

MATERIAL GROUP	Vc (m/min)	
	BR-OX-NX-NI	TiN-TiCN PV15
1-5	5~10	
13-14	8~12	
16-19-20	10~20	



MATERIAL GROUPS / GRUPPI MATERIALE WERKSTOFFEGRUPPE / GROUPES MATIÈRE								1-5 13 14 16 19 20	1-5 13 14 16 19 20	1-5 13 14 16 19 20
								STR	STR	STR
								HSSE	HSSE	HSSE
								BR	BR	BR
								3,5 P	3,5 P	3,5 P
Dxn	D(mm)	Ø	L	l	d	k	Stock	Stock	Stock	
Rp 1/8x28	9.728	8.5	55	19	8	6	○			
	9.728	8.5	100	19	8	6		○		
	9.728	8.5	150	19	8	6			○	
1/4x19	13.157	11.4	62	28	11	9	○			
	13.157	11.4	100	28	11	9		○		
	13.157	11.4	150	28	11	9			○	
3/8x19	16.662	14.9	65	28	14	11	○			
	16.662	14.9	100	28	14	11		○		
	16.662	14.9	150	28	14	11			○	
1/2x14	20.955	18.6	80	35	18	14	○			
	20.955	18.6	150	35	18	14			○	
3/4x14	26.441	24	85	35	23	17	○			
	26.441	24	150	35	23	17			○	
1 x11	33.249	30.2	95	45	26	21	○			
	33.249	30.2	150	45	26	21			○	
1 1/4x11	41.910	38.8	105	45	32	26	○			
1 1/2x11	47.803	44.7	110	45	38	29	○			
2 x11	59.614	56.5	120	50	46	35	○			

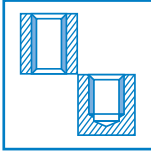
● stock standard ○ non-standard stock △ on request EX stock exhaustion



Rp 1/8 ~ 3/8	4	4	4
1/2 ~ 3/4	4		4
1 ~ 1 1/4	5		5
1 1/2 ~ 2	6		

**NEW**

<b>NPT</b>
DIN376-374 ANSI B94.9



MATERIAL GROUP	Vc (m/min)	
	BR-OX-NX-NI	TiN-TiCN PV15
<b>1-5</b>	5~15	
<b>9-11</b>	3~12	
<b>13-14</b>	8~12	
<b>16-19-20</b>	10~20	



MATERIAL GROUPS / GRUPPI MATERIALE WERKSTOFFEGRUPPE / GROUPES MATIÈRE										1-5 13 14 16 19 20	1-5 9 10	1-5 9-11
										STR	STR INT	45°
										HSSE BR	HSSE OX	HSSE OX
										3P	3P	2,5P
Dxn	Ø A B		L	I	I1	d	k	Stock	Stock			
<b>• ANSI</b>												
NPT 1/16x27	5.94	6.15	54	17.45	12	7.937	5.943	●	○			
1/8 x27	8.33	8.43	54	19.05	12.05	11.112	8.331	●	●			
1/4 x18	10.72	11.13	61.9	27	17.45	14.287	10.693	●	●			
3/8 x18	14.27	14.57	65.1	27	17.65	17.78	13.487	●	○			
1/2 x14	17.48	17.86	79.4	34.95	22.85	17.462	13.081	●	●			
3/4 x14	22.63	23.01	82.55	34.95	22.95	23.02	17.246	●	○			
1 x11.5	28.58	28.98	95.25	44.45	27.4	28.575	21.412	●	○			
<b>• DIN371-374</b>												
1/8 x27	8.33	8.43	90	12	26	10	8				●	
1/4 x18	10.72	11.13	100	18	34.5	14	11				●	
3/8 x18	14.27	14.57	110	18		14	11				●	
1/2 x14	17.48	17.86	140	23		16	12				●	
3/4 x14	22.63	23.01	150	24		20	16				○	
1 x11.5	28.58	28.98	170	30		25	20				○	

A with reaming before tapping / con alesatura prima della maschiatura  
mit Benutzung einer Reibahle / avec alésage avant le taraudage

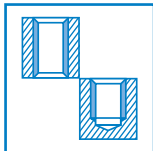
B without reaming before tapping / senza alesatura prima della maschiatura  
ohne Benutzung einer Reibahle / sans alésage avant le taraudage

● stock standard ○ non-standard stock △ on request EX stock exhaustion



NPT 1/16	4	3	
1/8 ~ 3/8	4	5	3
1/2	4	5	4
3/4 ~1	5	5	4

**NPTF**  
**ANSI B94.9**



MATERIAL GROUP	Vc (m/min)	
	BR-OX-NX-NI	TiN-TiCN PV15
1-5	5~10	
13-14	8~12	
16-19-20	10~20	

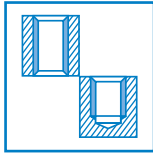
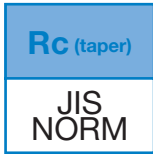


MATERIAL GROUPS / GRUPPI MATERIALE WERKSTOFFEGRUPPE / GROUPES MATIÈRE		1-5 13 14 16 19 20						
		STR						
		HSSE BR						
		3P						
Dxn	A	B	L	I	I1	d	k	Stock
NPTF1/16 x27	5.94	6.15	54	17.45	12	7.937	5.943	○
1/8 x27	8.33	8.43	54	19.05	12.05	11.112	8.331	●
1/4 x18	10.72	11.13	61.9	27	17.45	14.287	10.693	●
3/8 x18	14.27	14.57	65.1	27	17.65	17.78	13.487	○
1/2 x14	17.48	17.86	79.4	34.95	22.85	17.462	13.081	●
3/4 x14	22.63	23.01	82.55	34.95	22.95	23.02	17.246	○
1 x11.5	28.58	28.98	95.25	44.45	27.4	28.575	21.412	○

A with reaming before tapping / con alesatura prima della maschiatura  
 mit Benutzung einer Reibahle / avec alésage avant le taraudage ● stock standard ○ non-standard stock △ on request EX stock exhaustion  
 B without reaming before tapping / senza alesatura prima della maschiatura  
 ohne Benutzung einer Reibahle / sans alésage avant le taraudage



NPTF1/16 ~ 1/2	4
3/4 ~ 1	5



MATERIAL GROUP	Vc (m/min)	
	BR-OX-NX-NI	TiN-TiCN PV15
<b>1-5</b>	5~10	
<b>13-14</b>	8~12	
<b>16-19-20</b>	10~20	



MATERIAL GROUPS / GRUPPI MATERIALE WERKSTOFFEGRUPPE / GROUPES MATIÈRE									1-5 13 14 16 19 20	1-5 13 14 16 19 20	1-5 13 14 16 19 20
									STR	STR	STR
									HSSE	HSSE	HSSE
									BR	BR	BR
									2,5 P	2,5 P	2,5 P
Dxn	Ø		L	I	I1	d	k	Stock	Stock	Stock	
<b>Rc 1/8 x28</b>	8.10	8.20	55	19	13	8	6	●			
	8.10	8.20	100	19	13	8	6		●		
<b>1/4 x19</b>	8.10	8.20	150	19	13	8	6			○	
	10.70	11.00	62	28	21	11	9	●			
	10.70	11.00	100	28	21	11	9		●		
<b>3/8 x19</b>	10.70	11.00	150	28	21	11	9			○	
	14.20	14.50	65	28	21	14	11	●			
	14.20	14.50	100	28	21	14	11		○		
<b>1/2 x14</b>	14.20	14.50	150	28	21	14	11			○	
	17.60	18.00	80	35	25	18	14	●			
	17.60	18.00	150	35	25	18	14			○	
<b>3/4 x14</b>	23.00	23.30	85	35	25	23	17	○			
	23.00	23.30	150	35	25	23	17			○	
<b>1 x11</b>	28.80	29.25	95	45	32	36	21	○			
	28.80	29.25	150	45	32	36	21			○	
<b>1 1/4 x11</b>	37.30	37.80	105	45	32	32	26	○			
<b>1 1/2 x11</b>	43.40	44.00	110	45	32	38	29	○			
<b>2 x11</b>	55.50	56.00	120	50	35	46	35	○			

A with reaming before tapping / con alesatura prima della maschiatura  
 mit Benutzung einer Reibahle / avec alésage avant le taraudage ● stock standard ○ non-standard stock △ on request EX stock exhaustion  
 B without reaming before tapping / senza alesatura prima della maschiatura  
 ohne Benutzung einer Reibahle / sans alésage avant le taraudage



<b>Rc 1/8 ~ 3/8</b>	4	4	4
<b>1/2 ~ 3/4</b>	4		4
<b>1 ~ 1 1/4</b>	5		5
<b>1 1/2 ~ 2</b>	6		