Il grande fiume

The great river

Il grande fiume è il terminale di una rete nella quale sono convogliati tutti i "messaggi" che provengono dal territorio. Dalle Alpi, dalle colline, dalla pianura, il Po può rappresentare la colonna vertebrale del Piemonte manifestandosi come eccellenza.

Il sogno di riportare il Fiume Po e i terreni che lo fiancheggiano al loro ruolo originario è nato tanti anni fa nelle stanze della Regione Piemonte. Fin da allora era chiaro che un fiume in condizioni ottimali avrebbe rappresentato un vantaggio e si è cominciato a parlare di servizi ecosistemici, intesi come "benefici multipli forniti dagli ecosistemi al genere umano".
Il mantenimento della biodiversità, l'autodepurazione delle acque, la ricarica delle falde, il trasporto dei sedimenti, la mitigazione dei rischi alluvionali, la modellazione del paesaggio. La Regione Piemonte è l'unica ad aver tutelato il Fiume Po nel suo insieme ed è la sola ad aver dato una pianificazione all'intero suo tratto.
Negli anni '90 fu istituito un sistema di aree protette fatto di pezzi, di parti, di riserve naturali, collegati tra loro da una zona di salvaguardia avente funzione di raccordo. Nel 2021 è nato il Parco naturale del Po piemontese, asse portante delle Aree protette del Po piemontese; raduna tutte le attuali riserve naturali presenti lungo il corso del fiume Po, con significativi ampliamenti della superficie tutelata e si estende per circa 200 km.

La sorgente del Po si trova sulle Alpi Cozie, in Piemonte, nella provincia di Cuneo e precisamente in località Pian del Re, a 2020 mt di quota, nel comune di Crissolo, alle pendici del Monviso. Grazie all'apporto di molte altre sorgenti, il fiume prende a scorrere nella valle che da esso prende il nome di Valle Po e dopo appena una ventina di chilometri, sbocca nella pianura padana. In questo tratto vari affluenti arricchiscono la portata del fiume il quale entra poi nella provincia di Torino, attraversandone il capoluogo a solo un centinaio di chilometri dalla sorgente, presentandosi con un letto ampio 200 metri. All'interno della città di Torino vi confluiscono il Sangone, la Dora Riparia e la Stura di Lanzo.
Oltre Torino, con andamento verso est costeggia le estreme propaggini del Monferrato giungendo nella piana Vercellese dove si arricchisce dell'apporto di importanti affluenti come la Dora Baltea e il Sesia. Piegando con corso verso sud, continua poi a lambire in sponda destra il Monferrato in provincia di Alessandria, bagnando le città di Casale Monferrato e Valenza. Presso Bassignana, il fiume punta definitivamente verso est anche per merito della forte spinta del Tanaro, suo principale tributario di destra. Dopo questa confluenza il Grande Fiume, ormai possente, entra in territorio lombardo scorrendo in provincia di Pavia.

The great river is the culmination of a network that brings "messages" from all over the region.
From the Alps, from the hills and from the plain, the Po represents the spine of Piedmont and one of its glories.

The dream of returning the Po and the land surrounding it to their original role was born many years ago in the offices of the regional government. From the outset it was clear that a river in optimum condition would be advantageous, and people began talking about ecosystemic services, defined as "multiple benefits provided by ecosystems to humans".
The preservation of biodiversity, the self-purification of water, the replenishment of the water table, the transport of sediments, the mitigation of flood risk, the shaping of the landscape. The Piedmont Region is the only regional government to protect the Po as a whole, and the only one to draw up plans covering its entire length.
The 90s saw the establishment of a series of protected areas, consisting of sections and nature reserves joined by a conservation zone that functions as a connector. In 2021 the Parco Naturale del Po Piemontese came into being as an essential axis for the protected areas of the Po in Piedmont; it brings together all the existing nature reserves of the Po, with a considerable increase in the protected area. An environmental corridor extending for some 200 km.

The source of the Po is in the Cottian Alps in Piedmont; to be exact, the river rises at 2,020 metres above sea level in Pian del Re in the municipality of Crissolo, on the slopes of Monviso. With the contributions of many other springs, the river runs down the valley that takes its name, and just twenty or so kilometres later, emerges onto the Padan Plain. Here the river is joined by several tributaries before entering the province of Turin, traversing the city just a hundred kilometres from its source in a bed 200 metres wide. Three rivers flow into the Po in Turin: the Sangone, the Dora Riparia and the Stura di Lanzo.
Moving east from the city, the river flanks the edge of the Monferrato area, reaching the Vercelli Plain, where it is joined by large tributaries like the Dora Baltea and the Sesia. Turning south, it continues to brush the right edge of Monferrato in the province of Alessandria, bathing the towns of Casale Monferrato and Valenza. Reaching Bassignana, the river turns definitively to the east, partly due to the strong impetus of the Tanaro, the main tributary on its right bank. After this confluence, the Po - now a powerful river - enters Lombardy and the province of Pavia.

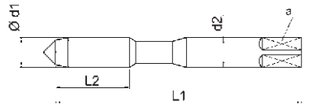
Sponde del Po, passeggiata Murazzi, Torino
Banks of the Po river near the Murazzi waterfront, Turin

UNC

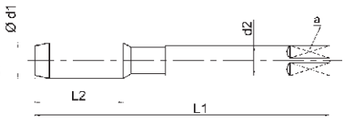
MASCHI A MANO - Per fori ciechi e passanti in serie di tre pezzi
HAND TAPS - For blind and through holes in sets of three pieces
TARAUDS À MAIN - Pour trous borgnes et débouchant en jeux de trois pièces

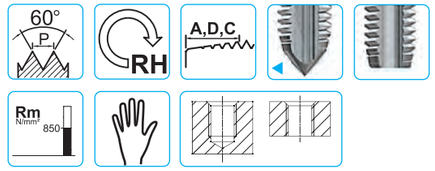
ASME B1.1 | USO GENERALE - GENERAL PURPOSE - USAGE GÉNÉRAL

DIN 2184-2 d1 ≤ 1/4



DIN 2184-2 d1 ≥ 5/16





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

	Ød1 UNC	P TPI	Ø mm	L_1	L_2	d_2 h9	a h12	Z		Finitore Bottoming - Finisseur	Serie Set - Jeu
◀	**6**	**32**	3,505	45	10	4	3	3	2,85	03UNC6-32	00UNC6-32
◀	**8**	**32**	4,166	45	11	4,5	3,4	3	3,5	03UNC8-32	00UNC8-32
◀	**10**	**24**	4,826	50	13	6	4,9	3	3,9	03UNC10-24	00UNC10-24
◀	**12**	**24**	5,486	56	15	6	4,9	3	4,5	03UNC12-24	00UNC12-24
◀	**1/4**	**20**	6,350	56	16	6	4,9	3	5,1	03UNC1/4	00UNC1/4
	5/16	**18**	7,938	63	19	6	4,9	3	6,6	03UNC5/16	00UNC5/16
	3/8	**16**	9,525	70	22	7	5,5	3	8	03UNC3/8	00UNC3/8
	7/16	**14**	11,113	70	22	8	6,2	3	9,4	03UNC7/16	00UNC7/16
	1/2	**13**	12,700	75	28	9	7	3	10,8	03UNC1/2	00UNC1/2
	9/16	**12**	14,288	80	30	11	9	4	12,2	03UNC9/16	00UNC9/16
	5/8	**11**	15,875	80	30	12	9	4	13,5	03UNC5/8	00UNC5/8
	3/4	**10**	19,050	95	34	14	11	4	16,5	03UNC3/4	00UNC3/4
	7/8	**9**	22,225	100	34	18	14,5	4	19,5	03UNC7/8	00UNC7/8
	1"	**8**	25,400	110	38	18	14,5	4	22,25	03UNC1"	00UNC1"
	1"1/8	**7**	28,575	125	45	22	18	4	25	03UNC1"1/8	00UNC1"1/8
	1"1/4	**7**	31,750	125	45	22	18	4	28	03UNC1"1/4	00UNC1"1/4

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		
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			

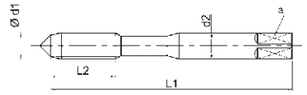
• Raccomandato - Optimal - Recommandé ❍ Adatto - Suitable - Adaptè

UNC

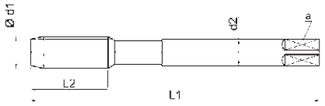
MASCHI A MACCHINA - Scanalature diritte per fori ciechi e passanti
MACHINE TAPS - Straight flutes for blind and through holes
TARAUDS MACHINE - Goujures droites pour trous borgnes et débouchant

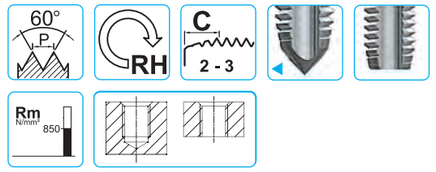
ASME B1.1 | USO GENERALE - GENERAL PURPOSE - USAGE GÉNÉRAL

DIN 2184-1 d1 ≤ 1/4



DIN 2184-1 d1 ≥ 5/16





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

	Ød1 UNC	P TPI	Ø mm	L_1	L_2	d_2 h9	a h12	Z		CODE
◀	**6**	**32**	3,505	45	10	4	3	3	2,85	E20UNC6-32
◀	**8**	**32**	4,166	45	11	4,5	3,4	3	3,5	E20UNC8-32
◀	**10**	**24**	4,826	50	13	6	4,9	3	3,9	E20UNC10-24
◀	**12**	**24**	5,486	56	15	6	4,9	3	4,5	E20UNC12-24
◀	**1/4**	**20**	6,350	56	16	6	4,9	3	5,1	E20UNC1/4

Ød1 UNC	P TPI	Ø mm	L_1	L_2	d_2 h9	a h12	Z		CODE
5/16	**18**	7,938	90	18	6	4,9	3	6,6	E21UNC5/16SP
3/8	**16**	9,525	100	20	7	5,5	3	8	E21UNC3/8SP
7/16	**14**	11,113	100	20	8	6,2	3	9,4	E21UNC7/16
1/2	**13**	12,700	110	25	9	7	3	10,8	E21UNC1/2
9/16	**12**	14,288	110	28	11	9	3	12,2	E21UNC9/16
5/8	**11**	15,875	110	28	12	9	3	13,5	E21UNC5/8
3/4	**10**	19,050	125	32	14	11	4	16,5	E21UNC3/4
7/8	**9**	22,225	140	32	18	14,5	4	19,5	E21UNC7/8
1"	**8**	25,400	160	36	18	14,5	4	22,25	E21UNC1"
1"1/8	**7**	28,575	180	46	22	18	4	25	E21UNC1"1/8
1"1/4	**7**	31,750	180	46	22	18	4	28	E21UNC1"1/4
1"3/8	**6**	34,925	200	50	28	22	4	30,75	E21UNC1"3/8
1"1/2	**6**	38,100	200	50	28	22	4	34	E21UNC1"1/2

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			

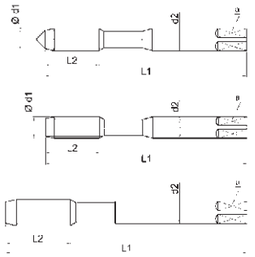
• Raccomandato - Optimal - Recommandé ❍ Adatto - Suitable - Adaptè

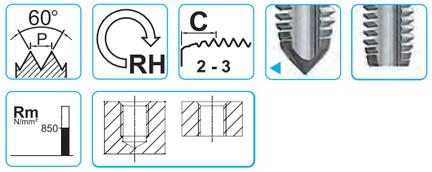
UNC

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

ASME B1.1 | GG | GHISA - CAST IRON - FONTE

DIN 2184-1 d1 ≤ 1/4
DIN 2184-1 *d1 =1/4
DIN 2184-1 d1 ≥ 5/16





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

	Ød1 UNC	P TPI	Ø mm	L_1	L_2	d_2 h9	a h12	Z		CODE	
◀	6	32	3,505	56	11	4	3	3	2,85	E26UNC6-32CT	-
◀	8	32	4,166	63	13	4,5	3,4	3	3,5	E26UNC8-32CT	-
◀	10	24	4,826	70	13	6	4,9	3	3,9	E26UNC10-24CT	-
◀	1/4	20	6,350	80	16	7	5,5	3	5,1	E26UNC1/4CT	-
*	1/4	20	6,350	80	16	7	5,5	3	5,1	E26UNC1/4SP-CT	E26UNC1/4FOR-CT

	Ød1 UNC	P TPI	Ø mm	L_1	L_2	d_2 h9	a h12	Z		CODE	
	5/16	18	7,938	90	18	6	4,9	4	6,6	E27UNC5/16SP-CT	E27UNC5/16FOR-CT
	3/8	16	9,525	100	20	7	5,5	4	8	E27UNC3/8SP-CT	E27UNC3/8FOR-CT
	7/16	14	11,113	100	20	8	6,2	4	9,4	E27UNC7/16CT	E27UNC7/16FOR-CT
	1/2	13	12,700	110	25	9	7	4	10,8	E27UNC1/2CT	E27UNC1/2FOR-CT
	5/8	11	15,875	110	28	12	9	4	13,5	E27UNC5/8CT	E27UNC5/8FOR-CT
	3/4	10	19,050	125	32	14	11	4	16,5	E27UNC3/4CT	E27UNC3/4FOR-CT
	1"	8	25,400	160	36	18	14,5	4	22,25	E27UNC1"CT	E27UNC1"FOR-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 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 25-30							
N	Leghe di magnesio Magnesium alloys - Alliages de magnésium	•4.5 20-30							
N	Leghe di rame - Copper alloys - Alliages de cuivre	•5.3 25-30							
N	Materiali termoindurenti Duroplastic - Thermodurcissables	•8.2 10-15							

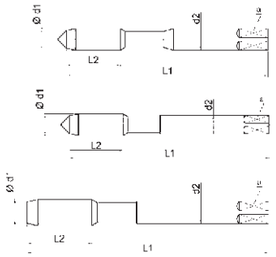
• Raccomandato - Optimal - Recommandé ◦ Adatto - Suitable - Adaptè

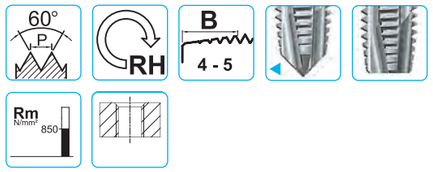
UNC

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

ASME B1.1 | USO GENERALE - GENERAL PURPOSE - USAGE GÉNÉRAL

DIN 2184-1 d1 ≤ 1/4
DIN 2184-1 d1 ≤ 3/8
DIN 2184-1 d1 ≥ 7/16





Profondità di filettatura - Thread depth - Prof. de filetage	3xD	3xD	3xD
Materiale - Tool Material - Substrat	HSSE	HSSE	HSSE
Tolleranza - Thread tolerance - Tolérance du filetage	2B	2B	2B
Trattamento superficiale - Surface treatment - Revêtement		V	TiN

	Ød1 UNC	P TPI	Ø mm	L_1	L_2	d_2 h9	a h12	Z		CODE		
◀	4	40	2,845	56	10	3,5	2,7	2	2,35	E24UNC4-40	E24UNC4-40V	E24UNC4-40T
◀	5	40	3,175	56	10	3,5	2,7	3	2,65	E24UNC5-40	E24UNC5-40V	E24UNC5-40T
◀	6	32	3,505	56	11	4	3	3	2,85	E24UNC6-32	E24UNC6-32V	E24UNC6-32T
◀	8	32	4,166	63	13	4,5	3,4	3	3,5	E24UNC8-32	E24UNC8-32V	E24UNC8-32T
◀	10	24	4,826	70	13	6	4,9	3	3,9	E24UNC10-24	E24UNC10-24V	E24UNC10-24T
◀	12	24	5,486	80	16	6	4,9	3	4,5	E24UNC12-24	E24UNC12-24V	E24UNC12-24T
◀	1/4	20	6,350	80	16	7	5,5	3	5,1	E24UNC1/4	E24UNC1/4V	E24UNC1/4T

	Ød1 UNC	P TPI	Ø mm	L_1	L_2	d_2 h9	a h12	Z		CODE		
◀	5/16	18	7,938	90	18	6	4,9	3	6,6	E25UNC5/16	E25UNC5/16V	E25UNC5/16T
◀	3/8	16	9,525	100	20	7	5,5	3	8	E25UNC3/8	E25UNC3/8V	E25UNC3/8T
	7/16	14	11,113	100	20	8	6,2	3	9,4	E25UNC7/16	E25UNC7/16V	E25UNC7/16T
	1/2	13	12,700	110	25	9	7	3	10,8	E25UNC1/2	E25UNC1/2V	E25UNC1/2T
	9/16	12	14,288	110	28	11	9	3	12,2	E25UNC9/16	E25UNC9/16V	E25UNC9/16T
	5/8	11	15,875	110	28	12	9	3	13,5	E25UNC5/8	E25UNC5/8V	E25UNC5/8T
	3/4	10	19,050	125	32	14	11	4	16,5	E25UNC3/4	E25UNC3/4V	E25UNC3/4T
	7/8	9	22,225	140	32	18	14,5	4	19,5	E25UNC7/8	E25UNC7/8V	E25UNC7/8T
	1"	8	25,400	160	36	18	14,5	4	22,25	E25UNC1"	E25UNC1"V	E25UNC1"T
	1"1/8	7	28,575	180	46	22	18	4	25	E25UNC1"1/8	E25UNC1"1/8V	-
	1"1/4	7	31,750	180	46	22	18	4	28	E25UNC1"1/4	E25UNC1"1/4V	-
	1"3/8	6	34,925	200	50	28	22	4	30,75	E25UNC1"3/8	E25UNC1"3/8V	-
	1"1/2	6	38,100	200	50	28	22	4	34	E25UNC1"1/2	E25UNC1"1/2V	-

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	

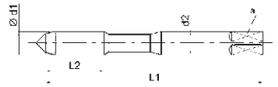
• Raccomandato - Optimal - Recommandé ◦ Adatto - Suitable - Adaptè

UNC

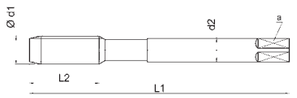
MASCHI A MACCHINA - Imbocco corretto per fori passanti
MACHINE TAPS - Straight flutes with spiral point for through holes
TARAUDS MACHINE - Goujures droites, entrée gun, pour trous débouchant

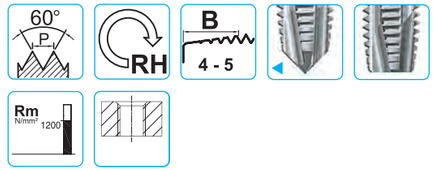
ASME B1.1 | U | APPLICAZIONI UNIVERSALI - UNIVERSAL APPLICATIONS - USINAGE UNIVERSELS

DIN 2184-1 d1 ≤ 3/8



DIN 2184-1 d1 ≥ 7/16





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	2BX	2BX		2B
Trattamento superficiale - Surface treatment - Revêtement	XP	XP		TiN-G

	Ød1 UNC	P TPI	Ø mm	L_1	L_2	d_2 h9	a h12	Z		CODE			
◀	4	40	2,845	56	10	3,5	2,7	2	2,35	K24UNC4-40XP	-		-
◀	5	40	3,175	56	10	3,5	2,7	3	2,65	K24UNC5-40XP	-		-
◀	6	32	3,505	56	11	4	3	3	2,85	K24UNC6-32XP	-		P24UNC6-32TG
◀	8	32	4,166	63	13	4,5	3,4	3	3,5	K24UNC8-32XP	-		P24UNC8-32TG
◀	10	24	4,826	70	13	6	4,9	3	3,9	K24UNC10-24XP	-		P24UNC10-24TG
◀	1/4	20	6,350	80	16	7	5,5	3	5,1	K24UNC1/4XP	K24UNC1/4FORY-XP		P24UNC1/4TG
◀	5/16	18	7,938	90	18	8	6,2	3	6,6	K24UNC5/16XP	K24UNC5/16FORY-XP		P24UNC5/16TG
◀	3/8	16	9,525	100	20	10	8	3	8	K24UNC3/8XP	K24UNC3/8FORY-XP		P24UNC3/8TG

	Ød1 UNC	P TPI	Ø mm	L_1	L_2	d_2 h9	a h12	Z		CODE			
	7/16	14	11,113	100	20	8	6,2	3	9,4	K25UNC7/16XP	K25UNC7/16FORY-XP		
	1/2	13	12,700	110	25	9	7	4	10,8	K25UNC1/2XP	K25UNC1/2FORY-XP		
	9/16	12	14,288	110	28	11	9	4	12,2	K25UNC9/16XP	-		
	5/8	11	15,875	110	28	12	9	4	13,5	K25UNC5/8XP	-		
	3/4	10	19,050	125	32	14	11	4	16,5	K25UNC3/4XP	-		
	7/8	9	22,225	140	32	18	14,5	4	19,5	K25UNC7/8XP	-		
	1"	8	25,400	160	36	18	14,5	4	22,25	K25UNC1"XP	-		
	7/16	14	11,113	100	20	8	6,2	3	9,4	-	-		P25UNC7/16TG
	1/2	13	12,700	110	25	9	7	3	10,8	-	-		P25UNC1/2TG
	9/16	12	14,288	110	28	11	9	3	12,2	-	-		P25UNC9/16TG
	5/8	11	15,875	110	28	12	9	3	13,5	-	-		P25UNC5/8TG
	3/4	10	19,050	125	32	14	11	4	16,5	-	-		P25UNC3/4TG

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			

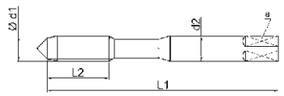
• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

UNC

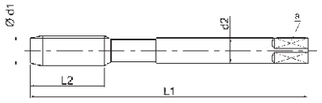
MASCHI A MACCHINA - Imbocco corretto per fori passanti
MACHINE TAPS - Straight flutes with spiral point for through holes
TARAUDS MACHINE - Goujures droites, entrée gun, pour trous débouchant

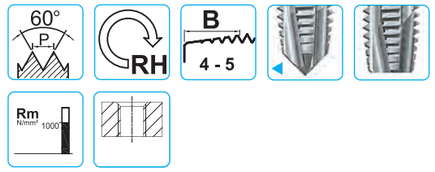
ASME B1.1 | INOX | ACCIAIO INOSSIDABILE - STAINLESS STEEL - ACIER INOXYDABLE

DIN 2184-1 d1 ≤ 3/8



DIN 2184-1 d1 ≥ 7/16





Profondità di filettatura - Thread depth - Prof. de filetage	3xD			
Materiale - Tool Material - Substrat	HSSV3			
Tolleranza - Thread tolerance - Tolérance du filetage	2BX			
Trattamento superficiale - Surface treatment - Revêtement	TXC			

	Ød1 UNC	P TPI	Ø mm	L_1	L_2	d_2 h9	a h12	Z		CODE
◀	6	32	3,505	56	11	4	3	3	2,85	V24UNC6-32TXC
◀	8	32	4,166	63	13	4,5	3,4	3	3,5	V24UNC8-32TXC
◀	10	24	4,826	70	13	6	4,9	3	3,9	V24UNC10-24TXC
◀	1/4	20	6,350	80	16	7	5,5	3	5,1	V24UNC1/4TXC
◀	5/16	18	7,938	90	18	8	6,2	3	6,6	V24UNC5/16TXC
◀	3/8	16	9,525	100	20	10	8	3	8	V24UNC3/8TXC

	Ød1 UNC	P TPI	Ø mm	L_1	L_2	d_2 h9	a h12	Z		CODE
	7/16	14	11,113	100	20	8	6,2	3	9,4	V25UNC7/16TXC
	1/2	13	12,700	110	25	9	7	4	10,8	V25UNC1/2TXC
	9/16	12	14,288	110	28	11	9	4	12,2	V25UNC9/16TXC
	5/8	11	15,875	110	28	12	9	4	13,5	V25UNC5/8TXC
	3/4	10	19,050	125	32	14	11	4	16,5	V25UNC3/4TXC
	7/8	9	22,225	140	32	18	14,5	4	19,5	V25UNC7/8TXC
	1"	8	25,400	160	36	18	14,5	4	22,25	V25UNC1"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	•1.3 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	○2.4 3-6	

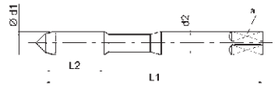
• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

UNC

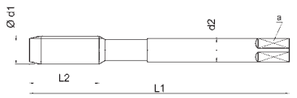
MASCHI A MACCHINA - Elica 15° sinistra per fori passanti
MACHINE TAPS - Left-hand spiral flutes 15° for through holes
TARAUDS MACHINE - Goujures 15° hélicoïdales à gauche pour trous débouchant

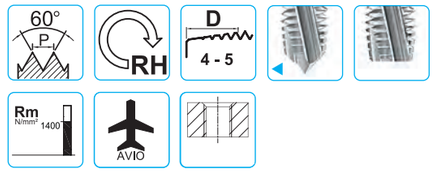
ASME B1.1 | Ti | TITANIO - TITANIUM - TITANE

DIN 2184-1 d1 ≤ 3/8



DIN 2184-1 d1 ≥ 7/16





Profondità di filettatura - Thread depth - Prof. de filetage	3xD	3xD		
Materiale - Tool Material - Substrat	PM3	PM3		
Tolleranza - Thread tolerance - Tolérance du filetage	2BX	3B		
Trattamento superficiale - Surface treatment - Revêtement	TiCN	TiCN		

	Ød1 UNC	P TPI	Ø mm	L_1	L_2	d_2 h9	a h12	Z		CODE	
◀	6	32	3,505	56	11	4	3	3	*2,85	K52UNC6-32CT	K52UNJC6-32CT
◀	8	32	4,166	63	13	4,5	3,4	3	*3,5	K52UNC8-32CT	K52UNJC8-32CT
◀	10	24	4,826	70	13	6	4,9	3	*3,9	K52UNC10-24CT	K52UNJC10-24CT
◀	1/4	20	6,350	80	16	7	5,5	3	*5,1	K52UNC1/4CT	K52UNJC1/4CT
◀	5/16	18	7,938	90	18	8	6,2	3	*6,6	K52UNC5/16CT	-
◀	3/8	16	9,525	100	20	10	8	3	*8	K52UNC3/8CT	-

	Ød1 UNC	P TPI	Ø mm	L_1	L_2	d_2 h9	a h12	Z		CODE
	7/16	14	11,113	100	20	8	6,2	3	*9,4	K53UNC7/16CT
	1/2	13	12,700	110	25	9	7	3	*10,8	K53UNC1/2CT

* Diametri di preforo UNJC a pag: 271 - Bore hole for thread UNJC to page: 271 - Pour UNJC voir le tableau de perçage page: 271

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		

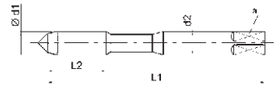
• Raccomandato - Optimal - Recommandé ◦ Adatto - Suitable - Adaptè

UNC

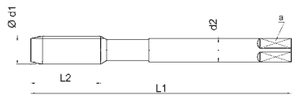
MASCHI A MACCHINA - Elica destra a 15° per fori ciechi
MACHINE TAPS - Spiral flutes 15° for blind holes
TARAUDS MACHINE - Goujures hélicoïdales 15° pour trous borgnes

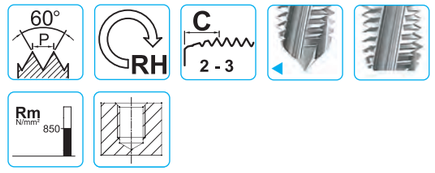
ASME B1.1 | USO GENERALE - GENERAL PURPOSE - USAGE GÉNÉRAL

DIN 2184-1 d1 ≤ 1/4



DIN 2184-1 d1 ≥ 5/16





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

	Ød1 UNC	P TPI	Ø mm	L_1	L_2	d_2 h9	a h12	Z		CODE	
◀	6	32	3,505	56	11	4	3	3	2,85	E40UNC6-32	E40UNC6-32T
◀	8	32	4,166	63	13	4,5	3,4	3	3,5	E40UNC8-32	E40UNC8-32T
◀	10	24	4,826	70	13	6	4,9	3	3,9	E40UNC10-24	E40UNC10-24T
◀	12	24	5,486	80	16	6	4,9	3	4,5	E40UNC12-24	E40UNC12-24T
◀	1/4	20	6,350	80	16	7	5,5	3	5,1	E40UNC1/4	E40UNC1/4T

	Ød1 UNC	P TPI	Ø mm	L_1	L_2	d_2 h9	a h12	Z		CODE	
	5/16	18	7,938	90	18	6	4,9	3	6,6	E41UNC5/16SP	E41UNC5/16SP-T
	3/8	16	9,525	100	20	7	5,5	3	8	E41UNC3/8SP	E41UNC3/8SP-T
	7/16	14	11,113	100	20	8	6,2	3	9,4	E41UNC7/16	E41UNC7/16T
	1/2	13	12,700	110	25	9	7	3	10,8	E41UNC1/2	E41UNC1/2T
	9/16	12	14,288	110	28	11	9	3	12,2	E41UNC9/16	E41UNC9/16T
	5/8	11	15,875	110	28	12	9	3	13,5	E41UNC5/8	E41UNC5/8T
	3/4	10	19,050	125	32	14	11	4	16,5	E41UNC3/4	E41UNC3/4T
	7/8	9	22,225	140	32	18	14,5	4	19,5	E41UNC7/8	E41UNC7/8T
	1"	8	25,400	160	36	18	14,5	4	22,25	E41UNC1"	E41UNC1"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		

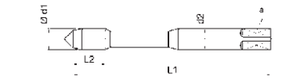
• Raccomandato - Optimal - Recommandé ◦ Adatto - Suitable - Adaptè

UNC

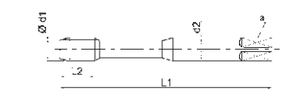
MASCHI A MACCHINA - Elica destra a 15° per fori ciechi
MACHINE TAPS - Spiral flutes 15° for blind holes
TARAUDS MACHINE - Goujures hélicoïdales 15° pour trous borgnes

ASME B1.1 | Ti | TITANIO - TITANIUM - TITANE

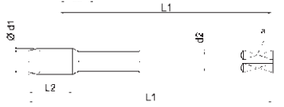
DIN 2184-1 d1 ≤ 1/4

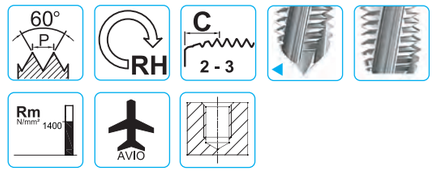


DIN 2184-1 d1 ≤ 3/8



DIN 2184-1 d1 ≥ 7/16





NEW

UNJC

Profondità di filettatura - Thread depth - Prof. de filetage	1,5xD	1,5xD	
Materiale - Tool Material - Substrat	PM3	PM3	
Tolleranza - Thread tolerance - Tolérance du filetage	2BX	3B	
Trattamento superficiale - Surface treatment - Revêtement	TiCN	TiCN	

	Ød1 UNC	P TPI	Ø mm	L_1	L_2	d_2 h9	a h12	Z		CODE	
◀	6	32	3,505	56	7	4	3	3	*2,85	K42UNC6-32CT	K42UNJC6-32CT
◀	8	32	4,166	63	7	4,5	3,4	3	*3,5	K42UNC8-32CT	K42UNJC8-32CT
◀	10	24	4,826	70	8	6	4,9	3	*3,9	K42UNC10-24CT	K42UNJC10-24CT
◀	1/4	20	6,350	80	10	7	5,5	3	*5,1	K42UNC1/4CT	K42UNJC1/4CT
	5/16	18	7,938	90	13	8	6,2	3	*6,6	K42UNC5/16CT	-
	3/8	16	9,525	100	15	10	8	3	*8	K42UNC3/8CT	-

	Ød1 UNC	P TPI	Ø mm	L_1	L_2	d_2 h9	a h12	Z		CODE
	7/16	14	11,113	100	15	8	6,2	4	*9,4	K43UNC7/16CT
	1/2	13	12,700	110	18	9	7	4	*10,8	K43UNC1/2CT
	5/8	11	15,875	110	20	12	9	4	*13,5	K43UNC5/8CT
	3/4	10	19,050	125	25	14	11	4	*16,5	K43UNC3/4CT

* Diametri di preforo UNJC a pag: 271 - Bore hole for thread UNJC to page: 271 - Pour UNJC voir le tableau de perçage page: 271

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	

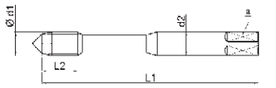
• Raccomandato - Optimal - Recommandé ◦ Adatto - Suitable - Adaptè

UNC

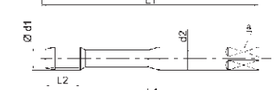
MASCHI A MACCHINA - Elica destra a 40° per fori ciechi
MACHINE TAPS - Spiral flutes 40° for blind holes
TARAUDS MACHINE - Goujures hélicoïdales 40° pour trous borgnes

ASME B1.1 | USO GENERALE - GENERAL PURPOSE - USAGE GÉNÉRAL

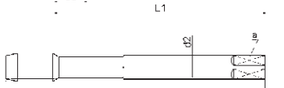
DIN 2184-1 d1 ≤ 1/4

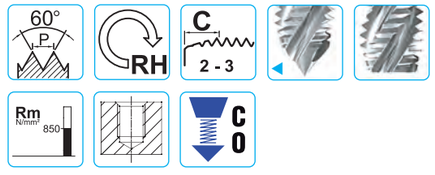


DIN 2184-1 d1 = 5/16



DIN 2184-1 d1 ≥ 5/16





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	2B	2B	2B	2B
Trattamento superficiale - Surface treatment - Revêtement		V	TiN	XP

	Ød1 UNC	P TPI	Ø mm	L_1	L_2	d_2 h9	a h12	Z		CODE			
◀	4	40	2,845	56	5	3,5	2,7	2	2,35	E60UNC4-40	E60UNC4-40V	E60UNC4-40T	E60UNC4-40XP
◀	5	40	3,175	56	5	3,5	2,7	3	2,65	E60UNC5-40	E60UNC5-40V	E60UNC5-40T	E60UNC5-40XP
◀	6	32	3,505	56	7	4	3	3	2,85	E60UNC6-32	E60UNC6-32V	E60UNC6-32T	E60UNC6-32XP
◀	8	32	4,166	63	7	4,5	3,4	3	3,5	E60UNC8-32	E60UNC8-32V	E60UNC8-32T	E60UNC8-32XP
◀	10	24	4,826	70	8	6	4,9	3	3,9	E60UNC10-24	E60UNC10-24V	E60UNC10-24T	E60UNC10-24XP
◀	12	24	5,486	80	10	6	4,9	3	4,5	E60UNC12-24	E60UNC12-24V	E60UNC12-24T	E60UNC12-24XP
◀	1/4	20	6,350	80	10	7	5,5	3	5,1	E60UNC1/4	E60UNC1/4V	E60UNC1/4T	E60UNC1/4XP
*	5/16	18	7,938	90	13	8	6,2	3	6,6	E60UNC5/16	E60UNC5/16V	E60UNC5/16T	E60UNC5/16XP

	Ød1 UNC	P TPI	Ø mm	L_1	L_2	d_2 h9	a h12	Z		CODE			
	5/16	18	7,938	90	13	6	4,9	3	6,6	E61UNC5/16	E61UNC5/16V	E61UNC5/16T	E61UNC5/16XP
	3/8	16	9,525	100	15	7	5,5	3	8	E61UNC3/8	E61UNC3/8V	E61UNC3/8T	E61UNC3/8XP
	7/16	14	11,113	100	15	8	6,2	3	9,4	E61UNC7/16	E61UNC7/16V	E61UNC7/16T	E61UNC7/16XP
	1/2	13	12,700	110	18	9	7	3	10,8	E61UNC1/2	E61UNC1/2V	E61UNC1/2T	E61UNC1/2XP
	9/16	12	14,288	110	20	11	9	4	12,2	E61UNC9/16	E61UNC9/16V	E61UNC9/16T	E61UNC9/16XP
	5/8	11	15,875	110	20	12	9	4	13,5	E61UNC5/8	E61UNC5/8V	E61UNC5/8T	E61UNC5/8XP
	3/4	10	19,050	125	25	14	11	4	16,5	E61UNC3/4	E61UNC3/4V	E61UNC3/4T	E61UNC3/4XP
	7/8	9	22,225	140	25	18	14,5	4	19,5	E61UNC7/8	E61UNC7/8V	E61UNC7/8T	E61UNC7/8XP
	1"	8	25,400	160	30	18	14,5	4	22,25	E61UNC1"	E61UNC1"V	E61UNC1"T	E61UNC1"XP
	1"1/8	7	28,575	180	35	22	18	4	25	E61UNC1"1/8	-	-	-
	1"1/4	7	31,750	180	35	22	18	4	28	E61UNC1"1/4	-	-	-
	1"3/8	6	34,925	200	40	28	22	4	30,75	E61UNC1"3/8	-	-	-
	1"1/2	6	38,100	200	40	28	22	4	34	E61UNC1"1/2	-	-	-

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

UNC

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

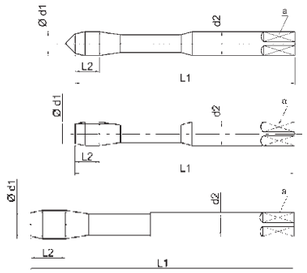
UFS LINE

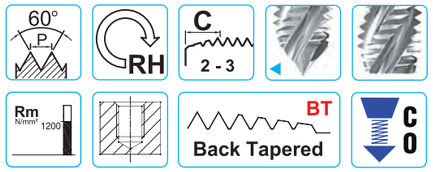
ASME B1.1 | USO GENERALE - GENERAL PURPOSE - USAGE GÉNÉRAL

DIN 2184-1 d1 ≤ 1/4

DIN 2184-1 d1 ≤ 3/8

DIN 2184-1 d1 ≥ 7/16





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	2BX	2BX	2BX
Trattamento superficiale - Surface treatment - Revêtement		V	TiN-G

	Ød1 UNC	P TPI	Ø mm	L_1	L_2	d_2 h9	a h12	Z		CODE		
◀	6	32	3,505	56	7	4	3	3	2,85	E92UNC6-32	E92UNC6-32V	E92UNC6-32TG
◀	8	32	4,166	63	7	4,5	3,4	3	3,5	E92UNC8-32	E92UNC8-32V	E92UNC8-32TG
◀	10	24	4,826	70	8	6	4,9	3	3,9	E92UNC10-24	E92UNC10-24V	E92UNC10-24TG
◀	1/4	20	6,350	80	10	7	5,5	3	5,1	E92UNC1/4	E92UNC1/4V	E92UNC1/4TG
	5/16	18	7,938	90	13	8	6,2	3	6,6	E92UNC5/16	E92UNC5/16V	E92UNC5/16TG
	3/8	16	9,525	100	15	10	8	3	8	E92UNC3/8	E92UNC3/8V	E92UNC3/8TG

	Ød1 UNC	P TPI	Ø mm	L_1	L_2	d_2 h9	a h12	Z		CODE		
	7/16	14	11,113	100	15	8	6,2	3	9,4	E93UNC7/16	E93UNC7/16V	E93UNC7/16TG
	1/2	13	12,700	110	18	9	7	3	10,8	E93UNC1/2	E93UNC1/2V	E93UNC1/2TG
	9/16	12	14,288	110	20	11	9	3	12,2	E93UNC9/16	E93UNC9/16V	E93UNC9/16TG
	5/8	11	15,875	110	20	12	9	3	13,5	E93UNC5/8	E93UNC5/8V	E93UNC5/8TG
	3/4	10	19,050	125	25	14	11	4	16,5	E93UNC3/4	E93UNC3/4V	E93UNC3/4TG

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

UNC

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

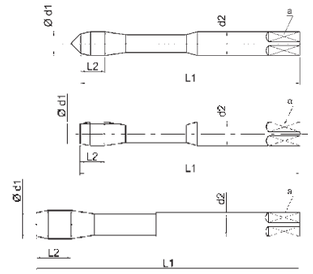
TOP UFS

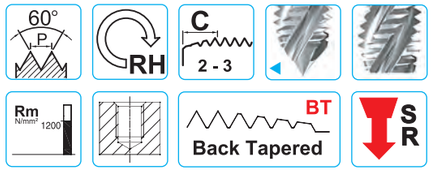
ASME B1.1 | U | APPLICAZIONI UNIVERSALI - UNIVERSAL APPLICATIONS - USINAGE UNIVERSELS

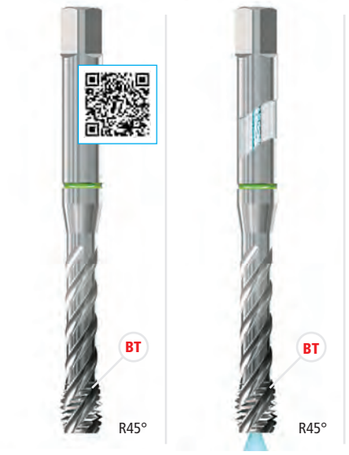
DIN 2184-1 d1 ≤ 1/4

DIN 2184-1 d1 ≤ 3/8

DIN 2184-1 d1 ≥ 7/16







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

	Ød1 UNC	P TPI	Ø mm	L_1	L_2	d_2 h9	a h12	Z		CODE	
◀	4	40	2,845	56	5	3,5	2,7	3	2,35	K82UNC4-40XP	-
◀	5	40	3,175	56	5	3,5	2,7	3	2,65	K82UNC5-40XP	-
◀	6	32	3,505	56	7	4	3	3	2,85	K82UNC6-32XP	-
◀	8	32	4,166	63	7	4,5	3,4	3	3,5	K82UNC8-32XP	-
◀	10	24	4,826	70	8	6	4,9	3	3,9	K82UNC10-24XP	-
◀	1/4	20	6,350	80	10	7	5,5	3	5,1	K82UNC1/4XP	K82UNC1/4FOR-XP
	5/16	18	7,938	90	13	8	6,2	3	6,1	K82UNC5/16XP	K82UNC5/16FOR-XP
	3/8	16	9,525	100	15	10	8	3	8	K82UNC3/8XP	K82UNC3/8FOR-XP

	Ød1 UNC	P TPI	Ø mm	L_1	L_2	d_2 h9	a h12	Z		CODE	
	7/16	14	11,113	100	15	8	6,2	3	9,4	K83UNC7/16XP	K83UNC7/16FOR-XP
	1/2	13	12,700	110	18	9	7	4	10,8	K83UNC1/2XP	K83UNC1/2FOR-XP
	9/16	12	14,288	110	20	11	9	4	12,2	K83UNC9/16XP	K83UNC9/16FOR-XP
	5/8	11	15,875	110	20	12	9	4	13,5	K83UNC5/8XP	K83UNC5/8FOR-XP
	3/4	10	19,050	125	25	14	11	4	16,5	K83UNC3/4XP	K83UNC3/4FOR-XP
	7/8	9	22,225	140	25	18	14,5	4	19,5	K83UNC7/8XP	K83UNC7/8FOR-XP
	1"	8	25,400	160	30	18	14,5	4	22,25	K83UNC1"XP	K83UNC1"FOR-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					

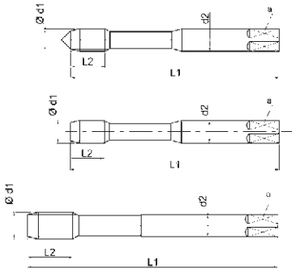
• Raccomandato - Optimal - Recommandé ◑ Adatto - Suitable - Adaptè

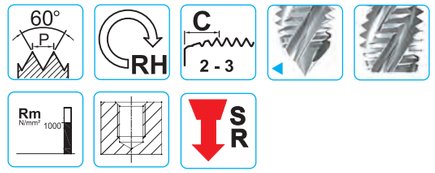
UNC

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

ASME B1.1 | INOX | ACCIAIO INOSSIDABILE - STAINLESS STEEL - ACIER INOXYDABLE

DIN 2184-1 d1 ≤ 1/4
DIN 2184-1 d1 ≤ 3/8
DIN 2184-1 d1 ≥ 7/16





Profondità di filettatura - Thread depth - Prof. de filetage	3,5xD	3,5xD	
Materiale - Tool Material - Substrat	HSSV3	HSSV3	
Tolleranza - Thread tolerance - Tolérance du filetage	2BX	2BX	
Trattamento superficiale - Surface treatment - Revêtement	TXC	TXC	

	Ød1 UNC	P TPI	Ø mm	L_1	L_2	d_2 h9	a h12	Z		CODE	
◀	6	32	3,505	56	7	4	3	3	2,85	V82UNC6-32TXC	-
◀	8	32	4,166	63	7	4,5	3,4	3	3,5	V82UNC8-32TXC	-
◀	10	24	4,826	70	8	6	4,9	3	3,9	V82UNC10-24TXC	-
◀	1/4	20	6,350	80	10	7	5,5	3	5,1	V82UNC1/4TXC	V82UNC1/4FOR-TXC
	5/16	18	7,938	90	13	8	6,2	3	6,1	V82UNC5/16TXC	V82UNC5/16FOR-TXC
	3/8	16	9,525	100	15	10	8	3	8	V82UNC3/8TXC	V82UNC3/8FOR-TXC
	7/16	14	11,113	100	15	8	6,2	3	9,4	V83UNC7/16TXC	V83UNC7/16FOR-TXC
	1/2	13	12,700	110	18	9	7	3	10,8	V83UNC1/2TXC	V83UNC1/2FOR-TXC
	9/16	12	14,288	110	20	11	9	4	12,2	V83UNC9/16TXC	V83UNC9/16FOR-TXC
	5/8	11	15,875	110	20	12	9	4	13,5	V83UNC5/8TXC	V83UNC5/8FOR-TXC
	3/4	10	19,050	125	25	14	11	4	16,5	V83UNC3/4TXC	V83UNC3/4FOR-TXC
	7/8	9	22,225	140	25	18	14,5	4	19,5	V83UNC7/8TXC	V83UNC7/8FOR-TXC
	1"	8	25,400	160	30	18	14,5	4	22,25	V83UNC1"TXC	V83UNC1"FOR-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 ≤ 1000 N/mm²	•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 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

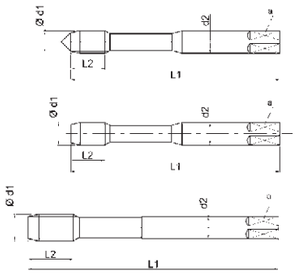
• Raccomandato - Optimal - Recommandé ❍ Adatto - Suitable - Adaptè

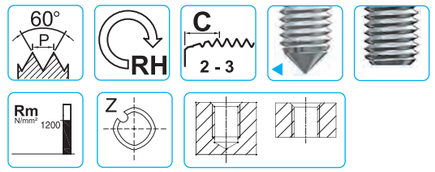
UNC

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

ASME B1.1 | MASCHI A RULLARE - ROLL FORM TAPS - TARAUDS À REFOULER

DIN 2184-1 d1 ≤ 3/8
DIN 2184-1 *d1
DIN 2184-1 d1 ≥ 7/16





Profondità di filettatura - Thread depth - Prof. de filetage	3xD	3xD	3xD
Materiale - Tool Material - Substrat	PM8	PM8	PM8
Tolleranza - Thread tolerance - Tolérance du filetage	2BX	2BX	2BX
Trattamento superficiale - Surface treatment - Revêtement	TiN	TiN-G	TiN-G

	Ød1 UNC	P TPI	Ø mm	L_1	L_2	d_2 h9	a h12	Z	CODE		
◀	6	32	3,505	56	11	4	3	2	3,15	P2CCUNC6-32T	
◀	8	32	4,166	63	13	4,5	3,4	4	3,8	P2CCUNC8-32T	
◀	10	24	4,826	70	13	6	4,9	4	4,3	P2CCUNC10-24T	
◀	12	24	5,486	80	16	6	4,9	5	5	P2CCUNC12-24T	
◀	1/4	20	6,350	80	16	7	5,5	5	5,75	P2CCUNC1/4T	
◀	5/16	18	7,938	90	18	8	6,2	5	7,25	P2CCUNC5/16T	
◀	3/8	16	9,525	100	20	10	8	5	8,75	P2CCUNC3/8T	
	7/16	14	11,113	100	20	8	6,2	5	10,3	P2CCUNC7/16T	
	1/2	13	12,700	110	25	9	7	5	11,8	P2CCUNC1/2T	
	9/16	12	14,288	110	28	11	9	6	13,3	P2CCUNC9/16T	
	5/8	11	15,875	110	28	12	9	6	14,8	P2CCUNC5/8T	
	3/4	10	19,050	125	32	14	11	6	17,9	P2CCUNC3/4T	

	Ød1 UNC	P TPI	Ø mm	L_1	L_2	d_2 h9	a h12	Z		CODE	
◀	6	32	3,505	56	8	4	3	4	3,15	K2CCUNC6-32TG	-
◀	8	32	4,166	63	8	4,5	3,4	4	3,8	K2CCUNC8-32TG	-
◀	10	24	4,826	70	10	6	4,9	5	4,3	K2CCUNC10-24TG	-
*	1/4	20	6,350	80	13	7	5,5	5	5,75	K2CCUNC1/4TG	K2CCUNC1/4FORY-TG
*	5/16	18	7,938	90	13	8	6,2	5	7,25	K2CCUNC5/16TG	K2CCUNC5/16FORY-TG
*	3/8	16	9,525	100	15	10	8	8	8,75	K2CCUNC3/8TG	K2CCUNC3/8FORY-TG
	7/16	14	11,113	100	18	8	6,2	8	10,3	K2CCUNC7/16TG	K2CCUNC7/16FORY-TG
	1/2	13	12,700	110	20	9	7	8	11,8	K2CCUNC1/2TG	K2CCUNC1/2FORY-TG
	5/8	11	15,875	110	23	12	9	8	14,8	K2CCUNC5/8TG	K2CCUNC5/8FORY-TG
	3/4	10	19,050	125	25	14	11	8	17,9	K2CCUNC3/4TG	K2CCUNC3/4FORY-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 ≤ 850 N/mm²	•1.1 20-30	•1.2 20-30	•1.3 20-25	•1.4 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	❍2.1 10-15	❍2.2 10-12	❍2.3 6-10		❍2.2 10-12	❍2.3 6-10	❍2.4 6-8	❍2.2 10-12	❍2.3 6-10	❍2.4 6-8
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								

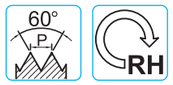
• Raccomandato - Optimal - Recommandé ❍ Adatto - Suitable - Adaptè

UNC

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

ASME B1.1

ANSI / ASME B1.2



Tolleranza - Thread tolerance - Tolérance du filetage	**2B**
Trattamento superficiale - Surface treatment - Revêtement	

Ød1 UNC	P TPI	CODE
4	**40**	P-NPUNC4-40
5	**40**	P-NPUNC5-40
6	**32**	P-NPUNC6-32
8	**32**	P-NPUNC8-32
10	**24**	P-NPUNC10-24
12	**24**	P-NPUNC12-24
1/4	**20**	P-NPUNC1/4-20
5/16	**18**	P-NPUNC5/16-18
3/8	**16**	P-NPUNC3/8-16
7/16	**14**	P-NPUNC7/16-14
1/2	**13**	P-NPUNC1/2-13
9/16	**12**	P-NPUNC9/16-12
5/8	**11**	P-NPUNC5/8-11
3/4	**10**	P-NPUNC3/4-10
7/8	**9**	P-NPUNC7/8-9
1"	**8**	P-NPUNC1"-8
1"1/8	**7**	P-NPUNC1"1/8-7
1"1/4	**7**	P-NPUNC1"1/4-7
1"3/8	**6**	P-NPUNC1"3/8-6
1"1/2	**6**	P-NPUNC1"1/2-6
1"3/4	**5**	P-NPUNC1"3/4-5
2"	**4,5**	P-NPUNC2"-4,5

La cultura secolare

The culture of centuries

1404: Ludovico di Savoia-Acaia promuove la formazione di un centro di insegnamento superiore, su sollecitazione di alcuni "magistri" fuggiti dalle sedi universitarie di Pavia e Piacenza; la sede prescelta è Torino, città vescovile.
1424: Amedeo VIII avvia una riforma per rendere più organico ed efficiente lo studium torinese, e nomina il collegio dei riformatori, principale organo di governo dell'Università, al quale appartiene il sigillo che in seguito fu adottato come logo dell'Università di Torino. Il consolidamento dell'Università si accompagna al rafforzamento del ruolo di Torino come capitale subalpina, fatto che le garantisce quasi un secolo di stabilità.
1506: Erasmo da Rotterdam consegue a Torino la laurea in Teologia. Con i governanti di casa Savoia Emanuele Filiberto e Carlo Emanuele I l'Ateneo visse una stagione di successo per la presenza di un corpo studentesco numeroso e culturalmente motivato. L'Ateneo ha invece un lungo periodo di crisi intorno alla metà del Seicento a causa di peste, carestie e continue guerre.
1800: il secondo Governo provvisorio piemontese trasforma l'Ateneo in Università Nazionale. L'adeguamento al sistema francese porta l'introduzione nel Piemonte francese del nuovo ordinamento imperiale, con il quale a capo di ogni Università veniva posto un Rettore. Per dimensioni, numero di cattedre, docenti e studenti, l'Ateneo piemontese è il secondo dell'Impero, dopo quello di Parigi. Le facoltà sono sostituite da 8 scuole speciali: Chimica, Chirurgia, Belle Arti, Giurisprudenza, Medicina, Fisica e Matematica, Letteratura e Medicina Veterinaria.
1801-1817: l'Impero Napoleonico istituisce le 5 facoltà di teologia, legge, medicina, scienze e letteratura e viene istituito un corso di Economia politica e la Scuola di Medicina Veterinaria apre a Venaria Reale.
Nel XVIII e XIX secolo l'Ateneo torinese, grazie alla presenza di moltissime Facoltà, è la seconda istituzione universitaria d'Italia preceduta solo da Napoli. All'Inizio del '900 da una costola dell'Università si costituisce il primo nucleo del Politecnico ad opera di Galileo Ferraris e vengono fondati l'Istituto per la Storia dell'Arte Medievale e Moderna e l'Istituto per l'Archeologia.
Tantissimi nomi illustri hanno frequentato l'ateneo. I Presidenti della repubblica italiana Luigi Einaudi e Giuseppe Saragat. l'Università di Torino è stata protagonista di quella straordinaria stagione culturale che diede al paese personaggi del calibro di Antonio Gramsci, Palmiro Togliatti, Norberto Bobbio, Alessandro Galante Garrone, Leone Ginzburg, Massimo Mila, Vittorio Foa, Giorgio Agosti, Dante Livio Bianco, Cesare Pavese, Primo Levi, Fernanda Pivano e Tullio Regge oltre a molti altri.
I premi Nobel Salvatore Luria, Rita Levi Montalcini e Renato Dulbecco si sono laureati in Medicina e Chirurgia.

1404: Ludovico of Savoy-Acaia orders the founding of a higher education centre, at the request of certain "learned men" from the universities of Pavia and Piacenza; the chosen site is Turin, because it is an episcopal city.
1424: Amadeus VIII embarks on reforms to make Turin's university more organic and efficient; he appoints a board of reformers as the institution's main governance body, with a seal which is subsequently adopted as the logo of the University of Turin. The strengthening of the university coincides with the consolidation of Turin as the subalpine capital, leading to almost a century of stability.
1506: Erasmus of Rotterdam gains a degree in Theology at the University of Turin. Under the Savoy rulers Emmanuel Philibert and Charles Emmanuel I, the university experiences a period of success, thanks to large numbers of cultured and motivated students. But around the mid 17th century, it undergoes a lengthy time of crisis, due to plague, famine and constant wars.
1800: The second provisional Piedmont government declares the institution to be a State University. The adoption of the French system brings new imperial organisation to French-ruled Piedmont, with a Rector appointed to lead the university. In terms of size, number of lecturers, teachers and students, Piedmont's university is the second-largest in the empire, after Paris. The faculties are replaced by eight special schools: Chemistry, Surgery, Fine Arts, Law, Medicine, Physics and Mathematics, Literature, and Veterinary Medicine.
1801-1817: The Napoleonic Empire establishes the five faculties of Theology, Law, Medicine, Science and Literature; an Economics and Politics course is introduced and the School of Veterinary Medicine opens at Venaria Reale.
In the 18th and 19th centuries the University of Turin is Italy's second most important university after Naples, with a large number of faculties. In the early 20th century a branch of the university establishes the first section of the Politecnico, thanks to Galileo Ferraris, with the foundation of the Institute for Medieval Art History and the Institute for Archaeology.
Many illustrious names have been educated at the university, Including presidents of the Italian Republic Luigi Einaudi and Giuseppe Saragat. The University of Turin played a key role in the extraordinary cultural boom that gave the world figures including Antonio Gramsci, Palmiro Togliatti, Norberto Bobbio, Alessandro Galante Garrone, Leone Ginzburg, Massimo Mila, Vittorio Foa, Giorgio Agosti, Dante Livio Bianco, Cesare Pavese, Primo Levi, Fernanda Pivano, Tullio Regge and many others.
Nobel prize winners Salvatore Luria, Rita Levi Montalcini and Renato Dulbecco graduated in Medicine and Surgery.

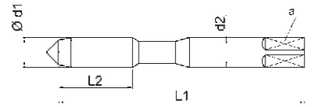
Campus Universitario Luigi Einaudi, Torino
Luigi Einaudi University Campus, Turin

UNF

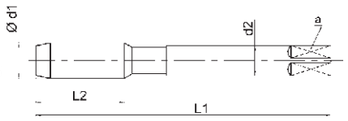
MASCHI A MANO - Per fori ciechi e passanti in serie di due pezzi
HAND TAPS - for blind and through holes in sets in sets of two pieces
TARAUDS À MAIN - pour trous borgnes et débouchant en jeu de deux pièces

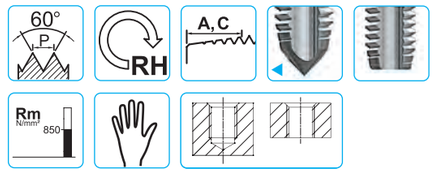
ASME B1.1 | USO GENERALE - GENERAL PURPOSE - USAGE GÉNÉRAL

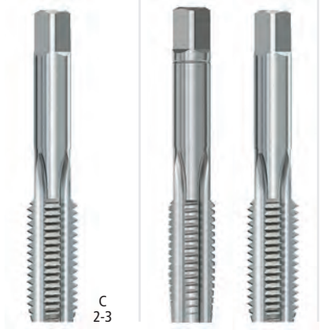
DIN 2184-2 d1 ≤ 1/4



DIN 2184-2 d1 ≥ 5/16







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

	Ød1 UNF	P TPI	Ø mm	L_1	L_2	d_2 h9	a h12	Z	Finitore Bottoming - Finisseur	Serie Set - Jeu
◀	**6**	**40**	3,505	45	10	4	3	3	03UNF6-40	00UNF6-40
◀	**8**	**36**	4,166	45	11	4,5	3,4	3	03UNF8-36	00UNF8-36
◀	**10**	**32**	4,826	50	13	6	4,9	3	03UNF10-32	00UNF10-32
◀	**12**	**28**	5,486	56	15	6	4,9	3	03UNF12-28	00UNF12-28
◀	**1/4**	**28**	6,350	56	16	6	4,9	3	03UNF1/4	00UNF1/4
	5/16	**24**	7,938	63	19	6	4,9	3	03UNF5/16	00UNF5/16
	3/8	**24**	9,525	63	19	7	5,5	3	03UNF3/8	00UNF3/8
	7/16	**20**	11,113	70	22	8	6,2	3	03UNF7/16	00UNF7/16
	1/2	**20**	12,700	70	22	9	7	4	03UNF1/2	00UNF1/2
	9/16	**18**	14,288	70	22	11	9	4	03UNF9/16	00UNF9/16
	5/8	**18**	15,875	70	22	12	9	4	03UNF5/8	00UNF5/8
	3/4	**16**	19,050	80	22	14	11	4	03UNF3/4	00UNF3/4
	7/8	**14**	22,225	80	22	18	14,5	4	03UNF7/8	00UNF7/8
	1"	**12**	25,400	90	22	18	14,5	4	03UNF1"	00UNF1"

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
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	

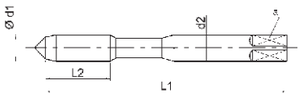
• Raccomandato - Optimal - Recommandé ◦ Adatto - Suitable - Adaptè

UNF

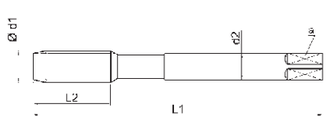
MASCHI A MACCHINA - Scanalature diritte per fori ciechi e passanti
MACHINE TAPS - Straight flutes for blind and through holes
TARAUDS MACHINE - Goujures droites pour trous borgnes et débouchant

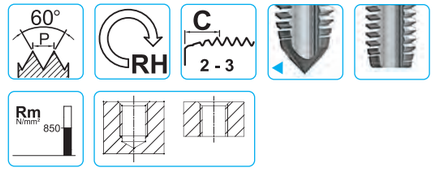
ASME B1.1 | USO GENERALE - GENERAL PURPOSE - USAGE GÉNÉRAL

DIN 2184-1 d1 ≤ 1/4



DIN 2184-1 d1 ≥ 5/16





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

	Ød1 UNF	P TPI	Ø mm	L_1	L_2	d_2 h9	a h12	Z	CODE
◀	**6**	**40**	3,505	56	11	4	3	3	E20UNF6-40
◀	**8**	**36**	4,166	63	13	4,5	3,4	3	E20UNF8-36
◀	**10**	**32**	4,826	70	13	6	4,9	3	E20UNF10-32
◀	**12**	**28**	5,486	80	16	6	4,9	3	E20UNF12-28
◀	**1/4**	**28**	6,350	80	16	7	5,5	3	E20UNF1/4

	Ød1 UNF	P TPI	Ø mm	L_1	L_2	d_2 h9	a h12	Z	CODE
	5/16	**24**	7,938	90	18	6	4,9	3	6,9	E21UNF5/16SP
	3/8	**24**	9,525	90	15	7	5,5	3	8,5	E21UNF3/8SP
	7/16	**20**	11,113	100	20	8	6,2	3	9,9	E21UNF7/16
	1/2	**20**	12,700	100	20	9	7	3	11,5	E21UNF1/2
	9/16	**18**	14,288	100	22	11	9	4	12,9	E21UNF9/16
	5/8	**18**	15,875	100	22	12	9	4	14,5	E21UNF5/8
	3/4	**16**	19,050	110	25	14	11	4	17,5	E21UNF3/4
	7/8	**14**	22,225	125	25	18	14,5	4	20,4	E21UNF7/8
	1"	**12**	25,400	140	28	18	14,5	4	23,25	E21UNF1"

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

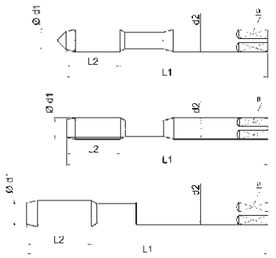
UNF

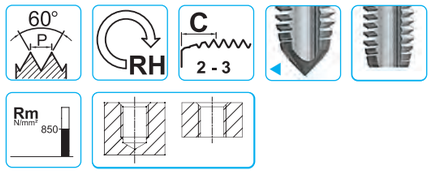
MASCHI A MACCHINA - Tagli diritti per ghisa
MACHINE TAPS - Straight flutes for cast iron
TARAUDS MACHINE - Goujures droites pour fonte

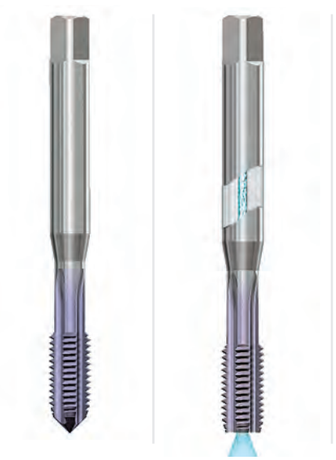
UFS LINE

ASME B1.1 | GG | GHISA - CAST IRON - FONTE

DIN 2184-1 d1 ≤ 1/4
DIN 2184-1 *d1 = 1/4
DIN 2184-1 d1 ≥ 5/16







Profondità di filettatura - Thread depth - Prof. de filetage	3xD	3xD
Materiale - Tool Material - Substrat	HSSE	HSSE
Tolleranza - Thread tolerance - Tolérance du filetage	2BX	2BX
Trattamento superficiale - Surface treatment - Revêtement	TiCN	TiCN

	Ød1 UNF	P TPI	Ø mm	L_1	L_2	d_2 h9	a h12	Z		CODE	
◀	6	40	3,505	56	11	4	3	3	2,95	E26UNF6-40CT	
◀	8	36	4,166	63	13	4,5	3,4	3	3,5	E26UNF8-36CT	
◀	10	32	4,826	70	13	6	4,9	3	4,1	E26UNF10-32CT	
◀	12	28	5,486	80	16	6	4,9	3	4,6	E26UNF12-28CT	
◀	1/4	28	6,350	80	16	7	5,5	3	5,5	E26UNF1/4CT	
*	1/4	28	6,350	80	16	7	5,5	3	5,5	-	E26UNF1/4FOR-CT

	Ød1 UNF	P TPI	Ø mm	L_1	L_2	d_2 h9	a h12	Z		CODE	
	5/16	24	7,938	90	18	6	4,9	4	6,9	E27UNF5/16SP-CT	E27UNF5/16FOR-CT
	3/8	24	9,525	90	15	7	5,5	4	8,5	E27UNF3/8SP-CT	E27UNF3/8FOR-CT
	7/16	20	11,113	100	20	8	6,2	4	9,9	E27UNF7/16CT	E27UNF7/16FOR-CT
	1/2	20	12,700	100	20	9	7	4	11,5	E27UNF1/2CT	E27UNF1/2FOR-CT
	9/16	18	14,288	100	22	11	9	4	12,9	E27UNF9/16CT	E27UNF9/16FOR-CT
	5/8	18	15,875	100	22	12	9	4	14,5	E27UNF5/8CT	E27UNF5/8FOR-CT
	3/4	16	19,050	110	25	14	11	4	17,5	E27UNF3/4CT	E27UNF3/4FOR-CT
	7/8	14	22,225	125	25	18	14,5	4	20,4	E27UNF7/8CT	E27UNF7/8FOR-CT
	1"	12	25,400	140	28	18	14,5	4	23,25	E27UNF1"CT	E27UNF1"FOR-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 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 25-30											
N	Leghe di magnesio Magnesium alloys - Alliages de magnésium	•4.5 20-30											
N	Leghe di Rame - Copper alloys - Alliages de cuivre	•5.3 25-30											
N	Materiali termoindurenti Duroplastic - Thermodurcissables	•8.2 10-15											

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

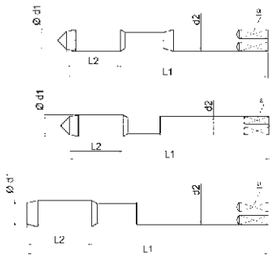
UNF

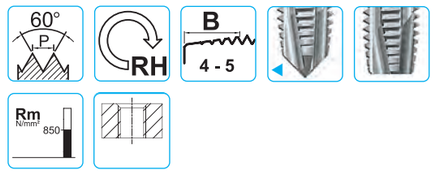
MASCHI A MACCHINA - Imbocco corretto per fori passanti
MACHINE TAPS - Straight flutes with spiral point for through holes
TARAUDS MACHINE - Goujures droites, entrée gun, pour trous débouchant

UFS LINE

ASME B1.1 | USO GENERALE - GENERAL PURPOSE - USAGE GÉNÉRAL

DIN 2184-1 d1 ≤ 1/4
DIN 2184-1 d1 ≤ 3/8
DIN 2184-1 d1 ≥ 7/16





Profondità di filettatura - Thread depth - Prof. de filetage	3xD	3xD	3xD
Materiale - Tool Material - Substrat	HSSE	HSSE	HSSE
Tolleranza - Thread tolerance - Tolérance du filetage	2B	2B	2B
Trattamento superficiale - Surface treatment - Revêtement		V	TiN

	Ød1 UNF	P TPI	Ø mm	L_1	L_2	d_2 h9	a h12	Z		CODE		
◀	6	40	3,505	56	11	4	3	3	2,95	E24UNF6-40	E24UNF6-40V	E24UNF6-40T
◀	8	36	4,166	63	13	4,5	3,4	3	3,5	E24UNF8-36	E24UNF8-36V	E24UNF8-36T
◀	10	32	4,826	70	13	6	4,9	3	4,1	E24UNF10-32	E24UNF10-32V	E24UNF10-32T
◀	12	28	5,486	80	16	6	4,9	3	4,6	E24UNF12-28	E24UNF12-28V	E24UNF12-28T
◀	1/4	28	6,350	80	16	7	5,5	3	5,5	E24UNF1/4	E24UNF1/4V	E24UNF1/4T

	Ød1 UNF	P TPI	Ø mm	L_1	L_2	d_2 h9	a h12	Z		CODE		
◀	5/16	24	7,938	90	18	6	4,9	3	6,9	E25UNF5/16	E25UNF5/16V	E25UNF5/16T
◀	3/8	24	9,525	90	15	7	5,5	3	8,5	E25UNF3/8	E25UNF3/8V	E25UNF3/8T
	7/16	20	11,113	100	20	8	6,2	3	9,9	E25UNF7/16	E25UNF7/16V	E25UNF7/16T
	1/2	20	12,700	100	20	9	7	3	11,5	E25UNF1/2	E25UNF1/2V	E25UNF1/2T
	9/16	18	14,288	100	22	11	9	4	12,9	E25UNF9/16	E25UNF9/16V	E25UNF9/16T
	5/8	18	15,875	100	22	12	9	4	14,5	E25UNF5/8	E25UNF5/8V	E25UNF5/8T
	3/4	16	19,050	110	25	14	11	4	17,5	E25UNF3/4	E25UNF3/4V	E25UNF3/4T
	7/8	14	22,225	125	25	18	14,5	4	20,4	E25UNF7/8	E25UNF7/8V	E25UNF7/8T
	1"	12	25,400	140	28	18	14,5	4	23,25	E25UNF1"	E25UNF1"V	E25UNF1"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
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		

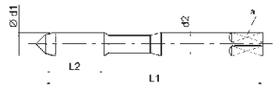
• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

UNF

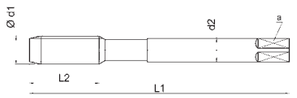
MASCHI A MACCHINA - Imbocco corretto per fori passanti
MACHINE TAPS - Straight flutes with spiral point for through holes
TARAUDS MACHINE - Goujures droites, entrée gun, pour trous débouchant

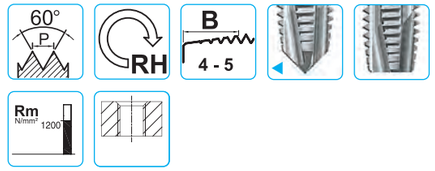
ASME B1.1 | U | APPLICAZIONI UNIVERSALI - UNIVERSAL APPLICATIONS - USINAGE UNIVERSELS

DIN 2184-1 d1 ≤ 1/4



DIN 2184-1 d1 ≥ 5/16





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	2BX	2BX		2B
Trattamento superficiale - Surface treatment - Revêtement	XP	XP		TiN-G

	Ød1 UNF	P TPI	Ø mm	L_1	L_2	d_2 h9	a h12	Z		CODE		
◀	4	48	2,845	56	10	3,5	2,7	3	2,4	K24UNF4-48XP	-	-
◀	6	40	3,505	56	11	4	3	3	2,95	K24UNF6-40XP	-	P24UNF6-40TG
◀	8	36	4,166	63	13	4,5	3,4	3	3,5	K24UNF8-36XP	-	P24UNF8-36TG
◀	10	32	4,826	70	13	6	4,9	3	4,1	K24UNF10-32XP	-	P24UNF10-32TG
◀	1/4	28	6,35	80	16	7	5,5	3	5,5	K24UNF1/4XP	K24UNF1/4FORY-XP	P24UNF1/4TG

Ød1 UNF	P TPI	Ø mm	L_1	L_2	d_2 h9	a h12	Z		CODE		
5/16	24	7,938	90	18	6	4,9	3	6,9	K25UNF5/16XP	K25UNF5/16FORY-XP	P25UNF5/16TG
3/8	24	9,525	90	15	7	5,5	3	8,5	K25UNF3/8XP	K25UNF3/8FORY-XP	P25UNF3/8TG
7/16	20	11,113	100	20	8	6,2	3	9,9	K25UNF7/16XP	K25UNF7/16FORY-XP	P25UNF7/16TG
1/2	20	12,700	100	20	9	7	4	11,5	K25UNF1/2XP	K25UNF1/2FORY-XP	P25UNF1/2TG
9/16	18	14,288	100	22	11	9	4	12,9	K25UNF9/16XP	-	P25UNF9/16TG
5/8	18	15,875	100	22	12	9	4	14,5	K25UNF5/8XP	-	P25UNF5/8TG
3/4	16	19,050	110	25	14	11	4	17,5	K25UNF3/4XP	-	P25UNF3/4TG
7/8	14	22,225	125	25	18	14,5	4	20,4	K25UNF7/8XP	-	-
1"	12	25,400	140	28	18	14,5	4	23,25	K25UNF1"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			•1.2 20-30	•1.3 20-25	•1.4 15-20	○1.5 15-20
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			

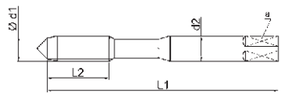
• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

UNF

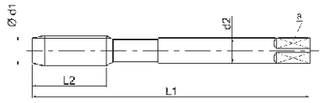
MASCHI A MACCHINA - Imbocco corretto per fori passanti
MACHINE TAPS - Straight flutes with spiral point for through holes
TARAUDS MACHINE - Goujures droites, entrée gun, pour trous débouchant

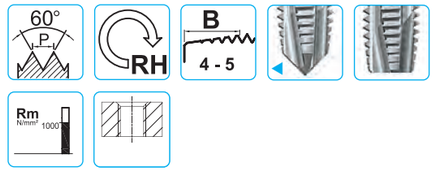
ASME B1.1 | INOX | ACCIAIO INOSSIDABILE - STAINLESS STEEL - ACIER INOXYDABLE

DIN 2184-1 d1 ≤ 1/4



DIN 2184-1 d1 ≥ 5/16





Profondità di filettatura - Thread depth - Prof. de filetage	3xD			
Materiale - Tool Material - Substrat	HSSV3			
Tolleranza - Thread tolerance - Tolérance du filetage	2BX			
Trattamento superficiale - Surface treatment - Revêtement	TXC			

	Ød1 UNF	P TPI	Ø mm	L_1	L_2	d_2 h9	a h12	Z		CODE
◀	6	40	3,505	56	11	4	3	3	2,95	V24UNF6-40TXC
◀	8	36	4,166	63	13	4,5	3,4	3	3,5	V24UNF8-36TXC
◀	10	32	4,826	70	13	6	4,9	3	4,1	V24UNF10-32TXC
◀	1/4	28	6,350	80	16	7	5,5	3	5,5	V24UNF1/4TXC

Ød1 UNF	P TPI	Ø mm	L_1	L_2	d_2 h9	a h12	Z		CODE
5/16	24	7,938	90	18	6	4,9	3	6,9	V25UNF5/16TXC
3/8	24	9,525	90	15	7	5,5	3	8,5	V25UNF3/8TXC
7/16	20	11,113	100	20	8	6,2	3	9,9	V25UNF7/16TXC
1/2	20	12,700	100	20	9	7	4	11,5	V25UNF1/2TXC
9/16	18	14,288	100	22	11	9	4	12,9	V25UNF9/16TXC
5/8	18	15,875	100	22	12	9	4	14,5	V25UNF5/8TXC
3/4	16	19,050	110	25	14	11	4	17,5	V25UNF3/4TXC
7/8	14	22,225	125	25	18	14,5	4	20,4	V25UNF7/8TXC
1"	12	25,400	140	28	18	14,5	4	23,25	V25UNF1"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	•1.3 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	○2.4 3-6	

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

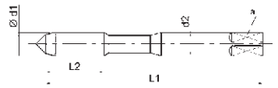
UNF

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

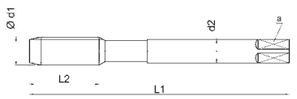
TOP UFS

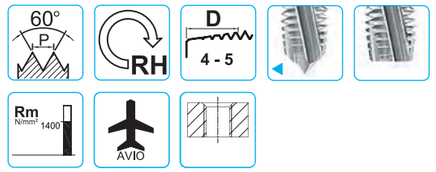
ASME B1.1 | Ti | TITANIO - TITANIUM - TITANE

DIN 2184-1 d1 ≤ 3/8



DIN 2184-1 d1 ≥ 7/16





Profondità di filettatura - Thread depth - Prof. de filetage	3xD	3xD		
Materiale - Tool Material - Substrat	PM3	PM3		
Tolleranza - Thread tolerance - Tolérance du filetage	2BX	3B		
Trattamento superficiale - Surface treatment - Revêtement	TiCN	TiCN		

	Ød1 UNF	P TPI	Ø mm	L_1	L_2	d_2 h9	a h12	Z		CODE	
◀	6	40	3,505	56	11	4	3	3	*2,95	K52UNF6-40CT	-
◀	8	36	4,166	63	13	4,5	3,4	3	*3,5	K52UNF8-36CT	-
◀	10	32	4,826	70	13	6	4,9	3	*4,1	K52UNF10-32CT	K52UNJF10-32CT
◀	1/4	28	6,350	80	16	7	5,5	3	*5,5	K52UNF1/4CT	K52UNJF1/4CT
◀	5/16	24	7,938	90	18	8	6,2	3	*6,9	K52UNF5/16CT	K52UNJF5/16CT
◀	3/8	24	9,525	100	20	10	8	3	*8,5	K52UNF3/8CT	K52UNJF3/8CT

	Ød1 UNF	P TPI	Ø mm	L_1	L_2	d_2 h9	a h12	Z		CODE
	7/16	20	11,113	100	20	8	6,2	3	*9,9	K53UNF7/16CT
	1/2	20	12,700	100	20	9	7	3	*11,5	K53UNF1/2CT

* Diametri di preforo UNJF a pag: 272 - Bore hole for thread UNJF to page: 272 - Pour UNJF voir le tableau de perçage page: 272

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

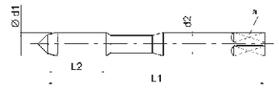
UNF

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

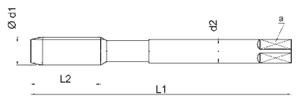
UFS LINE

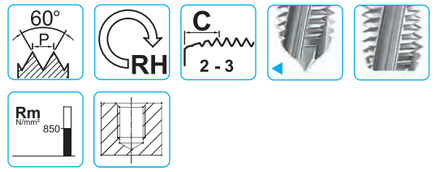
ASME B1.1 | USO GENERALE - GENERAL PURPOSE - USAGE GÉNÉRAL

DIN 2184-1 d1 ≤ 1/4



DIN 2184-1 d1 ≥ 5/16





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

	Ød1 UNF	P TPI	Ø mm	L_1	L_2	d_2 h9	a h12	Z		CODE	
◀	6	40	3,505	56	11	4	3	3	2,95	E40UNF6-40	E40UNF6-40T
◀	8	36	4,166	63	13	4,5	3,4	3	3,5	E40UNF8-36	E40UNF8-36T
◀	10	32	4,826	70	13	6	4,9	3	4,1	E40UNF10-32	E40UNF10-32T
◀	12	28	5,486	80	16	6	4,9	3	4,6	E40UNF12-28	E40UNF12-28T
◀	1/4	28	6,350	80	16	7	5,5	3	5,5	E40UNF1/4	E40UNF1/4T

	Ød1 UNF	P TPI	Ø mm	L_1	L_2	d_2 h9	a h12	Z		CODE	
	5/16	24	7,938	90	18	6	4,9	3	6,9	E41UNF5/16SP	E41UNF5/16SP-T
	3/8	24	9,525	90	15	7	5,5	3	8,5	E41UNF3/8SP	E41UNF3/8SP-T
	7/16	20	11,113	100	20	8	6,2	3	9,9	E41UNF7/16	E41UNF7/16T
	1/2	20	12,700	100	20	9	7	3	11,5	E41UNF1/2	E41UNF1/2T
	9/16	18	14,288	100	22	11	9	3	12,9	E41UNF9/16	E41UNF9/16T
	5/8	18	15,875	100	22	12	9	3	14,5	E41UNF5/8	E41UNF5/8T
	3/4	16	19,050	110	25	14	11	4	17,5	E41UNF3/4	E41UNF3/4T
	7/8	14	22,225	125	25	18	14,5	4	20,4	E41UNF7/8	E41UNF7/8T
	1"	12	25,400	140	28	18	14,5	4	23,25	E41UNF1"	E41UNF1"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

UNF

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

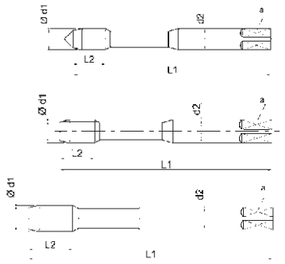
TOP UFS

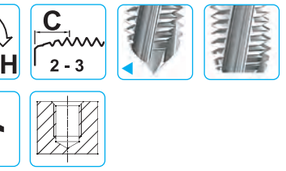
ASME B1.1 | Ti | TITANIO - TITANIUM - TITANE

DIN 2184-1 d1 ≤ 1/4

DIN 2184-1 d1 ≤ 3/8

DIN 2184-1 d1 ≥ 7/16





Profondità di filettatura - Thread depth - Prof. de filetage	1,5xD	1,5xD		
Materiale - Tool Material - Substrat	PM3	PM3		
Tolleranza - Thread tolerance - Tolérance du filetage	2BX	3B		
Trattamento superficiale - Surface treatment - Revêtement	TiCN	TiCN		

	Ød1 UNF	P TPI	Ø mm	L_1	L_2	d_2 h9	a h12	Z		CODE	
◀	6	40	3,505	56	7	4	3	3	*2,95	K42UNF6-40CT	-
◀	8	36	4,166	63	7	4,5	3,4	3	*3,5	K42UNF8-36CT	-
◀	10	32	4,826	70	8	6	4,9	3	*4,1	K42UNF10-32CT	K42UNJF10-32CT
◀	1/4	28	6,350	80	10	7	5,5	3	*5,5	K42UNF1/4CT	K42UNJF1/4CT
	5/16	24	7,938	90	13	8	6,2	3	*6,9	K42UNF5/16CT	K42UNJF5/16CT
	3/8	24	9,525	100	15	10	8	3	*8,5	K42UNF3/8CT	K42UNJF3/8CT

	Ød1 UNF	P TPI	Ø mm	L_1	L_2	d_2 h9	a h12	Z		CODE
	7/16	20	11,113	100	15	8	6,2	3	*9,9	K43UNF7/16CT
	1/2	20	12,700	100	13	9	7	4	*11,5	K43UNF1/2CT

* Diametri di preforo UNJF a pag: 272 - Bore hole for thread UNJF to page: 272 - Pour UNJF voir le tableau de perçage page: 272

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	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

UNF

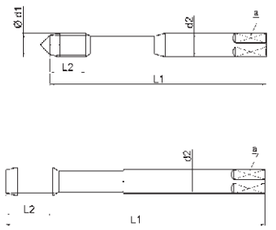
MASCHI A MACCHINA - Elica destra a 40° per fori ciechi
MACHINE TAPS - Spiral flutes 40° for blind holes
TARAUDS MACHINE - Goujures hélicoïdales 40° pour trous borgnes

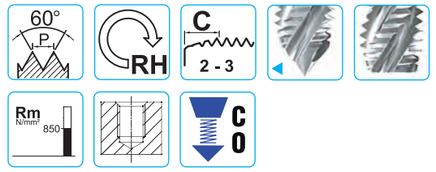
UFS LINE

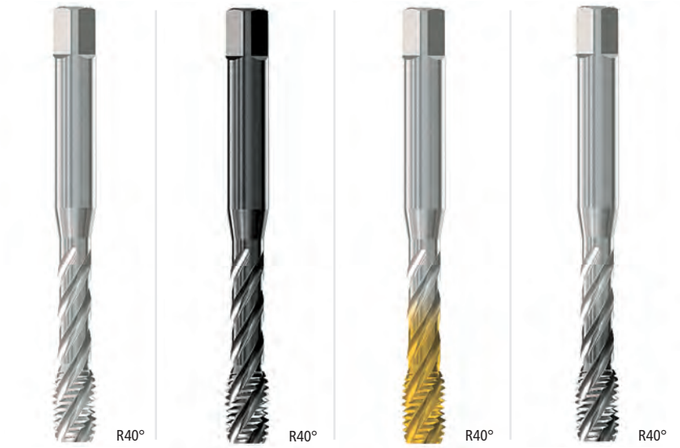
ASME B1.1 | USO GENERALE - GENERAL PURPOSE - USAGE GÉNÉRAL

DIN 2184-1 d1 ≤ 1/4

DIN 2184-1 d1 ≥ 5/16







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	2B	2B	2B	2B
Trattamento superficiale - Surface treatment - Revêtement		V	TiN	XP

	Ød1 UNF	P TPI	Ø mm	L_1	L_2	d_2 h9	a h12	Z		CODE			
◀	6	40	3,505	56	7	4	3	3	2,95	E60UNF6-40	E60UNF6-40V	E60UNF6-40T	E60UNF6-40XP
◀	8	36	4,166	63	7	4,5	3,4	3	3,5	E60UNF8-36	E60UNF8-36V	E60UNF8-36T	E60UNF8-36XP
◀	10	32	4,826	70	8	6	4,9	3	4,1	E60UNF10-32	E60UNF10-32V	E60UNF10-32T	E60UNF10-32XP
◀	12	28	5,486	80	10	6	4,9	3	4,6	E60UNF12-28	E60UNF12-28V	E60UNF12-28T	E60UNF12-28XP
◀	1/4	28	6,350	80	10	7	5,5	3	5,5	E60UNF1/4	E60UNF1/4V	E60UNF1/4T	E60UNF1/4XP

	Ød1 UNF	P TPI	Ø mm	L_1	L_2	d_2 h9	a h12	Z		CODE			
	5/16	24	7,938	90	13	6	4,9	3	6,9	E61UNF5/16	E61UNF5/16V	E61UNF5/16T	E61UNF5/16XP
	3/8	24	9,525	90	15	7	5,5	3	8,5	E61UNF3/8	E61UNF3/8V	E61UNF3/8T	E61UNF3/8XP
	7/16	20	11,113	100	15	8	6,2	3	9,9	E61UNF7/16	E61UNF7/16V	E61UNF7/16T	E61UNF7/16XP
	1/2	20	12,700	100	13	9	7	3	11,5	E61UNF1/2	E61UNF1/2V	E61UNF1/2T	E61UNF1/2XP
	9/16	18	14,288	100	15	11	9	4	12,9	E61UNF9/16	E61UNF9/16V	E61UNF9/16T	E61UNF9/16XP
	5/8	18	15,875	100	15	12	9	4	14,5	E61UNF5/8	E61UNF5/8V	E61UNF5/8T	E61UNF5/8XP
	3/4	16	19,050	110	17	14	11	4	17,5	E61UNF3/4	E61UNF3/4V	E61UNF3/4T	E61UNF3/4XP
	7/8	14	22,225	125	18	18	14,5	4	20,4	E61UNF7/8	E61UNF7/8V	E61UNF7/8T	E61UNF7/8XP
	1"	12	25,400	140	22	18	14,5	4	23,25	E61UNF1"	E61UNF1"V	E61UNF1"T	E61UNF1"XP
	1"1/4	12	31,750	150	22	22	18	5	29,5	E61UNF1"1/4	-	-	-
	1"1/2	12	38,100	170	24	28	22	6	36	E61UNF1"1/2	-	-	-

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

UNF

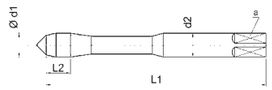
MASCHI A MACCHINA - Elicoidali 45° per fori ciechi
MACHINE TAPS - Spiral flutes 45° for blind holes
TARAUDS MACHINE - Goujures hélicoïdales 45° pour trous borgnes

CSC CHIP SYSTEM CONTROL

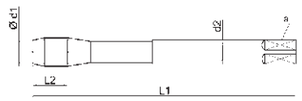
UFS LINE

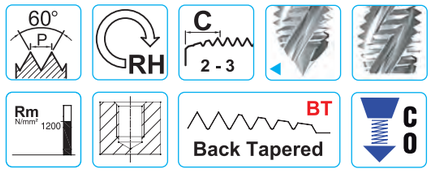
ASME B1.1 | USO GENERALE - GENERAL PURPOSE - USAGE GÉNÉRAL

DIN 2184-1 d1 ≤ 1/4



DIN 2184-1 d1 ≥ 7/16





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	2BX	2BX	2BX
Trattamento superficiale - Surface treatment - Revêtement		V	TiN-G

	Ød1 UNF	P TPI	Ø mm	L_1	L_2	d_2 h9	a h12	Z		CODE		
◀	6	40	3,505	56	7	4	3	3	2,95	E92UNF6-40	E92UNF6-40V	E92UNF6-40TG
◀	8	36	4,166	63	7	4,5	3,4	3	3,5	E92UNF8-36	E92UNF8-36V	E92UNF8-36TG
◀	10	32	4,826	70	8	6	4,9	3	4,1	E92UNF10-32	E92UNF10-32V	E92UNF10-32TG
◀	12	28	5,846	80	10	6	4,9	3	4,6	E92UNF12-28	E92UNF12-28V	E92UNF12-28TG
◀	1/4	28	6,350	80	10	7	5,5	3	5,5	E92UNF1/4	E92UNF1/4V	E92UNF1/4TG

	Ød1 UNF	P TPI	Ø mm	L_1	L_2	d_2 h9	a h12	Z		CODE		
	5/16	24	7,938	90	13	6	4,9	3	6,9	E93UNF5/16	E93UNF5/16V	E93UNF5/16TG
	3/8	24	9,525	90	15	7	5,5	3	8,5	E93UNF3/8	E93UNF3/8V	E93UNF3/8TG
	7/16	20	11,113	100	15	8	6,2	3	9,9	E93UNF7/16	E93UNF7/16V	E93UNF7/16TG
	1/2	20	12,700	100	13	9	7	3	11,5	E93UNF1/2	E93UNF1/2V	E93UNF1/2TG
	9/16	18	14,288	100	15	11	9	4	12,9	E93UNF9/16	E93UNF9/16V	E93UNF9/16TG
	5/8	18	15,875	100	15	12	9	4	14,5	E93UNF5/8	E93UNF5/8V	E93UNF5/8TG
	3/4	16	19,050	110	17	14	11	4	17,5	E93UNF3/4	E93UNF3/4V	E93UNF3/4TG

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

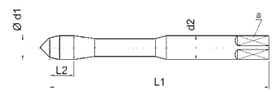
UNF

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

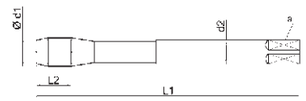
TOP UFS

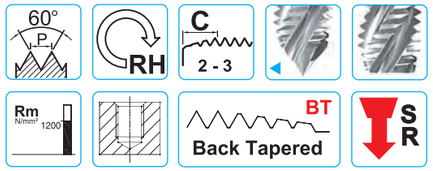
ASME B1.1 | U | APPLICAZIONI UNIVERSALI - UNIVERSAL APPLICATIONS - USINAGE UNIVERSELS

DIN 2184-1 d1 ≤ 1/4



DIN 2184-1 d1 ≥ 5/16





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

	Ød1 UNF	P TPI	Ø mm	L_1	L_2	d_2 h9	a h12	Z		CODE	
◀	4	48	2,845	56	5	3,5	2,7	3	2,4	K82UNF4-48XP	-
◀	6	40	3,505	56	7	4	3	3	2,95	K82UNF6-40XP	-
◀	8	36	4,166	63	7	4,5	3,4	3	3,5	K82UNF8-36XP	-
◀	10	32	4,826	70	8	6	4,9	3	4,1	K82UNF10-32XP	-
◀	1/4	28	6,350	80	10	7	5,5	3	5,5	K82UNF1/4XP	K82UNF1/4FOR-XP

	Ød1 UNF	P TPI	Ø mm	L_1	L_2	d_2 h9	a h12	Z		CODE	
	5/16	24	7,938	90	13	6	4,9	3	6,9	K83UNF5/16XP	K83UNF5/16FOR-XP
	3/8	24	9,525	90	15	7	5,5	3	8,5	K83UNF3/8XP	K83UNF3/8FOR-XP
	7/16	20	11,113	100	15	8	6,2	3	9,9	K83UNF7/16XP	K83UNF7/16FOR-XP
	1/2	20	12,700	100	13	9	7	4	11,5	K83UNF1/2XP	K83UNF1/2FOR-XP
	9/16	18	14,288	100	15	11	9	4	12,9	K83UNF9/16XP	-
	5/8	18	15,875	100	15	12	9	4	14,5	K83UNF5/8XP	-
	3/4	16	19,050	110	17	14	11	4	17,5	K83UNF3/4XP	-
	7/8	14	22,225	125	18	18	14,5	4	20,4	K83UNF7/8XP	-
	1"	12	25,400	140	22	18	14,5	4	23,25	K83UNF1"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

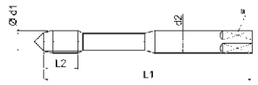
• Raccomandato - Optimal - Recommandé ◑ Adatto - Suitable - Adaptè

UNF

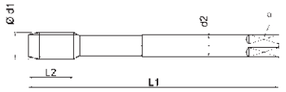
MASCHI A MACCHINA - Elicoidali 48° per fori ciechi
MACHINE TAPS - Spiral flutes 48° for blind holes
TARAUDS MACHINE - Goujures hélicoïdales 48° pour trous borgnes

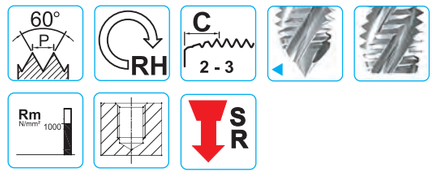
ASME B1.1 | INOX | ACCIAIO INOSSIDABILE - STAINLESS STEEL - ACIER INOXYDABLE

DIN 2184-1 d1 ≤ 1/4



DIN 2184-1 d1 ≥ 5/16





Profondità di filettatura - Thread depth - Prof. de filetage	3,5xD	3,5xD	
Materiale - Tool Material - Substrat	HSSV3	HSSV3	
Tolleranza - Thread tolerance - Tolérance du filetage	2BX	2BX	
Trattamento superficiale - Surface treatment - Revêtement	TXC	TXC	

	Ød1 UNF	P TPI	Ø mm	L_1	L_2	d_2 h9	a h12	Z		CODE	
◀	6	40	3,505	56	7	4	3	3	2,95	V82UNF6-40TXC	-
◀	8	36	4,166	63	7	4,5	3,4	3	3,5	V82UNF8-36TXC	-
◀	10	32	4,826	70	8	6	4,9	3	4,1	V82UNF10-32TXC	-
◀	1/4	28	6,350	80	10	7	5,5	3	5,5	V82UNF1/4TXC	V82UNF1/4FOR-TXC

	Ød1 UNF	P TPI	Ø mm	L_1	L_2	d_2 h9	a h12	Z		CODE	
	5/16	24	7,938	90	13	6	4,9	3	6,9	V83UNF5/16TXC	V83UNF5/16FOR-TXC
	3/8	24	9,525	90	15	7	5,5	3	8,5	V83UNF3/8TXC	V83UNF3/8FOR-TXC
	7/16	20	11,113	100	15	8	6,2	3	9,9	V83UNF7/16TXC	V83UNF7/16FOR-TXC
	1/2	20	12,700	100	13	9	7	4	11,5	V83UNF1/2TXC	V83UNF1/2FOR-TXC
	9/16	18	14,288	100	15	11	9	4	12,9	V83UNF9/16TXC	V83UNF9/16FOR-TXC
	5/8	18	15,875	100	15	12	9	4	14,5	V83UNF5/8TXC	V83UNF5/8FOR-TXC
	3/4	16	19,050	110	17	14	11	4	17,5	V83UNF3/4TXC	V83UNF3/4FOR-TXC
	7/8	14	22,225	125	18	18	14,5	4	20,4	V83UNF7/8TXC	V83UNF7/8FOR-TXC
	1”	12	25,400	140	22	18	14,5	4	23,25	V83UNF1"TXC	V83UNF1"FOR-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 ≤ 1000 N/mm²	•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 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

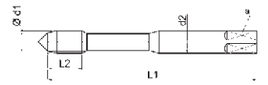
• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

UNF

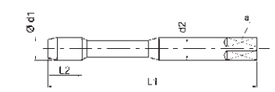
MASCHI A MACCHINA per fori ciechi e passanti con canalini di lubrificazione
MACHINE TAPS - for blind and through holes with oil grooves
TARAUDS MACHINE - pour trous borgnes et débouchant avec rainures de lubrification

ASME B1.1 | MASCHI A RULLARE - ROLL FORM TAPS - TARAUDS À REFOULER

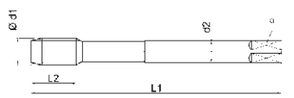
DIN 2184-1 d1 ≤ 3/8

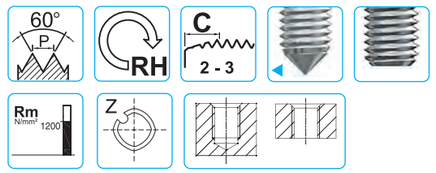


DIN 2184-1 *d1



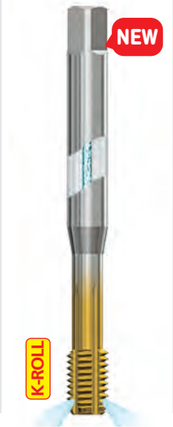
DIN 2184-1 d1 ≥ 7/16





Rm < 850 Nm/m²

Rm < 1200 Nm/m²



Profondità di filettatura - Thread depth - Prof. de filetage	3xD	3xD	3xD
Materiale - Tool Material - Substrat	PM8	PM8	PM8
Tolleranza - Thread tolerance - Tolérance du filetage	2BX	2BX	2BX
Trattamento superficiale - Surface treatment - Revêtement	TiN	TiN-G	TiN-G

	Ød1 UNF	P TPI	Ø mm	L_1	L_2	d_2 h9	a h12	Z		CODE
◀	6	40	3,505	56	11	4	3	2	3,20	P2CCUNF6-40T
◀	8	36	4,166	63	13	4,5	3,4	4	3,85	P2CCUNF8-36T
◀	10	32	4,826	70	13	6	4,9	4	4,45	P2CCUNF10-32T
◀	1/4	28	6,350	80	16	7	5,5	5	5,9	P2CCUNF1/4T
◀	5/16	24	7,938	90	18	8	6,2	5	7,45	P2CCUNF5/16T
◀	3/8	24	9,525	90	15	10	8	5	9	P2CCUNF3/8T
	7/16	20	11,113	100	18	8	6,2	5	10,5	P2CCUNF7/16T
	1/2	20	12,700	100	20	9	7	6	12,1	P2CCUNF1/2T
	9/16	18	14,288	100	22	11	9	6	13,7	P2CCUNF9/16T
	3/4	16	19,050	110	25	14	11	8	18,4	P2CCUNF3/4T
	1”	12	25,400	140	28	18	14,5	8	24,45	P2CCUNF1"T

	Ød1 UNF	P TPI	Ø mm	L_1	L_2	d_2 h9	a h12	Z		CODE	
◀	6	40	3,505	56	8	4	3	4	3,20	K2CCUNF6-40TG	-
◀	8	36	4,166	63	8	4,5	3,4	4	3,85	K2CCUNF8-36TG	-
◀	10	32	4,826	70	10	6	4,9	5	4,45	K2CCUNF10-32TG	-
*	1/4	28	6,350	80	13	7	5,5	5	5,9	K2CCUNF1/4TG	K2CCUNF1/4FORY-TG
*	5/16	24	7,938	90	13	8	6,2	5	7,45	K2CCUNF5/16TG	K2CCUNF5/16FORY-TG
*	3/8	24	9,525	90	15	10	8	8	9	K2CCUNF3/8TG	K2CCUNF3/8FORY-TG
	7/16	20	11,113	100	13	8	6,2	8	10,5	K2CCUNF7/16TG	K2CCUNF7/16FORY-TG
	1/2	20	12,700	100	13	9	7	8	12,1	K2CCUNF1/2TG	K2CCUNF1/2FORY-TG
	9/16	18	14,288	100	15	11	9	8	13,7	K2CCUNF9/16TG	K2CCUNF9/16FORY-TG
	3/4	16	19,050	110	16	14	11	8	18,4	K2CCUNF3/4TG	K2CCUNF3/4FORY-TG
	1”	12	25,400	140	22	18	14,5	8	24,45	K2CCUNF1"TG	K2CCUNF1"FORY-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	•1.1 20-30	•1.2 20-30	•1.3 20-25	○1.4 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	○2.1 10-15	○2.2 10-12	○2.3 6-10		○2.2 10-12	○2.3 6-10	○2.4 6-8		○2.2 10-12	○2.3 6-10	○2.4 6-8
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									

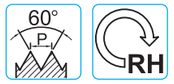
• Raccomandato - Optimal - Recommandé ○ Adatto - Suitable - Adaptè

UNF

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

ASME B1.1

ANSI / ASME B1.2



Tolleranza - Thread tolerance - Tolérance du filetage	**2B**
Trattamento superficiale - Surface treatment - Revêtement	

Ød1 UNF	P TPI	CODE
5	**44**	P-NPUNF5-44
6	**40**	P-NPUNF6-40
8	**36**	P-NPUNF8-36
10	**32**	P-NPUNF10-32
12	**28**	P-NPUNF12-28
1/4	**28**	P-NPUNF1/4-28
5/16	**24**	P-NPUNF5/16-24
3/8	**24**	P-NPUNF3/8-24
7/16	**20**	P-NPUNF7/16-20
1/2	**20**	P-NPUNF1/2-20
9/16	**18**	P-NPUNF9/16-18
5/8	**18**	P-NPUNF5/8-18
3/4	**16**	P-NPUNF3/4-16
7/8	**14**	P-NPUNF7/8-14
1"	**12**	P-NPUNF1"-12
1"1/8	**12**	P-NPUNF1"1/8-12
1"1/4	**12**	P-NPUNF1"1/4-12
1"3/8	**12**	P-NPUNF1"3/8-12
1"1/2	**12**	P-NPUNF1"1/2-12
1"1/2	**6**	P-NPUNC1"1/2-6
1"3/4	**5**	P-NPUNC1"3/4-5
2"	**4,5**	P-NPUNC2"-4,5

Le Residenze Sabaude

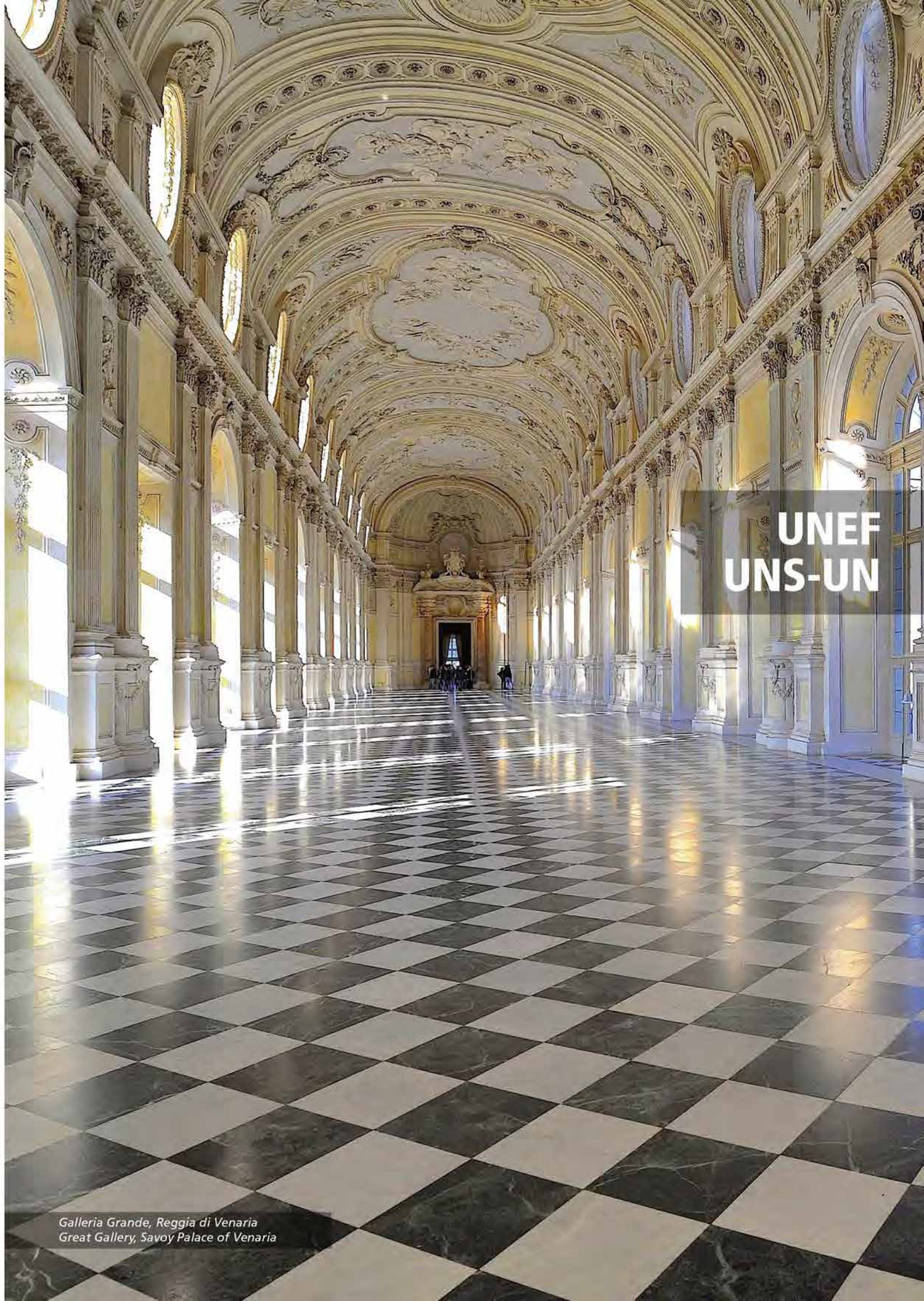
The Savoy Residences

Le residenze sabaude in Piemonte, molti delle quali sono eccellenze perchè iscritte nella Lista del Patrimonio Mondiale dell'UNESCO, sono l'insieme degli edifici residenziali della Casa Reale dei Savoia.
Dinastia che deriva il suo nome dall'omonima regione in cui originariamente aveva i propri possedimenti. Regnò nel corso di circa un millennio sul ducato di Savoia, sul Piemonte, sul regno di Sicilia, sul regno di Sardegna e infine sul regno d'Italia (Stato Sabaudo).
Il sistema delle Residenze Sabaude ha origine nel 1563 quando il duca di Savoia, Emanuele Filiberto, fa di Torino la capitale del ducato e decide di avviare un progetto di riorganizzazione complessiva del territorio con l'obiettivo di celebrare il potere assoluto della casa regnante. I suoi successori, tra il XVII e il XVIII secolo, realizzano il programma con l'organizzazione della "Zona di Comando", nel centro della città, e la creazione di un sistema di maisons de plaisance, la "Corona di Delizie", mediante la rifunzionalizzazione di residenze preesistenti e la costruzione di nuovi edifici destinati alla pratica venatoria e al loisir della corte.
Il carattere unitario del complesso di edifici, che rappresentano un panorama completo dell'architettura monumentale europea del XVII e XVIII secolo, è dato dalla omogeneità stilistica dovuta al gruppo di architetti e artisti di corte operanti in maniera diffusa nelle residenze e nei palazzi governativi.

Il sito seriale è composto da 22 edifici, 11 nel centro di Torino e gli altri intorno alla città.
A Torino un ampio complesso di edifici connessi alla corte, dove il potere accentrato veniva esercitato nelle sue forme politiche, amministrative e culturali e comprende il Palazzo Reale, l'Armeria Reale, il Palazzo della Prefettura e Archivio di Stato, il Teatro Regio, l'Accademia Militare, la Cavallerizza Reale destinata agli esercizi e agli spettacoli equestri di corte, la Regia Zecca, Palazzo Chiablese, Palazzo Madama e Palazzo Carignano che nel 1859 ospitava il primo Parlamento italiano.
Le residenze extraurbane dedicate allo svago, alle feste e alla caccia. Comprendono il Castello del Valentino sul Po, la Villa della Regina sulla collina di Torino, il Castello di Moncalieri, il Castello di Rivoli, il Castello di Venaria Reale, la Palazzina di Caccia di Stupinigi, il Castello di Agliè, il Borgo Castello de La Mandria, il Castello di Racconigi, il Castello di Pollenzo e il Castello di Govone.
Spiccano per bellezza e particolarità, costruiti in una miscela di stili, dal manieristico al trionfante barocco piemontese. Gioielli progettati o rimaneggiati da architetti del calibro di Filippo Juvarra, Amedeo e Carlo di Castellamonte, Guarino Guarini, Benedetto Alfieri, Claudio Francesco Beaumont e Pelagio Palagi.

The Savoy Residences of Piedmont, many of which are listed as UNESCO World Heritage sites, are a series of homes belonging to the Royal House of Savoy.
The dynasty takes its name from the region where its original properties were. The family ruled for almost a thousand years over the Duchy of Savoy, Piedmont, Sicily, the Kingdom of Sardinia and, finally, the Kingdom of Italy (the State of Savoy).
The Savoy Residences originated in 1563 when the Duke of Savoy, Emmanuel Philibert, made Turin the capital of the Duchy and embarked on a comprehensive reorganisation of the region with the aim of celebrating the absolute power of the ruling family. During the 17th and 18th centuries, his successors implemented the plan, establishing the "Area of Command" in the city centre and a system of maisons de plaisance, known as the "Corona di Delizie", by refurbishing already existing residences and building new ones for the court's hunting and leisure activities.
The uniform character of the series of buildings, which offer a complete panorama of European monumental architecture of the 17th and 18th centuries, is due to the shared style of the group of court architects and artists who worked on the various residences and government buildings.

In total there are 22 buildings, 11 in the centre of Turin and the others located around the city.
In Turin there is a substantial complex of court-related buildings used for the political, administrative and cultural exercise of centralised power. These include the Royal Palace, the Royal Armoury, the Palazzo della Prefettura and the State Archive, the Royal Theatre, the Military Academy, the Cavallerizza Reale - used for equestrian practice and the court's horsemanship displays - the Regia Zecca, Palazzo Chiablese, Palazzo Madama and Palazzo Carignano, home to the first Italian parliament in 1859.
Rural residences devoted to leisure, parties and hunting. These include the Valentino Castle on the bank of the Po, the Villa della Regina on the hill of Turin, the castles of Moncalieri and Rivoli, Venaria Reale, the Stupinigi hunting lodge, Agliè Castle, the castles of La Mandria, Racconigi, Pollenzo and Govone.
All outstanding for their extraordinary beauty, they are built in a mix of styles, ranging from Mannerism to triumphant Piedmont Baroque. The residences are architectural gems designed or restored by the likes of Filippo Juvarra, Amedeo and Carlo di Castellamonte, Guarino Guarini, Benedetto Alfieri, Claudio Francesco Beaumont and Pelagio Palagi.



Galleria Grande, Reggia di Venaria
Great Gallery, Savoy Palace of Venaria

UNEF

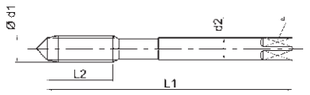
MASCHI A MACCHINA - Scanalature diritte per fori ciechi e passanti
MACHINE TAPS - Straight flutes for blind and through holes
TARAUDS MACHINE - Goujures droites pour trous borgnes et débouchant

UFS LINE

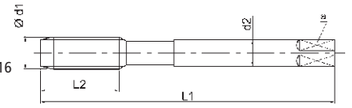
ASME B1.1

USO GENERALE - GENERAL PURPOSE - USAGE GÉNÉRAL

DIN 2184-1 d1 = 1/4



DIN 2184-1 d1 ≥ 5/16



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

	Ød1 UNEF	P TPI	Ø mm	L_1	L_2	d_2 h9	a h12	Z	CODE
◀	1/4	32	6,350	80	16	4,5	3,4	3	E21UNEF1/4
◀	5/16	32	7,938	90	18	6	4,9	3	E21UNEF5/16SP
◀	3/8	32	9,525	90	15	7	5,5	3	E21UNEF3/8SP
	7/16	28	11,113	100	20	8	6,2	3	E21UNEF7/16
	1/2	28	12,700	100	20	9	7	3	E21UNEF1/2
	9/16	24	14,288	100	22	11	9	4	E21UNEF9/16
	5/8	24	15,875	100	22	12	9	4	E21UNEF5/8
	11/16	24	17,462	110	25	14	11	4	E21UNEF11/16
	3/4	20	19,050	110	25	14	11	4	E21UNEF3/4
	13/16	20	20,638	125	25	18	14,5	4	E21UNEF13/16
	7/8	20	22,225	125	25	18	14,5	4	E21UNEF7/8
	1"	20	25,400	140	28	18	14,5	4	E21UNEF1"
	1"1/16	18	26,988	140	25	20	16	4	E21UNEF1"1/16
	1"1/8	18	28,575	150	28	22	18	4	E21UNEF1"1/8
	1"3/16	18	30,163	150	28	22	18	4	E21UNEF1"3/16
	1"1/4	18	31,750	150	28	22	18	5	E21UNEF1"1/4
	1"3/8	18	34,925	170	30	28	22	5	E21UNEF1"3/8
	1"7/16	18	36,513	170	30	28	22	6	E21UNEF1"7/16
	1"1/2	18	38,100	170	30	28	22	6	E21UNEF1"1/2

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

UNEF

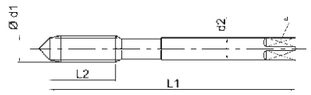
MASCHI A MACCHINA - Imbocco corretto per fori passanti
MACHINE TAPS - Straight flutes with spiral point for through holes
TARAUDS MACHINE - Goujures droites, entrée gun, pour trous débouchant

UFS LINE

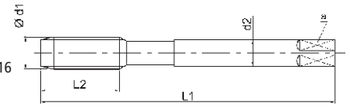
ASME B1.1

USO GENERALE - GENERAL PURPOSE - USAGE GÉNÉRAL

DIN 2184-1 d1 ≤ 3/8



DIN 2184-1 d1 ≥ 7/16



Profondità di filettatura - Thread depth - Prof. de filetage	**3xD**
Materiale - Tool Material - Substrat	**HSSE**
Tolleranza - Thread tolerance - Tolérance du filetage	**2B**
Trattamento superficiale - Surface treatment - Revêtement	

	Ød1 UNEF	P TPI	Ø mm	L_1	L_2	d_2 h9	a h12	Z	CODE
◀	1/4	32	6,350	80	16	4,5	3,4	3	E25UNEF1/4
◀	5/16	32	7,938	90	18	6	4,9	3	E25UNEF5/16
◀	3/8	32	9,525	90	15	7	5,5	3	E25UNEF3/8
	7/16	28	11,113	100	20	8	6,2	3	E25UNEF7/16
	1/2	28	12,700	100	20	9	7	3	E25UNEF1/2
	9/16	24	14,288	100	22	11	9	4	E25UNEF9/16
	5/8	24	15,875	100	22	12	9	4	E25UNEF5/8
	11/16	24	17,462	110	25	14	11	4	E25UNEF11/16
	3/4	20	19,050	110	25	14	11	4	E25UNEF3/4
	13/16	20	20,638	125	25	18	14,5	4	E25UNEF13/16
	7/8	20	22,225	125	25	18	14,5	4	E25UNEF7/8
	1"	20	25,400	140	28	18	14,5	4	E25UNEF1"
	1"1/16	18	26,988	140	25	20	16	4	E25UNEF1"1/16
	1"1/8	18	28,575	150	28	22	18	4	E25UNEF1"1/8
	1"3/16	18	30,163	150	28	22	18	4	E25UNEF1"3/16
	1"1/4	18	31,750	150	28	22	18	5	E25UNEF1"1/4
	1"3/8	18	34,925	170	30	28	22	5	E25UNEF1"3/8
	1"7/16	18	36,513	170	30	28	22	6	E25UNEF1"7/16
	1"1/2	18	38,100	170	30	28	22	6	E25UNEF1"1/2

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

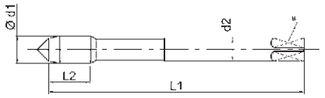
UNEF

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

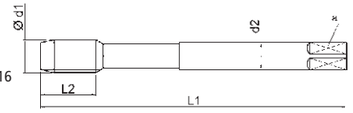
ASME B1.1

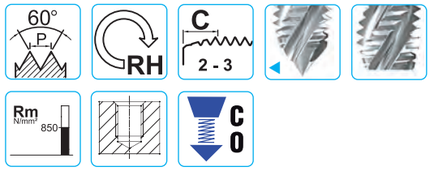
USO GENERALE - GENERAL PURPOSE - USAGE GÉNÉRAL

DIN 2184-1 d1 = 1/4



DIN 2184-1 d1 ≥ 5/16





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

	Ød1 UNEF	P TPI	Ø mm	L_1	L_2	d_2 h9	a h12	Z	CODE
◀	**1/4**	**32**	6,350	80	10	4,5	3,4	3	5,55	E61UNEF1/4
	5/16	**32**	7,938	90	13	6	4,9	3	7,15	E61UNEF5/16
	3/8	**32**	9,525	90	15	7	5,5	3	8,7	E61UNEF3/8
	7/16	**28**	11,113	100	15	8	6,2	3	10,2	E61UNEF7/16
	1/2	**28**	12,700	100	13	9	7	3	11,8	E61UNEF1/2
	9/16	**24**	14,288	100	15	11	9	4	13,2	E61UNEF9/16
	5/8	**24**	15,875	110	15	12	9	4	14,8	E61UNEF5/8
	11/16	**24**	17,462	110	17	14	11	4	16,4	E61UNEF11/16
	3/4	**20**	19,050	110	17	14	11	4	17,8	E61UNEF3/4
	13/16	**20**	20,638	125	18	16	12	4	19,4	E61UNEF13/16
	7/8	**20**	22,225	125	18	18	14,5	4	20,95	E61UNEF7/8
	1”	**20**	25,400	140	22	18	14,5	4	24,15	E61UNEF1"
	1”1/16	**18**	26,988	140	20	20	16	4	25,6	E61UNEF1"1/16
	1”1/8	**18**	28,575	150	22	22	18	4	27,15	E61UNEF1"1/8
	1”3/16	**18**	30,163	150	22	22	18	4	28,75	E61UNEF1"3/16
	1”1/4	**18**	31,750	150	22	22	18	5	30,3	E61UNEF1"1/4
	1”3/8	**18**	34,925	170	24	28	22	5	33,5	E61UNEF1"3/8
	1”7/16	**18**	36,513	170	24	28	22	6	35,1	E61UNEF1"7/16
	1”1/2	**18**	38,100	170	24	28	22	6	36,7	E61UNEF1"1/2

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

UNEF

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

ASME B1.1

ANSI / ASME B1.2

Tolleranza - Thread tolerance - Tolérance du filetage	**2B**
Trattamento superficiale - Surface treatment - Revêtement	

Ød1 UNEF	P TPI	CODE
1/4	**32**	P-NPUNEF1/4-32
5/16	**32**	P-NPUNEF5/16-32
3/8	**32**	P-NPUNEF3/8-32
7/16	**28**	P-NPUNEF7/16-28
1/2	**28**	P-NPUNEF1/2-28
9/16	**24**	P-NPUNEF9/16-24
5/8	**24**	P-NPUNEF5/8-24
11/16	**24**	P-NPUNEF11/16-24
3/4	**20**	P-NPUNEF3/4-20
13/16	**20**	P-NPUNEF13/16-20
7/8	**20**	P-NPUNEF7/8-20
1"	**20**	P-NPUNEF1"-20
1”1/16	**18**	P-NPUNEF1"1/16-18
1"1/8	**18**	P-NPUNEF1"1/8-18
1”3/16	**18**	P-NPUNEF1"3/16-18
1"1/4	**18**	P-NPUNEF1"1/4-18
1"3/8	**18**	P-NPUNEF1"3/8-18
1”7/16	**18**	P-NPUNEF1"7/16-18
1"1/2	**18**	P-NPUNEF1"1/2-18

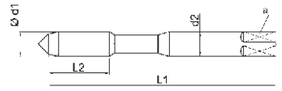
UNS

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

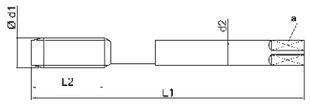
ASME B1.1

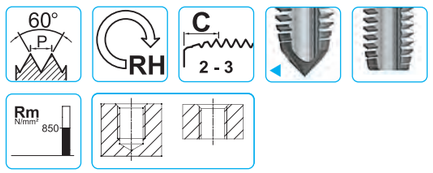
USO GENERALE - GENERAL PURPOSE - USAGE GÉNÉRAL

DIN 2184-1 d1 ≤ 1/4



DIN 2184-1 d1 ≥ 3/8





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

	Ød1 UNS	P TPI	Ø mm	L_1	L_2	d_2 h9	a h12	Z		CODE
◀	10	40	4,826	70	13	6	4,9	3	4,2	E20-40UNS10
◀	10	48	4,826	70	13	6	4,9	3	4,3	E20-48UNS10
◀	12	36	5,486	80	16	6	4,9	3	4,8	E20-36UNS12
◀	1/4	24	6,350	80	16	7	5,5	3	5,3	E20-24UNS1/4
◀	1/4	36	6,350	80	16	7	5,5	3	5,6	E20-36UNS1/4
◀	1/4	40	6,350	80	16	7	5,5	3	5,7	E20-40UNS1/4

	Ød1 UNS	P TPI	Ø mm	L_1	L_2	d_2 h9	a h12	Z		CODE
	3/8	40	9,525	100	15	7	5,5	3	8,9	E21-40UNS3/8SP
	7/16	24	11,113	100	20	8	6,2	3	10,05	E21-24UNS7/16
	1/2	24	12,700	100	20	9	7	3	11,6	E21-24UNS1/2
	1"	14	25,400	140	28	18	14,5	4	23,6	E21-14UNS1"

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				

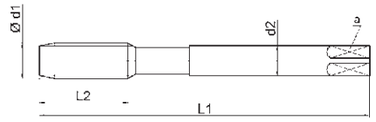
• Raccomandato - Optimal - Recommandé ❍ Adatto - Suitable - Adaptè

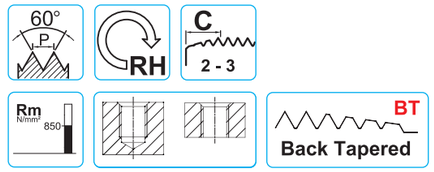
8-UN 12-UN

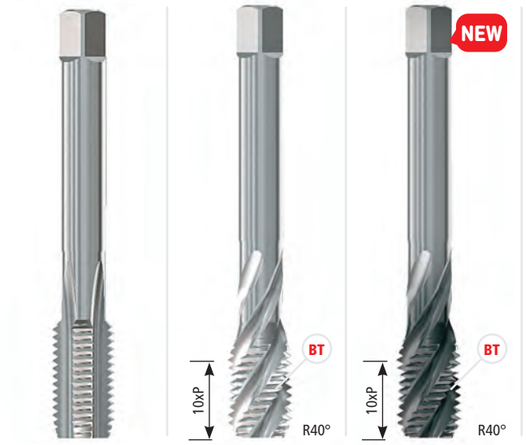
MASCHI A MACCHINA - Scanalature diritte ed elicoidali a 40° rastremati
MACHINE TAPS - Straight flutes and 40° spiral flutes back tapered
TARAUDS MACHINE - Goujures droites et goujures hélicoïdales 40° conicité arrière

ASME B1.1

USO GENERALE - GENERAL PURPOSE - USAGE GÉNÉRAL







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

DIN 2184-1	Ød1 8-UN	P TPI	Ø mm	L_1	L_2	d_2 h9	a h12	Z		CODE		
	1"1/8	8	28,575	180	40	22	18	4	25,4	E21-8UN1"1/8	E81-8UN1"1/8	E81-8UN1"1/8XP
	1"1/4	8	31,750	180	40	22	18	4	28,6	E21-8UN1"1/4	E81-8UN1"1/4	E81-8UN1"1/4XP
	1"3/8	8	34,925	200	50	28	22	4	31,75	E21-8UN1"3/8	E81-8UN1"3/8	E81-8UN1"3/8XP
	1"1/2	8	38,100	200	50	28	22	4	34,9	E21-8UN1"1/2	E81-8UN1"1/2 (Z=5)	E81-8UN1"1/2XP (Z=5)
	1"5/8	8	41,275	200	50	32	24	5	38,1	E21-8UN1"5/8	E81-8UN1"5/8	E81-8UN1"5/8XP
■	1"3/4	8	44,450	200	50	36	29	5	41,3	E21-8UN1"3/4	E81-8UN1"3/4	E81-8UN1"3/4XP
■	1"7/8	8	47,625	225	60	36	29	5	44,45	E21-8UN1"7/8	E81-8UN1"7/8	E81-8UN1"7/8XP
■	2"	8	50,800	225	60	40	32	5	47,6	E21-8UN2"	E81-8UN2"	E81-8UN2"XP
■	2"1/4	8	57,150	250	65	45	35	6	54	E21-8UN2"1/4	E81-8UN2"1/4	E81-8UN2"1/4XP
■	2"1/2	8	63,500	275	70	50	39	6	60,3	E21-8UN2"1/2	E81-8UN2"1/2	E81-8UN2"1/2XP

UFS Norm	Ød1 12-UN	P TPI	Ø mm	L_1	L_2	d_2 h9	a h12	Z		NEW CODE		
	7/8	12	22,225	125	25	18	14,5	4	20,1	E21-12UN7/8	E81-12UN7/8	E81-12UN7/8XP
	1"1/16	12	26,988	140	25	20	16	4	24,9	E21-12UN1"1/16	E81-12UN1"1/16	E81-12UN1"1/16XP
	1"3/16	12	30,163	150	28	22	18	4	28	E21-12UN1"3/16	E81-12UN1"3/16	E81-12UN1"3/16XP
	1"5/16	12	33,338	170	30	28	22	5	31,2	E21-12UN1"5/16	E81-12UN1"5/16	E81-12UN1"5/16XP
	1"5/8	12	41,275	170	30	32	24	6	39,2	E21-12UN1"5/8	E81-12UN1"5/8	E81-12UN1"5/8XP

■ = 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
M	Acciaio inox - Stainless steel - Acier inoxydable									❍2.1 10-15	❍2.2 8-10		
K	Ghisa - Cast iron - Fonte	❍3.4 8-10								❍3.3 10-15	•3.4 15-20		
N	Leghe di Allumino – Al alloys - Alliage Al	❍4.2 15-20	❍4.3 20-15			•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 10-15	❍5.3 15-20			❍5.1 8-12	❍5.2 10-15			•5.2 20-25			
N	Leghe di Rame - Copper alloys - Alliages de cuivre	❍8.2 8-10											

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