



TECO Tooling P/L

121 Bittern-Dromana Road

Merricks North Vic 3926

PO Box 497

Balnarring Vic 3926

Australia

Ph: +61 3 5989 7532

info@teco.net.au

Information Booklet on Tapping

- Tap Prices for most thread sizes and materials
- Bilz-style tapping collets – Price List
- Tapping drill size charts
- Tapping Drills Price list HSS and Carbide, 3 x D
- Tapping Arms - pneumatic and hydraulic
- Thread Gauges information

All our products are made in Western Europe:

STOCK AG Germany

NORIS Germany

CMA Spain

Powertools Sweden

D'Andrea Italy

SCM Italy

BOSS Germany

Taps to M 30 and drills to suit

Taps to M 140 !

Tapping Arms Hydraulic to M 60

Tapping Arms Pneumatic to M 27

Tapping Collets

Tapping Collets

Thread Gauges, any size

We appreciate any suggestions for improvement of this publication

Nov 2008



TECO Tooling - Taps Price List
updated Nov 2010

METRIC TAPS
List Prices

Diameter	YELLOW RING general steels				BLUE RING stainless steel				RED RING high tensile steel				BLACK RING aluminium				size of tap shank tapping collet
	gun tap		spiral fluted		gun tap		spiral fluted		gun tap		spiral fluted		gun tap		spiral fluted		
	Part No.	Price (\$)	Part No.	Price (\$)	Part No.	Price (\$)	Part No.	Price (\$)	Part No.	Price (\$)	Part No.	Price (\$)	Part No.	Price (\$)	Part No.	Price (\$)	
M3	73133-M3	15.20	73146-M3	19.00	73641-M3	19.00	73662-M3	22.80	73640-M3	19.00	73661-M3	22.80	73131-M3	15.20	73156-M3	19.00	3.5x2.7
M4	73133-M4	15.20	73146-M4	19.00	73641-M4	19.00	73662-M4	22.80	73640-M4	19.00	73661-M4	22.80	73131-M4	15.20	73156-M4	19.00	4.5x3.4
M5	73133-M5	15.20	73146-M5	19.00	73641-M5	19.00	73662-M5	22.80	73640-M5	19.00	73661-M5	22.80	73131-M5	15.20	73156-M5	19.00	6x4.9
M6	73133-M6	15.20	73146-M6	19.00	73641-M6	19.00	73662-M6	22.80	73640-M6	19.00	73661-M6	22.80	73131-M6	15.20	73156-M6	19.00	6x4.9
M8	73133-M8	19.00	73146-M8	22.80	73641-M8	22.80	73662-M8	26.60	73640-M8	22.80	73661-M8	26.60	73131-M8	19.00	73156-M8	22.80	8x6.2
M10	73133-M10	22.80	73146-M10	26.60	73641-M10	26.60	73662-M10	30.40	73640-M10	26.60	73661-M10	30.40	73131-M10	22.80	73156-M10	26.60	10x8
M12	73138-M12	34.20	73148-M12	38.00	73643-M12	38.00	73665-M12	41.80	73645-M12	38.00	73664-M12	41.80	73189-M12	51.22	73136-M12	60.99	9x7
M14	73138-M14	49.40	73148-M14	53.20	73643-M14	49.40	73665-M14	57.00	73645-M14	84.17	73664-M14	57.00					11x9
M16	73138-M16	49.40	73148-M16	53.20	73643-M16	49.40	73665-M16	57.00	73645-M16	49.40	73664-M16	57.00	73189-M16	79.31	73136-M16	84.17	12x9
M18	73138-M18	112.63	73148-M18	117.31	73643-M18	101.23	73665-M18	133.72	73645-M18	137.52	73664-M18	137.52					14x11
M20	73138-M20	76.00	73148-M20	83.60	73643-M20	76.00	73665-M20	83.60	73645-M20	76.00	73664-M20	83.60	73189-M20	128.10	73136-M20	137.86	16x12
M24	73138-M24	148.96	73148-M24	145.46													18x14.5
M30	73138-M30	239.48	73148-M30	241.64													22x18
M33	7080AAZAA	343.86	7640AACAA	408.92													25x20
M36	7080AAOAA	390.34	7640AADAA	408.92													28x22

Diam.	NORIS	
	Metric Hand Taps	
	Part No.	Price (\$)
M4	5000ACXAA	59.62
M6	5000AARAA	63.50
M8	5000AA7AA	71.90
M10	5000ABNAA	90.59

Diam.	NORIS (OSM)	
	Spiral for High Tensile	
	Part No.	Price (\$)
M3	6643AADAD	48.79
M4	6643AAEAD	48.79
M5	6643AAFAD	51.87
M6	6643AAGAD	53.43
M8	6643AAAAD	67.75
M10	6643AAHAD	76.68
M12	7643AAIAD	104.54
M16	7643AAKAD	139.38
M18	7643E4379	190.49
M20	7643AALAD	198.25

Diam.	NORIS (HCR)	
	Spiral for Aluminium	
	Part No.	Price (\$)
M3	6641AAGAD	44.16
M4	6641AAHAE	45.30
M5	6641AAIAE	45.68
M6	6641AAJAE	46.85
M8	6641AAKAG	53.05
M10	6641AALAF	60.80
M12	7641AAGAG	76.68

These are list prices. Deduct resellers discounts accordingly

Price on request for thread sizes not listed



TECO Tooling - Taps Price List
Update Nov 2010

UNC TAPS													
LIST PRICES													
Diameter	GREEN RING general purpose				BLUE RING stainless steel				RED RING high tensile steel				size of tap shank tapping collets
	gun tap		spiral fluted		gun tap		spiral fluted		gun tap		spiral fluted (OSM)		
	Part No.	Price (\$)	Part No.	Price (\$)	Part No.	Price (\$)	Part No.	Price (\$)	Part No.	Price (\$)	Part No.	Price (\$)	
UNC 4-40	73308 4-40	44.54	73322 4-40	57.95	73297 4-40	53.05	73304 4-40	57.95	6560AB3AA	52.29	6643A1955	62.13	3.5x2.7
UNC 6-32	73308 6-32	39.63	73322 6-32	48.79	73297 6-32	46.36	73304 6-32	54.26	6560AB5AA	46.47	6643AAIAD	57.68	4x3
UNC 8-32	73308 8-32	40.28	73322 8-32	54.26	73297 8-32	45.11	73304 8-32	49.44	6560AB6AA	44.16	6643AAJAD	60.00	4.5x3.4
UNC 10-24	73308 10-24	54.26	73322 10-24	53.05	73297 10-24	57.95	73304 10-24	50.01	6560AB7AA	49.97	6643AAKAD	61.56	6x4.9
UNC 1/4-20	73308 1/4	45.11	73322 1/4	57.34	73297 1/4	49.44	73304 1/4	50.01	6560AB9AA	53.81	6643AALAD	67.37	7x5.5
UNC 5/16-18	73308 5/16	53.05	73322 5/16	54.26	73297 5/16	63.42	73304 5/16	51.22	6560ABNAA	61.56	6643AAMAD	79.00	8x6.2
UNC 3/8-16	73308 3/8	71.97	73322 3/8	59.77	73297 3/8	74.40	73304 3/8	57.34	6560ABPAA	68.93	6643AANAD	86.75	10x8
UNC 1/2-13	73309 1/2	89.07	73323 1/2	91.50	73298 1/2	92.72	73305 1/2	102.49	7560AC7AA	82.08	7643AAWAD	123.92	9x7
UNC 5/8-11	73309 5/8	112.21	73323 5/8	112.21	73298 5/8	112.21	73305 5/8	123.20	7560AC8AA	114.61	7643AAXAD	153.33	12x9
UNC 3/4-10	73309 3/4	143.98	73323 3/4	153.71	73298 3/4	153.71	73305 3/4	139.08	7560AC9AA	140.94	7643AAYAD	201.36	14x11
UNC 7/8-9											7643E4301	252.47	18x14.5
UNC 1 - 8	7080AGQAA	201.36	7640ADJAA	224.58	73298 1"	295.22			7560AB9AB	230.77	7643E4299	359.33	18x14.5
UNC 1-1/4x7	7080AGSAA	328.36	7640ADLAA	334.55									22x18
UNC 1-1/8x7			7640ADKAA	292.75									22x18
UNC 1-1/2x6	7080AGUAA	501.83	7640ADNAA	486.36									28x22

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TECO Tooling - Taps Price List

updated Nov 2010

UNF TAPS													
LIST PRICES													
Diameter	YELLOW / GREEN RING general purpose				BLUE RING stainless steel				RED RING high tensile steel				size of tap shank tapping collets
	gun tap		spiral fluted		gun tap		spiral fluted		gun tap		spiral fluted (OSM)		
	Part No.	Price (\$)	Part No.	Price (\$)	Part No.	Price (\$)	Part No.	Price (\$)	Part No.	Price (\$)	Part No.	Price (\$)	
UNF 10-32	73310 10-32	60.99	73324 10-32	54.26	73299 10-32	49.44	73306 10-32	65.89	6560ABCAA	58.10	6643E4333	76.27	3.5x2.7
UNF 1/4-28	73310 1/4	75.62	73324 1/4	63.42	73299 1/4	70.76	73306 1/4	73.19	6560ABBAA	64.30	6643E4335	74.33	4.5x3.4
UNF 3/8-24	73310 3/8	81.74	73324 3/8	69.54	73299 3/8	78.09	73306 3/8	78.09	7560AEYAA	96.86	7643E4339	129.88	7x5.5
UNF 7/16-20	73310-7/16	62.85	7640AC3AA	80.56							7643E4341	116.17	8x6.2
UNF 1/2-20	73310 1/2	87.74	73324-1/2	108.60							73306 1/2	108.60	7560AE0AA
UNF 5/8-18	73310 5/8	139.08	73324 5/8	142.73	73299 5/8	145.20	73306 5/8	148.81	7560AE2AA	115.41	7643E4343	153.33	12x9
UNF 3/4-16	73310 3/4	160.06	7640AC7AA	136.31			7645B0632	174.27	7560AE3AA	144.82	7643E4346	204.48	14x11
UNF 7/8-14	73310 7/8	201.55	7640AC8AA	164.20			73299 7/8	221.69	73306 7/8	226.44	7560AE4AA	189.73	7643E4301
UNF 1 -12	73310 1"	230.01	7640AC9AA	226.14	73299 1"	308.26	73306 1"	320.11	7560AAMAA	247.84	7643E4354	359.33	18x14.5

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Price on request for thread sizes not listed



TECO Tooling - Taps Price List
updated Nov 2010

BSP (G) TAPS													
LIST PRICES													
Diameter	GREEN RING general purpose				BLUE RING stainless steel				high tensile steel				size of tap shank tapping collets
	gun tap		spiral fluted		gun tap		spiral fluted		gun tap		spiral fluted (OSM)		
BSP=G	Part No.	Price (\$)	Part No.	Price (\$)	Part No.	Price (\$)	Part No.	Price (\$)	Part No.	Price (\$)	Part No.	Price (\$)	
G 1/8-28	73321 G1/8	56.73	73325 G1/8	60.99	73300 G1/8	59.77	73325 G1/8	60.99	7560AD0AA	72.43	7643AASAD	92.95	7x5.5
G 1/4-19	73321 G1/4	75.62	73325 G1/4	86.60	73300 G1/4	81.74	73325 G1/4	86.60	7560AAEAB	97.58	7643AATAD	130.87	11x9
G 3/8-19	73321 G3/8	93.94	73325 G3/8	125.67	73300 G3/8	111.00	73325 G3/8	125.67	7560AD1AA	120.80	7643AAUAD	159.52	12x9
G 1/2-14	73321 G1/2	129.31	73325 G1/2	162.26	73300 G1/2	150.06	73325 G1/2	162.26	7560AAFAB	154.89	7643AAVAD	210.63	16x12
G 3/4-14	73321 G3/4	253.76	73325 G3/4	248.90	73300 G3/4	241.57	73325 G3/4	248.90	7560AD3AA	250.91	7643E4294	359.33	20x16
G 1-11	73321 G1	280.59	73325 G1	336.72	73300 G1	439.20	73325 G1	336.72	7560AD5AA	387.22	7643AA3AD	470.86	25x20

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Price on request for thread sizes not listed



TECO Tooling - Taps Price List
updated Nov 2010

BSPT (Rc) TAPS List Prices			
Diameter	general purpose straight fluted		size of tap shank tapping collets
	Part No.	Price (\$)	
BSPT=Rc			
Rc 1/8-28	5100A1925	118.48	7x5.5
Rc 1/4-19	5100A1924	121.60	11x9
Rc 3/8-19	5100A1923	142.50	12x9
Rc 1/2-14	5100A1922	185.86	16x12
Rc 3/4-14	5100A1921	257.11	20x16
Rc 1-11	5100A1920	365.52	25x20

NPT TAPS List Prices			
Diameter	general purpose straight fluted		size of tap shank tapping collets
	Part No.	Price (\$)	
NPT 1/8-27	6100A1733	96.82	10x8
NPT 1/4-18	6100F0007	99.90	14x11
NPT 3/8-18	7100AIGAB	120.04	14x11
NPT 1/2-14	7100AIEAH	162.64	16x12
NPT 3/4-14	7100AIFAE	209.11	20x16
NPT 1-11.5	7100AIHAD	303.58	25x20

BSW TAPS					
List Prices					
Diameter	general purpose				size of tap shank tapping collets
	gun tap		spiral fluted		
	Part No.	Price (\$)	Part No.	Price (\$)	
BSW 1/8-40	6560ABUAA	63.12	6640AB2AA	45.68	3.5x2.7
BSW 3/16-24	6560ABWAA	63.12	6640AB3AA	44.92	6x4.9
BSW 1/4-20	6560ABXAA	69.31	6640AB4AA	54.23	7x5.5
BSW 5/16-18	6560ABYAA	78.20	6640AB5AA	58.10	8x6.2
BSW 3/8-16	6560ABZAA	85.96	6640AB6AA	62.36	10x8
BSW 7/16-14	7560F0037	101.46	7640A3606	98.34	8x6.2
BSW 1/2-12	7560AEMAA	103.78	7640AB3AA	82.08	9x7
BSW 5/8-11	7560AENAA	144.82	7640AB4AA	109.97	12x9
BSW 3/4-10	7560AEPAA	193.61	7640AB5AA	144.82	14x11
BSW 1-8	7560AERAA	331.47	7640AB7AA	254.03	18x14.5

These are list prices. Deduct resellers discounts accordingly

Price on request for thread sizes not listed



Deduct resellers discounts accordingly

ROLL FORMING TAPS		
Product No.	Product Title	Trade Price
With Lubrication		
63120-M3	M3x0.5 Forming Tap TIN	30.40
63120-M4	M4x0.7 Forming Tap TIN	30.40
63120-M5	M5x0.8 Forming Tap TIN	34.20
63120-M6	M6x1 Forming Tap TIN	42.00
63120-M8	M8x1.25 Forming Tap TIN	45.60
63120-M10	M10x1.5 Forming Tap TIN	49.40
63122-M12	M12x1.75 Forming Tap TCN	113.00
6970B0303	M2x0.4 Form Tap HCR	82.31
6970AAKAA	M2x0.4 HSS-E Former TiN	60.65
6970AAMAA	M2.5x0.45 HSS-E Former TiN	55.23
6970AAAAA	M3x0.5 HSS-E Former TiN	53.43
6970AAAAC	M3x0.5 HSS-E Former HCR	52.35
6970AABAA	M4x0.7 HSS-E Former TiN	55.23
6970AABAC	M4x0.7 HSS-E Former HCR	53.43
6970AACAA	M5x0.8 HSS-E Former TiN	57.04
6970AACAD	M5x0.8 HSS-E Former HCR	55.96
6970AADAA	M6x1 HSS-E Former TiN	65.34
6970AADAB	M6x1 HSS-E Former HCR	55.96
6970AAEAA	M8x1.25 HSS-E Former TiN	71.84
6970AAEAB	M8x1.25 HSS-E Former HCR	64.26
6970AAFAA	M10x1.5 HSS-E Former TiN	90.25
6970AAFAB	M10x1.5 HSS-E Former HCR	84.47
7970AADAA	M12x1.75 HSS-E TiN Former	111.91
7970F0047	M12x1.75 HSS-E HCR Former	make an offer
7970AARAA	M16x1.5 HSS-E MF TiN Former	168.95
7970AAEAB	M16x2 HSS-E TiN Former	173.28
7970F0082 CRN	M16x2 Forming Tap CRN	make an offer
6970AAZAA	4-40 UNC 2BX Fomer - TiN	72.20
6970AA1AA	6-32 UNC Former 2B - Tin	67.15
6970AA3AA	10-24 UNC 2BX Former TiN	74.37
6970AA5AA	1/4-20 UNC 2BX Former TiN	85.92
6970AA7AA	3/8-16 UNC 2BX Former TiN	108.30
6970A5009	5/16-24 UNF 2BX Former TIN	130.68
6970ABEAA	10-32 UNF 2BX Former TIN	83.03
6970ABGAA	1/4-28 UNF 2BX Former TIN	97.47
6970F0038	3/8-24 UNF 2BX Former TIN	116.96
7970AAHAA	7/16-20 UNF 2BX Former TIN	144.40

Updated Nov 2010



Tapping Drill Pricelist
Updated Nov 2010

Deduct resellers discounts accordingly

							Drill 3xD		
Metric	UNC	UNF	G (BSPT)	Rc (BSPT)	NPT	BSW	Diam.	HSS-Co Tin 61220	Carbide Dixi 1130R Dicut (1-6mm) 51873 Fire (6.1-20mm)
M2							1.6	\$9.27	\$19.76
	4-40						2.4	\$9.77	\$21.28
M3						W1/8-40	2.5	\$8.51	\$21.36
	6-32						2.7	\$10.60	\$24.85
	8-32						2.9	\$10.49	\$25.50
M4							3.3	\$9.04	\$29.15
	10-24						3.5	\$9.04	\$27.40
						W3/16-24	3.6	\$11.21	\$30.13
	1/4-20						3.9	\$12.43	\$32.68
		10-32					4.1	\$11.74	\$33.06
M5							4.2	\$10.15	\$33.14
	5/16-18						4.5	\$11.59	\$33.14
M6							5.0	\$11.21	\$34.81
						W1/4-20	5.1	\$12.31	\$40.89
		1/4-28		Rc 1/8-28			5.5	\$12.65	\$41.76
						W5/16-18	6.5	\$16.00	\$63.31
M8							6.8	\$19.38	\$63.31
						W3/8-16	7.9	\$23.67	\$63.31
	3/8-16						8.0	\$22.08	\$63.31
M10		3/8-24			1/8-27		8.5	\$25.61	\$71.02
			G1/8-28				8.8	\$32.34	\$71.02
				Rc 1/4-19			9.0	\$26.83	\$71.02
						W7/16-14	9.3	\$29.87	\$71.02
		7/16-20					9.9	\$34.77	\$183.01
M12							10.2	\$35.99	\$105.87
						W1/2-12	10.5	\$34.77	\$105.87
	1/2-13						10.8	\$46.82	\$105.87
				Rc 3/8-19			11.0	\$37.81	\$105.87
					1/4-18		11.1	Avail Reqst	\$105.87
		1/2-20					11.5	\$29.30	\$105.87
			G1/4-19				11.8	\$56.32	\$105.87
M14				Rc 1/2-14			12.0	\$42.71	\$105.87
	5/8-11					W5/8-11	13.5	\$50.01	\$142.04
M16							14.0	\$62.21	\$142.04
		5/8-18			3/8-18		14.5	\$69.96	\$183.31
			G3/8-19				15.3	Available on request	
M18							15.5	\$92.49	\$183.31
				Rc 3/4-14			16.0	\$75.89	\$183.31
	3/4-10					W3/4-10	16.5	\$92.49	\$322.09
M20		3/4-16					17.5	\$96.03	\$322.09
					1/2-14		17.8	Available on request	
			G1/2-14				19.0	\$109.06	\$351.39
	7/8-9						19.5	\$125.67	\$351.39
				Rc 1-11			20.0	\$120.84	\$351.39
		7/8-14					20.4	Available upon request	
						W1-8	22.0		
	1-8						22.3		
					1-11.5		23.0		
		1-12					23.3		
			G3/4-14				24.5		
							29.0		
			G1-11				30.8		



Tapping Drill Pricelist

Updated Nov 2010

List Prices. Deduct resellers discounts accordingly

Metric	UNC	UNF	G (BSP)	Rc (BSPT)	NPT	BSW	Diam.	HSS	
								Jobber Drill	M/T Drills
								71115	102
M2							1.60	2.47	
	4-40						2.40	2.36	
M3						W1/8-40	2.50	2.36	
	6-32						2.70	2.47	
	8-32						2.90	2.47	
M4							3.30	12.54	
	10-24						3.50	2.36	
						W3/16-24	3.60	2.93	
	1/4-20						3.90	3.19	
		10-32					4.10	3.53	
M5							4.20	3.04	
	5/16-18						4.50	3.15	
M6							5.00	3.08	
						W1/4-20	5.10	3.91	
		1/4-28		Rc 1/8-28			5.50	4.29	
						W5/16-18	6.50	5.28	
M8							6.80	7.18	
						W3/8-16	7.90	8.82	
	3/8-16						8.00	7.18	
M10		3/8-24			1/8-27		8.50	9.16	
			G1/8-28				8.80	11.32	
				Rc 1/4-19			9.00	9.99	
						W7/16-14	9.30	12.20	
		7/16-20					9.90	14.14	
M12							10.20	15.24	
						W1/2-12	10.50	15.47	
	1/2-13						10.80	22.19	
				Rc 3/8-19			11.00	17.94	
					1/4-18		11.20	22.69	
		1/2-20					11.50	19.65	
			G1/4-19				11.80	25.04	73.95
M14				Rc 1/2-14			12.00	22.08	27.49
	5/8-11					W5/8-11	13.50	31.12	34.28
M16							14.00		31.84
		5/8-18			3/8-18		14.50		32.89
			G3/8-19				15.30		82.99
M18							15.50		37.41
				Rc 3/4-14			16.00		37.41
	3/4-10					W3/4-10	16.50		40.89
M20		3/4-16					17.50		43.50
					1/2-14		17.80		101.95
			G1/2-14				19.00		49.59
						W7/8-9	19.25		89.07
M22	7/8-9						19.50		56.55
				Rc 1-11			20.00		53.07
		7/8-14					20.40		171.91
M24							21.00		59.16
						W1-8	22.00		65.25
	1-8						22.25		104.92
					1-11.5		23.00		78.30
		1-12					23.25		130.53
			G3/4-14				24.50		84.39
							29.00		121.80
			G1-11				30.75		222.03

Gewindekernlöcher für Gewindebohrer

Tapping drill sizes for taps / Avant-trous de taraudage

Prefori per maschi / Dimensiones de la broca previa para machos

M

Metrisches ISO Regelgewinde

Metric ISO thread / Filetage métrique ISO standard

Filettatura metrica ISO / Rosca Métrica ISO

Kurzzeichen Thread size Désignation Diametro del filetto Dimensión rosca	Vorbohr-Ø Tapping drill size Ø de l'avantrou Diam. del preforo Dimensión broca (mm)	Muttergewinde Kern-Ø Minor diameter / Ø-intérieur Diametro del nocciolo Diám. Núcleo (mm)	
		min	max / mass
M 1	0,75	0,729	0,785
M 1,2	0,95	0,929	0,985
M 1,4	1,1	1,075	1,142
M 1,6	1,25	1,221	1,321
M 1,7	1,3	1,321	1,421
M 1,8	1,45	1,421	1,521
M 2	1,6	1,567	1,679
M 2,2	1,75	1,713	1,838
M 2,3	1,9	1,867	1,979
M 2,5	2,05	2,013	2,138
M 2,6	2,1	2,113	2,238
M 3	2,5	2,459	2,599
M 3,5	2,9	2,850	3,010
M 4	3,3	3,242	3,422
M 4,5	3,7	3,688	3,878
M 5	4,2	4,134	4,334
M 6	5	4,917	5,153
M 7	6	5,917	6,153
M 8	6,8	6,647	6,912
M 9	7,8	7,647	7,912
M 10	8,5	8,376	8,676
M 11	9,5	9,376	9,676
M 12	10,2	10,106	10,441
M 14	12	11,835	12,210
M 16	14	13,835	14,210
M 18	15,5	15,294	15,744
M 20	17,5	17,294	17,744
M 22	19,5	19,294	19,744
M 24	21	20,752	21,252
M 27	24	23,752	24,252
M 30	26,5	26,211	26,771
M 33	29,5	29,211	29,771
M 36	32	31,670	32,270
M 39	35	34,670	35,270
M 42	37,5	37,129	37,799
M 45	40,5	40,129	40,799
M 48	43	42,587	43,297
M 52	47	46,587	47,297
M 56	50,5	50,046	50,756

MF

Metrisches ISO Feingewinde

Metric ISO-Fine thread / Filetage métrique fin ISO

Filettatura metrica ISO fine / Rosca Métrica ISO Fina

Kurzzeichen Thread size Désignation Diametro del filetto Dimensión rosca	Vorbohr-Ø Tapping drill size Ø de l'avantrou Diam. del preforo Dimensión broca (mm)	Muttergewinde Kern-Ø Minor diameter / Ø-intérieur Diametro del nocciolo Diám. Núcleo (mm)	
		min	max / mass
MF 2x0,25	1,75	1,729	1,785
MF 2,2x0,25	1,95	1,929	1,985
MF 2,3x0,25	2,05	2,029	2,085
MF 2,5x0,35	2,15	2,121	2,221
MF 3x0,25	2,75	2,729	2,785
MF 3x0,35	2,65	2,621	2,721
MF 3,5x0,35	3,15	3,121	3,221
MF 4x0,35	3,65	3,621	3,721
MF 4x0,50	3,5	3,459	3,599
MF 4,5x0,50	4	3,959	4,099
MF 5 x 0,35	4,65	4,621	4,721
MF 5 x 0,50	4,5	4,459	4,599
MF 5 x 0,75	4,2	4,188	4,378
MF 6 x 0,50	5,5	5,459	5,599
MF 6 x 0,75	5,2	5,188	5,378
MF 7 x 0,50	6,5	6,459	6,599
MF 7 x 0,75	6,2	6,188	6,378
MF 8 x 0,50	7,5	7,459	7,599
MF 8 x 0,75	7,2	7,188	7,378
MF 8 x 1,00	7	6,917	7,153
MF 9 x 0,50	8,5	8,459	8,599
MF 9 x 0,75	8,2	8,188	8,378
MF 9 x 1,00	8	7,917	8,153
MF 10 x 0,50	9,5	9,459	9,599
MF 10 x 0,75	9,2	9,188	9,378
MF 10 x 1,00	9	8,917	9,153
MF 10 x 1,25	8,8	8,647	8,912
MF 10 x 1,50	8,5	8,376	8,676
MF 11 x 1,00	10	9,917	10,153
MF 12 x 0,50	11,5	11,459	11,599
MF 12 x 0,75	11,2	11,188	11,378
MF 12 x 1,00	11	10,917	11,153
MF 12 x 1,25	10,8	10,647	10,912
MF 12 x 1,50	10,5	10,376	10,676
MF 13 x 1,00	12	11,917	12,153
MF 14 x 0,75	13,2	13,188	13,378
MF 14 x 1,00	13	12,917	13,153
MF 14 x 1,25	12,8	12,647	12,912
MF 14 x 1,50	12,5	12,376	12,676
MF 15 x 1,00	14	13,917	14,153
MF 15 x 1,50	13,5	13,376	13,676
MF 16 x 0,75	15,2	15,188	15,378
MF 16 x 1,00	15	14,917	15,153
MF 16 x 1,25	14,8	14,647	14,912
MF 16 x 1,50	14,5	14,376	14,676
MF 17 x 1,00	16	15,917	16,153
MF 18 x 1,00	17	16,917	17,153
MF 18 x 1,50	16,5	16,376	16,676
MF 18 x 2,00	16	15,835	16,210
MF 20 x 1,00	19	18,917	19,153
MF 20 x 1,50	18,5	18,376	18,676
MF 20 x 2,00	18	17,835	18,210

UNC

Unified Coarse Gewinde

Unified Coarse thread / Filetage Unified Coarse
Filettatura grossa unificata / Rosca Unificada Gruesa

Kurzzeichen Thread size Désignation Diametro del filetto Dimensión rosca	Vorböhr-Ø Tapping drill size Ø de l'avantrou Diam. del preforo Dimensión broca (mm)	Muttergewinde Kern-Ø Minor diameter / Ø-intérieur Diametro del nocciolo Diám. Núcleo (mm)		
		min	max / mass	
		2B/3B	2B	3B
Nr. 1-64	1,55	1,425	1,582	1,582
Nr. 2-56	1,85	1,694	1,872	1,872
Nr. 3-48	2,1	1,941	2,146	2,146
Nr. 4-40	2,35	2,156	2,385	2,385
Nr. 5-40	2,65	2,487	2,697	2,697
Nr. 6-32	2,85	2,642	2,896	2,896
Nr. 8-32	3,5	3,302	3,531	3,528
Nr. 10-24	3,9	3,683	3,962	3,950
Nr. 12-24	4,5	4,343	4,597	4,590
1/4-20	5,1	4,976	5,268	5,250
5/16-18	6,6	6,411	6,734	6,680
3/8-16	8	7,805	8,164	8,082
7/16-14	9,4	9,149	9,550	9,441
1/2-13	10,8	10,584	11,013	10,881
9/16-12	12,2	11,996	12,456	12,301
5/8-11	13,5	13,376	13,868	13,693
3/4-10	16,5	16,299	16,833	16,624
7/8-9	19,5	19,169	19,748	19,520
1-8	22,25	21,963	22,598	22,344
1 1/8-7	25	24,648	25,349	25,082
1 1/4-7	28	27,823	28,524	28,258
1 1/2-6	34	33,518	34,295	34,026

UNF

Unified Fine-Gewinde

Unified Fine thread / Filetage Unified Fine
Filettatura fine unificata / Rosca Unificada Fina

Kurzzeichen Thread size Désignation Diametro del filetto Dimensión rosca	Vorböhr-Ø Tapping drill size Ø de l'avantrou Diam. del preforo Dimensión broca (mm)	Muttergewinde Kern-Ø Minor diameter / Ø-intérieur Diametro del nocciolo Diám. Núcleo (mm)		
		min	max / mass	
		2B/3B	2B	3B
Nr. 0-80	1,25	1,181	1,306	1,306
Nr. 1-72	1,55	1,473	1,613	1,613
Nr. 2-64	1,85	1,755	1,913	1,913
Nr. 3-56	2,15	2,024	2,197	2,197
Nr. 4-48	2,4	2,271	2,459	2,459
Nr. 5-44	2,7	2,550	2,741	2,741
Nr. 6-40	2,95	2,819	3,023	3,012
Nr. 8-36	3,5	3,404	3,607	3,597
Nr. 10-32	4,1	3,962	4,166	4,168
Nr. 12-28	4,6	4,496	4,724	4,717
1/4-28	5,5	5,367	5,580	5,563
5/16-24	6,9	6,792	7,038	6,995
3/8-24	8,5	8,379	8,626	8,565
7/16-20	9,9	9,738	10,030	9,947
1/2-20	11,5	11,326	11,618	11,524
9/16-18	12,9	12,761	13,084	12,969
5/8-18	14,5	14,348	14,671	14,554
3/4-16	17,5	17,330	17,689	17,546
7/8-14	20,4	20,262	20,663	20,493
1-12	23,25	23,109	23,569	23,363
1 1/8-12	26,5	26,284	26,744	26,538
1 1/4-12	29,5	29,459	29,919	29,713
1 3/8-12	32,75	32,634	33,094	32,888

Kurzzeichen Thread size Désignation Diametro del filetto Dimensión rosca	Vorböhr-Ø Tapping drill size Ø de l'avantrou Diam. del preforo Dimensión broca (mm)	Muttergewinde Kern-Ø Minor diameter / Ø-intérieur Diametro del nocciolo Diám. Núcleo (mm)	
		min	max / mass
MF 22 x 2,00	20	19,835	20,210
MF 24 x 1,00	23	22,917	23,153
MF 24 x 1,50	22,5	22,376	22,676
MF 24 x 2,00	22	21,835	22,210
MF 25 x 1,00	24	23,917	24,153
MF 25 x 1,5	23,5	23,376	23,676
MF 26 x 1,50	24,5	24,376	24,676
MF 27 x 1,00	26	25,917	26,153
MF 27 x 1,50	25,5	25,376	25,676
MF 27 x 2,00	25	24,835	25,210
MF 28 x 1,50	26,5	26,376	26,676
MF 28 x 2,00	26	25,835	26,210
MF 30 x 1,00	29	28,917	29,153
MF 30 x 1,50	28,5	28,376	28,676
MF 30 x 2,00	28	27,835	28,210
MF 32 x 1,50	30,5	30,376	30,676
MF 32 x 2,00	30	29,835	30,210
MF 33 x 1,50	31,5	31,376	31,676
MF 33 x 2,00	31	30,835	31,210
MF 34 x 1,50	32,5	32,376	32,676
MF 35 x 1,50	33,5	33,376	33,676
MF 36 x 1,50	34,5	34,376	34,676
MF 36 x 2,00	34	33,835	34,210
MF 36 x 3,00	33	32,752	33,252
MF 38 x 1,50	36,5	36,376	36,676
MF 39 x 1,50	37,5	37,376	37,676
MF 39 x 2,00	37	36,835	37,210
MF 39 x 3,00	36	35,752	36,252
MF 40 x 1,50	38,5	38,376	38,676
MF 40 x 2,00	38	37,835	38,210
MF 40 x 3,00	37	36,752	37,252
MF 42 x 1,50	40,5	40,376	40,676
MF 42 x 2,00	40	39,835	40,210
MF 42 x 3,00	39	38,752	39,252
MF 45 x 1,50	43,5	43,376	43,676
MF 45 x 2,00	43	42,835	43,210
MF 45 x 3,00	42	41,752	42,252
MF 48 x 1,50	46,5	46,376	46,676
MF 48 x 2,00	46	45,835	46,210
MF 48 x 3,00	45	44,752	45,252
MF 50 x 1,50	48,5	48,376	48,676
MF 50 x 2,00	48	47,835	48,210
MF 50 x 3,00	47	46,752	47,252
MF 52 x 1,50	50,5	50,376	50,676
MF 52 x 2,00	50	49,835	50,210
MF 52 x 3,00	49	48,752	49,252
MF 56 x 1,50	54,5	54,376	54,676
MF 56 x 2,00	54	53,835	54,210
MF 56 x 3,00	53	52,752	53,252
MF 58 x 1,50	56,5	56,376	56,676
MF 60 x 1,50	58,5	58,376	58,676
MF 60 x 2,00	58	57,835	58,210
MF 60 x 3,00	57	56,752	57,252

UNEF

Unified Extra-Fine-Gewinde
Unified Extra Fine thread
Filetage Unified Extra-fine
Filettatura extra fine unificata
Rosca Unificada Extra Fina

Kurzzeichen Thread size Désignation Diametro del filetto Dimensión rosca	Vorbohr-Ø Tapping drill size Ø de l'avantrou Diam. del preforo Dimensión broca (mm)
1/4-32	5,55
5/16-32	7,15
3/8-32	8,70
7/16-28	10,2
1/2-28	11,8
9/16-24	13,2
5/8-24	14,8
11/16-24	16,4
3/4-20	17,8
7/8-20	20,95
1-20	24,2

UNJC

Unified Coarse-Gewinde (modifiziert)
Unified Coarse thread (modified)
Filetage Unified Coarse (modifié)
Filettatura grossa unificata (modificata)
Rosca Unificada Gruesa (modificada)

Kurzzeichen Thread size Désignation Diametro del filetto Dimensión rosca	Vorbohr-Ø Tapping drill size Ø de l'avantrou Diam. del preforo Dimensión broca (mm)
Nr. 1-64	1,5
Nr. 2-56	1,8
Nr. 3-48	2,05
Nr. 4-40	2,3
Nr. 5-40	2,65
Nr. 6-32	2,8
Nr. 8-32	3,5
Nr. 10-24	3,9
Nr. 12-24	4,6
1/4-20	5,2
5/16-18	6,7
3/8-16	8,1
7/16-14	9,5
1/2-13	10,9
9/16-12	12,3
5/8-11	13,7
3/4-10	16,75

UNJF

Unified Fine-Gewinde (modifiziert)
Unified Fine thread (modified)
Filetage Unified Fine (modifié)
Filettatura fine unificata (modificata)
Rosca Unificada Fina (modificada)

Kurzzeichen Thread size Désignation Diametro del filetto Dimensión rosca	Vorbohr-Ø Tapping drill size Ø de l'avantrou Diam. del preforo Dimensión broca (mm)
Nr. 0-80	1,25
Nr. 1-72	1,55
Nr. 2-64	1,85
Nr. 3-56	2,1
Nr. 4-48	2,4
Nr. 5-44	2,7
Nr. 6-40	2,95
Nr. 8-36	3,6
Nr. 10-32	4,15
Nr. 12-28	4,7
1/4-28	5,6
5/16-24	7
3/8-24	8,6
7/16-20	10,0
1/2-20	11,5
9/16-12	12,3
5/8-18	14,5

BSW

British Standard-Whitworth-Gewinde
British Standard Whitworth thread
Filetage British Standard Whitworth
Filettatura Whitworth standard inglese
Rosca Whitworth Norma Británica

Kurzzeichen Thread size Désignation Diametro del filetto Dimensión rosca	Vorbohr-Ø Tapping drill size Ø de l'avantrou Diam. del preforo Dimensión broca (mm)
* 1/16-60	1,15
* 3/32-48	1,8
1/8-40	2,55
* 5/32-32	3,1
3/16-24	3,6
* 7/32-24	4,4
1/4-20	5,1
5/16-18	6,5
3/8-16	7,9
7/16-14	9,2
1/2-12	10,5
* 9/16-12	12
5/8-11	13,5
3/4-10	16,25
7/8-9	19,25
1 - 8	21,75
1 1/8-7	24,75
1 1/4-7	27,75
1 3/8-6	30,5
1 1/2-6	33,5
1 5/8-5	35,5
1 3/4-5	39
* 1 7/8-4 1/2	41,5
2 - 4 1/2	44,5
2 1/4-4	50
2 1/2-4	56,5
* 2 3/4-3 1/2	62

* Withworth-Gewinde DIN 11 zurückgezogen 1970
* Withworth-thread DIN 11 was withdrawn in 1970
* Filetage Whitworth DIN 11 supprimé depuis 1970
* Filettatura Whitworth DIN 11 ritirata in 1970
* Rosca Whitworth DIN 11 fue retirada en 1970

UN

Unified Coarse-Gewinde (8-Gang-Reihe)
Unified Coarse thread (8 thread series)
Filetage Unified Coarse (8 filets)
Filettatura grossa unificata (serie di 8 filetti)
Rosca Unificada Gruesa (series 8 hilos)

Kurzzeichen Thread size Désignation Diametro del filetto Dimensión rosca	Vorbohr-Ø Tapping drill size Ø de l'avantrou Diam. del preforo Dimensión broca (mm)
1 1/8-8	25,4
1 1/4-8	28,5
1 3/8-8	31,8
1 1/2-8	35
1 5/8-8	38,1
1 3/4-8	41,3
1 7/8-8	44,5
2 - 8	47,7

BSF

British Standard-Fine-Gewinde
British Standard Fine thread
Filetage British Standard Fine
Filettatura fine standard inglese
Rosca Fina, Norma Británica

Kurzzeichen Thread size Désignation Diametro del filetto Dimensión rosca	Vorbohr-Ø Tapping drill size Ø de l'avantrou Diam. del preforo Dimensión broca (mm)
3/16-32	4
7/32-28	4,5
1/4-26	5,2
9/32-26	6
5/16-22	6,6
3/8-20	8,1
7/16-18	9,5
1/2-16	11
9/16-16	12,5
5/8-14	14
11/16-14	15,5
3/4-12	16,5
13/16-12	18,25
7/8-11	19,5
1 - 10	22,5
1 1/8-9	25,5
1 1/4-9	28,5
1 3/8-8	31,5
1 1/2-8	34,5

Kurzzeichen Thread size Désignation Diametro del filetto Dimensión rosca	Vorbohr-Ø zylindrisch Tapping drill size parallel Ø de l'avantrou cylindrique Diam. del preforo cilindrico Dimensión broca cilin. d ₁ (mm)	Vorbohr-Ø konisch Tapping drill size tapered Ø de l'avantrou conique Diam. del preforo conico Dimensión broca cónica D ₁ (mm)	Einschneidtiefe Thread depth Profondeur de taraudage Profondità di filettatura Profundidad rosca ET (mm)	Bohrtiefe Drill depth BT Profondità di foratura Profundidad broca min BT (mm)	Flanken-Ø pitch diameter dia. sur flancs diametro medio dia. medio E ₁ (mm)
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NPT

Amerikanisches kegeliges Rohrgewinde, Kegel 1:16

American standard pipe taper thread, taper 1:16 / Filetage standard américain conicité 1:16 pour tube conique avec perçage cylindrique
Filettatura conica americana, conicità 1:16 / Rosca cónica para tubo norma americana, conicidad 1:16

1/16-27	6,15	6,39	9,29	10,7	7,142
1/8-27	8,4	8,74	9,32	10,8	9,489
1/4-18	11,1	11,36	13,52	15,6	12,487
3/8-18	14,3	14,8	13,83	16	15,926
1/2-14	17,9	18,32	18,07	20,8	19,772
3/4-14	23,3	23,67	18,55	21,3	25,117
1-1 1/2	29	29,69	22,29	25,6	31,461
1 1/4-1 1/2	37,7	38,45	22,8	26,1	40,218
1 1/2-1 1/2	43,7	44,52	22,8	26,1	46,287
2-1 1/2	55,6	56,56	23,2	26,5	58,325
2 1/2-8	66,3	67,62	31,57	36,3	70,158
3-8	82,3	83,52	33,74	38,5	86,068

NPTF

Amerikanisches kegeliges Rohrgewinde, Kegel 1:16

American standard pipe taper thread, taper 1:16 / Filetage standard américain conicité 1:16 pour tube conique avec perçage cylindrique
Filettatura conica americana, conicità 1:16 / Rosca cónica para tubo norma americana, conicidad 1:16

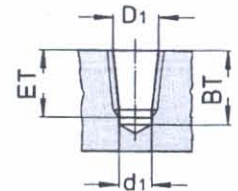
1/16-27	6,10	6,41	9,29	10,3	7,142
1/8-27	8,4	8,77	9,32	10,3	9,489
1/4-18	11,0	11,4	13,52	15	12,487
3/8-18	14,5	14,84	13,83	15,3	15,926
1/2-14	17,5	18,33	18,07	19,9	19,772
3/4-14	23,0	23,72	18,55	20,4	25,117
1-1 1/2	29,0	29,76	22,29	24,5	31,461
1 1/4-1 1/2	37,5	38,52	22,8	25	40,218
1 1/2-1 1/2	43,5	44,59	22,8	25	46,287
2-1 1/2	56,0	56,62	23,2	25,4	58,325
2 1/2-8	66,0	67,71	34,75	38	70,158
3-8	82,0	83,62	36,88	40	86,068

Rc = PT

Kegeliges Rohrgewinde ISO 7/1 und DIN 2999, Kegel 1:16

British Standard taper pipe thread ISO 7/1, taper 1:16 / Filetage pour tubes coniques, ISO 7/1, conicité 1:16
Filettatura Whitworth, filetto conico interno, ISO 7/1 e DIN 2999, conicità 1:16 / Rosca cónica para tubo norma británica ISO 7/1, conicidad 1:16

Rc 1/16-28	6,3	6,49	8,31	10,1
Rc 1/8-28	8,3	8,50	8,31	10,1
Rc 1/4-19	11	11,35	12,37	15
Rc 3/8-19	14,5	14,85	12,77	15,4
Rc 1/2-14	18,1	18,49	16,83	20,5
Rc 3/4-14	23,5	23,98	18,13	21,8
Rc 1-11	29,6	30,11	21,42	26
Rc 1 1/4-11	38,1	38,78	23,72	28,3
Rc 1 1/2-11	44	44,67	23,72	28,3
Rc 2-11	55,6	56,48	28,02	32,6
Rc 2 1/2-11	71,1	72	31,32	37,1
Rc 3-11	83,6	84,71	34,42	40,2



W keg / tap / con / cón

Kegeliges Whitworth-Gewinde DIN 477, Kegel 3:25

Whitworth Gas cylinder thread DIN 477, taper 3:25 / Filetage Whitworth conique DIN 477, conicité 3:25
Filettatura Whitworth, filetto conico, DIN 477, conicità 3:25 / Rosca Whitworth cónica botellas de gas

W 19,80-14	14,6	16,8	24,2	27,8
W 28,80-14	22,6	25,4	29,2	32,8
W 31,30-14	25,1	27,9	29,2	32,8

NPSM

Amerikanisches zylindrisches Rohrgewinde

American standard straight pipe thread
Filetage standard américain pour tubes cylindriques
Filettatura cilindrica americana
Rosca americana para tubo

Kurzzeichen Thread size Désignation Diametro del filetto Dimensión rosca	Vorbohr-Ø Tapping drill size Ø de l'avantrou Diam. del preforo Dimensión broca (mm)	Muttergewinde Kern-Ø Minor diameter Ø-intérieur Diametro del nocciolo Diám. Núcleo max / mass (mm)
1/8-27	9,1	9,246
1/4-18	12	12,217
3/8-18	15,5	15,545
1/2-14	19	19,279
3/4-14	24,5	24,639
1 - 11 1/2	30,5	30,759
1 1/4-11 1/2	39,5	39,497
1 1/2-11 1/2	45,5	45,568
2-11 1/2	57,5	57,607
2 1/2-8	69	69,266
3 - 8	85	85,166

Rp = PS

Whitworth-Rohrgewinde ISO 7/1 und DIN 2999

Whitworth Standard parallel internal pipe thread ISO 7/1 and DIN 2999
Filetage Whitworth pour tubes DIN 2999
Filettatura Whitworth ISO 7/1 e DIN 2999
Rosca cilíndrica interna para tubos ISO 7/1 y DIN 2999, norma Whitworth

Kurzzeichen Thread size Désignation Diametro del filetto Dimensión rosca	Vorbohr-Ø Tapping drill size Ø de l'avantrou Diam. del preforo Dimensión broca (mm)	Muttergewinde Kern-Ø Minor diameter Ø-intérieur Diametro del nocciolo Diám. Núcleo max / mass (mm)
Rp 1/16	6,55	6,632
Rp 1/8	8,6	8,637
Rp 1/4	11,5	11,549
Rp 3/8	15	15,054
Rp 1/2	18,5	18,773
Rp 3/4	24	24,259
Rp 1	30,25	30,471
Rp 1 1/4	39	39,132
Rp 1 1/2	44,85	45,025
Rp 2	56,5	56,836
Rp 2 1/2	72,25	72,443
Rp 3	85	85,143

W zyl / par / cyl / cil / cilínd.

Zylindrisches Whitworth-Gewinde DIN 477

Whitworth Gas cylinder thread DIN 477 / Filetage Whitworth, cylindrique DIN 477
Filettatura Whitworth, filetto cilindrico, DIN 477
Rosca Whitworth cilíndrica para botellas de gas, DIN 477

Kurzzeichen Thread size Désignation Diametro del filetto Dimensión rosca	Vorbohr-Ø Tapping drill size Ø de l'avantrou Diam. del preforo Dimensión broca (mm)	Muttergewinde Kern-Ø Minor diameter Ø-intérieur Diametro del nocciolo Diám. Núcleo max / mass (mm)
W 21,80-14	19,75	20,066
W 24,32-14	22,25	22,586

Pg

Stahlpanzer-Rohrgewinde DIN 40 430

Steel conduit thread DIN 40 430
Filetage pour raccords de tubes électriques DIN 40 430
Filettatura tubo corazzato / Rosca para tubos blindados DIN 40 430

Kurzzeichen Thread size Désignation Diametro del filetto Dimensión rosca	Vorbohr-Ø Tapping drill size Ø de l'avantrou Diam. del preforo Dimensión broca (mm)	Muttergewinde Kern-Ø Minor diameter Ø-intérieur Diametro del nocciolo Diám. Núcleo max / mass (mm)
Pg 7	11,4	11,43
Pg 9	14	14,01
Pg 11	17,25	17,41
Pg 13,5	19	19,21
Pg 16	21,25	21,31
Pg 21	26,9	27,03
Pg 29	35,5	35,73
Pg 36	45,5	45,73
Pg 42	52,5	52,73
Pg 48	58	58,03

Tr

Metrisches ISO-Trapez-Gewinde DIN 103

Metric ISO trapezoidal thread DIN 103 / Filetage métrique ISO trapézoïdal DIN 103
Filettatura trapezoidale ISO DIN 103 / Rosca trapezoidal métrica ISO, DIN 103

Kurzzeichen Thread size Désignation Diametro del filetto Dimensión rosca	Steigung Pitch Pas Paso P (mm)	Vorbohr-Ø Tapping drill size Ø de l'avantrou Diam. del preforo Dimensión broca (mm)	Muttergewinde Kern-Ø Minor diameter Ø-intérieur Diametro del nocciolo Diám. Núcleo max / mass (mm)
8	1,5	6,60	6,690
10	1,5	8,60	8,690
10	2	8,20	8,236
*10	3	7,50	7,500
12	2	10,20	10,236
12	3	9,2	9,315
14	2	12,20	12,236
14	3	11,25	11,315
*14	4	10,50	10,500
16	4	12,25	12,375
18	4	14,25	14,375
20	4	16,25	16,375
22	5	17,25	17,450
24	5	19,25	19,450
26	5	21,25	21,450
28	5	23,25	23,450
30	6	24,25	24,500
32	6	26,25	26,500
36	6	30,25	30,500
38	7	31,50	31,560
40	7	33,50	33,560
44	7	37,50	37,560
48	8	40,50	40,630
50	8	42,50	42,630

BA

British Association Standard Gewinde

British Association Standard thread / Filetage standard British Association
Filettatura associazione British standard / Rosca estándar British Association

Kurzzeichen Thread size Désignation Diametro del filetto Dimensión rosca	Steigung Pitch Pas Paso P (mm)	Vorbohr-Ø Tapping drill size Ø de l'avantrou Diam. del preforo Dimensión broca (mm)
Nr. 0	1	5,1
Nr. 1	0,9	4,5
Nr. 2	0,81	4
Nr. 3	0,73	3,4
Nr. 4	0,66	3
Nr. 5	0,59	2,6
Nr. 6	0,53	2,3
Nr. 7	0,48	2
Nr. 8	0,43	1,8
Nr. 9	0,39	1,5
Nr. 10	0,35	1,3
Nr. 11	0,31	1,2
Nr. 12	0,28	1
Nr. 13	0,25	0,95

G = PF**Rohrgewinde DIN ISO 228-1**

British Standard pipe thread DIN ISO 228-1/ Filetage tube DIN ISO 228-1

Filettatura Whitworth a Gas cilindrica, DIN ISO 228-1 /

Rosca para tubos DIN ISO 228-1, Norma Británica

Kurzzzeichen Thread size Désignation Diametro del filetto Dimensión rosca	Vorböhr-Ø Tapping drill size Ø de l'avantrou Diam. del preforo Dimensión broca (mm)	Muttergewinde Kern-Ø Minor diameter / Ø-intérieur Diametro del nocciolo Diám. Núcleo (mm)	
		min	max / mass
G 1/8-28	8,8	8,566	8,848
G 1/4-19	11,8	11,445	11,890
G 3/8-19	15,25	14,950	15,395
G 1/2-14	19	18,631	19,172
G 5/8-14	21	20,587	21,128
G 3/4-14	24,5	24,117	24,658
G 7/8-14	28,25	27,877	28,418
G 1-11	30,75	30,291	30,931
G 1 1/8-11	35,5	34,939	35,579
G 1 1/4-11	39,5	38,952	39,592
G 1 3/8-11	41,9	41,366	42,006
G 1 1/2-11	45,25	44,845	45,485
G 1 3/4-11	51	50,788	51,428
G 2-11	57	56,656	57,296
G 2 1/4-11	63,1	62,752	63,392
G 2 1/2-11	72,6	72,226	72,866
G 3-11	85,5	84,926	85,566

EG M**Metrisches ISO-Regelgewinde**

für Gewindeeinsätze aus Draht

Metric ISO thread for screw thread inserts

Filetage métrique ISO standard

Filettatura metrica ISO per inserti filettati

Rosca Métrica ISO para montaje de insertos

Kurzzzeichen Thread size Désignation Diametro del filetto Dimensión rosca	Vorböhr-Ø Tapping drill size Ø de l'avantrou Diam. del preforo Dimensión broca (mm)
EG M 2,5	2,6
EG M 3	3,2
EG M 3,5	3,7
EG M 4	4,2
EG M 5	5,2
EG M 6	6,3
EG M 8	8,4
EG M 10	10,5
EG M 12	12,5
EG M 14	14,5
EG M 16	16,5
EG M 18	18,75
EG M 20	20,75
EG M 22	22,75
EG M 24	24,75

EG MF**Metrisches ISO-Feingewinde**

für Gewindeeinsätze aus Draht

Metric ISO Fine thread for screw thread inserts

Filetage métrique ISO fin

Filettatura metrica ISO fine per inserti filettati

Rosca Métrica ISO fina para montaje de insertos

Kurzzzeichen Thread size Désignation Diametro del filetto Dimensión rosca	Vorböhr-Ø Tapping drill size Ø de l'avantrou Diam. del preforo Dimensión broca (mm)
EG M 8 x 1	8,3
EG M 10 x 1	10,25
EG M 10 x 1,25	10,4
EG M 12 x 1,25	12,25
EG M 12 x 1,5	12,5
EG M 14 x 1,5	14,5
EG M 16 x 1,5	16,5
EG M 18 x 1,5	18,5
EG M 20 x 1,5	20,5
EG M 18 x 2	19,5

EG UNC**Unified Coarse-Gewinde**

für Gewindeeinsätze aus Draht

Unified Coarse thread for screw thread inserts

Filetage Unified Coarse

Filettatura grossa unificata per inserti filettati

Rosca Unificada Gruesa para montaje de insertos

Kurzzzeichen Thread size Désignation Diametro del filetto Dimensión rosca	Vorböhr-Ø Tapping drill size Ø de l'avantrou Diam. del preforo Dimensión broca (mm)
EG-Nr. 2-56	2,3
EG-Nr. 3-48	2,7
EG-Nr. 4-40	3
EG-Nr. 5-40	3,4
EG-Nr. 6-32	3,7
EG-Nr. 8-32	4,4
EG-Nr. 10-24	5,1
EG-Nr. 12-24	5,8
EG 1/4-20	6,7
EG 5/16-18	8,4
EG 3/8-16	10
EG 7/16-14	11,7
EG 1/2-13	13,3

EG UNF**Unified Fine-Gewinde**

für Gewindeeinsätze aus Draht

Unified Fine thread for screw thread inserts

Filetage Unified Fine

Filettatura fina unificata per inserti filettati

Rosca Unificada Fina para montaje de insertos

Kurzzzeichen Thread size Désignation Diametro del filetto Dimensión rosca	Vorböhr-Ø Tapping drill size Ø de l'avantrou Diam. del preforo Dimensión broca (mm)
EG-Nr. 2-64	2,3
EG-Nr. 3-56	2,65
EG-Nr. 4-48	3
EG-Nr. 5-44	3,3
EG-Nr. 6-40	3,7
EG-Nr. 8-36	4,4
EG-Nr. 10-32	5,1
EG 1/4-28	6,6
EG 5/16-24	8,2
EG 3/8-24	9,8
EG 7/16-20	11,5
EG 1/2-20	13,1

Gewindekernlöcher für Gewindeformer

Tapping drill sizes for Internal thread formers / Avant-trous de tarauds travaillant par déformation

Prefori per maschi rullatori / Dimensiones de la broca previa para machos laminadores

M

Metrisches ISO Regelgewinde

Metric ISO thread
Filetage métrique ISO standard
Filettatura metrica ISO
Rosca Métrica ISO

Kurzzeichen Thread size Désignation Diametro del filetto Dimensión rosca	Vorbohr-Ø Tapping drill size Ø de l'avantrou Diam. del preforo Dimensión broca (mm)
M 1	0,88±0,01
M 1,2	1,08±0,01
M 1,4	1,25±0,01
M 1,6	1,45±0,02
M 1,7	1,55±0,02
M 1,8	1,65±0,02
M 2	1,8±0,02
M 2,2	2±0,02
M 2,3	2,1±0,02
M 2,5	2,3±0,02
M 2,6	2,4±0,02
M 3	2,8±0,03
M 3,5	3,25±0,03
M 4	3,7±0,03
M 5	4,65±0,03
M 6	5,55±0,05
M 8	7,4±0,05
M 10	9,3±0,05
M 12	11,2±0,05
M 14	13,1±0,05
M 16	15,1±0,05
M 18	16,9±0,05
M 20	18,9±0,05
M 22	20,9±0,05
M 24	22,65±0,05

MF

Metrisches ISO Fein-gewinde

Metric ISO-Fine thread
Filetage métrique fin ISO
Filettatura metrica ISO fine
Rosca Métrica ISO Fina

Kurzzeichen Thread size Désignation Diametro del filetto Dimensión rosca	Vorbohr-Ø Tapping drill size Ø de l'avantrou Diam. del preforo Dimensión broca (mm)
M 4 x 0,5	3,75±0,03
M 5 x 0,5	4,75±0,03
M 6 x 0,5	5,75±0,03
M 8 x 0,5	7,75±0,03
M 6 x 0,75	5,65±0,03
M 8 x 0,75	7,65±0,03
M 10x0,75	9,65±0,03
M 8 x 1	7,55±0,05
M 10 x 1	9,55±0,05
M 12 x 1	11,55±0,05
M 14 x 1	13,55±0,05
M 16 x 1	15,55±0,05
M 18 x 1	17,55±0,05
M 12 x 1,5	11,3±0,05
M 14 x 1,5	13,3±0,05
M 16 x 1,5	15,3±0,05
M 18 x 1,5	17,3±0,05
M 20 x 1,5	19,3±0,05
M 22 x 1,5	21,3±0,05
M 24 x 1,5	23,3±0,05
M 20 x 2	19,1±0,05
M 22 x 2	21,1±0,05
M 24 x 2	23,1±0,05

UNC

Unified Coarse Gewinde

Unified Coarse thread
Filetage Unified Coarse
Filettatura grossa unificata
Rosca Unificada Gruesa

Kurzzeichen Thread size Désignation Diametro del filetto Dimensión rosca	Vorbohr-Ø Tapping drill size Ø de l'avantrou Diam. del preforo Dimensión broca (mm)
Nr. 2-56	1,95±0,02
Nr. 3-48	2,25±0,03
Nr. 4-40	2,55±0,03
Nr. 5-40	2,9±0,03
Nr. 6-32	3,15±0,03
Nr. 8-32	3,8±0,03
Nr. 10-24	4,35±0,05
Nr. 12-24	5±0,05
1/4-20	5,75±0,05
5/16-18	7,3±0,05
3/8-16	8,8±0,05
7/16-14	10,3±0,05
1/2-13	11,8±0,05
9/16-12	13,3±0,05
5/8-11	14,8±0,05
3/4-10	17,9±0,05
7/8-9	20,95±0,05
1-8	24±0,05

UNF

Unified Fine-Gewinde

Unified Fine thread / Filetage Unified Fine
Filettatura fine unificata / Rosca Unificada Fina

Kurzzeichen Thread size Désignation Diametro del filetto Dimensión rosca	Vorbohr-Ø Tapping drill size Ø de l'avantrou Diam. del preforo Dimensión broca (mm)
Nr. 2-64	2±0,02
Nr. 3-56	2,3±0,02
Nr. 4-48	2,6±0,03
Nr. 5-44	2,9±0,03
Nr. 6-40	3,2±0,03
Nr. 8-36	3,85±0,03
Nr. 10-32	4,45±0,03
Nr. 12-28	5,1±0,05
1/4-28	5,95±0,05
5/16-24	7,45±0,05
3/8-24	9±0,05
7/16-20	10,5±0,05
1/2-20	12,1±0,05
9/16-8	13,65±0,05
5/8-18	15,25±0,05
3/4-16	18,3±0,05
7/8-14	21,4±0,05

UNEF

Unified Extra-Fine-Gewinde

Unified Extra Fine thread
Filetage Unified Extra-fine
Filettatura extra fine unificata
Rosca Unificada Extra Fina

Kurzzeichen Thread size Désignation Diametro del filetto Dimensión rosca	Vorbohr-Ø Tapping drill size Ø de l'avantrou Diam. del preforo Dimensión broca (mm)
1/4-32	6 ±0,05
5/16-32	7,6±0,05
3/8-32	9,1±0,05
7/16-28	10,7±0,05
1/2-8	12,3±0,05
9/16-24	13,8±0,05
5/8-24	15,4±0,05
3/4-20	18,5±0,05
7/8-20	21,6±0,05
1-20	24,8±0,05

BSW

British Standard-Whitworth-Gewinde

British Standard Whitworth thread
Filetage British Standard Whitworth
Filettatura Whitworth standard inglese
Rosca Whitworth Norma Británica

Kurzzeichen Thread size Désignation Diametro del filetto Dimensión rosca	Vorbohr-Ø Tapping drill size Ø de l'avantrou Diam. del preforo Dimensión broca (mm)
3/32-48	2,10±0,02
1/8-40	2,85±0,03
5/32-32	3,55±0,03
3/16-24	4,2±0,03
1/4-20	5,7±0,05
5/16-18	7,2±0,05
3/8-16	8,7±0,05
7/16-14	10,2±0,05
1/2-12	11,6±0,05
9/16-12	13,2±0,05
5/8-11	14,7±0,05
1 1/16-11	16,25±0,05
3/4-10	17,7±0,05
7/8-9	20,75±0,05
1-8	23,75±0,05

G

Rohrgewinde DIN ISO 228-1

British Standard pipe thread DIN ISO 228-1
Filetage tube DIN ISO 228-1
Filettatura Whitworth a Gas cilindrica,
DIN ISO 228-1
Rosca para tubos DIN ISO 228-1,
Norma Británica

Kurzzeichen Thread size Désignation Diametro del filetto Dimensión rosca	Vorbohr-Ø Tapping drill size Ø de l'avantrou Diam. del preforo Dimensión broca (mm)
G 1/16	7,25±0,05
G 1/8	9,25±0,05
G 1/4	12,5±0,05
G 3/8	16±0,05
G 1/2	20±0,05
G 5/8	22±0,05
G 3/4	25,5±0,05
G 7/8	29,25±0,05
G 1	32±0,05

Muttergewinde /	
Internal thread /	8H
Ecrou /	
Filetto interno /	
Rosca hembra	

**Gewindebohrer /
Taps / Tarauds /
Maschi / Machos**

**Gewindebohrer
mit Typenaufmaß /
Taps with specific P.D.
(pitch dia.) /
Taraud avec surcôte /
Maschio con tipo
di svoramisura /
Macho con tipo
de sobremedida**

**Gewindeformer /
Internal thread formers/
Tarauds travaillant par
déformation /
Maschi rullatori /
Machos laminadores**

Muttergewinde /
Internal thread / Erou /
Filetto interno / Rosca hembra



pitch diameter D_2

t = tolerance unit

Diamètre sur flancs
du profil de base

t = unité de tolérance

Diam. dei fianchi del profilo
di base

t = Unità di tolleranza

Dia. de flancos del
perfil base

t = Unidad de tolerancia

Tapping ~~is~~ a problem was



FROM M-3
TO M-60



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SL 1200 M2-M16

SL 1200 är speciellt lämpad för arbeten på begränsade ytor. Tack vare en enkelt justerbar luftcylinder blir rörelsen mjuk och exakt.

Ingående komponenter SL 1200

Stationärt bänkfäste
 Gängarm med ljuddämpare av typen RD (Reduced Decibel) och filter för returluften
 Luftberedningsenhet med vattenavskiljare och dimsmörjare samt manometer
 2,5 dl dimsmörjolja
 Motorfäste för vertikal gängning (VE) eller för både vertikal och horisontell gängning (HV)
 Luftmotor 400 Rpm med Bilz snabbväxelchuck, WF1

SL 1200 is especially suitable for operations in tight work spaces. Due to the easily adjustable counter balance air cylinder it has a smooth and precise movement.

Included components SL 1200

*Stationary bench bracket
 Tapping arm with silencer and filter for the exhaust air
 Air preparation unit with water trap, mist lubricator and pressure gauge
 2,5 dl lubrication oil
 Motor bracket for vertical (VE) tapping or for both vertical and horizontal (HV) tapping
 Air driven motor, 400 Rpm with Bilz quick change chuck, WF1*

SL 1200

Art. nr Item No	Arbetsområde Working area		Max viktbelastning Maximum charge	Vridmoment motor Max. torque of motor	Kapacitet Capacity	Luftförbrukning Air consumption	Lufttryck Air pressure	Luftanslutning Air inlet hose	Rek. dimsmörolja Rec. lubrication oil	Vikt Weight
	Rmin	Rmax	kg	Nm		l/min	bar	tum/inch		kg
SL60400	260	1200	3,5	52	M2-M16	950	6-7	3/8	ISO VG 05	12

Thread Gauges

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Praisionswerkzeugfabrik

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worldwide for
their quality
and resistance
to wear...*



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- Optimum surface finish on the thread flanks and high hardness provide outstanding resistance to wear and long gauge life.
- Optimum price/performance relationship for improved cost-effectiveness.
- Large stocks covering more than 7,000 different thread dimensions and tolerances for quick delivery (ex. Germany)
- Manufactured from aged gauge steel for durable dimensional stability.



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