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**GHISA**  
Cast Iron - Fonte





## Materiale

*Material - Matériau*

PM3 Acciaio super rapido sinterizzato ad alto contenuto di vanadio e cobalto.

*PM3 Powdered metallurgy high speed steel with high contents of vanadium and cobalt.*

*Acier super rapide fritté PM3 à haute teneur en vanadium et cobalt.*

## Anello colorato

*Colored ring - Bague de couleur*

Identifica in maniera molto pratica il campo di applicazione del maschio.

*The colored ring allows to identify the practical destination of the tap.*

*Sert à identifier de façon rapide le champ d'application du taraud.*

## Scanalature diritte

*Straight Flutes*

*Goujures droites*

Progettate per lavorare la ghisa; basso angolo di taglio e spoglie dorsali accentuate.

*Designed for machining cast iron; low cutting angle combined with high reliefs.*

*Conçue pour l'usinage de fonte ; angle de coupe faible et haut dépouille.*

## Rivestimento

*Coating - Revêtement*

TX e TXS ottima resistenza all'usura e all'ossidazione, ottimale per lavorare materiali abrasivi come le ghise.

*TX and TXS: excellent combination of coating against wear and oxidation. Optimal to machine abrasive materials such as cast iron.*

*TX et TXS excellente résistance à l'usure et à l'oxydation, optimale pour les matériaux abrasifs tels que la fonte.*

## Imbocco

*Chamfer - Entrée*

Imbocco tipo C (2-3xP), disponibili anche con imbocco E (1,5-2xP).

*Chamfer type C (2-3xP), also available with chamfer E (1,5-2xP).*

*Entrée type C (2-3xP), aussi disponibles avec entrée E (1,5-2xP).*

**A richiesta – On request – Sur demande**

## FOR

**Lubrificazione interna con uscita assiale.**

*Through coolant, axial flow.*

*Lubrification interne à sortie axiale.*



## FORY

**Lubrificazione interna con uscita radiale.**

*Through coolant, radial flow.*

*Lubrification interne à sortie radiale.*



## Filettature – Thread – Filetage

<b>M</b>	pag	4 - 6
<b>MF</b>	pag	8 - 9
<b>UNC</b>	pag	10
<b>UNF</b>	pag	11
<b>GAS</b>	pag	12
<b>ISO529</b>	pag	13

## Materiale – Material – Matériau

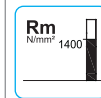
**PM3** Acciaio sinterizzato ad alta % di Co & V – Powdered metallurgy with high % Co and V – Acier fritté avec haute % Co et V

## Rivestimento – Coating – Revêtement

<b>TiAlN</b>	Resistenza all'usura e all'ossidazione – Oxidation and wear resistance – Résistance à l'usure et à l'oxydation
<b>TiCN</b>	Resistenza all'usura – Wear resistance – Résistance à l'usure
<b>TXS</b>	Applicazione su ghisa ed elevata resa produttiva – Application for cast iron and high yield – Application sur la fonte et à haut rendement

## Campo applicativo – Application field – Champs d'applications

<b>3.1 3.2 3.3 3.4 3.5</b>	Ghisa – Cast iron – Fonte
<b>4.4</b>	Leghe di alluminio Si $\geq$ 10% – Aluminium alloys Si $\geq$ 10% – Alliages aluminium Si $\geq$ 10%
<b>5.3 5.4</b>	Leghe di rame, ottone, bronzo - Truciolo corto – Cooper alloys, brass, bronze - Short chipping – Alliages de cuivre, laiton, bronze - Coupeaux courts
<b>10.1</b>	Grafite – Graphite



## Per fori ciechi e passanti – For Blind and through holes – Pour trous débouchants et borgnes

**K26 K27** Tagli diritti – Straight flutes – Goujournes droites

A richiesta – On request – Sur demande

Lubrificazione interna con uscita assiale – Through coolant, axial flow – Lubrification interne avec sortie axiale

Lubrificazione interna con uscita radiale – Through coolant, radial flow – Lubrification interne avec sortie radiale

## Per fori ciechi – For blind holes – Pour trous borgnes

**K28 K29** Elica 25° dx rastremazione posteriore – Spiral flutes 25° rh back tapered tread – Hélice 25° dx détalonnage arrière

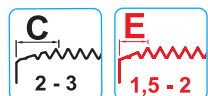
A richiesta – On request – Sur demande

Lubrificazione interna con uscita assiale – Through coolant, axial flow – Lubrification interne avec sortie axiale

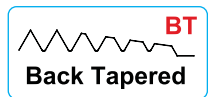
## Legenda icone – Icon description – Légende icônes



Filettatura destra – Right thread – Filetage à droite



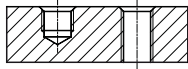
Tipi di imbocco – Chamfer type – Nombre de filets d'entrée



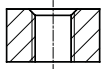
Rastremazione posteriore a botte del filetto – Back tapered thread – Détalonnage arrière

# TABELLA D'IMPIEGO

## APPLICATION TABLE TABLE D'OPÉRATION



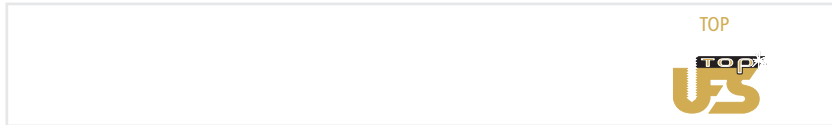
Applicazione per foro cieco e passante  
Blind and through hole application  
Application pour trou borgne et débouchant



Applicazione per foro passante  
Through hole application  
Application pour trou débouchant



Applicazione per foro cieco  
Blind hole application  
Application pour trou borgne



- LH Filettatura sinistra  
*Left hand thread - Filetage à gauche*
- Ms58 Applicazione specifica per ottone Ms58  
*Specific application for brass Ms58 - Spécifique pour laiton Ms58*
- AZ Alternatura del filetto  
*Interrupted threads - Taraud avec filets alternés*
- SR Synchro Rigid, maschiatura rigida sincronizzata  
*Rigid tapping Synchro - Synchro Rigide, taraudage rigide synchronisée*
- XL Maschi con gambo lungo  
*Taps with long shank - Tarauds série longue*
- BT Back Tapered, rastremazione posteriore a botte del filetto  
*Back tapered thread - Détalonnage arrière*
- IT Inox Tapered, rastremazione posteriore orizzontale del filetto  
*Horizontal back tapered for Inox application  
INOX Tapered, détalonné conique horizontale pour application Inox*
- con1:16 Maschi con filettatura conica  
*Taps with tapered thread - Tarauds à filetage conique*
- Al Applicazione specifica per alluminio e leghe d'alluminio  
*Specific application for aluminium and aluminium alloys  
Application spécifique pour l'aluminium et alliages d'aluminium*
- Cu Applicazione specifica per rame e leghe rame  
*Specific application for cooper and cooper alloys - Application spécifique pour le cuivre et ses alliages*
- Ti Applicazione specifica per titanio e leghe di titanio  
*Specific application for titanium and titanium alloys - Application spécifique pour titane et alliages de titane*
- Ni Applicazione specifica per nichel e leghe di nichel  
*Specific application for nickel and nickel alloys - Application spécifique pour le nickel et ses alliages*

- Utilizzo raccomandato - velocità di taglio m/min      ○ Utilizzo accettabile - velocità di taglio m/min
- Recommended Use - cutting speed m/min            ○ Acceptable Use - cutting speed m/min
- Utilisation-Recommandée - vitesse de coupe m/min      ○ Utilisation acceptable - vitesse de coupe m/min

1. Acciaio <i>Steel Acier</i>	1.1 Acciaio dolce magnetico Magnetic soft steel Acier doux magnétique	1.2 Acciaio da costruzione, cementazione, automatico Structural, case carburizing and free cutting steel Acier de construction, trempé et automatique	1.3 Acciaio al carbonio Plain carbon steel Acier au carbone	1.4 Acciaio legato - Bonificato, fusioni d'acciaio Alloyed steel - Tempered steel, steel castings Acier allié, trempé et revenu, moulages d'acier	1.5 Acciaio legato - Bonificato Alloyed steel - Tempered steel Acier allié, trempé et revenu	1.6 Acciaio legato - Alta resistenza Alloyed steel - High strength steel Acier allié, haute résistance	1.7 Acciaio legato - Alta resistenza Alloyed steel - High strength steel Acier allié, haute résistance	1.8 Acciaio legato - Temprato Hardened steel Acier trempé						
2. Acciaio INOX <i>Stainless Steel Acier inoxydable</i>	2.1 Acciaio inox automatico Free machining stainless steel Acier inoxydable, automatique	2.2 Austenitico Austenitic Austénitique	2.3 Ferritico, Ferritico + Austenitico, Martensitico Ferritic, Ferritic + Austenitic, Martensitic Ferritique, austénitique + ferritiques, martensitiques	2.4 Leghe Cr-Ni resistenti alle alte temperature Cr-Ni alloys high temperatures resistant Alliage Cr-Ni résistant à des températures élevées	< 250	< 250	< 250	< 250						
	3. Ghisa <i>Cast iron Fonte</i>	3.1 Ghisa grigia lamellare Lamellar grey cast iron Fonte grise lamellaire	3.2 Ghisa grigia lamellare Lamellar grey cast iron Fonte grise lamellaire	3.3 Ghisa sferoidale Nodular cast iron Fonte ductile	3.4 Ghisa malleabile Malleable cast iron Fonte malléable	250÷350	38÷45 HRC	45÷49 HRC	49÷62 HRC					
		3.5 Ghisa vermicolare a grafite compatta Compacted cast iron with vermicular graphite Fonte vermiculaire à graphite compacté	4.1 Alluminio / Magnesio non legato Aluminium / Magnesium unalloyed Aluminium / Magnésium non allié	4.2 Leghe di Al, Si < 0,5% - Truciolo lungo Al alloys, Si < 0.5% - Long chipping Alliage Al, Si < 0.5% copeaux longs	4.3 Leghe di Al, Si < 10% - Truciolo medio Al alloys, Si < 10% - Medium chipping Alliage Al, Si < 10% copeaux moyens	4.4 Leghe Al, Si > 10% - Truciolo corto Al alloys, Si > 10% - Short chipping Alliage Al, Si > 10% copeaux courts	4.5 Leghe standard di magnesio Magnesium standard alloys Alliages de magnésium standards	4.6 Leghe di magnesio ad alta resistenza High strength magnesium alloys Alliages de magnésium de haute résistance	70÷120	240÷400				
		5. Rame <i>Cooper Cuivre</i>	5.1 Rame puro, Rame elettrolitico - Truciolo lungo Cooper unalloyed - Long chipping Cuivre pur, cuivre électrolytique, copeaux longs	5.2 Leghe di rame, α-ottone - Truciolo lungo Cooper alloys, soft brass - Long chipping Alliages de cuivre, α-laiton copeaux longs	5.3 Leghe di rame, β-ottone, Bronzo - Truciolo corto Cooper alloys, hard brass, bronze - Short chipping Alliages de cuivre, β-laiton, bronze copeaux courts	5.4 Bronzo ad alta resistenza High strength bronze Bronze haute résistance	< 100	< 200	< 200	< 200				
6. Titanio <i>Titanium Titane</i>			6.1 Titanio non legato Titanium unalloyed Titane non allié	6.2 Leghe di titanio Titanium alloys Alliages de titane	6.3 Leghe di titanio Titanium alloys Alliages de titane	7.1 Nichel non legato Nickel unalloyed Nickel non allié	7.2 Leghe di Nichel Nickel alloys Alliages de nickel	7.3 Leghe di Nichel Nickel alloys Alliages de nickel	< 200	< 270	< 410	< 150	< 270	< 470
	8. Materie plastiche <i>Synthetic Material Matériaux Plastiques</i>		8.1 Materiali termoplastici - Truciolo extralungo Thermoplastics - Extra long chipping Matériaux thermoplastique copeaux extra-longues	8.2 Materiali termoindurenti - Truciolo corto Thermosetting plastics - Short chipping Matériaux thermodurcissables copeaux courts	8.3 Materie plastiche con fibre di rinforzo Reinforced plastic materials Plastiques avec fibres de renfort	9.1 Materiali metallo - Ceramic (Cermets) TIC - Hard materials Matériaux métalliques, céramiques (Cermet)	9.2 Leghe a base cobalto Alloys on cobalt base Alliages à base de cobalt	9.3 Leghe di tungsteno Tungsten alloys Alliages de tungstène	< 80	< 110	240÷440	800÷1500	< 51 HRC	< 1700
			9. Materiali speciali <i>Special materials Matériaux spéciaux</i>	10.1 Grafite Graphite Graphite						< 80	< 110	< 350	< 1200	< 52 HRC
10. Grafite / Graphite								< 80	< 110	< 350	< 1200	< 52 HRC	< 1800	

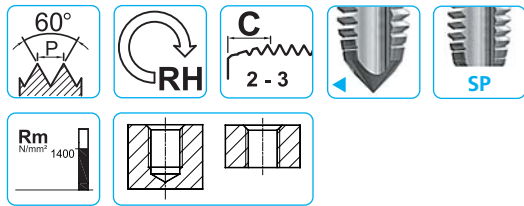
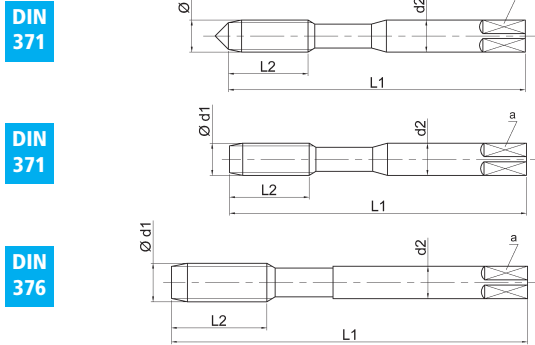
Descrizione <i>Description - Description</i>	
Tipi di foro <i>Hole Types - Type de trous</i>	
CODICE - CODE - CODE	
Linea - Product line - Ligne	
Elica / NOTE <i>Flute Type / Notes - Hélice / Notes</i>	
M	ISO2/6H
MJ	ISO1/4H
	ISO3/6G
	7G   6H+0,1
MF	ISO2/6H
MJF	ISO1/4H
	ISO3/6G
	7G   6H+0,1
UNC	2B   3BX
UNF	2B   3BX
UNEF	2B
UNS	2B
8-12-16 UN	2B
20-28-32 UN	2B
G, (Rp)	
NPSM	
NPSF	
Rc	
NPT	
NPTF	
BSW	
PG, Tr, Rd	
EG-M	
Imbocco / Chamfer / Entrée	
Materiale / Steel tap / Matériel	
Rivestimenti / Coating / Revêtements	
Classe appl. / Appl. Class. / Classe d'appl.	
Prof. filetto / Thread depth / Profondeur fil	

Indicazione numero di pagina  
Page number  
Numéro de page

Maschi scanalature diritte per GHISA-PM3 Straight flutes for CAST IRON - PM3 Goujures Droites pour FONTE - PM3				Maschi scanalature diritte per GHISA imb.E-PM3 Straight flutes for CAST IRON - chamfer E Goujures Droites pour FONTE - entrée E			Elica 25° per GHISA Helix 25° for CAST IRON Hélice 25° pour FONTE			Maschi ISO529 Taps ISO529 Tarauds ISO529
K26/K27...TX	K26/K27_FOR-TX	K26/K27_FOR-TX	K26/K27...TXS	K26/K27E...TX	K26/K27E_FOR-TX	K26/K27E_FOR-TX	K28/K29...	K28/K29...CT	K28/K29...FOR-CT	529K26...TXC
TOP	TOP	TOP	TOP	TOP	TOP	TOP	TOP	TOP	TOP	TOP
							BT R25°	BT R25°	BT R25°	
4	4	4	4	5	5	5	6	6	6	13
8	8	8	8	9	9	9				
10	10									
11	11									
12	12									
C (2-3)	C (2-3)	C (2-3)	C (2-3)	E (1,5-2)	E (1,5-2)	E (1,5-2)	C (2-3)	C (2-3)	C (2-3)	C (2-3)
PM3	PM3	PM3	PM3	PM3	PM3	PM3	PM3	PM3	PM3	PM3
TiAlN	TiAlN	TiAlN	TXS	TiAlN	TiAlN	TiAlN	Br	TiCN	TiCN	TXC
GG	GG	GG	GG	GG	GG	GG	GG	GG	GG	GG
3xD	3,5xD	3,5xD	3,5xD	3xD	3,5xD	3,5xD	2,5xD	2,5xD	2,5xD	3xD
1.1										
1.2										
1.3										
1.4							○ 8-10	■ 15-20	■ 15-20	
1.5							○ 3-5	■ 5-12	■ 5-12	○ 5-12
1.6										■ 5-8
1.7										
1.8										
2.1										
2.2										
2.3										
2.4										
3.1	■ 25-30	■ 25-30	■ 25-30	■ 25-30	■ 20-25	■ 20-25	■ 20-25			■ 25-30
3.2	■ 20-25	■ 20-25	■ 20-25	■ 20-25	■ 15-20	■ 15-20	■ 15-20			■ 20-25
3.3	○ 20-25	○ 20-25	○ 20-25	○ 20-25	○ 15-20	○ 15-20	○ 15-20	○ 8-10	■ 15-20	■ 15-20
3.4	○ 25-30	○ 25-30	○ 25-30	○ 25-30	○ 20-25	○ 20-25	○ 20-25	○ 10-15	■ 20-25	■ 20-25
3.5	■ 20-25	■ 20-25	■ 20-25	■ 20-25	■ 15-20	■ 15-20	■ 15-20			■ 20-25
4.1										
4.2										
4.3										
4.4	○ 25-30	○ 25-30	○ 25-30	○ 25-30	○ 25-30	○ 25-30	○ 25-30			■ 25-30
4.5										
4.6										
5.1										
5.2										
5.3	■ 25-30	■ 25-30	■ 25-30	■ 25-30	■ 25-30	■ 25-30	■ 25-30			■ 25-30
5.4	○ 5-8	○ 5-8	○ 5-8	○ 5-8						○ 5-8
6.1										
6.2										
6.3										
7.1										
7.2										
7.3										
8.1										
8.2										■ 10-15
8.3										■ 6-10
9.1										
9.2										
9.3										
10.1	○ 15-20	○ 15-20	○ 15-20	○ 15-20	○ 15-20	○ 15-20	○ 15-20			○ 15-20

## MASCHI A MACCHINA

### MACHINE TAPS - TARAUDS MACHINE



Profond. di filettatura - Thread depth - Profond. de filetage

Materiale - Material - Matériau

Tolleranza - Tolerance - Tolérance

Trattamento superficiale - Surface treatment - Revêtement

Al Si > 10%,  
 Ottone / Brass / Laiton  
 Bronzo / Bronze / Bronze  
 truciolo corto / short chip /  
 copeaux courts

Numero gruppi materiali  
 Material's groups number  
 Nombre de groupes du matériau

3xD	3,5xD	3,5xD	3xD
PM3	PM3	PM3	PM3
6HX	6HX	6HX	6HX
TiAIN	TiAIN	TiAIN	TXS
3.1 3.2 3.3 3.4 3.5	3.1 3.2 3.3 3.4 3.5	3.1 3.2 3.3 3.4 3.5	3.1 3.2 3.3 3.4 3.5
4.4 5.3 5.4	4.4 5.3 5.4	4.4 5.3 5.4	4.4 5.3 5.4
10.1	10.1	10.1	10.1

DIN 371	Ød1 M	P mm	L1	L2 10xP	d2 h9	a h12	Z	
◀	4	0,7	63	13	4,5	3,4	3	3,3
◀	5	0,8	70	13	6	4,9	3	4,2
◀	6	1	80	16	6	4,9	4	5
◀	8	1,25	90	18	8	6,2	4	6,8
◀	10	1,5	100	20	10	8	4	8,5
	6	1	80	16	6	4,9	4	5
	8	1,25	90	18	8	6,2	4	6,8
	10	1,5	100	20	10	8	4	8,5

CODICE - CODE			
K26M...TX			K26M...TXS
•			•
•			•
•			•
•			•
•			•
K26M...SP-TX	K26M...FOR-TX	K26M...FORY-TX	
◊	◊	◊	
◊	◊	◊	
◊	◊	◊	

DIN 376	Ød1 M	P mm	L1	L2 10xP	d2 h9	a h12	Z	
	12	1,75	110	25	9	7	4	10,3
	14	2	110	28	11	9	4	12
	16	2	110	28	12	9	4	14
	18	2,5	125	33	14	11	5	15,5
	20	2,5	140	33	16	12	5	17,5
	22	2,5	140	33	18	14,5	5	19,5
	24	3	160	39	18	14,5	5	21

CODICE - CODE			
K27M...TX	K27M... FOR-TX	K27M...FORY-TX	K27M...TXS
•	◊	◊	•
•	◊	◊	•
•	◊	◊	•
◊	◊	◊	◊
◊	◊	◊	◊
◊	◊	◊	◊
◊	◊	◊	◊

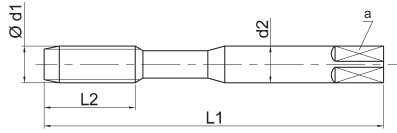
Confezione / Box / Colis: M3 - M12: 5 pezzi / pcs >M12: singoli / single pcs	€ Pag. listino - Price list - Liste des prix	8	8	8	8
• Standard	◊ Disponibilità da richiedere, prezzo a listino On enquiry, standard price-list / Stock à vérifier			★ Solo a richiesta Only on request / Sur demande	

**GG** **GHISA**  
 Cast Iron - Fonte

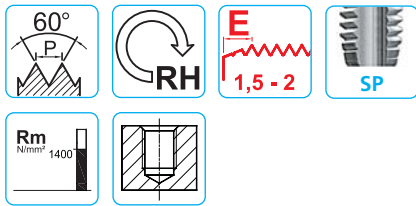
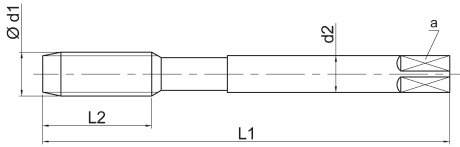
**MASCHI A MACCHINA**

**MACHINE TAPS - TARAUDS MACHINE**

**DIN 371**



**DIN 376**



**TOP**



**TOP**



**TOP**



Profond. di filettatura - Thread depth - Profond. de filetage

Materiale - Material - Matériau

Tolleranza - Tolerance - Tolérance

Trattamento superficiale - Surface treatment - Revêtement

Al Si > 10%,  
 Ottone / Brass / Laiton  
 Bronzo / Bronze / Bronze  
 truciolo corto / short chip /  
 coupeaux courts

Numero gruppi materiali  
 Material's groups number  
 Nombre de groupes du matériau

**3xD**

**PM3**

**6HX**

**TiAlN**

3.1 3.2 3.3 3.4 3.5

4.4 5.3

10.1

**3,5xD**

**PM3**

**6HX**

**TiAlN**

3.1 3.2 3.3 3.4 3.5

4.4 5.3

10.1

**3,5xD**

**PM3**

**6HX**

**TiAlN**

3.1 3.2 3.3 3.4 3.5

4.4 5.3

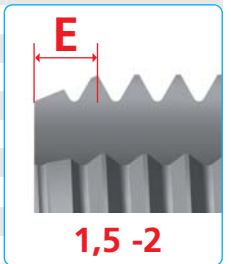
10.1

DIN 371	Ød1 M	P mm	L <sub>1</sub>	L <sub>2</sub>	d <sub>2</sub> h9	a h12	Z	
<b>6</b>	<b>1</b>	80	16	6	4,9	4	5	
<b>8</b>	<b>1,25</b>	90	18	8	6,2	4	6,8	
<b>10</b>	<b>1,5</b>	100	20	10	8	4	8,5	

CODICE - CODE		
K26EM...TX	K26EM...FOR-TX	K26EM...FORY-TX
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<input type="radio"/>	<input type="radio"/>	<input type="radio"/>
<input type="radio"/>	<input type="radio"/>	<input type="radio"/>

DIN 376	Ød1 M	P mm	L <sub>1</sub>	L <sub>2</sub>	d <sub>2</sub> h9	a h12	Z	
<b>12</b>	<b>1,75</b>	110	25	9	7	4	10,3	
<b>14</b>	<b>2</b>	110	28	11	9	4	12	
<b>16</b>	<b>2</b>	110	28	12	9	4	14	
<b>18</b>	<b>2,5</b>	125	33	14	11	5	15,5	
<b>20</b>	<b>2,5</b>	140	33	16	12	5	17,5	
<b>22</b>	<b>2,5</b>	140	33	18	14,5	5	19,5	
<b>24</b>	<b>3</b>	160	39	18	14,5	5	21	

CODICE - CODE		
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<input type="radio"/>	<input type="radio"/>	<input type="radio"/>
<input type="radio"/>	<input type="radio"/>	<input type="radio"/>
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<input type="radio"/>	<input type="radio"/>	<input type="radio"/>
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Confezione / Box / Colis: M3 - M12: 5 pezzi / pcs >M12: singoli / single pcs

€ Pag. listino - Price list - Liste des prix

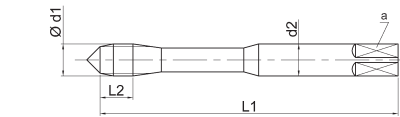
● Standard      ○ Disponibilità da richiedere, prezzo a listino  
 On enquiry, standard price-list / Stock à vérifier

★ Solo a richiesta  
 Only on request / Sur demande

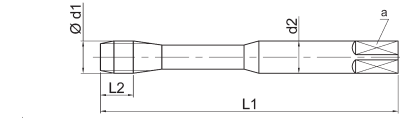
## MASCHI A MACCHINA

### MACHINE TAPS - TARAUDS MACHINE

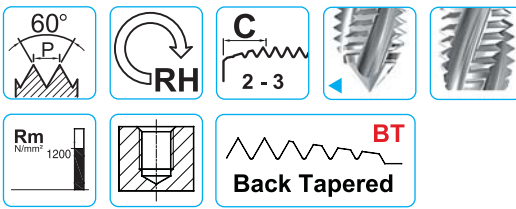
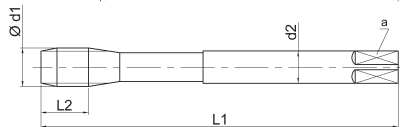
**DIN 371**



**DIN 371**



**DIN 376**



**TOP**



**BT**

R25°

**TOP**



**BT**

R25°

**TOP**



**BT**

R25°

Profond. di filettatura - Thread depth - Profond. de filetage

Materiale - Material - Matériau

Tolleranza - Tolerance - Tolérance

Trattamento superficiale - Surface treatment - Revêtement

Acciai legati trattati  
 Alloyed steel - tempered steel  
 Aciers alliés traités  
 Fusioni d'acciaio  
 Steel castings / Moulages d'acier

Numero gruppi materiali  
 Material's groups number  
 Nombre de groupes du matériau

**2,5xD**

**PM3**

**6HX**

**BR**

1.4 1.5

3.3 3.4

**2,5xD**

**PM3**

**6HX**

**TiCN**

1.4 1.5

3.3 3.4

**3xD**

**PM3**

**6HX**

**TiCN**

1.4 1.5

3.3 3.4

DIN 371	Ød1 M	P mm	L <sub>1</sub>	L <sub>2</sub>	d <sub>2</sub> h9	a h12	Z	
◀	4	0,7	63	13	4,5	3,4	3	3,3
◀	5	0,8	70	13	6	4,9	3	4,2
◀	6	1	80	16	6	4,9	3	5
	8	1,25	90	18	8	6,2	3	6,8
	10	1,5	100	20	10	8	3	8,5

CODICE - CODE		
K28M...	K28M...CT	K28M...FOR-CT
○	○	-
○	○	-
○	○	○
○	○	○
○	○	○

DIN 376	Ød1 M	P mm	L <sub>1</sub>	L <sub>2</sub>	d <sub>2</sub> h9	a h12	Z	
	12	1,75	110	25	9	7	4	10,3
	14	2	110	28	11	9	4	12
	16	2	110	28	12	9	4	14

CODICE - CODE		
K29M...	K29M...CT	K29M...FOR-CT
○	○	○
*	*	*
○	○	○

Confezione / Box / Colis:  
 M3 - M10: 10 pezzi / pcs  
 M12 - M16: 5 pezzi / pcs

€ Pag. listino - Price list - Liste des prix  
 ● Standard

**36**  
 ○ Disponibilità da richiedere, prezzo a listino  
 On enquiry, standard price-list / Stock à vérifier

**36**  
 ★ Solo a richiesta  
 Only on request / Sur demande





### Anello colorato

*Colored ring - Bague de couleur*  
 Identifica in maniera molto pratica il campo di applicazione del maschio.  
*The colored ring allows to identify the practical destination of the tap.*  
*Sert à identifier de façon rapide le champ d'application du taraud.*

### Materiale

*Material - Matériau*  
 PM3 Acciaio super rapido sinterizzato ad alto contenuto di vanadio e cobalto.  
*PM3 Powdered metallurgy high speed steel with high contents of vanadium and cobalt.*  
*Acier super rapide fritté PM3 à haute teneur en vanadium et cobalt.*

### Scanalature

*Flutes - Goujures*  
 Elicoidali a 25°, progettate per lavorare la ghisa 3.3 e 3.4, fusioni d'acciaio ed acciai legati fino a 1200 N/mm<sup>2</sup>  
*Spiral flutes 25°, designed for machining cast iron 3.3 and 3.4, steel castings and alloyed steel up to 1200 N/mm<sup>2</sup>.*  
*Goujures 25° pour l'usinage de fonte 3.3 et 3.4, aciers alliés jusqu'à 1200 N/mm<sup>2</sup>.*

### Rivestimento

*Coating - Revêtement*  
 TiCN resistenza all'usura, ottimale per lavorare materiali abrasivi come le ghise.  
*TiCN wear resistance, optimal to machine abrasive materials such as cast iron.*  
*TiCN résistance à l'usure et à l'oxydation, optimale pour les matériaux abrasifs tels que la fonte.*

### Rastremazione posteriore

*Back tapered*  
 La rastremazione posteriore conica comporta un minor contatto maschio-pezzo con conseguente riduzione dell'attrito e della coppia torcente.  
*The back tapered threads means a lower contact between tap and workpiece, thus reducing friction and torque.*  
*Le détalonnage arrière implique un contact mineur taraud-pièce avec une réduction conséquente de la friction et de la couple.*

**A richiesta – On request – Sur demande**

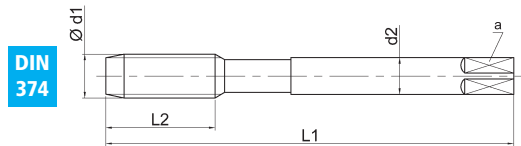
### FOR

**Lubrificazione interna con uscita assiale.**  
*Through coolant, axial flow.*  
*Lubrification interne à sortie axiale.*



### MASCHI A MACCHINA

### MACHINE TAPS - TARAUDS MACHINE



DIN 374

60° P<sub>r</sub>  
RH  
C 2-3  
Rm Norm 1400



Profond. di filettatura - Thread depth - Profond. de filetage	3xD	3,5xD	3,5xD	3xD
Materiale - Material - Matériau	PM3	PM3	PM3	PM3
Tolleranza - Tolerance - Tolérance	6HX	6HX	6HX	6HX
Trattamento superficiale - Surface treatment - Revêtement	TiAlN	TiAlN	TiAlN	TXS
Al Si > 10%, Ottone / Brass / Laiton Bronzo / Bronze / Bronze truciolo corto / short chip / coupeaux courts	3.1 3.2 3.3 3.4 3.5 4.4 5.3 5.4 10.1	3.1 3.2 3.3 3.4 3.5 4.4 5.3 5.4 10.1	3.1 3.2 3.3 3.4 3.5 4.4 5.3 5.4 10.1	3.1 3.2 3.3 3.4 3.5 4.4 5.3 5.4 10.1

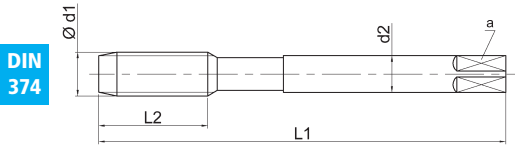
Numero gruppi materiali  
Material's groups number  
Nombre de groupes du matériau

DIN 374	Ød1 MF	P mm	L <sub>1</sub>	L <sub>2</sub>	d <sub>2</sub> h9	a h12	Z	
	8	1	90	18	6	4,9	4	7
	10	1	90	15	7	5,5	4	9
	10	1,25	100	20	7	5,5	4	8,75
	12	1,25	100	22	9	7	4	10,75
	12	1,5	100	22	9	7	4	10,5
	14	1,5	100	22	11	9	4	12,5
	16	1,5	100	22	12	9	4	14,5
	18	1,5	110	25	14	11	5	16,5
	20	1,5	125	25	16	12	5	18,5
	22	1,5	125	25	18	14,5	6	20,5
	24	1,5	140	25	18	14,5	6	22,5

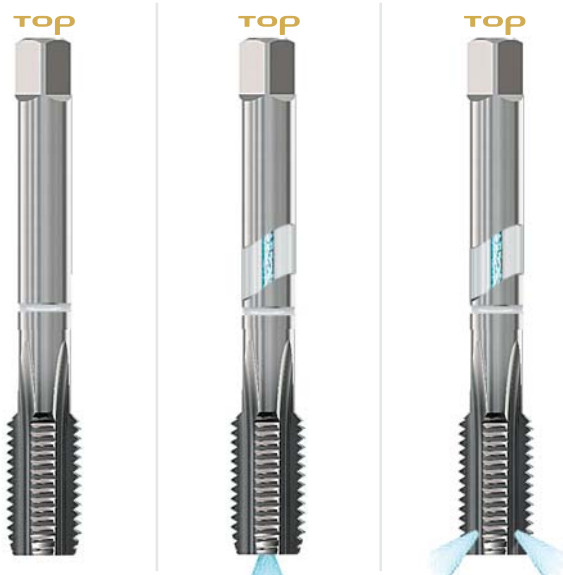
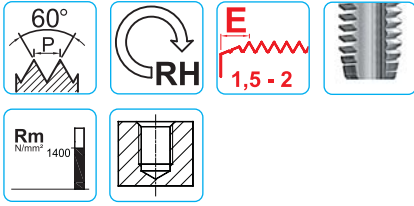
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**GG** GHISA  
Cast Iron - Fonte

**MASCHI A MACCHINA**  
MACHINE TAPS - TARAUDS MACHINE



**DIN 374**



Profond. di filettatura - Thread depth - Profond. de filetage  
 Materiale - Material - Matériau

Tolleranza - Tolerance - Tolérance

Trattamento superficiale - Surface treatment - Revêtement

Al Si > 10%,  
Ottone / Brass / Laiton  
Bronzo / Bronze / Bronze  
truciolo corto / short chip /  
coupeaux courts

Numero gruppi materiali  
Material's groups number  
Nombre de groupes du matériau

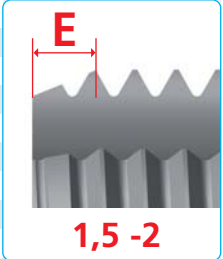
3xD	3,5xD	3,5xD
PM3	PM3	PM3
6HX	6HX	6HX
TiAlN	TiAlN	TiAlN
3.1 3.2 3.3 3.4 3.5	3.1 3.2 3.3 3.4 3.5	3.1 3.2 3.3 3.4 3.5
4.4 5.3	4.4 5.3	4.4 5.3
10.1	10.1	10.1

DIN 374	Ød1 MF	P mm	L <sub>1</sub>	L <sub>2</sub>	d <sub>2</sub> h9	a h12	Z	
8	1	90	18	6	4,9	4	7	
10	1	90	15	7	5,5	4	9	
10	1,25	100	20	7	5,5	4	8,75	
12	1,25	100	22	9	7	4	10,75	
12	1,5	100	22	9	7	4	10,5	
14	1,5	100	22	11	9	4	12,5	
16	1,5	100	22	12	9	4	14,5	
18	1,5	110	25	14	11	5	16,5	
20	1,5	125	25	16	12	5	18,5	
22	1,5	125	25	18	14,5	6	20,5	
24	1,5	140	25	18	14,5	6	22,5	

CODICE - CODE	K27EMF...TX		
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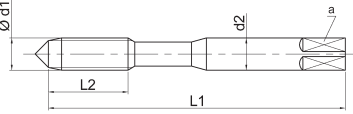
Treatment TX abbinato a specifici processi di microfinitura superficiale. Insuperabile!  
 TX treatment combined with specific processes of honing surface. Unbeatable!  
 Traitement TX combinée à des processus spécifiques de finition de surface. Inégalée !



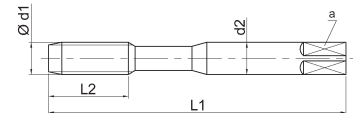
### MASCHI A MACCHINA

#### MACHINE TAPS - TARAUDS MACHINE

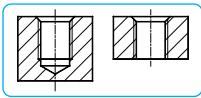
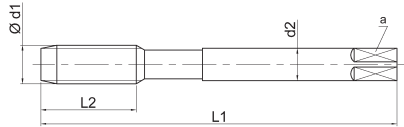
DIN 371



DIN 371



DIN 376



TOP



TOP



Profond. di filettatura - Thread depth - Profond. de filetage

Materiale - Material - Matériau

Tolleranza - Tolerance - Tolérance

Trattamento superficiale - Surface treatment - Revêtement

Al Si > 10%,  
Ottone / Brass / Laiton  
Bronzo / Bronze / Bronze  
truciolo corto / short chip /  
coupeaux courts

Numero gruppi materiali  
Material's groups number  
Nombre de groupes du matériau

3xD

3,5xD

PM3

PM3

2BX

2BX

TiAlN

TiAlN

3.1 3.2 3.3 3.4 3.5

3.1 3.2 3.3 3.4 3.5

4.4 5.3 5.4

4.4 5.3 5.4

10.1

10.1

DIN	$\varnothing d_1$	P	$\varnothing$	$L_1$	$L_2$	$d_2$	a	Z	
371	UNC	TPI	mm			h9	h12		
◀	1/4	20	6,350	80	16	7	5,5	4	5,1
	5/16	18	7,938	90	18	8	6,2	4	6,6
	3/8	16	9,525	100	20	10	8	4	8
	1/4	20	6,350	80	16	7	5,5	4	5,1

CODICE - CODE

K26UNC...TX

○

○

○

K26UNC...SP-TX

○

K26UNC...FOR-TX

○

DIN	$\varnothing d_1$	P	$\varnothing$	$L_1$	$L_2$	$d_2$	a	Z	
376	UNC	TPI	mm			h9	h12		
	7/16	14	11,113	100	20	8	6,2	4	9,4
	1/2	13	12,700	110	25	9	7	4	10,8
	9/16	12	14,288	110	28	11	9	4	12,2
	5/8	11	15,875	110	28	12	9	4	13,5
	3/4	10	19,050	125	32	14	11	5	16,5
	7/8	9	22,225	140	32	18	14,5	5	19,5
	1"	8	25,400	160	36	18	14,5	5	22,25

CODICE - CODE

K27UNC...TX

○

○

○

○

○

○

○

K27UNC...FOR-TX

○

○

○

○

○

○

○

Confezione / Box / Colis:  
6 - 7/16: 10 pezzi / pcs  
1/2 - 9/16: 5 pezzi / pcs  
>9/16: singoli / single pcs

€ Pag. listino - Price list - Liste des prix

73

73

• Standard

○ Disponibilità da richiedere, prezzo a listino  
On enquiry, standard price-list / Stock à vérifier

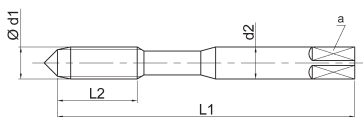
★ Solo a richiesta  
Only on request / Sur demande

**GG** **GHISA**  
 Cast Iron - Fonte

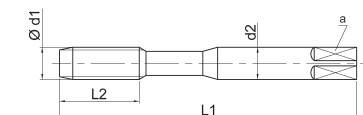
**MASCHI A MACCHINA**

**MACHINE TAPS - TARAUDS MACHINE**

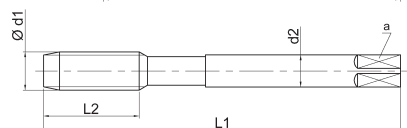
**DIN 371**



**DIN 374**



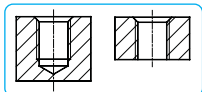
**DIN 374**



**TOP**



**TOP**



Profond. di filettatura - Thread depth - Profond. de filetage

**3xD**

**3,5xD**

Materiale - Material - Matériau

**PM3**

**PM3**

Tolleranza - Tolerance - Tolérance

**2BX**

**2BX**

Trattamento superficiale - Surface treatment - Revêtement

**TiAlN**

**TiAlN**

Al Si > 10%,  
 Ottone / Brass / Laiton  
 Bronzo / Bronze / Bronze  
 truciolo corto / short chip /  
 coupeaux courts

Numero gruppi materiali  
 Material's groups number  
 Nombre de groupes du matériau

3.1 3.2 3.3 3.4 3.5

3.1 3.2 3.3 3.4 3.5

4.4 5.3 5.4

4.4 5.3 5.4

10.1

10.1

DIN 371	Ød1 UNF	P TPI	Ø mm	L <sub>1</sub>	L <sub>2</sub>	d <sub>2</sub> h9	a h12	Z	
◀	1/4	28	6,350	80	16	7	5,5	4	5,5
	1/4	28	6,350	80	16	7	5,5	4	5,5

CODICE - CODE	
K26UNF...TX	K26UNF...FOR-TX
○	-
-	○

DIN 374	Ød1 UNF	P TPI	Ø mm	L <sub>1</sub>	L <sub>2</sub>	d <sub>2</sub> h9	a h12	Z	
	1/4	28	6,350	80	16	4,5	3,4	3	5,5
	5/16	24	7,938	90	18	6	4,9	4	6,9
	3/8	24	9,525	90	15	7	5,5	4	8,5
	7/16	20	11,113	100	20	8	6,2	4	9,9
	1/2	20	12,700	100	20	9	7	4	11,5
	9/16	18	14,288	100	22	11	9	4	12,9
	5/8	18	15,875	100	22	12	9	4	14,5
	3/4	16	19,050	110	25	14	11	5	17,5
	7/8	14	22,225	125	25	18	14,5	6	20,4
	1"	12	25,400	140	28	18	14,5	6	23,25

CODICE - CODE	
K27UNF...TX	K27UNF...FOR-TX
○	○
○	○
○	○
○	○
○	○
○	○
○	○
○	○
○	○

Confezione / Box / Colis:  
 6 - 7/16: 10 pezzi / pcs  
 1/2 - 9/16: 5 pezzi / pcs  
 >9/16: singoli / single pcs

€ Pag. listino - Price list - Liste des prix

**82**

**83**

● Standard

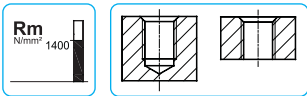
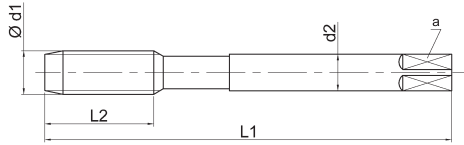
○ Disponibilità da richiedere, prezzo a listino  
 On enquiry, standard price-list / Stock à vérifier

★ Solo a richiesta  
 Only on request / Sur demande

### MASCHI A MACCHINA

#### MACHINE TAPS - TARAUDS MACHINE

DIN 5156



Profond. di filettatura - Thread depth - Profond. de filetage

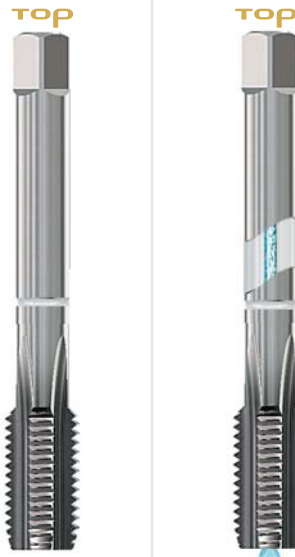
Materiale - Material - Matériau

Tolleranza - Tolerance - Tolérance

Trattamento superficiale - Surface treatment - Revêtement

Al Si>10%, Ottone / Brass / Laiton  
Bronzo / Bronze / Bronze  
truciolo corto / short chip / coupeaux courts

Numero gruppi materiali  
Material's groups number  
Nombre de groupes du matériau

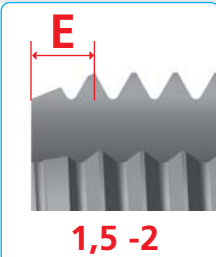


<b>3xD</b>	<b>3,5xD</b>
<b>PM3</b>	<b>PM3</b>
<b>ISO 228X</b>	<b>ISO 228X</b>
<b>TiAlN</b>	<b>TiAlN</b>
3.1 3.2 3.3 3.4 3.5	3.1 3.2 3.3 3.4 3.5
4.4 5.3 5.4	4.4 5.3 5.4
10.1	10.1

DIN 5156	$\emptyset d_1$ GAS	P TPI	$\emptyset$ mm	$L_1$	$L_2$	$d_2$ h9	a h12	Z	
	<b>1/8</b>	<b>28</b>	9,73	90	15	7	5,5	4	8,8
	<b>1/4</b>	<b>19</b>	13,16	100	22	11	9	4	11,8
	<b>3/8</b>	<b>19</b>	16,66	100	22	12	9	4	15,25
	<b>1/2</b>	<b>14</b>	20,96	125	25	16	12	6	19
	<b>3/4</b>	<b>14</b>	26,44	140	25	20	16	6	24,5

CODICE - CODE	
K27G...TX	K27G...FOR-TX
<input type="checkbox"/>	<input type="checkbox"/>
<input type="checkbox"/>	<input type="checkbox"/>
<input type="checkbox"/>	<input type="checkbox"/>
<input type="checkbox"/>	<input type="checkbox"/>
<input type="checkbox"/>	<input type="checkbox"/>

A richiesta:  
On request:  
Sur demande:



Confezione / Box / Colis:  
1/8 G: 10 pezzi / pcs  
1/4 G - 3/8 G: 5 pezzi / pcs

€ Pag. listino - Price list - Liste des prix  
● Standard

**93**  
○ Disponibilità da richiedere, prezzo a listino  
On enquiry, standard price-list / Stock à vérifier

**93**  
★ Solo a richiesta  
Only on request / Sur demande

GG

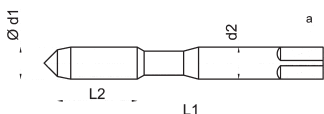
GHISA

Cast Iron - Fonte

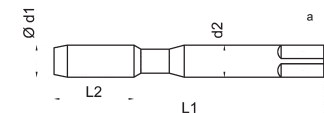
**MASCHI A MACCHINA**

MACHINE TAPS - TARAUDS MACHINE

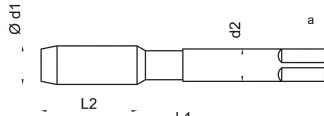
ISO 529



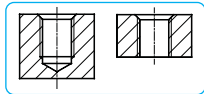
ISO 529



ISO 529



TOP



Profond. di filettatura - Thread depth - Profond. de filetage

**3xD**

Materiale - Material - Matériau

**PM3**

Tolleranza - Tolerance - Tolérance

**6HX**

Trattamento superficiale - Surface treatment - Revêtement

**TXC**

Al Si &gt; 10%,

Ottone / Brass / Laiton

Bronzo / Bronze / Bronze

truciolo corto / short chip /

coupeaux courts

Numero gruppi materiali

Material's groups number

Nombre de groupes du matériau

1.5 1.6

3.1 3.2 3.3 3.4 3.5

4.4 5.3 5.4

8.2 8.3 10.1

ISO 529	Ød1 M	P mm	L <sub>1</sub>	L <sub>2</sub>	d <sub>2</sub> h9	a h12	Z	
◀	<b>3</b>	<b>0,5</b>	48	11	3,15	2,5	3	2,5
◀	<b>4</b>	<b>0,7</b>	53	13	4	3,15	3	3,3
◀	<b>5</b>	<b>0,8</b>	58	16	5	4	3	4,2
◀	<b>6</b>	<b>1</b>	66	19	6,3	5	4	5
	<b>8</b>	<b>1,25</b>	72	22	8	6,3	4	6,8
	<b>10</b>	<b>1,5</b>	80	24	10	8	4	8,5
	<b>12</b>	<b>1,75</b>	89	29	9	7,1	4	10,30
	<b>14</b>	<b>2</b>	95	30	11,2	9	4	12
	<b>16</b>	<b>2</b>	102	32	12,5	10	4	14
	<b>18</b>	<b>2,5</b>	112	37	14	11,20	4	15,5
	<b>20</b>	<b>2,5</b>	112	37	14	11,20	4	17,5

CODICE - CODE

529K26M...TXC

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 Confezione / Box / Colis:  
 M3 - M10: 10 pezzi / pcs  
 M12 - M16: 5 pezzi / pcs

€ Pag. listino - Price list - Liste des prix

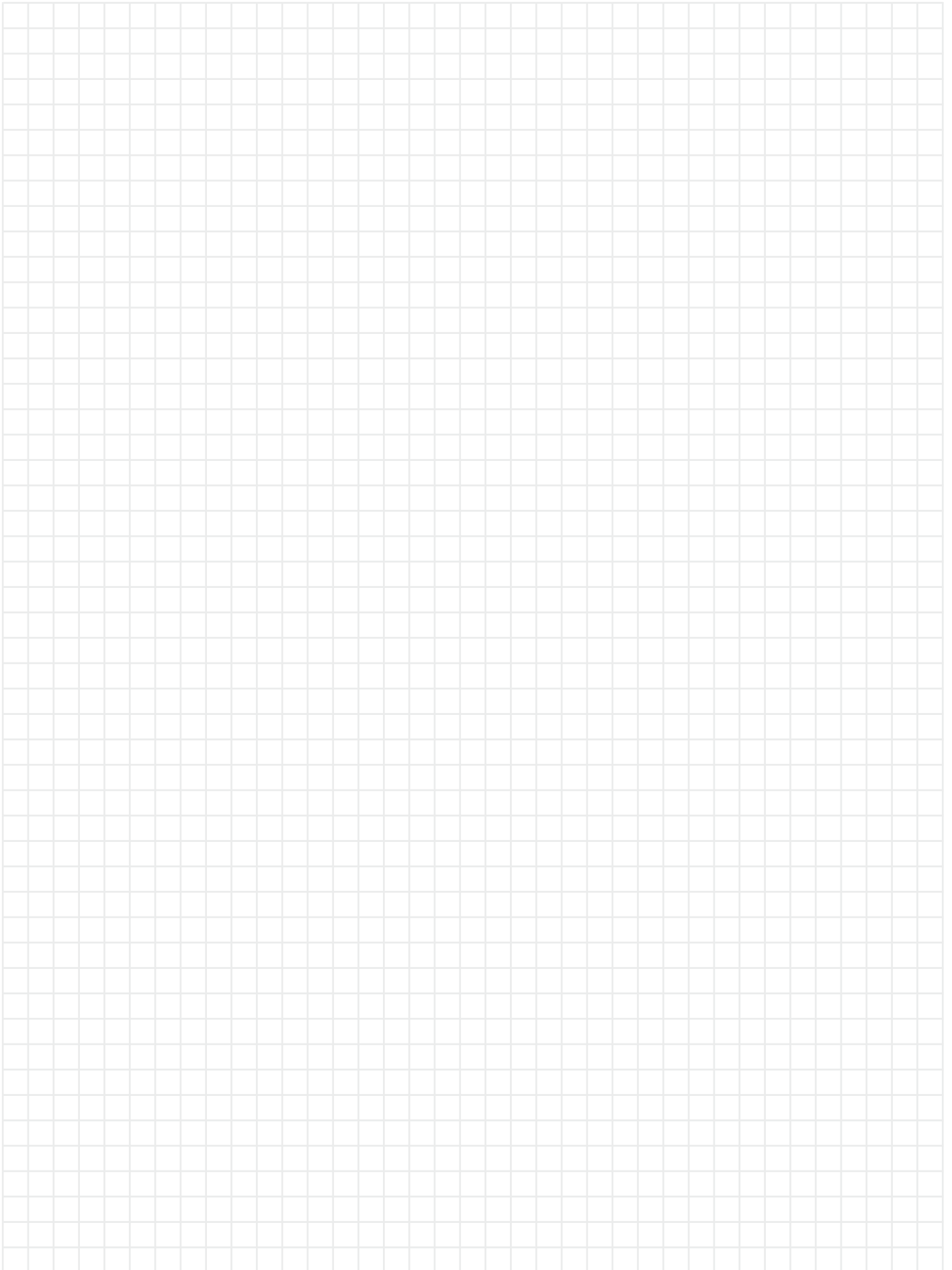
104

● Standard

 ○ Disponibilità da richiedere, prezzo a listino  
 On enquiry, standard price-list / Stock à vérifier

 ★ Solo a richiesta  
 Only on request / Sur demande

# Note

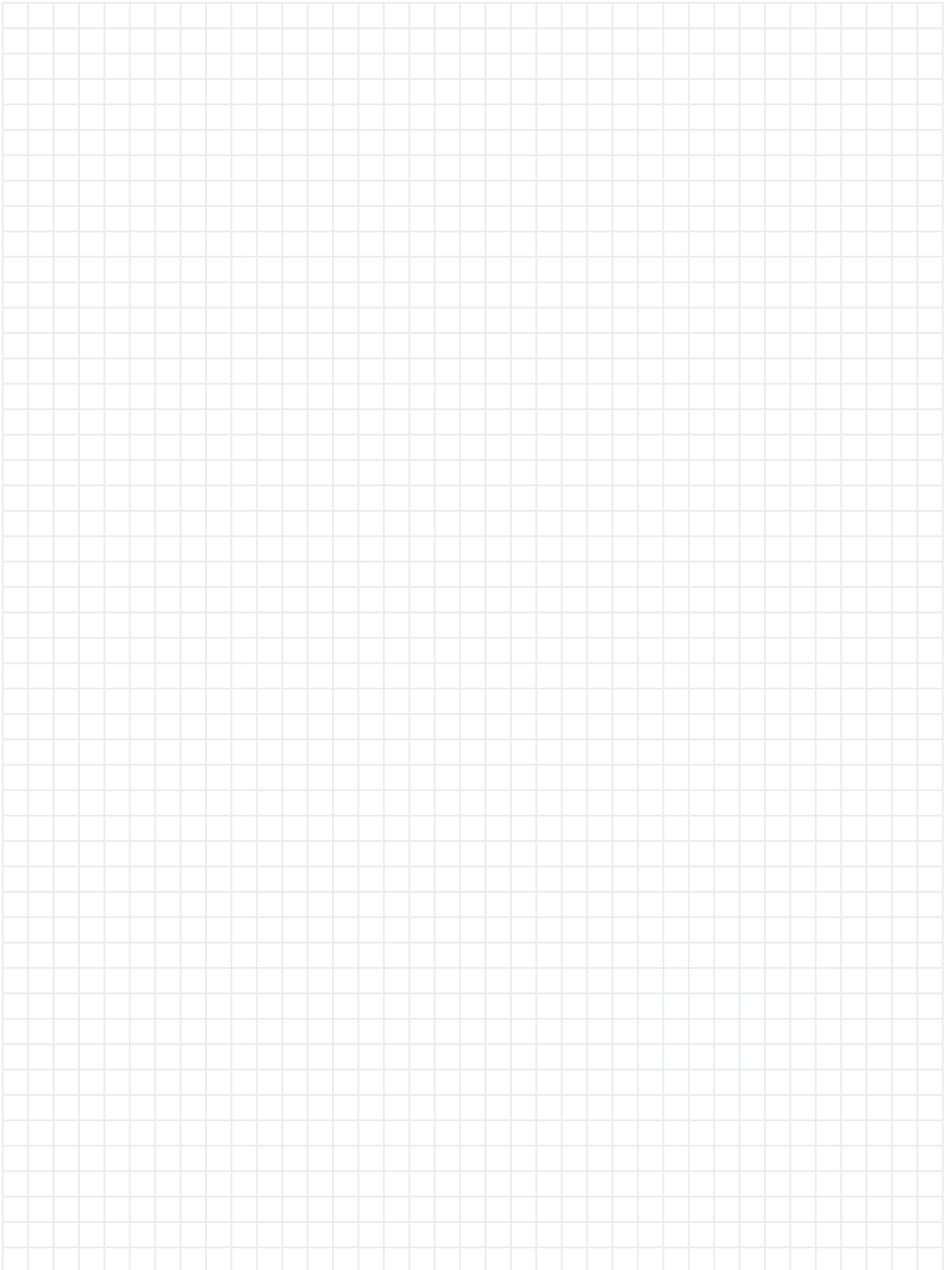




<b>3</b>	<b>Ghisa - Cast Iron - Fonte</b>		
3.1	<b>Ghisa grigia lamellare Rm &lt; 600 N/mm<sup>2</sup>, &lt; 180 HB</b>		
	<i>Lamellar grey cast iron - Fonte grise lamellaire</i>		
	<b>W-Nr.</b>	<b>DIN - Germany</b>	<b>UNI - Italy</b>
	0.6010	GG-10	G 10
	0.6015	GG-15	G 15
	0.6020	GG-20	G 20
3.2	<b>Ghisa grigia lamellare Rm 600 ÷ 1000 N/mm<sup>2</sup>, 180 ÷ 300 HB</b>		
	<i>Lamellar grey cast iron - Fonte grise lamellaire</i>		
	<b>W-Nr.</b>	<b>DIN - Germany</b>	<b>UNI - Italy</b>
	0.6025	GG-25	G 25
	0.6030	GG-30	G 30
	0.6035	GG-35	G 35
	0.6040	GG-40	G 40
3.3	<b>Ghisa sferoidale Rm &lt; 1000 N/mm<sup>2</sup>, &lt; 300 HB</b>		
	<i>Nodular cast iron - Fonte ductile</i>		
	<b>W-Nr.</b>	<b>DIN - Germany</b>	<b>UNI - Italy</b>
	0.7033	GGG-35.3	-
	0.7040	GGG-40	GS400-12
	0.7043	GGG-40.3	GSO 42/17
	0.7050	GGG-50	GS500-7
	0.7060	GGG-60	GS600-3
	0.7070	GGG-70	GS700-2
	0.7080	GGG-80	GS800-2
	0.7670	GGG-Ni22	-
	0.7683	GGG-Ni35	-
	0.7660	GGG-NiCr20-2	-
	0.7677	GGG-NiCr30-1	-
0.7685	GGG-NiCr35-3	-	
3.4	<b>Ghisa malleabile Rm &lt; 700 N/mm<sup>2</sup>, &lt; 210 HB</b>		
	<i>Malleable cast iron - Fonte malléable</i>		
	<b>W-Nr.</b>	<b>DIN - Germany</b>	<b>UNI - Italy</b>
	0.8035	GTW-35-04	-
	0.8045	GTW-45-07	-
	0.8145	GTS-45-06	-
	0.8165	GTS-65-02	-
	0.8170	GTS-70-02	-
3.5	<b>Ghisa vermicolare a grafite compatta Rm 700 ÷ 1000 N/mm<sup>2</sup>, 200 ÷ 300 HB</b>		
	<i>Compacted cast iron with vermicular graphite - Fonte vermiculaire à graphite compacté</i>		
	<b>W-Nr.</b>	<b>DIN - Germany</b>	<b>Denom. comm./Trade name/Nom comm</b>
			(CGI)
		(GGV)	
		(GJV)	

<b>4</b>	<b>Alluminio, Magnesio - Aluminium, Magnesium - Alliage, Magnésium</b>		
<b>4.1</b>	<b>Alluminio / Magnesio non legato Rm &lt; 350 N/mm<sup>2</sup>, &lt; 100 HB</b>		
	<i>Aluminium / Magnesium unalloyed - Aluminium / Magnésium non allié</i>		
	<b>W-Nr.</b>	<b>DIN - Germany</b>	<b>UNI - Italy</b>
Si > 10%	3.2381	G-ALSi10Mg	3049
Leghe da getti	3.2383	G-ALSi10Mg(Cu)	-
<i>Al casting alloys</i>	3.2581	G-ALSi12	5079
<i>Tarauts pour alliages coulée</i>	3.2583	G-ALSi12(Cu)	3048
<b>5</b>	<b>RAME - Cooper - Cuivre</b>		
<b>5.1</b>	<b>Rame puro, rame elettrolitico - truciolo lungo Rm &lt; 350 N/mm<sup>2</sup>, &lt; 100 HB</b>		
	<i>Cooper unalloyed, long chipping - Cuivre pur, cuivre électrolytique, coupeaux longs</i>		
	<b>W-Nr.</b>	<b>DIN - Germany</b>	<b>Denom. comm./Trade name/Nom comm</b>
Ottone / Brass / Laiton	2.0360	CuZn40 (Ms60)	-
	2.0380	CuZn39Pb2 (Ms58)	-
	2.0410	CuZn44Pb2 (Ms56)	-
	2.0510	CuZn37Al1	-
	2.0550	CuZn40Al2	-
	2.0561	CuZn40Al1	-
	2.0580	CuZn40Mn1Pb	-
	2.2140	G-ZnAl4	(ZAMAK)
Bronzo / Bronze	2.1086	G-CuSn10Zn	-
	2.1093	G-CuSn6ZnNi	-
	2.1096	G-CuSn5ZnPb	-
<b>10</b>	<b>Grafite - Graphite</b>		
<b>10.1</b>	<b>Grafite Rm &lt; 100 N/mm<sup>2</sup></b>		
	<i>Graphite</i>		
	<b>W-Nr.</b>	<b>DIN - Germany</b>	<b>Denom. comm./Trade name/Nom comm</b>
			Graphit R8340
			Technograph 15
			Technograph 30
			R8510
			R8650
			Union Poco EDM1
			Union Poco EDM3

# Note





La linea di utensili, definita **"TOP"** è stata creata come risposta alle esigenze evolutive del mercato e rappresenta la più alta espressione qualitativa dei prodotti UFS. Ottima per applicazioni in tutte le lavorazioni di materiali difficili e per alte produzioni automatizzate. Le caratteristiche e gli impieghi sono sviluppati nelle brochure specifiche.

*The "TOP" line was created as a specific answer to the market evolution needs, and represents the highest quality expression of the UFS products. Excellent for application on difficult materials and on high automatized productions. See all the technical information and practical use on the specific brochures.*

*La ligne d'outils "TOP" a été créée pour répondre aux exigences d'évolution du marché et représente la meilleure qualité des produits UFS. Une ligne d'excellence pour les applications sur matériaux difficiles et production automatisée. Voir caractéristiques techniques et utilisations sur les brochures spécifiques.*

