

**UNC  
UNF**

**DIN371**

MATERIAL GROUP	Vc (m/min)	
	BR-OX-NX-NI	TiN-TiCN PV15
1-5	5~20	
6-7	5~10	
9-12	5~20	
13-14	8~12	
15-20	10~20	
21-23-25-26	5~10	
22-24	3~10	



MATERIAL GROUPS / GRUPPI MATERIALE WERKSTOFFEGRUPPE / GROUPES MATIÈRE									4 5 6 9-12 22 24	4 5 6 7 13 14 18-20 21 23 25 26	1-5 13 14 15-20	1-5 9 10
									48° HSS-P OX 2BX 3P	15° HSS-P NI 2BX 3P	40° HSSE BR 2B 2P-3P C	45° HSSE OX 2B 2P-3P C
D	UNC UNF	D(mm)	Ø	L	l	l1	d	k	Stock	Stock	Stock	Stock
Nr. 4	40	2.845	2.3	56	5	18	3.5	2.7	●	●	●	●
4	48	2.845	2.4	56	4.5	18	3.5	2.7				
5	40	3.175	2.6	56	5	18	3.5	2.7				
5	44	3.175	2.7	56	5	18	3.5	2.7				
6	32	3.505	2.8	56	6	20	4	3	●	●	●	●
6	40	3.505	2.9	56	6	20	4	3			●	
8	32	4.166	3.5	63	6.5	21	4.5	3.4	●	●	●	●
8	36	4.166	3.5	63	6.5	21	4.5	3.4			●	
10	24	4.826	3.9	70	8	25	6	4.9	●	●	●	●
10	32	4.826	4.1	70	8	25	6	4.9	●	●	●	●
12	24	5.486	4.5	80	8.5	25	6	4.9				
12	28	5.486	4.5	80	8.5	25	6	4.9				
1/4	20	6.35	5.2	80	10	30	7	5.5	●	●	●	●
1/4	28	6.35	5.5	80	8.5	30	7	5.5	●	●	●	●
5/16	18	7.938	6.6	90	11	35	8	6.2	●	●	●	●
3/8	16	9.525	8	100	13	39	9	7	●	●	●	●

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



Nr. 4 ~ 3/8

3

3

3

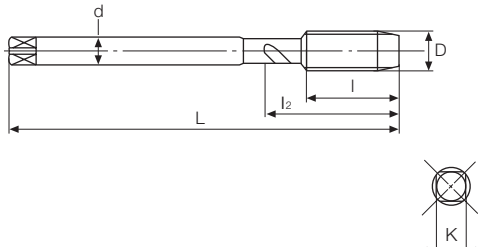
3

**UNC UNF**  
DIN376  
DIN374



MATERIAL GROUP	Vc (m/min)	
	BR-OX-NX-NI	TiN-TiCN PV15
1-5	5~20	
6-7	5~10	
9-12	5~20	
13-14	8~12	
15-20	10~20	
21-23-25-26	5~10	
22-24	3~10	



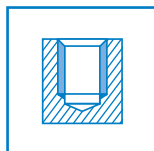
MATERIAL GROUPS / GRUPPI MATERIALE WERKSTOFFEGRUPPE / GROUPES MATIÈRE										4 5 6 9-12 22 24	4 5 6 7 13 14 18-20 21 23 25 26	1-5 13 14 15-20	1-5 9 10
										48° HSS-P OX 2BX 3P	15° HSS-P NI 2BX 3P	40° HSSE BR 2B 2P-3P C	45° HSSE OX 2B 2P-3P C
D	UNC UNF	D(mm)	Ø	L	l <sub>1</sub>	l <sub>2</sub>	d	k	Stock	Stock	Stock	Stock	
5/16	24	7.938	6.9	90	9	35	6	4.9	●	●	●	●	
3/8	24	9.525	8.5	100	9	39	7	5.5	●	●	●	●	
7/16	14	11.112	9.4	100	14	42	8	6.2			●	●	
7/16	20	11.112	9.9	100	14	42	8	6.2			●	●	
1/2	13	12.7	10.75	110	15	45	9	7	●	●	●	●	
1/2	20	12.7	11.5	100	15	45	9	7	●	●	●	●	
9/16	12	14.288	12.25	110	17	52	11	9			●	●	
9/16	18	14.288	12.9	100	17	52	11	9			●	●	
5/8	11	15.875	13.6	110	18	59	12	9	○ NEW	○	●	●	
5/8	18	15.875	14.5	100	17	59	12	9	○ NEW		●	●	
3/4	10	19.05	16.5	125	20	66	14	11	○ NEW	○	●	●	
3/4	16	19.05	17.5	110	17	66	14	11	○ NEW		●	●	
7/8	9	22.225	19.5	140	22	73	18	14.5	○ NEW		●	●	
7/8	14	22.225	20.5	125	18	73	18	14.5	○ NEW		●	●	
1	8	25.4	22.25	160	25	87	18	14.5	○ NEW		●	●	
1	12	25.4	23.3	140	18	87	18	14.5	○ NEW		●	●	
1 1/8	7	28.575	25	180	35	85	22	18				○ NEW	
1 1/8	12	28.575	26.5	150	22	70	22	18				○ NEW	
1 1/4	7	31.75	28	180	35	85	22	18				○ NEW	
1 1/4	12	31.75	29.5	150	22	70	22	18				○ NEW	
1 3/8	6	34.925	30.75	200	40	100	28	22				○ NEW	
1 3/8	12	34.925	32.75	170	24	80	28	22				○ NEW	
1 1/2	6	38.1	34	200	40	100	28	22				○ NEW	
1 1/2	12	38.1	36	170	24	80	28	22				○ NEW	

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



5/16 ~ 9/16	3	3	3	3
5/8	3	4	3	3
3/4 ~ 1 1/2	4	4	4	4

**UN-8**  
DIN376



MATERIAL GROUP	Vc (m/min)	
	BR-OX-NX-NI	TiN-TiCN PV15
1-5	5~15	
9-10	5~12	

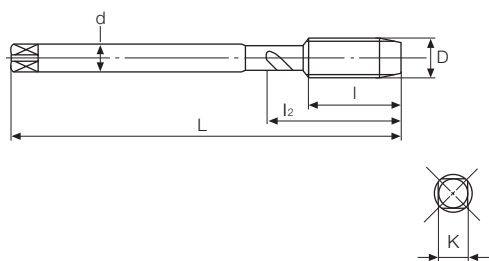
**NEW**

**94450X**  
SP-VA



MATERIAL GROUPS / GRUPPI MATERIALE  
WERKSTOFFEGRUPPE / GROUPES MATIÈRE

1-5 9 10



HSSE  
OX

2B



D	UN-8	D(mm)	Ø	L	l	l <sub>2</sub>	d	k	Stock
1 1/8	8	28.575	25.4	180	28	85	22	18	○
1 1/4	8	31.75	28.6	180	28	85	22	18	○
1 3/8	8	34.925	31.75	200	30	100	28	22	○
1 1/2	8	38.1	35	200	30	100	28	22	○
1 5/8	8	41.275	38.1	200	30	100	32	24	○
1 3/4	8	44.45	41.3	200	40	100	36	29	○
2	8	50.8	47.7	225	40	125	40	32	○

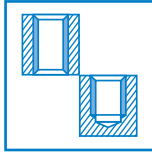
● stock standard ○ non-standard stock △ on request EX stock exhaustion



1 1/8 ~ 2

4

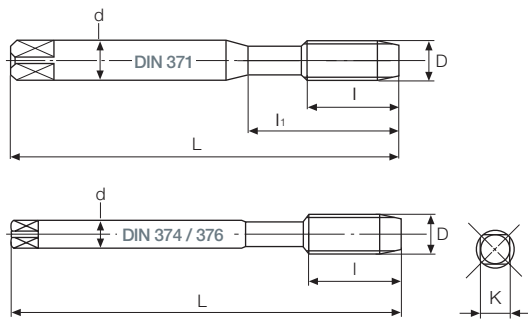
<b>UNC UNF</b>
DIN371 DIN374 DIN376



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

- STR
- HSSE
- BR
- 2B
- 2P-3P  
C

D	UNC UNF	D(mm)	Ø	L	l	l1	d	k	Stock
<b>• DIN371</b>									
Nr. 4	40	2.845	2.3	56	11	18	3.5	2.7	
4	48	2.845	2.4	56	11	18	3.5	2.7	
5	40	3.175	2.6	56	11	18	3.5	2.7	
5	44	3.175	2.7	56	11	18	3.5	2.7	
6	32	3.505	2.8	56	12	20	4	3	
6	40	3.505	2.9	56	12	20	4	3	
8	32	4.166	3.5	63	13	21	4.5	3.4	
8	36	4.166	3.5	63	13	21	4.5	3.4	
10	24	4.826	3.9	70	15	25	6	4.9	
10	32	4.826	4.1	70	14	25	6	4.9	
12	24	5.486	4.5	80	16	26	6	4.9	
12	28	5.486	4.6	80	15	26	6	4.9	
1/4	20	6.35	5.2	80	17	30	7	5.5	○
1/4	28	6.35	5.5	80	16	30	7	5.5	○
5/16	18	7.938	6.6	90	20	35	8	6.2	○
3/8	16	9.525	8	100	22	39	9	7	○
<b>• DIN374 - DIN376</b>									
5/16	24	7.938	6.9	90	17	6	4.9		○
3/8	24	9.525	8.5	100	18	7	5.5		○
7/16	14	11.112	9.4	100	22	8	6.2		○
7/16	20	11.112	9.9	100	20	8	6.2		○
1/2	13	12.7	10.75	110	25	9	7		○
1/2	20	12.7	11.5	100	22	9	7		○
9/16	12	14.288	12.25	110	25	11	9		○
9/16	18	14.288	12.9	100	22	11	9		○
5/8	11	15.875	13.6	110	28	12	9		○
5/8	18	15.875	14.5	100	22	12	9		○
3/4	10	19.05	16.5	125	32	14	11		○
3/4	16	19.05	17.5	110	25	14	11		○
7/8	9	22.225	19.5	140	32	18	14.5		○
7/8	14	22.225	20.5	125	26	18	14.5		○
1	8	25.4	22.25	160	36	18	14.5		○
1	12	25.4	23.3	140	28	18	14.5		○

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



Nr. 2	~4	2
5	~ 1/4	3
5/16	~1	4

UNC / UNF - UN-8  
UNJC / UNJF

**UNC  
UNF**

**DIN371**

MATERIAL GROUP	Vc (m/min)	
	BR-OX-NX-NI	TiN-TiCN PV15
1-5	5~20	
6-7	5~10	
9-12	5~20	
13-14	8~12	
15-20	10~20	
21-23-25-26	5~10	
22-24	3~10	



MATERIAL GROUPS / GRUPPI MATERIALE WERKSTOFFEGRUPPE / GROUPES MATIÈRE									4 5 6 7 9-12 22 23 24 25	4 5 6 7 13 14 18-20 21 23 25 26	1-5 13 14 15-20	1-5 9-11
									PO HSS-P NX 2BX 3.5P-5P B	L15° HSS-P NI 2BX 3.5P-5P D	PO HSSE BR 2B 3.5P-5P B	PO HSSE OX 2BX 3.5P-5P B
D	UNC UNF	D(mm)	Ø	L	l	l1	d	k	Stock	Stock	Stock	Stock
Nr. 4	40	2.845	2.3	56	11	18	3.5	2.7			●	●
4	48	2.845	2.4	56	11	18	3.5	2.7				
5	40	3.175	2.6	56	11	18	3.5	2.7				
5	44	3.175	2.7	56	11	18	3.5	2.7				
6	32	3.505	2.8	56	12	20	4	3	●		●	●
6	40	3.505	2.9	56	12	20	4	3			○	
8	32	4.166	3.5	63	13	21	4.5	3.4	●		●	●
8	36	4.166	3.5	63	13	21	4.5	3.4			○	
10	24	4.826	3.9	70	15	25	6	4.9	●		●	●
10	32	4.826	4.1	70	14	25	6	4.9	●		●	●
12	24	5.486	4.5	80	16	26	6	4.9				
12	28	5.486	4.6	80	15	26	6	4.9				
1/4	20	6.35	5.2	80	17	30	7	5.5	●		●	●
1/4	28	6.35	5.5	80	16	30	7	5.5	●		●	●
5/16	18	7.938	6.6	90	20	35	8	6.2	●		●	●
3/8	16	9.525	8	100	22	39	9	7	●		●	●

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



Nr. 4	~ 3/8	3	3	3	3
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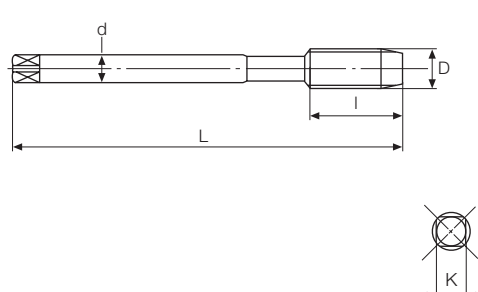
**UNC UNF**

**DIN376  
DIN374**



MATERIAL GROUP	Vc (m/min)	
	BR-OX-NX-NI	TiN-TiCN PV15
1-5	5~20	
6-7	5~10	
9-12	5~20	
13-14	8~12	
15-20	10~20	
21-23-25-26	5~10	
22-24	3~10	



MATERIAL GROUPS / GRUPPI MATERIALE WERKSTOFFEGRUPPE / GROUPES MATIÈRE									4 5 6 7 9-12 22 23 24 25	4 5 6 7 13 14 18-20 21 23 25 26	1-5 13 14 18-20	1-5 9-11
									PO HSS-P NX 2BX 3.5P-5P B	L15° HSS-P NI 2BX 3.5P-5P D	PO HSSE BR 2B 3.5P-5P B	PO HSSE OX 2BX 3.5P-5P B
D	UNC UNF	D(mm)	Ø	L	l	l1	d	k	Stock	Stock	Stock	Stock
5/16	24	7.938	6.9	90	17	-	6	4.9	●		●	●
3/8	24	9.525	8.5	100	18	-	7	5.5	●		●	●
7/16	14	11.112	9.4	100	22	-	8	6.2			●	○
7/16	20	11.112	9.9	100	20	-	8	6.2			●	○
1/2	13	12.7	10.75	110	25	-	9	7	●		●	●
1/2	20	12.7	11.5	100	22	-	9	7	●		●	○
9/16	12	14.288	12.25	110	25	-	11	9			●	○
9/16	18	14.288	12.9	100	22	-	11	9			●	○
5/8	11	15.875	13.6	110	28	-	12	9	○ NEW		●	●
5/8	18	15.875	14.5	100	22	-	12	9	○ NEW		●	○
3/4	10	19.05	16.5	125	32	-	14	11	○ NEW		●	○
3/4	16	19.05	17.5	110	25	-	14	11	○ NEW		●	○
7/8	9	22.225	19.5	140	32	-	18	14.5	○ NEW		●	○
7/8	14	22.225	20.5	125	26	-	18	14.5	○ NEW		●	○
1	8	25.4	22.25	160	36	-	18	14.5	○ NEW		●	○
1	12	25.4	23.3	140	28	-	18	14.5	○ NEW		●	○
1 1/8	7	28.575	25	180	40	-	22	18				
1 1/8	12	28.575	26.5	150	28	-	22	18				
1 1/4	7	31.75	28	180	40	-	22	18				
1 1/4	12	31.75	29.5	150	28	-	22	18				
1 3/8	6	34.925	30.75	200	50	-	28	22				
1 3/8	12	34.925	32.75	170	30	-	28	22				
1 1/2	6	38.1	34	200	50	-	28	22				
1 1/2	12	38.1	36	170	30	-	28	22				

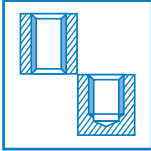
● stock standard ○ non-standard stock △ on request EX stock exhaustion



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

UNC / UNF - UN-8  
UNJC / UNJF

UNC  
UNF  
JIS  
NORM



MATERIAL GROUP	Vc (m/min)	
	BR-OX-NX-NI	TiN-TiCN PV15
1-5		20-40
9-10-11		10-30
15-20		20-40



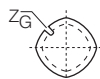
MATERIAL GROUPS / GRUPPI MATERIALE  
WERKSTOFFEGRUPPE / GROUPES MATIÈRE

1-5  
9-11 15-20

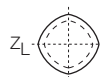
HP-RZ  
HSS-P  
TiCN  
2BX  
2P

D	UNC UNF	D(mm)	Ø	L	l	d	k	Stock
Nr. 2	56	2.184	1.93	42	9.5	3	2.5	△ (G4)
2	64	2.184	1.97	42	9.5	3	2.5	△ (G4)
3	48	2.515	2.22	44	9.5	3	2.5	△ (G4)
3	56	2.515	2.27	44	9.5	3	2.5	△ (G4)
4	40	2.845	2.53	44	11	3	2.5	△ (G5)
4	48	2.845	2.58	44	11	3	2.5	△ (G5)
5	40	3.175	2.86	46	11	4	3.2	△ (G5)
5	44	3.175	2.89	46	11	4	3.2	△ (G5)
6	32	3.505	3.11	48	13	4	3.2	△ (G5)
6	40	3.505	3.19	48	13	4	3.2	△ (G5)
8	32	4.166	3.77	52	13	5	4	△ (G6)
8	36	4.166	3.81	52	13	5	4	△ (G5)
10	24	4.826	4.3	60	16	5.5	4.5	△ (G6)
10	32	4.826	4.43	60	16	5.5	4.5	△ (G6)
12	24	5.486	4.96	60	17	5.5	4.5	△ (G6)
12	28	5.486	5.03	60	17	5.5	4.5	△ (G6)
1/4	20	6.35	5.78	62	19	6	4.5	△ (G7)
1/4	28	6.35	5.94	62	19	6	4.5k (G7)	△ (G7)

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



Nr. 2	~4	0
5	~ 1/4	2



Nr. 2~	1/4	4
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MATERIAL GROUP	Vc (m/min)	
	BR-OX-NX-NI	TiN-TiCN PV15
4-5	10~20	
6-7	5~10	
9-12	5~20	
14	8~12	
18-20	10~20	
21-23-25-26	5~10	
22-24	3~10	



MATERIAL GROUPS / GRUPPI MATERIALE WERKSTOFFEGRUPPE / GROUPES MATIÈRE										4 5 6 7	4 5 6	4 5 6 7	4 5 6 7	
										9-12	9-12 22 24	13 14 18-20	13 14 18-20	
										22 23 24 25		21 23 25 26	21 23 25 26	
										PO	48°	L15°	15°	
										HSS-P NX	HSS-P OX	HSS-P NI	HSS-P NI	
										3BX	3BX	3BX	3BX	
										3.5P-5P B	3P	3.5P-5P D	3P	
D	UNJC	UNJF	D(mm)	Ø	L	l	*	l1	d	k	Stock	Stock	Stock	Stock
<b>• DIN371</b>														
Nr. 4	40		2.745	2.3	56	5	11	18	3.5	2.7				
4	48		2.745	2.4	56	4.5	11	18	3.5	2.7				
6	32		3.505	2.85	56	6	12	20	4	3	○	○	○	○
6	40		3.505	3	56	6	12	20	4	3				
8	32		4.166	3.5	63	6.5	13	21	4.5	3.4	○	○	○	○
8	36		4.166	3.55	63	6.5	13	21	4.5	3.4				
10	24		4.826	3.93	70	8	15	25	6	4.9	○	○	○	○
10	32		4.826	4.15	70	8	14	25	6	4.9	● NEW	● NEW	● NEW	● NEW
1/4	20		6.35	5.25	80	10	17	30	7	5.5	○	○	○	○
1/4	28		6.35	5.55	80	8.5	17	30	7	5.5	● NEW	● NEW	● NEW	● NEW
5/16	18		7.938	6.7	90	11	20	35	8	6.2	○	○	○	○
3/8	16		9.525	8.1	100	13	22	39	9	7	○	○	○	○
<b>• DIN374</b>														
5/16	24		7.938	7	90	9	17		6	4.9	● NEW	● NEW	● NEW	● NEW
3/8	24		9.525	8.6	100	9	18		7	5.5	● NEW	● NEW	● NEW	● NEW

\*l-ZEN-P / ZET-P

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



Nr. 4 ~ 3/8

3 3 3 3