

## ダイス Dies

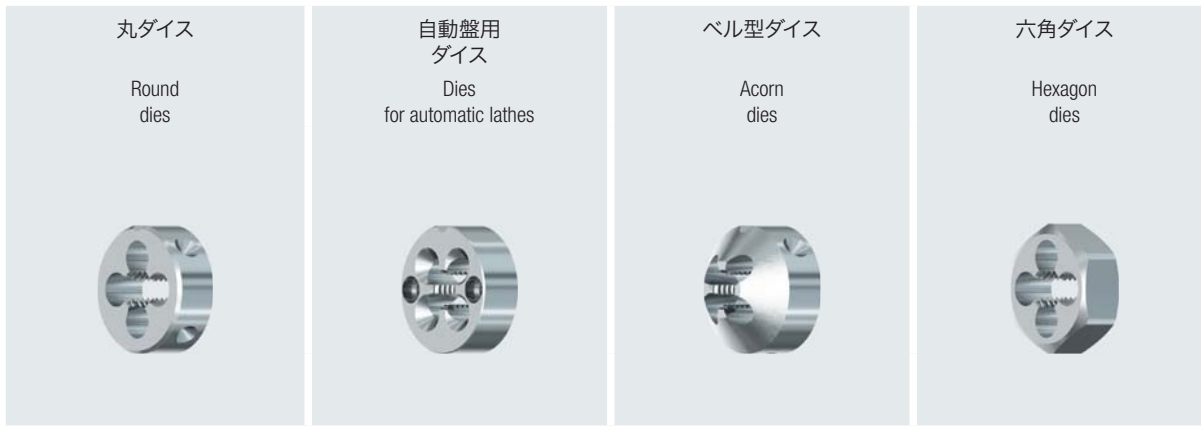
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Product Finder
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BSW, BSF
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Zubehör Accessories





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Product Finder

V<sub>c</sub>

M

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Accessories

## 推奨アプリケーションと 切削条件

**注記:**  
表中の切削速度(v<sub>c</sub> in m/min)は推奨値です。個々の加工環境(被削材、切削油、機械など)に合わせて適宜調整してください。


切削速度の推奨値は呼び径 10 mm の場合を基準にしています。

 = 食付き山数 (チャンファー長さ)

## Application recommendation and cutting data

**Please note:**  
The cutting speeds (v<sub>c</sub> in m/min) listed in the respective columns are standard values which have to be adjusted to individual work conditions (material, lubrication, machine etc.).

The recommended cutting speeds are related to a nominal thread diameter of 10 mm.

 = Chamfer length

材料規格対照表は 764 - 785 ページをご覧ください

International comparison of materials, see page 764 - 785

適用範囲 - 被削材 Applications - material		引張り強さ Tensile Strength	材種例(DIN他) Material examples	材種例(JIS他) Material examples			
P	<b>鋼</b> 1.1 冷間押し出し鋼 機械構造用炭素鋼 快削鋼	Steel materials Cold-extrusion steels, Construction steels, Free-cutting steels, etc.	Cg15 S235JR (St37-2) 10SPb20	SPC, SPH, SS400, STKM, SUM22, SWRCH, SWRM			
	2.1 機械構造用炭素鋼 浸炭鋼 鋳鋼	Construction steels, Cementation steels, Steel castings, etc.	E360 (St70-2) 16MnCr5 GS-25CrMo4	S35C, S45C, SCr415H, SCMn, SMn438, SUM24L			
	3.1 浸炭鋼 熱処理鋼 冷間鍛造鋼	Cementation steels, Heat-treatable steels, Cold work steels, etc.	20MoCr3 42CrMo4 102Cr6	SACM, SCM415H, SCM440H, SCMn, SCPH, SCr440H, SUJ2			
	4.1 熱処理鋼 冷間鍛造鋼 窒化鋼	Heat-treatable steels, Cold work steels, Nitriding steels, etc.	50CrMo4 X45NiCrMo4 31CrMo12	SCM445H, SKH, SKS, SKT, SUP			
	5.1 高合金鋼 合金工具鋼 (冷間金型用) 合金工具鋼 (熱間金型用)	High-alloyed steels, Cold work steels, Hot work steels, etc.	X38CrMoV5-3 X100CrMoV8-1-1 X40CrMoV5-1	SKD12, SKD61, SKT, SUH, SKH			
	M	<b>ステンレス</b> 1.1 フェライト、マルテンサイト 2.1 オーステナイト 3.1 オーステナイト/フェライト 二相系、析出硬化系 4.1 オーステナイト/フェライト 二相系、析出硬化系	Stainless steel materials Ferritic, martensitic Austenitic Austenitic-ferritic (Duplex) Austenitic-ferritic heat-resistant (Super Duplex)	X2CrTi12 X6CrNiMoTi17-12-2 X2CrNiMoN22-5-3 X2CrNiMoN25-7-4	SCS, SUS420J2, SUS403 SCS, SUH, SUS304, SUS316 SUS329J3L, SUS630, 15-5PH SUS329J4L, SCS14A,		
K		<b>鋳鉄</b> 1.1 ねずみ鋳鉄 1.2 2.1 ダクタイル鋳鉄 2.2 3.1 ハミキュラー鋳鉄 3.2 4.1 可鍛鋳鉄 4.2	Cast materials Cast iron with lamellar graphite (GJL) Cast iron with nodular graphite (GJS) Cast iron with vermicular graphite (GJV) Malleable cast iron (GTMW, GTMB)	EN-GJL-200 (GG20) EN-GJL-300 (GG30) EN-GJS-400-15 (GGG40) EN-GJS-700-2 (GGG70) GJV 300 GJV 450 EN-GJMW-350-4 (GTW-35) EN-GJMB-450-6 (GTS-45)	FC200 FC300 FCD400 FCD700 FCV300 FCV400 FCMW330 FCMW370		
		N	<b>非鉄</b> アルミニウム合金 1.1 1.2 アルミニウム合金 展伸材 1.3 1.4 1.5 アルミニウム合金 鋳物 1.6 銅合金 2.1 純銅、低合金銅 2.2 黄銅 2.3 快削黄銅 2.4 アルミ青銅 2.5 青銅 2.6 快削青銅 2.7 2.8 特殊銅合金 マグネシウム合金 3.1 マグネシウム合金 3.2 マグネシウム合金鋳物 合成樹脂 4.1 熱硬化性樹脂 4.2 熱可塑性樹脂 4.3 繊維強化樹脂 (繊維含有量<30%) 4.4 繊維強化樹脂 (繊維含有量>30%) 特殊材料 5.1 グラファイト 5.2 タングステン-銅合金 5.3 複合材料	Non ferrous materials Aluminium alloys Aluminium wrought alloys Aluminium cast alloys Copper alloys Pure copper, low-alloyed copper Copper-zinc alloys (brass, long-chipping) Copper-zinc alloys (brass, short-chipping) Copper-aluminium alloys (alu bronze, long-chipping) Copper-tin alloys (tin bronze, long-chipping) Copper-tin alloys (tin bronze, short-chipping) Special copper alloys Magnesium alloys Magnesium wrought alloys Magnesium cast alloys Synthetics Duroplastics (short-chipping) Thermoplastics (long-chipping) Fibre-reinforced synthetics (fibre content ≤ 30%) Fibre-reinforced synthetics (fibre content > 30%) Special materials Graphite Tungsten-copper alloys Composite materials	EN AW-AlMn1 EN AW-AlMgSi EN AW-AlZn5Mg3Cu EN AC-AlMg5 EN AC-AISi9Cu3 GD-AISi17Cu4FeMg E-Cu 57 CuZn37 (Ms63) CuZn36Pb3 (Ms58) CuAl10Ni5Fe4 CuSn8P CuSn7 ZnPb (Rg7) (AMP-CO® 8) (AMP-CO® 45) MgAl6Zn EN-MCMgAl9Zn1 Bakelit, Pertinax PMMA, POM, PVC GFK, CFK, AFK GFK, CFK, AFK C 8000 W-Cu 80/20 Hyllite, Alucobond	A1050, A3030 A5052, A6061 A7075 ADC5, AC7A ADC11, ADC12, AC2A ADC14 純銅, C2400 C2720, C2801 C3560, C3710 C5210, C6280 LBC3 BC3 MC2A, MD1A	
			S	<b>耐熱合金</b> チタン合金 1.1 純チタン 1.2 1.3 チタン合金 ニッケル基合金、コバルト基合金、鉄基合金 2.1 純ニッケル 2.2 2.3 ニッケル基合金 2.4 コバルト基合金 2.5 2.6 鉄基合金	Special materials Titanium alloys Pure titanium Titanium alloys Nickel alloys, cobalt alloys and iron alloys Pure nickel Nickel-base alloys Cobalt-base alloys Iron-base alloys	Ti1 TiAl6V4 TiAl4Mo4Sn2 Ni 99.6 Monel 400 Inconel 718 Udimet 605 Haynes 25 Incoloy 800	純チタン Ti-6Al-4V TiAl4Mo4Sn2 純ニッケル モネル 400, ハステロイ B インコネル 718 Udimet 605 ヘインズ 25 インコロイ 800
	H			<b>高硬度鋼</b> 1.1 1.2 1.3 高強度鋼、高硬度鋼、高硬度鋳鉄 1.4 1.5	Hard materials High strength steels, hardened steels, hard castings	Weldox 1100 Hardox 550 Armox 600T Ferro-Titanit HSSE	SKT4 ハードックス550 SKD61 SKD11



**EMUGE**  
-STEEL-

**EMUGE**  
-VA-

**EMUGE**  
-MS-

**EMUGE**  
-STEEL-



Product  
Finder

V<sub>C</sub>

M

MF

UNC

UNF

UNEF

NPT, NPTF

R

BSW, BSF

R

BSW

BSF

Tr, Tr-F

Zubehör

Accessories

SE-B nor STEEL		SE-B gel STEEL		SE-B nor VA		SE-B gel VA		SE-B gel MS		SE-AUT-LD gel STEEL		vc [m/min]		
min.	推奨 rec.	max.		min.	推奨 rec.	max.		min.	推奨 rec.	max.				
1,5			1,5	2			2	1			1,5			
520			520	521			521	522			523			
526			526	527			527							
528			528											
529			529											
530			530					531						
531			531											
536														
537														
min. 推奨 rec. max.		min. 推奨 rec. max.		min. 推奨 rec. max.		min. 推奨 rec. max.		min. 推奨 rec. max.		min. 推奨 rec. max.		vc [m/min]		
1	<b>5</b>	8	1	<b>5</b>	8	1	<b>5</b>	8	1	<b>5</b>	8	1.1		
1	<b>3</b>	5	1	<b>3</b>	5	1	<b>3</b>	5	1	<b>3</b>	5	2.1		
1	<b>2</b>	3	1	<b>2</b>	3	1	<b>2</b>	3	1	<b>2</b>	3	3.1		
												4.1		
												5.1		
			1	<b>2</b>	4	1	<b>2</b>	4				1.1		
			1	<b>2</b>	4	1	<b>2</b>	4				2.1		
												3.1		
												4.1		
2	<b>5</b>	10	2	<b>5</b>	10				2	<b>5</b>	10	1.1		
2	<b>5</b>	10	2	<b>5</b>	10				2	<b>5</b>	10	1.2		
2	<b>5</b>	10	2	<b>5</b>	10				2	<b>5</b>	10	2.1		
2	<b>5</b>	10	2	<b>5</b>	10				2	<b>5</b>	10	2.2		
												3.1		
												3.2		
												4.1		
												4.2		
			10	<b>15</b>	20				10	<b>15</b>	20	1.1		
			10	<b>15</b>	20				10	<b>15</b>	20	1.2		
			10	<b>15</b>	20				10	<b>15</b>	20	1.3		
			10	<b>15</b>	20				10	<b>15</b>	20	1.4		
												1.5		
												1.6		
			10	<b>15</b>	20				10	<b>15</b>	20	2.1		
			10	<b>15</b>	20				10	<b>15</b>	20	2.2		
			10	<b>15</b>	25			10	<b>15</b>	25		2.3		
			1	<b>5</b>	8			1	<b>5</b>	8		2.4		
												2.5		
												2.6		
												2.7		
												2.8		
												3.1		
												3.2		
			1	<b>5</b>	8			10	<b>15</b>	25	1	<b>5</b>	8	4.1
													4.2	
													4.3	
													4.4	
													5.1	
													5.2	
													5.3	
													1.1	
													1.2	
													1.3	
													2.1	
													2.2	
													2.3	
													2.4	
													2.5	
													2.6	
													1.1	
													1.2	
													1.3	
													1.4	
													1.5	



		EMUGE -STEEL-	EMUGE -MS-	EMUGE -STEEL-	KEG	EMUGE -STEEL-	TRAPEZ	EMUGE -STEEL-
Product Finder								
V <sub>c</sub>								
M								
MF								
UNC								
UNF UNEF		SE-GLOCK gel STEEL	SE-GLOCK gel MS	SE-6KT nor STEEL		SE-KEG nor STEEL		TRAPEZ SE-B-nor STEEL
M		1	1	1,5		1,5		1,5-2
MF		524		525				
UNC								
UNF UNEF								
G			532					
NPT, NPTF R						533		
BSW, BSF						534		
Tr, Tr-F						535		
Zubehör Accessories								538 539
v <sub>c</sub> [m/min]		min. 推奨 rec. max.	min. 推奨 rec. max.	min. 推奨 rec. max.		min. 推奨 rec. max.		min. 推奨 rec. max.
P	1.1	1 5 8		1 5 8		1 2 3		1 2 3 1)
	2.1	1 3 5		1 3 5		1 3 5		
	3.1	1 2 3		1 2 3		1 2 3		
	4.1							
	5.1							
M	1.1							
	2.1							
	3.1							
	4.1							
K	1.1	2 5 10		2 5 10		1 3 5		
	1.2	2 5 10		2 5 10		1 3 5		
	2.1	2 5 10		2 5 10		1 3 5		
	2.2	2 5 10		2 5 10		1 3 5		
	3.1							
	3.2							
	4.1							
4.2								
N	1.1	10 15 20						
	1.2	10 15 20						
	1.3	10 15 20						
	1.4	10 15 20						
	1.5							
	1.6							
	2.1	10 15 20						
	2.2	10 15 20						
	2.3		10 15 25			1 3 5		1 2 3 1)
	2.4	1 5 8						
	2.5							
	2.6							
	2.7							
	2.8							
	3.1							
3.2								
4.1		10 15 25			1 3 5			
4.2	1 5 8							
4.3								
4.4								
5.1								
5.2								
5.3								
S	1.1							
	1.2							
	1.3							
	2.1							
	2.2							
	2.3							
	2.4							
2.5								
2.6								
H	1.1							
	1.2							
	1.3							
	1.4							
	1.5							





Product Finder
V <sub>c</sub>
M
MF
UNC
UNF UNEF
G
NPT, NPTF R
BSW, BSF
Tr, Tr-F
Zubehör Accessories

エムゲ社ではほとんど全てのアプリケーション用にねじロール、ウォームギアロール、ローレットロールとセレーションロールを提供しています。

### プロセスの特性：

- 切りくずが出ない
- 外径の加工
- 材料変位による形状加工
- 高合金鋼製のロールを使用

### プロセスに必要な条件：

- 破断伸び  $\geq 8\%$  の被削材
- シャフトブランク径の調整が必要

### プロセスの利点：

- 材料の高密度化を伴うスムーズな表面性状
- 面精度  $R_a 0.2$  レベルが可能
- 反応表面が減少することで耐食性が向上
- 途切れのない結晶粒構造
- プロファイルの静的・動的強度の向上
- 高い寸法精度と形状精度
- 外径が盛り上がり形成されるため材料のシャフト径が小さく、材料の節減効果が極めて大きい
- 短い加工時間

ロール加工されたねじは強度が高く、優れた耐摩耗性と耐食性を持ちます。さらに、一般的に転造加工は極めて加工時間が短く、その経済性の高さが大きなメリットとして注目されています。

### 評価すべき課題：

- ねじの大径は不完全形状となる
- 専用の設備が必要

さらなる詳細については弊社までお問い合わせください

EMUGE offers you a comprehensive programme of thread rolls, worm rolls, knurling rolls and serration rolls for practically all application cases.

### Process characteristics:

- Chipless process
- External machining
- Production of profile contours by material displacement
- Rolls made of high-alloyed tool steel

### Requirements:

- Workpiece materials with a breaking elongation  $\geq 8\%$
- Specially adjusted blank diameters are necessary for rolling

### Advantages:

- Smooth rolled surfaces achieved by densification of the material structure
- Surface quality grade  $R_a 0.2$  on the rolled profile
- Increased corrosion resistance due to reduced reaction surfaces
- Uninterrupted grain structure
- Increased static and dynamic strength of the profile
- High dimensional and form precision
- Considerable material savings, since work does not start from the major diameter of the workpiece but from its pitch, or preparatory diameter
- Short machining times

This means that rolled threads can better withstand stress: they show increased wear resistance, and are better protected against corrosion. Another advantage which deserves attention lies in the possibility of improving economic efficiency in thread production by the extremely short machining times which are common in thread rolling.

### Disadvantages:

- Incompletely formed major diameter
- Special machines are necessary

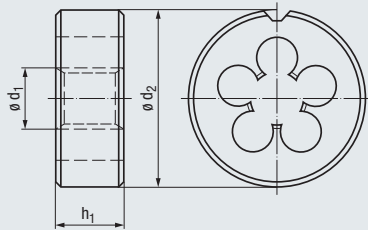
For further information please get in touch with your sales contact.

- Product Finder
- V<sub>c</sub>
- M
- MF
- UNC
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UNEF
- G
- NPT, NPTF  
R
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- Tr, Tr-F
- Zubehör  
Accessories



**M**  
DIN 13

DIN EN  
22568



シャフト径  $d \approx$   
Preparatory diameter  $d \approx$



**STEEL**  
鋼



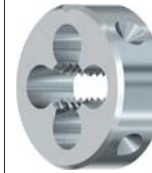
スタンダード  
standard



ラップ  
lapped



スタンダード  
standard

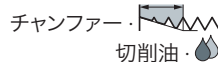


スタンダード  
standard



公差・Tolerance  
母材・Cutting material

技術情報  
Technical information



6g <sup>*)</sup>	6g <sup>*)</sup>	<b>6e</b>	6g
HSS	HSS	HSS	HSS
1,5	1,5	1,5	<b>左ねじ</b> 1,5
E/O	E/O	E/O	E/O

アプリケーション - 被削材  
Applications - material



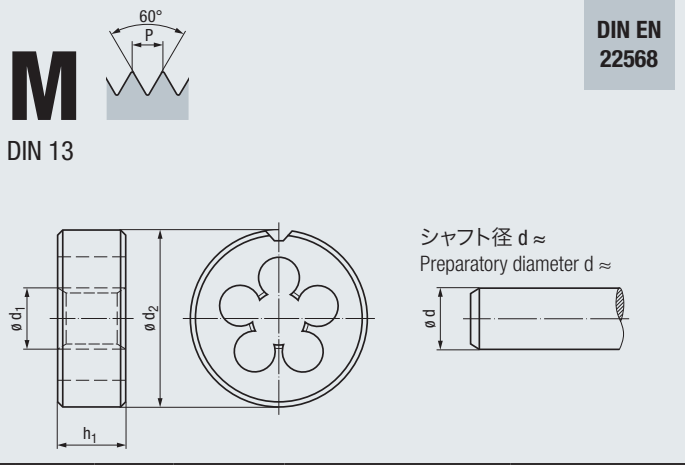
<b>P</b> 1.1-3.1	<b>P</b> 1.1-3.1	<b>P</b> 1.1-3.1	<b>P</b> 1.1-3.1
<b>K</b> 1.1-2.2	<b>M</b> 1.1-2.1	<b>K</b> 1.1-2.2	<b>K</b> 1.1-2.2
	<b>N</b> 1.1-1.4		
	<b>N</b> 2.1-2.4, 4.2		

M	$\phi d_1$ mm	P mm	$\phi d_2$	x	h <sub>1</sub>	$\phi d \approx$			SE-B nor STEEL	SE-B gel STEEL	SE-B nor STEEL	SE-B nor STEEL-LH
						4h	6g	6e				
	1	0,25	16	x	5	0,98	0,97	0,93	D0101000.0010	D0101500.0010		
	1,1	0,25	16	x	5	1,08	1,07	1,03	D0101000.0011	D0101500.0011		
	1,2	0,25	16	x	5	1,18	1,17	1,13	D0101000.0012	D0101500.0012		
	1,4	0,3	16	x	5	1,38	1,36	1,32	D0101000.0014	D0101500.0014		
	1,6	0,35	16	x	5	1,57	1,54	1,51	D0101000.0016	D0101500.0016		
	1,7	0,35	16	x	5	1,67	1,64	1,61	D0101000.0017	D0101500.0017		
	1,8	0,35	16	x	5	1,77	1,74	1,71	D0101000.0018	D0101500.0018		
	2	0,4	16	x	5	1,97	1,93	1,90	D0101000.0020	D0101500.0020		
	2,2	0,45	16	x	5	2,16	2,13	2,10	D0101000.0022	D0101500.0022	D0101030.0022	D0101050.0022
	2,3	0,4	16	x	5	2,26	2,23	2,20	D0101000.0023	D0101500.0023		D0101050.0023
	2,5	0,45	16	x	5	2,46	2,43	2,40	D0101000.0025	D0101500.0025	D0101030.0025	D0101050.0025
	2,6	0,45	16	x	5	2,56	2,53	2,50	D0101000.0026	D0101500.0026		D0101050.0026
	3	0,5	20	x	5	2,96	2,92	2,89	D0101000.0030	D0101500.0030	D0101030.0030	D0101050.0030
	3,5	0,6	20	x	5	3,46	3,41	3,38	D0101000.0035	D0101500.0035	D0101030.0035	D0101050.0035
	4	0,7	20	x	5	3,95	3,90	3,87	D0101000.0040	D0101500.0040	D0101030.0040	D0101050.0040
	4,5	0,75	20	x	7	4,45	4,40	4,37	D0101000.0045	D0101500.0045		
	5	0,8	20	x	7	4,95	4,90	4,86	D0101000.0050	D0101500.0050	D0101030.0050	D0101050.0050
	6	1	20	x	7	5,94	5,88	5,85	D0101000.0060	D0101500.0060	D0101030.0060	D0101050.0060
	7	1	25	x	9	6,94	6,88	6,85	D0101000.0070	D0101500.0070	D0101030.0070	D0101050.0070
	8	1,25	25	x	9	7,93	7,86	7,83	D0101000.0080	D0101500.0080	D0101030.0080	D0101050.0080
	9	1,25	25	x	9	8,93	8,86	8,83	D0101000.0090	D0101500.0090		
	10	1,5	30	x	11	9,92	9,85	9,81	D0101000.0100	D0101500.0100	D0101030.0100	D0101050.0100
	11	1,5	30	x	11	10,92	10,85	10,81	D0101000.0111	D0101500.0111		
	12	1,75	38	x	14	11,91	11,83	11,81	D0101000.0112	D0101500.0112	D0101030.0112	D0101050.0112
	14	2	38	x	14	13,91	13,82	13,78	D0101000.0114	D0101500.0114	D0101030.0114	D0101050.0114
	16	2	45	x	18	15,91	15,82	15,78	D0101000.0116	D0101500.0116	D0101030.0116	D0101050.0116
	18	2,5	45	x	18	17,89	17,79	17,75	D0101000.0118	D0101500.0118		D0101050.0118
	20	2,5	45	x	18	19,89	19,79	19,75	D0101000.0120	D0101500.0120		D0101050.0120
	22	2,5	55	x	22	21,89	21,79	21,75	D0101000.0122	D0101500.0122		D0101050.0122
	24	3	55	x	22	23,88	23,76	23,72	D0101000.0124	D0101500.0124		D0101050.0124
	27	3	65	x	25	26,88	26,76	26,72	D0101000.0127	D0101500.0127		
	30	3,5	65	x	25	29,87	29,73	29,70	D0101000.0130	D0101500.0130		
	33	3,5	65	x	25	32,87	32,73	32,70	D0101000.0133	D0101500.0133		
	36	4	65	x	25	35,85	35,70	35,66	D0101000.0136	D0101500.0136		
	39	4	75	x	30	38,85	38,70	38,66	D0101000.0139	D0101500.0139		
	42	4,5	75	x	30	41,84	41,68	41,65	D0101000.0142	D0101500.0142		
	45	4,5	90	x	36	44,84	44,68	44,65	D0101000.0145	D0101500.0145		
	48	5	90	x	36	47,83	47,66	47,62	D0101000.0148	D0101500.0148		
	52	5	90	x	36	51,83	51,66	51,62	D0101000.0152	D0101500.0152		

<sup>\*)</sup> ≤ M1,4 Tol. 6h

公差 4h 用も特殊対応致します  
Tolerance class 4h upon request





技術情報  
Technical information

公差・Tolerance  
母材・Cutting material

チャンファー・ 切削油・

アプリケーション - 被削材  
Applications - material

▶ 516

VA ステンレス	
スタンダード standard	ラップ lapped
6g HSSE	6g HSSE
2 E/O/P	2 E/O/P
<b>P</b> 1.1-3.1 <b>M</b> 1.1-2.1	<b>P</b> 1.1-3.1 <b>M</b> 1.1-2.1 <b>N</b> 1.1-1.4 <b>N</b> 2.1-2.2, 2.4 <b>N</b> 4.2

- Product Finder
- V<sub>c</sub>
- M
- MF
- UNC
- UNF  
UNEF
- G
- NPT, NPTF  
R
- BSW, BSF
- Tr, Tr-F
- Zubehör  
Accessories

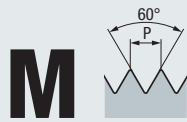
M	$\phi d_1$ mm	P mm	$\phi d_2$	x	h <sub>1</sub>	$\phi d \approx$			SE-B nor VA	SE-B gel VA
						4h	6g	6e		
	1	0,25	16	x	5	0,98	0,97	0,93		
	1,1	0,25	16	x	5	1,08	1,07	1,03		
	1,2	0,25	16	x	5	1,18	1,17	1,13		
	1,4	0,3	16	x	5	1,38	1,36	1,32		
	1,6	0,35	16	x	5	1,57	1,54	1,51		
	1,7	0,35	16	x	5	1,67	1,64	1,61		
	1,8	0,35	16	x	5	1,77	1,74	1,71		
	2	0,4	16	x	5	1,97	1,93	1,90	D0103000.0020	D0103500.0020
	2,2	0,45	16	x	5	2,16	2,13	2,10		
	2,3	0,4	16	x	5	2,26	2,23	2,20	D0103000.0023	D0103500.0023
	2,5	0,45	16	x	5	2,46	2,43	2,40	D0103000.0025	D0103500.0025
	2,6	0,45	16	x	5	2,56	2,53	2,50		
	3	0,5	20	x	5	2,96	2,92	2,89	D0103000.0030	D0103500.0030
	3,5	0,6	20	x	5	3,46	3,41	3,38	D0103000.0035	D0103500.0035
	4	0,7	20	x	5	3,95	3,90	3,87	D0103000.0040	D0103500.0040
	4,5	0,75	20	x	7	4,45	4,40	4,37		
	5	0,8	20	x	7	4,95	4,90	4,86	D0103000.0050	D0103500.0050
	6	1	20	x	7	5,94	5,88	5,85	D0103000.0060	D0103500.0060
	7	1	25	x	9	6,94	6,88	6,85	D0103000.0070	D0103500.0070
	8	1,25	25	x	9	7,93	7,86	7,83	D0103000.0080	D0103500.0080
	9	1,25	25	x	9	8,93	8,86	8,83		
	10	1,5	30	x	11	9,92	9,85	9,81	D0103000.0100	D0103500.0100
	11	1,5	30	x	11	10,92	10,85	10,81		
	12	1,75	38	x	14	11,91	11,83	11,81	D0103000.0112	D0103500.0112
	14	2	38	x	14	13,91	13,82	13,78	D0103000.0114	D0103500.0114
	16	2	45	x	18	15,91	15,82	15,78	D0103000.0116	D0103500.0116
	18	2,5	45	x	18	17,89	17,79	17,75	D0103000.0118	D0103500.0118
	20	2,5	45	x	18	19,89	19,79	19,75	D0103000.0120	D0103500.0120
	22	2,5	55	x	22	21,89	21,79	21,75	D0103000.0122	D0103500.0122
	24	3	55	x	22	23,88	23,76	23,72	D0103000.0124	D0103500.0124
	27	3	65	x	25	26,88	26,76	26,72	D0103000.0127	D0103500.0127
	30	3,5	65	x	25	29,87	29,73	29,70	D0103000.0130	D0103500.0130
	33	3,5	65	x	25	32,87	32,73	32,70		
	36	4	65	x	25	35,85	35,70	35,66		
	39	4	75	x	30	38,85	38,70	38,66		
	42	4,5	75	x	30	41,84	41,68	41,65		
	45	4,5	90	x	36	44,84	44,68	44,65		
	48	5	90	x	36	47,83	47,66	47,62		
	52	5	90	x	36	51,83	51,66	51,62		



Typ EM-SE 丸ダイス用クイックチェンジアダプタは 737 ページをご覧ください

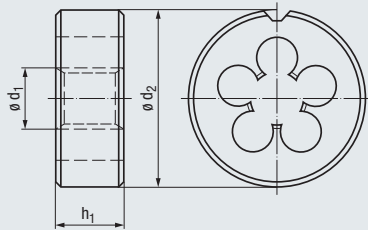
Quick-change adapters for round dies type EM-SE, see page 737

- Product Finder
- V<sub>c</sub>
- M
- MF
- UNC
- UNF  
UNEF
- G
- NPT, NPTF  
R
- BSW, BSF
- Tr, Tr-F
- Zubehör  
Accessories



**M**  
DIN 13

**DIN EN  
22568**



シャフト径  $d \approx$   
Preparatory diameter  $d \approx$



**MS**  
黄銅



ラップ  
lapped



技術情報  
Technical information

公差・Tolerance  
母材・Cutting material

チャンファー : 切削油・

6g

HSS

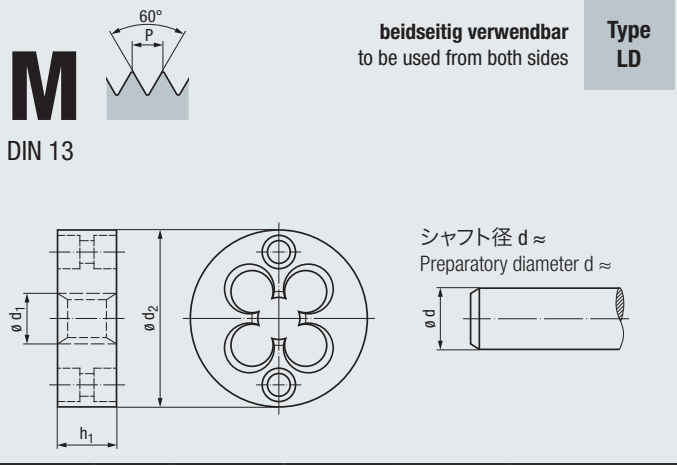
1

E / O

**N 2.3.4.1**

アプリケーション - 被削材  
Applications - material 516

M	$\phi d_1$ mm	P mm	$\phi d_2$	x	$h_1$	$\phi d \approx$			SE-B gel MS
						4h	6g	6e	
	1	0,25	16	x	5	0,98	0,97	0,93	
	1,1	0,25	16	x	5	1,08	1,07	1,03	
	1,2	0,25	16	x	5	1,18	1,17	1,13	
	1,4	0,3	16	x	5	1,38	1,36	1,32	
	1,6	0,35	16	x	5	1,57	1,54	1,51	
	1,7	0,35	16	x	5	1,67	1,64	1,61	
	1,8	0,35	16	x	5	1,77	1,74	1,71	
	2	0,4	16	x	5	1,97	1,93	1,90	<b>D0102500.0020</b>
	2,2	0,45	16	x	5	2,16	2,13	2,10	D0102500.0022
	2,3	0,4	16	x	5	2,26	2,23	2,20	D0102500.0023
	2,5	0,45	16	x	5	2,46	2,43	2,40	<b>D0102500.0025</b>
	2,6	0,45	16	x	5	2,56	2,53	2,50	D0102500.0026
	3	0,5	20	x	5	2,96	2,92	2,89	<b>D0102500.0030</b>
	3,5	0,6	20	x	5	3,46	3,41	3,38	<b>D0102500.0035</b>
	4	0,7	20	x	5	3,95	3,90	3,87	<b>D0102500.0040</b>
	4,5	0,75	20	x	7	4,45	4,40	4,37	
	5	0,8	20	x	7	4,95	4,90	4,86	<b>D0102500.0050</b>
	6	1	20	x	7	5,94	5,88	5,85	<b>D0102500.0060</b>
	7	1	25	x	9	6,94	6,88	6,85	<b>D0102500.0070</b>
	8	1,25	25	x	9	7,93	7,86	7,83	<b>D0102500.0080</b>
	9	1,25	25	x	9	8,93	8,86	8,83	
	10	1,5	30	x	11	9,92	9,85	9,81	<b>D0102500.0100</b>
	11	1,5	30	x	11	10,92	10,85	10,81	
	12	1,75	38	x	14	11,91	11,83	11,81	<b>D0102500.0112</b>
	14	2	38	x	14	13,91	13,82	13,78	D0102500.0114
	16	2	45	x	18	15,91	15,82	15,78	D0102500.0116
	18	2,5	45	x	18	17,89	17,79	17,75	D0102500.0118
	20	2,5	45	x	18	19,89	19,79	19,75	D0102500.0120
	22	2,5	55	x	22	21,89	21,79	21,75	
	24	3	55	x	22	23,88	23,76	23,72	
	27	3	65	x	25	26,88	26,76	26,72	
	30	3,5	65	x	25	29,87	29,73	29,70	
	33	3,5	65	x	25	32,87	32,73	32,70	
	36	4	65	x	25	35,85	35,70	35,66	
	39	4	75	x	30	38,85	38,70	38,66	
	42	4,5	75	x	30	41,84	41,68	41,65	
	45	4,5	90	x	36	44,84	44,68	44,65	
	48	5	90	x	36	47,83	47,66	47,62	
	52	5	90	x	36	51,83	51,66	51,62	



**STEEL**  
鋼

ラップ  
lapped

- Product Finder
- V<sub>c</sub>
- M
- MF
- UNC
- UNF  
UNEF
- G
- NPT, NPTF  
R
- BSW, BSF
- Tr, Tr-F
- Zubehör  
Accessories

技術情報  
Technical information

6g *)
HSS
1,5
E / O

アプリケーション – 被削材  
Applications – material

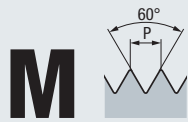
- P** 1.1-3.1
- K** 1.1-2.2
- N** 1.1-1.4
- N** 2.1-2.2, 2.4
- N** 4.2

M	ø d <sub>1</sub> mm	P mm	ø d <sub>2</sub>	x	h <sub>1</sub>	ø d ≈			SE-AUT-LD gel STEEL
						4h	6g	6e	
	1	0,25	16	x	2	0,98	0,97	0,93	
	1,1	0,25	16	x	2	1,08	1,07	1,03	
	1,2	0,25	16	x	2	1,18	1,17	1,13	D0361500.0012
	1,4	0,3	16	x	2,6	1,38	1,36	1,32	<b>D0361500.0014</b>
	1,6	0,35	16	x	2,6	1,57	1,54	1,51	<b>D0361500.0016</b>
	1,7	0,35	16	x	2,6	1,67	1,64	1,61	<b>D0361500.0017</b>
	1,8	0,35	16	x	2,6	1,77	1,74	1,71	D0361500.0018
	2	0,4	16	x	3,5	1,97	1,93	1,90	<b>D0361500.0020</b>
	2,2	0,45	16	x	3,5	2,17	2,13	2,10	D0361500.0022
	2,3	0,4	16	x	3,5	2,27	2,23	2,20	<b>D0361500.0023</b>
	2,5	0,45	16	x	3,5	2,47	2,43	2,40	<b>D0361500.0025</b>
	3	0,5	16	x	3,5	2,97	2,92	2,89	<b>D0361500.0030</b>
	3,5	0,6	16	x	4	3,46	3,41	3,38	<b>D0361500.0035</b>
	4	0,7	16	x	5	3,96	3,90	3,87	<b>D0361500.0040</b>
	4,5	0,75	20	x	7	4,46	4,40	4,37	
	5	0,8	20	x	7	4,95	4,90	4,86	<b>D0361500.0050</b>
	6	1	20	x	7	5,94	5,88	5,85	<b>D0361500.0060</b>
	7	1	25	x	7	6,94	6,88	6,85	
	8	1,25	25	x	9	7,93	7,86	7,83	
	10	1,5	30	x	11	9,92	9,85	9,81	
	12	1,75	35	x	12	11,91	11,83	11,81	
	14	2	35	x	14	13,91	13,82	13,78	
	16	2	45	x	18	15,91	15,82	15,78	

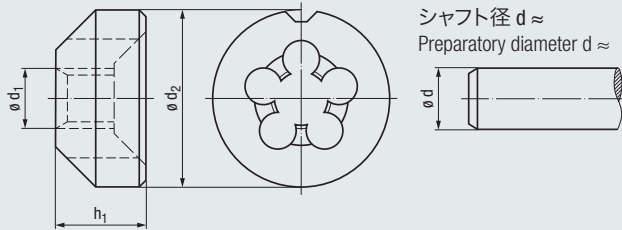
\*) ≤ M1,4 Tol. 6h



- Product Finder
- V<sub>c</sub>
- M
- MF
- UNC
- UNF  
UNEF
- G
- NPT, NPTF  
R
- BSW, BSF
- Tr, Tr-F
- Zubehör  
Accessories



**M**  
DIN 13



**STEEL**  
鋼



ラップ  
lapped



公差・Tolerance  
母材・Cutting material  
チャンファー・ 切削油・

- 6g
- HSS
- 1
- E / O

アプリケーション - 被削材  
Applications - material 516

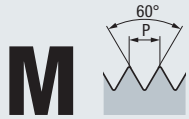
- P** 1.1-3.1
- K** 1.1-2.2
- N** 1.1-1.4
- N** 2.1-2.2, 2.4
- N** 4.2

	$\phi d_1$ mm	P mm	$\phi d_2$	x	$h_1$	$\phi d \approx$			SE-GLOCK gel STEEL
						4h	6g	6e	
<b>M</b>	2	0,4	16	x	8	1,97	1,93	1,90	<b>D0301500.0020</b>
	2,5	0,45	16	x	8	2,47	2,43	2,40	<b>D0301500.0025</b>
	3	0,5	16	x	8	2,97	2,92	2,89	<b>D0301500.0030</b>
	3,5	0,6	16	x	9,5	3,46	3,41	3,38	D0301500.0035
	4	0,7	16	x	9,5	3,96	3,90	3,87	<b>D0301500.0040</b>
	5	0,8	20	x	9,5	4,95	4,90	4,86	<b>D0301500.0050</b>
	6	1	20	x	9,5	5,94	5,88	5,85	<b>D0301500.0060</b>
	8	1,25	25	x	14	7,93	7,86	7,83	<b>D0301500.0080</b>

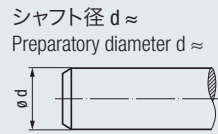
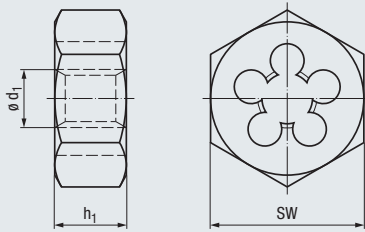


切削油は 300 - 301 ページを  
ご覧ください

Coolant-lubricants, see page 300 - 301



DIN 13



シャフト径  $d \approx$   
Preparatory diameter  $d \approx$

STEEL  
鋼



スタンダード  
standard



技術情報  
Technical information

公差・Tolerance  
母材・Cutting material

チャンファ―  
切削油・

6g

HSS

1,5

E / O

P 1.1-3.1

K 1.1-2.2

アプリケーション - 被削材  
Applications - material

516

M	$\phi d_1$ mm	P mm	SW	x	$h_1$	$\phi d \approx$			SE-6KT nor STEEL
						4h	6g	6e	
	3	0,5	18	x	5	2,97	2,92	2,89	D0401000.0030
	3,5	0,6	18	x	5	3,46	3,41	3,38	D0401000.0035
	4	0,7	18	x	5	3,96	3,90	3,87	D0401000.0040
	5	0,8	18	x	7	4,95	4,90	4,86	D0401000.0050
	6	1	18	x	7	5,94	5,88	5,85	D0401000.0060
	7	1	21	x	9	6,94	6,88	6,85	D0401000.0070
	8	1,25	21	x	9	7,93	7,86	7,83	D0401000.0080
	10	1,5	27	x	11	9,92	9,85	9,81	D0401000.0100
	12	1,75	36	x	14	11,91	11,83	11,81	D0401000.0112
	14	2	36	x	14	13,91	13,82	13,78	D0401000.0114
	16	2	41	x	18	15,91	15,82	15,78	D0401000.0116
	18	2,5	41	x	18	17,89	17,79	17,75	D0401000.0118
	20	2,5	41	x	18	19,89	19,79	19,75	D0401000.0120
	22	2,5	50	x	22	21,89	21,79	21,75	D0401000.0122
	24	3	50	x	22	23,88	23,76	23,72	D0401000.0124
	27	3	60	x	25	26,88	26,76	26,72	D0401000.0127
	30	3,5	60	x	25	29,87	29,73	29,70	D0401000.0130
	33	3,5	60	x	25	32,87	32,73	32,70	D0401000.0133
	36	4	60	x	25	35,85	35,70	35,66	D0401000.0136

Product  
Finder

V<sub>c</sub>

M

MF

UNC

UNF  
UNEF

G

NPT, NPTF  
R

BSW, BSF

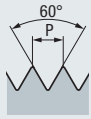
Tr, Tr-F

Zubehör  
Accessories



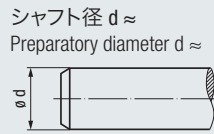
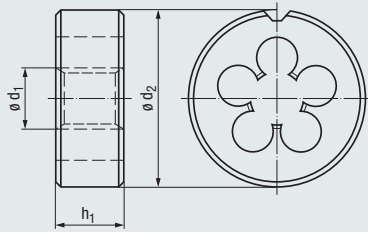
- Product Finder
- V<sub>c</sub>
- M
- MF**
- UNC
- UNF  
UNEF
- G
- NPT, NPTF  
R
- BSW, BSF
- Tr, Tr-F
- Zubehör  
Accessories

**MF**



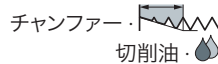
DIN 13

DIN EN  
22568



公差・Tolerance  
母材・Cutting material

技術情報  
Technical information



STEEL  
鋼



スタンダード  
standard



ラップ  
lapped



スタンダード  
standard



スタンダード  
standard



6g

HSS

1,5

E/O

6g

HSS

1,5

E/O

6e

HSS

1,5

E/O

6g

HSS

左ねじ

1,5

E/O

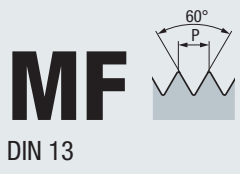
アプリケーション - 被削材  
Applications - material



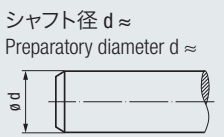
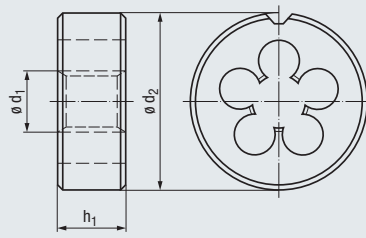
<b>P</b> 1.1-3.1	<b>P</b> 1.1-3.1	<b>P</b> 1.1-3.1	<b>P</b> 1.1-3.1
<b>K</b> 1.1-2.2	<b>M</b> 1.1-2.1	<b>K</b> 1.1-2.2	<b>K</b> 1.1-2.2
	<b>N</b> 1.1-1.4		
	<b>N</b> 2.1-2.4, 4.2		

	$\phi d_1$ mm	P mm	$\phi d_2$	x	$h_1$	$\phi d \approx$			SE-B nor STEEL	SE-B gel STEEL	SE-B nor STEEL	SE-B nor STEEL-LH
						4h	6g	6e				
<b>M</b>	2,5	x 0,35	16	x 5	2,47	2,44	—	D0101000.0196	D0101500.0196			
	2,6	x 0,35	16	x 5	2,57	2,54	—	D0101000.0199	D0101500.0199			
	3	x 0,35	20	x 5	2,97	2,94	—	D0101000.0202	D0101500.0202			
	3,5	x 0,35	20	x 5	3,47	3,44	—	D0101000.0205	D0101500.0205			
	4	x 0,35	20	x 5	3,97	3,94	—	D0101000.0209	D0101500.0209			
	4	x 0,5	20	x 5	3,96	3,92	3,89	D0101000.0210	D0101500.0210		D0101050.0210	
	5	x 0,5	20	x 5	4,96	4,92	4,89	D0101000.0218	D0101500.0218		D0101050.0218	
	6	x 0,5	20	x 5	5,96	5,92	5,89	D0101000.0228	D0101500.0228		D0101050.0228	
	6	x 0,75	20	x 7	5,95	5,90	5,87	D0101000.0229	D0101500.0229	D0101030.0229	D0101050.0229	
	7	x 0,75	25	x 9	6,95	6,90	6,87	D0101000.0239	D0101500.0239			
	8	x 0,5	25	x 9	7,96	7,92	7,89	D0101000.0249	D0101500.0249			
	8	x 0,75	25	x 9	7,95	7,90	7,87	D0101000.0250	D0101500.0250		D0101050.0250	
	8	x 1	25	x 9	7,94	7,88	7,85	D0101000.0251	D0101500.0251	D0101030.0251	D0101050.0251	
	9	x 0,75	25	x 9	8,95	8,90	8,87	D0101000.0262	D0101500.0262			
	9	x 1	25	x 9	8,94	8,88	8,85	D0101000.0263	D0101500.0263			
	10	x 0,75	30	x 11	9,95	9,90	9,87	D0101000.0275	D0101500.0275			
	10	x 1	30	x 11	9,94	9,88	9,85	D0101000.0276	D0101500.0276	D0101030.0276	D0101050.0276	
	10	x 1,25	30	x 11	9,93	9,86	9,83	D0101000.0277	D0101500.0277			
	11	x 1	30	x 11	10,94	10,88	10,85	D0101000.0288	D0101500.0288			
	12	x 1	38	x 10	11,94	11,88	11,85	D0101000.0301	D0101500.0301	D0101030.0301	D0101050.0301	
	12	x 1,25	38	x 10	11,93	11,86	11,83	D0101000.0302	D0101500.0302			
	12	x 1,5	38	x 10	11,92	11,85	11,81	D0101000.0303	D0101500.0303	D0101030.0303	D0101050.0303	
	13	x 1	38	x 10	12,94	12,88	12,85	D0101000.0315	D0101500.0315			
	14	x 1	38	x 10	13,94	13,88	13,85	D0101000.0329	D0101500.0329		D0101050.0329	
	14	x 1,25	38	x 10	13,93	13,86	13,83	D0101000.0330	D0101500.0330			
	14	x 1,5	38	x 10	13,92	13,85	13,81	D0101000.0331	D0101500.0331	D0101030.0331	D0101050.0331	
	15	x 1	38	x 10	14,94	14,88	14,85	D0101000.0343	D0101500.0343			
	15	x 1,5	38	x 10	14,92	14,85	14,81	D0101000.0345	D0101500.0345			
	16	x 1	45	x 14	15,94	15,88	15,85	D0101000.0357	D0101500.0357			
	16	x 1,5	45	x 14	15,92	15,85	15,81	D0101000.0359	D0101500.0359	D0101030.0359	D0101050.0359	
	18	x 1	45	x 14	17,94	17,88	17,85	D0101000.0388	D0101500.0388			
	18	x 1,5	45	x 14	17,92	17,85	17,81	D0101000.0390	D0101500.0390		D0101050.0390	
	18	x 2	45	x 14	17,91	17,82	17,78	D0101000.0391	D0101500.0391			
	20	x 1	45	x 14	19,94	19,88	19,85	D0101000.0420	D0101500.0420			
	20	x 1,5	45	x 14	19,92	19,85	19,81	D0101000.0422	D0101500.0422		D0101050.0422	
	20	x 2	45	x 14	19,91	19,82	19,78	D0101000.0423	D0101500.0423			
	22	x 1	55	x 16	21,94	21,88	21,85	D0101000.0436	D0101500.0436			
	22	x 1,5	55	x 16	21,92	21,85	21,81	D0101000.0438	D0101500.0438		D0101050.0438	
	22	x 2	55	x 16	21,91	21,82	21,78	D0101000.0439	D0101500.0439			
	24	x 1	55	x 16	23,94	23,88	23,85	D0101000.0450	D0101500.0450			
	24	x 1,5	55	x 16	23,92	23,85	23,81	D0101000.0452	D0101500.0452		D0101050.0452	
	24	x 2	55	x 16	23,91	23,82	23,78	D0101000.0453	D0101500.0453			
	25	x 1	55	x 16	24,94	24,88	24,85	D0101000.0456	D0101500.0456			
	25	x 1,5	55	x 16	24,92	24,85	24,81	D0101000.0458	D0101500.0458			
	26	x 1,5	55	x 16	25,92	25,85	25,81	D0101000.0464	D0101500.0464			
	27	x 1	65	x 18	26,94	26,88	26,85	D0101000.0468	D0101500.0468			
	27	x 1,5	65	x 18	26,92	26,85	26,81	D0101000.0470	D0101500.0470			
	27	x 2	65	x 18	26,91	26,82	26,78	D0101000.0471	D0101500.0471			
	28	x 1	65	x 18	27,94	27,88	27,85	D0101000.0474	D0101500.0474			
	28	x 1,5	65	x 18	27,92	27,85	27,81	D0101000.0476	D0101500.0476			
	30	x 1	65	x 18	29,94	29,88	29,85	D0101000.0488	D0101500.0488			
	30	x 1,5	65	x 18	29,92	29,85	29,81	D0101000.0490	D0101500.0490			
	30	x 2	65	x 18	29,91	29,82	29,78	D0101000.0491	D0101500.0491			





DIN EN 22568



**VA**  
ステンレス

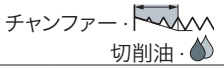
スタンダード  
standard

**MS**  
黄銅

ラップ  
lapped

技術情報  
Technical information

公差・Tolerance  
母材・Cutting material



6g  
HSSE

2  
E/O/P

6g  
HSS

1  
E/O

アプリケーション - 被削材  
Applications - material

**P** 1.1-3.1  
**M** 1.1-2.1

**N** 2.3, 4.1

	$\phi d_1$ mm	P mm	$\phi d_2$	x	$h_1$	$\phi d \approx$			SE-B nor VA	SE-B gel MS
						4h	6g	6e		
<b>M</b>	2,5	x 0,35	16	x	5	2,47	2,44	—		
	2,6	x 0,35	16	x	5	2,57	2,54	—		
	3	x 0,35	20	x	5	2,97	2,94	—		
	3,5	x 0,35	20	x	5	3,47	3,44	—		
	4	x 0,35	20	x	5	3,97	3,94	—		
	4	x 0,5	20	x	5	3,96	3,92	3,89		
	5	x 0,5	20	x	5	4,96	4,92	4,89		
	6	x 0,5	20	x	5	5,96	5,92	5,89		
	6	x 0,75	20	x	7	5,95	5,90	5,87	D0103000.0229	D0102500.0228 D0102500.0229
	7	x 0,75	25	x	9	6,95	6,90	6,87		D0102500.0239
	8	x 0,5	25	x	9	7,96	7,92	7,89		D0102500.0249
	8	x 0,75	25	x	9	7,95	7,90	7,87	D0103000.0250	D0102500.0250
	8	x 1	25	x	9	7,94	7,88	7,85	D0103000.0251	D0102500.0251
	9	x 0,75	25	x	9	8,95	8,90	8,87		
	9	x 1	25	x	9	8,94	8,88	8,85		
	10	x 0,75	30	x	11	9,95	9,90	9,87		D0102500.0275
	10	x 1	30	x	11	9,94	9,88	9,85	D0103000.0276	D0102500.0276
	10	x 1,25	30	x	11	9,93	9,86	9,83		
	11	x 1	30	x	11	10,94	10,88	10,85		
	12	x 1	38	x	10	11,94	11,88	11,85	D0103000.0301	D0102500.0301
	12	x 1,25	38	x	10	11,93	11,86	11,83		
	12	x 1,5	38	x	10	11,92	11,85	11,81	D0103000.0303	D0102500.0303
	13	x 1	38	x	10	12,94	12,88	12,85		
	14	x 1	38	x	10	13,94	13,88	13,85		D0102500.0329
	14	x 1,25	38	x	10	13,93	13,86	13,83		
	14	x 1,5	38	x	10	13,92	13,85	13,81	D0103000.0331	D0102500.0331
	15	x 1	38	x	10	14,94	14,88	14,85		
	15	x 1,5	38	x	10	14,92	14,85	14,81		
	16	x 1	45	x	14	15,94	15,88	15,85		D0102500.0357
	16	x 1,5	45	x	14	15,92	15,85	15,81	D0103000.0359	D0102500.0359
	18	x 1	45	x	14	17,94	17,88	17,85		
	18	x 1,5	45	x	14	17,92	17,85	17,81	D0103000.0390	D0102500.0390
	18	x 2	45	x	14	17,91	17,82	17,78		
	20	x 1	45	x	14	19,94	19,88	19,85		D0102500.0420
	20	x 1,5	45	x	14	19,92	19,85	19,81	D0103000.0422	D0102500.0422
	20	x 2	45	x	14	19,91	19,82	19,78		
	22	x 1	55	x	16	21,94	21,88	21,85		D0102500.0436
	22	x 1,5	55	x	16	21,92	21,85	21,81	D0103000.0438	D0102500.0438
	22	x 2	55	x	16	21,91	21,82	21,78		
	24	x 1	55	x	16	23,94	23,88	23,85		
	24	x 1,5	55	x	16	23,92	23,85	23,81	D0103000.0452	D0102500.0452
	24	x 2	55	x	16	23,91	23,82	23,78		
	25	x 1	55	x	16	24,94	24,88	24,85		
	25	x 1,5	55	x	16	24,92	24,85	24,81		
	26	x 1,5	55	x	16	25,92	25,85	25,81		D0102500.0464
	27	x 1	65	x	18	26,94	26,88	26,85		
	27	x 1,5	65	x	18	26,92	26,85	26,81		
	27	x 2	65	x	18	26,91	26,82	26,78		
	28	x 1	65	x	18	27,94	27,88	27,85		
	28	x 1,5	65	x	18	27,92	27,85	27,81		
	30	x 1	65	x	18	29,94	29,88	29,85		
	30	x 1,5	65	x	18	29,92	29,85	29,81		
	30	x 2	65	x	18	29,91	29,82	29,78		

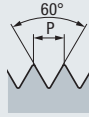
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- V<sub>c</sub>
- M
- MF
- UNC
- UNC/UNEF
- G
- NPT, NPTF/R
- BSW, BSF
- Tr, Tr-F
- Zubehör Accessories



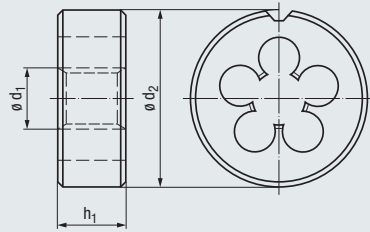
- Product Finder
- V<sub>c</sub>
- M
- MF
- UNC**
- UNF  
UNEF
- G
- NPT, NPTF  
R
- BSW, BSF
- Tr, Tr-F
- Zubehör  
Accessories

# UNC

ASME B1.1



DIN EN  
22568



シャフト径  $d \approx$   
Preparatory diameter  $d \approx$



STEEL  
鋼



スタンダード  
standard



ラップ  
lapped



技術情報  
Technical information

公差・Tolerance  
母材・Cutting material

チャンファー・  
切削油・

2A	2A
HSS	HSS
1,5	1,5
E/O	E/O

アプリケーション - 被削材  
Applications - material

▶▶ 516

<b>P</b> 1.1-3.1	<b>P</b> 1.1-3.1
<b>K</b> 1.1-2.2	<b>M</b> 1.1-2.1
	<b>K</b> 1.1-2.2
	<b>N</b> 1.1-1.4
	<b>N</b> 2.1-2.4, 4.2

Nr.	$\phi d_1$		P 山数 Gg/1" (tpi)	$\phi d_2$	x	$h_1$	$\phi d \approx$		SE-B nor STEEL	SE-B gel STEEL
	inch	inch					2A	3A		
Nr. 1	0.0730		64	16	x	5	1,79	1,81	D0101000.5000	D0101500.5000
Nr. 2	0.0860		56	16	x	5	2,12	2,14	D0101000.5001	D0101500.5001
Nr. 3	0.0990		48	16	x	5	2,44	2,46	D0101000.5002	D0101500.5002
Nr. 4	0.1120		40	16	x	5	2,76	2,78	D0101000.5003	D0101500.5003
Nr. 5	0.1250		40	20	x	5	3,09	3,11	D0101000.5004	D0101500.5004
Nr. 6	0.1380		32	20	x	7	3,41	3,43	D0101000.5005	D0101500.5005
Nr. 8	0.1640		32	20	x	7	4,07	4,09	D0101000.5006	D0101500.5006
Nr. 10	0.1900		24	20	x	7	4,71	4,73	D0101000.5007	D0101500.5007
Nr. 12	0.2160		24	20	x	7	5,37	5,39	D0101000.5008	D0101500.5008
1/4	0.2500		20	20	x	7	6,22	6,25	D0101000.5009	D0101500.5009
5/16	0.3125		18	25	x	9	7,80	7,83	D0101000.5010	D0101500.5010
3/8	0.3750		16	30	x	11	9,37	9,41	D0101000.5011	D0101500.5011
7/16	0.4375		14	30	x	11	10,95	10,98	D0101000.5012	D0101500.5012
1/2	0.5000		13	38	x	14	12,52	12,56	D0101000.5013	D0101500.5013
9/16	0.5625		12	38	x	14	14,10	14,14	D0101000.5014	D0101500.5014
5/8	0.6250		11	45	x	18	15,68	15,72	D0101000.5015	D0101500.5015
3/4	0.7500		10	45	x	18	18,84	18,89	D0101000.5016	D0101500.5016
7/8	0.8750		9	55	x	22	22,00	22,05	D0101000.5017	D0101500.5017
1"	1.0000		8	55	x	22	25,16	25,21	D0101000.5018	D0101500.5018
1 1/8	1.1250		7	65	x	25	28,31	28,37	D0101000.5019	D0101500.5019
1 1/4	1.2500		7	65	x	25	31,49	31,54	D0101000.5020	D0101500.5020
1 3/8	1.3750		6	65	x	25	34,63	34,69	D0101000.5021	D0101500.5021
1 1/2	1.5000		6	75	x	30	37,80	37,87	D0101000.5022	D0101500.5022
1 3/4	1.7500		5	90	x	36	44,12	44,19	D0101000.5023	D0101500.5023
2"	2.0000		4 1/2	90	x	36	50,45	50,52	D0101000.5024	D0101500.5024

公差 3A および 1A 用も特殊対応致します  
Tolerance classes 3A and 1A upon request

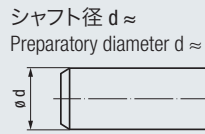
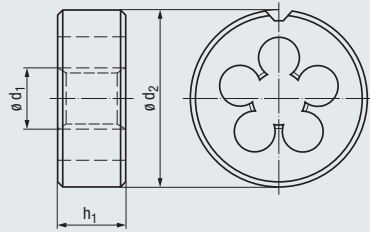


# UNF

ASME B1.1



DIN EN 22568



STEEL  
鋼



スタンダード  
standard

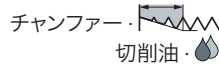


ラップ  
lapped



技術情報  
Technical information

公差・Tolerance  
母材・Cutting material



2A
HSS
1,5
E / O

2A
HSS
1,5
E / O

アプリケーション - 被削材  
Applications - material

▶ 516

P 1.1-3.1
K 1.1-2.2
P 1.1-3.1
M 1.1-2.1
K 1.1-2.2
N 1.1-1.4
N 2.1-2.4, 4.2

$\phi d_1$ inch	P 山数 Gg/1" (tpi)	$\phi d_2$	x	$h_1$	$\phi d \approx$		SE-B nor STEEL	SE-B gel STEEL	
					2A	3A			
Nr. 0	0.0600	80	16	x	5	1,47	1,49	D0101000.5033	D0101500.5033
Nr. 1	0.0730	72	16	x	5	1,80	1,81	D0101000.5034	D0101500.5034
Nr. 2	0.0860	64	16	x	5	2,12	2,14	D0101000.5035	D0101500.5035
Nr. 3	0.0990	56	16	x	5	2,44	2,46	D0101000.5036	D0101500.5036
Nr. 4	0.1120	48	16	x	5	2,77	2,79	D0101000.5037	D0101500.5037
Nr. 5	0.1250	44	20	x	5	3,10	3,12	D0101000.5038	D0101500.5038
Nr. 6	0.1380	40	20	x	5	3,42	3,44	D0101000.5039	D0101500.5039
Nr. 8	0.1640	36	20	x	7	4,08	4,10	D0101000.5040	D0101500.5040
Nr. 10	0.1900	32	20	x	7	4,73	4,75	D0101000.5041	D0101500.5041
Nr. 12	0.2160	28	20	x	7	5,38	5,40	D0101000.5042	D0101500.5042
1/4	0.2500	28	20	x	7	6,24	6,27	D0101000.5043	D0101500.5043
5/16	0.3125	24	25	x	9	7,82	7,85	D0101000.5044	D0101500.5044
3/8	0.3750	24	30	x	11	9,41	9,43	D0101000.5045	D0101500.5045
7/16	0.4375	20	30	x	11	10,98	11,01	D0101000.5046	D0101500.5046
1/2	0.5000	20	38	x	10	12,56	12,60	D0101000.5047	D0101500.5047
9/16	0.5625	18	38	x	10	14,14	14,18	D0101000.5048	D0101500.5048
5/8	0.6250	18	45	x	14	15,73	15,77	D0101000.5049	D0101500.5049
3/4	0.7500	16	45	x	14	18,89	18,93	D0101000.5050	D0101500.5050
7/8	0.8750	14	55	x	16	22,05	22,09	D0101000.5051	D0101500.5051
1"	1.0000	12	55	x	16	25,21	25,26	D0101000.5052	D0101500.5052
1 1/8	1.1250	12	65	x	18	28,38	28,43	D0101000.5053	D0101500.5053
1 1/4	1.2500	12	65	x	18	31,55	31,60	D0101000.5054	D0101500.5054
1 3/8	1.3750	12	65	x	18	34,73	34,78	D0101000.5055	D0101500.5055
1 1/2	1.5000	12	75	x	20	37,90	37,95	D0101000.5056	D0101500.5056

公差 3A および 1A 用も特殊対応致します  
Tolerance classes 3A and 1A upon request

- Product Finder
- V<sub>c</sub>
- M
- MF
- UNC
- UNF
- UNEF
- G
- NPT, NPTF
- R
- BSW, BSF
- Tr, Tr-F
- Zubehör
- Accessories



ダイスハンドルは 540 ページを  
ご覧ください

Die stocks for round dies,  
see page 540

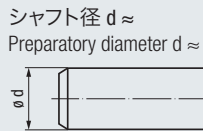
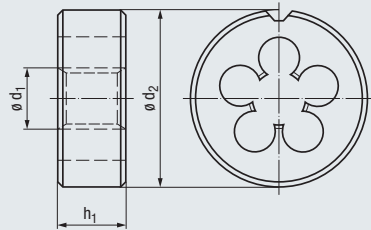
- Product Finder
- V<sub>c</sub>
- M
- MF
- UNC
- UNF  
UNEF
- G
- NPT, NPTF  
R
- BSW, BSF
- Tr, Tr-F
- Zubehör  
Accessories



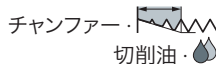
**UNE F**

ASME B1.1

≈ DIN EN 22568



シャフト径  $d \approx$   
Preparatory diameter  $d \approx$



チャンファー・切削油

技術情報  
Technical information

公差・Tolerance  
母材・Cutting material

アプリケーション - 被削材  
Applications - material

▶▶ 516

STEEL  
鋼



スタンダード  
standard



ラップ  
lapped



2A  
HSS

2A  
HSS

1,5  
E/O

1,5  
E/O

<b>P</b> 1.1-3.1	<b>P</b> 1.1-3.1
<b>K</b> 1.1-2.2	<b>M</b> 1.1-2.1
	<b>K</b> 1.1-2.2
	<b>N</b> 1.1-1.4
	<b>N</b> 2.1-2.4, 4.2

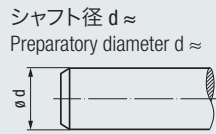
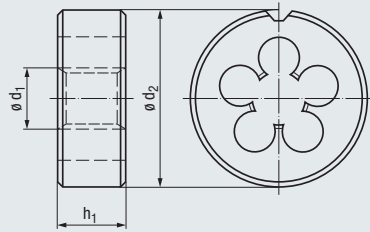
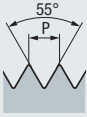
Nr.	$\phi d_1$ inch	P 山数 Gg/1" (tpi)	$\phi d_2$	x	$h_1$	$\phi d \approx$		SE-B nor STEEL	SE-B gel STEEL
						2A	3A		
12	0.2160	32	20	x	7	5,39	5,41	D0101000.5057	D0101500.5057
1/4	0.2500	32	20	x	7	6,25	6,27	D0101000.5058	D0101500.5058
5/16	0.3125	32	25	x	9	7,84	7,86	D0101000.5059	D0101500.5059
3/8	0.3750	32	30	x	11	9,42	9,45	D0101000.5060	D0101500.5060
7/16	0.4375	28	30	x	11	11,00	11,03	D0101000.5061	D0101500.5061
1/2	0.5000	28	38	x	10	12,59	12,62	D0101000.5062	D0101500.5062
9/16	0.5625	24	38	x	10	14,17	14,20	D0101000.5063	D0101500.5063
5/8	0.6250	24	45	x	14	15,75	15,78	D0101000.5064	D0101500.5064
3/4	0.7500	20	45	x	14	18,91	18,95	D0101000.5066	D0101500.5066
7/8	0.8750	20	55	x	16	22,09	22,12	D0101000.5068	D0101500.5068
1"	1.0000	20	55	x	16	25,26	25,30	D0101000.5070	D0101500.5070

公差 3A および 1A 用も特殊対応致します  
Tolerance classes 3A and 1A upon request



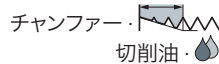
# G (BSP)

DIN EN ISO 228



技術情報  
Technical information

公差・Tolerance  
母材・Cutting material



アプリケーション - 被削材  
Applications - material

▶ 516

呼び径 Nom. size $\phi d_1$	$\phi d_1$ mm	P 山数 Gg/1" (tpi)	$\phi d_2$	x	$h_1$	$\phi d \approx$ Class A	SE-B nor STEEL	SE-B gel STEEL	SE-B gel MS 1)
<b>G</b> 1/16	7,72	28	25	x	9	7,62			
1/8	9,73	28	30	x	11	9,62	D0101000.4035	D0101500.4035	D0102500.4035
1/4	13,16	19	38	x	10	13,03	D0101000.4036	D0101500.4036	D0102500.4036
3/8	16,66	19	45	x	14	16,54	D0101000.4037	D0101500.4037	D0102500.4037
1/2	20,96	14	45	x	14	20,81	D0101000.4038	D0101500.4038	D0102500.4038
5/8	22,91	14	55	x	16	22,77	D0101000.4039	D0101500.4039	
3/4	26,44	14	55	x	16	26,30	D0101000.4040	D0101500.4040	D0102500.4040
7/8	30,20	14	65	x	18	30,06	D0101000.4041	D0101500.4041	
1"	33,25	11	65	x	18	33,07	D0101000.4042	D0101500.4042	D0102500.4042
1 1/8	37,90	11	75	x	20	37,72	D0101000.4043	D0101500.4043	
1 1/4	41,91	11	75	x	20	41,73	D0101000.4044	D0101500.4044	D0102500.4044
1 3/8	44,32	11	90	x	22	44,14	D0101000.4045	D0101500.4045	
1 1/2	47,80	11	90	x	22	47,62	D0101000.4046	D0101500.4046	D0102500.4046
1 3/4	53,75	11	90	x	22	53,57	D0101000.4048	D0101500.4048	
2"	59,61	11	105	x	22	59,43	D0101000.4050	D0101500.4050	

1) 黄銅薄肉チューブへの加工の際は詳細をお問い合わせください  
If thin-walled brass tubes are to be cut we need more technical details or a sketch of the workpiece

STEEL  
鋼



スタンダード  
standard



ラップ  
lapped



MS  
黄銅



ラップ  
lapped



Product  
Finder

V<sub>c</sub>

M

MF

UNC

UNF  
UNEF

G

NPT, NPTF  
R

BSW, BSF

Tr, Tr-F

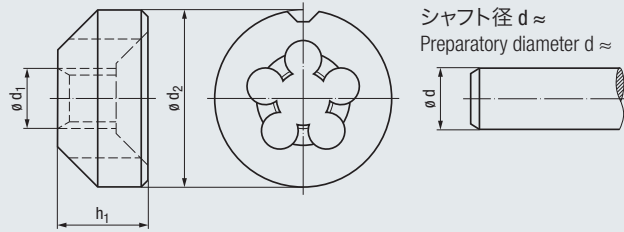
Zubehör  
Accessories



- Product Finder
- V<sub>c</sub>
- M
- MF
- UNC
- UNF  
UNEF
- G**
- NPT, NPTF  
R
- BSW, BSF
- Tr, Tr-F
- Zubehör  
Accessories

**G (BSP)**

DIN EN ISO 228



シャフト径 d ≈  
Preparatory diameter d ≈

**MS**  
黄銅



ラップ  
lapped



技術情報  
Technical information

公差・Tolerance  
母材・Cutting material

チャンファー・ 切削油・

Class A

HSS

1

E / O

**N 2.3.4.1**

アプリケーション - 被削材  
Applications - material

▶▶ 516

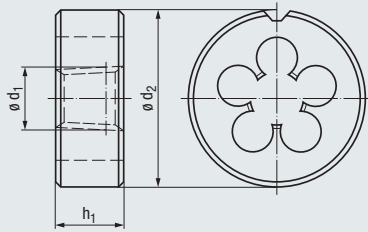
呼び径 Nom. size	ø d <sub>1</sub> mm	P 山数 Gg/1" (tpi)	ø d <sub>2</sub>	x	h <sub>1</sub>	ø d ≈ Class A	SE-GLOCK gel MS
<b>G</b> 1/8	9,73	28	25	x	14	9,62	
1/4	13,16	19	30	x	18	13,03	<b>D0302500.4036</b>
3/8	16,66	19	38	x	20	16,54	<b>D0302500.4037</b>
1/2	20,96	14	45	x	24	20,81	<b>D0302500.4038</b>
3/4	26,44	14	55	x	28	26,30	<b>D0302500.4040</b>
1"	33,25	11	65	x	30	33,07	<b>D0302500.4042</b>



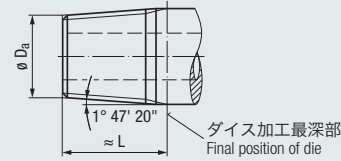


**NPT**

ANSI/ASME B1.20.1



1:16 テーパーボルト径  
Preparatory bolt dimensions on taper 1:16



ダイス加工最深部  
Final position of die

STEEL  
鋼



スタンダード  
standard



技術情報  
Technical information

公差・Tolerance  
母材・Cutting material

チャンファー・ 切削油・

HSS

1,5

0 / P

アプリケーション - 被削材  
Applications - material

▶ 516

P 1.1-3.1  
K 1.1-2.2  
N 2.3, 4.1

呼び径 Nom. size $\phi d_1$	P 山数 Gg/1" (tpi)	$\phi d_2$	x	$h_1$	$\phi D_a$ min.	$\phi D_a$ max.	$\approx L$	SE-KEG nor STEEL
1/16	27	25	x	9	7,52	7,64	8,3	D0191000.5763
1/8	27	30	x	11	9,87	9,99	8,4	D0191000.5764
1/4	18	38	x	14	13,10	13,26	12,7	D0191000.5765
3/8	18	45	x	14	16,52	16,67	12,9	D0191000.5766
1/2	14	45	x	18	20,55	20,71	16,8	D0191000.5767
3/4	14	55	x	22	25,87	26,03	17,0	D0191000.5768
1"	11 1/2	65	x	25	32,42	32,59	21,2	D0191000.5769
1 1/4	11 1/2	75	x	26	41,14	41,32	21,9	D0191000.5770
1 1/2	11 1/2	90	x	27	47,21	47,39	22,3	D0191000.5771
2"	11 1/2	105	x	28	59,25	59,42	23,1	D0191000.5772

Product  
FinderV<sub>c</sub>

M

MF

UNC

UNF  
UNEF

G

NPT NPTF  
R

BSW, BSF

Tr, Tr-F

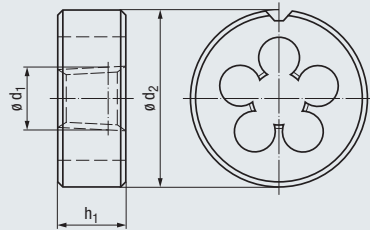
Zubehör  
Accessories

- Product Finder
- Vc
- M
- MF
- UNC
- UNF  
UNEF
- G
- NPT, NPTF  
R
- BSW, BSF
- Tr, Tr-F
- Zubehör  
Accessories

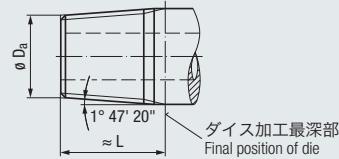


# NPTF

ANSI B1.20.3



1:16 テーパーボルト径  
Preparatory bolt dimensions on taper 1:16



**STEEL**  
鋼



スタンダード  
standard



技術情報  
Technical information

公差・Tolerance  
母材・Cutting material

チャンファー・ 切削油・

HSS

1,5

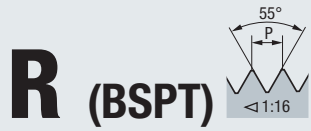
O/P

アプリケーション - 被削材  
Applications - material 516

- P** 1.1-3.1
- K** 1.1-2.2
- N** 2.3, 4.1

呼び径 Nom. size $\phi d_1$	P 山数 Gg/1" (tpi)	$\phi d_2$	x	$h_1$	$\phi D_a$ min.	$\phi D_a$ max.	$\approx L$	SE-KEG nor STEEL
1/16	27	25	x	9	7,52	7,62	9,2	<b>D0191000.5782</b>
1/8	27	30	x	11	9,87	9,96	9,3	<b>D0191000.5783</b>
1/4	18	38	x	14	13,13	13,21	14,1	<b>D0191000.5784</b>
3/8	18	45	x	14	16,55	16,63	14,3	<b>D0191000.5785</b>
1/2	14	45	x	18	20,62	20,70	18,6	<b>D0191000.5786</b>
3/4	14	55	x	22	25,93	26,02	18,9	<b>D0191000.5787</b>
1"	11 1/2	65	x	25	32,47	32,56	23,5	<b>D0191000.5788</b>
1 1/4	11 1/2	75	x	26	41,20	41,29	24,1	
1 1/2	11 1/2	90	x	27	47,27	47,36	24,5	
2"	11 1/2	105	x	28	59,28	59,37	25,3	





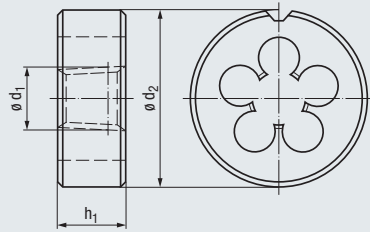
**R (BSPT)**  
DIN EN 10226-1, ISO 7-1

≈ DIN EN 24230

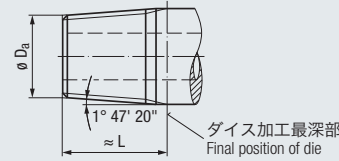
STEEL  
鋼



スタンダード  
standard



1:16 テーパーボルト径  
Preparatory bolt dimensions on taper 1:16



技術情報  
Technical information

公差・Tolerance  
母材・Cutting material

チャンファー・ 切削油・

HSS

1,5  
0 / P

アプリケーション - 被削材  
Applications - material

▶ 516

**P** 1.1-3.1  
**K** 1.1-2.2  
**N** 2.3, 4.1

呼び径 Nom. size	P 山数 Gg/1" (tpi)	$\phi d_2$	x	$h_1$	$\phi D_a$	Tol.	$\approx L$	SE-KEG nor STEEL
<b>R</b> 1/8	28	30	x	11	9,48	± 0,05	8,1	<b>D0191000.4069</b>
1/4	19	38	x	14	12,78	± 0,08	12,0	<b>D0191000.4070</b>
3/8	19	45	x	14	16,26	± 0,08	12,4	<b>D0191000.4071</b>
1/2	14	45	x	18	20,44	± 0,11	16,4	<b>D0191000.4072</b>
3/4	14	55	x	22	25,85	± 0,11	17,7	<b>D0191000.4073</b>
1"	11	65	x	25	32,60	± 0,14	20,8	<b>D0191000.4074</b>

最適な平行めねじとの組み合わせは 243 - 245 ページをご覧ください  
The appropriate internal thread is cylindrical, see taps, page 243 - 245

- Product Finder
- V<sub>c</sub>
- M
- MF
- UNC
- UNF  
UNEF
- G
- NPT, NPTF  
R
- BSW, BSF
- Tr, Tr-F
- Zubehör  
Accessories



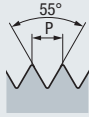
GF-KEG テーパーねじ用ねじ切り  
カッターは 449 - 462 ページを  
ご覧ください

Thread milling cutters for tapered threads  
type GF-KEG, see page 449 - 462

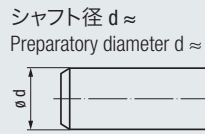
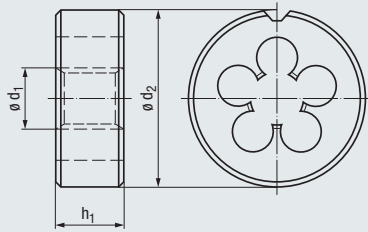
- Product Finder
- V<sub>c</sub>
- M
- MF
- UNC
- UNF  
UNEF
- G
- NPT, NPTF  
R
- BSW, BSF
- Tr, Tr-F
- Zubehör  
Accessories

# BSW

BS 84



DIN EN  
22568



シャフト径  $d \approx$   
Preparatory diameter  $d \approx$

STEEL  
鋼



スタンダード  
standard



技術情報  
Technical information

公差・Tolerance  
母材・Cutting material

チャンファー・ 切削油・

medium class

HSS

1,5

E / O

アプリケーション - 被削材  
Applications - material 516

**P** 1.1-3.1

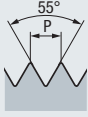
**K** 1.1-2.2

	$\phi d_1$ inch	inch	P 山数 Gg/1" (tpi)	$\phi d_2$	x	$h_1$	$\phi d \approx$ medium class	SE-B nor STEEL
<b>BSW</b>	1/16	1,59	60	16	x	5	1,51	D0101000.3044
	3/32	2,38	48	16	x	5	2,30	D0101000.3045
	1/8	3,18	40	20	x	5	3,09	D0101000.3046
	5/32	3,97	32	20	x	7	3,88	D0101000.3047
	3/16	4,76	24	20	x	7	4,66	D0101000.3048
	7/32	5,56	24	20	x	7	5,46	D0101000.3049
	1/4	6,35	20	20	x	7	6,24	D0101000.3050
	5/16	7,94	18	25	x	9	7,82	D0101000.3051
	3/8	9,53	16	30	x	11	9,40	D0101000.3052
	7/16	11,11	14	30	x	11	10,98	D0101000.3053
	1/2	12,70	12	38	x	14	12,56	D0101000.3054
	9/16	14,29	12	38	x	14	14,14	D0101000.3055
	5/8	15,88	11	45	x	18	15,72	D0101000.3056
	3/4	19,05	10	45	x	18	18,89	D0101000.3058
	7/8	22,23	9	55	x	22	22,10	D0101000.3060
	1"	25,40	8	55	x	22	25,27	D0101000.3062
	1 1/8	28,58	7	65	x	25	28,44	D0101000.3063
	1 1/4	31,75	7	65	x	25	31,61	D0101000.3064
	1 3/8	34,93	6	65	x	25	34,77	D0101000.3065
	1 1/2	38,10	6	75	x	30	37,95	D0101000.3066
	1 5/8	41,28	5	75	x	30	41,11	D0101000.3067
	1 3/4	44,45	5	90	x	36	44,28	D0101000.3068
	2"	50,80	4 1/2	90	x	36	50,62	D0101000.3070



# BSF

BS 84

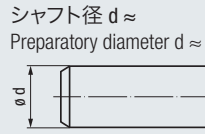
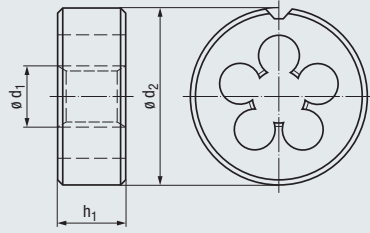


DIN EN 22568

STEEL  
鋼



スタンダード  
standard



シャフト径  $d \approx$   
Preparatory diameter  $d \approx$

技術情報  
Technical information

公差・Tolerance  
母材・Cutting material

チャンファア  
切削油

- medium class
- HSS
- 1,5
- E / O

アプリケーション - 被削材  
Applications - material

- P** 1.1-3.1
- K** 1.1-2.2

BSF	$\phi d_1$		P 山数 Gg/1" (tpi)	$\phi d_2$	x	$h_1$	$\phi d \approx$ medium class	SE-B nor STEEL
	inch	inch						
	3/16	4,76	32	20	x	7	4,67	D0101000.3088
	1/4	6,35	26	20	x	7	6,25	D0101000.3090
	5/16	7,94	22	25	x	9	7,83	D0101000.3092
	3/8	9,53	20	30	x	11	9,41	D0101000.3093
	7/16	11,11	18	30	x	11	10,99	D0101000.3094
	1/2	12,70	16	38	x	10	12,57	D0101000.3095
	5/8	15,88	14	45	x	14	15,73	D0101000.3097
	3/4	19,05	12	45	x	14	18,89	D0101000.3099
	7/8	22,23	11	55	x	16	22,11	D0101000.3101
	1"	25,40	10	55	x	16	25,28	D0101000.3102

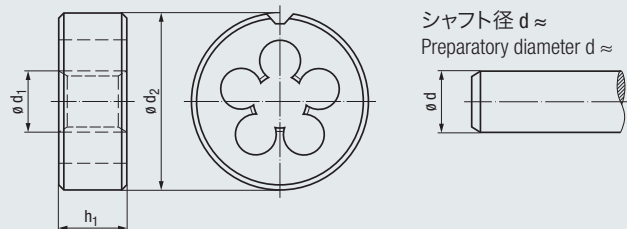
- Product Finder
- V<sub>c</sub>
- M
- MF
- UNC
- UNF  
UNEF
- G
- NPT, NPTF  
R
- BSW, BSF
- Tr, Tr-F
- Zubehör  
Accessories



- Product Finder
- Vc
- M
- MF
- UNC
- UNF  
UNEF
- G
- NPT, NPTF  
R
- BSW, BSF
- Tr, Tr-F
- Zubehör  
Accessories



**Tr**  
DIN 103



**STEEL**  
鋼



スタンダード  
standard



技術情報  
Technical information

公差・Tolerance  
母材・Cutting material

チャンファー・ 切削油・

- 7e
- HSS
- 1,5-2
- O/P

アプリケーション - 被削材  
Applications - material

▶ 516

- P 1.1<sup>1)</sup>**
- N 2.3<sup>1)</sup>**

$\varnothing d_1$ mm	P mm	$\varnothing d_2$	x	$h_1$	$\varnothing d \approx$ 7e	TRAPEZ-SE-B nor STEEL
<b>Tr</b> 8	x 1,5	25	x	9	7,93	
10	x 2	38	x	14	9,91	<b>D0101000.7043</b>
10	x 3	38	x	14	9,88	<b>D0101000.7044</b>
11	x 3	38	x	14	10,88	
12	x 3	38	x	14	11,88	<b>D0101000.7046</b>
14	x 3	45	x	18	13,88	<b>D0101000.7047</b>
14	x 4	45	x	18	13,85	<b>D0101000.7048</b>
16	x 4	45	x	18	15,85	<b>D0101000.7051</b>
18	x 4	45	x	18	17,85	<b>D0101000.7052</b>
20	x 4	55	x	22	19,85	<b>D0101000.7053</b>
22	x 5	55	x	22	21,83	<b>D0101000.7054</b>
24	x 5	65	x	25	23,83	<b>D0101000.7055</b>
26	x 5	65	x	25	25,83	<b>D0101000.7057</b>
28	x 5	65	x	25	27,83	<b>D0101000.7058</b>
30	x 6	65	x	25	29,81	<b>D0101000.7059</b>
32	x 6	65	x	25	31,81	<b>D0101000.7060</b>

<sup>1)</sup> ねじの修正加工にのみ適用可能  
Suitable only for reconditioning



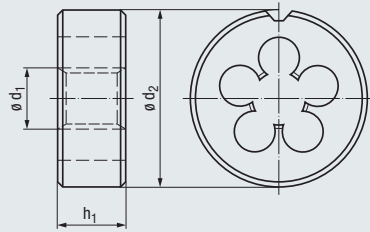
台形ねじ用タップは 294 - 298  
ページをご覧ください

Taps for trapezoidal threads,  
see page 294 - 298

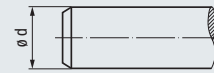




DIN 103



シャフト径  $d \approx$   
Preparatory diameter  $d \approx$



STEEL  
鋼



スタンダード  
standard



技術情報  
Technical information

公差・Tolerance  
母材・Cutting material

チャンファー・ 切削油・

7e

HSS

1,5-2

0 / P

**P** 1.1 <sup>1)</sup>

**N** 2.3 <sup>1)</sup>

アプリケーション - 被削材  
Applications - material 516

$\phi d_1$ mm	P mm	$\phi d_2$	x	$h_1$	$\phi d \approx$ 7e	TRAPEZ-SE-B nor STEEL
<b>Tr</b> 12	x 2	38	x 14	11,91	<b>D0101000.7129</b>	
14	x 2	38	x 14	13,91	<b>D0101000.7130</b>	
16	x 2	45	x 18	15,91	<b>D0101000.7132</b>	
18	x 2	45	x 18	17,91	<b>D0101000.7133</b>	
20	x 2	45	x 18	19,91	<b>D0101000.7134</b>	
22	x 3	55	x 22	21,88		
24	x 3	55	x 22	23,88		
26	x 3	55	x 22	25,88		
28	x 3	65	x 25	27,88		
30	x 3	65	x 25	29,88		

<sup>1)</sup> ねじの修正加工にのみ適用可能  
Suitable only for reconditioning

- Product Finder
- V<sub>c</sub>
- M
- MF
- UNC
- UNF  
UNEF
- G
- NPT, NPTF  
R
- BSW, BSF
- Tr, Tr-F**
- Zubehör  
Accessories



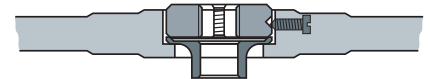
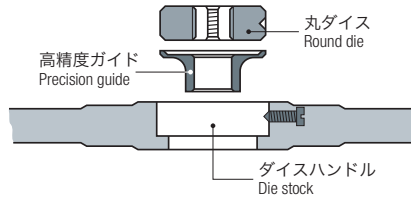
- Product Finder
- V<sub>c</sub>
- M
- MF
- UNC
- UNF  
UNEF
- G
- NPT, NPTF  
R
- BSW, BSF
- Tr, Tr-F
- Zubehör  
Accessories

DIN EN  
22568



ダイスハンドル No. Die stock no.	ダイスサイズ Die adaptation ∅ d <sub>2</sub> x h <sub>1</sub>	
1	16 x 5	FZ201000.01
2	20 x 5	FZ201000.02
3	20 x 7	FZ201000.03
4	25 x 9	FZ201000.04
5	30 x 11	FZ201000.05
6	38 x 10	FZ201000.06
7	38 x 14	FZ201000.07
8	45 x 14	FZ201000.08
9	45 x 18	FZ201000.09
10	55 x 16	FZ201000.10
11	55 x 22	FZ201000.11
12	65 x 18	FZ201000.12
13	65 x 25	FZ201000.13
14	75 x 20	FZ201000.14
15	75 x 30	FZ201000.15
16	90 x 22	FZ201000.16
17	90 x 36	FZ201000.17
18	105 x 22	FZ201000.18
19	105 x 36	FZ201000.19

**高精度ガイド**  
Precision guides



マニュアル加工時の高精度ガイドは特殊対応致します  
Precision guides for better performance when cutting by hand upon request

