•1.1 10-15		•1.1 10-15	
N	Leghe di Allumino - Al alloys - Alliage Al	•4.1 10-15	•4.2 15-20	•4.1 10-15	•4.2 15-20
N	Leghe di Rame - Copper alloys - Alliages de cuivre	•5.1 8-12	•5.2 15-15	•5.1 8-12	•5.2 15-15
N	Materiali termoindurenti Duroplastic - Thermodurcissables	◑8.1 20-25		◑8.1 20-25	

• Raccomandato - Optimal - Recommandé ◑ Adatto - Suitable - Adaptè

M

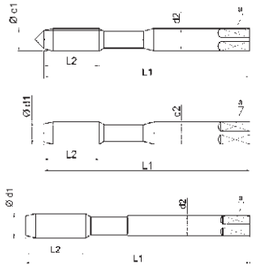
MASCHI A MACCHINA - Scanalature diritte per ghisa
MACHINE TAPS - Straight flutes for cast iron
TARAUDS MACHINE - Goujures droites pour fonte

DIN13 | GG | GHISA - CAST IRON - FONTE

DIN 371 d1 ≤ M6

DIN 371 d1 ≤ M10

DIN 376 d1 ≥ M8



Profondità di filettatura - Thread depth - Prof. de filetage	3xD	3xD	3,5xD
Materiale - Tool Material - Substrat	HSSE	HSSE	HSSE
Tolleranza - Thread tolerance - Tolérance du filetage	6HX	6HX	6HX
Trattamento superficiale - Surface treatment - Revêtement	NQ	TiCN	TiCN

DIN 371	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z	
◀	3	0,7	56	10	3,5	2,7	3	2,5
◀	4	0,7	63	13	4,5	3,4	3	3,3
◀	5	0,8	70	13	6	4,9	3	4,2
◀	6	1	80	16	6	4,9	3	5
	6	1	80	16	6	4,9	3	5
	8	1,25	90	18	8	6,2	4	6,8
	9	1,25	90	18	9	7	4	7,8
	10	1,5	100	20	10	8	4	8,5

CODE		
-	E26M3CT	
-	E26M4CT	
E26M5NQ	E26M5CT	
E26M6NQ	E26M6CT	
-	E26M6SP-CT	E26M6FOR-CT
E26M8SP-NQ	E26M8SP-CT	E26M8FOR-CT
-	E26M9CT	-
E26M10SP-NQ	E26M10SP-CT	E26M10FOR-CT

DIN 376 d1 ≥ M8

DIN 376	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z	
	8	1,25	90	18	6	4,9	4	6,8
	10	1,5	100	20	7	5,5	4	8,5
	12	1,75	110	25	9	7	4	10,3
	14	2	110	28	11	9	4	12
	16	2	110	28	12	9	4	14
	18	2,5	125	33	14	11	4	15,5
	20	2,5	140	33	16	12	4	17,5
	22	2,5	140	33	18	14,5	4	19,5
	24	3	160	39	18	14,5	4	21
	27	3	160	39	20	16	4	24
	30	3,5	180	46	22	18	4	26,5

CODE		
E27M8SP-NQ	E27M8SP-CT	-
E27M10SP-NQ	E27M10SP-CT	-
E27M12NQ	E27M12CT	E27M12FOR-CT
-	E27M14CT	E27M14FOR-CT
E27M16NQ	E27M16CT	E27M16FOR-CT
-	E27M18CT	E27M18FOR-CT
-	E27M20CT	E27M20FOR-CT
-	E27M22CT	E27M22FOR-CT
-	E27M24CT	E27M24FOR-CT
-	E27M27CT	-
-	E27M30CT	-

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min											
K	Ghisa - Cast iron - Fonte	•3.1 10-15	•3.2 8-10	❍3.3 8-10	❍3.4 10-15	•3.1 20-25	•3.2 15-20	❍3.3 15-20	❍3.4 20-25	•3.1 20-25	•3.2 15-20	❍3.3 15-20	❍3.4 20-25
N	Leghe Al, Si > 10% Al alloys, Si > 10% - Alliage Al, Si > 10%	•4.4 10-15				•4.4 25-30				•4.4 25-30			
N	Leghe di magnesio Magnesium alloys - Alliages de magnésium	•4.5 10-15				•4.5 20-30				•4.5 20-30			
N	Leghe di Rame - Copper alloys - Alliages de cuivre	•5.3 18-20				•5.3 25-30				•5.3 25-30			
N	Materiali termoindurenti Duroplastic - Thermodurcissables	•8.2 8-10				•8.2 10-15				•8.2 10-15			

• Raccomandato - Optimal - Recommandé ❍ Adatto - Suitable - Adaptè

M

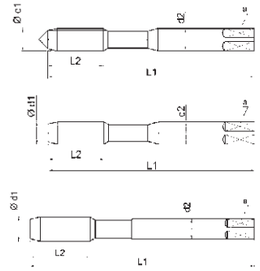
MASCHI A MACCHINA - Scanalature diritte per ghisa
MACHINE TAPS - Straight flutes for cast iron
TARAUDS MACHINE - Goujures droites pour fonte

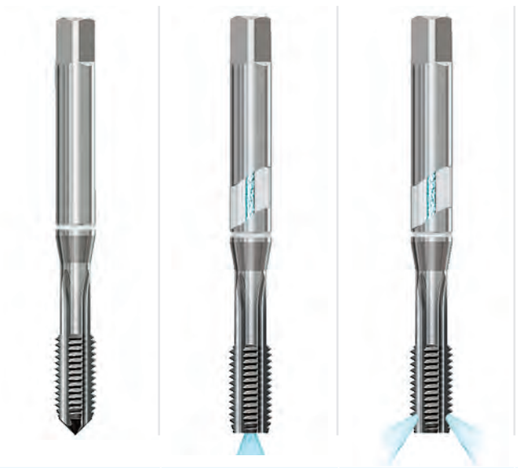
DIN13 | GG | GHISA - CAST IRON - FONTE

DIN 371 d1 ≤ M6

DIN 371 d1 ≤ M10

DIN 376 d1 ≥ M12





Profondità di filettatura - Thread depth - Prof. de filetage	3xD	3,5xD	3,5xD
Materiale - Tool Material - Substrat	PM3	PM3	PM3
Tolleranza - Thread tolerance - Tolérance du filetage	6HX	6HX	6HX
Trattamento superficiale - Surface treatment - Revêtement	TiAlN	TiAlN	TiAlN

DIN 371	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z	
◀	4	0,7	63	13	4,5	3,4	3	3,3
◀	5	0,8	70	13	6	4,9	3	4,2
◀	6	1	80	16	6	4,9	4	5
	8	1,25	90	18	8	6,2	4	6,8
	10	1,5	100	20	10	8	4	8,5
	6	1	80	16	6	4,9	4	5
	8	1,25	90	18	8	6,2	4	6,8
	10	1,5	100	20	10	8	4	8,5

CODE		
K26M4TX		
K26M5TX		
K26M6TX		
K26M8SP-TX		
K26M10SP-TX		
	K26M6FOR-TX	K26M6FORY-TX
	K26M8FOR-TX	K26M8FORY-TX
	K26M10FOR-TX	K26M10FORY-TX

DIN 376	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z	
	12	1,75	110	25	9	7	4	10,3
	14	2	110	28	11	9	4	12
	16	2	110	28	12	9	4	14
	18	2,5	125	33	14	11	5	15,5
	20	2,5	140	33	16	12	5	17,5
	22	2,5	140	33	18	14,5	5	19,5
	24	3	160	39	18	14,5	5	21

CODE		
K27M12TX	K27M12FOR-TX	K27M12FORY-TX
K27M14TX	K27M14FOR-TX	K27M14FORY-TX
K27M16TX	K27M16FOR-TX	K27M16FORY-TX
K27M18TX	K27M18FOR-TX	K27M18FORY-TX
K27M20TX	K27M20FOR-TX	K27M20FORY-TX
K27M22TX	K27M22FOR-TX	K27M22FORY-TX
K27M24TX	K27M24FOR-TX	K27M24FORY-TX

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min				
K	Ghisa - Cast iron - Fonte	•3.1 25-30	•3.2 20-25	❍3.3 20-25	❍3.4 25-30	•3.5 10-15

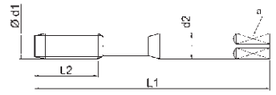
• Raccomandato - Optimal - Recommandé ❍ Adatto - Suitable - Adaptè

M

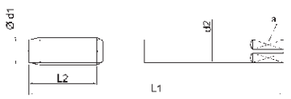
MASCHI A MACCHINA - Scanalature diritte per ghisa imbocco E
MACHINE TAPS - Straight flutes for cast iron chamfer E
TARAUDS MACHINE - Goujures droites pour fonte forme d'entrée E

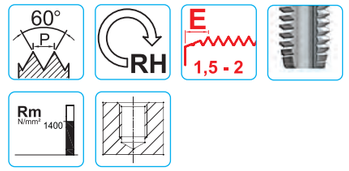
DIN13 | GG | GHISA - CAST IRON - FONTE

DIN 371 d1 ≤ M10



DIN 376 d1 ≥ M12





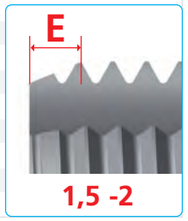
Profondità di filettatura - Thread depth - Prof. de filetage	3xD	3,5xD	3,5xD
Materiale - Tool Material - Substrat	PM3	PM3	PM3
Tolleranza - Thread tolerance - Tolérance du filetage	6HX	6HX	6HX
Trattamento superficiale - Surface treatment - Revêtement	AHI	AHI	AHI

DIN 371	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z	
	6	**1**	80	16	6	4,9	4	5
	8	**1,25**	90	18	8	6,2	4	6,8
	10	**1,5**	100	20	10	8	4	8,5

CODE		
K26EM6AHI	K26EM6FOR-AHI	K26EM6FORY-AHI
K26EM8AHI	K26EM8FOR-AHI	K26EM8FORY-AHI
K26EM10AHI	K26EM10FOR-AHI	K26EM10FORY-AHI

DIN 376	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z	
	12	**1,75**	110	25	9	7	4	10,3

CODE		
K27EM12AHI	K27EM12FOR-AHI	K27EM12FORY-AHI



ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min
K	Ghisa - Cast iron - Fonte	•3.1 20-25 · •3.2 15-20 · ❍3.3 15-20 · ❍3.4 20-25 · •3.5 10-15

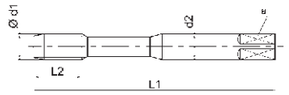
• Raccomandato - Optimal - Recommandé ❍ Adatto - Suitable - Adaptè

M

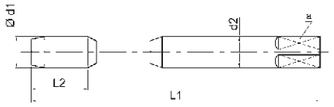
MASCHI A MACCHINA - Scanalature diritte
MACHINE TAPS - Straight flutes
TARAUDS MACHINE - Goujures droites

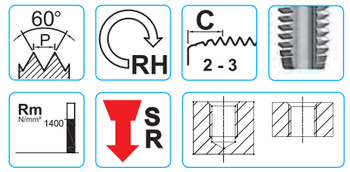
DIN13 | SYNCHRO RIGID | MASCHIATURA RIGIDA SINCRONIZZATA - RIGID TAPPING SYNCHRO - TARAUDAGE RIGIDE SYNCHRONISÉ

DIN 371 d1 ≤ M10



UFS Norm d1 ≥ M12





Profondità di filettatura - Thread depth - Prof. de filetage	3xD	3,5xD
Materiale - Tool Material - Substrat	PM3	PM3
Tolleranza - Thread tolerance - Tolérance du filetage	6HX	6HX
Trattamento superficiale - Surface treatment - Revêtement	TXC	TXC

DIN 371	Ød1 M	P mm	L_1	L_2	d_2 h6	a h12	Z	
	6	**1**	80	10	6	4,9	4	5
	8	**1,25**	90	13	8	6,2	4	6,8
	10	**1,5**	100	15	10	8	4	8,5

CODE	
S20M6SP-TXC	S20M6FOR-TXC
S20M8TXC	S20M8FOR-TXC
S20M10TXC	S20M10FOR-TXC

UFS Norm	Ød1 M	P mm	L_1	L_2	d_2 h6	a h12	Z	
	12	**1,75**	110	25	12	7	4	10,3
	16	**2**	110	20	16	12	4	14

CODE	
S20M12TXC	S20M12FOR-TXC
S20M16TXC	S20M16FOR-TXC

Dimensioni a norma di fabbrica
Dimensions according to standard factory
Dimensions selon la norme d'usine

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min
P	Acciaio - Steel - Acier - Rm ≤ 1400 N/mm²	❍1.5 10-15 · •1.6 8-10
K	Ghisa - Cast iron - Fonte	•3.1 25-30 · •3.2 20-25 · ❍3.3 20-25 · ❍3.4 25-30 · •3.5 10-15
N	Leghe di Allumino - Al alloys - Alliage Al	•4.4 25-30
N	Leghe di magnesio Magnesium alloys - Alliages de magnésium	•4.5 30-40
N	Leghe di Rame - Copper alloys - Alliages de cuivre	•5.3 35-40 · ❍5.4 8-10
N	Materiali termoindurenti Duroplastic - Thermodurcissables	•8.2 20-25 · •8.3 10-15

• Raccomandato - Optimal - Recommandé ❍ Adatto - Suitable - Adaptè

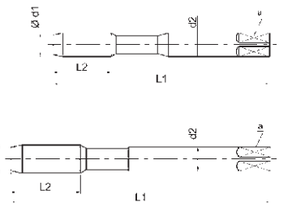
M

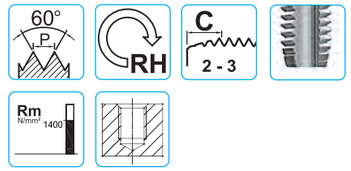
MASCHI A MACCHINA - Scanalature diritte - geometria di taglio rompitruciolo
MACHINE TAPS - Straight flutes - chip breaker cutting edge geometry
TARAUDS MACHINE - Goujures droites - géométrie brise copeaux

DIN13 | **RT** | ROMPITRUCIOLO - CHIP BREAKER - BRISE COPEAUX

DIN 371 d1 ≤ M10

DIN 376 d1 ≥ M12





Profondità di filettatura - Thread depth - Prof. de filetage	**3,5xD**			
Materiale - Tool Material - Substrat	**PM3**			
Tolleranza - Thread tolerance - Tolérance du filetage	**ISO2/6H**			
Trattamento superficiale - Surface treatment - Revêtement	**TXC**			

DIN 371	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE
	6	**1**	80	10	6	4,9	4	5	K22M6FOR-TXC
	8	**1,25**	90	13	8	6,2	4	6,8	K22M8FOR-TXC
	10	**1,5**	100	15	10	8	4	8,5	K22M10FOR-TXC

DIN 376	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE
	12	**1,75**	110	25	9	7	3	10,3	K23M12FOR-TXC
	14	**2**	110	28	11	9	3	12	K23M14FOR-TXC
	16	**2**	110	28	12	9	3	14	K23M16FOR-TXC
	18	**2,5**	125	33	14	11	3	15,5	K23M18FOR-TXC
	20	**2,5**	140	33	16	12	3	17,5	K23M20FOR-TXC
	22	**2,5**	140	33	18	14,5	3	19,5	K23M22FOR-TXC
	24	**3**	160	39	18	14,5	4	21	K23M24FOR-TXC

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min				
P	Acciaio - Steel - Acier - Rm ≤ 1400 N/mm²	•1.3 25-30	•1.4 20-25	•1.5 5-12	○1.6 5-8	
K	Ghisa - Cast iron - Fonte	○3.1 25-30	○3.2 20-25	•3.3 20-25	•3.4 25-30	
N	Leghe di Allumino - Al alloys - Alliage Al	○4.4 25-30				
N	Leghe di magnesio Magnesium alloys - Alliages de magnésium	○4.5 20-30				
N	Ottone a truciolo corto Hard brass short chipping - Laiton coupeaux courts	○5.3 25-30				
N	Materie plastiche con fibre di rinforzo - Reinforced plastic materials - Matiéres synthétiques renforcés par fibres	○8.3 6-10				

• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

M

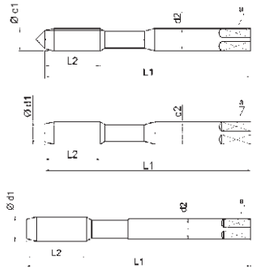
MASCHI A MACCHINA - Scanalature diritte per alta resistenza
MACHINE TAPS - Straight flutes for high resistance
TARAUDS MACHINE - Goujures droites pour haute résistance

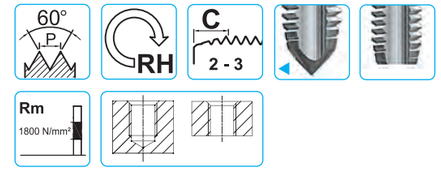
DIN13 | **HR** | ALTA RESISTENZA - HIGH RESISTANCE - HAUTE RÉSISTANCE

DIN 371 d1 ≤ M6

DIN 371 d1 ≤ M10

DIN 376 d1 ≥ M12





Profondità di filettatura - Thread depth - Prof. de filetage	**1,5xD**	**1,5xD**
Materiale - Tool Material - Substrat	**PM3**	**PM1**
Tolleranza - Thread tolerance - Tolérance du filetage	**6HX**	**6HX**
Trattamento superficiale - Surface treatment - Revêtement	**TXC**	**AHI**

DIN 371	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE
◄	**3**	**0,5**	56	10	3,5	2,7	3	2,5	K20M3TXC
◄	**4**	**0,7**	63	13	4,5	3,4	3	3,3	K20M4TXC
◄	**5**	**0,8**	70	13	6	4,9	3	4,2	K20M5TXC
◄	**6**	**1**	80	16	6	4,9	4	5	K20M6TXC
	8	**1,25**	90	18	8	6,2	4	6,8	K20M8TXC
	10	**1,5**	100	20	10	8	4	8,5	K20M10TXC

DIN 371	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE
	12	**1,75**	110	25	9	7	4	10,3	K21M12TXC
	14	**2**	110	28	11	9	4	12	K21M14TXC
	16	**2**	110	28	12	9	4	14	K21M16TXC

UFS Norm	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE
*	**6**	**1**	80	18	6	4,9	4	5	XT20M6AHI
*	**8**	**1,25**	90	25	8	6,2	5	6,8	XT20M8AHI
*	**10**	**1,5**	100	30	10	8	5	8,5	XT20M10AHI
*	**12**	**1,75**	110	30	12	9	5	10,3	XT20M12AHI

* Dimensioni a norma di fabbrica
Dimensions according to standard factory
Dimensions selon la norme d'usine

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min				
P	Acciaio - Steel – Acier < 45 HRC	○1.5 5-12	•1.6 5-8			
H	Acciaio temprato Hardened steel - Acier trempé < 52 HRC				•1.7 1-3	
N	Leghe di Allumino – Al alloys - Alliage Al	○4.3 30-40	•4.4 25-30			
N	Leghe di magnesio Magnesium alloys - Alliages de magnésium	•4.5 20-30				
N	Ottone a truciolo corto Hard brass short chipping – Laiton coupeaux courts	•5.3 25-30				
N	Bronzo ad alta resistenza High strength bronze - Bronze haute résistance	○5.4 5-8			•5.4 5-8	
N	Materie plastiche con fibre di rinforzo - Reinforced plastic materials - Matiéres synthétiques renforcés par fibres	•8.2 10-15	•8.3 6-10			

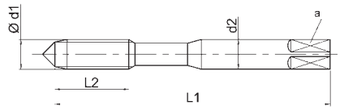
• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

M

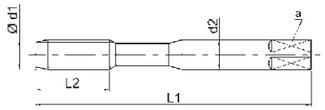
MASCHI A MACCHINA - Imbocco corretto per fori passanti
MACHINE TAPS - Straight flutes with spiral point for through holes
TARAUDS MACHINE - Goujures droites, entrée gun, pour trous débouchant

DIN13 — USO GENERALE - GENERAL PURPOSE - USAGE GÉNÉRAL

DIN 371 d1 ≤ M10



DIN 371 d1 =M9



Profondità di filettatura - Thread depth - Prof. de filetage	3xD	3xD	3xD	3xD
Materiale - Tool Material - Substrat	HSSE	HSSE	HSSE	HSSE
Tolleranza - Thread tolerance - Tolérance du filetage	ISO2/6H	ISO2/6H	ISO2/6H	ISO2/6H
Trattamento superficiale - Surface treatment - Revêtement		V	TiN	XP

DIN 371	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE			
◀	1	0,25	40	5	2,5	2,1	-	0,75	E24M1	-	-	-
◀	1,2	0,25	40	5	2,5	2,1	-	0,95	E24M1,2	-	-	-
◀	1,4	0,3	40	7	2,5	2,1	-	1,1	E24M1,4	-	-	-
◀	1,6	0,35	40	8	2,5	2,1	-	1,25	E24M1,6	-	-	-
◀	1,7	0,35	40	8	2,5	2,1	-	1,35	E24M1,7	-	-	-
◀	1,8	0,35	40	8	2,5	2,1	-	1,45	E24M1,8	-	-	-
◀	2	0,4	45	10	2,8	2,1	3	1,6	E24M2	E24M2V	-	* E24M2VS
◀	2,5	0,45	50	13	2,8	2,1	3	2,05	E24M2,5	E24M2,5V	-	* E24M2,5VS
◀	2,6	0,45	50	13	2,8	2,1	3	2,15	E24M2,6	E24M2,6V	-	* E24M2,6VS
◀	3	0,5	56	10	3,5	2,7	3	2,5	E24M3	E24M3V	E24M3T	E24M3XP
◀	3,5	0,6	56	11	4	3	3	2,9	E24M3,5	E24M3,5V	E24M3,5T	E24M3,5XP
◀	4	0,7	63	13	4,5	3,4	3	3,3	E24M4	E24M4V	E24M4T	E24M4XP
◀	4,5	0,75	70	13	6	4,9	3	3,7	E24M4,5	E24M4,5V	E24M4,5T	E24M4,5XP
◀	5	0,8	70	13	6	4,9	3	4,2	E24M5	E24M5V	E24M5T	E24M5XP
◀	6	1	80	16	6	4,9	3	5	E24M6	E24M6V	E24M6T	E24M6XP
◀	7	1	80	16	7	5,5	3	6	E24M7	E24M7V	E24M7T	E24M7XP
◀	8	1,25	90	18	8	6,2	3	6,8	E24M8	E24M8V	E24M8T	E24M8XP
	9	1,25	90	18	9	7	3	7,8	E24M9	E24M9V	E24M9T	E24M9XP
◀	10	1,5	100	20	10	8	3	8,5	E24M10	E24M10V	E24M10T	E24M10XP

* Rivestimento VS - Coating VS - Revêtement VS

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min															
P	Acciaio – Steel – Acier - Rm ≤ 850 N/mm²	○1.1 10-15	•1.2 10-15	•1.3 10-12	○1.4 8-10	•1.1 10-15	•1.2 10-15	•1.3 10-12	○1.4 8-10	•1.1 20-30	•1.2 20-30	•1.3 20-25	•1.4 15-20	•1.1 20-30	•1.2 20-30	•1.3 20-25	•1.4 15-20
M	Acciaio inox - Stainless steel - Acier inoxydable													○2.1 10-15	○2.2 8-10		
K	Ghisa - Cast iron - Fonte									○3.3 10-15	•3.4 15-20			○3.3 10-15	•3.4 15-20		
N	Leghe di Allumino – Al alloys - Alliage Al	○4.1 10-15	•4.2 15-20			•4.1 10-15	•4.2 15-20			○4.1 20-25	•4.2 25-30	○4.3 20-25		•4.2 25-30	○4.3 20-25		
N	Leghe di Rame - Copper alloys - Alliages de cuivre	○5.1 8-12	○5.2 10-15			•5.1 8-12	•5.2 10-15			•5.1 15-20	•5.2 20-25			•5.2 20-25			

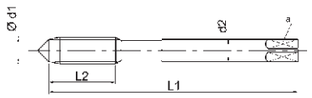
• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

M

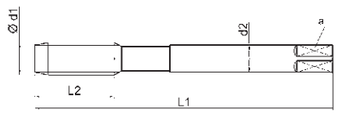
MASCHI A MACCHINA - Imbocco corretto per fori passanti
MACHINE TAPS - Straight flutes with spiral point for through holes
TARAUDS MACHINE - Goujures droites, entrée gun, pour trous débouchant

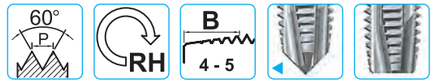
DIN13 — USO GENERALE - GENERAL PURPOSE - USAGE GÉNÉRAL

DIN 376 d1 ≤ M10



DIN 376 d1 ≥ M11





Profondità di filettatura - Thread depth - Prof. de filetage	3xD	3xD	3xD	3xD
Materiale - Tool Material - Substrat	HSSE	HSSE	HSSE	HSSE
Tolleranza - Thread tolerance - Tolérance du filetage	ISO2/6H	ISO2/6H	ISO2/6H	ISO2/6H
Trattamento superficiale - Surface treatment - Revêtement		V	TiN	XP

DIN 376	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE			
◀	4	0,7	63	13	2,8	2,1	3	3,3	E25M4	E25M4V	E25M4T	-
◀	5	0,8	70	13	3,5	2,7	3	4,2	E25M5	E25M5V	E25M5T	-
◀	6	1	80	16	4,5	3,4	3	5	E25M6	E25M6V	E25M6T	-
◀	8	1,25	90	18	6	4,9	3	6,8	E25M8	E25M8V	E25M8T	E25M8XP
◀	10	1,5	100	20	7	5,5	3	8,5	E25M10	E25M10V	E25M10T	E25M10XP
	11	1,5	100	20	8	6,2	3	9,5	E25M11	E25M11V	E25M11T	E25M11XP
	12	1,75	110	25	9	7	3	10,3	E25M12	E25M12V	E25M12T	E25M12XP
	14	2	110	28	11	9	3	12	E25M14	E25M14V	E25M14T	E25M14XP
	16	2	110	28	12	9	3	14	E25M16	E25M16V	E25M16T	E25M16XP
	18	2,5	125	33	14	11	4	15,5	E25M18	E25M18V	E25M18T	E25M18XP
	20	2,5	140	33	16	12	4	17,5	E25M20	E25M20V	E25M20T	E25M20XP
	22	2,5	140	33	18	14,5	4	19,5	E25M22	E25M22V	E25M22T	-
	24	3	160	39	18	14,5	4	21	E25M24	E25M24V	E25M24T	-
	27	3	160	39	20	16	4	24	E25M27	E25M27V	E25M27T	-
	30	3,5	180	46	22	18	4	26,5	E25M30	E25M30V	E25M30T	-
	33	3,5	180	46	25	20	4	29,5	E25M33	E25M33V	E25M33T	-
	36	4	200	50	28	22	4	32	E25M36	E25M36V	E25M36T	-
	39	4	200	50	32	24	4	35	E25M39	E25M39V	E25M39T	-
	42	4,5	200	55	32	24	5	37,5	E25M42	E25M42V	E25M42T	-
■	45	4,5	220	60	36	29	5	40,5	E25M45	E25M45V	E25M45T	-
■	48	5	250	65	36	29	5	43	E25M48	E25M48V	E25M48T	-
■	52	5	250	65	40	32	5	47	E25M52	E25M52V	E25M52T	-

■ = HSS

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min															
P	Acciaio – Steel – Acier - Rm ≤ 850 N/mm²	○1.1 10-15	•1.2 10-15	•1.3 10-12	○1.4 8-10	•1.1 10-15	•1.2 10-15	•1.3 10-12	○1.4 8-10	•1.1 20-30	•1.2 20-30	•1.3 20-25	•1.4 15-20	•1.1 20-30	•1.2 20-30	•1.3 20-25	•1.4 15-20
M	Acciaio inox - Stainless steel - Acier inoxydable													○2.1 10-15	○2.2 8-10		
K	Ghisa - Cast iron - Fonte									○3.3 10-15	•3.4 15-20			○3.3 10-15	•3.4 15-20		
N	Leghe di Allumino – Al alloys - Alliage Al	○4.1 10-15	•4.2 15-20			•4.1 10-15	•4.2 15-20			○4.1 20-25	•4.2 25-30	○4.3 20-25		•4.2 25-30	○4.3 20-25		
N	Leghe di Rame - Copper alloys - Alliages de cuivre	○5.1 8-12	○5.2 10-15			•5.1 8-12	•5.2 10-15			○5.1 15-20	•5.2 20-25			•5.2 20-25			

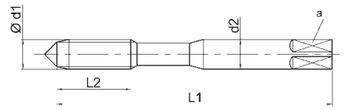
• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

M

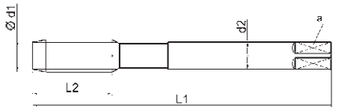
MASCHI A MACCHINA - Imbocco corretto per fori passanti filettatura sinistra
MACHINE TAPS - Straight flutes with spiral point for through holes left thread
TARAUDS MACHINE - Goujures droites, entrée gun, pour trous débouchant filetage à gauche

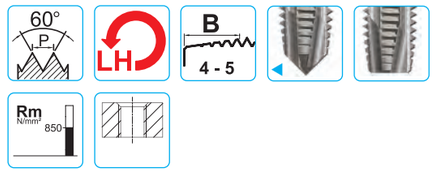
DIN13 — USO GENERALE - GENERAL PURPOSE - USAGE GÉNÉRAL

DIN 371 d1 ≤ M10



DIN 376 d1 ≥ M12





Profondità di filettatura - Thread depth - Prof. de filetage	3xD	3xD	3xD
Materiale - Tool Material - Substrat	HSSE	HSSE	HSSE
Tolleranza - Thread tolerance - Tolérance du filetage	ISO2/6H	ISO2/6H	ISO2/6H
Trattamento superficiale - Surface treatment - Revêtement		V	TiN

DIN 371	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE		
◀	3	0,5	56	10	3,5	2,7	3	2,5	-	-	-
◀	4	0,7	63	13	4,5	3,4	3	3,3	-	-	-
◀	5	0,8	70	13	6	4,9	3	4,2	E24M5LH	E24M5LH-V	E24M5LH-T
◀	6	1	80	16	6	4,9	3	5	E24M6LH	E24M6LH-V	E24M6LH-T
◀	8	1,25	90	18	8	6,2	3	6,8	E24M8LH	E24M8LH-V	E24M8LH-T
◀	10	1,5	100	20	10	8	3	8,5	E24M10LH	E24M10LH-V	E24M10LH-T

DIN 376	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE		
	12	1,75	110	25	9	7	3	10,3	E25M12LH	E25M12LH-V	E25M12LH-T
	14	2	110	28	11	9	3	12	E25M14LH	E25M14LH-V	E25M14LH-T
	16	2	110	28	12	9	3	14	E25M16LH	E25M16LH-V	E25M16LH-T
	18	2,5	125	33	14	11	4	15,5	E25M18LH	E25M18LH-V	E25M18LH-T
	20	2,5	140	33	16	12	4	17,5	E25M20LH	E25M20LH-V	E25M20LH-T
	22	2,5	140	33	18	14,5	4	19,5	E25M22LH	E25M22LH-V	E25M22LH-T
	24	3	160	39	18	14,5	4	21	E25M24LH	E25M24LH-V	E25M24LH-T
	27	3	160	39	20	16	4	24	E25M27LH	E25M27LH-V	E25M27LH-T
	30	3,5	180	46	22	18	4	26,5	E25M30LH	E25M30LH-V	E25M30LH-T

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min												
P	Acciaio - Steel - Acier - Rm ≤ 850 N/mm²	○1.1 10-15	•1.2 10-15	•1.3 10-12	○1.4 8-10	•1.1 10-15	•1.2 10-15	•1.3 10-12	○1.4 8-10	•1.1 20-30	•1.2 20-30	•1.3 20-25	•1.4 15-20	
K	Ghisa - Cast iron - Fonte									○3.3 10-15	•3.4 15-20			
N	Leghe di Allumino – Al alloys - Alliage Al	○4.1 10-15	•4.2 15-20			•4.1 10-15	•4.2 15-20			○4.1 20-25	•4.2 25-30	○4.3 20-25		
N	Leghe di Rame - Copper alloys - Alliages de cuivre	○5.1 8-12	○5.2 10-15			•5.1 8-12	•5.2 10-15			○5.1 15-20	•5.2 20-25			

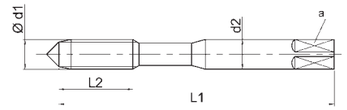
• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

M

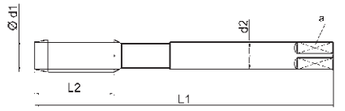
MASCHI A MACCHINA - Imbocco corretto per fori passanti toll. 4H e 6G
MACHINE TAPS - Straight flutes with spiral point for through holes tolerance 4H and 6G
TARAUDS MACHINE - Goujures droites, entrée gun, pour trous débouchant tolérance 4H et 6G

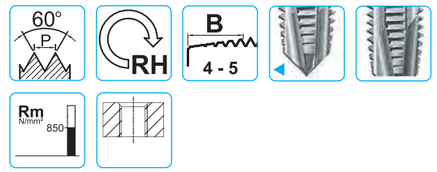
DIN13 — USO GENERALE - GENERAL PURPOSE - USAGE GÉNÉRAL

DIN 371 d1 ≤ M10



DIN 376 d1 ≥ M12





Profondità di filettatura - Thread depth - Prof. de filetage	3xD	3xD	3xD	3xD
Materiale - Tool Material - Substrat	HSSE	HSSE	HSSE	HSSE
Tolleranza - Thread tolerance - Tolérance du filetage	ISO1/4H	ISO1/4H	ISO3/6G	ISO3/6G
Trattamento superficiale - Surface treatment - Revêtement		TiN		TiN

DIN 371	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE			
◀	3	0,5	56	10	3,5	2,7	3	2,5	-	-	E24M3-6G	E24M3T-6G
◀	4	0,7	63	13	4,5	3,4	3	3,3	-	-	E24M4-6G	E24M4T-6G
◀	5	0,8	70	13	6	4,9	3	4,2	E24M5-4H	E24M5T-4H	E24M5-6G	E24M5T-6G
◀	6	1	80	16	6	4,9	3	5	E24M6-4H	E24M6T-4H	E24M6-6G	E24M6T-6G
◀	8	1,25	90	18	8	6,2	3	6,8	E24M8-4H	E24M8T-4H	E24M8-6G	E24M8T-6G
◀	10	1,5	100	20	10	8	3	8,5	E24M10-4H	E24M10T-4H	E24M10-6G	E24M10T-6G

DIN 376	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE			
	12	1,75	110	25	9	7	3	10,3	E25M12-4H	E25M12T-4H	E25M12-6G	E25M12T-6G

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min														
P	Acciaio - Steel - Acier - Rm ≤ 850 N/mm²	○1.1 10-15	•1.2 10-15	•1.3 10-12	○1.4 8-10	•1.1 20-30	•1.2 20-30	•1.3 20-25	•1.4 15-20	○1.1 10-15	•1.2 10-15	•1.3 10-12	○1.4 8-10	•1.1 20-30	•1.2 20-30	•1.3 20-25	•1.4 15-20
K	Ghisa - Cast iron - Fonte					○3.3 10-15	•3.4 15-20							○3.3 10-15	•3.4 15-20		
N	Leghe di Allumino – Al alloys - Alliage Al	○4.1 10-15	•4.2 15-20			○4.1 20-25	•4.2 25-30	○4.3 20-25		○4.1 10-15	•4.2 15-20			○4.1 20-25	•4.2 25-30	○4.3 20-25	
N	Leghe di Rame - Copper alloys - Alliages de cuivre	○5.1 8-12	○5.2 10-15			○5.1 15-20	•5.2 20-25			○5.1 8-12	○5.2 10-15			○5.1 15-20	•5.2 20-25		

• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

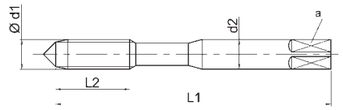
M

MASCHI A MACCHINA - Imbocco corretto per fori passanti toll. 7G e 6H+0,1
MACHINE TAPS - Straight flutes with spiral point for through holes tolerance 7G and 6H+0,1
TARAUDS MACHINE - Goujures droites, entrée gun, pour trous débouchant tolérance 7G et 6H+0,1

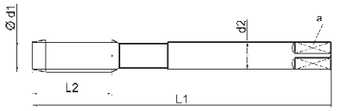
UFS LINE

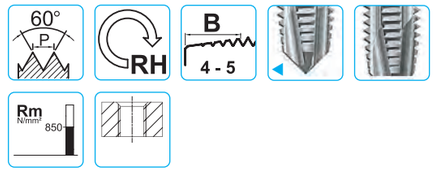
DIN13 — USO GENERALE - GENERAL PURPOSE - USAGE GÉNÉRAL

DIN 371 d1 ≤ M10



DIN 376 d1 ≥ M12





Profondità di filettatura - Thread depth - Prof. de filetage	3xD	3xD	3xD	3xD
Materiale - Tool Material - Substrat	HSSE	HSSE	HSSE	HSSE
Tolleranza - Thread tolerance - Tolérance du filetage	7G	7G	6H+0,1	6H+01
Trattamento superficiale - Surface treatment - Revêtement		TiN		TiN

DIN 371	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE			
◀	3	0,5	56	10	3,5	2,7	3	2,5	-	-	E24M3+0,1	E24M3T+0,1
◀	4	0,7	63	13	4,5	3,4	3	3,3	-	-	E24M4+0,1	E24M4T+0,1
◀	5	0,8	70	13	6	4,9	3	4,2	E24M5-7G	E24M5T-7G	E24M5+0,1	E24M5T+0,1
◀	6	1	80	16	6	4,9	3	5	E24M6-7G	E24M6T-7G	E24M6+0,1	E24M6T+0,1
◀	8	1,25	90	18	8	6,2	3	6,8	E24M8-7G	E24M8T-7G	E24M8+0,1	E24M8T+0,1
◀	10	1,5	100	20	10	8	3	8,5	E24M10-7G	E24M10T-7G	E24M10+0,1	E24M10T+0,1

DIN 376	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE			
	12	1,75	110	25	9	7	3	10,3	E25M12-7G	E25M12T-7G	E25M12+0,1	E25M12T+0,1

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min														
P	Acciaio - Steel - Acier - Rm ≤ 850 N/mm²	○1.1 10-15	•1.2 10-15	•1.3 10-12	○1.4 8-10	•1.1 20-30	•1.2 20-30	•1.3 20-25	•1.4 15-20	○1.1 10-15	•1.2 10-15	•1.3 10-12	○1.4 8-10	•1.1 20-30	•1.2 20-30	•1.3 20-25	•1.4 15-20
K	Ghisa - Cast iron - Fonte					○3.3 10-15	•3.4 15-20							○3.3 10-15	•3.4 15-20		
N	Leghe di Allumino – Al alloys - Alliage Al	○4.1 10-15	•4.2 15-20			○4.1 20-25	•4.2 25-30	○4.3 20-25		○4.1 10-15	•4.2 15-20			○4.1 20-25	•4.2 25-30	○4.3 20-25	
N	Leghe di Rame - Copper alloys - Alliages de cuivre	○5.1 8-12	○5.2 10-15			○5.1 15-20	•5.2 20-25			○5.1 8-12	○5.2 10-15			○5.1 15-20	•5.2 20-25		

• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

M

MASCHI A MACCHINA - Imbocco corretto per fori passanti **gambo lungo**
MACHINE TAPS - Straight flutes with spiral point for through holes **long shank**
TARAUDS MACHINE - Goujures droites, entrée gun, pour trous débouchant **queue long**

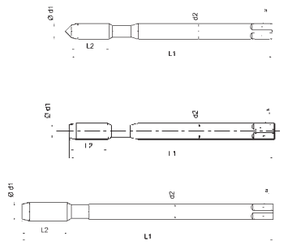
UFS LINE

DIN13 — USO GENERALE - GENERAL PURPOSE - USAGE GÉNÉRAL

UFS Norm d1 ≤ M6

UFS Norm d1 ≤ M10

UFS Norm d1 ≥ M12



Profondità di filettatura - Thread depth - Prof. de filetage	3xD	3xD		
Materiale - Tool Material - Substrat	HSSE	HSSE		
Tolleranza - Thread tolerance - Tolérance du filetage	ISO2/6H	ISO2/6H		
Trattamento superficiale - Surface treatment - Revêtement		TiCN		

UFS Norm	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE	
◀	4	0,7	125	12	4,5	3,4	3	3,3	L24M4	L24M4CT
◀	5	0,8	140	14	6	4,9	3	4,2	L24M5	L24M5CT
◀	6	1	160	18	6	4,9	3	5	L24M6	L24M6CT
	8	1,25	180	20	8	6,2	3	6,8	L24M8	L24M8CT
	10	1,5	180	20	10	8	3	8,5	L24M10	L24M10CT

UFS Norm	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE	
	12	1,75	225	24	9	7	3	10,3	L25M12	L25M12CT
	14	2	225	26	11	9	3	12	L25M14	L25M14CT
	16	2	225	32	12	9	3	14	L25M16	L25M16CT

Dimensioni a norma di fabbrica
Dimensions according to standard factory
Dimensions selon la norme d'usine

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min							
P	Acciaio - Steel - Acier - Rm ≤ 850 N/mm²	○1.1 10-15	•1.2 10-15	•1.3 10-12	○1.4 8-10	•1.1 20-30	•1.2 20-30	•1.3 20-25	•1.4 15-20
M	Acciaio inox - Stainless steel - Acier inoxydable					○2.1 10-15	○2.2 8-10		
K	Ghisa - Cast iron - Fonte					○3.3 10-15	•3.4 15-20		
N	Leghe di Allumino – Al alloys - Alliage Al	○4.1 10-15	•4.2 15-20			•4.2 25-30	○4.3 20-25		
N	Leghe di Rame - Copper alloys - Alliages de cuivre	○5.1 8-12	○5.2 10-15			•5.2 20-25			

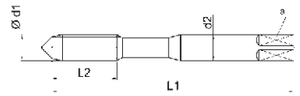
• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

M

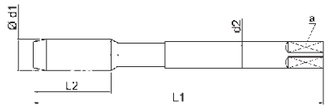
MASCHI A MACCHINA - Imbocco corretto per fori passanti
MACHINE TAPS - Straight flutes with spiral point for through holes
TARAUDS MACHINE - Goujures droites, entrée gun, pour trous débouchant

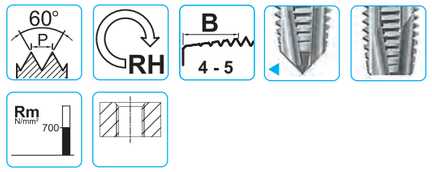
DIN13 | AL-CU-FE | ALLUMINIO, RAME, FERRO - ALUMINIUM, COPPER, IRON - ALUMINIUM, CUIVRE, FER

DIN 371 d1 ≤ M10



DIN 376 d1 ≥ M12





Profondità di filettatura - Thread depth - Prof. de filetage	**3xD**	**3xD**		
Materiale - Tool Material - Substrat	**HSSE**	**HSSE**		
Tolleranza - Thread tolerance - Tolérance du filetage	**ISO2/6H**	**ISO2/6H**		
Trattamento superficiale - Surface treatment - Revêtement		**TXC**		

DIN 371	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE	
◀	**3**	**0,5**	56	10	3,5	2,7	2	2,5	E24M3AL	E24M3AL-TXC
◀	**4**	**0,7**	63	13	4,5	3,4	2	3,3	E24M4AL	E24M4AL-TXC
◀	**5**	**0,8**	70	13	6	4,9	2	4,2	E24M5AL	E24M5AL-TXC
◀	**6**	**1**	80	16	6	4,9	2	5	E24M6AL	E24M6AL-TXC
◀	**8**	**1,25**	90	18	8	6,2	2	6,8	E24M8AL	E24M8AL-TXC
◀	**10**	**1,5**	100	20	10	8	2	8,5	E24M10AL	E24M10AL-TXC

DIN 376	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE	
	12	**1,75**	110	25	9	7	3	10,3	E25M12AL	E25M12AL-TXC
	14	**2**	110	28	11	9	3	12	E25M14AL	E25M14AL-TXC
	16	**2**	110	28	12	9	3	14	E25M16AL	E25M16AL-TXC

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min			
P	Acciaio dolce magnetico - Magnetic soft steel Acier doux magnétique - Rm <400 N/mm²	•1.1 10-15		•1.1 20-30	
N	Leghe di Allumino - Al alloys - Alliage Al	•4.1 10-15	•4.2 15-20	•4.1 20-25	•4.2 25-30	○4.3 20-25
N	Leghe di Rame - Copper alloys - Alliages de cuivre	•5.1 8-12	•5.2 10-15	•5.1 15-20	•5.2 20-25
S	Titanio puro - Pure titanium - Titane pur	•6.1 5-8			
S	Nichel puro - Pure nickel - Nickel pure	•7.1 6-8			
N	Materiali termoplastici - Thermoplastics - Thermoplastiques Truciolo lungo - Long chipping - Copeaux longue	•8.1 20-25			

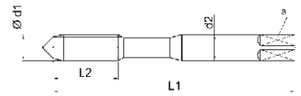
• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

M

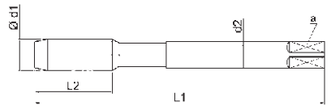
MASCHI A MACCHINA - Imbocco corretto per fori passanti filetti alternati
MACHINE TAPS - Straight flutes with spiral point for through holes interrupted thread
TARAUDS MACHINE - Goujures droites, entrée gun, pour trous débouchant filets alternés

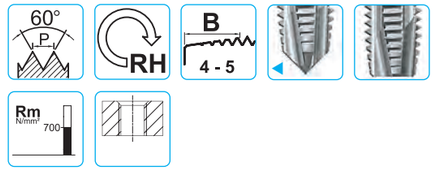
DIN13 | AL-CU-FE | ALLUMINIO, RAME, FERRO - ALUMINIUM, COPPER, IRON - ALUMINIUM, CUIVRE, FER

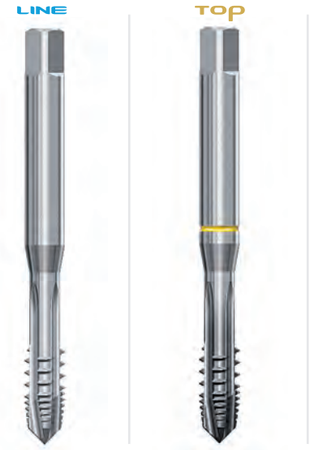
DIN 371 d1 ≤ M10



DIN 376 d1 ≥ M12







Profondità di filettatura - Thread depth - Prof. de filetage	**3xD**	**3xD**		
Materiale - Tool Material - Substrat	**HSSE**	**HSSE**		
Tolleranza - Thread tolerance - Tolérance du filetage	**ISO2/6H**	**ISO2/6H**		
Trattamento superficiale - Surface treatment - Revêtement		**TXC**		

DIN 371	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE	
◀	**3**	**0,5**	56	10	3,5	2,7	3	2,5	E24M3AZ	E24M3AZ-TXC
◀	**4**	**0,7**	63	13	4,5	3,4	3	3,3	E24M4AZ	E24M4AZ-TXC
◀	**4,5**	**0,75**	70	13	6	4,9	3	3,7	E24M4,5AZ	E24M4,5AZ-TXC
◀	**5**	**0,8**	70	13	6	4,9	3	4,2	E24M5AZ	E24M5AZ-TXC
◀	**6**	**1**	80	16	6	4,9	3	5	E24M6AZ	E24M6AZ-TXC
◀	**8**	**1,25**	90	18	8	6,2	3	6,8	E24M8AZ	E24M8AZ-TXC
◀	**10**	**1,5**	100	20	10	8	3	8,5	E24M10AZ	E24M10AZ-TXC

DIN 376	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE	
	12	**1,75**	110	25	9	7	3	10,3	E25M12AZ	E25M12AZ-TXC
	14	**2**	110	28	11	9	3	12	E25M14AZ	E25M14AZ-TXC
	16	**2**	110	28	12	9	3	14	E25M16AZ	E25M16AZ-TXC

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min				
P	Acciaio - Steel - Acier - Rm ≤ 700 N/mm²	•1.1 10-15	○1.2 10-15	•1.1 20-30	•1.2 20-30	
N	Leghe di Allumino - Al alloys - Alliage Al Truciolo lungo - Long chipping - Copeaux longs	•4.1 10-15	•4.2 15-20	•4.1 20-25	•4.2 25-30	
N	Leghe di Rame - Copper alloys - Alliages de cuivre	•5.1 8-12	•5.2 10-15	•5.1 15-20	•5.2 20-25	
S	Titanio puro - Pure titanium - Titane pur	○6.1 5-8				
S	Nichel puro - Pure nickel - Nickel pure	○7.1 6-8				
N	Materiali termoplastici – Thermoplastics - Thermoplastiques Truciolo lungo – Long chipping - Copeaux longue	○8.1 20-25				

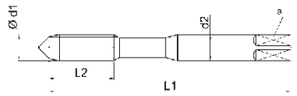
• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

M

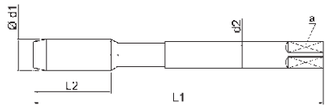
MASCHI A MACCHINA - Imbocco corretto per fori passanti
MACHINE TAPS - Straight flutes with spiral point for through holes
TARAUDS MACHINE - Goujures droites, entrée gun, pour trous débouchant

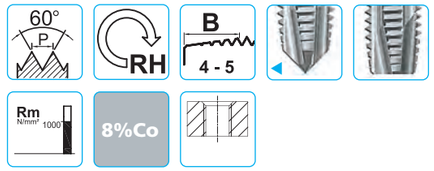
DIN13 | USO GENERALE - GENERAL PURPOSE - USAGE GÉNÉRAL

DIN 371 d1 ≤ M10



DIN 376 d1 ≥ M12





s-plus NEW

Profondità di filettatura - Thread depth - Prof. de filetage	3xD	3xD	3xD
Materiale - Tool Material - Substrat	HSSP	HSSP	HSSP
Tolleranza - Thread tolerance - Tolérance du filetage	ISO2/6H	ISO2/6H	ISO2/6H
Trattamento superficiale - Surface treatment - Revêtement		V	TiN-G

DIN 371	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE		
◀	3	0,5	56	10	3,5	2,7	3	2,5	P24M3	P24M3V	P24M3TG
◀	4	0,7	63	13	4,5	3,4	3	3,3	P24M4	P24M4V	P24M4TG
◀	5	0,8	70	13	6	4,9	3	4,2	P24M5	P24M5V	P24M5TG
◀	6	1	80	16	6	4,9	3	5	P24M6	P24M6V	P24M6TG
◀	8	1,25	90	18	8	6,2	3	6,8	P24M8	P24M8V	P24M8TG
◀	10	1,5	100	20	10	8	3	8,5	P24M10	P24M10V	P24M10TG

DIN 376	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE		
	12	1,75	110	25	9	7	4	10,3	P25M12	P25M12V	P25M12TG
	14	2	110	28	11	9	4	12	P25M14	P25M14V	P25M14TG
	16	2	110	28	12	9	4	14	P25M16	P25M16V	P25M16TG

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min									
P	Acciaio - Steel - Acier - Rm < 1000 N/mm²	•1.2 10-15	•1.3 10-12	•1.4 8-10	•1.2 10-15	•1.3 10-12	•1.4 8-10	•1.2 20-30	•1.3 20-25	•1.4 15-20	○1.5 5-12
K	Ghisa - Cast iron - Fonte							•3.3 10-15	•3.4 15-20		
N	Leghe di Allumino - Al alloys - Alliage Al - Si < 10% Truciolo medio - Medium chipping - Copeaux moyen	•4.3 10-15			•4.3 10-15			•4.3 20-25			
N	Leghe di Rame - Copper alloys - Alliages de cuivre Truciolo lungo - Long chipping - Copeaux longs	•5.2 10-15			•5.2 10-15			•5.2 20-25			

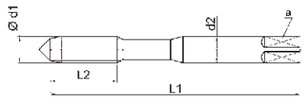
• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

M

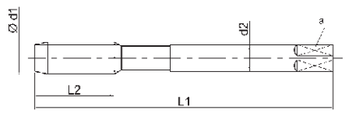
MASCHI A MACCHINA - Imbocco corretto per fori passanti
MACHINE TAPS - Straight flutes with spiral point for through holes
TARAUDS MACHINE - Goujures droites, entrée gun, pour trous débouchant

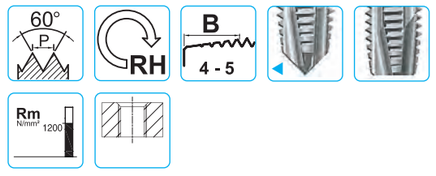
DIN13 | U | APPLICAZIONI UNIVERSALI - UNIVERSAL APPLICATIONS - USINAGE UNIVERSELS

DIN 371 d1 ≤ M10



DIN 376 d1 ≥ M12





Profondità di filettatura - Thread depth - Prof. de filetage	3xD	3,5xD	
Materiale - Tool Material - Substrat	PM3	PM3	
Tolleranza - Thread tolerance - Tolérance du filetage	6HX	6HX	
Trattamento superficiale - Surface treatment - Revêtement	XP	XP	

DIN 371	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE	
◀	3	0,5	56	10	3,5	2,7	3	2,5	K24M3XP	-
◀	4	0,7	63	13	4,5	3,4	3	3,3	K24M4XP	-
◀	5	0,8	70	13	6	4,9	3	4,2	K24M5XP	-
◀	6	1	80	16	6	4,9	3	5	K24M6XP	K24M6FORY-XP
◀	8	1,25	90	18	8	6,2	3	6,8	K24M8XP	K24M8FORY-XP
◀	10	1,5	100	20	10	8	3	8,5	K24M10XP	K24M10FORY-XP

DIN 376	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE	
	12	1,75	110	25	9	7	4	10,3	K25M12XP	K25M12FORY-XP
	14	2	110	28	11	9	4	12	K25M14XP	-
	16	2	110	28	12	9	4	14	K25M16XP	-
	18	2,5	125	33	14	11	4	15,5	K25M18XP	-
	20	2,5	140	33	16	12	4	17,5	K25M20XP	-
	22	2,5	140	33	18	14,5	4	19,5	K25M22XP	-
	24	3	160	39	18	14,5	4	21	K25M24XP	-
New	27	3	160	39	20	16	4	24	K25M27XP	-
New	30	3,5	180	46	22	18	4	26,5	K25M30XP	-

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min						
P	Acciaio - Steel - Acier - Rm ≤ 1200 N/mm²	○1.1 20-30	•1.2 20-30	•1.3 20-25	•1.4 15-20	•1.5 5-12		
M	Acciaio INOX – Stainless steel - Acier inoxydable	•2.1 10-15	•2.2 8-10	•2.3 6-8				
K	Ghisa - Cast iron - Fonte	•3.3 10-15	•3.4 15-20					
N	Leghe di Allumino – Al alloys - Alliage Al	•4.2 25-30	•4.3 20-25					
N	Leghe di Rame - Copper alloys - Alliages de cuivre	•5.2 20-25						

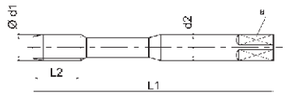
• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

M

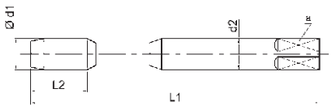
MASCHI A MACCHINA - Imbocco corretto per fori passanti
MACHINE TAPS - Straight flutes with spiral point for through holes
TARAUDS MACHINE - Goujures droites, entrée gun, pour trous débouchant

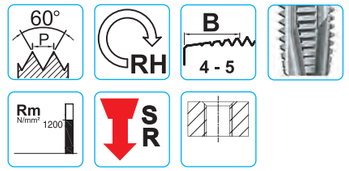
DIN13 | SYNCHRO RIGID | MASCHIATURA RIGIDA SINCRONIZZATA - RIGID TAPPING SYNCHRO - TARAUDAGE RIGIDE SYNCHRONISÉ

DIN 371 d1 ≤ M10



UFS Norm d1 ≥ M12





Profondità di filettatura - Thread depth - Prof. de filetage	**3xD**
Materiale - Tool Material - Substrat	**PM3**
Tolleranza - Thread tolerance - Tolérance du filetage	**6HX**
Trattamento superficiale - Surface treatment - Revêtement	**TXC**

DIN 371	Ød1 M	P mm	L_1	L_2	d_2 h6	a h12	Z		CODE
	6	**1**	80	10	6	4,9	3	5	S24M6TXC
	8	**1,25**	90	13	8	6,2	3	6,8	S24M8TXC
	10	**1,5**	100	15	10	8	3	8,5	S24M10TXC

UFS Norm	Ød1 M	P mm	L_1	L_2	d_2 h6	a h12	Z		CODE
	12	**1,75**	110	25	12	9	3	10,3	S24M12TXC
	16	**2**	110	20	16	12	4	14	S24M16TXC

Dimensioni a norma di fabbrica
Dimensions according to standard factory
Dimensions selon la norme d'usine

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min				
P	Acciaio - Steel - Acier - Rm<1200 N/mm²	•1.1 40-45	•1.2 40-45	•1.3 35-40	•1.4 25-30	•1.5 10-15
M	Acciaio INOX – Stainless steel - Acier inoxydable	•2.1 20-25	•2.2 15-20	•2.3 10-15	•2.4 10-12	
K	Ghisa - Cast iron - Fonte	•3.3 20-25	•3.4 25-30			
N	Leghe di Allumino – Al alloys - Alliage Al Si < 10%	•4.1 30-40	•4.2 45-50	•4.3 30-40		
N	Leghe di Rame - Copper alloys - Alliages de cuivre Truciolo lungo - Long chipping - Copeaux longs	•5.1 20-25	•5.2 25-30			
S	Leghe di titanio - Titanium alloys Alliage de titane Rm<900 N/mm²	•6.1 20-30	○6.2 12-15			
S	Leghe di Nichel - Nickel alloys Alliages de nickel Rm<900 N/mm²	•7.1 20-30	○7.2 8-12			

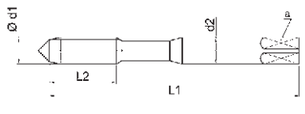
• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

M

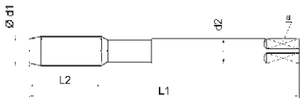
MASCHI A MACCHINA - Imbocco corretto per fori passanti
MACHINE TAPS - Straight flutes with spiral point for through holes
TARAUDS MACHINE - Goujures droites, entrée gun, pour trous débouchant

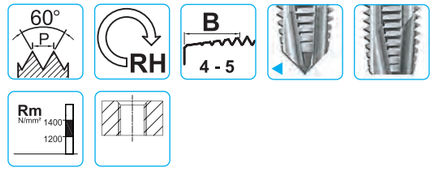
DIN13 | HR | ALTA RESISTENZA - HIGH RESISTANCE - HAUTE RÉSISTANCE

DIN 371 d1 ≤ M10



DIN 376 d1 ≥ M12





Profondità di filettatura - Thread depth - Prof. de filetage	**3xD**
Materiale - Tool Material - Substrat	**PM3**
Tolleranza - Thread tolerance - Tolérance du filetage	**6HX**
Trattamento superficiale - Surface treatment - Revêtement	**TXC**

DIN 371	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE
◀	**3**	**0,5**	56	10	3,5	2,7	3	2,5	K24M3TXC
◀	**4**	**0,7**	63	13	4,5	3,4	3	3,3	K24M4TXC
◀	**5**	**0,8**	70	13	6	4,9	3	4,2	K24M5TXC
◀	**6**	**1**	80	16	6	4,9	3	5	K24M6TXC
◀	**8**	**1,25**	90	18	8	6,2	3	6,8	K24M8TXC
◀	**10**	**1,5**	100	20	10	8	3	8,5	K24M10TXC

DIN 376	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE
	12	**1,75**	110	25	9	7	4	10,3	K25M12TXC
	14	**2**	110	28	11	9	4	12	K25M14TXC
	16	**2**	110	28	12	9	4	14	K25M16TXC

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min		
P	Acciaio - Steel - Acier - Rm < 1400 N/mm²	•1.5 5-12	•1.6 5-8	
K	Ghisa - Cast iron - Fonte	•3.3 15-20	•3.4 20-25	
N	Leghe di Allumino – Al alloys - Alliage Al Si > 10%	○4.4 25-30		
N	Ottone a truciolo corto - hard brass short chipping - laiton coupeaux courts	•5.3 25-30		

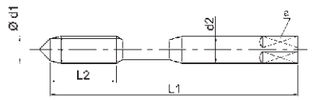
• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

M

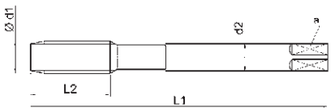
MASCHI A MACCHINA - Imbocco corretto per fori passanti
MACHINE TAPS - Straight flutes with spiral point for through holes
TARAUDS MACHINE - Goujures droites, entrée gun, pour trous débouchant

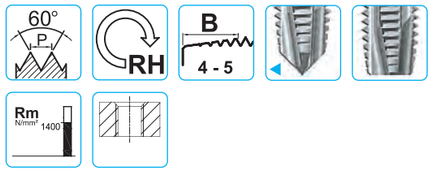
DIN13 | INOX | ACCIAIO INOSSIDABILE - STAINLESS STEEL - ACIER INOXYDABLE

DIN 371 d1 ≤ M10



DIN 376 d1 ≥ M12





	LINE	TOP	TOP
Profondità di filettatura - Thread depth - Prof. de filetage	3xD	3xD	3xD
Materiale - Tool Material - Substrat	HSSV3	HSSV3	PM3
Tolleranza - Thread tolerance - Tolérance du filetage	6HX	6HX	6HX
Trattamento superficiale - Surface treatment - Revêtement	VS	TXC	TXC

DIN 371	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE		
◀	3	0,5	56	10	3,5	2,7	3	2,5	V24M3VS	V24M3TXC	K24M3X-TXC
◀	4	0,7	63	13	4,5	3,4	3	3,3	V24M4VS	V24M4TXC	K24M4X-TXC
◀	5	0,8	70	13	6	4,9	3	4,2	V24M5VS	V24M5TXC	K24M5X-TXC
◀	6	1	80	16	6	4,9	3	5	V24M6VS	V24M6TXC	K24M6X-TXC
◀	8	1,25	90	18	8	6,2	3	6,8	V24M8VS	V24M8TXC	K24M8X-TXC
◀	10	1,5	100	20	10	8	3	8,5	V24M10VS	V24M10TXC	K24M10X-TXC

DIN 376	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE	
	12	1,75	110	25	9	7	4	10,3	V25M12VS	V25M12TXC
	14	2	110	28	11	9	4	12	V25M14VS	V25M14TXC
	16	2	110	28	12	9	4	14	V25M16VS	V25M16TXC
	18	2,5	125	33	14	11	4	15,5	V25M18VS	V25M18TXC
	20	2,5	140	33	16	12	4	17,5	V25M20VS	V25M20TXC
	22	2,5	140	33	18	14,5	4	19,5	V25M22VS	V25M22TXC
	24	3	160	39	18	14,5	4	21	V25M24VS	V25M24TXC

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min												
P	Acciaio - Steel - Acier - Rm ≤ 1400 N/mm²	•1.1 10-15	•1.2 10-15		•1.3 20-25	•1.4 15-20	◦1.5 5-12		•1.3 20-25	•1.4 15-20	•1.5 5-12	◦1.6 5-8		
M	Acciaio INOX – Stainless steel - Acier inoxydable	•2.1 6-8	•2.2 5-7	•2.3 3-5	•2.1 10-15	•2.2 8-10	•2.3 6-8	◦2.4 3-6	•2.1 10-15	•2.2 8-10	•2.3 6-8	•2.4 3-6		

• Raccomandato - Optimal - Recommandé ◦ Adatto - Suitable - Adaptè

MJ UNJC UNJF AVIO

DIAMETRO ESTERNO ARROTONDATO
WITH ROUNDED CREST
DIAMÈTRE EXTÉRIEUR ARRONDI

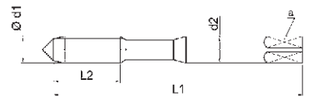
Ti | TITANIO - TITANIUM - TITANE

M

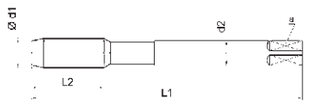
MASCHI A MACCHINA - Elica 15° sinistra per fori passanti
MACHINE TAPS - Left-hand spiral flutes 15° for through holes
TARAUDS MACHINE - Goujures 15° hélicoïdales à gauche pour trous débouchant

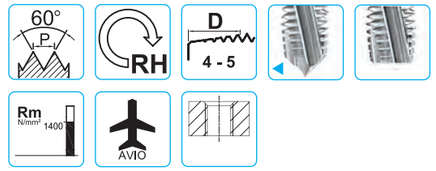
DIN13 | Ti | TITANIO - TITANIUM - TITANE

DIN 371 d1 ≤ M10



DIN 376 d1 ≥ M12





Profondità di filettatura - Thread depth - Prof. de filetage	3xD	3xD		
Materiale - Tool Material - Substrat	PM3	PM3		
Tolleranza - Thread tolerance - Tolérance du filetage	6HX	4H		
Trattamento superficiale - Surface treatment - Revêtement	TiCN	TiCN		

DIN 371	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE	
◀	3	0,5	56	10	3,5	2,7	3	*2,5	K52M3CT	K52MJ3CT
◀	4	0,7	63	13	4,5	3,4	3	*3,3	K52M4CT	K52MJ4CT
◀	5	0,8	70	13	6	4,9	3	*4,2	K52M5CT	K52MJ5CT
◀	6	1	80	16	6	4,9	3	*5	K52M6CT	K52MJ6CT
◀	8	1,25	90	18	8	6,2	3	*6,8	K52M8CT	K52MJ8CT
◀	10	1,5	100	20	10	8	3	*8,5	K52M10CT	K52MJ10CT

DIN 376	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE
	12	1,75	110	25	9	7	3	*10,3	K53M12CT
	16	2	110	28	12	9	3	*14	K53M16CT

* Diametri di preforo MJ a pag: 269 - Bore hole for thread MJ to page: 269 - Pour MJ voir le tableau de perçage page: 269

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min	
P	Acciaio - Steel - Acier - Rm ≤ 1200-1400 N/mm²	•1.6 5-8	
M	Inox - Stainless steel - Acier inoxydable Cr–Ni, Rm < 1400 N/mm²	•2.4 3-6	
K	Ghisa - Cast iron - Fonte	•3.3 15-20	•3.4 20-25
N	Leghe di Allumino - Al alloys - Alliage Al Si > 10%	○4.4 25-30	
N	Leghe di Rame - Copper alloys - Alliages de cuivre Ottone, Bronzo - Hard brass, bronze - Laiton, bronze	•5.3 25-30	○5.4 5-8
S	Leghe di titanio - Titanium alloys Alliage de titane Rm<1400 N/mm²	•6.2 4-8	•6.3 2-4
S	Leghe di Nichel - Nickel alloys Alliages de nickel Rm<900 N/mm²	•7.2 2-4	

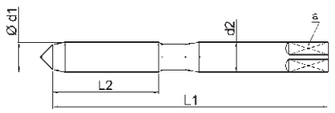
• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

M

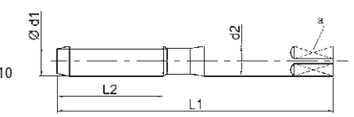
MASCHI A MACCHINA - Elica 10° sinistra per fori passanti
MACHINE TAPS - Left-hand spiral flutes 10° for through holes
TARAUDS MACHINE - Goujures 10° hélicoïdales à gauche pour trous débouchant

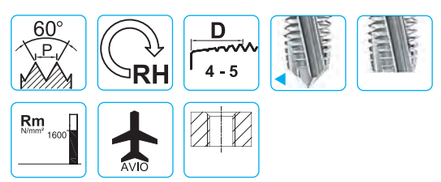
DIN13 | Ni | NICHEL - NICKEL

UFS Norm d1 ≤ M6



UFS Norm d1 =M8, M10





Profondità di filettatura - Thread depth - Prof. de filetage	3xD	3xD		
Materiale - Tool Material - Substrat	PM3	PM3		
Tolleranza - Thread tolerance - Tolérance du filetage	6HX	4H		
Trattamento superficiale - Surface treatment - Revêtement	TiCN	TiCN		

UFS Norm	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE	
◀	3	0,5	56	10	3,5	2,7	3	*2,5	K52M3NI-CT	K52MJ3NI-CT
◀	4	0,7	63	13	4,5	3,4	3	*3,3	K52M4NI-CT	K52MJ4NI-CT
◀	5	0,8	70	15	6	4,9	3	*4,2	K52M5NI-CT	K52MJ5NI-CT
◀	6	1	80	18	6	4,9	3	*5	K52M6NI-CT	K52MJ6NI-CT
	8	1,25	90	25	8	6,2	3	*6,8	K52M8NI-CT	K52MJ8NI-CT
	10	1,5	100	30	10	8	3	*8,5	K52M10NI-CT	K52MJ10NI-CT

Dimensioni a norma di fabbrica
Dimensions according to standard factory
Dimensions selon la norme d'usine

* Diametri di preforo MJ a pag: 269 - Bore hole for thread MJ to page: 269 - Pour MJ voir le tableau de perçage page: 269

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min	
P	Acciaio - Steel - Acier - Rm ≤ 1600 N/mm²	○1.6 5-8	•1.7 1-3
N	Bronzo ad alta resistenza - High strength bronze - Bronze haute résistance Rm<1500 N/mm²	•5.4 5-8	
S	Leghe di Nichel - Nickel alloys - Alliages de nickel Rm<1600 N/mm²	○7.2 2-4	•7.3 1-3

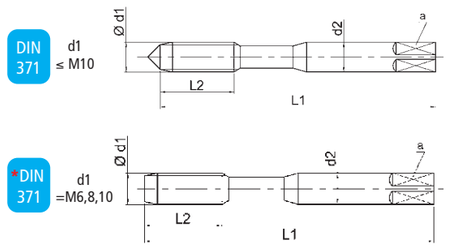
• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

M

MASCHI A MACCHINA - Elica destra a 15° per fori ciechi
MACHINE TAPS - Spiral flutes 15° for blind holes
TARAUDS MACHINE - Goujures hélicoïdales 15° pour trous borgnes

UFS LINE

DIN13 USO GENERALE - GENERAL PURPOSE - USAGE GÉNÉRAL



Profondità di filettatura - Thread depth - Prof. de filetage	1,5xD	1,5xD	1,5xD	2,5xD
Materiale - Tool Material - Substrat	HSSE	HSSE	HSSE	HSSE
Tolleranza - Thread tolerance - Tolérance du filetage	ISO2/6H	ISO2/6H	ISO2/6H	ISO2/6H
Trattamento superficiale - Surface treatment - Revêtement		V	TiN	TiN

DIN 371	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE			
◀	2	0,4	45	10	2,8	2,1	3	1,6	E40M2	E40M2V	-	
◀	2,2	0,45	45	10	2,8	2,1	3	1,75	E40M2,2	E40M2,2V	-	
◀	2,5	0,45	50	13	2,8	2,1	3	2,05	E40M2,5	E40M2,5V	-	
◀	2,6	0,45	50	13	2,8	2,1	3	2,15	E40M2,6	E40M2,6V	-	
◀	3	0,5	56	10	3,5	2,7	3	2,5	E40M3	E40M3V	E40M3T	
◀	3,5	0,6	56	11	4	3	3	2,9	E40M3,5	E40M3,5V	E40M3,5T	
◀	4	0,7	63	13	4,5	3,4	3	3,3	E40M4	E40M4V	E40M4T	
◀	5	0,8	70	13	6	4,9	3	4,2	E40M5	E40M5V	E40M5T	
◀	6	1	80	16	6	4,9	3	5	E40M6	E40M6V	E40M6T	
◀	7	1	80	16	7	5,5	3	6	E40M7	E40M7V	E40M7T	
◀	8	1,25	90	18	8	6,2	3	6,8	E40M8	E40M8V	E40M8T	
◀	10	1,5	100	20	10	8	3	8,5	E40M10	E40M10V	E40M10T	
*	6	1	80	16	6	4,9	3	5				E40M6FOR-T
*	8	1,25	90	18	8	6,2	3	6,8				E40M8FOR-T
*	10	1,5	100	20	10	8	3	8,5				E40M10FOR-T

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min															
P	Acciaio - Steel - Acier - Rm ≤ 850 N/mm²	○1.1 10-15	•1.2 10-15	•1.3 10-12	○1.4 8-10	•1.1 10-15	•1.2 10-15	•1.3 10-12	○1.4 8-10	○1.1 20-30	•1.2 20-30	•1.3 20-25	•1.4 15-20	•1.1 20-30	•1.2 20-30	•1.3 20-25	•1.4 15-20
M	Acciaio inox - Stainless steel - Acier inoxydable																
K	Ghisa - Cast iron - Fonte									○3.3 10-15	•3.4 15-20			○3.3 10-15	•3.4 15-20		
N	Leghe di Allumino – Al alloys - Alliage Al	○4.1 10-15	•4.2 15-20			•4.1 10-15	•4.2 15-20			○4.1 20-25	•4.2 25-30	○4.3 20-25		○4.1 20-25	•4.2 25-30	○4.3 20-25	
N	Leghe di Rame - Copper alloys - Alliages de cuivre	○5.1 8-12	○5.2 10-15			•5.1 8-12	•5.2 10-15			○5.1 15-20	•5.2 20-25			○5.1 15-20	•5.2 20-25		

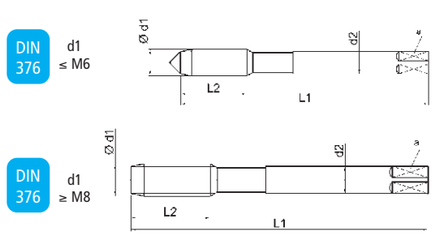
• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

M

MASCHI A MACCHINA - Elica destra a 15° per fori ciechi
MACHINE TAPS - Spiral flutes 15° for blind holes
TARAUDS MACHINE - Goujures hélicoïdales 15° pour trous borgnes

UFS LINE

DIN13 USO GENERALE - GENERAL PURPOSE - USAGE GÉNÉRAL



Profondità di filettatura - Thread depth - Prof. de filetage	1,5xD	1,5xD	1,5xD	2,5xD
Materiale - Tool Material - Substrat	HSSE	HSSE	HSSE	HSSE
Tolleranza - Thread tolerance - Tolérance du filetage	ISO2/6H	ISO2/6H	ISO2/6H	ISO2/6H
Trattamento superficiale - Surface treatment - Revêtement		V	TiN	TiN

DIN 376	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE			
◀	4	0,7	63	13	2,8	2,1	3	3,3	E41M4	E41M4V	E41M4T	-
◀	5	0,8	70	13	3,5	2,7	3	4,2	E41M5	E41M5V	E41M5T	-
◀	6	1	80	16	4,5	3,4	3	5	E41M6	E41M6V	E41M6T	-
	8	1,25	90	18	6	4,9	3	6,8	E41M8SP	E41M8SP-V	E41M8SP-T	-
	10	1,5	100	20	7	5,5	3	8,5	E41M10SP	E41M10SP-V	E41M10SP-T	-
	11	1,5	100	20	8	6,2	3	9,5	E41M11	E41M11V	E41M11T	-
	12	1,75	110	25	9	7	3	10,3	E41M12	E41M12V	E41M12T	E41M12FOR-T
	14	2	110	28	11	9	3	12	E41M14	E41M14V	E41M14T	E41M14FOR-T
	16	2	110	28	12	9	3	14	E41M16	E41M16V	E41M16T	E41M16FOR-T
	18	2,5	125	33	14	11	4	15,5	E41M18	E41M18V	E41M18T	-
	20	2,5	140	33	16	12	4	17,5	E41M20	E41M20V	E41M20T	-
	22	2,5	140	33	18	14,5	4	19,5	E41M22	E41M22V	E41M22T	-
	24	3	160	39	18	14,5	4	21	E41M24	E41M24V	E41M24T	-
	27	3	160	39	20	16	4	24	E41M27	E41M27V	E41M27T	-
	30	3,5	180	46	22	18	4	26,5	E41M30	E41M30V	E41M30T	-

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min															
P	Acciaio - Steel - Acier - Rm ≤ 850 N/mm²	○1.1 10-15	•1.2 10-15	•1.3 10-12	○1.4 8-10	•1.1 10-15	•1.2 10-15	•1.3 10-12	○1.4 8-10	○1.1 20-30	•1.2 20-30	•1.3 20-25	•1.4 15-20	•1.1 20-30	•1.2 20-30	•1.3 20-25	•1.4 15-20
M	Acciaio inox - Stainless steel - Acier inoxydable																
K	Ghisa - Cast iron - Fonte									○3.3 10-15	•3.4 15-20			○3.3 10-15	•3.4 15-20		
N	Leghe di Allumino – Al alloys - Alliage Al	○4.1 10-15	•4.2 15-20			•4.1 10-15	•4.2 15-20			○4.1 20-25	•4.2 25-30	○4.3 20-25		○4.1 20-25	•4.2 25-30	○4.3 20-25	
N	Leghe di Rame - Copper alloys - Alliages de cuivre	○5.1 8-12	○5.2 10-15			•5.1 8-12	•5.2 10-15			○5.1 15-20	•5.2 20-25			○5.1 15-20	•5.2 20-25		

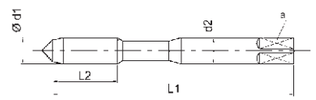
• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

M

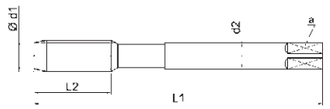
MASCHI A MACCHINA - Elica destra a 15° per fori ciechi toll 6G e 6H+0,1
MACHINE TAPS - Spiral flutes 15° for blind holes tolerance 6G e 6H+0,1
TARAUDS MACHINE - Goujures hélicoïdales 15° pour trous borgnes tolérance 6G et 6H+0,1

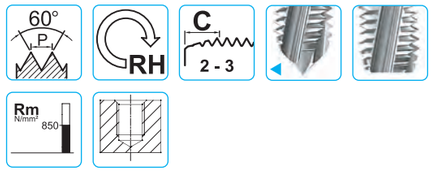
DIN13 | USO GENERALE - GENERAL PURPOSE - USAGE GÉNÉRAL

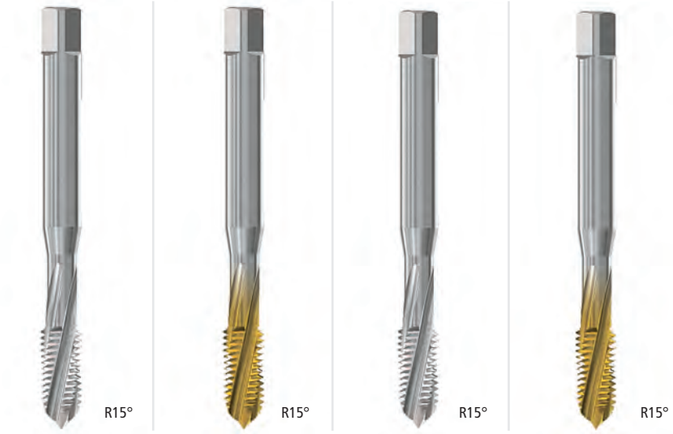
DIN 371 d1 ≤ M10



DIN 376 d1 ≥ M12







Profondità di filettatura - Thread depth - Prof. de filetage	**1,5xD**	**1,5xD**	**1,5xD**	**1,5xD**
Materiale - Tool Material - Substrat	**HSSE**	**HSSE**	**HSSE**	**HSSE**
Tolleranza - Thread tolerance - Tolérance du filetage	**ISO3/6G**	**ISO3/6G**	**6H+0,1**	**6H+0,1**
Trattamento superficiale - Surface treatment - Revêtement		**TiN**		**TiN**

DIN 371	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z	
◀	**3**	**0,5**	56	10	3,5	2,7	3	2,5
◀	**4**	**0,7**	63	13	4,5	3,4	3	3,3
◀	**5**	**0,8**	70	13	6	4,9	3	4,2
◀	**6**	**1**	80	16	6	4,9	3	5
◀	**8**	**1,25**	90	18	8	6,2	3	6,8
◀	**10**	**1,5**	100	20	10	8	3	8,5

CODE			
E40M3-6G	E40M3T-6G	E40M3+0,1	E40M3T+0,1
E40M4-6G	E40M4T-6G	E40M4+0,1	E40M4T+0,1
E40M5-6G	E40M5T-6G	E40M5+0,1	E40M5T+0,1
E40M6-6G	E40M6T-6G	E40M6+0,1	E40M6T+0,1
E40M8-6G	E40M8T-6G	E40M8+0,1	E40M8T+0,1
E40M10-6G	E40M10T-6G	E40M10+0,1	E40M10T+0,1

DIN 376	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z	
	12	**1,75**	110	25	9	7	4	10,3

CODE			
-	-	E41M12+0,1	E41M12T+0,1

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min															
P	Acciaio - Steel - Acier - Rm ≤ 850 N/mm²	○1.1 10-15	•1.2 10-15	•1.3 10-12	○1.4 8-10	•1.1 20-30	•1.2 20-30	•1.3 20-25	•1.4 15-20	○1.1 10-15	•1.2 10-15	•1.3 10-12	○1.4 8-10	•1.1 20-30	•1.2 20-30	•1.3 20-25	•1.4 15-20
M	Acciaio inox - Stainless steel - Acier inoxydable																
K	Ghisa - Cast iron - Fonte					○3.3 10-15	•3.4 15-20							○3.3 10-15	•3.4 15-20		
N	Leghe di Allumino – Al alloys - Alliage Al	○4.1 10-15	•4.2 15-20			○4.1 20-25	•4.2 25-30	○4.3 20-25		○4.1 10-15	•4.2 15-20			○4.1 20-25	•4.2 25-30	○4.3 20-25	
N	Leghe di Rame - Copper alloys - Alliages de cuivre	○5.1 8-12	○5.2 10-15			○5.1 15-20	•5.2 20-25			○5.1 8-12	○5.2 10-15			○5.1 15-20	•5.2 20-25		

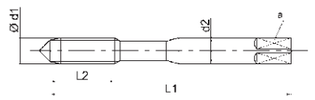
• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

M

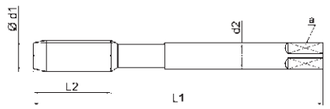
MASCHI A MACCHINA - Elica destra a 15° per fori ciechi filetti alternati
MACHINE TAPS - Spiral flutes 15° for blind holes interrupted threads
TARAUDS MACHINE - Goujures hélicoïdales 15° pour trous borgnes filets alternés

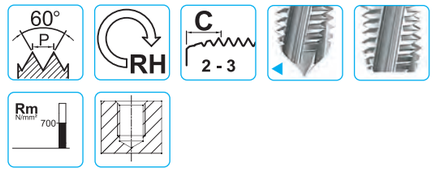
DIN13 | AL-CU-FE | ALLUMINIO, RAME, FERRO - ALUMINIUM, COPPER, IRON - ALUMINIUM, CUIVRE, FER

DIN 371 d1 ≤ M10



DIN 376 d1 ≥ M12





Profondità di filettatura - Thread depth - Prof. de filetage	**1,5xD**			
Materiale - Tool Material - Substrat	**HSSE**			
Tolleranza - Thread tolerance - Tolérance du filetage	**ISO2/6H**			
Trattamento superficiale - Surface treatment - Revêtement				

DIN 371	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z	
◀	**3**	**0,5**	56	10	3,5	2,7	3	2,5
◀	**4**	**0,7**	63	13	4,5	3,4	3	3,3
◀	**5**	**0,8**	70	13	6	4,9	3	4,2
◀	**6**	**1**	80	16	6	4,9	3	5
◀	**8**	**1,25**	90	18	8	6,2	3	6,8
◀	**10**	**1,5**	100	20	10	8	3	8,5

CODE
E40M3AZ
E40M4AZ
E40M5AZ
E40M6AZ
E40M8AZ
E40M10AZ

DIN 376	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z	
	12	**1,75**	110	25	9	7	3	10,3
	14	**2**	110	28	11	9	3	12
	16	**2**	110	28	12	9	3	14

CODE
E41M12AZ
E41M14AZ
E41M16AZ

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min	
P	Acciaio - Steel - Acier - Rm ≤ 700 N/mm²	• 1.1 10-15	○1.2 10-15
N	Leghe di Allumino - Al alloys - Alliage Al Truciolo lungo - Long chipping - Copeaux longs	•4.1 10-15	•4.2 15-20
N	Leghe di Rame - Copper alloys - Alliages de cuivre	•5.1 8-12	•5.2 10-15
S	Titanio puro - Pure titanium - Titane pur	○6.1 5-8	
S	Nichel puro - Pure nickel - Nickel pure	○7.1 6-8	
N	Materiali termoplastici - Thermoplastics - Thermoplastiques Truciolo lungo - Long chipping - Copeaux longue	○8.1 20-25	

• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

M

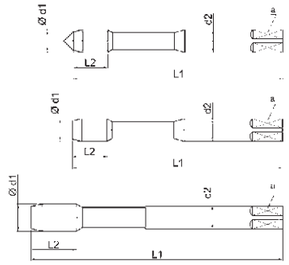
MASCHI A MACCHINA - Elica destra a 15° per fori ciechi
MACHINE TAPS - Spiral flutes 15° for blind holes
TARAUDS MACHINE - Goujures hélicoïdales 15° pour trous borgnes

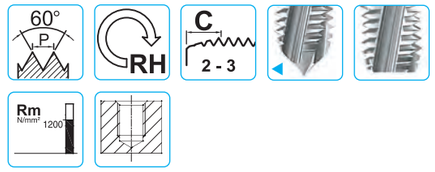
DIN13 | U | APPLICAZIONI UNIVERSALI - UNIVERSAL APPLICATIONS - USINAGE UNIVERSELS

DIN 371 d1 ≤ M6

DIN 371 d1 ≤ M10

DIN 376 d1 ≥ M12





Profondità di filettatura - Thread depth - Prof. de filetage	**1,5xD**	**2,5xD**	**3xD**
Materiale - Tool Material - Substrat	**HSSE-PM**	**HSSE-PM**	**HSSE-PM**
Tolleranza - Thread tolerance - Tolérance du filetage	**6HX**	**6HX**	**6HX**
Trattamento superficiale - Surface treatment - Revêtement	**XP**	**XP**	**XP**

DIN 371	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE		
◀	**3**	**0,5**	56	5	3,5	2,7	3	2,5	K40M3XP	-	-
◀	**4**	**0,7**	63	7	4,5	3,4	3	3,3	K40M4XP	-	-
◀	**5**	**0,8**	70	8	6	4,9	3	4,2	K40M5XP	-	-
◀	**6**	**1**	80	10	6	4,9	3	5	K40M6XP	K40M6FOR-XP	K44M6FOR-XP
	8	**1,25**	90	13	8	6,2	3	6,8	K40M8XP	K40M8FOR-XP	K44M8FOR-XP
	10	**1,5**	100	15	10	8	3	8,5	K40M10XP	K40M10FOR-XP	K44M10FOR-XP

DIN 376	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE		
	12	**1,75**	110	18	9	7	3	10,3	K41M12XP	K41M12FOR-XP	K45M12FOR-XP
	14	**2**	110	20	11	9	3	12	K41M14XP	-	-
	16	**2**	110	20	12	9	3	14	K41M16XP	K41M16FOR-XP	K45M16FOR-XP
	18	**2,5**	125	25	14	11	4	15,5	K41M18XP	-	-
	20	**2,5**	140	25	16	12	4	17,5	K41M20XP	-	-
	22	**2,5**	140	25	18	14,5	4	19,5	K41M22XP	-	-
	24	**3**	160	30	18	14,5	4	21	K41M24XP	-	-

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min											
P	Acciaio - Steel - Acier - Rm<1200 N/mm²	•1.3 20-25	•1.4 15-20	•1.5 5-12	•1.6 5-8	•1.3 20-25	•1.4 15-20	•1.5 5-12	•1.6 5-8	•1.3 20-25	•1.4 15-20	•1.5 5-12	•1.6 5-8
K	Ghisa - Cast iron - Fonte	•3.3 15-20	•3.4 20-25			•3.3 15-20	•3.4 20-25						
N	Leghe di Allumino – Al alloys - Alliage Al - Si < 10% Truciolo medio - Medium chipping - Copeaux moyen	•4.3 20-25				•4.3 20-25							
S	Leghe di titanio - Titanium alloys - Alliage de titane Rm<900 N/mm²	•6.2 2-3				•6.2 2-3							
S	Leghe di Nichel - Nickel alloys - Alliages de nickel Rm<900 N/mm²	•7.2 2-3				•7.2 2-3							

• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

M

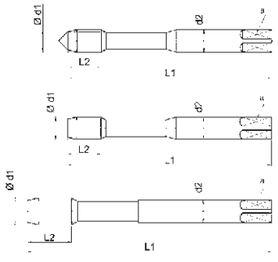
MASCHI A MACCHINA - Elica destra a 15° per fori ciechi
MACHINE TAPS - Spiral flutes 15° for blind holes
TARAUDS MACHINE - Goujures hélicoïdales 15° pour trous borgnes

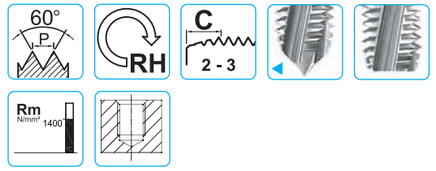
DIN13 | HR | ALTA RESISTENZA - HIGH RESISTANCE - HAUTE RÉSISTANCE

DIN 371 d1 ≤ M6

DIN 371 d1 ≤ M10

DIN 376 d1 ≥ M12





Profondità di filettatura - Thread depth - Prof. de filetage	**1,5xD**	**2,5xD**
Materiale - Tool Material - Substrat	**PM3**	**PM3**
Tolleranza - Thread tolerance - Tolérance du filetage	**6HX**	**6HX**
Trattamento superficiale - Surface treatment - Revêtement	**TXC**	**TXC**

DIN 371	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE	
◀	**3**	**0,5**	56	5	3,5	2,7	3	2,5	K40M3TXC	
◀	**4**	**0,7**	63	7	4,5	3,4	3	3,3	K40M4TXC	
◀	**5**	**0,8**	70	8	6	4,9	3	4,2	K40M5TXC	
◀	**6**	**1**	80	10	6	4,9	3	5	K40M6TXC	
	8	**1,25**	90	13	8	6,2	3	6,8	K40M8TXC	
	10	**1,5**	100	15	10	8	3	8,5	K40M10TXC	

DIN 376	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE	
	6	**1**	80	10	6	4,9	3	5	K40M6FOR-TXC	
	8	**1,25**	90	13	8	6,2	3	6,8	K40M8FOR-TXC	
	10	**1,5**	100	15	10	8	3	8,5	K40M10FOR-TXC	

DIN 376	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE	
	12	**1,75**	110	18	9	7	4	10,3	K41M12TXC	K41M12FOR-TXC
	14	**2**	110	20	11	9	4	12	K41M14TXC	K41M14FOR-TXC
	16	**2**	110	20	12	9	4	14	K41M16TXC	K41M16FOR-TXC

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min											
P	Acciaio - Steel - Acier - Rm < 1400 N/mm²	•1.5 5-12	•1.6 5-8										
K	Ghisa - Cast iron - Fonte	•3.3 15-20	•3.4 20-25										
N	Leghe di Allumino – Al alloys - Alliage Al Si > 10%	○4.4 25-30											
N	Leghe di magnesio Magnesium alloys - Alliages de magnésium	○4.5 20-30											
N	Ottone a truciolo corto Hard brass short chipping – Laiton coupeaux courts	•5.3 25-30											

• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

M

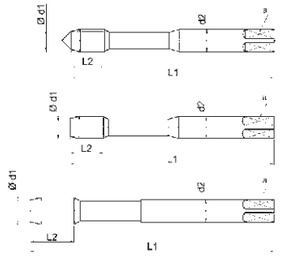
MASCHI A MACCHINA - Elica destra a 15° per fori ciechi
MACHINE TAPS - Spiral flutes 15° for blind holes
TARAUDS MACHINE - Goujures hélicoïdales 15° pour trous borgnes

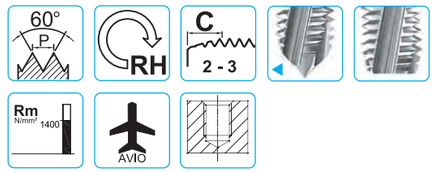
DIN13 | Ti | TITANIO - TITANIUM - TITANE

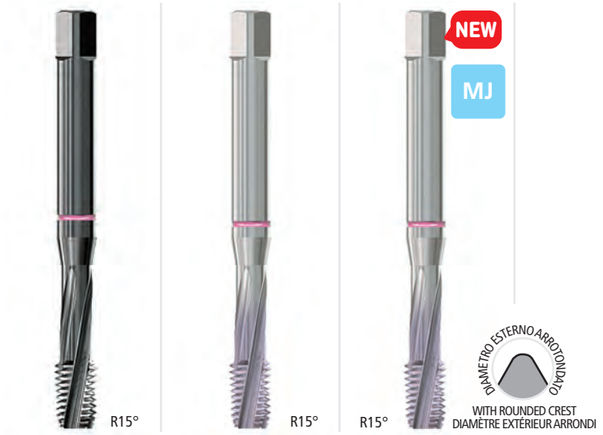
DIN 371 d1 ≤ M6

DIN 371 d1 ≤ M10

DIN 376 d1 ≥ M12







Profondità di filettatura - Thread depth - Prof. de filetage	1,5xD	1,5xD	1,5xD
Materiale - Tool Material - Substrat	PM3	PM3	PM3
Tolleranza - Thread tolerance - Tolérance du filetage	6HX	6HX	4H
Trattamento superficiale - Surface treatment - Revêtement	V	TiCN	TiCN

DIN 371	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE		
◀	3	0,5	56	5	3,5	2,7	3	*2,5	K42M3V	K42M3CT	K42MJ3CT
◀	4	0,7	63	7	4,5	3,4	3	*3,3	K42M4V	K42M4CT	K42MJ4CT
◀	5	0,8	70	8	6	4,9	3	*4,2	K42M5V	K42M5CT	K42MJ5CT
◀	6	1	80	10	6	4,9	3	*5	K42M6V	K42M6CT	K42MJ6CT
	8	1,25	90	13	8	6,2	3	*6,8	K42M8V	K42M8CT	K42MJ8CT
	10	1,5	100	15	10	8	3	*8,5	K42M10V	K42M10CT	K42MJ10CT

DIN 376	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE	
	12	1,75	110	18	9	7	4	*10,3	K43M12V	K43M12CT
	16	2	110	20	12	9	4	*14	K43M16V	K43M16CT

* Diametri di preforo MJ a pag: 269 - Bore hole for thread MJ to page: 269 - Pour MJ voir le tableau de perçage page: 269

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min							
P	Acciaio - Steel - Acier - Rm ≤ 1200-1400 N/mm²			•1.6 5-8		•1.6 5-8			
M	Inox - Stainless steel - Acier inoxydable Cr–Ni, Rm < 1400 N/mm²			•2.4 3-6		•2.4 3-6			
K	Ghisa - Cast iron - Fonte			•3.3 15-20	•3.4 20-25	•3.3 15-20	•3.4 20-25		
N	Leghe di Allumino - Al alloys - Alliage Al Si > 10%			○4.4 25-30		○4.4 25-30			
N	Leghe di Rame - Copper alloys - Alliages de cuivre Ottone, Bronzo - Hard brass, bronze - Laiton, bronze			•5.3 25-30	○5.4 5-8	•5.3 25-30	○5.4 5-8		
S	Titanio puro - Pure titanium - Titane pur	•6.1 5-10							
S	Leghe di titanio - Titanium alloys - Alliage de titane Rm<1400 N/mm²			•6.2 4-8	•6.3 2-4	•6.2 4-8	•6.3 2-4		
S	Leghe di Nichel - Nickel alloys - Alliages de nickel Rm<900 N/mm²			•7.2 2-4		•7.2 2-4			

• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

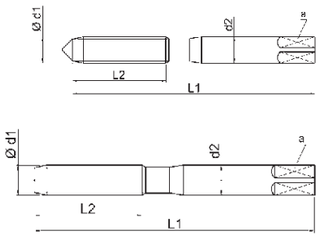
M

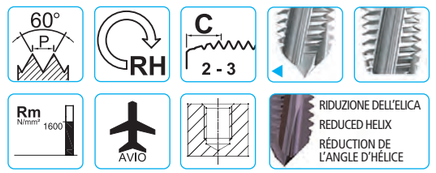
MASCHI A MACCHINA - Elica 10° destra per fori ciechi
MACHINE TAPS - Spiral flutes 10° for blind holes
TARAUDS MACHINE - Goujures hélicoïdales 10° pour trous borgnes

DIN13 | Ni | NICHEL - NICKEL

UFS Norm d1 ≤ M6

UFS Norm d1 =M8, M10





Profondità di filettatura - Thread depth - Prof. de filetage	1,5xD	1,5xD			
Materiale - Tool Material - Substrat	PM3	PM3			
Tolleranza - Thread tolerance - Tolérance du filetage	6HX	4H			
Trattamento superficiale - Surface treatment - Revêtement	TiCN	TiCN			

UFS Norm	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE	
◀	3	0,5	56	10	3,5	2,7	3	*2,5	K42M3NI-CT	K42MJ3NI-CT
◀	4	0,7	63	13	4,5	3,4	3	*3,3	K42M4NI-CT	K42MJ4NI-CT
◀	5	0,8	70	15	6	4,9	3	*4,2	K42M5NI-CT	K42MJ5NI-CT
◀	6	1	80	18	6	4,9	3	*5	K42M6NI-CT	K42MJ6NI-CT
	8	1,25	90	25	8	6,2	3	*6,8	K42M8NI-CT	K42MJ8NI-CT
	10	1,5	100	30	10	8	3	*8,5	K42M10NI-CT	K42MJ10NI-CT

Dimensioni a norma di fabbrica
Dimensions according to standard factory
Dimensions selon la norme d'usine

* Diametri di preforo MJ a pag: 269 - Bore hole for thread MJ to page: 269 - Pour MJ voir le tableau de perçage page: 269

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min							
P	Acciaio - Steel - Acier - Rm ≤ 1600 N/mm²	○1.6 5-8	•1.7 1-3						
N	Bronzo ad alta resistenza - High strength bronze - Bronze haute résistance Rm<1500 N/mm²	•5.4 5-8							
S	Leghe di Nichel - Nickel alloys - Alliages de nickel Rm<1600 N/mm²	○7.2 2-4	•7.3 1-3						

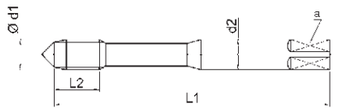
• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

M

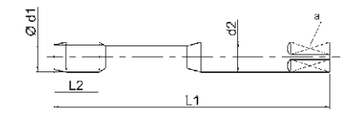
MASCHI A MACCHINA - Elica destra a 40° per fori ciechi
MACHINE TAPS - Spiral flutes 40° for blind holes
TARAUDS MACHINE - Goujures hélicoïdales 40° pour trous borgnes

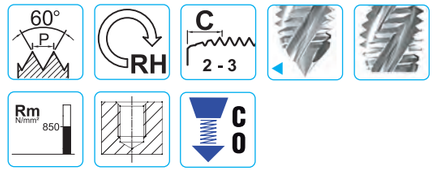
DIN13 — USO GENERALE - GENERAL PURPOSE - USAGE GÉNÉRAL

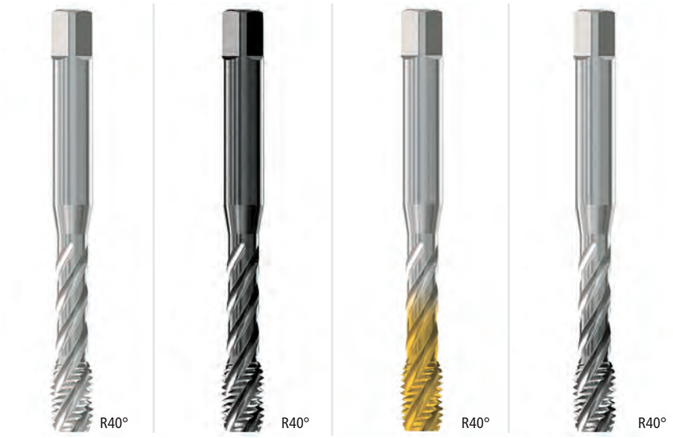
DIN 371 d1 ≤ M6



DIN 371 d1 ≥ M7







Profondità di filettatura - Thread depth - Prof. de filetage	2,5xD	2,5xD	2,5xD	2,5xD
Materiale - Tool Material - Substrat	HSSE	HSSE	HSSE	HSSE
Tolleranza - Thread tolerance - Tolérance du filetage	ISO2/6H	ISO2/6H	ISO2/6H	ISO2/6H
Trattamento superficiale - Surface treatment - Revêtement		V	TiN	XP

DIN 371	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE			
◀	1	0,25	40	5	2,5	2,1	-	0,75	E60M1	-	-	-
◀	1,2	0,25	40	5	2,5	2,1	-	0,95	E60M1,2	-	-	-
◀	1,4	0,3	40	7	2,5	2,1	-	1,1	E60M1,4	-	-	-
◀	1,6	0,35	40	8	2,5	2,1	-	1,25	E60M1,6	-	-	-
◀	1,7	0,35	40	8	2,5	2,1	-	1,35	E60M1,7	-	-	-
◀	1,8	0,35	40	8	2,5	2,1	-	1,45	E60M1,8	-	-	-
◀	2	0,4	45	7	2,8	2,1	3	1,6	E60M2	E60M2V	-	* E60M2VS
◀	2,5	0,45	50	9	2,8	2,1	3	2,05	E60M2,5	E60M2,5V	-	* E60M2,5VS
◀	2,6	0,45	50	9	2,8	2,1	3	2,15	E60M2,6	E60M2,6V	-	* E60M2,6VS
◀	3	0,5	56	5	3,5	2,7	3	2,5	E60M3	E60M3V	E60M3T	E60M3XP
◀	3,5	0,6	56	7	4	3	3	2,9	E60M3,5	E60M3,5V	E60M3,5T	E60M3,5XP
◀	4	0,7	63	7	4,5	3,4	3	3,3	E60M4	E60M4V	E60M4T	E60M4XP
◀	4,5	0,75	70	8	6	4,9	3	3,7	E60M4,5	E60M4,5V	E60M4,5T	E60M4,5XP
◀	5	0,8	70	8	6	4,9	3	4,2	E60M5	E60M5V	E60M5T	E60M5XP
◀	6	1	80	10	6	4,9	3	5	E60M6	E60M6V	E60M6T	E60M6XP
	7	1	80	10	7	5,5	3	6	E60M7	E60M7V	E60M7T	E60M7XP
	8	1,25	90	13	8	6,2	3	6,8	E60M8	E60M8V	E60M8T	E60M8XP
	9	1,25	90	18	9	7	3	7,8	E60M9	E60M9V	E60M9T	E60M9XP
	10	1,5	100	15	10	8	3	8,5	E60M10	E60M10V	E60M10T	E60M10XP

* Rivestimento VS - Coating VS - Revêtement VS

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min															
P	Acciaio - Steel - Acier - Rm ≤ 850 N/mm²	○1.1 10-15	•1.2 10-15	•1.3 10-12	○1.4 8-10	•1.1 10-15	•1.2 10-15	•1.3 10-12	○1.4 8-10	•1.1 20-30	•1.2 20-30	•1.3 20-25	•1.4 15-20	•1.1 20-30	•1.2 20-30	•1.3 20-25	•1.4 15-20
M	Acciaio inox - Stainless steel - Acier inoxydable													○2.1 10-15	○2.2 8-10		
K	Ghisa - Cast iron - Fonte									○3.3 10-15	•3.4 15-20			○3.3 10-15	•3.4 15-20		
N	Leghe di Allumino - Al alloys - Alliage Al	○4.1 10-15	•4.2 15-20			•4.1 10-15	•4.2 15-20			○4.1 20-25	•4.2 25-30	○4.3 20-25		•4.2 25-30	○4.3 20-25		
N	Leghe di Rame - Copper alloys - Alliages de cuivre	○5.1 8-12	○5.2 10-15			•5.1 8-12	•5.2 10-15			○5.1 15-20	•5.2 20-25			•5.2 20-25			

• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

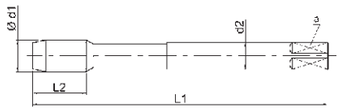
M

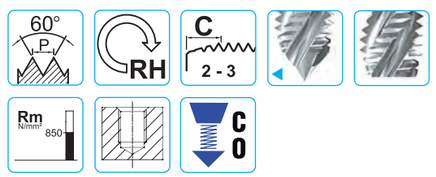
MASCHI A MACCHINA - Elica destra a 40° per fori ciechi
MACHINE TAPS - Spiral flutes 40° for blind holes
TARAUDS MACHINE - Goujures hélicoïdales 40° pour trous borgnes

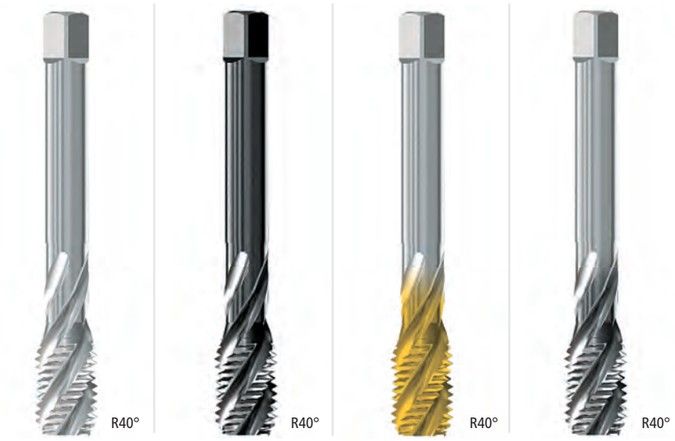
DIN13 — USO GENERALE - GENERAL PURPOSE - USAGE GÉNÉRAL

DIN 376 d1 ≤ M6

DIN 376 d1 ≥ M8







Profondità di filettatura - Thread depth - Prof. de filetage	2,5xD	2,5xD	2,5xD	2,5xD
Materiale - Tool Material - Substrat	HSSE	HSSE	HSSE	HSSE
Tolleranza - Thread tolerance - Tolérance du filetage	ISO2/6H	ISO2/6H	ISO2/6H	ISO2/6H
Trattamento superficiale - Surface treatment - Revêtement		V	TiN	XP

DIN 376	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE			
◀	5	0,8	70	8	3,5	2,7	3	4,2	E61M5	E61M5V	E61M5T	-
◀	6	1	80	10	4,5	3,4	3	5	E61M6	E61M6V	E61M6T	-
	8	1,25	90	13	6	4,9	3	6,8	E61M8	E61M8V	E61M8T	E61M8XP
	10	1,5	100	15	7	5,5	3	8,5	E61M10	E61M10V	E61M10T	E61M10XP
	11	1,5	100	15	8	6,2	3	9,5	E61M11	E61M11V	E61M11T	E61M11XP
	12	1,75	110	18	9	7	3	10,3	E61M12	E61M12V	E61M12T	E61M12XP
	14	2	110	20	11	9	3	12	E61M14	E61M14V	E61M14T	E61M14XP
	16	2	110	20	12	9	4	14	E61M16	E61M16V	E61M16T	E61M16XP
	18	2,5	125	25	14	11	4	15,5	E61M18	E61M18V	E61M18T	E61M18XP
	20	2,5	140	25	16	12	4	17,5	E61M20	E61M20V	E61M20T	E61M20XP
	22	2,5	140	25	18	14,5	4	19,5	E61M22	E61M22V	E61M22T	E61M22XP
	24	3	160	30	18	14,5	4	21	E61M24	E61M24V	E61M24T	E61M24XP
	27	3	160	30	20	16	4	24	E61M27	E61M27V	E61M27T	E61M27XP
	30	3,5	180	35	22	18	4	26,5	E61M30	E61M30V	E61M30T	E61M30XP
	33	3,5	180	35	25	20	4	29,5	E61M33	E61M33V	E61M33T	-
	36	4	200	40	28	22	4	32	E61M36	E61M36V	E61M36T	-
	39	4	200	40	32	24	4	35	E61M39	E61M39V	-	-
	42	4,5	200	40	32	24	5	37,5	E61M42	E61M42V	-	-
■	45	4,5	220	50	36	29	5	40,5	E61M45	E61M45V	-	-
■	48	5	250	50	36	29	5	43	E61M48	E61M48V	-	-
■	52	5	250	50	40	32	5	47	E61M52	E61M52V	-	-

■ = HSS

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min															
P	Acciaio - Steel - Acier - Rm ≤ 850 N/mm²	○1.1 10-15	•1.2 10-15	•1.3 10-12	○1.4 8-10	•1.1 10-15	•1.2 10-15	•1.3 10-12	○1.4 8-10	•1.1 20-30	•1.2 20-30	•1.3 20-25	•1.4 15-20	•1.1 20-30	•1.2 20-30	•1.3 20-25	•1.4 15-20
M	Acciaio inox - Stainless steel - Acier inoxydable													○2.1 10-15	○2.2 8-10		
K	Ghisa - Cast iron - Fonte									○3.3 10-15	•3.4 15-20			○3.3 10-15	•3.4 15-20		
N	Leghe di Allumino - Al alloys - Alliage Al	○4.1 10-15	•4.2 15-20			•4.1 10-15	•4.2 15-20			○4.1 20-25	•4.2 25-30	○4.3 20-25		•4.2 25-30	○4.3 20-25		
N	Leghe di Rame - Copper alloys - Alliages de cuivre	○5.1 8-12	○5.2 10-15			•5.1 8-12	•5.2 10-15			○5.1 15-20	•5.2 20-25			•5.2 20-25			

• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

M

MASCHI A MACCHINA - Elicoidali 35° per fori ciechi filettatura sinistra
MACHINE TAPS - Spiral flutes 35° for blind holes left thread
TARAUDS MACHINE - Goujures hélicoïdales 35° pour trous borgnes filetage à gauche

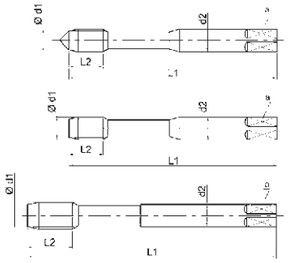
UFS LINE

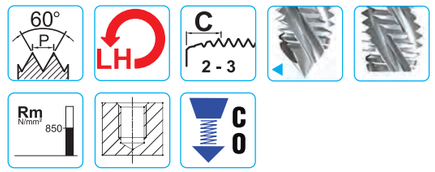
DIN13 USO GENERALE - GENERAL PURPOSE - USAGE GÉNÉRAL

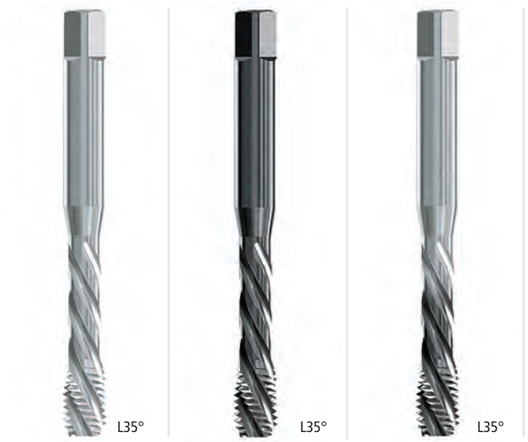
DIN 371 d1 ≤ M6

DIN 371 d1 M8, M10

DIN 376 d1 ≥ M12







Profondità di filettatura - Thread depth - Prof. de filetage	2,5xD	2,5xD	2,5xD
Materiale - Tool Material - Substrat	HSSE	HSSE	HSSE
Tolleranza - Thread tolerance - Tolérance du filetage	ISO2/6H	ISO2/6H	ISO2/6H
Trattamento superficiale - Surface treatment - Revêtement		V	XP

DIN 371	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE		
◀	4	0,7	63	7	4,5	3,4	3	3,3	E60M4LH	E60M4LH-V	E60M4LH-XP
◀	5	0,8	70	8	6	4,9	3	4,2	E60M5LH	E60M5LH-V	E60M5LH-XP
◀	6	1	80	10	6	4,9	3	5	E60M6LH	E60M6LH-V	E60M6LH-XP
	8	1,25	90	13	8	6,2	3	6,8	E60M8LH	E60M8LH-V	E60M8LH-XP
	10	1,5	100	15	10	8	3	8,5	E60M10LH	E60M10LH-V	E60M10LH-XP

DIN 376	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE		
	12	1,75	110	18	9	7	3	10,3	E61M12LH	E61M12LH-V	E61M12LH-XP
	14	2	110	20	11	9	3	12	E61M14LH	E61M14LH-V	E61M14LH-XP
	16	2	110	20	12	9	4	14	E61M16LH	E61M16LH-V	E61M16LH-XP
	18	2,5	125	25	14	11	4	15,5	E61M18LH	E61M18LH-V	E61M18LH-XP
	20	2,5	140	25	16	12	4	17,5	E61M20LH	E61M20LH-V	E61M20LH-XP
	22	2,5	140	25	18	14,5	4	19,5	E61M22LH	E61M22LH-V	E61M22LH-XP
	24	3	160	30	18	14,5	4	21	E61M24LH	E61M24LH-V	E61M24LH-XP

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min												
P	Acciaio - Steel - Acier - Rm ≤ 850 N/mm²	◑1.1 10-15	•1.2 10-15	•1.3 10-12	◑1.4 8-10	•1.1 10-15	•1.2 10-15	•1.3 10-12	◑1.4 8-10	•1.1 20-30	•1.2 20-30	•1.3 20-25	•1.4 15-20	
M	Acciaio inox - Stainless steel - Acier inoxydable									◑2.1 10-15	◑2.2 8-10			
K	Ghisa - Cast iron - Fonte									◑3.3 10-15	•3.4 15-20			
N	Leghe di Allumino - Al alloys - Alliage Al	◑4.1 10-15	•4.2 15-20			•4.1 10-15	•4.2 15-20			•4.2 25-30	◑4.3 20-25			
N	Leghe di Rame - Copper alloys - Alliages de cuivre	◑5.1 8-12	◑5.2 10-15			•5.1 8-12	•5.2 10-15			•5.2 20-25				

• Raccomandato - Optimal - Recommandé ◑ Adatto - Suitable - Adaptè

M

MASCHI A MACCHINA - Elicoidali 40° per fori ciechi tolleranza 4H e 6G
MACHINE TAPS - Spiral flutes 40° for blind holes tolerance 4H and 6G
TARAUDS MACHINE - Goujures hélicoïdales 40° pour trous borgnes tolérance 4H et 6G

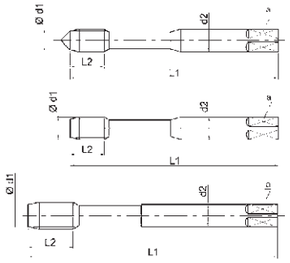
UFS LINE

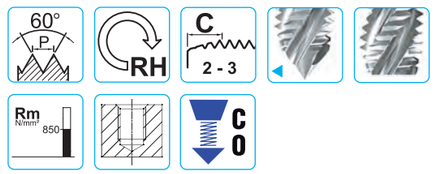
DIN13 USO GENERALE - GENERAL PURPOSE - USAGE GÉNÉRAL

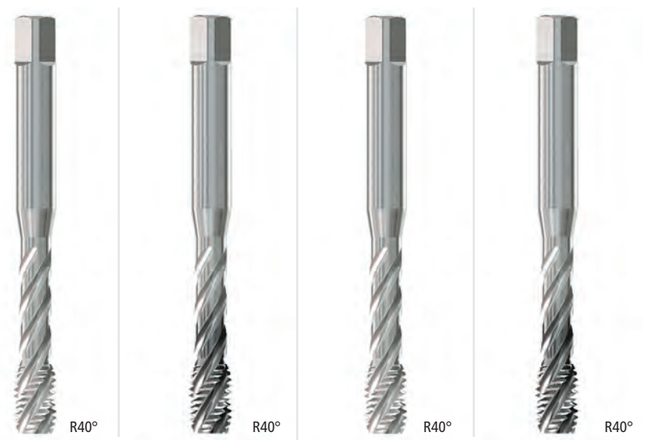
DIN 371 d1 ≤ M6

DIN 371 d1 M8, M10

DIN 376 d1 ≥ M12







Profondità di filettatura - Thread depth - Prof. de filetage	2,5xD	2,5xD	2,5xD	2,5xD
Materiale - Tool Material - Substrat	HSSE	HSSE	HSSE	HSSE
Tolleranza - Thread tolerance - Tolérance du filetage	ISO1/4H	ISO1/4H	ISO3/6G	ISO3/6G
Trattamento superficiale - Surface treatment - Revêtement		XP		XP

DIN 371	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE			
◀	3	0,5	56	5	3,5	2,7	3	2,5	E60M3-4H	E60M3XP-4H	E60M3-6G	E60M3XP-6G
◀	4	0,7	63	7	4,5	3,4	3	3,3	E60M4-4H	E60M4XP-4H	E60M4-6G	E60M4XP-6G
◀	5	0,8	70	8	6	4,9	3	4,2	E60M5-4H	E60M5XP-4H	E60M5-6G	E60M5XP-6G
◀	6	1	80	10	6	4,9	3	5	E60M6-4H	E60M6XP-4H	E60M6-6G	E60M6XP-6G
	8	1,25	90	13	8	6,2	3	6,8	E60M8-4H	E60M8XP-4H	E60M8-6G	E60M8XP-6G
	10	1,5	100	15	10	8	3	8,5	E60M10-4H	E60M10XP-4H	E60M10-6G	E60M10XP-6G

DIN 376	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE			
	12	1,75	110	18	9	7	3	10,3	E61M12-4H	E61M12XP-4H	E61M12-6G	E61M12XP-6G
	14	2	110	20	11	9	3	12	E61M14-4H	E61M14XP-4H	E61M14-6G	E61M14XP-6G
	16	2	110	20	12	9	4	14	E61M16-4H	E61M16XP-4H	E61M16-6G	E61M16XP-6G
	18	2,5	125	25	14	11	4	15,5	E61M18-4H	E61M18XP-4H	E61M18-6G	E61M18XP-6G
	20	2,5	140	25	16	12	4	17,5	E61M20-4H	E61M20XP-4H	E61M20-6G	E61M20XP-6G
	22	2,5	140	25	18	14,5	4	19,5	E61M22-4H	E61M22XP-4H	E61M22-6G	E61M22XP-6G
	24	3	160	30	18	14,5	4	21	E61M24-4H	E61M24XP-4H	E61M24-6G	E61M24XP-6G

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min														
P	Acciaio - Steel - Acier - Rm ≤ 850 N/mm²	◑1.1 10-15	•1.2 10-15	•1.3 10-12	◑1.4 8-10	•1.1 20-30	•1.2 20-30	•1.3 20-25	•1.4 15-20	◑1.1 10-15	•1.2 10-15	•1.3 10-12	◑1.4 8-10	•1.1 20-30	•1.2 20-30	•1.3 20-25	•1.4 15-20
M	Acciaio inox - Stainless steel - Acier inoxydable					◑2.1 10-15	◑2.2 8-10							◑2.1 10-15	◑2.2 8-10		
K	Ghisa - Cast iron - Fonte					◑3.3 10-15	•3.4 15-20							◑3.3 10-15	•3.4 15-20		
N	Leghe di Allumino - Al alloys - Alliage Al	◑4.1 10-15	•4.2 15-20			•4.2 25-30	◑4.3 20-25			◑4.1 10-15	•4.2 15-20			•4.2 25-30	◑4.3 20-25		
N	Leghe di Rame - Copper alloys - Alliages de cuivre	◑5.1 8-12	◑5.2 10-15			•5.2 20-25				◑5.1 8-12	◑5.2 10-15			•5.2 20-25			

• Raccomandato - Optimal - Recommandé ◑ Adatto - Suitable - Adaptè

M

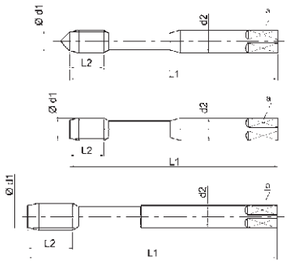
MASCHI A MACCHINA - Elicoidali 40° per fori ciechi tolleranza 7G e 6H+0,1
MACHINE TAPS - Spiral flutes 40° for blind holes tolerance 7G and 6H+0,1
TARAUDS MACHINE - Goujures hélicoïdales 40° pour trous borgnes tolérance 7G et 6H+0,1

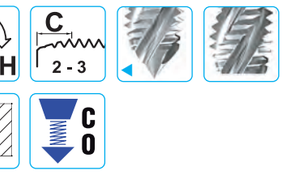
DIN13 — USO GENERALE - GENERAL PURPOSE - USAGE GÉNÉRAL

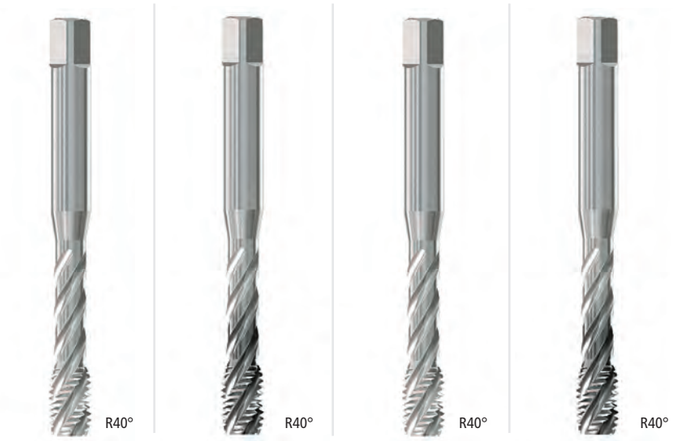
DIN 371 d1 ≤ M6

DIN 371 d1 M8, M10

DIN 376 d1 ≥ M12







Profondità di filettatura - Thread depth - Prof. de filetage	2,5xD	2,5xD	2,5xD	2,5xD
Materiale - Tool Material - Substrat	HSSE	HSSE	HSSE	HSSE
Tolleranza - Thread tolerance - Tolérance du filetage	7G	7G	6H+0,1	6H+0,1
Trattamento superficiale - Surface treatment - Revêtement		XP		XP

DIN 371	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE			
◀	3	0,5	56	5	3,5	2,7	3	2,5	E60M3-7G	E60M3XP-7G	E60M3+0,1	E60M3XP+0,1
◀	4	0,7	63	7	4,5	3,4	3	3,3	E60M4-7G	E60M4XP-7G	E60M4+0,1	E60M4XP+0,1
◀	5	0,8	70	8	6	4,9	3	4,2	E60M5-7G	E60M5XP-7G	E60M5+0,1	E60M5XP+0,1
◀	6	1	80	10	6	4,9	3	5	E60M6-7G	E60M6XP-7G	E60M6+0,1	E60M6XP+0,1
	8	1,25	90	13	8	6,2	3	6,8	E60M8-7G	E60M8XP-7G	E60M8+0,1	E60M8XP+0,1
	10	1,5	100	15	10	8	3	8,5	E60M10-7G	E60M10XP-7G	E60M10+0,1	E60M10XP+0,1

DIN 376	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE			
	12	1,75	110	18	9	7	3	10,3	E61M12-7G	E61M12XP-7G	E61M12+0,1	E61M12XP+0,1
	14	2	110	20	11	9	3	12	E61M14-7G	E61M14XP-7G	E61M14+0,1	E61M14XP+0,1
	16	2	110	20	12	9	4	14	E61M16-7G	E61M16XP-7G	E61M16+0,1	E61M16XP+0,1
	18	2,5	125	25	14	11	4	15,5	E61M18-7G	E61M18XP-7G	E61M18+0,1	E61M18XP+0,1
	20	2,5	140	25	16	12	4	17,5	E61M20-7G	E61M20XP-7G	E61M20+0,1	E61M20XP+0,1
	22	2,5	140	25	18	14,5	4	19,5	E61M22-7G	E61M22XP-7G	E61M22+0,1	E61M22XP+0,1
	24	3	160	30	18	14,5	4	21	E61M24-7G	E61M24XP-7G	E61M24+0,1	E61M24XP+0,1

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min														
P	Acciaio - Steel - Acier - Rm ≤ 850 N/mm²	◦1.1 10-15	•1.2 10-15	•1.3 10-12	◦1.4 8-10	•1.1 20-30	•1.2 20-30	•1.3 20-25	•1.4 15-20	◦1.1 10-15	•1.2 10-15	•1.3 10-12	◦1.4 8-10	•1.1 20-30	•1.2 20-30	•1.3 20-25	•1.4 15-20
M	Acciaio inox - Stainless steel - Acier inoxydable					◦2.1 10-15	◦2.2 8-10							◦2.1 10-15	◦2.2 8-10		
K	Ghisa - Cast iron - Fonte					◦3.3 10-15	•3.4 15-20							◦3.3 10-15	•3.4 15-20		
N	Leghe di Allumino - Al alloys - Alliage Al	◦4.1 10-15	•4.2 15-20			•4.2 25-30	◦4.3 20-25			◦4.1 10-15	•4.2 15-20			•4.2 25-30	◦4.3 20-25		
N	Leghe di Rame - Copper alloys - Alliages de cuivre	◦5.1 8-12	◦5.2 10-15			•5.2 20-25				◦5.1 8-12	◦5.2 10-15			•5.2 20-25			

• Raccomandato - Optimal - Recommandé ◦ Adatto - Suitable - Adaptè

M

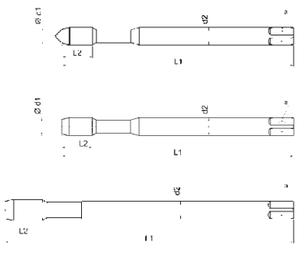
MASCHI A MACCHINA - Elica destra a 40° per fori ciechi **gambo lungo**
MACHINE TAPS - Spiral flutes 40° for blind holes **long shank**
TARAUDS MACHINE - Goujures hélicoïdales 40° pour trous borgnes **queue long**

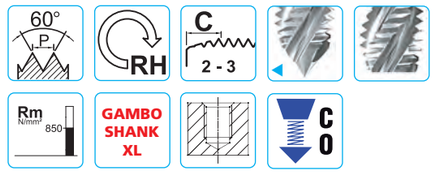
DIN13 — USO GENERALE - GENERAL PURPOSE - USAGE GÉNÉRAL

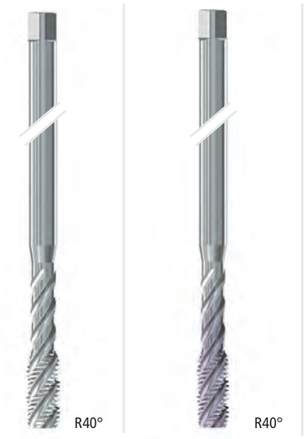
UFS Norm d1 ≤ M6

UFS Norm d1 M8, M10

UFS Norm d1 ≥ M12







Profondità di filettatura - Thread depth - Prof. de filetage	2,5xD	2,5xD		
Materiale - Tool Material - Substrat	HSSE	HSSE		
Tolleranza - Thread tolerance - Tolérance du filetage	ISO2/6H	ISO2/6H		
Trattamento superficiale - Surface treatment - Revêtement		TiCN		

UFS Norm	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE			
◀	4	0,7	125	7	4,5	3,4	3	3,3	L60M4	L60M4CT		
◀	5	0,8	140	8	6	4,9	3	4,2	L60M5	L60M5CT		
◀	6	1	160	10	6	4,9	3	5	L60M6	L60M6CT		
	8	1,25	180	13	8	6,2	3	6,8	L60M8	L60M8CT		
	10	1,5	180	16	10	8	3	8,5	L60M10	L60M10CT		

UFS Norm	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE			
	12	1,75	225	23	9	7	3	10,3	L61M12	L61M12CT		
	14	2	225	23	11	9	3	12	L61M14	L61M14CT		
	16	2	225	23	12	9	4	14	L61M16	L61M16CT		

Dimensioni a norma di fabbrica
Dimensions according to standard factory
Dimensions selon la norme d'usine

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min														
P	Acciaio - Steel - Acier - Rm ≤ 850 N/mm²	◦1.1 10-15	•1.2 10-15	•1.3 10-12	◦1.4 8-10	•1.1 20-30	•1.2 20-30	•1.3 20-25	•1.4 15-20							
M	Acciaio inox - Stainless steel - Acier inoxydable					◦2.1 10-15	◦2.2 8-10									
K	Ghisa - Cast iron - Fonte					◦3.3 10-15	•3.4 15-20									
N	Leghe di Allumino - Al alloys - Alliage Al	◦4.1 10-15	•4.2 15-20			•4.2 25-30	◦4.3 20-25									
N	Leghe di Rame - Copper alloys - Alliages de cuivre	◦5.1 8-12	◦5.2 10-15			•5.2 20-25										

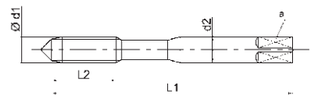
• Raccomandato - Optimal - Recommandé ◦ Adatto - Suitable - Adaptè

M

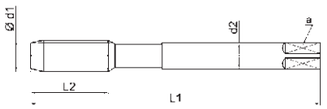
MASCHI A MACCHINA - Elica destra a 45° per fori ciechi
MACHINE TAPS - Spiral flutes 45° for blind holes
TARAUDS MACHINE - Goujures hélicoïdales 45° pour trous borgnes

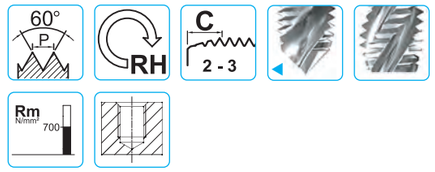
DIN13 | AL-CU-FE | ALLUMINIO, RAME, FERRO - ALUMINIUM, COPPER, IRON - ALUMINIUM, CUIVRE, FER

DIN 371 d1 ≤ M10



DIN 376 d1 = M12





LINE

TOP

Profondità di filettatura - Thread depth - Prof. de filetage	3xD	3xD		
Materiale - Tool Material - Substrat	HSSE	HSSE		
Tolleranza - Thread tolerance - Tolérance du filetage	ISO2/6H	ISO2/6H		
Trattamento superficiale - Surface treatment - Revêtement		TXC		

DIN 371	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z	
◀	3	0,5	56	10	3,5	2,7	2	2,5
◀	4	0,7	63	13	4,5	3,4	2	3,3
◀	5	0,8	70	13	6	4,9	2	4,2
◀	6	1	80	16	6	4,9	2	5
◀	8	1,25	90	18	8	6,2	2	6,8
◀	10	1,5	100	20	10	8	2	8,5

CODE		
E70M3	E70M3TXC	
E70M4	E70M4TXC	
E70M5	E70M5TXC	
E70M6	E70M6TXC	
E70M8	E70M8TXC	
E70M10	E70M10TXC	

DIN 376	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z	
	12	1,75	110	25	9	7	3	10,3
	14	2	110	28	11	9	3	12
	16	2	110	28	12	9	3	14

CODE	
E71M12	E71M12TXC
E71M14	E71M14TXC
E71M16	E71M16TXC

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min							
P	Acciaio dolce magnetico - Magnetic soft steel - Acier doux magnétique - Rm <400 N/mm²	•1.1 10-15			•1.1 20-30				
N	Leghe di Allumino - Al alloys - Alliage Al	•4.1 10-15	•4.2 15-20		•4.1 20-25	•4.2 25-30	○4.2 20-25		
N	Leghe di Rame - Copper alloys - Alliages de cuivre	•5.1 8-12	•5.2 10-15		•5.1 15-202	•5.2 20-25			
S	Titanio puro - Pure titanium - Titane pur	•6.1 5-8							
S	Nichel puro - Pure nickel - Nickel pure	•7.1 6-8							
N	Materiali termoplastici - Thermoplastics - Thermoplastiques Truciolo lungo - Long chipping - Copeaux longue	•8.1 20-25							

• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

M

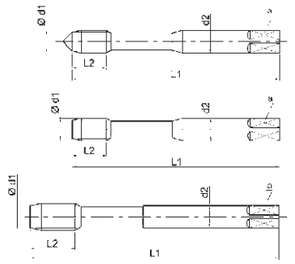
MASCHI A MACCHINA - Elica destra a 40° per fori ciechi
MACHINE TAPS - Spiral flutes 40° for blind holes
TARAUDS MACHINE - Goujures hélicoïdales 40° pour trous borgnes

DIN13 | USO GENERALE - GENERAL PURPOSE - USAGE GÉNÉRAL

DIN 371 d1 ≤ M6

DIN 371 d1 = M8, M10

DIN 376 d1 ≥ M12



Profondità di filettatura - Thread depth - Prof. de filetage	2,5xD	2,5xD	2,5xD	
Materiale - Tool Material - Substrat	HSSP	HSSP	HSSP	
Tolleranza - Thread tolerance - Tolérance du filetage	ISO2/6H	ISO2/6H	ISO2/6H	
Trattamento superficiale - Surface treatment - Revêtement		V	XP	

DIN 371	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z	
◀	3	0,5	56	5	3,5	2,7	3	2,5
◀	4	0,7	63	7	4,5	3,4	3	3,3
◀	5	0,8	70	8	6	4,9	3	4,2
◀	6	1	80	10	6	4,9	3	5
	8	1,25	90	13	8	6,2	3	6,8
	10	1,5	100	15	10	8	3	8,5

CODE		
P60M3	P60M3V	P60M3XP
P60M4	P60M4V	P60M4XP
P60M5	P60M5V	P60M5XP
P60M6	P60M6V	P60M6XP
P60M8	P60M8V	P60M8XP
P60M10	P60M10V	P60M10XP

DIN 376	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z	
	12	1,75	110	18	9	7	4	10,3
	14	2	110	20	11	9	4	12
	16	2	110	20	12	9	4	14

CODE		
P61M12	P61M12V	P61M12XP
P61M14	P61M14V	P61M14XP
P61M16	P61M16V	P61M16XP

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min											
P	Acciaio - Steel - Acier - Rm ≤ 1000 N/mm²	•1.2 10-15	•1.3 10-12	•1.4 8-10		•1.2 10-15	•1.3 10-12	•1.4 8-10		•1.2 20-30	•1.3 20-25	•1.4 15-20	○1.5 5-12
M	Acciaio inox - Stainless steel - Acier inoxydable									○2.1 10-15	○2.2 8-10		
K	Ghisa - Cast iron - Fonte									○3.3 10-15	•3.4 15-20		
N	Leghe di Allumino - Al alloys - Alliage Al	○4.2 15-20	•4.3 10-15			○4.2 15-20	•4.3 10-15			○4.2 25-30	•4.3 20-25		
N	Leghe di Rame - Copper alloys - Alliages de cuivre Truciolo lungo - Long chipping - Copeaux longs	•5.2 10-15				•5.2 10-15				•5.2 20-25			

• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

M

MASCHI A MACCHINA - Elicoidali 45° per fori ciechi
MACHINE TAPS - Spiral flutes 45° for blind holes
TARAUDS MACHINE - Goujures hélicoïdales 45° pour trous borgnes

CSC CHIP SYSTEM CONTROL

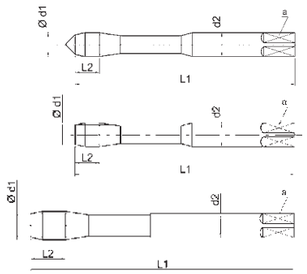
UFS LINE

DIN13 | USO GENERALE - GENERAL PURPOSE - USAGE GÉNÉRAL

DIN 371 d1 ≤ M6

DIN 371 d1 = M8, M10

DIN 376 d1 ≥ M12



60° P | RH | C 2 - 3 | Rm N/mm² 1200 | BT Back Tapered | C O

s-plus NEW

Profondità di filettatura - Thread depth - Prof. de filetage	3xD	3xD	3xD
Materiale - Tool Material - Substrat	HSSE-PM	HSSE-PM	HSSE-PM
Tolleranza - Thread tolerance - Tolérance du filetage	6HX	6HX	6HX
Trattamento superficiale - Surface treatment - Revêtement		V	TiN-G

DIN 371	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE		
◀	3	0,5	56	5	3,5	2,7	3	2,5	E92M3	E92M3V	E92M3TG
◀	4	0,7	63	7	4,5	3,4	3	3,3	E92M4	E92M4V	E92M4TG
◀	5	0,8	70	8	6	4,9	3	4,2	E92M5	E92M5V	E92M5TG
◀	6	1	80	10	6	4,9	3	5	E92M6	E92M6V	E92M6TG
	8	1,25	90	13	8	6,2	3	6,8	E92M8	E92M8V	E92M8TG
	10	1,5	100	15	10	8	3	8,5	E92M10	E92M10V	E92M10TG

DIN 376	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE		
	12	1,75	110	18	9	7	3	10,3	E93M12	E93M12V	E93M12TG
	14	2	110	20	11	9	3	12	E93M14	E93M14V	E93M14TG
	16	2	110	20	12	9	4	14	E93M16	E93M16V	E93M16TG
	18	2,5	125	25	14	11	4	15,5	E93M18	E93M18V	E93M18TG
	20	2,5	140	25	16	12	4	17,5	E93M20	E93M20V	E93M20TG
	22	2,5	140	25	18	14,5	4	19,5	E93M22	E93M22V	E93M22TG
	24	3	160	30	18	14,5	4	21	E93M24	E93M24V	E93M24TG

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min										
P	Acciaio - Steel - Acier - Rm ≤ 1200 N/mm²	❍1.1 10-15	•1.2 10-15	•1.3 10-12	❍1.4 8-10	•1.1 10-15	•1.2 10-15	•1.3 10-12	❍1.4 8-10	•1.2 20-30	•1.3 20-25	•1.4 15-20	❍1.5 5-12
M	Acciaio inox - Stainless steel - Acier inoxydable					•2.1 6-8	•2.2 5-7						
N	Leghe di Allumino - Al alloys - Alliage Al	•4.2 15-20								•4.3 20-25			
N	Leghe di Rame - Copper alloys - Alliages de cuivre	•5.1 8-12	•5.2 10-15							•5.2 20-25			

• Raccomandato - Optimal - Recommandé ❍ Adatto - Suitable - Adaptè

M

MASCHI A MACCHINA - Elicoidali 45° per fori ciechi
MACHINE TAPS - Spiral flutes 45° for blind holes
TARAUDS MACHINE - Goujures hélicoïdales 45° pour trous borgnes

CSC CHIP SYSTEM CONTROL

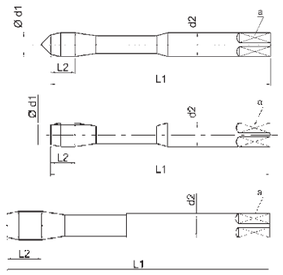
UFS LINE

DIN13 | USO GENERALE - GENERAL PURPOSE - USAGE GÉNÉRAL

DIN 371 d1 ≤ M6

DIN 371 d1 = M8, M10

DIN 376 d1 ≥ M12



60° P | RH | C 2 - 3 | Rm N/mm² 1200 | BT Back Tapered | S R

NEW

Profondità di filettatura - Thread depth - Prof. de filetage	3xD	3,5xD	
Materiale - Tool Material - Substrat	HSSE-PM	HSSE-PM	
Tolleranza - Thread tolerance - Tolérance du filetage	6HX	6HX	
Trattamento superficiale - Surface treatment - Revêtement	TXC	TXC	

DIN 371	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE	
◀	3	0,5	56	5	3,5	2,7	3	2,5	E94M3TXC	-
◀	4	0,7	63	7	4,5	3,4	3	3,3	E94M4TXC	-
◀	5	0,8	70	8	6	4,9	3	4,2	E94M5TXC	-
◀	6	1	80	10	6	4,9	3	5	E94M6TXC	E94M6FOR-TXC
	8	1,25	90	13	8	6,2	3	6,8	E94M8TXC	E94M8FOR-TXC
	10	1,5	100	15	10	8	3	8,5	E94M10TXC	E94M10FOR-TXC

DIN 376	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE	
	12	1,75	110	18	9	7	3	10,3	E95M12TXC	E95M12FOR-TXC
	14	2	110	20	11	9	3	12	E95M14TXC	E95M14FOR-TXC
	16	2	110	20	12	9	4	14	E95M16TXC	E95M16FOR-TXC
	18	2,5	125	25	14	11	4	15,5	E95M18TXC	E95M18FOR-TXC
	20	2,5	140	25	16	12	4	17,5	E95M20TXC	E95M20FOR-TXC
	22	2,5	140	25	18	14,5	4	19,5	E95M22TXC	E95M22FOR-TXC
	24	3	160	30	18	14,5	4	21	E95M24TXC	E95M24FOR-TXC

S R Per filettatura rigida
Syncro rigid threading
Pour le taraudage rigide

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min								
P	Acciaio - Steel - Acier - Rm ≤ 1200 N/mm²	•1.2 20-30	•1.3 20-25	•1.4 15-20	❍1.5 5-12	•1.2 20-30	•1.3 20-25	•1.4 15-20	❍1.5 5-12	
M	Acciaio inox - Stainless steel - Acier inoxydable	•2.1 10-15	•2.2 8-10	•2.3 6-8		•2.1 10-15	•2.2 8-10	•2.3 6-8		
N	Leghe di Allumino – Al alloys - Alliage Al - Si < 10% Truciolo medio - Medium chipping - Copeaux moyen									
N	Leghe di Rame - Copper alloys - Alliages de cuivre Truciolo lungo - Long chipping - Copeaux longs									

• Raccomandato - Optimal - Recommandé ❍ Adatto - Suitable - Adaptè

M

MASCHI A MACCHINA - Elicoidali 45° per fori ciechi
MACHINE TAPS - Spiral flutes 45° for blind holes
TARAUDS MACHINE - Goujures hélicoïdales 45° pour trous borgnes

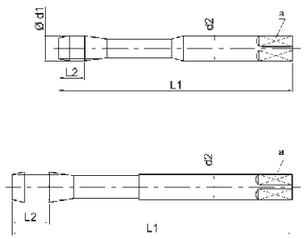
CSC CHIP SYSTEM CONTROL

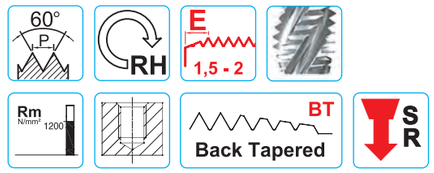
UFS LINE

DIN13 | USO GENERALE - GENERAL PURPOSE - USAGE GÉNÉRAL

DIN 371 d1 ≤ M10

DIN 376 d1 ≥ M12





Profondità di filettatura - Thread depth - Prof. de filetage	3xD	3,5xD		
Materiale - Tool Material - Substrat	HSSE-PM	HSSE-PM		
Tolleranza - Thread tolerance - Tolérance du filetage	6HX	6HX		
Trattamento superficiale - Surface treatment - Revêtement	TXC	TXC		

DIN 371	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z	
	3	0,5	56	5	3,5	2,7	3	2,5
	4	0,7	63	7	4,5	3,4	3	3,3
	5	0,8	70	8	6	4,9	3	4,2
	6	1	80	10	6	4,9	3	5
	8	1,25	90	13	8	6,2	3	6,8
	10	1,5	100	15	10	8	3	8,5

CODE	
E94EM3TXC	-
E94EM4TXC	-
E94EM5TXC	-
E94EM6TXC	E94EM6FOR-TXC
E94EM8TXC	E94EM8FOR-TXC
E94EM10TXC	E94EM10FOR-TXC

DIN 376	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z	
	12	1,75	110	18	9	7	3	10,3
	14	2	110	20	11	9	3	12
	16	2	110	20	12	9	4	14

CODE	
E95EM12TXC	E95EM12FOR-TXC
E95EM14TXC	E95EM14FOR-TXC
E95EM16TXC	E95EM16FOR-TXC

S R Per filettatura rigida
Syncro rigid threading
Pour le taraudage rigide

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min								
P	Acciaio - Steel - Acier - Rm ≤ 1200 N/mm²	•1.2 20-30	•1.3 20-25	•1.4 15-20	◑1.5 5-12	•1.2 20-30	•1.3 20-25	•1.4 15-20	◑1.5 5-12	
M	Acciaio inox - Stainless steel - Acier inoxydable	•2.1 10-15	•2.2 8-10	•2.3 6-8		•2.1 10-15	•2.2 8-10	•2.3 6-8		

• Raccomandato - Optimal - Recommandé ◑ Adatto - Suitable - Adaptè

M

MASCHI A MACCHINA - Elicoidali 45° per fori ciechi
MACHINE TAPS - Spiral flutes 45° for blind holes
TARAUDS MACHINE - Goujures hélicoïdales 45° pour trous borgnes

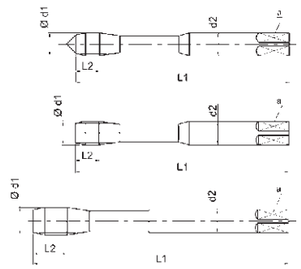
TOP UFS

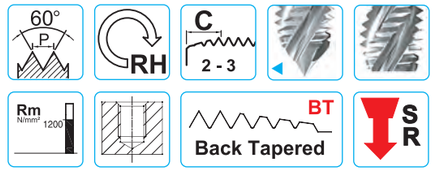
DIN13 | U | APPLICAZIONI UNIVERSALI - UNIVERSAL APPLICATIONS - USINAGE UNIVERSELS

DIN 371 d1 ≤ M6

DIN 371 d1 = M8, M10

DIN 376 d1 ≥ M12





Profondità di filettatura - Thread depth - Prof. de filetage	3xD	3,5xD		
Materiale - Tool Material - Substrat	PM3	PM3		
Tolleranza - Thread tolerance - Tolérance du filetage	6HX	6HX		
Trattamento superficiale - Surface treatment - Revêtement	XP	XP		

DIN 371	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z	
◀	3	0,5	56	5	3,5	2,7	3	2,5
◀	4	0,7	63	7	4,5	3,4	3	3,3
◀	5	0,8	70	8	6	4,9	3	4,2
◀	6	1	80	10	6	4,9	3	5
	8	1,25	90	13	8	6,2	3	6,8
	10	1,5	100	15	10	8	3	8,5

CODE	
K82M3XP	-
K82M4XP	-
K82M5XP	-
K82M6XP	K82M6FOR-XP
K82M8XP	K82M8FOR-XP
K82M10XP	K82M10FOR-XP

DIN 376	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z	
	12	1,75	110	18	9	7	4	10,3
	14	2	110	20	11	9	4	12
	16	2	110	20	12	9	4	14
	18	2,5	125	25	14	11	4	15,5
	20	2,5	140	25	16	12	4	17,5
	22	2,5	140	25	18	14,5	4	19,5
	24	3	160	30	18	14,5	4	21
	27	3	160	30	20	16	4	24
	30	3,5	180	35	22	18	4	26,5

CODE	
K83M12XP	K83M12FOR-XP
K83M14XP	K83M14FOR-XP
K83M16XP	K83M16FOR-XP
K83M18XP	K83M18FOR-XP
K83M20XP	K83M20FOR-XP
K83M22XP	K83M22FOR-XP
K83M24XP	K83M24FOR-XP
K83M27XP	K83M27FOR-XP
K83M30XP	K83M30FOR-XP

S R Raccomandato per filettatura rigida
We recommend Syncro rigid threading
Recommandè pour le taraudage rigide

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min								
P	Acciaio - Steel - Acier - Rm ≤ 1200 N/mm²	◑1.1 20-30	•1.2 20-30	•1.3 20-25	•1.4 15-20	•1.5 5-12	◑1.1 20-30	•1.2 20-30	•1.3 20-25	•1.4 15-20	•1.5 5-12
M	Acciaio inox - Stainless steel - Acier inoxydable	•2.1 10-15	•2.2 8-10	•2.3 6-8			•2.1 10-15	•2.2 8-10	•2.3 6-8		
K	Ghisa - Cast iron - Fonte	•3.3 10-15	•3.4 15-20				•3.3 10-15	•3.4 15-20			
N	Leghe di Allumino - Al alloys - Alliage Al	•4.2 25-30	•4.3 20-25				•4.2 25-30	•4.3 20-25			
N	Leghe di Rame - Copper alloys - Alliages de cuivre Truciolo lungo - Long chipping - Copeaux longs	•5.2 20-25					•5.2 20-25				

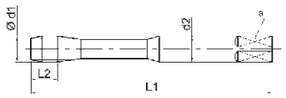
• Raccomandato - Optimal - Recommandé ◑ Adatto - Suitable - Adaptè

M

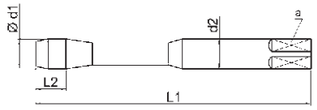
MASCHI A MACCHINA - Elicoidali 40° per fori ciechi
MACHINE TAPS - Spiral flutes 40° for blind holes
TARAUDS MACHINE - Goujures hélicoïdales 40° pour trous borgnes

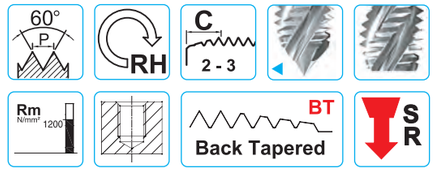
DIN13 | SYNCHRO RIGID | MASCHIATURA RIGIDA SINCRONIZZATA - RIGID TAPPING SYNCHRO - TARAUDAGE RIGIDE SYNCHRONISÉ

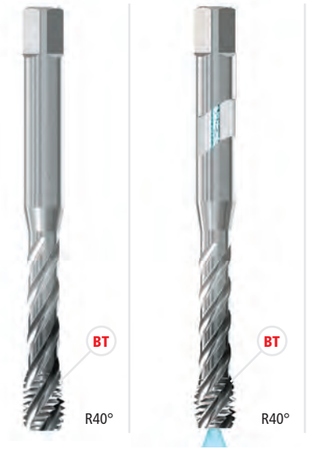
DIN 371 d1 ≤ M10



UFS Norm d1 ≥ M12







Profondità di filettatura - Thread depth - Prof. de filetage	2,5xD	3xD
Materiale - Tool Material - Substrat	PM3	PM3
Tolleranza - Thread tolerance - Tolérance du filetage	6HX	6HX
Trattamento superficiale - Surface treatment - Revêtement	TXC	TXC

DIN 371	Ød1 M	P mm	L_1	L_2	d_2 h6	a h12	Z	
	6	1	80	10	6	4,9	3	5
	8	1,25	90	13	8	6,2	3	6,8
	10	1,5	100	15	10	8	3	8,5

CODE	
S80M6TXC	S80M6FOR-TXC
S80M8TXC	S80M8FOR-TXC
S80M10TXC	S80M10FOR-TXC

UFS Norm	Ød1 M	P mm	L_1	L_2	d_2 h6	a h12	Z	
	12	1,75	110	18	12	9	3	10,3
	14	2	110	20	12	9	3	12
	16	2	110	20	16	12	4	14

CODE	
S80M12TXC	S80M12FOR-TXC
S80M14TXC	S80M14FOR-TXC
S80M16TXC	S80M16FOR-TXC

Dimensioni a norma di fabbrica
Dimensions according to standard factory
Dimensions selon la norme d'usine

Raccomandato per filettatura rigida
We recommend Syncro rigid threading
Recommandè pour le taraudage rigide

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min				
P	Acciaio - Steel - Acier - Rm<1200 N/mm²	•1.1 40-45	•1.2 40-45	•1.3 35-40	•1.4 25-30	•1.5 10-15
M	Acciaio INOX – Stainless steel - Acier inoxydable	•2.1 20-25	•2.2 15-20	•2.3 10-15	•2.4 10-12	
K	Ghisa - Cast iron - Fonte	•3.3 20-25	•3.4 25-30			
N	Leghe di Allumino – Al alloys - Alliage Al Si < 10%	•4.1 30-40	•4.2 45-50	•4.3 30-40		
N	Leghe di Rame - Copper alloys - Alliages de cuivre Truciolo lungo - Long chipping - Copeaux longs	•5.1 20-25	•5.2 25-30			
S	Leghe di titanio - Titanium alloys Alliage de titane Rm<900 N/mm²	•6.1 20-30	○6.2 12-15			
S	Leghe di Nichel - Nickel alloys Alliages de nickel Rm<900 N/mm²	•7.1 20-30	○7.2 8-12			

• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

M

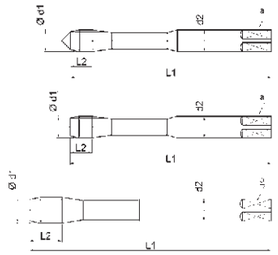
MASCHI A MACCHINA - Elicoidali 40° per fori ciechi
MACHINE TAPS - Spiral flutes 40° for blind holes
TARAUDS MACHINE - Goujures hélicoïdales 40° pour trous borgnes

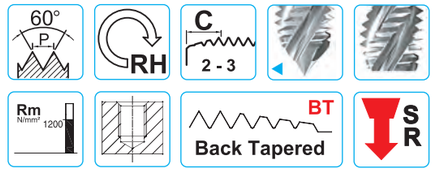
DIN13 | HR | ALTA RESISTENZA - HIGH RESISTANCE - HAUTE RÉSISTANCE

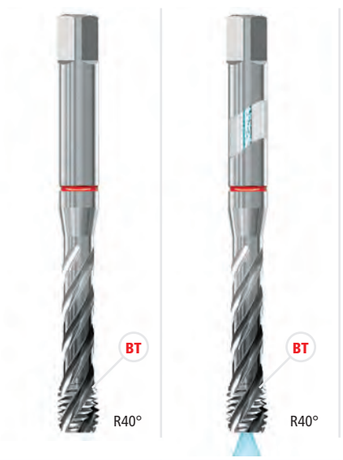
DIN 371 d1 ≤ M6

DIN 371 d1 =M8, M10

DIN 376 d1 ≥ M12







Profondità di filettatura - Thread depth - Prof. de filetage	2,5xD	3xD
Materiale - Tool Material - Substrat	PM3	PM3
Tolleranza - Thread tolerance - Tolérance du filetage	6HX	6HX
Trattamento superficiale - Surface treatment - Revêtement	TXC	TXC

DIN 371	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z	
◄	3	0,5	56	5	3,5	2,7	3	2,5
◄	4	0,7	63	7	4,5	3,4	3	3,3
◄	5	0,8	70	8	6	4,9	3	4,2
◄	6	1	80	10	6	4,9	3	5
	8	1,25	90	13	8	6,2	3	6,8
	10	1,5	100	15	10	8	3	8,5

CODE	
K80M3TXC	-
K80M4TXC	-
K80M5TXC	-
K80M6TXC	K80M6FOR-TXC
K80M8TXC	K80M8FOR-TXC
K80M10TXC	K80M10FOR-TXC

DIN 376	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z	
	12	1,75	110	18	9	7	4	10,3
	14	2	110	20	11	9	4	12
	16	2	110	20	12	9	4	14

CODE	
K81M12TXC	K81M12FOR-TXC
K81M14TXC	K81M14FOR-TXC
K81M16TXC	K81M16FOR-TXC

Raccomandato per filettatura rigida
We recommend Syncro rigid threading
Recommandè pour le taraudage rigide

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min	
P	Acciaio - Steel - Acier - Rm<1200 N/mm²	•1.4 15-20	•1.5 5-12
K	Ghisa - Cast iron - Fonte	•3.3 15-20	•3.4 20-25

• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

M

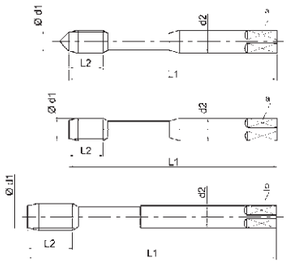
MASCHI A MACCHINA - Elicoidali 45°/48° per fori ciechi
MACHINE TAPS - Spiral flutes 45°/48° for blind holes
TARAUDS MACHINE - Goujures hélicoïdales 45°/48° pour trous borgnes

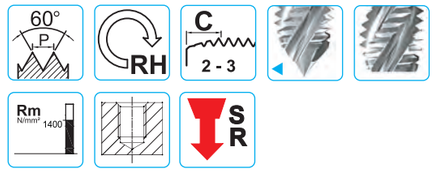
DIN13 | INOX | ACCIAIO INOSSIDABILE - STAINLESS STEEL - ACIER INOXYDABLE

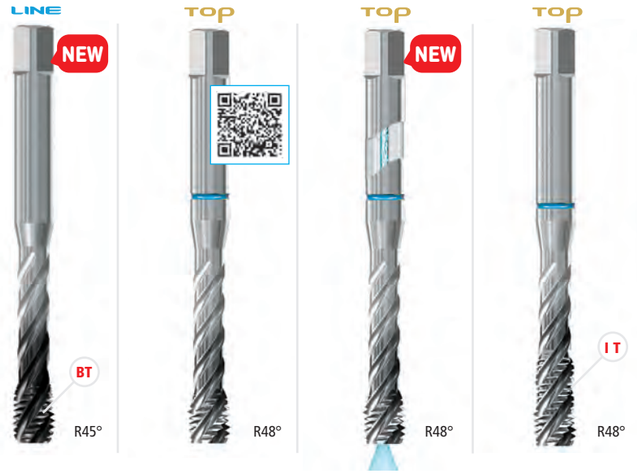
DIN 371 d1 ≤ M6

DIN 371 d1 = M8, M10

DIN 376 d1 ≥ M12







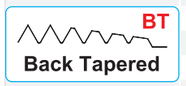
Profondità di filettatura - Thread depth - Prof. de filetage	3xD	3,5xD	3,5xD	3,5xD
Materiale - Tool Material - Substrat	HSSE-PM	HSSV3	HSSV3	PM3
Tolleranza - Thread tolerance - Tolérance du filetage	6HX	6HX	6HX	6HX
Trattamento superficiale - Surface treatment - Revêtement	VS	TXC	TXC	TXC

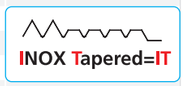
DIN 371	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z	
◀	3	0,5	56	5	3,5	2,7	3	2,5
◀	4	0,7	63	7	4,5	3,4	3	3,3
◀	5	0,8	70	8	6	4,9	3	4,2
◀	6	1	80	10	6	4,9	3	5
	8	1,25	90	13	8	6,2	3	6,8
	10	1,5	100	15	10	8	3	8,5

CODE			
E92M3VS	V82M3TXC	-	K82M3X-TXC
E92M4VS	V82M4TXC	-	K82M4X-TXC
E92M5VS	V82M5TXC	-	K82M5X-TXC
E92M6VS	V82M6TXC	V82M6FOR-TXC	K82M6X-TXC
E92M8VS	V82M8TXC	V82M8FOR-TXC	K82M8X-TXC
E92M10VS	V82M10TXC	V82M10FOR-TXC	K82M10X-TXC

DIN 376	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z	
	12	1,75	110	18	9	7	3	10,3
	14	2	110	20	11	9	3	12
	16	2	110	20	12	9	4	14
	18	2,5	125	25	14	11	4	15,5
	20	2,5	140	25	16	12	4	17,5
	22	2,5	140	25	18	14,5	4	19,5
	24	3	160	30	18	14,5	4	21

CODE			
E93M12VS	V83M12TXC	V83M12FOR-TXC	K83M12X-TXC
E93M14VS	V83M14TXC	V83M14FOR-TXC	K83M14X-TXC
E93M16VS	V83M16TXC	V83M16FOR-TXC	K83M16X-TXC
E93M18VS	V83M18TXC	-	-
E93M20VS	V83M20TXC	-	-
E93M22VS	V83M22TXC	-	-
E93M24VS	V83M24TXC	-	-





ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min														
P	Acciaio - Steel - Acier - Rm ≤ 1400 N/mm²	•1.1 10-15	•1.2 10-15		•1.3 20-25	•1.4 15-20	•1.5 5-12		•1.3 20-25	•1.4 15-20	•1.5 5-12		•1.3 20-25	•1.4 15-20	•1.5 5-12	
M	Acciaio INOX - Stainless steel - Acier inoxydable	•2.1 6-8	•2.2 5-7	•2.3 3-5	•2.1 10-15	•2.2 8-10	•2.3 6-8	◦2.4 3-6	•2.1 10-15	•2.2 8-10	•2.3 6-8	◦2.4 3-6	•2.1 10-15	•2.2 8-10	•2.3 6-8	•2.4 3-6

• Raccomandato - Optimal - Recommandé ◦ Adatto - Suitable - Adaptè

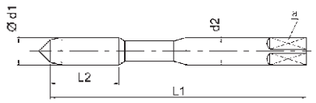
M

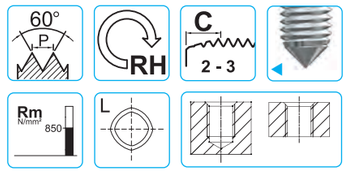
MASCHI A MACCHINA - Per fori ciechi e passanti senza canaline
MACHINE TAPS - For blind and through holes without oil grooves
TARAUDS MACHINE - Pour trous borgnes et débouchant sans rainures de lubrification

DIN13 | P - ROLL | MASCHI A RULLARE - ROLL FORM TAPS - TARAUDS À REFOULER

Rm < 850 Nm/m²

DIN 371 d1 ≤ M10





Profondità di filettatura - Thread depth - Prof. de filetage	3xD	3xD		
Materiale - Tool Material - Substrat	PM8	PM8		
Tolleranza - Thread tolerance - Tolérance du filetage	6HX	6GX		
Trattamento superficiale - Surface treatment - Revêtement	TiN	TiN		

DIN 371	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE	
◀	2	0,4	45	10	2,8	2,1	-	1,82	P2SCM2T	-
◀	2,5	0,45	50	13	2,8	2,1	-	2,30	P2SCM2,5T	-
◀	3	0,5	56	10	3,5	2,7	-	2,80	P2SCM3T	P3SCM3T
◀	4	0,7	63	13	4,5	3,4	-	3,70	P2SCM4T	P3SCM4T
◀	5	0,8	70	13	6	4,9	-	4,65	P2SCM5T	P3SCM5T
◀	6	1	80	16	6	4,9	-	5,55	P2SCM6T	P3SCM6T
◀	8	1,25	90	18	8	6,2	-	7,40	P2SCM8T	P3SCM8T
◀	10	1,5	100	20	10	8	-	9,30	P2SCM10T	P3SCM10T

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min															
P	Acciaio - Steel - Acier - Rm ≤ 850 N/mm²	•1.1 20-30	•1.2 20-30	❍1.3 20-25													
M	Acciaio INOX – Stainless steel - Acier inoxydable	❍2.1 10-15	❍2.2 10-12														
N	Leghe di Allumino – Al alloys - Alliage Al	•4.1 35-40	•4.2 40-45	❍4.3 35-40													
N	Leghe di Rame - Copper alloys - Alliages de cuivre	•5.1 15-20	❍5.2 15-20														

• Raccomandato - Optimal - Recommandé ❍ Adatto - Suitable - Adaptè

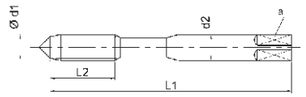
M

MASCHI A MACCHINA - Per fori ciechi e passanti con canalini di lubrificazione
MACHINE TAPS - For blind and through holes with oil grooves
TARAUDS MACHINE - Pour trous borgnes et débouchant avec rainures de lubrification

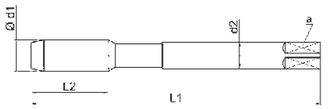
DIN13 | P - ROLL | MASCHI A RULLARE - ROLL FORM TAPS - TARAUDS À REFOULER

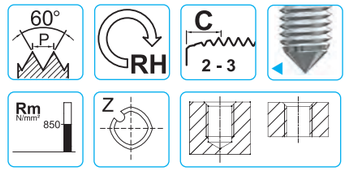
Rm < 850 Nm/m²

DIN 371 d1 ≤ M10



DIN 376 d1 ≥ M12





Profondità di filettatura - Thread depth - Prof. de filetage	3xD	3xD	3xD	3xD
Materiale - Tool Material - Substrat	PM8	PM8	PM8	PM8
Tolleranza - Thread tolerance - Tolérance du filetage	6HX	6HX	6GX	6HX
Trattamento superficiale - Surface treatment - Revêtement	TiN	AHI	TiN	TiN

DIN 371	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE			
◀	3	0,5	56	10	3,5	2,7	2	2,80	P2CCM3T	P2CCM3AHI	P3CCM3T	P2CCM3LH-T
◀	4	0,7	63	13	4,5	3,4	4	3,70	P2CCM4T	P2CCM4AHI	P3CCM4T	P2CCM4LH-T
◀	5	0,8	70	13	6	4,9	5	4,65	P2CCM5T	P2CCM5AHI	P3CCM5T	P2CCM5LH-T
◀	6	1	80	16	6	4,9	5	5,55	P2CCM6T	P2CCM6AHI	P3CCM6T	P2CCM6LH-T
◀	8	1,25	90	18	8	6,2	5	7,40	P2CCM8T	P2CCM8AHI	P3CCM8T	P2CCM8LH-T
◀	10	1,5	100	20	10	8	5	9,30	P2CCM10T	P2CCM10AHI	P3CCM10T	P2CCM10LH-T

DIN 376	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE
	12	1,75	110	25	9	7	5	11,20	P2CCM12T
	14	2	110	28	11	9	6	13,10	P2CCM14T
	16	2	110	28	12	9	6	15,10	P2CCM16T

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min															
P	Acciaio - Steel - Acier - Rm ≤ 850 N/mm²	•1.1 20-30	•1.2 20-30	•1.3 20-25	❍1.4 15-20	•1.1 20-30	•1.2 20-30	•1.3 20-25	❍1.4 15-20	•1.1 20-30	•1.2 20-30	•1.3 20-25	❍1.4 15-20	•1.1 20-30	•1.2 20-30	•1.3 20-25	❍1.4 15-20
M	Acciaio INOX – Stainless steel - Acier inoxydable	❍2.1 10-15	❍2.2 10-12	❍2.3 6-10		•2.1 10-15	•2.2 10-12	•2.3 6-10		❍2.1 10-15	❍2.2 10-12	❍2.3 6-10		❍2.1 10-15	❍2.2 10-12	❍2.3 6-10	
N	Leghe di Allumino – Al alloys - Alliage Al	❍4.1 35-40	❍4.2 40-45	❍4.3 35-40		•4.1 35-40	•4.2 40-45	•4.3 35-40		❍4.1 35-40	❍4.2 40-45	❍4.3 35-40		❍4.1 35-40	❍4.2 40-45	❍4.3 35-40	
N	Leghe di Rame - Copper alloys - Alliages de cuivre	❍5.1 15-20	❍5.2 15-20			•5.1 15-20	•5.2 20-25			❍5.1 15-20	❍5.2 15-20			❍5.1 15-20	❍5.2 15-20		

• Raccomandato - Optimal - Recommandé ❍ Adatto - Suitable - Adaptè

M

MASCHI A MACCHINA - Per fori ciechi e passanti con canalini di lubrificazione
MACHINE TAPS - For blind and through holes with oil grooves
TARAUDS MACHINE - Pour trous borgnes et débouchant avec rainures de lubrification

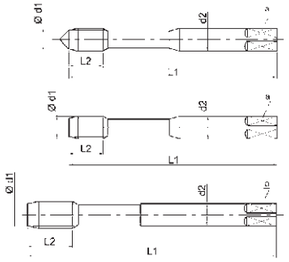
DIN13 | K-ROLL | MASCHI A RULLARE - ROLL FORM TAPS - TARAUDS À REFOULER

Rm < 1200 Nm/m²

DIN 371 d1 ≤ M5

DIN 371 d1 ≤ M10

DIN 376 d1 ≥ M12



60° P RH C 2 - 3 Rm N/mm² 1200 Z CNC

Profondità di filettatura - Thread depth - Prof. de filetage	3xD	3xD	3xD
Materiale - Tool Material - Substrat	PM8	PM8	PM8
Tolleranza - Thread tolerance - Tolérance du filetage	6HX	6HX	6GX
Trattamento superficiale - Surface treatment - Revêtement	TiN-G	AHI	TiN-G

DIN 371	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE		
◄	3	0,7	56	5	3,5	2,7	4	2,80	K2CCM3TG	K2CCM3AHI	K3CCM3TG
◄	4	0,8	63	7	4,5	3,4	4	3,70	K2CCM4TG	K2CCM4AHI	K3CCM4TG
◄	5	0,8	70	8	6	4,9	5	4,65	K2CCM5TG	K2CCM5AHI	K3CCM5TG
	6	1	80	10	6	4,9	5	5,55	K2CCM6TG	K2CCM6AHI	K3CCM6TG
	8	1,25	90	13	8	6,2	5	7,40	K2CCM8TG	K2CCM8AHI	K3CCM8TG
	10	1,5	100	15	10	8	8	9,30	K2CCM10TG	K2CCM10AHI	K3CCM10TG

DIN 376	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE		
	12	1,75	110	18	9	7	8	11,20	K2CCM12TG	K2CCM12AHI	K3CCM12TG
	14	2	110	20	11	9	8	13,10	K2CCM14TG	K2CCM14AHI	K3CCM14TG
	16	2	110	20	12	9	8	15,10	K2CCM16TG	K2CCM16AHI	K3CCM16TG
New	18	2,5	125	25	14	11	8	16,9	K2CCM18TG	K2CCM18AHI	-
New	20	2,5	140	25	16	12	8	18,9	K2CCM20TG	K2CCM20AHI	-
New	22	2,5	140	25	18	14,5	8	20,9	K2CCM22TG	K2CCM22AHI	-
New	24	3	160	30	18	14,5	8	22,7	K2CCM24TG	K2CCM24AHI	-

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min								
P	Acciaio - Steel - Acier - Rm ≤ 1200 N/mm²	•1.3 30-35	•1.4 25-30	•1.5 15-20	•1.3 30-35	•1.4 25-30	•1.5 15-20	•1.3 30-35	•1.4 25-30	•1.5 15-20
M	Acciaio INOX - Stainless steel - Acier inoxydable	❍2.2 10-12	❍2.3 6-10	❍2.4 6-8	❍2.2 10-12	❍2.3 6-10	❍2.4 6-8	❍2.2 10-12	❍2.3 6-10	❍2.4 6-8

• Raccomandato - Optimal - Recommandé ❍ Adatto - Suitable - Adaptè

M

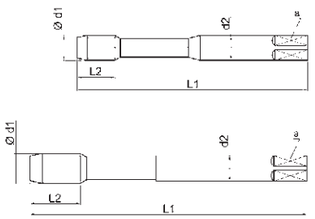
MASCHI A MACCHINA - Per fori ciechi e passanti con canalini di lubrificazione
MACHINE TAPS - For blind and through holes with oil grooves
TARAUDS MACHINE - Pour trous borgnes et débouchant avec rainures de lubrification

DIN13 | K-ROLL | MASCHI A RULLARE - ROLL FORM TAPS - TARAUDS À REFOULER

Rm < 1200 Nm/m²

DIN 371 d1 ≤ M10

DIN 376 d1 ≥ M12



60° P RH C 2 - 3 Rm N/mm² 1200 Z CNC

Profondità di filettatura - Thread depth - Prof. de filetage	3xD	3xD	3xD
Materiale - Tool Material - Substrat	PM8	PM8	PM8
Tolleranza - Thread tolerance - Tolérance du filetage	6HX	6HX	6HX
Trattamento superficiale - Surface treatment - Revêtement	TiN-G	AHI	TiN-G

DIN 371	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE		
	6	1	80	10	6	4,9	5	5,55	K2CCM6FOR-TG	K2CCM6FOR-AHI	K2CCM6FORY-TG
	8	1,25	90	13	8	6,2	5	7,40	K2CCM8FOR-TG	K2CCM8FOR-AHI	K2CCM8FORY-TG
	10	1,5	100	15	10	8	8	9,30	K2CCM10FOR-TG	K2CCM10FOR-AHI	K2CCM10FORY-TG

DIN 376	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE		
	12	1,75	110	18	9	7	8	11,20	K2CCM12FOR-TG	K2CCM12FOR-AHI	K2CCM12FORY-TG
	14	2	110	20	11	9	8	13,10	K2CCM14FOR-TG	K2CCM14FOR-AHI	K2CCM14FORY-TG
	16	2	110	20	12	9	8	15,10	K2CCM16FOR-TG	K2CCM16FOR-AHI	K2CCM16FORY-TG
New	18	2,5	125	25	14	11	8	16,9	K2CCM18FOR-TG	K2CCM18FOR-AHI	K2CCM18FORY-TG
New	20	2,5	140	25	16	12	8	18,9	K2CCM20FOR-TG	K2CCM20FOR-AHI	K2CCM20FORY-TG
New	22	2,5	140	25	18	14,5	8	20,9	K2CCM22FOR-TG	K2CCM22FOR-AHI	K2CCM22FORY-TG
New	24	3	160	30	18	14,5	8	22,7	K2CCM24FOR-TG	K2CCM24FOR-AHI	K2CCM24FORY-TG

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min								
P	Acciaio - Steel - Acier - Rm ≤ 1200 N/mm²	•1.3 30-35	•1.4 25-30	•1.5 15-20	•1.3 30-35	•1.4 25-30	•1.5 15-20	•1.3 30-35	•1.4 25-30	•1.5 15-20
M	Acciaio INOX - Stainless steel - Acier inoxydable	❍2.2 10-12	❍2.3 6-10	❍2.4 6-8	❍2.2 10-12	❍2.3 6-10	❍2.4 6-8	❍2.2 10-12	❍2.3 6-10	❍2.4 6-8

• Raccomandato - Optimal - Recommandé ❍ Adatto - Suitable - Adaptè

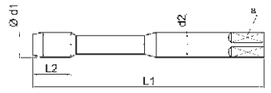
M

MASCHI A MACCHINA - Per fori ciechi con canalini di lubrificazione
MACHINE TAPS - For blind holes with oil grooves
TARAUDS MACHINE - Pour trous borgnes avec rainures de lubrification

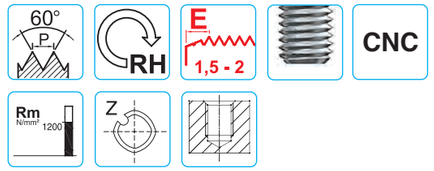
DIN13 | K-ROLL | MASCHI A RULLARE - ROLL FORM TAPS - TARAUDS À REFOULER

Rm < 1200 Nm/m²

DIN 371 d1 ≤ M10



DIN 376 d1 M12, M16



Profondità di filettatura - Thread depth - Prof. de filetage	**3xD**	**3xD**	**3xD**
Materiale - Tool Material - Substrat	**PM8**	**PM8**	**PM8**
Tolleranza - Thread tolerance - Tolérance du filetage	**6HX**	**6HX**	**6HX**
Trattamento superficiale - Surface treatment - Revêtement	**TiN-G**	**AHI**	**TiN-G**

DIN 371	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE		
	6	**1**	80	10	6	4,9	5	5,55	K2CCEM6TG	K2CCEM6AHI	K2CCEM6FOR-TG
	8	**1,25**	90	13	8	6,2	5	7,40	K2CCEM8TG	K2CCEM8AHI	K2CCEM8FOR-TG
	10	**1,5**	100	15	10	8	8	9,30	K2CCEM10TG	K2CCEM10AHI	K2CCEM10FOR-TG

DIN 376	Ød1 M	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE		
New	**12**	**1,75**	110	18	9	7	8	11,20	K2CCEM12TG	K2CCEM12AHI	K2CCEM12FOR-TG
New	**16**	**2**	110	20	12	9	8	15,10	K2CCEM16TG	K2CCEM16AHI	K2CCEM16FOR-TG

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min								
P	Acciaio - Steel - Acier - Rm ≤ 1200 N/mm²	•1.3 30-35	•1.4 25-30	•1.5 15-20	•1.3 30-35	•1.4 25-30	•1.5 15-20	•1.3 30-35	•1.4 25-30	•1.5 15-20
M	Acciaio INOX - Stainless steel - Acier inoxydable	○2.2 10-12	○2.3 6-10	○2.4 6-8	○2.2 10-12	○2.3 6-10	○2.4 6-8	○2.2 10-12	○2.3 6-10	○2.4 6-8

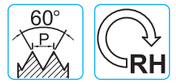
• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

M

Calibri a tampone filettati Passa / Non passa
Thread plug gauges Go / No-Go
Tampon de filetage Entre / N'entre pas

DIN13

DIN ISO 1502



Tolleranza - Thread tolerance - Tolérance du filetage	**6H**
Trattamento superficiale - Surface treatment - Revêtement	

Ød1 M	P mm	CODE
2	**0,4**	P-NPM2
2,2	**0,45**	P-NPM2,2
2,5	**0,45**	P-NPM2,5
3	**0,5**	P-NPM3
3,5	**0,6**	P-NPM3,5
4	**0,7**	P-NPM4
4,5	**0,75**	P-NPM4,5
5	**0,8**	P-NPM5
6	**1**	P-NPM6
7	**1**	P-NPM7
8	**1,25**	P-NPM8
9	**1,25**	P-NPM9
10	**1,5**	P-NPM10
11	**1,5**	P-NPM11
12	**1,75**	P-NPM12
14	**2**	P-NPM14
16	**2**	P-NPM16
18	**2,5**	P-NPM18
20	**2,5**	P-NPM20
22	**2,5**	P-NPM22
24	**3**	P-NPM24
27	**3**	P-NPM27
30	**3,5**	P-NPM30
33	**3,5**	P-NPM33
36	**4**	P-NPM36
39	**4**	P-NPM39
42	**4,5**	P-NPM42
45	**4,5**	P-NPM45
48	**5**	P-NPM48

Le morbide colline

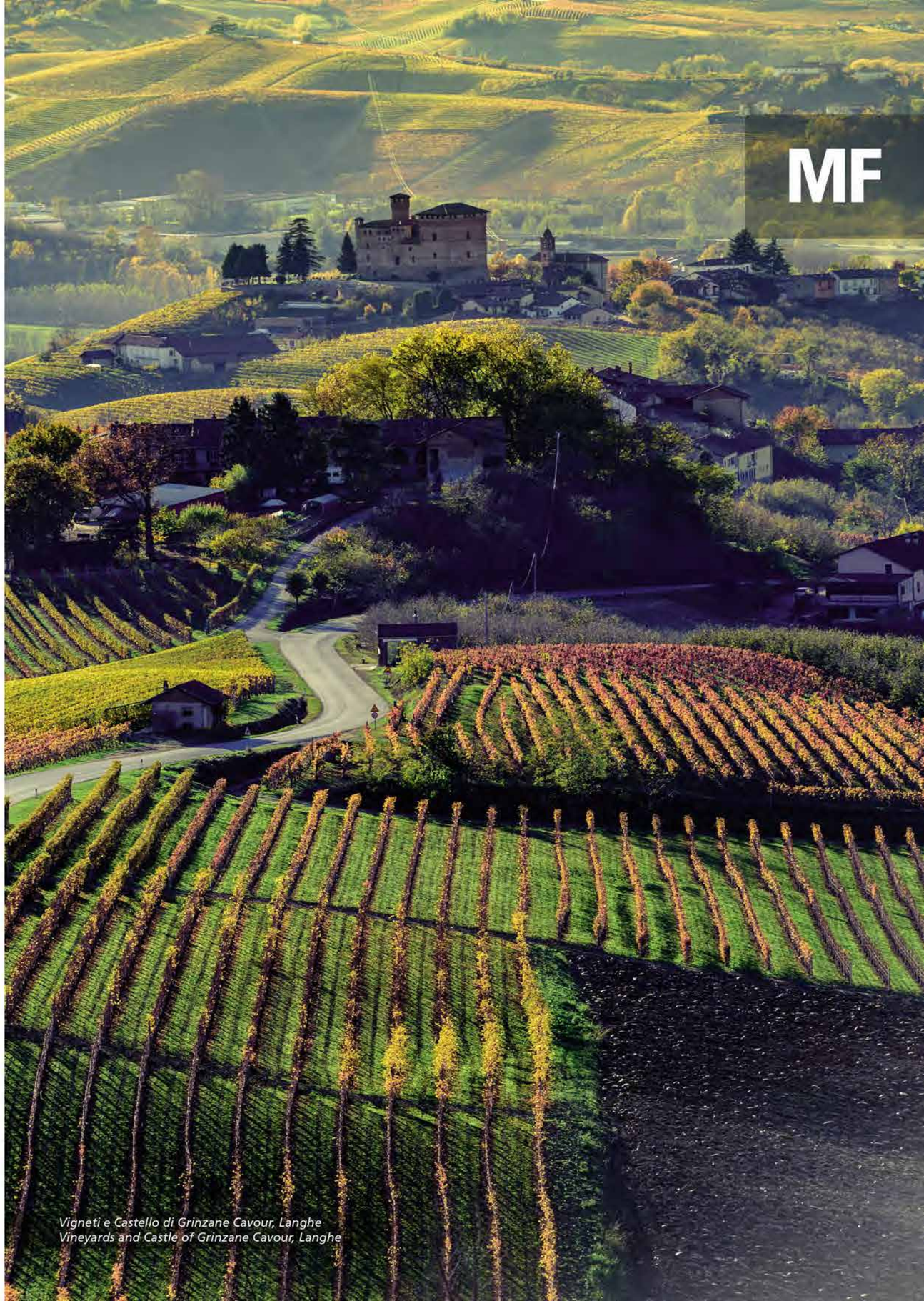
The rolling hills

Le Langhe sono un territorio incantato reso sublime da prodotti enogastronomici di eccellenza e dai suoi paesaggi, con geometrie ondulate di vigneti curati come giardini che in Alta Langa cedono il passo a boschi, noccioleti e pascoli.
Uno scrigno di cultura, patria di indimenticati scrittori che hanno saputo raccontare l'essenza di questi luoghi; di storia, che si legge nel patrimonio artistico di queste colline; di tradizione, soprattutto enologica, che si esprime nei suoi vini apprezzati in tutto il mondo.
Le colline armoniose del Monferrato profumano di vino, tradizione, arte e cultura. La storia ha lasciato tra queste colline bellezze artistiche che vanno dal Romanico al Barocco, un patrimonio di castelli, torri, borghi, palazzi, opere d'arte e antiche pievi, che regalano itinerari tutti da scoprire.
Il Roero è una scoperta continua tra borghi e natura, le dolci colline che convivono accanto a boschi e frutteti. L'elemento più caratteristico del Roero sono certamente le Rocche, veri e propri canyon che tagliano la terra. E' il regalo lasciato dal fiume Tanaro che ha deviato il suo corso, che qui ricopriva ogni cosa. Paesaggi insoliti, boschi che si alternano a balconi panoramici, vite rigogliosa grazie ad un terreno che non ha eguali.

In questi contesti nascono i vini del Piemonte, vere e proprie eccellenze mondiali. Un lungo viaggio tra storia, cultura, millenarie tradizioni e stupendi paesaggi di lunghe distese di vigneti. Le origini della viticoltura piemontese risale alla media età del Bronzo, intorno al 1500 a.C. La viticoltura, mirata alla qualità più che alla quantità del prodotto, è stata dettata dalla particolare conformità morfologica del territorio e dalle condizioni ambientali ai piedi delle montagne. Ciò ha anche permesso alla regione di essere riconosciuta a livello mondiale come zona vinicola di grande importanza.
Il Piemonte può vantare un patrimonio di 18 D.O.C.G. e 42 D.O.C. in un gran numero di vitigni; il Barbera, con più di 16 mila ettari, è quello più diffuso sul territorio regionale seguito da Moscato, Dolcetto e Nebbiolo.
Ma anche Erbaluce, Avanà, Ruchè, Timorasso, Quagliano, Neretta, Avarengo, Freisa, Bonarda, Arneis, Favorita e Malvasia nera oltre a numerosi vitigni autoctoni minori.
Nel 1980 sono state costituite le enoteche regionali e delle botteghe del vino, strutture finalizzate alla valorizzazione sia del prodotto che del territorio di produzione.

The Langhe is a delightful area, made sublime by the excellence of its food and wine and its beautiful scenery, with rolling hills of well-tended vineyards which, in the Upper Langa, give way to woods, hazelnut groves and pasture land.
It's a treasure chest of culture, the birthplace of unforgettable writers who have captured the essence of this land; of history, seen in the artistic heritage of the hill country; and of tradition, particularly wine-making, expressed in wines that are renowned worldwide.
The peaceful hills of Monferrato are steeped in wine, tradition, art and culture. Here history has left art and architecture that ranges from the Romanesque to the Baroque: a legacy of castles, towers, fortified villages and palaces, artworks and ancient churches, in itineraries just waiting to be explored.
The Roero area is a continuous journey of discovery, with its villages and nature, and its gentle hills flanked by woods and orchards. The most distinctive feature of the Roero is undoubtedly the Rocche, a series of gorges that cut through the land. They are the gift of the river Tanaro, which once covered the whole area, but has since changed its course. Extraordinary landscapes, woods interspersed with rocky viewpoints and vines growing luxuriantly in the area's unparalleled soil.

This is the birthplace of Piedmont's wines, a true global excellence. A long journey among history, culture, ancient traditions and breathtaking views of extensive vineyards. The origins of Piedmontese winemaking date back to the Bronze Age around 1500 BC. Vine growing, aiming for quality rather than quantity, was dictated by the specific morphological layout of the land and the weather conditions at the foot of the mountains. These have since led the region to global recognition as an important winemaking area.
Piedmont boasts a total of 18 DOCGs and 42 DOCs for a large number of grape varieties; Barbera, with over 16,000 hectares, is the most widespread in the region, followed by Moscato, Dolcetto and Nebbiolo.
But there are also Erbaluce, Avanà, Ruchè, Timorasso, Quagliano, Neretta, Avarengo, Freisa, Bonarda, Arneis, Favorita and Malvasia nera, as well as numerous minor native grapes.
In 1980 regional wineries and shops were established, to promote both the product and the production area.

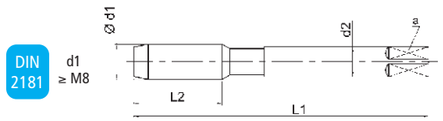


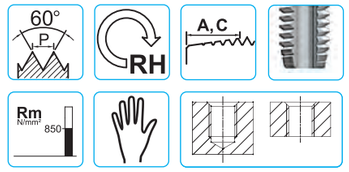
Vigneti e Castello di Grinzane Cavour, Langhe
Vineyards and Castle of Grinzane Cavour, Langhe

MF

MASCHI A MANO - Per fori ciechi e passanti in serie di due pezzi
HAND TAPS - For blind and through holes in sets in sets of two pieces
TARAUDS À MAIN - Pour trous borgnes et débouchant en jeu de deux pièces

DIN13 | USO GENERALE - GENERAL PURPOSE - USAGE GÉNÉRAL





Profondità di filettatura - Thread depth - Prof. de filetage	**2xD**	**2xD**	
Materiale - Tool Material - Substrat	**HSS**	**HSS**	
Tolleranza - Thread tolerance - Tolérance du filetage	**ISO2/6H**	**ISO2/6H**	
Trattamento superficiale - Surface treatment - Revêtement			

	Ød1 MF	P mm	L_1	L_2	d_2 h9	a h12	Z		Finitore Bottoming - Finisseur	Serie Set - Jeu
	8	**1**	63	19	6	4,9	3	7	03MF8X1	00MF8X1
	10	**1**	63	20	7	5,5	3	9	03MF10X1	00MF10X1
	10	**1,25**	70	22	7	5,5	3	8,75	03MF10X1,25	00MF10X1,25
	12	**1**	70	22	9	7	4	11	03MF12X1	00MF12X1
	12	**1,25**	70	22	9	7	4	10,75	03MF12X1,25	00MF12X1,25
	12	**1,5**	70	22	9	7	4	10,5	03MF12X1,5	00MF12X1,5
	14	**1,5**	70	22	11	9	4	12,5	03MF14X1,5	00MF14X1,5
	16	**1**	70	22	12	9	4	15	03MF16X1	00MF16X1
	16	**1,5**	70	22	12	9	4	14,5	03MF16X1,5	00MF16X1,5
	18	**1,5**	80	22	14	11	4	16,5	03MF18X1,5	00MF18X1,5
	20	**1**	80	22	16	12	4	19	03MF20X1	00MF20X1
	20	**1,5**	80	22	16	12	4	18,5	03MF20X1,5	00MF20X1,5
	22	**1**	80	22	18	14,5	4	21	03MF22X1	00MF22X1
	22	**1,5**	80	22	18	14,5	4	20,5	03MF22X1,5	00MF22X1,5
	24	**1,5**	90	22	18	14,5	4	22,5	03MF24X1,5	00MF24X1,5
	24	**2**	90	22	18	14,5	4	22	03MF24X2	00MF24X2
	27	**2**	90	22	20	16	4	25	03MF27X2	00MF27X2
	30	**1,5**	90	22	22	18	4	28,5	03MF30X1,5	00MF30X1,5
	30	**2**	90	22	22	18	4	28	03MF30X2	00MF30X2

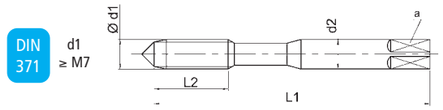
ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min							
P	Acciaio - Steel - Acier - Rm ≤ 850 N/mm²	•1.1	•1.2	•1.3	•1.4	•1.1	•1.2	•1.3	•1.4
M	Acciaio INOX – Stainless steel - Acier inoxydable	◦2.1	◦2.2	◦2.3		◦2.1	◦2.2	◦2.3	
K	Ghisa - Cast iron - Fonte	◦3.1	◦3.4			◦3.1	◦3.4		
N	Leghe di Allumino – Al alloys - Alliage Al	•4.1	•4.2	•4.3	◦4.4	•4.1	•4.2	•4.3	◦4.4
N	Leghe di Rame - Copper alloys - Alliages de cuivre	•5.1	•5.2	◦5.3		•5.1	•5.2	◦5.3	

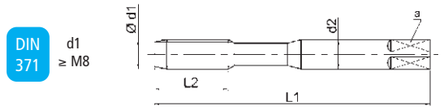
• Raccomandato - Optimal - Recommandé ◦ Adatto - Suitable - Adaptè

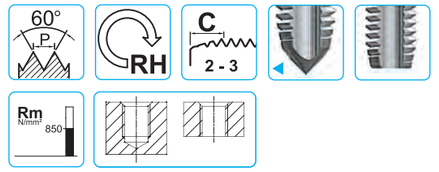
MF

MASCHI A MACCHINA - Scanalature diritte per fori ciechi e passanti
MACHINE TAPS - Straight flutes for blind and through holes
TARAUDS MACHINE - Goujures droites pour trous borgnes et débouchant

DIN13 | USO GENERALE - GENERAL PURPOSE - USAGE GÉNÉRAL







Profondità di filettatura - Thread depth - Prof. de filetage	**1,5xD**		
Materiale - Tool Material - Substrat	**HSSE**		
Tolleranza - Thread tolerance - Tolérance du filetage	**ISO2/6H**		
Trattamento superficiale - Surface treatment - Revêtement			

	DIN 371	Ød1 MF	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE
◀	**4**	**0,5**	63	13	4,5	3,4	3	3,5		E20MF4X0,5
◀	**5**	**0,5**	70	13	6	4,9	3	4,5		E20MF5X0,5
◀	**6**	**0,5**	80	16	6	4,9	3	5,5		E20MF6X0,5
◀	**6**	**0,75**	80	16	6	4,9	3	5,25		E20MF6X0,75
◀	**7**	**0,75**	80	16	7	5,5	3	6,25		E20MF7X0,75
	8	**0,5**	90	18	8	6,2	3	7,5		E20MF8X0,5SP
	8	**0,75**	90	18	8	6,2	3	7,25		E20MF8X0,75SP
	8	**1**	90	18	8	6,2	3	7		E20MF8X1SP
	9	**0,5**	90	18	9	7	3	8,5		E20MF9X0,5
	9	**0,75**	90	18	9	7	3	8,25		E20MF9X0,75
	9	**1**	90	18	9	7	3	8		E20MF9X1
	10	**0,5**	90	15	10	8	3	9,5		E20MF10X0,5SP
	10	**0,75**	90	15	10	8	3	9,25		E20MF10X0,75SP
	10	**1**	90	15	10	8	3	9		E20MF10X1SP
	10	**1,25**	100	20	10	8	3	8,75		E20MF10X1,25SP

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min			
P	Acciaio - Steel - Acier - Rm ≤ 850 N/mm²	◦1.1 10-15	•1.2 10-15	•1.3 10-12	◦1.4 8-10
K	Ghisa - Cast iron - Fonte	◦3.4 8-10			
N	Leghe di Allumino – Al alloys - Alliage Al	◦4.2 15-20	◦4.3 10-15		
N	Leghe di Rame - Copper alloys - Alliages de cuivre	◦5.2 10-15	◦5.3 15-20		
N	Materiali termoindurenti Duroplastic - Thermodurcissables	◦8.2 8-10			

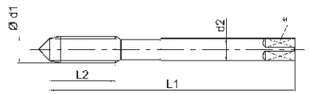
• Raccomandato - Optimal - Recommandé ◦ Adatto - Suitable - Adaptè

MF

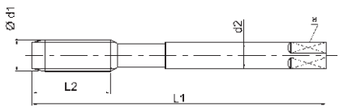
MASCHI A MACCHINA - Scanalature diritte per fori ciechi e passanti
MACHINE TAPS - Straight flutes for blind and through holes
TARAUDS MACHINE - Goujures droites pour trous borgnes et débouchant

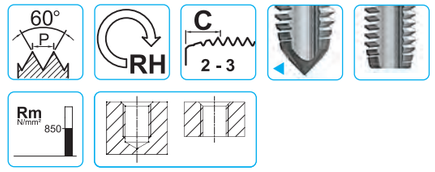
DIN13 | USO GENERALE - GENERAL PURPOSE - USAGE GÉNÉRAL

DIN 374 d1 ≤ M6



DIN 374 d1 ≥ M8





Profondità di filettatura - Thread depth - Prof. de filetage	**1,5xD**
Materiale - Tool Material - Substrat	**HSSE**
Tolleranza - Thread tolerance - Tolérance du filetage	**ISO2/6H**
Trattamento superficiale - Surface treatment - Revêtement	

DIN 374	Ød1 MF	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE
◀	**5**	**0,5**	70	13	3,5	2,7	3	4,5	E21MF5X0,5
◀	**6**	**0,5**	80	16	4,5	3,4	3	5,5	E21MF6X0,5
◀	**6**	**0,75**	80	16	4,5	3,4	3	5,25	E21MF6X0,75
◀	**7**	**0,75**	80	16	5,5	4,3	3	6,25	E21MF7X0,75
	8	**0,5**	90	18	6	4,9	3	7,5	E21MF8X0,5SP
	8	**0,75**	90	18	6	4,9	3	7,25	E21MF8X0,75SP
	8	**1**	90	18	6	4,9	3	7	E21MF8X1SP
	9	**1**	90	18	7	5,5	3	8	E21MF9X1
	10	**0,5**	90	15	7	5,5	3	9,5	E21MF10X0,5SP
	10	**0,75**	90	15	7	5,5	3	9,25	E21MF10X0,75SP
	10	**1**	90	15	7	5,5	3	9	E21MF10X1SP
	10	**1,25**	100	20	7	5,5	3	8,75	E21MF10X1,25SP
	11	**0,75**	90	15	8	6,2	3	10,25	E21MF11X0,75
	11	**1**	90	15	8	6,2	3	10	E21MF11X1
	12	**0,5**	100	22	9	7	3	11,5	E21MF12X0,5
	12	**0,75**	100	22	9	7	3	11,25	E21MF12X0,75
	12	**1**	100	22	9	7	3	11	E21MF12X1
	12	**1,25**	100	22	9	7	3	10,75	E21MF12X1,25
	12	**1,5**	100	22	9	7	3	10,5	E21MF12X1,5
	13	**1**	100	22	11	9	4	12	E21MF13X1
	13	**1,25**	100	22	11	9	4	12,75	E21MF13X1,25
	13	**1,5**	100	22	11	9	4	12,5	E21MF13X1,5
	14	**1**	100	22	11	9	4	13	E21MF14X1
	14	**1,25**	100	22	11	9	4	12,75	E21MF14X1,25

Ød1 MF	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE
14	**1,5**	100	22	11	9	4	12,5	E21MF14X1,5
15	**1**	100	22	12	9	4	14	E21MF15X1
15	**1,25**	100	22	12	9	4	13,75	E21MF15X1,25
15	**1,5**	100	22	12	9	4	13,5	E21MF15X1,5
16	**1**	100	22	12	9	4	15	E21MF16X1
16	**1,25**	100	22	12	9	4	14,75	E21MF16X1,25
16	**1,5**	100	22	12	9	4	14,5	E21MF16X1,5
17	**1**	110	25	14	11	4	16	E21MF17X1
17	**1,5**	110	25	14	11	4	15,5	E21MF17X1,5
18	**1**	110	25	14	11	4	17	E21MF18X1
18	**1,5**	110	25	14	11	4	16,5	E21MF18X1,5
18	**2**	125	33	14	11	4	16	E21MF18X2
19	**1**	110	25	14	11	4	18	E21MF19X1
19	**1,5**	110	25	14	11	4	17,5	E21MF19X1,5
20	**1**	125	25	16	12	4	19	E21MF20X1
20	**1,5**	125	25	16	12	4	18,5	E21MF20X1,5
20	**2**	140	33	16	12	4	18	E21MF20X2
21	**1**	125	25	16	12	4	20	E21MF21X1
21	**1,5**	125	25	16	12	4	19,5	E21MF21X1,5
22	**1**	125	25	18	14,5	4	21	E21MF22X1
22	**1,25**	125	25	18	14,5	4	20,75	E21MF22X1,25

Segue diametri / Diameters continue / Diamètres à suivre

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min				
P	Acciaio - Steel - Acier - Rm ≤ 850 N/mm²	○1.1 10-15	•1.2 10-15	•1.3 10-12	○1.4 8-10	
K	Ghisa - Cast iron - Fonte	○3.4 8-10				
N	Leghe di Allumino – Al alloys - Alliage Al	○4.2 15-20	○4.3 10-15			
N	Leghe di Rame - Copper alloys - Alliages de cuivre	○5.2 10-15	○5.3 15-20			
N	Materiali termoindurenti Duroplastic - Thermodurcissables	○8.2 8-10				

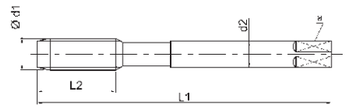
• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

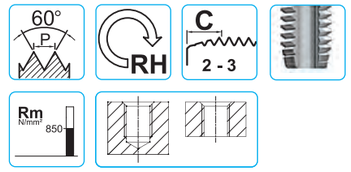
MF

MASCHI A MACCHINA - Scanalature diritte per fori ciechi e passanti
MACHINE TAPS - Straight flutes for blind and through holes
TARAUDS MACHINE - Goujures droites pour trous borgnes et débouchant

DIN13 | USO GENERALE - GENERAL PURPOSE - USAGE GÉNÉRAL

DIN 374





Profondità di filettatura - Thread depth - Prof. de filetage	**1,5xD**
Materiale - Tool Material - Substrat	**HSSE**
Tolleranza - Thread tolerance - Tolérance du filetage	**ISO2/6H**
Trattamento superficiale - Surface treatment - Revêtement	

DIN 374	Ød1 MF	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE
	22	**1,5**	125	25	18	14,5	4	20,5	E21MF22X1,5
	22	**2**	140	33	18	14,5	4	20	E21MF22X2
	23	**1**	125	25	18	14,5	4	22	E21MF23X1
	23	**1,5**	125	25	18	14,5	4	21,5	E21MF23X1,5
	24	**1**	140	25	18	14,5	4	23	E21MF24X1
	24	**1,5**	140	25	18	14,5	4	22,5	E21MF24X1,5
	24	**2**	140	25	18	14,5	4	22	E21MF24X2
	25	**1**	140	25	18	14,5	4	24	E21MF25X1
	25	**1,5**	140	25	18	14,5	4	23,5	E21MF25X1,5
	25	**2**	140	25	18	14,5	4	23	E21MF25X2
	26	**1**	140	25	18	14,5	4	25	E21MF26X1
	26	**1,5**	140	25	18	14,5	4	24,5	E21MF26X1,5
	26	**2**	140	25	18	14,5	4	24	E21MF26X2
	27	**1**	140	25	20	16	4	26	E21MF27X1
	27	**1,5**	140	25	20	16	4	25,5	E21MF27X1,5
	27	**2**	140	25	20	16	4	25	E21MF27X2
	28	**1**	140	25	20	16	4	27	E21MF28X1
	28	**1,5**	140	25	20	16	4	26,5	E21MF28X1,5
	28	**2**	140	25	20	16	4	26	E21MF28X2
	30	**1**	150	28	22	18	4	29	E21MF30X1
	30	**1,5**	150	28	22	18	4	28,5	E21MF30X1,5
	30	**2**	150	28	22	18	4	28	E21MF30X2
	30	**3**	180	46	22	18	4	27	E21MF30X3
	32	**1,5**	150	28	22	18	5	30,5	E21MF32X1,5

Ød1 MF	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE
32	**2**	150	28	22	18	5	30	E21MF32X2
33	**1,5**	160	30	25	20	5	31,5	E21MF33X1,5
33	**2**	160	30	25	20	5	31	E21MF33X2
33	**3**	180	46	25	20	4	30	E21MF33X3
34	**1**	170	30	28	22	5	33	E21MF34X1
34	**1,5**	170	30	28	22	5	32,5	E21MF34X1,5
34	**2**	170	30	28	22	5	32	E21MF34X2
35	**1,5**	170	30	28	22	5	33,5	E21MF35X1,5
35	**2**	170	30	28	22	5	33	E21MF35X2
35	**3**	200	50	28	22	4	32	E21MF35X3
36	**1**	170	30	28	22	5	35	E21MF36X1
36	**1,25**	170	30	28	22	5	34,75	E21MF36X1,25
36	**1,5**	170	30	28	22	5	34,5	E21MF36X1,5
36	**2**	170	30	28	22	5	34	E21MF36X2
36	**3**	200	50	28	22	4	33	E21MF36X3
37	**1**	170	30	28	22	6	36	E21MF37X1
37	**1,5**	170	30	28	22	6	35,5	E21MF37X1,5
38	**1**	170	30	28	22	6	37	E21MF38X1
38	**1,5**	170	30	28	22	6	36,5	E21MF38X1,5
38	**2**	170	30	28	22	6	36	E21MF38X2
38	**3**	200	50	28	22	4	35	E21MF38X3

Segue diametri / Diameters continue / Diamètres à suivre

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min				
P	Acciaio - Steel - Acier - Rm ≤ 850 N/mm²	○1.1 10-15	•1.2 10-15	•1.3 10-12	○1.4 8-10	
K	Ghisa - Cast iron - Fonte	○3.4 8-10				
N	Leghe di Allumino – Al alloys - Alliage Al	○4.2 15-20	○4.3 10-15			
N	Leghe di Rame - Copper alloys - Alliages de cuivre	○5.2 10-15	○5.3 15-20			
N	Materiali termoindurenti Duroplastic - Thermodurcissables	○8.2 8-10				

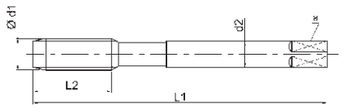
• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

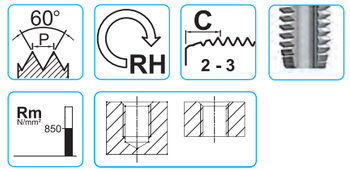
MF

MASCHI A MACCHINA - Scanalature diritte per fori ciechi e passanti
MACHINE TAPS - Straight flutes for blind and through holes
TARAUDS MACHINE - Goujures droites pour trous borgnes et débouchant

DIN13 | USO GENERALE - GENERAL PURPOSE - USAGE GÉNÉRAL

DIN 374





Profondità di filettatura - Thread depth - Prof. de filetage	**1,5xD**
Materiale - Tool Material - Substrat	**HSSE**
Tolleranza - Thread tolerance - Tolérance du filetage	**ISO2/6H**
Trattamento superficiale - Surface treatment - Revêtement	

DIN 374	Ød1 MF	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE
	39	**1**	170	30	32	24	6	38	E21MF39X1
	39	**1,5**	170	30	32	24	6	37,5	E21MF39X1,5
	39	**2**	170	30	32	24	6	37	E21MF39X2
	39	**3**	200	50	32	24	4	36	E21MF39X3
	40	**1**	170	30	32	24	6	39	E21MF40X1
	40	**1,5**	170	30	32	24	6	38,5	E21MF40X1,5
	40	**2**	170	30	32	24	6	38	E21MF40X2
	42	**1,5**	170	30	32	24	6	40,5	E21MF42X1,5
	42	**2**	170	30	32	24	6	40	E21MF42X2
	42	**3**	200	55	32	24	5	39	E21MF42X3
	45	**1,5**	180	32	36	29	6	43,5	E21MF45X1,5
	45	**2**	180	32	36	29	6	43	E21MF45X2
	48	**1,5**	190	32	36	29	6	46,5	E21MF48X1,5
	48	**2**	190	32	36	29	6	46	E21MF48X2
	***48**	**3**	220	65	36	29	6	45	E21MF48X3
	50	**1,5**	190	32	36	29	6	48,5	E21MF50X1,5
	50	**2**	190	32	36	29	6	48	E21MF50X2
	***50**	**3**	220	65	36	29	6	47	E21MF50X3
	52	**1,5**	190	32	40	32	6	50,5	E21MF52X1,5
	52	**2**	190	32	40	32	6	50	E21MF52X2
	***52**	**3**	220	65	40	32	6	49	E21MF52X3
	***54**	**1,5**	190	32	40	32	6	52,5	E21MF54X1,5
	***54**	**2**	190	32	40	32	6	52	E21MF54X2

Ød1 MF	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE
***55**	**1,5**	190	32	40	32	6	53,5	E21MF55X1,5
***55**	**2**	190	32	40	32	6	53	E21MF55X2
***56**	**2**	190	32	40	32	6	54	E21MF56X2
***56**	**3**	220	65	40	32	6	53	E21MF56X3
***56**	**4**	220	65	40	32	6	52	E21MF56X4
***60**	**1,5**	190	32	45	35	6	58,5	E21MF60X1,5
***60**	**2**	190	32	45	35	6	58	E21MF60X2
***60**	**3**	220	65	45	35	6	57	E21MF60X3
***60**	**4**	220	65	45	35	6	56	E21MF60X4
***62**	**1,5**	190	32	50	39	6	60,5	E21MF62X1,5
***63**	**1,5**	190	32	50	39	6	61,5	E21MF63X1,5
***64**	**1,5**	190	32	50	39	6	62,5	E21MF64X1,5
***64**	**2**	190	32	50	39	6	62	E21MF64X2
***64**	**4**	220	65	50	39	6	60	E21MF64X4

* Dimensioni a norma di fabbrica
Dimensions according to standard factory
Dimensions selon la norme d'usine

HSS Ø ≥ 45 — Acciaio HSS oltre ø ≥ 45
HSS Steel over ø ≥ 45
Acier HSS supérieur à ø ≥ 45

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min				
P	Acciaio - Steel - Acier - Rm ≤ 850 N/mm²	○1.1 10-15	•1.2 10-15	•1.3 10-12	○1.4 8-10	
K	Ghisa - Cast iron - Fonte	○3.4 8-10				
N	Leghe di Allumino – Al alloys - Alliage Al	○4.2 15-20	○4.3 10-15			
N	Leghe di Rame - Copper alloys - Alliages de cuivre	○5.2 10-15	○5.3 15-20			
N	Materiali termoindurenti Duroplastic - Thermodurcissables	○8.2 8-10				

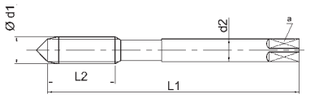
• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

MF

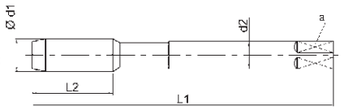
MASCHI A MACCHINA - Scanalature diritte filettatura sinistra
MACHINE TAPS - Straight flutes left thread
TARAUDS MACHINE - Goujures droites filetage à gauche

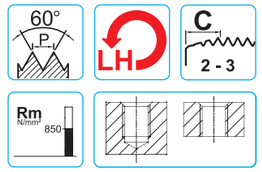
DIN13 | USO GENERALE - GENERAL PURPOSE - USAGE GÉNÉRAL

DIN 374 d1 = M6



DIN 374 d1 ≥ M8





Profondità di filettatura - Thread depth - Prof. de filetage	**1,5xD**
Materiale - Tool Material - Substrat	**HSSE**
Tolleranza - Thread tolerance - Tolérance du filetage	**ISO2/6H**
Trattamento superficiale - Surface treatment - Revêtement	

DIN 374	Ød1 MF	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE
◄	**6**	**0,75**	80	16	4,5	3,4	3	5,25	E21MF6X0,75LH
	8	**1**	90	18	6	4,9	3	7	E21MF8X1LH-SP
	10	**1**	90	15	7	5,5	3	9	E21MF10X1LH-SP
	10	**1,25**	100	20	7	5,5	3	8,75	E21MF10X1,25LH-SP
	12	**1,25**	100	22	9	7	3	10,75	E21MF12X1,25LH
	12	**1,5**	100	22	9	7	3	10,5	E21MF12X1,5LH
	14	**1,5**	100	22	11	9	4	12,5	E21MF14X1,5LH
	16	**1,5**	100	22	12	9	4	14,5	E21MF16X1,5LH
	18	**1,5**	110	25	14	11	4	16,5	E21MF18X1,5LH
	20	**1,5**	125	25	16	12	4	18,5	E21MF20X1,5LH

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min				
P	Acciaio - Steel - Acier - Rm ≤ 850 N/mm²	○1.1 10-15	•1.2 10-15	•1.3 10-12	○1.4 8-10	
K	Ghisa - Cast iron - Fonte	○3.4 8-10				
N	Leghe di Allumino – Al alloys - Alliage Al	○4.2 15-20	○4.3 10-15			
N	Leghe di Rame - Copper alloys - Alliages de cuivre	○5.2 10-15	○5.3 15-20			
N	Materiali termoindurenti Duroplastic - Thermodurcissables	○8.2 8-10				

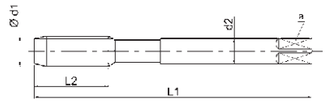
• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

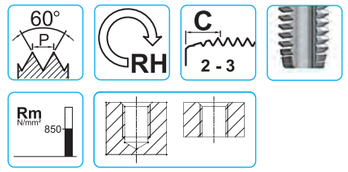
MF

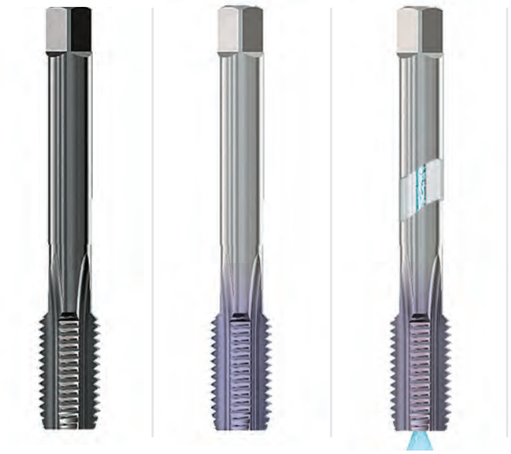
MASCHI A MACCHINA - Scanalature diritte per ghisa
MACHINE TAPS - Straight flutes for cast iron
TARAUDS MACHINE - Goujures droites pour fonte

DIN13 | GG | GHISA - CAST IRON - FONTE

DIN 374 d1 ≥ M8







Profondità di filettatura - Thread depth - Prof. de filetage	3xD	3xD	3,5xD
Materiale - Tool Material - Substrat	HSSE	HSSE	HSSE
Tolleranza - Thread tolerance - Tolérance du filetage	6HX	6HX	6HX
Trattamento superficiale - Surface treatment - Revêtement	NQ	TiCN	TiCN

DIN 374	Ød1 MF	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE		
	8	1	90	18	6	4,9	4	7	E27MF8X1SP-NQ	E27MF8X1SP-CT	E27MF8X1FOR-CT
	9	1	90	18	7	5,5	4	9	-	E27MF9X1CT	E27MF9X1FOR-CT
	10	1	90	15	7	5,5	4	9	E27MF10X1SP-NQ	E27MF10x1SP-CT	E27MF10X1FOR-CT
	10	1,25	100	20	7	5,5	4	8,75	E27MF10X1,25SP-NQ	E27MF10X1,25SP-CT	E27MF10X1,25FOR-CT
	12	1	100	22	9	7	4	11	-	E27MF12X1CT	E27MF12X1FOR-CT
	12	1,25	100	22	9	7	4	10,75	E27MF12X1,25NQ	E27MF12X1,25CT	E27MF12X1,25FOR-CT
	12	1,5	100	22	9	7	4	10,5	E27MF12X1,5NQ	E27MF12X1,5CT	E27MF12X1,5FOR-CT
	14	1,5	100	22	11	9	4	12,5	E27MF14X1,5NQ	E27MF14X1,5CT	E27MF14X1,5FOR-CT
	16	1,5	100	22	12	9	4	14,5	E27MF16X1,5NQ	E27MF16X1,5CT	E27MF16X1,5FOR-CT
	18	1,5	110	25	14	11	4	16,5	E27MF18X1,5NQ	E27MF18X1,5CT	E27MF18X1,5FOR-CT
	20	1,5	125	25	16	12	4	18,5	E27MF20X1,5NQ	E27MF20X1,5CT	E27MF20X1,5FOR-CT
	22	1,5	125	25	18	14,5	4	20,5	E27MF22X1,5NQ	E27MF22X1,5CT	E27MF22X1,5FOR-CT
	24	1,5	140	25	18	14,5	4	22,5	E27MF24X1,5NQ	E27MF24X1,5CT	E27MF24X1,5FOR-CT
	26	1,5	140	25	18	14,5	4	24,5	E27MF26X1,5NQ	E27MF26X1,5CT	-
	27	1,5	140	25	20	16	4	25,5	E27MF27X1,5NQ	E27MF27x1,5CT	E27MF27X1,5FOR-CT
	30	1,5	150	28	22	18	4	28,5	-	E27MF30X1,5CT	E27MF30X1,5FOR-CT

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min											
K	Ghisa - Cast iron - Fonte	•3.1 10-15	•3.2 8-10	○3.3 8-10	○3.4 10-15	•3.1 20-25	•3.2 15-20	○3.3 15-20	○3.4 20-25	•3.1 20-25	•3.2 15-20	○3.3 15-20	○3.4 20-25
N	Leghe Al, Si > 10% Al alloys, Si > 10% - Alliage Al, Si > 10%	•4.4 10-15				•4.4 25-30				•4.4 25-30			
N	Leghe di magnesio Magnesium alloys - Alliages de magnésium	•4.5 10-15				•4.5 20-30				•4.5 20-30			
N	Leghe di Rame - Copper alloys - Alliages de cuivre	•5.3 18-20				•5.3 25-30				•5.3 25-30			
N	Materiali termoindurenti Duroplastic - Thermodurcissables	•8.2 8-10				•8.2 10-15				•8.2 10-15			

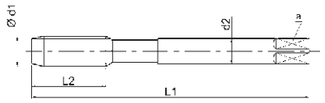
• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

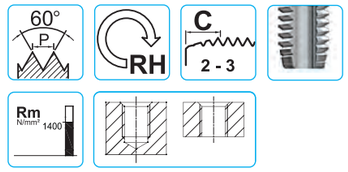
MF

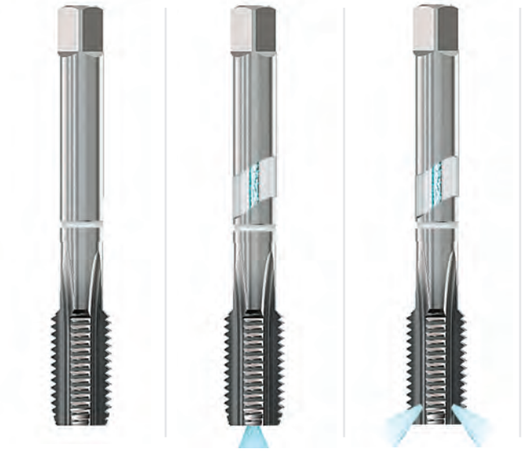
MASCHI A MACCHINA - Scanalature diritte per ghisa
MACHINE TAPS - Straight flutes for cast iron
TARAUDS MACHINE - Goujures droites pour fonte

DIN13 | GG | GHISA - CAST IRON - FONTE

DIN 374 d1 ≥ M8







Profondità di filettatura - Thread depth - Prof. de filetage	3xD	3,5xD	3,5xD
Materiale - Tool Material - Substrat	PM3	PM3	PM3
Tolleranza - Thread tolerance - Tolérance du filetage	6HX	6HX	6HX
Trattamento superficiale - Surface treatment - Revêtement	TiAlN	TiAlN	TiAlN

DIN 374	Ød1 MF	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE		
	8	1	90	18	6	4,9	4	7	K27MF8X1TX	K27MF8X1FOR-TX	K27MF8X1FORY-TX
	10	1	90	15	7	5,5	4	9	K27MF10X1TX	K27MF10X1FOR-TX	K27MF10X1FORY-TX
	10	1,25	100	20	7	5,5	4	8,75	K27MF10X1,25TX	K27MF10X1,25FOR-TX	K27MF10X1,25FORY-TX
	12	1,25	100	22	9	7	4	10,75	K27MF12X1,25TX	K27MF12X1,25FOR-TX	K27MF12X1,25FORY-TX
	12	1,5	100	22	9	7	4	10,5	K27MF12X1,5TX	K27MF12X1,5FOR-TX	K27MF12X1,5FORY-TX
	14	1,5	100	22	11	9	4	12,5	K27MF14X1,5TX	K27MF14X1,5FOR-TX	K27MF14X1,5FORY-TX
	16	1,5	100	22	12	9	4	14,5	K27MF16X1,5TX	K27MF16X1,5FOR-TX	K27MF16X1,5FORY-TX
	18	1,5	110	25	14	11	5	16,5	K27MF18X1,5TX	K27MF18X1,5FOR-TX	K27MF18X1,5FORY-TX
	20	1,5	125	25	16	12	5	18,5	K27MF20X1,5TX	K27MF20X1,5FOR-TX	K27MF20X1,5FORY-TX
	22	1,5	125	25	18	14,5	5	20,5	K27MF22X1,5TX	K27MF22X1,5FOR-TX	K27MF22X1,5FORY-TX
	24	1,5	140	25	18	14,5	5	22,5	K27MF24X1,5TX	K27MF24X1,5FOR-TX	K27MF24X1,5FORY-TX

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min					
K	Ghisa - Cast iron - Fonte	•3.1 25-30	•3.2 20-25	○3.3 20-25	○3.4 25-30	•3.5 10-15	

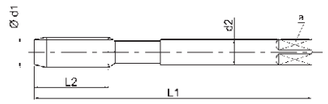
• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

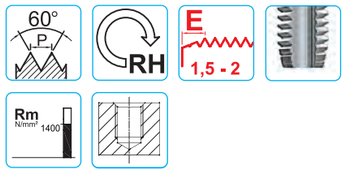
MF

MASCHI A MACCHINA - Scanalature diritte per ghisa imbocco E
MACHINE TAPS - Straight flutes for cast iron chamfer E
TARAUDS MACHINE - Goujures droites pour fonte forme d'entrée E

DIN13 | GG | GHISA - CAST IRON - FONTE

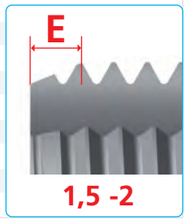
DIN 374 d1 ≥ M8





Profondità di filettatura - Thread depth - Prof. de filetage	3xD	3,5xD	3,5xD
Materiale - Tool Material - Substrat	PM3	PM3	PM3
Tolleranza - Thread tolerance - Tolérance du filetage	6HX	6HX	6HX
Trattamento superficiale - Surface treatment - Revêtement	AHI	AHI	AHI

DIN 374	Ød1 MF	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE		
8	1	90	18	6	4,9	4	7		K27EMF8X1AHI	K27EMF8X1FOR-AHI	K27EMF8X1FORY-AHI
10	1	90	15	7	5,5	4	9		K27EMF10X1AHI	K27EMF10X1FOR-AHI	K27EMF10X1FORY-AHI
10	1,25	100	20	7	5,5	4	8,75		K27EMF10X1,25AHI	K27EMF10X1,25FOR-AHI	K27EMF10X1,25FORY-AHI
12	1,25	100	22	9	7	4	10,75		K27EMF12X1,25AHI	K27EMF12X1,25FOR-AHI	K27EMF12X1,25FORY-AHI
12	1,5	100	22	9	7	4	10,5		K27EMF12X1,5AHI	K27EMF12X1,5FOR-AHI	K27EMF12X1,5FORY-AHI
14	1,5	100	22	11	9	4	12,5		K27EMF14X1,5AHI	K27EMF14X1,5FOR-AHI	K27EMF14X1,5FORY-AHI
16	1,5	100	22	12	9	4	14,5		K27EMF16X1,5AHI	K27EMF16X1,5FOR-AHI	K27EMF16X1,5FORY-AHI



ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min					
K	Ghisa - Cast iron - Fonte	•3.1 25-30	•3.2 20-25	❍3.3 20-25	❍3.4 25-30	•3.5 10-15	

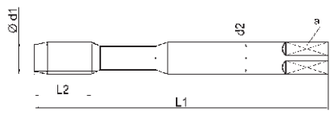
• Raccomandato - Optimal - Recommandé ❍ Adatto - Suitable - Adaptè

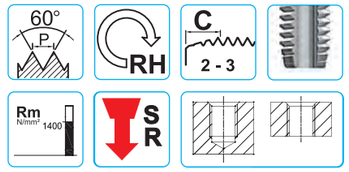
MF

MASCHI A MACCHINA - Scanalature diritte
MACHINE TAPS - Straight flutes
TARAUDS MACHINE - Goujures droites

DIN13 | SYNCHRO RIGID | MASCHIATURA RIGIDA SINCRONIZZATA - RIGID TAPPING SYNCHRO - TARAUDAGE RIGIDE SYNCHRONISÉ

*UFS norm d1 ≥ M8





Profondità di filettatura - Thread depth - Prof. de filetage	3xD	3,5xD
Materiale - Tool Material - Substrat	PM3	PM3
Tolleranza - Thread tolerance - Tolérance du filetage	6HX	6HX
Trattamento superficiale - Surface treatment - Revêtement	TXC	TXC

UFS norm	Ød1 MF	P mm	L_1	L_2	d_2 h6	a h12	Z		CODE	
8	1	90	13	8	6,2	4	7		S20MF8X1TXC	S20MF8X1FOR-TXC
10	1	100	15	10	8	4	9		S20MF10X1TXC	S20MF10X1FOR-TXC
10	1,25	100	15	10	8	4	8,75		S20MF10X1,25TXC	S20MF10X1,25FOR-TXC
12	1,25	110	18	12	9	4	10,75		S20MF12X1,25TXC	S20MF12X1,25FOR-TXC
12	1,5	110	18	12	9	4	10,5		S20MF12X1,5TXC	S20MF12X1,5FOR-TXC
14	1,5	110	20	12	9	4	12,5		S20MF14X1,5TXC	S20MF14X1,5FOR-TXC
16	1,5	110	20	16	12	4	14,5		S20MF16X1,5TXC	S20MF16X1,5FOR-TXC

*Dimensioni a norma di fabbrica
Dimensions according to standard factory
Dimensions selon la norme d'usine

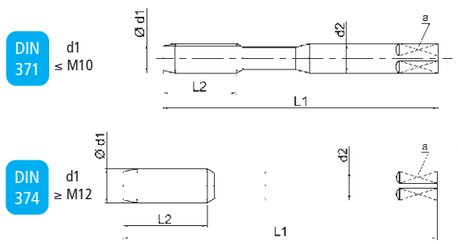
ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min					
P	Acciaio - Steel - Acier - Rm ≤ 1400 N/mm²	❍1.5 10-15	•1.6 8-10				
K	Ghisa - Cast iron - Fonte	•3.1 25-30	•3.2 20-25	❍3.3 20-25	❍3.4 25-30	•3.5 10-15	
N	Leghe di Allumino - Al alloys - Alliage Al	•4.4 25-30					
N	Leghe di magnesio Magnesium alloys - Alliages de magnésium	•4.5 30-40					
N	Leghe di Rame - Copper alloys - Alliages de cuivre	•5.3 35-40	❍5.4 8-10				
N	Materiali termoindurenti Duroplastic - Thermodurcissables	•8.2 20-25	•8.3 10-15				

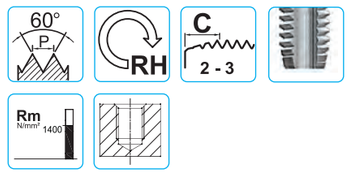
• Raccomandato - Optimal - Recommandé ❍ Adatto - Suitable - Adaptè

MF

MASCHI A MACCHINA - Scanalature diritte - geometria di taglio rompitruciolo
MACHINE TAPS - Straight flutes - chip breaker cutting edge geometry
TARAUDS MACHINE - Goujures droites - géométrie brise copeaux

DIN13 | RT | ROMPITRUCIOLO - CHIP BREAKER - BRISE COPEAUX





Profondità di filettatura - Thread depth - Prof. de filetage	**3,5xD**			
Materiale - Tool Material - Substrat	**PM3**			
Tolleranza - Thread tolerance - Tolérance du filetage	**ISO2/6H**			
Trattamento superficiale - Surface treatment - Revêtement	**TXC**			

DIN 371	Ød1 MF	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE
New	**8**	**1**	90	18	8	6,2	3	7	K22MF8X1FOR-TXC
New	**10**	**1**	100	20	10	8	3	9	K22MF10X1FOR-TXC
New	**10**	**1,25**	100	20	10	8	3	8,75	K22MF10X1,25FOR-TXC

DIN 374	Ød1 MF	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE
New	**12**	**1,25**	100	22	9	7	3	10,75	K23MF12x1,25FOR-TXC
	12	**1,5**	100	22	9	7	3	10,5	K23MF12X1,5FOR-TXC
	14	**1,5**	100	22	11	9	3	12,5	K23MF14X1,5FOR-TXC
	16	**1,5**	100	22	12	9	3	14,5	K23MF16X1,5FOR-TXC
	18	**1,5**	110	25	14	11	3	16,5	K23MF18X1,5FOR-TXC
	20	**1,5**	125	25	16	12	3	18,5	K23MF20X1,5FOR-TXC
	22	**1,5**	125	25	18	14,5	3	20,5	K23MF22X1,5FOR-TXC
	24	**1,5**	140	25	18	14,5	4	22,5	K23MF24X1,5FOR-TXC

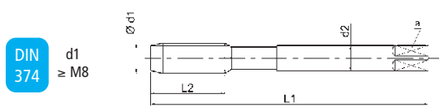
ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min			
P	Acciaio - Steel - Acier - Rm ≤ 1400 N/mm²	•1.3 25-30	•1.4 20-25	•1.5 5-12	○1.6 5-8
K	Ghisa - Cast iron - Fonte	○3.1 25-30	○3.2 20-25	•3.3 20-25	•3.4 25-30
N	Leghe di Allumino Al alloys - Alliage Al – Si >10%	○4.4 25-30			
N	Leghe di magnesio Magnesium alloys - Alliages de magnésium	○4.5 20-30			
N	Ottone a truciolo corto hard brass short chipping - laiton coupeaux courts	○5.3 25-30			
N	Materie plastiche con fibre di rinforzo - Reinforced plastic materials - Matiéres synthétiques renforcés par fibres	○8.3 6-10			

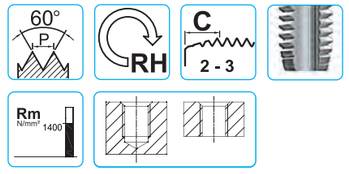
• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

MF

MASCHI A MACCHINA - Scanalature diritte per alta resistenza
MACHINE TAPS - Straight flutes for high resistance
TARAUDS MACHINE - Goujures droites pour haute résistance

DIN13 | HR | ALTA RESISTENZA - HIGH RESISTANCE - HAUTE RÉSISTANCE





Profondità di filettatura - Thread depth - Prof. de filetage	**1,5xD**			
Materiale - Tool Material - Substrat	**PM3**			
Tolleranza - Thread tolerance - Tolérance du filetage	**6HX**			
Trattamento superficiale - Surface treatment - Revêtement	**TXC**			

DIN 374	Ød1 MF	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE
	8	**1**	90	18	6	4,9	4	7	K21MF8X1TXC
	10	**1**	90	15	7	5,5	4	9	K21MF10X1TXC
	10	**1,25**	100	20	7	5,5	4	8,75	K21MF10X1,25TXC
	12	**1,25**	100	22	9	7	4	10,75	K21MF12X1,25TXC
	12	**1,5**	100	22	9	7	4	10,5	K21MF12X1,5TXC
	14	**1,5**	100	22	11	9	4	12,5	K21MF14X1,5TXC
	16	**1,5**	100	22	12	9	4	14,5	K21MF16X1,5TXC

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min			
P	Acciaio - Steel - Acier < 45 HRC	○1.5 5-12	•1.6 5-8		
N	Leghe di Allumino - Al alloys - Alliage Al	○4.3 30-40	•4.4 25-30		
N	Leghe di magnesio Magnesium alloys - Alliages de magnésium	•4.5 20-30			
N	Ottone a truciolo corto Hard brass short chipping - Laiton coupeaux courts	•5.3 25-30			
N	Bronzo ad alta resistenza High strength bronze - Bronze haute résistance	○5.4 5-8			
N	Materie plastiche con fibre di rinforzo - Reinforced plastic materials - Matiéres synthétiques renforcés par fibres	•8.2 10-15	•8.3 6-10		

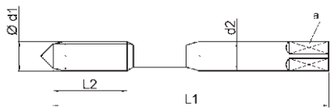
• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

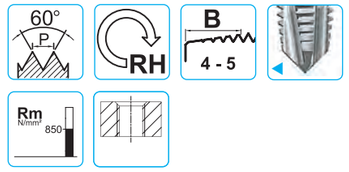
MF

MASCHI A MACCHINA - Imbocco corretto per fori passanti
MACHINE TAPS - Straight flutes with spiral point for through holes
TARAUDS MACHINE - Goujures droites, entrée gun, pour trous débouchant

DIN13 | USO GENERALE - GENERAL PURPOSE - USAGE GÉNÉRAL

DIN 371 d1 ≤ M10





Profondità di filettatura - Thread depth - Prof. de filetage	3xD	3xD	3xD	3xD
Materiale - Tool Material - Substrat	HSSE	HSSE	HSSE	HSSE
Tolleranza - Thread tolerance - Tolérance du filetage	ISO2/6H	ISO2/6H	ISO2/6H	ISO2/6H
Trattamento superficiale - Surface treatment - Revêtement		V	TiN	XP

DIN 371	Ød1 MF	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE			
◀	5	0,5	70	13	6	4,9	3	4,5	E24MF5X0,5	E24MF5X0,5V	E24MF5X0,5T	E24MF5X0,5XP
◀	6	0,75	80	16	6	4,9	3	5,25	E24MF6X0,75	E24MF6X0,75V	E24MF6X0,75T	E24MF6X0,75XP
◀	7	0,75	80	16	7	5,5	3	6,25	E24MF7X0,75	E24MF7X0,75V	E24MF7X0,75T	E24MF7X0,75XP
◀	8	0,75	90	18	8	6,2	3	7,25	E24MF8X0,75	E24MF8X0,75V	E24MF8X0,75T	E24MF8X0,75XP
◀	8	1	90	18	8	6,2	3	7	E24MF8X1	E24MF8X1V	E24MF8X1T	E24MF8X1XP
◀	10	0,75	90	15	10	8	4	9,25	E24MF10X0,75	E24MF10X0,75V	E24MF10X0,75T	E24MF10X0,75XP
◀	10	1	90	15	10	8	4	9	E24MF10X1	E24MF10X1V	E24MF10X1T	E24MF10X1XP
◀	10	1,25	100	20	10	8	3	8,75	E24MF10X1,25	E24MF10X1,25V	E24MF10X1,25T	E24MF10X1,25XP

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min															
P	Acciaio - Steel - Acier - Rm ≤ 850 N/mm²	○1.1 10-15	•1.2 10-15	•1.3 10-12	○1.4 8-10	•1.1 10-15	•1.2 10-15	•1.3 10-12	○1.4 8-10	•1.1 20-30	•1.2 20-30	•1.3 20-25	•1.4 15-20	•1.1 20-30	•1.2 20-30	•1.3 20-25	•1.4 15-20
M	Acciaio inox - Stainless steel - Acier inoxydable													○2.1 10-15	○2.2 8-10		
K	Ghisa - Cast iron - Fonte									○3.3 10-15	•3.4 15-20			○3.3 10-15	•3.4 15-20		
N	Leghe di Allumino - Al alloys - Alliage Al	○4.1 10-15	•4.2 15-20			•4.1 10-15	•4.2 15-20			○4.1 20-25	•4.2 25-30	○4.3 20-25		•4.2 25-30	○4.3 20-25		
N	Leghe di Rame - Copper alloys - Alliages de cuivre	○5.1 8-12	○5.2 10-15			•5.1 8-12	•5.2 10-15			○5.1 15-20	•5.2 20-25			•5.2 20-25			

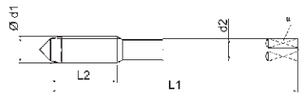
• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

MF

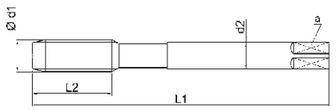
MASCHI A MACCHINA - Imbocco corretto per fori passanti
MACHINE TAPS - Straight flutes with spiral point for through holes
TARAUDS MACHINE - Goujures droites, entrée gun, pour trous débouchant

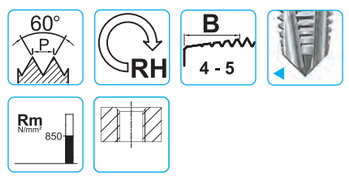
DIN13 | USO GENERALE - GENERAL PURPOSE - USAGE GÉNÉRAL

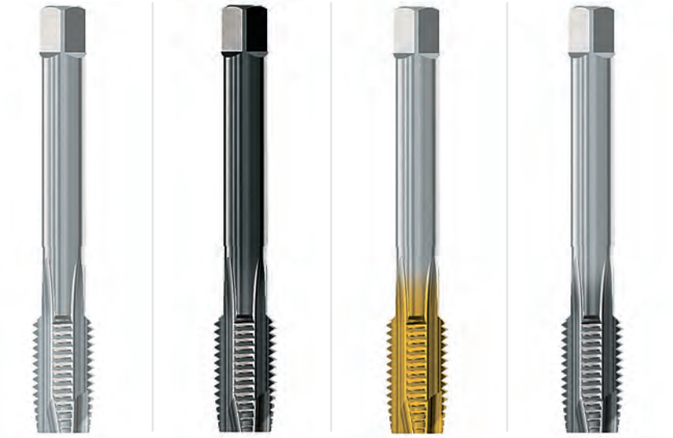
DIN 374 d1 ≤ M10



DIN 374 d1 ≥ M12







Profondità di filettatura - Thread depth - Prof. de filetage	3xD	3xD	3xD	3xD
Materiale - Tool Material - Substrat	HSSE	HSSE	HSSE	HSSE
Tolleranza - Thread tolerance - Tolérance du filetage	ISO2/6H	ISO2/6H	ISO2/6H	ISO2/6H
Trattamento superficiale - Surface treatment - Revêtement		V	TiN	XP

DIN 374	Ød1 MF	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE			
◀	8	1	90	18	6	4,9	3	7	E25MF8X1	E25MF8X1V	E25MF8X1T	E25MF8X1XP
◀	10	1,25	100	20	7	5,5	4	8,75	E25MF10X1,25	E25MF10X1,25V	E25MF10X1,25T	E25MF10X1,25XP
	12	1	100	22	9	7	3	11	E25MF12X1	E25MF12X1V	E25MF12X1T	E25MF12X1XP
	12	1,25	100	22	9	7	3	10,75	E25MF12X1,25	E25MF12X1,25V	E25MF12X1,25T	E25MF12X1,25XP
	12	1,5	100	22	9	7	3	10,5	E25MF12X1,5	E25MF12X1,5V	E25MF12X1,5T	E25MF12X1,5XP
	14	1	100	22	11	9	4	13	E25MF14X1	E25MF14X1V	E25MF14X1T	E25MF14X1XP
	14	1,5	100	22	11	9	4	12,5	E25MF14X1,5	E25MF14X1,5V	E25MF14X1,5T	E25MF14X1,5XP
	16	1	100	22	12	9	4	15	E25MF16X1	E25MF16X1V	E25MF16X1T	E25MF16X1XP
	16	1,5	100	22	12	9	4	14,5	E25MF16X1,5	E25MF16X1,5V	E25MF16X1,5T	E25MF16X1,5XP
	18	1	110	25	14	11	4	17	E25MF18X1	E25MF18X1V	E25MF18X1T	E25MF18X1XP
	18	1,5	110	25	14	11	4	16,5	E25MF18X1,5	E25MF18X1,5V	E25MF18X1,5T	E25MF18X1,5XP
	20	1	125	25	16	12	4	19	E25MF20X1	E25MF20X1V	E25MF20X1T	E25MF20X1XP
	20	1,5	125	25	16	12	4	18,5	E25MF20X1,5	E25MF20X1,5V	E25MF20X1,5T	E25MF20X1,5XP
	22	1	125	25	18	14,5	4	21	E25MF22X1	E25MF22X1V	E25MF22X1T	-
	22	1,5	125	25	18	14,5	4	20,5	E25MF22X1,5	E25MF22X1,5V	E25MF22X1,5T	-
	24	1	140	25	18	14,5	4	23	E25MF24X1	E25MF24X1V	E25MF24X1,5T	-
	24	1,5	140	25	18	14,5	4	22,5	E25MF24X1,5	E25MF24X1,5V	E25MF24X1T	-
	24	2	140	25	18	14,5	4	22	E25MF24X2	E25MF24X2V	E25MF24X2T	-
	25	1,5	140	25	18	14,5	4	23,5	E25MF25X1,5	E25MF25X1,5V	E25MF25X1,5T	-
	25	2	140	25	18	14,5	4	23	E25MF25X2	E25MF25X2V	E25MF25X2T	-
	26	1,5	140	25	18	14,5	4	24,5	E25MF26X1,5	E25MF26X1,5V	E25MF26X1,5T	-
	26	2	140	25	18	14,5	4	24	E25MF26X2	E25MF26X2V	E25MF26X2T	-

Segue diametri / Diameters continue / Diamètres à suivre

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min															
P	Acciaio - Steel - Acier - Rm ≤ 850 N/mm²	○1.1 10-15	•1.2 10-15	•1.3 10-12	○1.4 8-10	•1.1 10-15	•1.2 10-15	•1.3 10-12	○1.4 8-10	•1.1 20-30	•1.2 20-30	•1.3 20-25	•1.4 15-20	•1.1 20-30	•1.2 20-30	•1.3 20-25	•1.4 15-20
M	Acciaio inox - Stainless steel - Acier inoxydable													○2.1 10-15	○2.2 8-10		
K	Ghisa - Cast iron - Fonte									○3.3 10-15	•3.4 15-20			○3.3 10-15	•3.4 15-20		
N	Leghe di Allumino - Al alloys - Alliage Al	○4.1 10-15	•4.2 15-20			•4.1 10-15	•4.2 15-20			○4.1 20-25	•4.2 25-30	○4.3 20-25		•4.2 25-30	○4.3 20-25		
N	Leghe di Rame - Copper alloys - Alliages de cuivre	○5.1 8-12	○5.2 10-15			•5.1 8-12	•5.2 10-15			○5.1 15-20	•5.2 20-25			•5.2 20-25			

• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

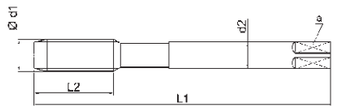
MF

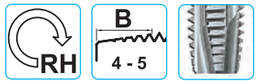
MASCHI A MACCHINA - Imbocco corretto per fori passanti
MACHINE TAPS - Straight flutes with spiral point for through holes
TARAUDS MACHINE - Goujures droites, entrée gun, pour trous débouchant

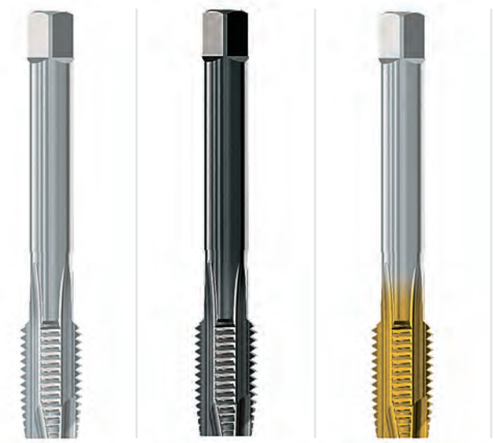
DIN13

USO GENERALE - GENERAL PURPOSE - USAGE GÉNÉRAL

DIN 374







Profondità di filettatura - Thread depth - Prof. de filetage	3xD	3xD	3xD
Materiale - Tool Material - Substrat	HSSE	HSSE	HSSE
Tolleranza - Thread tolerance - Tolérance du filetage	ISO2/6H	ISO2/6H	ISO2/6H
Trattamento superficiale - Surface treatment - Revêtement		V	TiN

DIN 374	Ød1 MF	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE		
	27	1	140	25	20	16	4	26	E25MF27X1	E25MF27X1V	E25MF27X1T
	27	1,5	140	25	20	16	4	25,5	E25MF27X1,5	E25MF27X1,5V	E25MF27X1,5T
	27	2	140	25	20	16	4	25	E25MF27X2	E25MF27X2V	E25MF27X2T
	28	1,5	140	25	20	16	4	26,5	E25MF28X1,5	E25MF28X1,5V	E25MF28X1,5T
	28	2	140	25	20	16	4	26	E25MF28X2	E25MF28X2V	E25MF28X2T
	30	1,5	150	28	22	18	4	28,5	E25MF30X1,5	E25MF30X1,5V	E25MF30X1,5T
	30	2	150	28	22	18	4	28	E25MF30X2	E25MF30X2V	E25MF30X2T
	30	3	180	46	22	18	4	27	E25MF30X3	E25MF30X3V	E25MF30X3T
	32	1,5	150	28	22	18	5	30,5	E25MF32X1,5	E25MF32X1,5V	E25MF32X1,5T
	32	2	150	28	22	18	5	30	E25MF32X2	E25MF32X2V	E25MF32X2T
	33	1,5	160	30	25	20	5	31,5	E25MF33X1,5	E25MF33X1,5V	E25MF33X1,5T
	33	2	160	30	25	20	5	31	E25MF33X2	E25MF33X2V	E25MF33X2T
	34	1,5	170	30	28	22	5	32,5	E25MF34X1,5	E25MF34X1,5V	E25MF34X1,5T
	35	1,5	170	30	28	22	5	33,5	E25MF35X1,5	E25MF35X1,5V	E25MF35X1,5T
	36	1,5	170	30	28	22	5	34,5	E25MF36X1,5	E25MF36X1,5V	E25MF36X1,5T
	36	2	170	30	28	22	5	34	E25MF36X2	E25MF36X2V	E25MF36X2T
	36	3	200	50	28	22	4	33	E25MF36X3	E25MF36X3V	E25MF36X3T
	38	1,5	170	30	28	22	6	36,5	E25MF38X1,5	E25MF38X1,5V	E25MF38X1,5T
	40	1,5	170	30	32	24	6	38,5	E25MF40X1,5	E25MF40X1,5V	E25MF40X1,5T
	40	2	170	30	32	24	6	38	E25MF40X2	E25MF40X2V	E25MF40X2T
	42	1,5	170	30	32	24	6	40,5	E25MF42X1,5	E25MF42X1,5V	E25MF42X1,5T
	42	2	170	30	32	24	6	40	E25MF42X2	E25MF42X2V	E25MF42X2T
	42	3	200	55	32	24	5	39	E25MF42X3	E25MF42X3V	E25MF42X3T

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min											
P	Acciaio - Steel - Acier - Rm ≤ 850 N/mm²	○1.1 10-15	•1.2 10-15	•1.3 10-12	○1.4 8-10	•1.1 10-15	•1.2 10-15	•1.3 10-12	○1.4 8-10	•1.1 20-30	•1.2 20-30	•1.3 20-25	•1.4 15-20
M	Acciaio inox - Stainless steel - Acier inoxydable												
K	Ghisa - Cast iron - Fonte									○3.3 10-15	•3.4 15-20		
N	Leghe di Allumino – Al alloys - Alliage Al	○4.1 10-15	•4.2 15-20			•4.1 10-15	•4.2 15-20			○4.1 20-25	•4.2 25-30	○4.3 20-25	
N	Leghe di Rame - Copper alloys - Alliages de cuivre	○5.1 8-12	○5.2 10-15			•5.1 8-12	•5.2 10-15			○5.1 15-20	•5.2 20-25		

• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

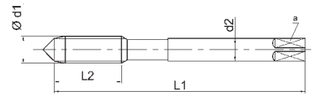
MF

MASCHI A MACCHINA - Imbocco corretto per fori passanti filettatura sinistra
MACHINE TAPS - Straight flutes with spiral point for through holes left thread
TARAUDS MACHINE - Goujures droites, entrée gun, pour trous débouchant filetage à gauche

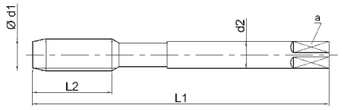
DIN13

USO GENERALE - GENERAL PURPOSE - USAGE GÉNÉRAL

DIN 374 d1 ≤ M10



DIN 374 d1 ≥ M12



Profondità di filettatura - Thread depth - Prof. de filetage	3xD	3xD	
Materiale - Tool Material - Substrat	HSSE	HSSE	
Tolleranza - Thread tolerance - Tolérance du filetage	ISO2/6H	ISO2/6H	
Trattamento superficiale - Surface treatment - Revêtement		TiN	TXC

DIN 374	Ød1 MF	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE	
◄	8	1	90	18	6	4,9	3	7	E25MF8X1LH	E25MF8X1LH-T
◄	10	1	90	15	7	5,5	4	9	E25MF10X1LH	E25MF10X1LH-T
◄	10	1,25	100	20	7	5,5	3	8,75	E25MF10X1,25LH	E25MF10X1,25LH-T
	12	1,25	100	22	9	7	3	10,75	E25MF12X1,25LH	E25MF12X1,25LH-T
	12	1,5	100	22	9	7	3	10,5	E25MF12X1,5LH	E25MF12X1,5LH-T
	14	1,5	100	22	11	9	4	12,5	E25MF14X1,5LH	E25MF14X1,5LH-T
	16	1,5	100	22	12	9	4	14,5	E25MF16X1,5LH	E25MF16X1,5LH-T

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min											
P	Acciaio - Steel - Acier - Rm ≤ 850 N/mm²	○1.1 10-15	•1.2 10-15	•1.3 10-12	○1.4 8-10	•1.1 20-30	•1.2 20-30	•1.3 20-25	•1.4 15-20				
M	Acciaio inox - Stainless steel - Acier inoxydable												
K	Ghisa - Cast iron - Fonte					○3.3 10-15	•3.4 15-20						
N	Leghe di Allumino – Al alloys - Alliage Al	○4.1 10-15	•4.2 15-20			○4.1 20-25	•4.2 25-30	○4.3 20-25					
N	Leghe di Rame - Copper alloys - Alliages de cuivre	○5.1 8-12	○5.2 10-15			○5.1 15-20	•5.2 20-25						

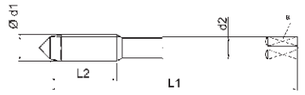
• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

MF

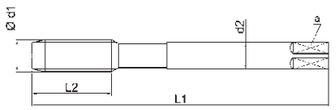
MASCHI A MACCHINA - Imbocco corretto per fori passanti toll. 4H, 6G, 7G e 6H+0,1
MACHINE TAPS - Straight flutes with spiral point for through holes tol. 4H, 6G, 7G and 6H+0,1
TARAUDS MACHINE - Goujures droites, entrée gun, pour trous débouchant tol. 4H, 6G, 7G et 6H+0,1

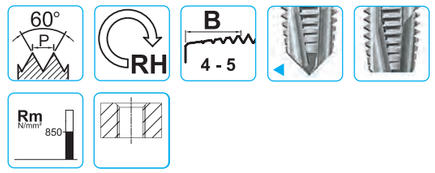
DIN13 | USO GENERALE - GENERAL PURPOSE - USAGE GÉNÉRAL

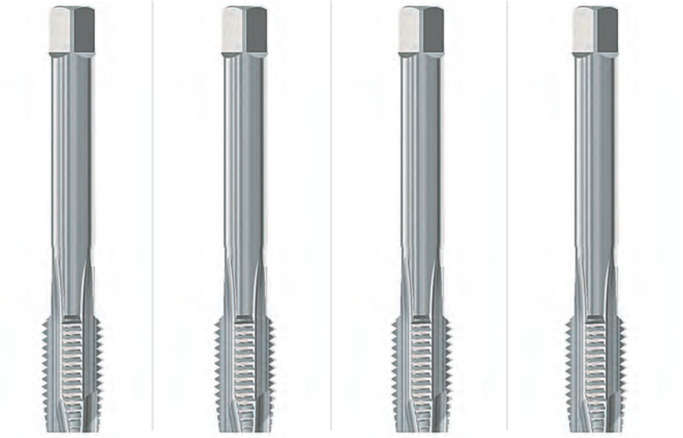
DIN 374 d1 ≤ M10



DIN 374 d1 ≥ M12







Profondità di filettatura - Thread depth - Prof. de filetage	3xD	3xD	3xD	3xD
Materiale - Tool Material - Substrat	HSSE	HSSE	HSSE	HSSE
Tolleranza - Thread tolerance - Tolérance du filetage	ISO1/4H	ISO3/6G	7G	6H+0,1
Trattamento superficiale - Surface treatment - Revêtement				

DIN 374	Ød1 MF	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE			
◀	8	1	90	18	6	4,9	3	7	E25MF8X1-4H	E25MF8X1-6G	E25MF8X1-7G	E25MF8X1+0,1
◀	10	1	90	15	7	5,5	4	9	E25MF10X1-4H	E25MF10X1-6G	E25MF10X1-7G	E25MF10X1+0,1
◀	10	1,25	100	20	7	5,5	3	8,75	E25MF10X1,25-4H	E25MF10X1,25-6G	E25MF10X1,25-7G	E25MF10X1,25+0,1
	12	1,25	100	22	9	7	3	10,75	E25MF12X1,25-4H	E25MF12X1,25-6G	E25MF12X1,25-7G	E25MF12X1,25+0,1
	12	1,5	100	22	9	7	3	10,5	E25MF12X1,5-4H	E25MF12X1,5-6G	E25MF12X1,5-7G	E25MF12X1,5+0,1
	14	1,5	100	22	11	9	4	12,5	E25MF14X1,5-4H	E25MF14X1,5-6G	E25MF14X1,5-7G	E25MF14X1,5+0,1
	16	1,5	100	22	12	9	4	14,5	E25MF16X1,5-4H	E25MF16X1,5-6G	E25MF16X1,5-7G	E25MF16X1,5+0,1

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min				
P	Acciaio - Steel - Acier - Rm ≤ 850 N/mm²	◑1.1 10-15	•1.2 10-15	•1.3 10-12	◑1.4 8-10	
M	Acciaio inox - Stainless steel - Acier inoxydable					
K	Ghisa - Cast iron - Fonte					
N	Leghe di Allumino - Al alloys - Alliage Al	◑4.1 10-15	•4.2 15-20			
N	Leghe di Rame - Copper alloys - Alliages de cuivre	◑5.1 8-12	◑5.2 10-15			

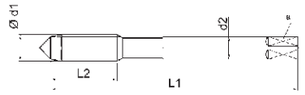
• Raccomandato - Optimal - Recommandé ◑ Adatto - Suitable - Adaptè

MF

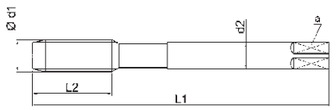
MASCHI A MACCHINA - Imbocco corretto per fori passanti
MACHINE TAPS - Straight flutes with spiral point for through holes
TARAUDS MACHINE - Goujures droites, entrée gun, pour trous débouchant

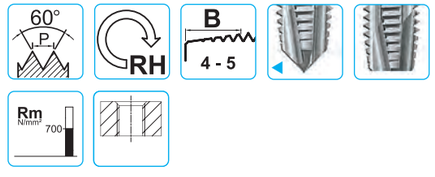
DIN13 | AL-CU-FE | ALLUMINIO, RAME, FERRO - ALUMINIUM, COPPER, IRON - ALUMINIUM, CUIVRE, FER

DIN 374 d1 ≤ M10



DIN 374 d1 ≥ M12





Profondità di filettatura - Thread depth - Prof. de filetage	3xD			
Materiale - Tool Material - Substrat	HSSE			
Tolleranza - Thread tolerance - Tolérance du filetage	ISO2/6H			
Trattamento superficiale - Surface treatment - Revêtement				

DIN 374	Ød1 MF	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE
◀	6	0,75	80	16	4,5	3,4	2	5,25	E25MF6X0,75AL
◀	8	1	90	18	6	4,9	2	7	E25MF8X1AL
◀	10	1	90	15	7	5,5	2	9	E25MF10X1AL
◀	10	1,25	100	20	7	5,5	2	8,75	E25MF10X1,25AL
	12	1,25	100	22	9	7	3	10,75	E25MF12X1,25AL
	12	1,5	100	22	9	7	3	10,5	E25MF12X1,5AL
	14	1,5	100	22	11	9	3	12,5	E25MF14X1,5AL
	16	1,5	100	22	12	9	3	14,5	E25MF16X1,5AL

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min			
P	Acciaio dolce magnetico - Magnetic soft steel - Acier doux magnétique - Rm <400 N/mm²	◑1.1 10-15			
N	Leghe di Allumino - Al alloys - Alliage Al	•4.1 10-15	•4.2 15-20		
N	Leghe di Rame - Copper alloys - Alliages de cuivre	•5.1 8-12	•5.2 10-15		
S	Titanio puro - Pure titanium - Titane pur	•6.1 5-8			
S	Nichel puro - Pure nickel - Nickel pure	•7.1 6-8			
N	Materiali termoplastici – Thermoplastics - Thermoplastiques Truciolo lungo - Long chipping - Copeaux longue	•8.1 20-25			

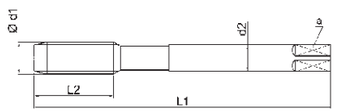
• Raccomandato - Optimal - Recommandé ◑ Adatto - Suitable - Adaptè

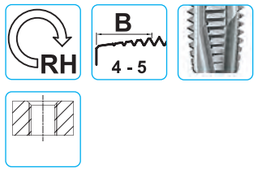
MF

MASCHI A MACCHINA - Imbocco corretto per fori passanti
MACHINE TAPS - Straight flutes with spiral point for through holes
TARAUDS MACHINE - Goujures droites, entrée gun, pour trous débouchant

DIN13 | U | APPLICAZIONI UNIVERSALI - UNIVERSAL APPLICATIONS - USINAGE UNIVERSELS

DIN 374





s-plus
NEW

Profondità di filettatura - Thread depth - Prof. de filetage	3xD	3,5xD		3xD
Materiale - Tool Material - Substrat	PM3	PM3		HSSP
Tolleranza - Thread tolerance - Tolérance du filetage	6HX	6HX		ISO2/6H
Trattamento superficiale - Surface treatment - Revêtement	XP	XP		TiN-G

DIN 374	Ød1 MF	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE			
8	**1**	90	18	6	4,9	3	7		K25MF8X1XP	K25MF8X1FORY-XP		P25MF8X1TG
10	**1**	90	15	7	5,5	4	9		K25MF10X1XP	K25MF10X1FORY-XP		P25MF10X1TG
10	**1,25**	100	20	7	5,5	3	8,75		K25MF10X1,25XP	K25MF10X1,25FORY-XP		P25MF10X1,25TG
12	**1**	100	22	9	7	4	11		-	-		P25MF12X1TG
12	**1,25**	100	22	9	7	4	10,75		-	-		P25MF12X1,25TG
12	**1,5**	100	22	9	7	4	10,5		K25MF12X1,5XP	K25MF12X1,5FORY-XP		P25MF12x1,5TG
14	**1,5**	100	22	11	9	4	12,5		K25MF14X1,5XP	K25MF14X1,5FORY-XP		P25MF14X1,5TG
16	**1,5**	100	22	12	9	4	14,5		K25MF16X1,5XP	K25MF16X1,5FORY-XP		P25MF16X1,5TG
18	**1,5**	110	25	14	11	4	16,5		K25MF18X1,5XP	K25MF18X1,5FORY-XP		P25MF18X1,5TG
20	**1,5**	125	25	16	12	4	18,5		K25MF20X1,5XP	K25MF20X1,5FORY-XP		P25MF20X1,5TG
22	**1,5**	125	25	18	14,5	4	20,5		K25MF22X1,5XP	K25MF22X1,5FORY-XP		P25MF22X1,5TG
24	**1,5**	140	25	18	14,5	4	22,5		K25MF24X1,5XP	K25MF24X1,5FORY-XP		P25MF24X1,5TG

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min										
P	Acciaio - Steel - Acier - Rm ≤ 1200 N/mm²	○1.1 20-30	•1.2 20-30	•1.3 20-25	•1.4 15-20	•1.5 5-12			•1.2 20-30	•1.3 20-25	•1.4 15-20	○1.5 5-12
M	Acciaio INOX - Stainless steel - Acier inoxydable	•2.1 10-15	•2.2 8-10	•2.3 6-8								
K	Ghisa - Cast iron - Fonte	•3.3 10-15	•3.4 15-20						•3.3 10-15	•3.4 15-20		
N	Leghe di Allumino - Al alloys - Alliage Al	•4.2 25-30	•4.3 20-25						•4.3 20-25			
N	Leghe di Rame - Copper alloys - Alliages de cuivre Truciolo lungo - Long chipping - Copeaux longs	•5.2 20-25							•5.2 20-25			

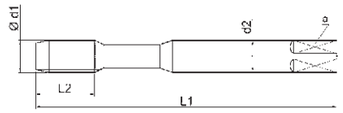
• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

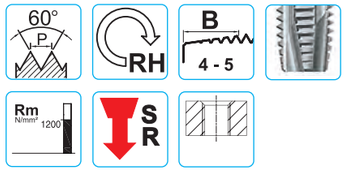
MF

MASCHI A MACCHINA - Imbocco corretto per fori passanti
MACHINE TAPS - Straight flutes with spiral point for through holes
TARAUDS MACHINE - Goujures droites, entrée gun, pour trous débouchant

DIN13 | SYNCHRO RIGID | MASCHIATURA RIGIDA SINCRONIZZATA - RIGID TAPPING SYNCHRO - TARAUDAGE RIGIDE SYNCHRONISÉ

UFS Norm





Profondità di filettatura - Thread depth - Prof. de filetage	3xD			
Materiale - Tool Material - Substrat	PM3			
Tolleranza - Thread tolerance - Tolérance du filetage	6HX			
Trattamento superficiale - Surface treatment - Revêtement	TXC			

UFS Norm	Ød1 MF	P mm	L_1	L_2	d_2 h6	a h12	Z		CODE
8	**1**	90	13	8	6,2	3	7		S24MF8X1TXC
10	**1**	100	15	10	8	3	9		S24MF10X1TXC
10	**1,25**	100	15	10	8	3	8,75		S24MF10X1,25TXC
12	**1,25**	110	18	12	9	3	10,75		S24MF12X1,25TXC
12	**1,5**	110	18	12	9	3	10,5		S24MF12X1,5TXC
14	**1,5**	110	20	12	9	3	12,5		S24MF14X1,5TXC
16	**1,5**	110	20	16	12	4	14,5		S24MF16X1,5TXC

Dimensioni a norma di fabbrica
Dimensions according to standard factory
Dimensions selon la norme d'usine

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min										
P	Acciaio - Steel - Acier - Rm<1200 N/mm²	•1.1 40-45	•1.2 40-45	•1.3 35-40	•1.4 25-30	•1.5 10-15						
M	Acciaio INOX – Stainless steel - Acier inoxydable	•2.1 20-25	•2.2 15-20	•2.3 10-15	•2.3 10-12							
K	Ghisa - Cast iron - Fonte	•3.3 20-25	•3.4 25-30									
N	Leghe di Allumino – Al alloys - Alliage Al Si < 10%	•4.1 30-40	•4.2 45-50	•4.3 30-40								
N	Leghe di Rame - Copper alloys - Alliages de cuivre Truciolo lungo - Long chipping - Copeaux longs	•5.1 20-25	•5.2 25-30									
S	Leghe di titanio - Titanium alloys Alliage de titane Rm<900 N/mm²	•6.1 20-30	○6.2 12-15									
S	Leghe di Nichel - Nickel alloys Alliages de nickel Rm<900 N/mm²	•7.1 20-30	○7.2 8-12									

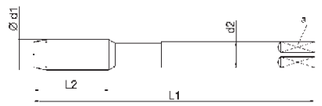
• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

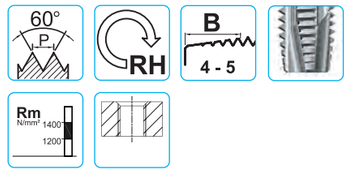
MF

MASCHI A MACCHINA - Imbocco corretto per fori passanti
MACHINE TAPS - Straight flutes with spiral point for through holes
TARAUDS MACHINE - Goujures droites, entrée gun, pour trous débouchant

DIN13 | HR | ALTA RESISTENZA - HIGH RESISTANCE - HAUTE RÉSISTANCE

DIN 374





Profondità di filettatura - Thread depth - Prof. de filetage	3xD
Materiale - Tool Material - Substrat	PM3
Tolleranza - Thread tolerance - Tolérance du filetage	6HX
Trattamento superficiale - Surface treatment - Revêtement	TXC

DIN 374	Ød1 MF	P mm	L_1	L_2	d_2 h9	a h12	Z	CODE
	8	**1**	90	18	6	4,9	3	7	K25MF8X1TXC
	10	**1**	90	15	7	5,5	3	9	K25MF10X1TXC
	10	**1,25**	100	20	7	5,5	3	8,75	K25MF10X1,25TXC
	12	**1,25**	100	22	9	7	4	10,75	K25MF12X1,25TXC
	12	**1,5**	100	22	9	7	4	10,5	K25MF12X1,5TXC
	14	**1,5**	100	22	11	9	4	12,5	K25MF14X1,5TXC
	16	**1,5**	100	22	12	9	4	14,5	K25MF16X1,5TXC

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min
P	Acciaio - Steel - Acier - Rm < 1400 N/mm²	•1.5 5-12 · •1.6 5-8
K	Ghisa - Cast iron - Fonte	•3.3 15-20 · •3.4 20-25
N	Leghe di Allumino - Al alloys - Alliage Al Si > 10%	◦4.4 25-30
N	Ottone a truciolo corto - Hard brass short chipping Laiton coupeaux courts	•5.3 25-30

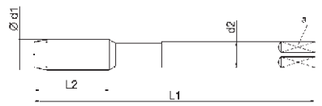
• Raccomandato - Optimal - Recommandé ◦ Adatto - Suitable - Adaptè

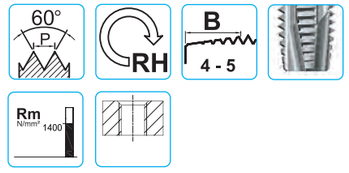
MF

MASCHI A MACCHINA - Imbocco corretto per fori passanti
MACHINE TAPS - Straight flutes with spiral point for through holes
TARAUDS MACHINE - Goujures droites, entrée gun, pour trous débouchant

DIN13 | INOX | ACCIAIO INOSSIDABILE - STAINLESS STEEL - ACIER INOXYDABLE

DIN 374





Profondità di filettatura - Thread depth - Prof. de filetage	3xD	3xD	3xD
Materiale - Tool Material - Substrat	HSSV3	HSSV3	PM3
Tolleranza - Thread tolerance - Tolérance du filetage	6HX	6HX	6HX
Trattamento superficiale - Surface treatment - Revêtement	VS	TXC	TXC

DIN 374	Ød1 MF	P mm	L_1	L_2	d_2 h9	a h12	Z	CODE		
	8	**1**	90	18	6	4,9	3	7	V25MF8X1VS	V25MF8X1TXC	K25MF8X1X-TXC
	10	**1**	90	15	7	5,5	3	9	V25MF10X1VS	V25MF10X1TXC	K25MF10X1X-TXC
	10	**1,25**	100	20	7	5,5	3	8,75	V25MF10X1,25VS	V25MF10X1,25TXC	K25MF10X1,25X-TXC
	12	**1,25**	100	22	9	7	4	10,75	V25MF12X1,25VS	V25MF12X1,25TXC	K25MF12X1,25X-TXC
	12	**1,5**	100	22	9	7	4	10,5	V25MF12X1,5VS	V25MF12X1,5TXC	K25MF12X1,5X-TXC
	14	**1,5**	100	22	11	9	4	12,5	V25MF14X1,5VS	V25MF14X1,5TXC	K25MF14X1,5X-TXC
	16	**1,5**	100	22	12	9	4	14,5	V25MF16X1,5VS	V25MF16X1,5TXC	K25MF16X1,5X-TXC

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min
P	Acciaio - Steel - Acier - Rm < 1400 N/mm²	•1.1 10-15 · •1.2 10-15 · •1.3 20-25 · •1.4 15-20 · ◦1.5 5-12 · •1.3 20-25 · •1.4 15-20 · •1.5 5-12 · ◦1.6 5-8
M	Acciaio INOX – Stainless steel - Acier inoxydable	•2.1 6-8 · •2.2 5-7 · •2.3 3-5 · •2.1 10-15 · •2.2 8-10 · •2.3 6-8 · ◦2.4 3-6 · •2.1 10-15 · •2.2 8-10 · •2.3 6-8 · •2.4 3-6

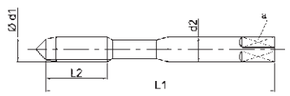
• Raccomandato - Optimal - Recommandé ◦ Adatto - Suitable - Adaptè

MF

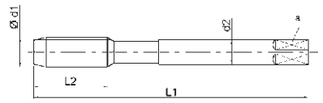
MASCHI A MACCHINA - Elica 15° sinistra per fori passanti
MACHINE TAPS - Left-hand spiral flutes 15° for through holes
TARAUDS MACHINE - Goujures 15° hélicoïdales à gauche pour trous débouchant

DIN13 | Ti | TITANIO - TITANIUM - TITANE

DIN 371 d1 ≤ M10



DIN 374 d1 ≥ M12



60° P RH D 4 - 5

Rm N/mm² 1400 AVIO

Profondità di filettatura - Thread depth - Prof. de filetage	3xD	3xD
Materiale - Tool Material - Substrat	PM3	PM3
Tolleranza - Thread tolerance - Tolérance du filetage	6HX	4H
Trattamento superficiale - Surface treatment - Revêtement	TiCN	TiCN

DIN 371	Ød1 MF	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE	
◀	8	1	90	18	8	6,2	3	*7	K52MF8X1CT	K52MJF8X1CT
◀	10	1	90	15	10	8	3	*9	K52MF10X1CT	K52MJF10X1CT
◀	10	1,25	100	20	10	8	3	*8,75	K52MF10X1,25CT	K52MJF10X1,25CT

DIN 374	Ød1 MF	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE
	12	1,25	100	22	9	7	3	*10,75	K53MF12X1,25CT
	12	1,5	100	22	9	7	3	*10,5	K53MF12X1,5CT

* Diametri di preforo MJ a pag: 269 - Bore hole for thread MJ to page: 269 - Pour MJ voir le tableau de perçage page: 269

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min	
P	Acciaio - Steel - Acier - Rm ≤ 1200-1400 N/mm²	•1.6 5-8	
M	Inox - Stainless steel - Acier inoxydable Cr–Ni, Rm < 1400 N/mm²	•2.4 3-6	
K	Ghisa - Cast iron - Fonte	•3.3 15-20	•3.4 20-25
N	Leghe di Allumino - Al alloys - Alliage Al Si > 10%	◦4.4 25-30	
N	Leghe di Rame - Copper alloys - Alliages de cuivre Ottone, Bronzo - Hard brass, bronze - Laiton, bronze	•5.3 25-30	◦5.4 5-8
S	Leghe di titanio - Titanium alloys Alliage de titane Rm<1400 N/mm²	•6.2 4-8	•6.3 2-4
S	Leghe di Nichel - Nickel alloys Alliages de nickel Rm<900 N/mm²	•7.2 2-4	

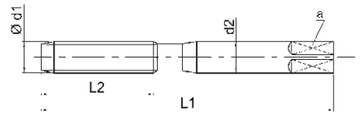
• Raccomandato - Optimal - Recommandé ◦ Adatto - Suitable - Adaptè

MF

MASCHI A MACCHINA - Elica 10° sinistra per fori passanti
MACHINE TAPS - Left-hand spiral flutes 10° for through holes
TARAUDS MACHINE - Goujures 10° hélicoïdales à gauche pour trous débouchant

DIN13 | Ni | NICHEL - NICKEL

UFS Norm



60° P RH D 4 - 5

Rm N/mm² 1600 AVIO

Profondità di filettatura - Thread depth - Prof. de filetage	3xD	3xD
Materiale - Tool Material - Substrat	PM3	PM3
Tolleranza - Thread tolerance - Tolérance du filetage	6HX	4H
Trattamento superficiale - Surface treatment - Revêtement	TiCN	TiCN

UFS Norm	Ød1 MF	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE	
	8	1	90	25	8	6,2	3	*7	K52MF8X1NI-CT	K52MJF8X1NI-CT
	10	1	100	30	10	8	3	*9	K52MF10X1,25NI-CT	K52MJF10X1NI-CT
	10	1,25	100	30	10	8	3	*8,75	K52MF10X1NI-CT	K52MJF10X1,25NI-CT
	12	1,25	110	25	12	9	3	*10,75	K52MF12X1,25NI-CT	-
	12	1,5	110	25	12	9	3	*10,5	K52MF12X1,5NI-CT	-

Dimensioni a norma di fabbrica
Dimensions according to standard factory
Dimensions selon la norme d'usine

* Diametri di preforo MJ a pag: 269 - Bore hole for thread MJ to page: 269 - Pour MJ voir le tableau de perçage page: 269

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min	
P	Acciaio – Steel – Acier - Rm ≤ 1600 N/mm²	◦1.6 5-8	•1.7 1-3
N	Bronzo ad alta resistenza - High strength bronze - Bronze haute résistance Rm<1500 N/mm²	•5.4 5-8	
S	Leghe di Nichel - Nickel alloys - Alliages de nickel Rm<1600 N/mm²	◦7.2 2-4	•7.3 1-3

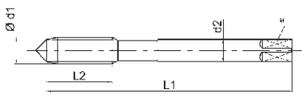
• Raccomandato - Optimal - Recommandé ◦ Adatto - Suitable - Adaptè

MF

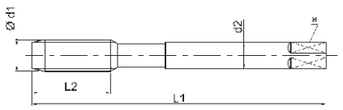
MASCHI A MACCHINA - Elica destra a 15° per fori ciechi
MACHINE TAPS - Spiral flutes 15° for blind holes
TARAUDS MACHINE - Goujures hélicoïdales 15° pour trous borgnes

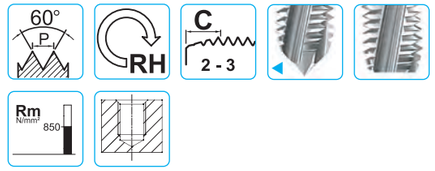
DIN13 | USO GENERALE - GENERAL PURPOSE - USAGE GÉNÉRAL

DIN 374 d1 = M6



DIN 374 d1 ≥ M8





Profondità di filettatura - Thread depth - Prof. de filetage	1,5xD	1,5xD	1,5xD	2,5xD
Materiale - Tool Material - Substrat	HSSE	HSSE	HSSE	HSSE
Tolleranza - Thread tolerance - Tolérance du filetage	ISO2/6H	ISO2/6H	ISO2/6H	ISO2/6H
Trattamento superficiale - Surface treatment - Revêtement		V	TiN	TiN

DIN 374	Ød1 MF	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE			
◄	6	0,75	80	16	4,5	3,4	3	5,25	E41MF6X0,75	E41MF6X0,75V	E41MF6X0,75T	-
	8	0,75	90	18	6	4,9	3	7,25	E41MF8X0,75SP	E41MF8X0,75SP-V	E41MF8X0,75SP-T	-
	8	1	90	18	6	4,9	3	7	E41MF8X1SP	E41MF8X1SP-V	E41MF8X1SP-T	E41MF8X1FOR-T
	10	0,75	90	15	7	5,5	3	9,15	E41MF10X0,75SP	E41MF10X0,75SP-V	E41MF10X0,75SP-T	-
	10	1	90	15	7	5,5	3	9	E41MF10X1SP	E41MF10X1SP-V	E41MF10X1SP-T	E41MF10X1FOR-T
	10	1,25	100	20	7	5,5	3	8,75	E41MF10X1,25SP	E41MF10X1,25SP-V	E41MF10X1,25SP-T	E41MF10X1,25FOR-T
	11	1,25	100	20	8	6,2	3	9,75	E41MF11X1,25	E41MF11X1,25V	E41MF11X1,25T	-
	12	1	100	22	9	7	3	11	E41MF12X1	E41MF12X1V	E41MF12X1T	-
	12	1,25	100	22	9	7	3	10,75	E41MF12X1,25	E41MF12X1,25V	E41MF12X1,25T	E41MF12X1,25FOR-T
	12	1,5	100	22	9	7	3	10,5	E41MF12X1,5	E41MF12X1,5V	E41MF12X1,5T	E41MF12X1,5FOR-T
	14	1	100	22	11	9	3	13	E41MF14X1	E41MF14X1V	E41MF14X1T	-
	14	1,25	100	22	11	9	3	12,75	E41MF14X1,25	E41MF14X1,25V	E41MF14X1,25T	-
	14	1,5	100	22	11	9	3	12,5	E41MF14X1,5	E41MF14X1,5V	E41MF14X1,5T	E41MF14X1,5FOR-T
	16	1	100	22	12	9	3	15	E41MF16X1	E41MF16X1V	E41MF16X1T	-
	16	1,25	100	22	12	9	3	14,75	E41MF16X1,25	E41MF16X1,25V	E41MF16X1,25T	-
	16	1,5	100	22	12	9	3	14,5	E41MF16X1,5	E41MF16X1,5V	E41MF16X1,5T	E41MF16X1,5FOR-T
	18	1	110	25	14	11	4	17	E41MF18X1	E41MF18X1V	E41MF18X1T	-
	18	1,5	110	25	14	11	4	16,5	E41MF18X1,5	E41MF18X1,5V	E41MF18X1,5T	E41MF18X1,5FOR-T
	20	1	125	25	16	12	4	19	E41MF20X1	E41MF20X1V	E41MF20X1T	-
	20	1,5	125	25	16	12	4	18,5	E41MF20X1,5	E41MF20X1,5V	E41MF20X1,5T	E41MF20X1,5FOR-T

Segue diametri / Diameters continue / Diamètres à suivre

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min														
P	Acciaio - Steel - Acier - Rm ≤ 850 N/mm²	○1.1 10-15	•1.2 10-15	•1.3 10-12	○1.4 8-10	•1.1 10-15	•1.2 10-15	•1.3 10-12	○1.4 8-10	•1.1 20-30	•1.2 20-30	•1.3 20-25	•1.4 15-20	•1.1 20-30	•1.2 20-30	•1.3 20-25	•1.4 15-20
M	Acciaio inox - Stainless steel - Acier inoxydable																
K	Ghisa - Cast iron - Fonte									○3.3 10-15	•3.4 15-20			○3.3 10-15	•3.4 15-20		
N	Leghe di Allumino - Al alloys - Alliage Al	○4.1 10-15	•4.2 15-20			•4.1 10-15	•4.2 15-20			○4.1 20-25	•4.2 25-30	○4.3 20-25		○4.1 20-25	•4.2 25-30	○4.3 20-25	
N	Leghe di Rame - Copper alloys - Alliages de cuivre	○5.1 8-12	○5.2 10-15			•5.1 8-12	•5.2 10-15			○5.1 15-20	•5.2 20-25			○5.1 15-20	•5.2 20-25		

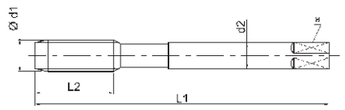
• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

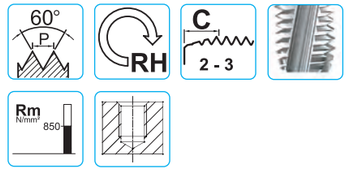
MF

MASCHI A MACCHINA - Elica destra a 15° per fori ciechi
MACHINE TAPS - Spiral flutes 15° for blind holes
TARAUDS MACHINE - Goujures hélicoïdales 15° pour trous borgnes

DIN13 | USO GENERALE - GENERAL PURPOSE - USAGE GÉNÉRAL

DIN 374





Profondità di filettatura - Thread depth - Prof. de filetage	1,5xD	1,5xD	1,5xD	2,5xD
Materiale - Tool Material - Substrat	HSSE	HSSE	HSSE	HSSE
Tolleranza - Thread tolerance - Tolérance du filetage	ISO2/6H	ISO2/6H	ISO2/6H	ISO2/6H
Trattamento superficiale - Surface treatment - Revêtement		V	TiN	TiN

DIN 374	Ød1 MF	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE			
	22	1,5	125	25	18	14,5	4	20,5	E41MF22X1,5	E41MF22X1,5V	E41MF22X1,5T	E41MF22X1,5FOR-T
	24	1	140	25	18	14,5	4	23	E41MF24X1	E41MF24X1V	E41MF24X1T	-
	24	1,5	140	25	18	14,5	4	22,5	E41MF24X1,5	E41MF24X1,5V	E41MF24X1,5T	E41MF24X1,5FOR-T
	24	2	140	25	18	14,5	4	22	E41MF24X2	E41MF24X2V	E41MF24X2T	-
	25	1	140	25	18	14,5	4	24	E41MF25X1	E41MF25X1V	E41MF25X1T	-
	25	1,5	140	25	18	14,5	4	23,5	E41MF25X1,5	E41MF25X1,5V	E41MF25X1,5T	-
	26	1	140	25	18	14,5	4	25	E41MF26X1	E41MF26X1V	E41MF26X1T	-
	26	1,5	140	25	18	14,5	4	24,5	E41MF26X1,5	E41MF26X1,5V	E41MF26X1,5T	E41MF26X1,5FOR-T
	27	2	140	25	20	16	4	25	E41MF27X2	E41MF27X2V	E41MF27X2T	-
	28	1,5	140	25	20	16	4	26,5	E41MF28X1,5	E41MF28X1,5V	E41MF28X1,5T	E41MF28X1,5FOR-T
	30	1	150	28	22	18	4	29	E41MF30X1	E41MF30X1V	E41MF30X1T	-
	30	1,5	150	28	22	18	4	28,5	E41MF30X1,5	E41MF30X1,5V	E41MF30X1,5T	-
	30	2	150	28	22	18	4	28	E41MF30X2	E41MF30X2V	E41MF30X2T	-
	36	2	170	30	28	22	5	34	E41MF36X2	-	-	-
	42	2	170	30	32	24	6	40	E41MF42X2	-	-	-
■	45	1,5	180	32	36	29	6	43,5	E41MF45X1,5	-	-	-
■	48	1,5	190	32	36	29	6	46,5	E41MF48X1,5	-	-	-
■	48	2	190	32	36	29	6	46	E41MF48X2	-	-	-
■	48	3	220	65	36	29	6	45	E41MF48X3	-	-	-
■	56	4	220	65	40	32	6	52	E41MF56X4	-	-	-

■ = HSS

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min														
P	Acciaio - Steel - Acier - Rm ≤ 850 N/mm²	○1.1 10-15	•1.2 10-15	•1.3 10-12	○1.4 8-10	•1.1 10-15	•1.2 10-15	•1.3 10-12	○1.4 8-10	•1.1 20-30	•1.2 20-30	•1.3 20-25	•1.4 15-20	•1.1 20-30	•1.2 20-30	•1.3 20-25	•1.4 15-20
M	Acciaio inox - Stainless steel - Acier inoxydable																
K	Ghisa - Cast iron - Fonte									○3.3 10-15	•3.4 15-20			○3.3 10-15	•3.4 15-20		
N	Leghe di Allumino - Al alloys - Alliage Al	○4.1 10-15	•4.2 15-20			•4.1 10-15	•4.2 15-20			○4.1 20-25	•4.2 25-30	○4.3 20-25		○4.1 20-25	•4.2 25-30	○4.3 20-25	
N	Leghe di Rame - Copper alloys - Alliages de cuivre	○5.1 8-12	○5.2 10-15			•5.1 8-12	•5.2 10-15			○5.1 15-20	•5.2 20-25			○5.1 15-20	•5.2 20-25		

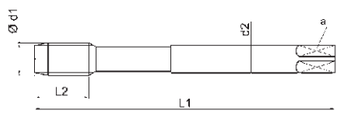
• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

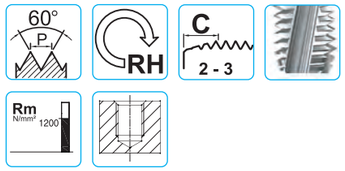
MF

MASCHI A MACCHINA - Elica destra a 15° per fori ciechi
MACHINE TAPS - Spiral flutes 15° for blind holes
TARAUDS MACHINE - Goujures hélicoïdales 15° pour trous borgnes

DIN13 | U | APPLICAZIONI UNIVERSALI - UNIVERSAL APPLICATIONS - USINAGE UNIVERSELS

DIN 374





Profondità di filettatura - Thread depth - Prof. de filetage	1,5xD	2,5xD	3xD
Materiale - Tool Material - Substrat	HSSE-PM	HSSE-PM	HSSE-PM
Tolleranza - Thread tolerance - Tolérance du filetage	6HX	6HX	6HX
Trattamento superficiale - Surface treatment - Revêtement	XP	XP	XP

DIN 374	Ød1 MF	P mm	L_1	L_2	d_2 h9	a h12	Z	
	8	**1**	90	13	6	4,9	3	7
	10	**1**	90	15	7	5,5	3	9
	10	**1,25**	100	15	7	5,5	3	8,75
	12	**1,25**	100	13	9	7	3	10,75
	12	**1,5**	100	13	9	7	3	10,5
	14	**1,5**	100	15	11	9	4	12,5
	16	**1,5**	100	15	12	9	4	14,5
	18	**1,5**	110	17	14	11	4	16,5
	20	**1,5**	125	17	16	12	4	18,5
	22	**1,5**	125	18	18	14,5	4	20,5
	24	**1,5**	140	20	18	14,5	4	22,5
	26	**1,5**	140	20	18	14,5	4	24,5
	28	**1,5**	140	20	20	16	4	26,5

CODE		
K41MF8X1XP	K41MF8X1FOR-XP	K45MF8X1FOR-XP
K41MF10X1XP	K41MF10X1FOR-XP	K45MF10X1FOR-XP
K41MF10X1,25XP	K41MF10X1,25FOR-XP	K45MF10X1,25FOR-XP
K41MF12X1,25XP	K41MF12X1,25FOR-XP	K45MF12X1,25FOR-XP
K41MF12X1,5XP	K41MF12X1,5FOR-XP	K45MF12X1,5FOR-XP
K41MF14X1,5XP	K41MF14X1,5FOR-XP	K45MF14X1,5FOR-XP
K41MF16X1,5XP	K41MF16X1,5FOR-XP	K45MF16X1,5FOR-XP
K41MF18X1,5XP	K41MF18X1,5FOR-XP	K45MF18X1,5FOR-XP
K41MF20X1,5XP	K41MF20X1,5FOR-XP	K45MF20X1,5FOR-XP
K41MF22X1,5XP	K41MF22X1,5FOR-XP	K45MF22X1,5FOR-XP
K41MF24X1,5XP	K41MF24X1,5FOR-XP	K45MF24X1,5FOR-XP
K41MF26X1,5XP	K41MF26X1,5FOR-XP	K45MF26X1,5FOR-XP
K41MF28X1,5XP	K41MF28X1,5FOR-XP	K45MF28X1,5FOR-XP

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min											
P	Acciaio - Steel - Acier - Rm<1200 N/mm²	•1.3 20-25	•1.4 15-20	•1.5 5-12	•1.6 5-8	•1.3 20-25	•1.4 15-20	•1.5 5-12	•1.6 5-8	•1.3 20-25	•1.4 15-20	•1.5 5-12	•1.6 5-8
K	Ghisa - Cast iron - Fonte	•3.3 15-20	•3.4 20-25			•3.3 15-20	•3.4 20-25						
N	Leghe di Allumino - Al alloys - Alliage Al - Si < 10% Truciolo medio - Medium chipping - Copeaux moyen	•4.3 20-25				•4.3 20-25							
S	Leghe di titanio - Titanium alloys - Alliage de titane Rm<900 N/mm²	•6.2 2-3				•6.2 2-3							
S	Leghe di Nichel - Nickel alloys - Alliages de nickel Rm<900 N/mm²	•7.2 2-3				•7.2 2-3							

• Raccomandato - Optimal - Recommandé ◦ Adatto - Suitable - Adaptè

MJ UNJC UNJF AMC

DIAMETRO ESTERNO ARROTONDATO
WITH ROUNDED CREST
DIAMÈTRE EXTÉRIEUR ARRONDI

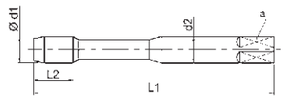
Ni | NICHEL - NICKEL

MF

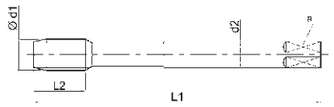
MASCHI A MACCHINA - Elica destra a 15° per fori ciechi
MACHINE TAPS - Spiral flutes 15° for blind holes
TARAUDS MACHINE - Goujures hélicoïdales 15° pour trous borgnes

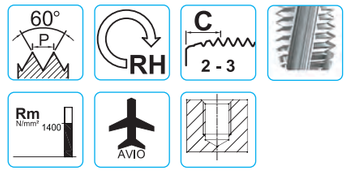
DIN13 | Ti | TITANIO - TITANIUM - TITANE

DIN 371 d1 ≤ M10



DIN 374 d1 ≥ M12





Profondità di filettatura - Thread depth - Prof. de filetage	1,5xD	1,5xD	
Materiale - Tool Material - Substrat	PM3	PM3	
Tolleranza - Thread tolerance - Tolérance du filetage	6HX	4H	
Trattamento superficiale - Surface treatment - Revêtement	TiCN	TiCN	

DIN 371	Ød1 MF	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE	
	8	1	90	13	8	6,2	3	*7	K42MF8X1CT	K42MJF8X1CT
	10	1	90	15	10	8	3	*9	K42MF10X1CT	K42MJF10X1CT
	10	1,25	100	15	10	8	3	*8,75	K42MF10X1,25CT	K42MJF10X1,25CT

DIN 374	Ød1 MF	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE	
	12	1,25	100	13	9	7	4	*10,75	K43MF12X1,25CT	-
	12	1,5	100	13	9	7	4	*10,5	K43MF12X1,5CT	-
	14	1,5	100	15	11	9	4	*12,5	K43MF14X1,5CT	-
	16	1,5	100	15	12	9	4	*14,5	K43MF16X1,5CT	-

* Diametri di preforo MJ a pag: 269 - Bore hole for thread MJ to page: 269 - Pour MJ voir le tableau de perçage page: 269

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min	
P	Acciaio - Steel - Acier - Rm ≤ 1200-1400 N/mm²	•1.6 5-8	
M	Inox - Stainless steel - Acier inoxydable Cr–Ni, Rm < 1400 N/mm²	•2.4 3-6	
K	Ghisa - Cast iron - Fonte	•3.3 15-20	•3.4 20-25
N	Leghe di Allumino - Al alloys - Alliage Al Si > 10%	◦4.4 25-30	
N	Leghe di Rame - Copper alloys - Alliages de cuivre Ottone, Bronzo - Hard brass, bronze - Laiton, bronze	•5.3 25-30	◦5.4 5-8
S	Leghe di titanio - Titanium alloys Alliage de titane Rm<1400 N/mm²	•6.2 4-8	•6.3 2-4
S	Leghe di Nichel - Nickel alloys Alliages de nickel Rm<900 N/mm²	•7.2 2-4	

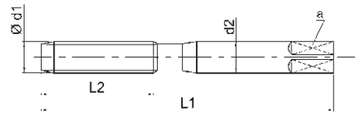
• Raccomandato - Optimal - Recommandé ◦ Adatto - Suitable - Adaptè

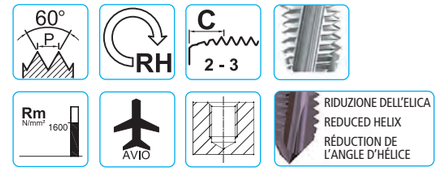
MF

MASCHI A MACCHINA - Elica 10° destra per fori ciechi
MACHINE TAPS - Spiral flutes 10° for blind holes
TARAUDS MACHINE - Goujures hélicoïdales 10° pour trous borgnes

DIN13 | Ni | NICHEL - NICKEL

UFS Norm





Profondità di filettatura - Thread depth - Prof. de filetage	1,5xD	1,5xD	
Materiale - Tool Material - Substrat	PM3	PM3	
Tolleranza - Thread tolerance - Tolérance du filetage	6HX	4H	
Trattamento superficiale - Surface treatment - Revêtement	TiCN	TiCN	

UFS Norm	Ød1 MF	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE	
	8	1	90	25	8	6,2	3	*7	K42MF8X1NI-CT	K42MJF8X1NI-CT
	10	1	100	30	10	8	3	*9	K42MF10X1NI-CT	K42MJF10X1NI-CT
	10	1,25	100	30	10	8	3	*8,75	K42MF10X1,25NI-CT	K42MJF10X1,25NI-CT
	12	1,25	110	25	12	9	3	*10,75	K42MF12X1,25NI-CT	-
	12	1,5	110	25	12	9	3	*10,5	K42MF12X1,5NI-CT	-

Dimensioni a norma di fabbrica
Dimensions according to standard factory
Dimensions selon la norme d'usine

* Diametri di preforo MJ a pag: 269 - Bore hole for thread MJ to page: 269 - Pour MJ voir le tableau de perçage page: 269

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min	
P	Acciaio – Steel – Acier - Rm ≤ 1600 N/mm²	◦1.6 5-8	•1.7 1-3
N	Bronzo ad alta resistenza - High strength bronze - Bronze haute résistance Rm<1500 N/mm²	•5.4 5-8	
S	Leghe di Nichel - Nickel alloys - Alliages de nickel Rm<1600 N/mm²	◦7.2 2-4	•7.3 1-3

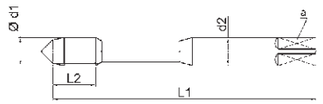
• Raccomandato - Optimal - Recommandé ◦ Adatto - Suitable - Adaptè

MF

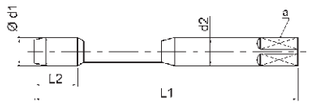
MASCHI A MACCHINA - Elica destra a 40° per fori ciechi
MACHINE TAPS - Spiral flutes 40° for blind holes
TARAUDS MACHINE - Goujures hélicoïdales 40° pour trous borgnes

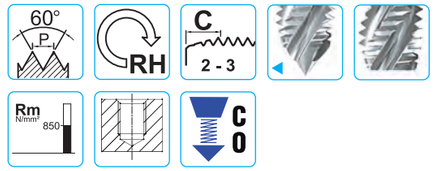
DIN13 | USO GENERALE - GENERAL PURPOSE - USAGE GÉNÉRAL

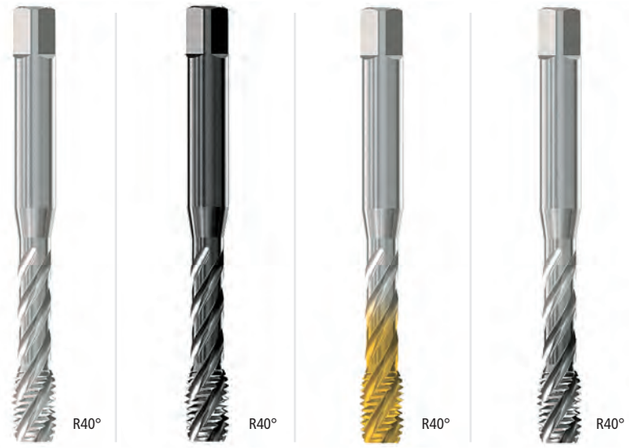
DIN 371 d1 ≤ M6



DIN 371 d1 ≥ M8







Profondità di filettatura - Thread depth - Prof. de filetage	2,5xD	2,5xD	2,5xD	2,5xD
Materiale - Tool Material - Substrat	HSSE	HSSE	HSSE	HSSE
Tolleranza - Thread tolerance - Tolérance du filetage	ISO2/6H	ISO2/6H	ISO2/6H	ISO2/6H
Trattamento superficiale - Surface treatment - Revêtement		V	TiN	XP

DIN 371	Ød1 MF	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE			
◄	4	0,75	63	7	4,5	3,4	3	3,5	E60MF4X0,5	E60MF4X0,5V	E60MF4X0,5T	E60MF4X0,5XP
◄	5	0,75	70	8	6	4,9	3	4,5	E60MF5X0,5	E60MF5X0,5V	E60MF5X0,5T	E60MF5X0,5XP
◄	6	0,75	80	10	6	4,9	3	5,25	E60MF6X0,75	E60MF6X0,75V	E60MF6X0,75T	E60MF6X0,75XP
	8	0,75	90	13	8	6,2	3	7,25	E60MF8X0,75	E60MF8X0,75V	E60MF8X0,75T	E60MF8X0,75XP
	8	1	90	13	8	6,2	3	7	E60MF8X1	E60MF8X1V	E60MF8X1T	E60MF8X1XP
	10	1	90	15	10	8	3	9	E60MF10X1	E60MF10X1V	E60MF10X1T	E60MF10X1XP
	10	1,25	100	15	10	8	3	8,75	E60MF10X1,25	E60MF10X1,25V	E60MF10X1,25T	E60MF10X1,25XP

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min															
P	Acciaio - Steel - Acier - Rm ≤ 850 N/mm²	○1.1 10-15	•1.2 10-15	•1.3 10-12	○1.4 8-10	•1.1 10-15	•1.2 10-15	•1.3 10-12	○1.4 8-10	•1.1 20-30	•1.2 20-30	•1.3 20-25	•1.4 15-20	•1.1 20-30	•1.2 20-30	•1.3 20-25	•1.4 15-20
M	Acciaio inox - Stainless steel - Acier inoxydable													○2.1 10-15	○2.2 8-10		
K	Ghisa - Cast iron - Fonte									○3.3 10-15	•3.4 15-20			○3.3 10-15	•3.4 15-20		
N	Leghe di Allumino - Al alloys - Alliage Al	○4.1 10-15	•4.2 15-20			•4.1 10-15	•4.2 15-20			○4.1 20-25	•4.2 25-30	○4.3 20-25		•4.2 25-30	○4.3 20-25		
N	Leghe di Rame - Copper alloys - Alliages de cuivre	○5.1 8-12	○5.2 10-15			•5.1 8-12	•5.2 10-15			○5.1 15-20	•5.2 20-25			•5.2 20-25			

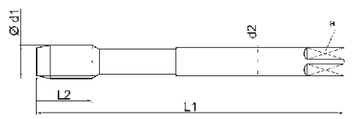
• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

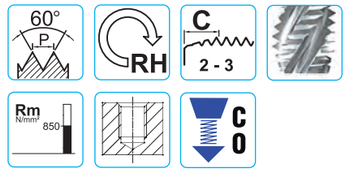
MF

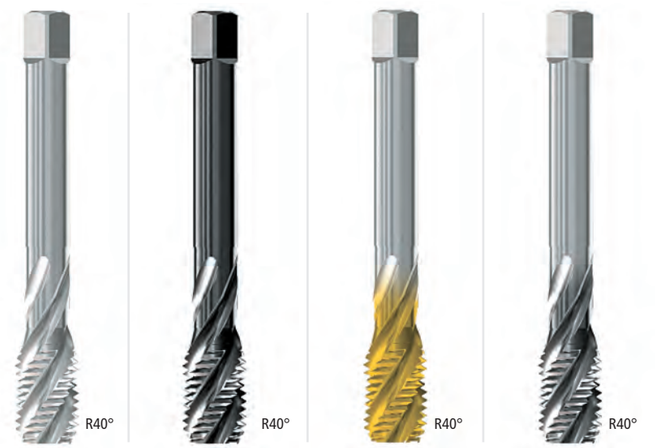
MASCHI A MACCHINA - Elica destra a 40° per fori ciechi
MACHINE TAPS - Spiral flutes 40° for blind holes
TARAUDS MACHINE - Goujures hélicoïdales 40° pour trous borgnes

DIN13 | USO GENERALE - GENERAL PURPOSE - USAGE GÉNÉRAL

DIN 374







Profondità di filettatura - Thread depth - Prof. de filetage	2,5xD	2,5xD	2,5xD	2,5xD
Materiale - Tool Material - Substrat	HSSE	HSSE	HSSE	HSSE
Tolleranza - Thread tolerance - Tolérance du filetage	ISO2/6H	ISO2/6H	ISO2/6H	ISO2/6H
Trattamento superficiale - Surface treatment - Revêtement		V	TiN	XP

DIN 374	Ød1 MF	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE			
	8	1	90	13	6	4,9	3	7	E61MF8X1	E61MF8X1V	E61MF8X1T	E61MF8X1XP
	9	1	90	18	7	5,5	3	8	E61MF9X1	E61MF9X1V	E61MF9X1T	E61MF9X1XP
	10	1	90	15	7	5,5	3	9	E61MF10X1	E61MF10X1V	E61MF10X1T	E61MF10X1XP
	10	1,25	100	15	7	5,5	3	8,75	E61MF10X1,25	E61MF10X1,25V	E61MF10X1,25T	E61MF10X1,25XP
	12	1	100	13	9	7	3	11	E61MF12X1	E61MF12X1V	E61MF12X1T	E61MF12X1XP
	12	1,25	100	13	9	7	3	10,75	E61MF12X1,25	E61MF12X1,25V	E61MF12X1,25T	E61MF12X1,25XP
	12	1,5	100	13	9	7	3	10,5	E61MF12X1,5	E61MF12X1,5V	E61MF12X1,5T	E61MF12X1,5XP
	13	1	100	15	11	9	4	12	E61MF13X1	E61MF13X1V	E61MF13X1T	E61MF13X1XP
	14	1	100	15	11	9	4	13	E61MF14X1	E61MF14X1V	E61MF14X1T	E61MF14X1XP
	14	1,25	100	15	11	9	4	12,75	E61MF14X1,25	E61MF14X1,25V	E61MF14X1,25T	E61MF14X1,25XP
	14	1,5	100	15	11	9	4	12,5	E61MF14X1,5	E61MF14X1,5V	E61MF14X1,5T	E61MF14X1,5XP
	15	1	100	22	12	9	4	14	E61MF15X1	E61MF15X1V	E61MF15X1T	E61MF15X1XP
	16	1	100	15	12	9	4	15	E61MF16X1	E61MF16X1V	E61MF16X1T	E61MF16X1XP
	16	1,5	100	15	12	9	4	14,5	E61MF16X1,5	E61MF16X1,5V	E61MF16X1,5T	E61MF16X1,5XP
	17	1	110	25	14	11	4	16	E61MF17X1	E61MF17X1V	E61MF17X1T	E61MF17X1XP
	18	1	110	17	14	11	4	17	E61MF18X1	E61MF18X1V	E61MF18X1T	E61MF18X1XP
	18	1,5	110	17	14	11	4	16,5	E61MF18X1,5	E61MF18X1,5V	E61MF18X1,5T	E61MF18X1,5XP
	18	2	125	25	14	11	4	16	E61MF18X2	E61MF18X2V	E61MF18X2T	E61MF18X2XP

Segue diametri / Diameters continue / Diamètres à suivre

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min															
P	Acciaio - Steel - Acier - Rm ≤ 850 N/mm²	○1.1 10-15	•1.2 10-15	•1.3 10-12	○1.4 8-10	•1.1 10-15	•1.2 10-15	•1.3 10-12	○1.4 8-10	•1.1 20-30	•1.2 20-30	•1.3 20-25	•1.4 15-20	•1.1 20-30	•1.2 20-30	•1.3 20-25	•1.4 15-20
M	Acciaio inox - Stainless steel - Acier inoxydable													○2.1 10-15	○2.2 8-10		
K	Ghisa - Cast iron - Fonte									○3.3 10-15	•3.4 15-20			○3.3 10-15	•3.4 15-20		
N	Leghe di Allumino - Al alloys - Alliage Al	○4.1 10-15	•4.2 15-20			•4.1 10-15	•4.2 15-20			○4.1 20-25	•4.2 25-30	○4.3 20-25		•4.2 25-30	○4.3 20-25		
N	Leghe di Rame - Copper alloys - Alliages de cuivre	○5.1 8-12	○5.2 10-15			•5.1 8-12	•5.2 10-15			○5.1 15-20	•5.2 20-25			•5.2 20-25			

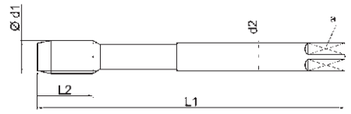
• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

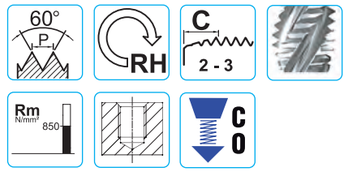
MF

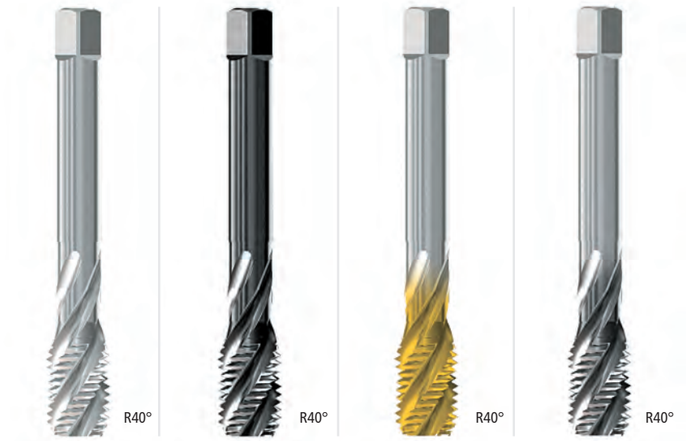
MASCHI A MACCHINA - Elica destra a 40° per fori ciechi
MACHINE TAPS - Spiral flutes 40° for blind holes
TARAUDS MACHINE - Goujures hélicoïdales 40° pour trous borgnes

DIN13 — USO GENERALE - GENERAL PURPOSE - USAGE GÉNÉRAL

DIN 374







Profondità di filettatura - Thread depth - Prof. de filetage	2,5xD	2,5xD	2,5xD	2,5xD
Materiale - Tool Material - Substrat	HSSE	HSSE	HSSE	HSSE
Tolleranza - Thread tolerance - Tolérance du filetage	ISO2/6H	ISO2/6H	ISO2/6H	ISO2/6H
Trattamento superficiale - Surface treatment - Revêtement		V	TiN	XP

DIN 374	Ød1 MF	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE			
	20	**1**	125	17	16	12	4	19	E61MF20X1	E61MF20X1V	E61MF20X1T	E61MF20X1XP
	20	**1,5**	125	17	16	12	4	18,5	E61MF20X1,5	E61MF20X1,5V	E61MF20X1,5T	E61MF20X1,5XP
	20	**2**	140	25	16	12	4	18	E61MF20X2	E61MF20X2V	E61MF20X2T	E61MF20X2XP
	22	**1,5**	125	18	18	14,5	4	20,5	E61MF22X1,5	E61MF22X1,5V	E61MF22X1,5T	E61MF22X1,5XP
	22	**2**	140	25	18	14,5	4	20	E61MF22X2	E61MF22X2V	E61MF22X2T	E61MF22X2XP
	24	**1**	140	20	18	14,5	4	23	E61MF24X1	E61MF24X1V	E61MF24X1T	E61MF24X1XP
	24	**1,5**	140	20	18	14,5	4	22,5	E61MF24X1,5	E61MF24X1,5V	E61MF24X1,5T	E61MF24X1,5XP
	24	**2**	140	20	18	14,5	4	22	E61MF24X2	E61MF24X2V	E61MF24X2T	-
	25	**1**	140	20	18	14,5	4	24	E61MF25X1	E61MF25X1V	E61MF25X1T	-
	25	**1,5**	140	20	18	14,5	4	23,5	E61MF25X1,5	E61MF25X1,5V	E61MF25X1,5T	-
	26	**1,5**	140	20	18	14,5	4	24,5	E61MF26X1,5	E61MF26X1,5V	E61MF26X1,5T	-
	27	**1,5**	140	20	20	16	4	25,5	E61MF27X1,5	E61MF27X1,5V	E61MF27X1,5T	-
	27	**2**	140	20	20	16	4	25	E61MF27X2	E61MF27X2V	E61MF27X2T	-
	28	**1,5**	140	20	20	16	4	26,5	E61MF28X1,5	E61MF28X1,5V	E61MF28X1,5T	-
	30	**1,5**	150	22	22	18	4	28,5	E61MF30X1,5	E61MF30X1,5V	E61MF30X1,5T	-
	30	**2**	150	22	22	18	4	28	E61MF30X2	E61MF30X2V	E61MF30X2T	-
	32	**1,5**	150	22	22	18	5	30,5	E61MF32X1,5	E61MF32X1,5V	E61MF32X1,5T	-
	32	**2**	150	22	22	18	5	30	E61MF32X2	E61MF32X2V	E61MF32X2T	-

Segue diametri / Diameters continue / Diamètres à suivre

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min															
P	Acciaio - Steel - Acier - Rm ≤ 850 N/mm²	○1.1 10-15	•1.2 10-15	•1.3 10-12	○1.4 8-10	•1.1 10-15	•1.2 10-15	•1.3 10-12	○1.4 8-10	•1.1 20-30	•1.2 20-30	•1.3 20-25	•1.4 15-20	•1.1 20-30	•1.2 20-30	•1.3 20-25	•1.4 15-20
M	Acciaio inox - Stainless steel - Acier inoxydable													○2.1 10-15	○2.2 8-10		
K	Ghisa - Cast iron - Fonte									○3.3 10-15	•3.4 15-20			○3.3 10-15	•3.4 15-20		
N	Leghe di Allumino - Al alloys - Alliage Al	○4.1 10-15	•4.2 15-20			•4.1 10-15	•4.2 15-20			○4.1 20-25	•4.2 25-30	○4.3 20-25		•4.2 25-30	○4.3 20-25		
N	Leghe di Rame - Copper alloys - Alliages de cuivre	○5.1 8-12	○5.2 10-15			•5.1 8-12	•5.2 10-15			○5.1 15-20	•5.2 20-25			•5.2 20-25			

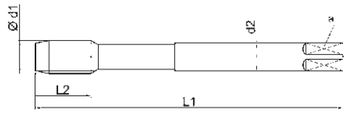
• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

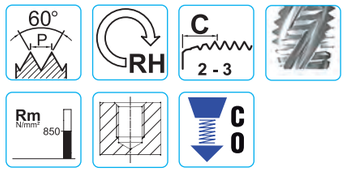
MF

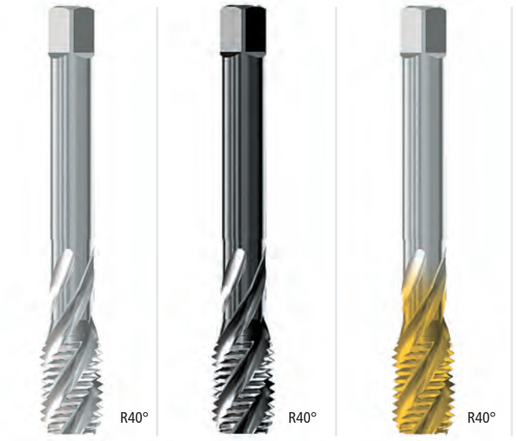
MASCHI A MACCHINA - Elica destra a 40° per fori ciechi
MACHINE TAPS - Spiral flutes 40° for blind holes
TARAUDS MACHINE - Goujures hélicoïdales 40° pour trous borgnes

DIN13 — USO GENERALE - GENERAL PURPOSE - USAGE GÉNÉRAL

DIN 374







Profondità di filettatura - Thread depth - Prof. de filetage	2,5xD	2,5xD	2,5xD
Materiale - Tool Material - Substrat	HSSE	HSSE	HSSE
Tolleranza - Thread tolerance - Tolérance du filetage	ISO2/6H	ISO2/6H	ISO2/6H
Trattamento superficiale - Surface treatment - Revêtement		V	TiN

DIN 374	Ød1 MF	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE		
	33	**2**	160	24	25	20	5	31	E61MF33X2	E61MF33X2V	E61MF33X2T
	33	**3**	180	35	25	20	4	30	E61MF33X3	E61MF33X3V	E61MF33X3T
	36	**1,5**	170	24	28	22	5	34,5	E61MF36X1,5	E61MF36X1,5V	E61MF36X1,5T
	36	**2**	170	24	28	22	5	34	E61MF36X2	E61MF36X2V	E61MF36X2T
	36	**3**	200	40	28	22	4	33	E61MF36X3	E61MF36X3V	E61MF36X3T
	39	**3**	200	40	32	24	4	36	E61MF39X3	E61MF39X3V	E61MF39X3T
	42	**2**	170	25	32	24	6	40	E61MF42X2	E61MF42X2V	E61MF42X2T
	42	**3**	200	40	32	24	5	39	E61MF42X3	E61MF42X3V	E61MF42X3T

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min															
P	Acciaio - Steel - Acier - Rm ≤ 850 N/mm²	○1.1 10-15	•1.2 10-15	•1.3 10-12	○1.4 8-10	•1.1 10-15	•1.2 10-15	•1.3 10-12	○1.4 8-10	•1.1 20-30	•1.2 20-30	•1.3 20-25	•1.4 15-20				
M	Acciaio inox - Stainless steel - Acier inoxydable																
K	Ghisa - Cast iron - Fonte									○3.3 10-15	•3.4 15-20						
N	Leghe di Allumino - Al alloys - Alliage Al	○4.1 10-15	•4.2 15-20			•4.1 10-15	•4.2 15-20			○4.1 20-25	•4.2 25-30	○4.3 20-25					
N	Leghe di Rame - Copper alloys - Alliages de cuivre	○5.1 8-12	○5.2 10-15			•5.1 8-12	•5.2 10-15			○5.1 15-20	•5.2 20-25						

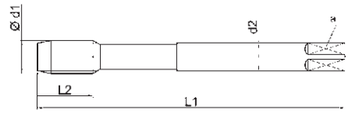
• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

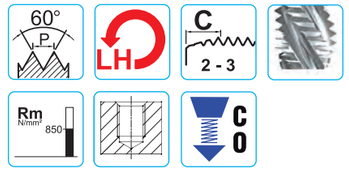
MF

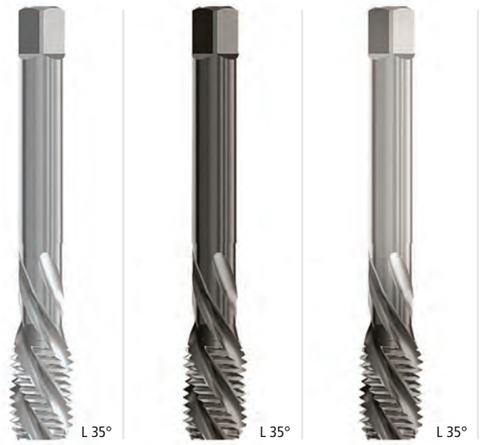
MASCHI A MACCHINA - Elicoidali 35° per fori ciechi filettatura sinistra
MACHINE TAPS - Spiral flutes 35° for blind holes left thread
TARAUDS MACHINE - Goujures hélicoïdales 35° pour trous borgnes filetage à gauche

DIN13 | USO GENERALE - GENERAL PURPOSE - USAGE GÉNÉRAL

DIN 374







Profondità di filettatura - Thread depth - Prof. de filetage	2,5xD	2,5xD	2,5xD
Materiale - Tool Material - Substrat	HSSE	HSSE	HSSE
Tolleranza - Thread tolerance - Tolérance du filetage	ISO2/6H	ISO2/6H	ISO2/6H
Trattamento superficiale - Surface treatment - Revêtement		V	XP

DIN 374	Ød1 MF	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE		
	8	**1**	90	13	6	4,9	3	7	E61MF8X1LH	E61MF8X1LH-V	E61MF8X1LH-XP
	10	**1**	90	15	7	5,5	3	9	E61MF10X1LH	E61MF10X1LH-V	E61MF10X1LH-XP
	10	**1,25**	100	15	7	5,5	3	8,75	E61MF10X1,25LH	E61MF10X1,25LH-V	E61MF10X1,25LH-XP
	12	**1,25**	100	13	9	7	3	10,75	E61MF12X1,25LH	E61MF12X1,25LH-V	E61MF12X1,25LH-XP
	12	**1,5**	100	13	9	7	3	10,5	E61MF12X1,5LH	E61MF12X1,5LH-V	E61MF12X1,5LH-XP
	14	**1,5**	100	15	11	9	4	12,5	E61MF14X1,5LH	E61MF14X1,5LH-V	E61MF14X1,5LH-XP
	16	**1,5**	100	15	12	9	4	14,5	E61MF16X1,5LH	E61MF16X1,5LH-V	E61MF16X1,5LH-XP

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min											
P	Acciaio - Steel - Acier - Rm ≤ 850 N/mm²	◑1.1 10-15	◑1.2 10-15	◑1.3 10-12	◑1.4 8-10	●1.1 10-15	●1.2 10-15	●1.3 10-12	◑1.4 8-10	●1.1 20-30	●1.2 20-30	●1.3 20-25	●1.4 15-20
M	Acciaio inox - Stainless steel - Acier inoxydable									◑2.1 10-15	◑2.2 8-10		
K	Ghisa - Cast iron - Fonte									◑3.3 10-15	●3.4 15-20		
N	Leghe di Allumino - Al alloys - Alliage Al	◑4.1 10-15	●4.2 15-20			●4.1 10-15	●4.2 15-20			●4.2 25-30	◑4.3 20-25		
N	Leghe di Rame - Copper alloys - Alliages de cuivre	◑5.1 8-12	◑5.2 10-15			●5.1 8-12	●5.2 10-15			●5.2 20-25			

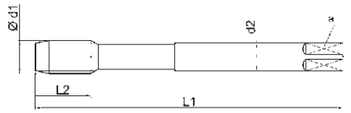
• Raccomandato - Optimal - Recommandé ◑ Adatto - Suitable - Adaptè

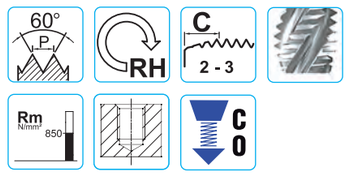
MF

MASCHI A MACCHINA - Elicoidali 40° per fori ciechi tolleranza 6G e 6H+0,1
MACHINE TAPS - Spiral flutes 40° for blind holes tolerance 6G and 6H+0,1
TARAUDS MACHINE - Goujures hélicoïdales 40° pour trous borgnes tolérance 6G et 6H+0,1

DIN13 | USO GENERALE - GENERAL PURPOSE - USAGE GÉNÉRAL

DIN 374





Profondità di filettatura - Thread depth - Prof. de filetage	2,5xD	2,5xD	2,5xD	2,5xD
Materiale - Tool Material - Substrat	HSSE	HSSE	HSSE	HSSE
Tolleranza - Thread tolerance - Tolérance du filetage	ISO3/6G	ISO3/6G	6H+0,1	6H+0,1
Trattamento superficiale - Surface treatment - Revêtement		XP		XP

DIN 374	Ød1 MF	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE			
	8	**1**	90	13	6	4,9	3	7	E61MF8X1-6G	E61MF8X1XP-6G	E61MF8X1+0,1	E61MF8X1XP+0,1
	10	**1**	90	15	7	5,5	3	9	E61MF10X1-6G	E61MF10X1XP-6G	E61MF10X1+0,1	E61MF10X1XP+0,1
	10	**1,25**	100	15	7	5,5	3	8,75	E61MF10X1,25-6G	E61MF10X1,25XP-6G	E61MF10X1,25+0,1	E61MF10X1,25XP+0,1
	12	**1,25**	100	13	9	7	3	10,75	E61MF12X1,25-6G	E61MF12X1,25XP-6G	E61MF12X1,25+0,1	E61MF12X1,25XP+0,1
	12	**1,5**	100	13	9	7	3	10,5	E61MF12X1,5-6G	E61MF12X1,5XP-6G	E61MF12X1,5+0,1	E61MF12X1,5XP+0,1
	14	**1,5**	100	15	11	9	4	12,5	E61MF14X1,5-6G	E61MF14X1,5XP-6G	E61MF14X1,5+0,1	E61MF14X1,5XP+0,1
	16	**1,5**	100	15	12	9	4	14,5	E61MF16X1,5-6G	E61MF16X1,5XP-6G	E61MF16X1,5+0,1	E61MF16X1,5XP+0,1

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min														
P	Acciaio - Steel - Acier - Rm ≤ 850 N/mm²	◑1.1 10-15	◑1.2 10-15	◑1.3 10-12	◑1.4 8-10	●1.1 20-30	●1.2 20-30	●1.3 20-25	●1.4 15-20	◑1.1 10-15	◑1.2 10-15	◑1.3 10-12	◑1.4 8-10	●1.1 20-30	●1.2 20-30	●1.3 20-25	●1.4 15-20
M	Acciaio inox - Stainless steel - Acier inoxydable					◑2.1 10-15	◑2.2 8-10							◑2.1 10-15	◑2.2 8-10		
K	Ghisa - Cast iron - Fonte					◑3.3 10-15	●3.4 15-20							◑3.3 10-15	●3.4 15-20		
N	Leghe di Allumino - Al alloys - Alliage Al	◑4.1 10-15	●4.2 15-20			●4.2 25-30	◑4.3 20-25			◑4.1 10-15	●4.2 15-20			●4.2 25-30	◑4.3 20-25		
N	Leghe di Rame - Copper alloys - Alliages de cuivre	◑5.1 8-12	◑5.2 10-15			●5.2 20-25				◑5.1 8-12	◑5.2 10-15			●5.2 20-25			

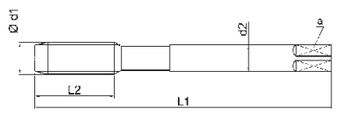
• Raccomandato - Optimal - Recommandé ◑ Adatto - Suitable - Adaptè

MF

MASCHI A MACCHINA - Elica destra a 45° per fori ciechi
MACHINE TAPS - Spiral flutes 45° for blind holes
TARAUDS MACHINE - Goujures hélicoïdales 45° pour trous borgnes

DIN13 | AL-CU-FE | ALLUMINIO, RAME, FERRO - ALUMINIUM, COPPER, IRON - ALUMINIUM, CUIVRE, FER

DIN 374



Profondità di filettatura - Thread depth - Prof. de filetage	**3xD**				
Materiale - Tool Material - Substrat	**HSSE**				
Tolleranza - Thread tolerance - Tolérance du filetage	**ISO2/6H**				
Trattamento superficiale - Surface treatment - Revêtement					

DIN 374	Ød1 MF	P mm	L_1	L_2	d_2 h9	a h12	Z	CODE
8	**1**	90	18	6	4,9	2	7	E71MF8X1SP
10	**1**	90	15	7	5,5	2	9	E71MF10X1SP
10	**1,25**	100	20	7	5,5	2	8,75	E71MF10X1,25SP
12	**1**	100	22	9	7	3	11	E71MF12X1
12	**1,25**	100	22	9	7	3	10,75	E71MF12X1,25
12	**1,5**	100	22	9	7	3	10,5	E71MF12X1,5
14	**1,5**	100	22	11	9	3	12,5	E71MF14X1,5
16	**1,5**	100	22	12	9	3	14,5	E71MF16X1,5

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min
P	Acciaio dolce magnetico - Magnetic soft steel - Acier doux magnétique - Rm <400 N/mm²	•1.1 10-15
N	Leghe di Allumino - Al alloys - Alliage Al	•4.1 10-15 · •4.2 15-20
N	Leghe di Rame - Copper alloys - Alliages de cuivre	•5.1 8-12 · •5.2 10-15
S	Titanio puro - Pure titanium - Titane pur	•6.1 5-8
S	Nichel puro - Pure nickel - Nickel pure	•7.1 6-8
N	Materiali termoplastici - Thermoplastics - Thermoplastiques Truciolo lungo - Long chipping - Copeaux longue	•8.1 20-25

• Raccomandato - Optimal - Recommandé ◦ Adatto - Suitable - Adaptè

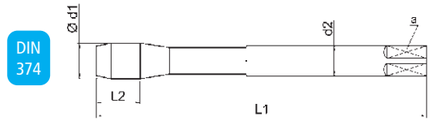
MF

MASCHI A MACCHINA - Elicoidali 45° per fori ciechi
MACHINE TAPS - Spiral flutes 45° for blind holes
TARAUDS MACHINE - Goujures hélicoïdales 45° pour trous borgnes

CSC CHIP SYSTEM CONTROL

DIN13 | USO GENERALE - GENERAL PURPOSE - USAGE GÉNÉRAL

DIN 374



Profondità di filettatura - Thread depth - Prof. de filetage	**3xD**	**3xD**	**3xD**
Materiale - Tool Material - Substrat	**HSSE-PM**	**HSSE-PM**	**HSSE-PM**
Tolleranza - Thread tolerance - Tolérance du filetage	**6HX**	**6HX**	**6HX**
Trattamento superficiale - Surface treatment - Revêtement		**V**	**TiN-G**

DIN 374	Ød1 MF	P mm	L_1	L_2	d_2 h9	a h12	Z	CODE		
8	**1**	90	13	6	4,9	3	7	E93MF8X1	E93MF8X1V	E93MF8X1TG
10	**1**	90	15	7	5,5	3	9	E93MF10X1	E93MF10X1V	E93MF10X1TG
10	**1,25**	100	15	7	5,5	3	8,75	E93MF10X1,25	E93MF10X1,25V	E93MF10X1,25TG
12	**1**	100	13	9	7	3	11	E93MF12X1	E93MF12X1V	E93MF12X1TG
12	**1,25**	100	13	9	7	3	10,75	E93MF12X1,25	E93MF12X1,25V	E93MF12X1,25TG
12	**1,5**	100	13	9	7	3	10,5	E93MF12X1,5	E93MF12X1,5V	E93MF12X1,5TG
14	**1,5**	100	15	11	9	4	12,5	E93MF14X1,5	E93MF14X1,5V	E93MF14X1,5TG
16	**1,5**	100	15	12	9	4	14,5	E93MF16X1,5	E93MF16X1,5V	E93MF16X1,5TG
18	**1,5**	110	17	14	11	4	16,5	E93MF18X1,5	E93MF18X1,5V	E93MF18X1,5TG
20	**1,5**	125	17	16	12	4	18,5	E93MF20X1,5	E93MF20X1,5V	E93MF20X1,5TG
22	**1,5**	125	18	18	14,5	4	20,5	E93MF22X1,5	E93MF22X1,5V	E93MF22X1,5TG
24	**1,5**	140	20	18	14,5	4	22,5	E93MF24X1,5	E93MF24X1,5V	E93MF24X1,5TG

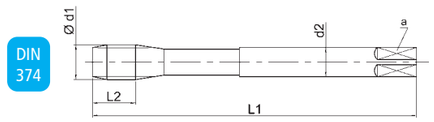
ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min
P	Acciaio - Steel - Acier - Rm ≤ 1200 N/mm²	◦1.1 10-15 · •1.2 10-15 · •1.3 10-12 · ◦1.4 8-10 · •1.1 10-15 · •1.2 10-15 · •1.3 10-12 · ◦1.4 8-10 · •1.2 20-30 · •1.3 20-25 · •1.4 15-20 · ◦1.5 5-12
M	Acciaio inox - Stainless steel - Acier inoxydable	•2.1 6-8 · •2.2 5-7
N	Leghe di Allumino - Al alloys - Alliage Al	•4.2 15-20 · •4.3 20-25
N	Leghe di Rame - Copper alloys - Alliages de cuivre	•5.1 8-12 · •5.2 10-15 · •5.2 20-25

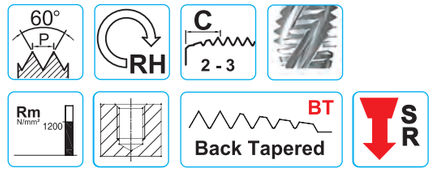
• Raccomandato - Optimal - Recommandé ◦ Adatto - Suitable - Adaptè

MF

MASCHI A MACCHINA - Elicoidali 45° per fori ciechi
MACHINE TAPS - Spiral flutes 45° for blind holes
TARAUDS MACHINE - Goujures hélicoïdales 45° pour trous borgnes

DIN13 | U | APPLICAZIONI UNIVERSALI - UNIVERSAL APPLICATIONS - USINAGE UNIVERSELS





Profondità di filettatura - Thread depth - Prof. de filetage	3xD	3,5xD	
Materiale - Tool Material - Substrat	PM3	PM3	
Tolleranza - Thread tolerance - Tolérance du filetage	6HX	6HX	
Trattamento superficiale - Surface treatment - Revêtement	XP	XP	

DIN 374	Ød1 MF	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE	
	8	**1**	90	13	6	4,9	3	7	K83MF8X1XP	K83MF8X1FOR-XP
	10	**1**	90	15	7	5,5	3	9	K83MF10X1XP	K83MF10X1,25FOR-XP
	10	**1,25**	100	15	7	5,5	3	8,75	K83MF10X1,25XP	K83MF10X1FOR-XP
	12	**1**	100	13	9	7	4	11	K83MF12X1XP	K83MF12X1,25FOR-XP
	12	**1,25**	100	13	9	7	4	10,75	K83MF12X1,25XP	K83MF12X1,5FOR-XP
	12	**1,5**	100	13	9	7	4	10,5	K83MF12X1,5XP	K83MF12X1FOR-XP
	14	**1,5**	100	15	11	9	4	12,5	K83MF14X1,5XP	K83MF14X1,5FOR-XP
	16	**1,5**	100	15	12	9	4	14,5	K83MF16X1,5XP	K83MF16X1,5FOR-XP
	18	**1,5**	110	17	14	11	4	16,5	K83MF18X1,5XP	K83MF18X1,5FOR-XP
	20	**1,5**	125	17	16	12	4	18,5	K83MF20X1,5XP	K83MF20X1,5FOR-XP
	22	**1,5**	125	18	18	14,5	4	20,5	K83MF22X1,5XP	K83MF22X1,5FOR-XP
	24	**1,5**	140	20	18	14,5	4	22,5	K83MF24X1,5XP	K83MF24X1,5FOR-XP

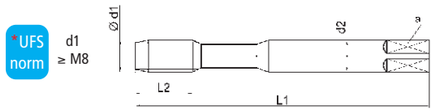
ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min
P	Acciaio - Steel - Acier - Rm ≤ 1200 N/mm²	◦1.1 20-30 · •1.2 20-30 · •1.3 20-25 · •1.4 15-20 · •1.5 5-12
M	Acciaio INOX - Stainless steel - Acier inoxydable	•2.1 10-15 · •2.2 8-10 · •2.3 6-8
K	Ghisa - Cast iron - Fonte	•3.3 10-15 · •3.4 15-20
N	Leghe di Allumino - Al alloys - Alliage Al	•4.2 25-30 · •4.3 20-25
N	Leghe di Rame - Copper alloys - Alliages de cuivre Truciolo lungo - Long chipping - Copeaux longs	•5.2 20-25

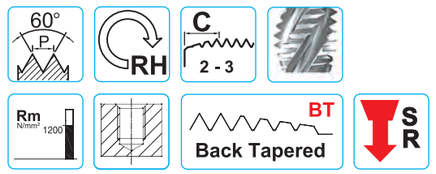
• Raccomandato - Optimal - Recommandé ◦ Adatto - Suitable - Adaptè

MF

MASCHI A MACCHINA - Elicoidali 40° per fori ciechi
MACHINE TAPS - Spiral flutes 40° for blind holes
TARAUDS MACHINE - Goujures hélicoïdales 40° pour trous borgnes

DIN13 | SYNCHRO RIGID | MASCHIATURA RIGIDA SINCRONIZZATA - RIGID TAPPING SYNCHRO - TARAUDAGE RIGIDE SYNCHRONISÉ





Profondità di filettatura - Thread depth - Prof. de filetage	2,5xD	3xD	
Materiale - Tool Material - Substrat	PM3	PM3	
Tolleranza - Thread tolerance - Tolérance du filetage	6HX	6HX	
Trattamento superficiale - Surface treatment - Revêtement	TXC	TXC	

UFS norm	Ød1 MF	P mm	L_1	L_2	d_2 h6	a h12	Z		CODE	
	8	**1**	90	13	8	6,2	3	7	S80MF8X1TXC	S80MF8X1FOR-TXC
	10	**1**	100	15	10	8	3	9	S80MF10X1TXC	S80MF10X1FOR-TXC
	10	**1,25**	100	15	10	8	3	8,75	S80MF10X1,25TXC	S80MF10X1,25FOR-TXC
	12	**1,25**	110	18	12	9	3	10,75	S80MF12X1,25TXC	S80MF12X1,25FOR-TXC
	12	**1,5**	110	18	12	9	3	10,5	S80MF12X1,5TXC	S80MF12X1,5FOR-TXC
	14	**1,5**	110	20	12	9	4	12,5	S80MF14X1,5TXC	S80MF14X1,5FOR-TXC
	16	**1,5**	110	20	16	12	4	14,5	S80MF16X1,5TXC	S80MF16X1,5FOR-TXC

* Dimensioni a norma di fabbrica
Dimensions according to standard factory
Dimensions selon la norme d'usine

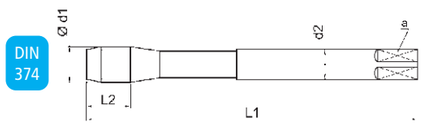
ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min
P	Acciaio - Steel - Acier - Rm ≤ 1200 N/mm²	•1.1 40-50 · •1.2 40-50 · •1.3 35-40 · •1.4 25-30 · •1.5 10-15
M	Acciaio INOX - Stainless steel - Acier inoxydable	•2.1 20-25 · •2.2 15-20 · •2.3 10-15 · •2.4 10-12
K	Ghisa - Cast iron - Fonte	•3.3 20-25 · •3.4 25-30
N	Leghe di Allumino - Al alloys - Alliage Al Si < 10%	•4.1 30-40 · •4.2 45-50 · •4.3 30-40
N	Leghe di Rame - Copper alloys - Alliages de cuivre Truciolo lungo - Long chipping - Copeaux longs	•5.1 20-25 · •5.2 25-30
S	Leghe di Titanio Titanium alloys - Alliage de Titane Rm<900 N/mm²	•6.1 20-30 · ◦6.2 12-15
S	Leghe di Nichel - Nickel alloys - Alliages de Nickel Rm<900 N/mm²	•7.1 20-30 · ◦7.2 8-12

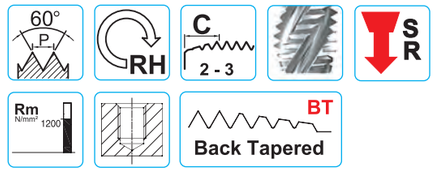
• Raccomandato - Optimal - Recommandé ◦ Adatto - Suitable - Adaptè

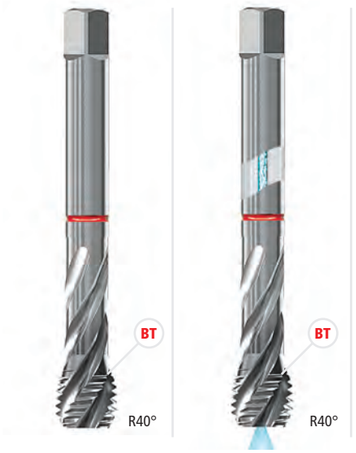
MF

MASCHI A MACCHINA - Elicoidali 40° per fori ciechi
MACHINE TAPS - Spiral flutes 40° for blind holes
TARAUDS MACHINE - Goujures hélicoïdales 40° pour trous borgnes

DIN13 | HR | ALTA RESISTENZA - HIGH RESISTANCE - HAUTE RÉSISTANCE







Profondità di filettatura - Thread depth - Prof. de filetage	2,5xD	3xD
Materiale - Tool Material - Substrat	PM3	PM3
Tolleranza - Thread tolerance - Tolérance du filetage	6HX	6HX
Trattamento superficiale - Surface treatment - Revêtement	TXC	TXC

DIN 374	Ød1 MF	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE	
8	**1**	90	13	6	4,9	3	7		K81MF8X1TXC	K81MF8X1FOR-TXC
10	**1**	90	15	7	5,5	3	9		K81MF10X1TXC	K81MF10X1FOR-TXC
10	**1,25**	100	15	7	5,5	3	8,75		K81MF10X1,25TXC	K81MF10X1,25FOR-TXC
12	**1,25**	100	13	9	7	4	10,75		K81MF12X1,25TXC	K81MF12X1,25FOR-TXC
12	**1,5**	100	13	9	7	4	10,5		K81MF12X1,5TXC	K81MF12X1,5FOR-TXC
14	**1,5**	100	15	11	9	4	12,5		K81MF14X1,5TXC	K81MF14X1,5FOR-TXC
16	**1,5**	100	15	12	9	4	14,5		K81MF16X1,5TXC	K81MF16X1,5FOR-TXC

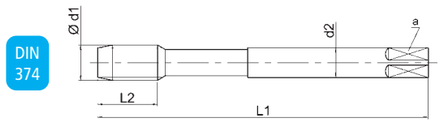
ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min	
P	Acciaio - Steel - Acier - Rm<1200 N/mm²	•1.4 15-20	•1.5 5-12
K	Ghisa - Cast iron - Fonte	•3.3 15-20	•3.4 20-25

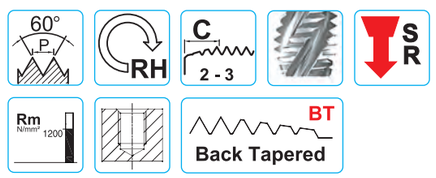
• Raccomandato - Optimal - Recommandé ◦ Adatto - Suitable - Adaptè

MF

MASCHI A MACCHINA - Elicoidali 45°/48° per fori ciechi
MACHINE TAPS - Spiral flutes 45°/48° for blind holes
TARAUDS MACHINE - Goujures hélicoïdales 45°/48° pour trous borgnes

DIN13 | INOX | ACCIAIO INOSSIDABILE - STAINLESS STEEL - ACIER INOXYDABLE





Profondità di filettatura - Thread depth - Prof. de filetage	3xD	3,5xD	3,5xD
Materiale - Tool Material - Substrat	HSSE	HSSV3	HSSV3
Tolleranza - Thread tolerance - Tolérance du filetage	6HX	6HX	6HX
Trattamento superficiale - Surface treatment - Revêtement	VS	TXC	TXC

DIN 374	Ød1 MF	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE		
8	**1**	90	13	6	4,9	3	7		E93MF8X1VS	V83MF8X1TXC	V83MF8X1FOR-TXC
10	**1**	90	15	7	5,5	3	9		E93MF10X1VS	V83MF10X1TXC	V83MF10X1FOR-TXC
10	**1,25**	100	15	7	5,5	3	8,75		E93MF10X1,25VS	V83MF10X1,25TXC	V83MF10X1,25FOR-TXC
12	**1**	100	13	9	7	4	11		E93MF12X1VS	V83MF12X1TXC	-
12	**1,25**	100	13	9	7	4	10,75		E93MF12X1,25VS	V83MF12X1,25TXC	V83MF12X1,25FOR-TXC
12	**1,5**	100	13	9	7	4	10,5		E93MF12X1,5VS	V83MF12X1,5TXC	V83MF12X1,5FOR-TXC
14	**1,5**	100	15	11	9	4	12,5		E93MF14X1,5VS	V83MF14X1,5TXC	V83MF14X1,5FOR-TXC
16	**1,5**	100	15	12	9	4	14,5		E93MF16X1,5VS	V83MF16X1,5TXC	V83MF16X1,5FOR-TXC
18	**1,5**	110	17	14	11	4	16,5		-	V83MF18X1,5TXC	-
20	**1,5**	125	17	16	12	4	18,5		-	V83MF20X1,5TXC	-
22	**1,5**	125	18	18	14,5	4	20,5		-	V83MF22X1,5TXC	-
24	**1,5**	140	20	18	14,5	4	22,5		-	V83MF24X1,5TXC	-

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min									
P	Acciaio - Steel - Acier - Rm < 1200 N/mm²	•1.1 20-25	•1.2 15-20		•1.3 20-25	•1.4 15-20	◦1.5 5-12		•1.3 20-25	•1.4 15-20	◦1.5 5-12	
M	Acciaio INOX – Stainless steel - Acier inoxydable	•2.1 6-8	•2.2 5-7	•2.3 3-5	•2.1 10-15	•2.2 8-10	•2.3 6-8	◦2.4 3-6	•2.1 10-15	•2.2 8-10	•2.3 6-8	•2.4 3-6

• Raccomandato - Optimal - Recommandé ◦ Adatto - Suitable - Adaptè

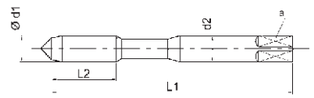
MF

MASCHI A MACCHINA - Per fori ciechi e passanti con canalini di lubrificazione
MACHINE TAPS - For blind and through holes with oil grooves
TARAUDS MACHINE - Pour trous borgnes et débouchant avec rainures de lubrification

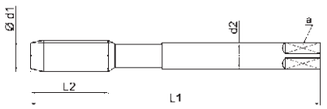
DIN13 | P - ROLL | MASCHI A RULLARE - ROLL FORM TAPS - TARAUDS À REFOULER

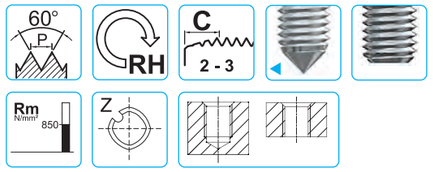
Rm < 850 Nm/m²

DIN 371 d1 ≤ M10



DIN 374 d1 ≥ M12





Profondità di filettatura - Thread depth - Prof. de filetage	3xD	3xD	3xD
Materiale - Tool Material - Substrat	PM8	PM8	PM8
Tolleranza - Thread tolerance - Tolérance du filetage	6HX	6GX	6HX
Trattamento superficiale - Surface treatment - Revêtement	TiN	TiN	TiN

DIN 371	Ød1 MF	P mm	L_1	L_2	d_2 h9	a h12	Z	
◄	8	1	90	18	8	6,2	5	7,55
◄	10	1,25	100	20	10	8	5	9,40

CODE		
P2CCMF8X1T	P3CCMF8X1T	P2CCMF8X1LH-T
P2CCMF10X1,25T	P3CCMF10X1,25T	P2CCMF10X1,25LH-T

DIN 374	Ød1 MF	P mm	L_1	L_2	d_2 h9	a h12	Z	
	12	1,5	100	22	9	7	6	11,30
	14	1,5	100	22	11	9	6	13,30
	16	1,5	100	22	12	9	6	15,30
	18	1,5	110	25	14	11	6	17,30
	20	1,5	125	25	16	12	6	19,30

CODE		
P2CCMF12X1,5T	P3CCMF12X1,5T	P2CCMF12X1,5LH-T
P2CCMF14X1,5T	P3CCMF14X1,5T	P2CCMF14X1,5LH-T
P2CCMF16X1,5T	P3CCMF16X1,5T	P2CCMF16X1,5LH-T
P2CCMF18X1,5T	P3CCMF18X1,5T	-
P2CCMF20X1,5T	P3CCMF20X1,5T	-

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min			
P	Acciaio - Steel - Acier - Rm ≤ 850 N/mm²	•1.1 20-30	•1.2 20-30	•1.3 20-25	•1.4 15-20
M	Acciaio inox - Stainless steel - Acier inoxydable	◦2.1 10-15	◦2.2 10-12	◦2.3 6-10	
N	Leghe di Allumino - Al alloys - Alliage Al	◦4.1 35-40	◦4.2 40-45	◦4.2 35-40	
N	Leghe di rame - Copper alloys - Alliages de cuivre	◦5.1 15-20	◦5.2 15-20		

• Raccomandato - Optimal - Recommandé ◦ Adatto - Suitable - Adaptè

MF

MASCHI A MACCHINA - Per fori ciechi e passanti con canalini di lubrificazione
MACHINE TAPS - For blind and through holes with oil grooves
TARAUDS MACHINE - Pour trous borgnes et débouchant avec rainures de lubrification

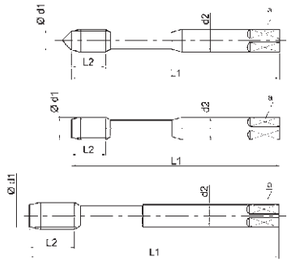
DIN13 | K-ROLL | MASCHI A RULLARE - ROLL FORM TAPS - TARAUDS À REFOULER

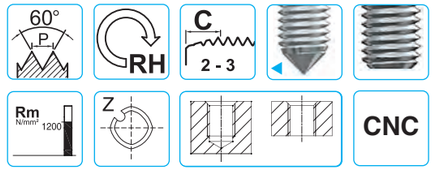
Rm < 1200 Nm/m²

DIN 371 d1 ≤ M5

DIN 371 d1 ≤ M10

DIN 374 d1 ≥ M12





Profondità di filettatura - Thread depth - Prof. de filetage	3xD	3xD	3xD
Materiale - Tool Material - Substrat	PM8	PM8	PM8
Tolleranza - Thread tolerance - Tolérance du filetage	6HX	6HX	6GX
Trattamento superficiale - Surface treatment - Revêtement	TiN-G	AHI	

DIN 371	Ød1 MF	P mm	L_1	L_2	d_2 h9	a h12	Z	
◄	4	0,5	63	7	4,5	3,4	4	3,80
◄	5	0,5	70	8	6	4,9	5	4,80
	6	0,75	80	10	6	4,9	5	5,65
	8	1	90	13	8	6,2	5	7,55
	10	1	90	10	10	8	8	9,55
	10	1,25	100	15	10	8	8	9,40

CODE		
K2CCMF4X0,5TG	K2CCMF4X0,5AHI	K3CCMF4X0,5TG
K2CCMF5X0,5TG	K2CCMF5X0,5AHI	K3CCMF5X0,5TG
K2CCMF6X0,75TG	K2CCMF6X0,75AHI	K3CCMF6X0,75TG
K2CCMF8X1TG	K2CCMF8X1AHI	K3CCMF8X1TG
K2CCMF10X1TG	K2CCMF10X1AHI	K3CCMF10X1TG
K2CCMF10X1,25TG	K2CCMF10X1,25AHI	K3CCMF10X1,25TG

DIN 374	Ød1 MF	P mm	L_1	L_2	d_2 h9	a h12	Z	
	12	1	100	15	9	7	8	11,55
	12	1,25	100	15	9	7	8	11,45
	12	1,5	100	15	9	7	8	11,30
	14	1,25	100	15	11	9	8	13,45
	14	1,5	100	15	11	9	8	13,30
	16	1,5	100	15	12	9	8	15,30
New	18	1,5	110	17	14	11	8	17,30
New	20	1,5	125	17	16	12	8	19,30
New	22	1,5	125	18	18	14,5	8	21,30
New	24	1,5	140	20	18	14,5	8	23,30

CODE		
K2CCMF12X1TG	K2CCMF12X1AHI	K3CCMF12X1TG
K2CCMF12X1,25TG	K2CCMF12X1,25AHI	K3CCMF12X1,25TG
K2CCMF12X1,5TG	K2CCMF12X1,5AHI	K3CCMF12X1,5TG
K2CCMF14X1,25TG	K2CCMF14X1,25AHI	K3CCMF14X1,25TG
K2CCMF14X1,5TG	K2CCMF14X1,5AHI	K3CCMF14X1,5TG
K2CCMF16X1,5TG	K2CCMF16X1,5AHI	K3CCMF16X1,5TG
K2CCMF18X1,5TG	K2CCMF18X1,5AHI	K3CCMF18X1,5TG
K2CCMF20X1,5TG	K2CCMF20X1,5AHI	K3CCMF20X1,5TG
K2CCMF22X1,5TG	K2CCMF22X1,5AHI	K3CCMF22X1,5TG
K2CCMF24X1,5TG	K2CCMF24X1,5AHI	K3CCMF24X1,5TG

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min								
P	Acciaio - Steel - Acier - Rm ≤ 1200 N/mm²	•1.3 35-50	•1.4 25-30	•1.5 15-20	•1.3 35-50	•1.4 25-30	•1.5 15-20	•1.3 35-50	•1.4 25-30	•1.5 15-20
M	Acciaio INOX - Stainless steel - Acier inoxydable	◦2.2 10-12	◦2.3 6-10	◦2.4 6-8	◦2.2 10-12	◦2.3 6-10	◦2.4 6-8	◦2.2 10-12	◦2.3 6-10	◦2.4 6-8

• Raccomandato - Optimal - Recommandé ◦ Adatto - Suitable - Adaptè

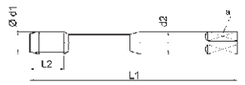
MF

MASCHI A MACCHINA - Per fori ciechi e passanti con canalini di lubrificazione
MACHINE TAPS - For blind and through holes with oil grooves
TARAUDS MACHINE - Pour trous borgnes et débouchant avec rainures de lubrification

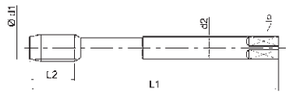
DIN13 | K-ROLL | MASCHI A RULLARE - ROLL FORM TAPS - TARAUDS À REFOULER

Rm < 1200 Nm/mm²

DIN 371 — d1 ≤ M10



DIN 374 — d1 ≥ M12



60° P | RH | C 2 - 3 | CNC | Rm N/mm² 1200 | Z

Profondità di filettatura - Thread depth - Prof. de filetage	3xD	3xD	3xD
Materiale - Tool Material - Substrat	PM8	PM8	PM8
Tolleranza - Thread tolerance - Tolérance du filetage	6HX	6HX	6HX
Trattamento superficiale - Surface treatment - Revêtement	TiN-G	AHI	TiN-G

DIN 371	Ød1 MF	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE		
	8	1	90	13	8	6,2	5	7,55	K2CCMF8X1FOR-TG	K2CCMF8X1FOR-AHI	K2CCMF8X1FORY-TG
	10	1	90	10	10	8	8	9,55	K2CCMF10X1FOR-TG	K2CCMF10X1FOR-AHI	K2CCMF10X1FORY-TG
	10	1,25	100	15	10	8	8	9,45	K2CCMF10X1,25FOR-TG	K2CCMF10X1,25FOR-AHI	K2CCMF10X1,25FORY-TG

DIN 374	Ød1 MF	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE		
	12	1	100	15	9	7	8	11,55	K2CCMF12X1FOR-TG	K2CCMF12X1FOR-AHI	K2CCMF12X1FORY-TG
	12	1,25	100	15	9	7	8	11,45	K2CCMF12X1,25FOR-TG	K2CCMF12X1,25FOR-AHI	K2CCMF12X1,25FORY-TG
	12	1,5	100	15	9	7	8	11,30	K2CCMF12X1,5FOR-TG	K2CCMF12X1,5FOR-AHI	K2CCMF12X1,5FORY-TG
	14	1,5	100	15	11	9	8	13,30	K2CCMF14X1,5FOR-TG	K2CCMF14X1,5FOR-AHI	K2CCMF14X1,5FORY-TG
	16	1,5	100	15	12	9	8	15,30	K2CCMF16X1,5FOR-TG	K2CCMF16X1,5FOR-AHI	K2CCMF16X1,5FORY-TG
New	18	1,5	110	17	14	11	8	17,30	K2CCMF18X1,5FOR-TG	K2CCMF18X1,5FOR-AHI	K2CCMF18X1,5FORY-TG
New	20	1,5	125	17	16	12	8	19,30	K2CCMF20X1,5FOR-TG	K2CCMF20X1,5FOR-AHI	K2CCMF20X1,5FORY-TG
New	22	1,5	125	18	18	14,5	8	21,30	K2CCMF22X1,5FOR-TG	K2CCMF22X1,5FOR-AHI	K2CCMF22X1,5FORY-TG
New	24	1,5	140	20	18	14,5	8	23,30	K2CCMF24X1,5FOR-TG	K2CCMF24X1,5FOR-AHI	K2CCMF24X1,5FORY-TG

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min								
P	Acciaio - Steel - Acier - Rm ≤ 1200 N/mm²	•1.3 35-50	•1.4 25-30	•1.5 15-20	•1.3 35-50	•1.4 25-30	•1.5 15-20	•1.3 35-50	•1.4 25-30	•1.5 15-20
M	Acciaio INOX - Stainless steel - Acier inoxydable	❍2.2 10-12	❍2.3 6-10	❍2.4 6-8	❍2.2 10-12	❍2.3 6-10	❍2.4 6-8	❍2.2 10-12	❍2.3 6-10	❍2.4 6-8

• Raccomandato - Optimal - Recommandé ❍ Adatto - Suitable - Adaptè

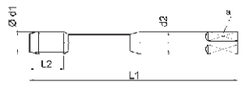
MF

MASCHI A MACCHINA - Per fori ciechi con canalini di lubrificazione
MACHINE TAPS - For blind holes with oil grooves
TARAUDS MACHINE - Pour trous borgnes avec rainures de lubrification

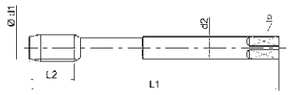
DIN13 | K-ROLL | MASCHI A RULLARE - ROLL FORM TAPS - TARAUDS À REFOULER

Rm < 1200 Nm/mm²

DIN 371 — d1 ≤ M10



DIN 374 — d1 ≥ M12



60° P | RH | E 1,5 - 2 | CNC | Rm N/mm² 1200 | Z

Profondità di filettatura - Thread depth - Prof. de filetage	3xD	3xD
Materiale - Tool Material - Substrat	PM8	PM8
Tolleranza - Thread tolerance - Tolérance du filetage	6HX	6HX
Trattamento superficiale - Surface treatment - Revêtement	TiN-G	TiN-G

DIN 371	Ød1 MF	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE	
	8	1	90	13	8	6,2	5	7,55	K2CCEMF8X1TG	K2CCEMF8X1FOR-TG
	10	1	90	10	10	8	8	9,55	K2CCEMF10X1TG	K2CCEMF10X1FOR-TG
	10	1,25	100	15	10	8	8	9,45	K2CCEMF10X1,25TG	K2CCEMF10X1,25FOR-TG

DIN 374	Ød1 MF	P mm	L_1	L_2	d_2 h9	a h12	Z		CODE	
	12	1	100	15	9	7	8	11,55	K2CCEMF12X1TG	K2CCEMF12X1FOR-TG
	12	1,25	100	15	9	7	8	11,45	K2CCEMF12X1,25TG	K2CCEMF12X1,25FOR-TG
	12	1,5	100	15	9	7	8	11,30	K2CCEMF12X1,5TG	K2CCEMF12X1,5FOR-TG
	14	1,5	100	15	11	9	8	13,30	K2CCEMF14X1,5TG	K2CCEMF14X1,5FOR-TG
	16	1,5	100	15	12	9	8	15,30	K2CCEMF16X1,5TG	K2CCEMF16X1,5FOR-TG

ISO	Campo di impiego Application range Gamme d'application	Gruppo di materiali - Velocità di taglio m/min Material groups - Cutting speed m/min Groupes de matières - Vitesse de coupe m/min								
P	Acciaio - Steel - Acier - Rm ≤ 1200 N/mm²	•1.3 30-35	•1.4 25-30	•1.5 15-20	•1.3 30-35	•1.4 25-30	•1.5 15-20			
M	Acciaio INOX - Stainless steel - Acier inoxydable	❍2.2 10-12	❍2.3 6-10	❍2.4 6-8	❍2.2 10-12	❍2.3 6-10	❍2.4 6-8			

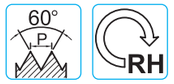
• Raccomandato - Optimal - Recommandé ❍ Adatto - Suitable - Adaptè

MF

Calibri a tampone filettati Passa / Non passa
Thread plug gauges Go / No-Go
Tampon de filetage Entre / N'entre pas

DIN13

DIN ISO 1502



Tolleranza - Thread tolerance - Tolérance du filetage	**6H**
Trattamento superficiale - Surface treatment - Revêtement	

Ød1 MF	P mm	CODE
4	**0,5**	P-NPMF4X0,5
5	**0,5**	P-NPMF5X0,5
6	**0,75**	P-NPMF6X0,75
7	**0,75**	P-NPMF7X0,75
8	**0,75**	P-NPMF8X0,75
8	**1**	P-NPMF8X1
9	**1**	P-NPMF9X1
10	**0,75**	P-NPMF10X0,75
10	**1**	P-NPMF10X1
10	**1,25**	P-NPMF10X1,25
12	**1**	P-NPMF12X1
12	**1,25**	P-NPMF12X1,25
12	**1,5**	P-NPMF12X1,5
14	**1**	P-NPMF14X1
14	**1,25**	P-NPMF14X1,25
14	**1,5**	P-NPMF14X1,5
16	**1**	P-NPMF16X1
16	**1,5**	P-NPMF16X1,5
18	**1**	P-NPMF18X1
18	**1,5**	P-NPMF18X1,5
18	**2**	P-NPMF18X2
20	**1**	P-NPMF20X1
20	**1,5**	P-NPMF20X1,5
20	**2**	P-NPMF20X2
22	**1**	P-NPMF22X1
22	**1,5**	P-NPMF22X1,5
24	**1**	P-NPMF24X1
24	**1,5**	P-NPMF24X1,5
24	**2**	P-NPMF24X2
25	**1**	P-NPMF25X1
25	**1,5**	P-NPMF25X1,5
25	**2**	P-NPMF25X2
26	**1,5**	P-NPMF26X1,5
26	**2**	P-NPMF26X2

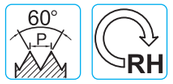
Segue diametri / Diameters continue / Diamètres à suivre >

MF

Calibri a tampone filettati Passa / Non passa
Thread plug gauges Go / No-Go
Tampon de filetage Entre / N'entre pas

DIN13

DIN ISO 1502



Tolleranza - Thread tolerance - Tolérance du filetage	**6H**
Trattamento superficiale - Surface treatment - Revêtement	

Ød1 MF	P mm	CODE
27	**1**	P-NPMF27X1
27	**1,5**	P-NPMF27X1,5
28	**1,5**	P-NPMF28X1,5
28	**2**	P-NPMF28X2
30	**1**	P-NPMF30X1
30	**1,5**	P-NPMF30X1,5
30	**2**	P-NPMF30X2
32	**1**	P-NPMF32X1
32	**1,5**	P-NPMF32X1,5
32	**2**	P-NPMF32X2
33	**2**	P-NPMF33X2
35	**1,5**	P-NPMF35X1,5
35	**2**	P-NPMF35X2
36	**1,5**	P-NPMF36X1,5
36	**2**	P-NPMF36X2
36	**3**	P-NPMF36X3
38	**1,5**	P-NPMF38X1,5
39	**2**	P-NPMF39X2
40	**1,5**	P-NPMF40X1,5
40	**2**	P-NPMF40X2
40	**3**	P-NPMF40X3
42	**1,5**	P-NPMF42X1,5
42	**2**	P-NPMF42X2
42	**3**	P-NPMF42X3
45	**1,5**	P-NPMF45X1,5
45	**2**	P-NPMF45X2
45	**3**	P-NPMF45X3
48	**1,5**	P-NPMF48X1,5
48	**2**	P-NPMF48X2
48	**3**	P-NPMF48X3
50	**1,5**	P-NPMF50X1,5
50	**2**	P-NPMF50X2
50	**3**	P-NPMF50X3

FILETTATURA AMERICANA UN
AMERICAN UNIFIED THREAD UN - FILETAGE AMÉRICAIN UN

Ø	PASSO - PITCH																					
	8	9	10	11	12	13	14	16	18	20	24	27	28	32	36	40	44	48	56	60	64	72	80
0																							UNF
1																					UNC	UNF	
2																			UNC		UNF		
3																		UNC	UNF				
4																UNC		UNF					
5																UNC	UNF						
6														UNC		UNF							
9/64																							
8														UNC	UNF								
11/64																							
10											UNC			UNF		UNS		UNS	UNS				
12											UNC		UNF	UNEF	UNS								
15/64																							
1/4										UNC	UNS		UNF	UNEF	UNS	UNS			UNS				
9/32																							
5/16									UNC		UNF			UNEF		UNS							
3/8								UNC	UNS	UN20	UNF	UNS	UN28	UNEF		UNS							
7/16							UNC			UNF	UNS	UNS	UNEF	UN32									
1/2						UNC				UNF	UNS	UNS	UNEF	UN32									
9/16					UNC				UNF		UNEF												
5/8				UNC				UN16	UNF	UN20	UNEF	UNS	UN28										
11/16								UN16	UNS		UNEF												
3/4			UNC					UNF	UNS	UNEF		UNS	UN28										
13/16								UN16		UNEF													
7/8		UNC			UN12		UNF	UN16	UNS	UNEF	UNS												
15/16								UN16	UNS														
1	UNC				UNF		UNS	UN16	UNS	UNEF	UNS			UN32									
1-1/16					UN12			UN16	UNEF	UN20													
1-1/8	UN8				UNF			UN16	UNEF	UN20													
1-3/16	UN8				UN12			UN16	UNEF														
1-1/4	UN8				UNF		UNS	UN16	UNEF	UN20													
1-5/16					UN12		UNS	UN16															
1-3/8	UN8				UNF				UNEF	UN20													
1-7/16					UN12				UNEF														
1-1/2	UN8				UNF			UN16	UNEF														
1-9/16																							
1-5/8	UN8				UN12																		
1-11/16																							
1-3/4	UN8				UN12																		
1-13/16																							
1-7/8	UN8				UN12					UN20													
1-15/16																							
2	UN8				UN12			UN16															
2-1/8																							
2-1/4	UN8																						
2-3/8																							
2-1/2	UN8				UN12																		
2-3/4																							
2-7/8	UN8																						
3	UN8																						

HR ALTA RESISTENZA - HIGH RESISTANCE - HAUTE RÉSISTANCE