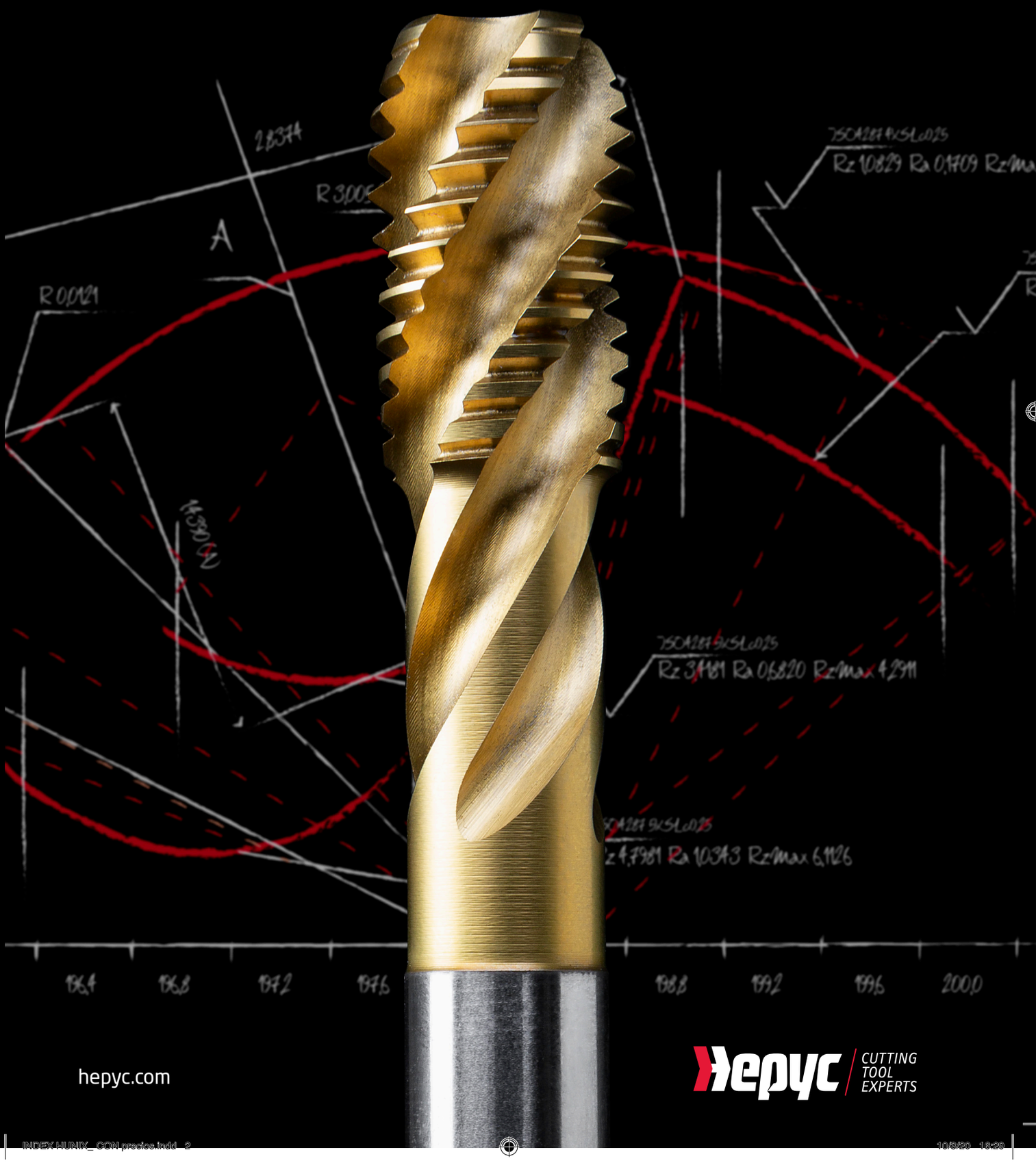
HUNIX

UNIVERSAL THREADING TAP

Simplifica tareas, ahorra problemas /
Simplifie les tâches, évite les problèmes /
Simplify tasks, save on problems /

NEW



hepyc.com

hepyc CUTTING TOOL EXPERTS

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HUNIX / UNIVERSAL THREADING TAP / by Hepyc



Simplifica tareas, ahorra problemas

Hunix es la nueva gama de machos de roscar universal de Hepyc. Una innovación, de desarrollo propio, que ha dado como resultado una herramienta capaz de mecanizar por si sola hasta el 77% de los materiales.

¿Imaginas lo que supone para un distribuidor reducir sus referencias aumentando la calidad?¿Y la optimización del proceso de mecanizado de una industria? Disminución de tiempos, reducción de incidencias, simplificación de stock... ¡menos problemas! ¡más eficiencia! Además, gracias a nuestro exclusivo diseño y fabricación, conseguimos hasta 2 veces más de vida útil y mejora en el mecanizado.

HUNIX / VAP



VAP / Básico para una mejor lubricación
La base d'une meilleure lubrification
Basic for better lubrication

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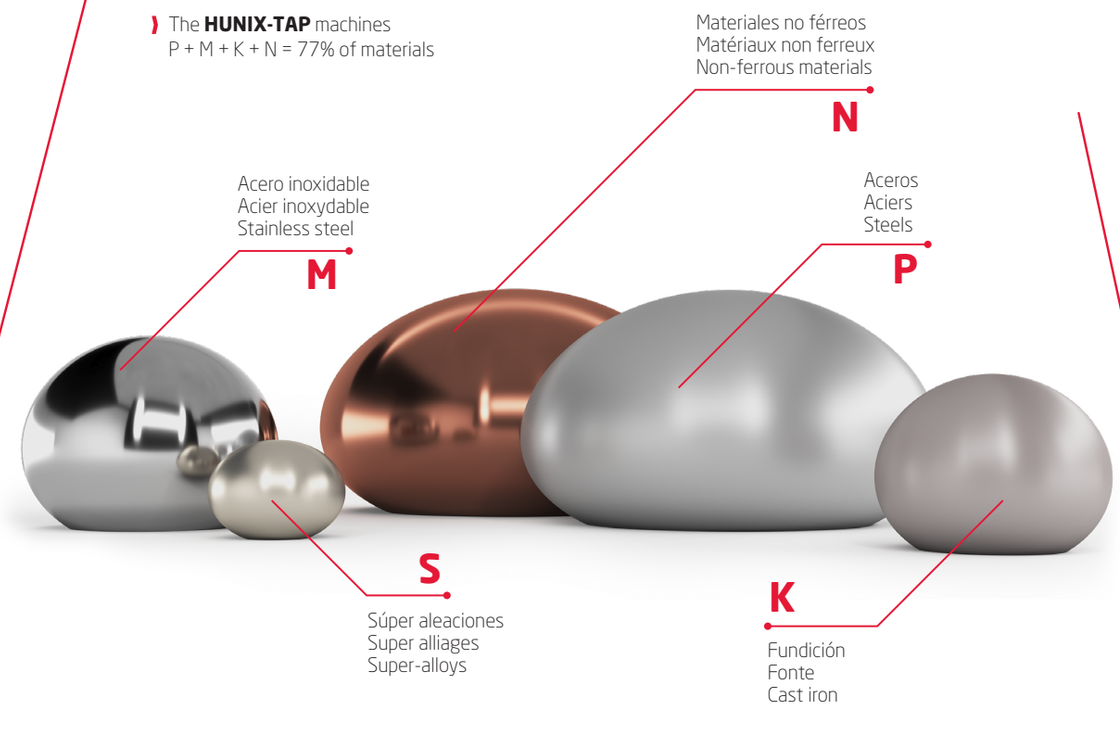
HUNIX-TAP puede mecanizar
P + M + K + N = 77% de los materiales

HUNIX-TAP peut usiner
P + M + K + N = 77% des matériaux

The **HUNIX-TAP** machines
P + M + K + N = 77% of materials



INNOVATION

Simplifie les tâches, évite les problèmes

Hunix est la nouvelle gamme filetages universels de Hepyc. Une innovation, développée en interne qui a donné naissance à un outil capable d'usiner seul jusqu'à 77% des matériaux.
Pouvez-vous imaginer ce que cela signifie pour un distributeur de réduire ses références en augmentant la qualité ? Et qu'en est-il de l'optimisation du processus d'usinage dans une industrie ? Réduction des temps, réduction des incidents, simplification du stock... moins de problèmes ! plus d'efficacité ! De plus, grâce à notre conception et à notre fabrication exclusive, nous obtenons jusqu'à 2 fois plus de durée de vie utile et d'amélioration de l'usinage.

Simplify tasks, save on problems

Hunix is the new Hepyc range of universal tap screws. A proprietary innovation that has resulted in a tool capable of machining up to 77% of materials by itself.
Can you imagine what it means for a distributor to reduce his references while increasing quality? And the optimization of the machining process of an industry? Decrease in production times, reduction of incidents, stock simplification... less problems! More efficiency! Moreover, thanks to our exclusive design and manufacturing, we achieve over a useful life over 2 times longer and machining improvements.

HUNIX / TIN+



TIN+ Tratamiento bicapa
Traitement à deux couches
Two-layer coating

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HUNIX / UNIVERSAL THREADING TAP / by Hepyc

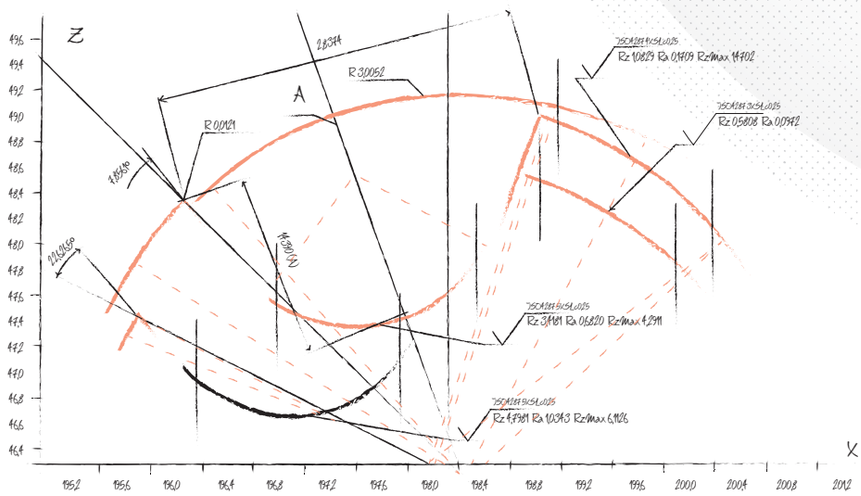
Único por su geometría universal
Unique par sa géométrie universelle
Unique for its universal design



Perfil de ranura optimizado
Profil de rainure optimisé
Optimized flute profile

Ranuras helicoidales progresivas
Rainures hélicoïdales progresives
Progressives spiral flutes

Destalonado adaptado
Détalonnage adapté
Adapted undercuts



Perfil de ranura optimizado / Profil de rainure optimisé / Optimized groove profile

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Único por su tecnología Microfinish
Unique par sa technologie Microfinish
Unique for its Microfinish

MICRO FINISH THREADING TECHNOLOGY



Redondeo de aristas de corte para mayor estabilidad y control del desgaste de la herramienta.

Filo de corte continuo para un mejor acabado de la rosca.

Evita roturas prematuras por su menor rugosidad superficial, lo que disminuye la fricción durante el roscado.

Arrondissement des arêtes de coupe pour une plus grande stabilité et contrôl l'usure des outils.

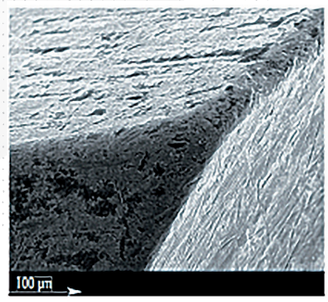
Arête de coupe continue pour une meilleure finition du filetage.

Prévient les cassures prématurées grâce à une moindre rugosité de la surface, ce qui réduit le frottement lors du filetage.

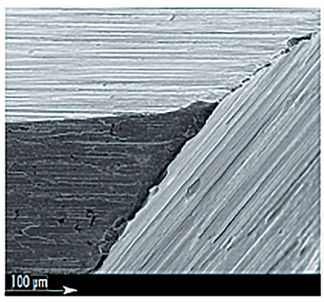
Rounded cutting edges to increase the stability and control of the tool wear.

Continuous cutting blade for a better tap finish.

Avoid premature breakdowns with decreased surface texture, which lessens tapping friction.



Con Microfinish
Avec Microfinish
Microfinished



Sin Microfinish
Sans Microfinish
Non-microfinished

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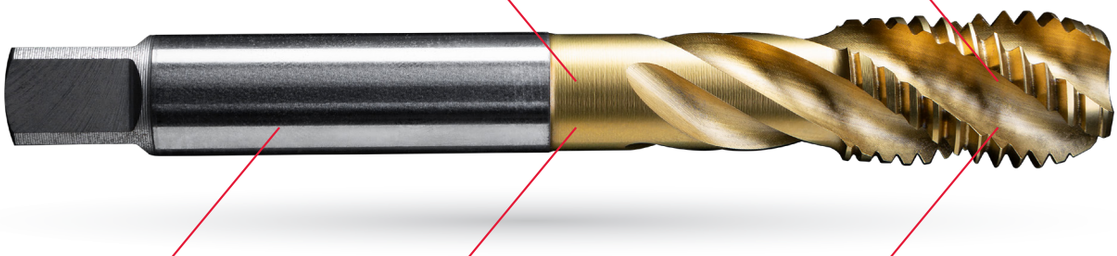
Único por su tratamiento de última generación
Unique par son traitement de pointe
Unique for its latest-generation treatment

TIN+

Mecaniza la mayoría de los materiales (P, M, K, N)
Usine la plupart des matériaux (P, M, K, N)
Machines most materials (P, M, K, N)

Evacua mejor la viruta
Meilleure évacuation des copeaux
Improved sliver evacuation



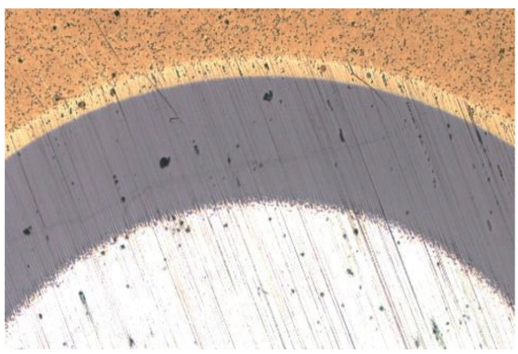
El doble de vida útil
Durée de vie double
Doubled service life

Mecanizado estable y correcto dimensionado de la rosca
Usinage de filets stables et correctement dimensionnés
Stable tap machining and proper tap sizing

El mejor en calidad-precio
Le meilleur en termes de qualité et de prix
The best price-quality ratio

TIN+

Recubrimiento/ Revêtement/ Coating: **TiAlN + TiN**
Estructura/ Structure/ Structure: **Bicapa / Deux couches / Dual layer**
Dureza/ Dureté / Hardness: **3500 HV0,05**
Coef. de fricción/ Coeff. de friction / Friction coefficient: **0,3**
Max. temperatura/ Température max/ Max. temperature: **800°C**
Color/ Couleur/ Colour: **Dorado / Doré / Golden**
Espesor/ Épaisseur/ Thickness: **4-5 µm**



TIN+ coating cross-section

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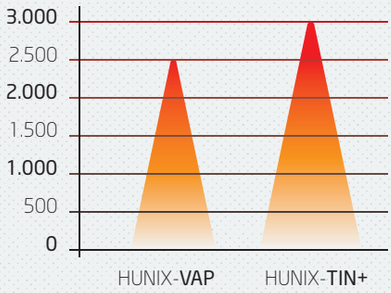
Rendimientos / Rendements /Performances

(Límite hasta 3.000 roscas / Limite jusqu'à 3.000 taraudages / Limit up to 3,000 threads)



P Aceros / Aciers / Steels

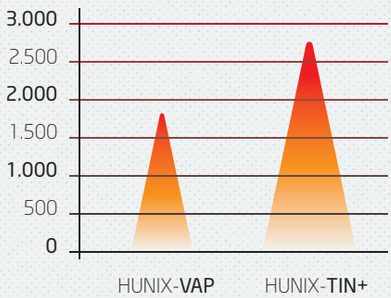
Condiciones de corte/ Conditions de coupe/ Cutting conditions
Material/ Matériau/ Material: **F114**
Ø: **M6**
Agujero/ Trou/ Hole: **Pasante/ Passant/ Through**
Profundidad/ Profondeur/ Depth: **2,5xD**
Vc: **11m/min**





M Acero inoxidable / Acier inoxydable / Stainless steel

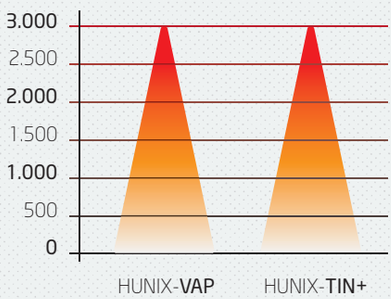
Condiciones de corte/ Conditions de coupe/ Cutting conditions
Material/ Matériau/ Material: **Aisi 304**
Ø: **M6**
Agujero/ Trou/ Hole: **Pasante/ Passant/ Through**
Profundidad/ Profondeur/ Depth: **2,5xD**
Vc: **6m/min**





N Materiales no férreos / Matériaux non ferreux / Non-ferrous materials

Condiciones de corte/ Conditions de coupe/ Cutting conditions
Material/ Matériau/ Material:
Ø: **M6**
Agujero/ Trou/ Hole: **Ciego/ Borgne/ Blind**
Profundidad/ Profondeur/ Depth: **1,5xD**
Vc: **20m/min**



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2251	HSSE	DIN 376/374	VAP		M-MF DIN 13 · Form. B "Gun" · Tol. 6H · 3XD · D · MF	P M N
2116	HSSE	DIN 371	TIN+		M DIN 13 · Form. B "Gun" · Tol. 6H · 3XD · R · MF	P M K N
2115	HSSE	DIN 376	TIN+		M-MF DIN 13 · Form. B "Gun" · Tol. 6H · 3XD · D · MF	P M K N
2252	HSSE	DIN 371	VAP		M DIN 13 · Form. C · Tol. 6H · 35° · 3XD · R · MF	P M N
2253	HSSE	DIN 376/374	VAP		M-MF DIN 13 · Form. C · Tol. 6H · 35° · 3XD · D · MF	P M N
2118	HSSE	DIN 371	TIN+		M DIN 13 · Form. C · Tol. 6H · 35° · 3XD · R · MF	P M K N
2117	HSSE	DIN 376/374	TIN+		M-MF DIN 13 · Form. C · Tol. 6H · 35° · 3XD · D · MF	P M K N

Machos de máquina / Tarauds machine / Machine taps (UNC-UNF)

2262	HSSE	DIN 371	VAP		UNC ANSI/ASME B1.1 · Form. B "Gun" · Tol. 2B · 3XD · R · MF	P M N
2263	HSSE	DIN 376	VAP		UNC ANSI/ASME B1.1 · Form. B "Gun" · Tol. 2B · 3XD · D · MF	P M N
2234	HSSE	DIN 371	TIN+		UNC ANSI/ASME B1.1 · Form. B "Gun" · Tol. 2B · 3XD · R · MF	P M K N
2235	HSSE	DIN 376	TIN+		UNC ANSI/ASME B1.1 · Form. B "Gun" · Tol. 2B · 3XD · D · MF	P M K N
2264	HSSE	DIN 371	VAP		UNC ANSI/ASME B1.1 · Form. C · Tol. 2B · 35° · 3XD · R · MF	P M N
2265	HSSE	DIN 371	VAP		UNC ANSI/ASME B1.1 · Form. C · Tol. 2B · 35° · 3XD · D · MF	P M N
2236	HSSE	DIN 371	TIN+		UNC ANSI/ASME B1.1 · Form. C · Tol. 2B · 35° · 3XD · R · MF	P M K N
2237	HSSE	DIN 376	TIN+		UNC ANSI/ASME B1.1 · Form. C · Tol. 2B · 35° · 3XD · D · MF	P M K N

P Aceros / Aciers / Steels
M Aceros Inox / Aciers Inox / Stainless Steels
K Fundicion / Fonte / Cast Iron
N Metales no ferrosos / Métal non Ferraux / Non Ferrous metals
S Titanio y Superaleaciones / Titanium et Supealliages / Titanium and Superalloys
H Materiales Duros / Materiels Durs / Hard materials

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2276	HSSE	DIN 371	VAP		UNF · Form. B "Gun" · Tol. 2B · 3XD · R · MF	P M N
2277	HSSE	DIN 374	VAP		UNF · Form. B "Gun" · Tol. 2B · 3XD · D · MF	P M N
2280	HSSE	DIN 371	TIN+		UNF · Form. B "Gun" · Tol. 2B · 3XD · R · MF	P M K N
2281	HSSE	DIN 374	TIN+		UNF · Form. B "Gun" · Tol. 2B · 3XD · D · MF	P M K N
2278	HSSE	DIN 371	VAP		UNF · Form. C · Tol. 2B · 35° · 3XD · R · MF	P M N
2279	HSSE	DIN 374	VAP		UNF · Form. C · Tol. 2B · 35° · 3XD · D · MF	P M N
2282	HSSE	DIN 371	TIN+		UNF · Form. C · Tol. 2B · 35° · 3XD · R · MF	P M K N
2283	HSSE	DIN 374	TIN+		UNF · Form. C · Tol. 2B · 35° · 3XD · D · MF	P M K N

Machos de máquina / Tarauds machine / Machine taps (G)

2284	HSSE	DIN 5156	VAP		G ISO 228 · Form. B "Gun" · 3XD · D · MF	P M N
2286	HSSE	DIN 5156	TIN+		G ISO 228 · Form. B "Gun" · 3XD · D · MF	P M K N
2285	HSSE	DIN 5156	VAP		G ISO 228 · Form. C · 35° · 3XD · D · MF	P M N
2287	HSSE	DIN 5156	TIN+		G ISO 228 · Form. C · 35° · 3XD · D · MF	P M K N

P Aceros Aciers Steels
M Aceros Inox Aciers Inox Stainless Steels
K Fundicion Fonte Cast Iron
N Metales no ferrosos Métal non Ferraux Non Ferrous metals
S Titanio y Superaleaciones Titanium et Supealliages Titanium and Superalloys
H Materiales Duros Materiels Durs Hard materials

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2250 HSSE DIN 371

M DIN13 | Form. B "Gun" | Tol. 6H | 3XD | R | VAP

P				M		K			N				S		H		
<800	<1.000	<1.200	<1.400	<950	<1.200	<500	<800	<1.400	Al	Cu	Mg/Zn	Plastic	Ti	Ni	50 HRC	55 HRC	60 HRC
● 10-25	○ 10-15			● 5-10	○ 5-8		○ 10-15		○ 10-15	● 10-20		○ 10-15					

Vc (m/min). ● Optima / Optimun ○ Alternativo / Alternative

MICRO FINISH THREADING TECHNOLOGY



Ø	P	€	L mm	l mm	☐ mm	d mm
M2,0	**0,40**	*25,70*	**45**	**10**	**2,10**	**2,8**
M2,5	**0,45**	*25,70*	**50**	**9**	**2,10**	**2,8**
M3,0	**0,50**	*13,41*	**56**	**11**	**2,70**	**3,5**
M3,5	**0,60**	*17,74*	**56**	**12**	**3,00**	**4,0**
M4,0	**0,70**	*13,60*	**63**	**13**	**3,40**	**4,5**

Ø	P	€	L mm	l mm	☐ mm	d mm
M5,0	**0,80**	*14,33*	**70**	**16**	**4,90**	**6,0**
M6,0	**1,00**	*14,33*	**80**	**19**	**4,90**	**6,0**
M8,0	**1,25**	*16,72*	**90**	**22**	**6,20**	**8,0**
M10,0	**1,50**	*21,39*	**100**	**24**	**8,00**	**10,0**

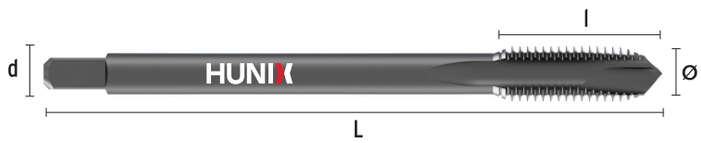
2251 HSSE DIN 376/374

M-MF DIN13 | Form. B "Gun" | Tol. 6H | 3XD | D | VAP

P				M		K			N				S		H		
<800	<1.000	<1.200	<1.400	<950	<1.200	<500	<800	<1.400	Al	Cu	Mg/Zn	Plastic	Ti	Ni	50 HRC	55 HRC	60 HRC
● 10-25	○ 10-15			● 5-10	○ 5-8		○ 10-15		○ 10-15	● 10-20		○ 10-15					

Vc (m/min). ● Optima / Optimun ○ Alternativo / Alternative

MICRO FINISH THREADING TECHNOLOGY



Ø	P	€	L mm	l mm	☐ mm	d mm
M3,0	**0,50**	*16,13*	**56**	**11**	**2,70**	**3,5**
M4,0	**0,70**	*17,21*	**63**	**13**	**2,10**	**2,8**
M5,0	**0,80**	*18,19*	**70**	**16**	**2,70**	**3,5**
M6,0	**1,00**	*18,19*	**80**	**19**	**3,40**	**4,5**
M8,0	1,00	*27,48*	90	20	4,90	6,0
M8,0	**1,25**	*21,17*	**90**	**22**	**4,90**	**6,0**
M10,0	1,00	*30,99*	90	20	5,50	7,0
M10,0	1,25	*36,20*	100	20	5,50	7,0
M10,0	**1,50**	*23,55*	**100**	**24**	**5,50**	**7,0**
M12,0	1,00	*40,08*	100	20	7,00	9,0
M12,0	1,25	*43,39*	100	20	7,00	9,0
M12,0	1,50	*40,08*	100	20	7,00	9,0
M12,0	**1,75**	*30,34*	**110**	**29**	**7,00**	**9,0**
M14,0	1,00	*54,71*	100	20	9,00	11,0
M14,0	1,25	*50,18*	100	20	9,00	11,0
M14,0	1,50	*54,71*	100	20	9,00	11,0

Ø	P	€	L mm	l mm	☐ mm	d mm
M14,0	**2,00**	*45,54*	**110**	**30**	**9,00**	**11,0**
M16,0	1,00	*63,43*	100	20	9,00	12,0
M16,0	1,50	*56,17*	100	22	9,00	12,0
M16,0	**2,00**	*48,78*	**110**	**30**	**9,00**	**12,0**
M18,0	1,00	*87,16*	110	24	11,00	14,0
M18,0	1,50	*66,99*	110	24	11,00	14,0
M18,0	**2,50**	*66,99*	**125**	**34**	**11,00**	**14,0**
M20,0	1,00	*85,18*	125	24	12,00	16,0
M20,0	1,50	*78,06*	125	25	12,00	16,0
M20,0	**2,50**	*70,95*	**140**	**34**	**12,00**	**16,0**
M22,0	1,00	*121,30*	125	25	14,50	18,0
M22,0	1,50	*101,14*	125	25	14,50	18,0
M22,0	**2,50**	*101,14*	**140**	**34**	**14,50**	**18,0**
M24,0	1,50	*103,04*	140	27	14,50	18,0
M24,0	2,00	*112,41*	140	27	14,50	18,0
M24,0	**3,00**	*93,67*	**160**	**38**	**14,50**	**18,0**

P Aceros / Aciers / Steels
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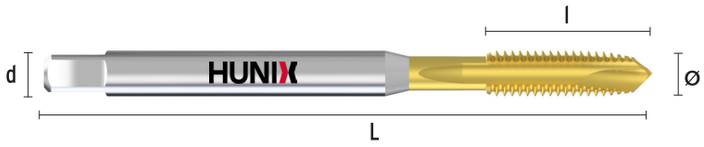
2116 HSSE DIN 371

M DIN 13 | Form. B "Gun" | Tol. 6H | 3XD | R | TIN+

P				M		K			N				S		H		
<800	<1.000	<1.200	<1.400	<950	<1.200	<500	<800	<1.400	Al	Cu	Mg/Zn	Plastic	Ti	Ni	50 HRC	55 HRC	60 HRC
● 15-30	● 12-18	○ 8-12		● 6-12	○ 6-10	● 10-15	● 15-20		● 15-25	● 15-25		○ 12-18					

Vc (m/min). ● Optima / Optimun ○ Alternativo / Alternative

MICRO FINISH THREADING TECHNOLOGY



Ø	P	€	L mm	l mm	⊠ mm	d mm
M2,0	**0,40**	*26,63*	**45**	**10**	**2,10**	**2,8**
M2,5	**0,45**	*26,63*	**50**	**9**	**2,10**	**2,8**
M3,0	**0,50**	*18,67*	**56**	**11**	**2,70**	**3,5**
M3,5	**0,60**	*21,98*	**56**	**12**	**3,00**	**4,0**
M4,0	**0,70**	*18,83*	**63**	**13**	**3,40**	**4,5**

Ø	P	€	L mm	l mm	⊠ mm	d mm
M5,0	**0,80**	*20,59*	**70**	**16**	**4,90**	**6,0**
M6,0	**1,00**	*21,34*	**80**	**19**	**4,90**	**6,0**
M8,0	**1,25**	*25,55*	**90**	**22**	**6,20**	**8,0**
M10,0	**1,50**	*33,60*	**100**	**24**	**8,00**	**10,0**

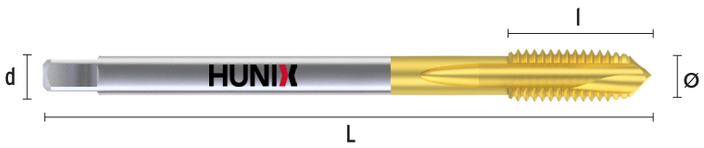
2115 HSSE DIN 376/374

M-MF DIN13 | Form. B "Gun" | Tol. 6H | 3XD | D | TIN+

P				M		K			N				S		H		
<800	<1.000	<1.200	<1.400	<950	<1.200	<500	<800	<1.400	Al	Cu	Mg/Zn	Plastic	Ti	Ni	50 HRC	55 HRC	60 HRC
● 15-30	● 12-18	○ 8-12		● 6-12	○ 6-10	● 10-15	● 15-20		● 15-25	● 15-25		○ 12-18					

Vc (m/min). ● Optima / Optimun ○ Alternativo / Alternative

MICRO FINISH THREADING TECHNOLOGY



Ø	P	€	L mm	l mm	⊠ mm	d mm
M3,0	**0,50**	*20,60*	**56**	**11**	**2,70**	**3,5**
M4,0	**0,70**	*22,19*	**63**	**13**	**2,10**	**2,8**
M5,0	**0,80**	*24,06*	**70**	**16**	**2,70**	**3,5**
M6,0	**1,00**	*24,86*	**80**	**19**	**3,40**	**4,5**
M8,0	1,00	*38,24*	90	20	4,90	6,0
M8,0	**1,25**	*29,71*	**90**	**22**	**4,90**	**6,0**
M10,0	1,00	*45,07*	90	20	5,50	7,0
M10,0	1,25	*49,23*	100	20	5,50	7,0
M10,0	**1,50**	*37,60*	**100**	**24**	**5,50**	**7,0**
M12,0	1,00	*56,06*	100	20	7,00	9,0
M12,0	1,25	*62,09*	100	20	7,00	9,0
M12,0	1,50	*53,77*	100	20	7,00	9,0
M12,0	**1,75**	*46,62*	**110**	**29**	**7,00**	**9,0**
M14,0	1,00	*73,93*	100	20	9,00	11,0
M14,0	1,25	*68,91*	100	20	9,00	11,0
M14,0	1,50	*71,26*	100	20	9,00	11,0

Ø	P	€	L mm	l mm	⊠ mm	d mm
M14,0	**2,00**	*61,50*	**110**	**30**	**9,00**	**11,0**
M16,0	1,00	*85,72*	100	20	9,00	12,0
M16,0	1,50	*74,57*	100	22	9,00	12,0
M16,0	**2,00**	*66,62*	**110**	**30**	**9,00**	**12,0**
M18,0	1,00	*106,10*	110	24	11,00	14,0
M18,0	1,50	*94,68*	110	24	11,00	14,0
M18,0	**2,50**	*90,46*	**125**	**34**	**11,00**	**14,0**
M20,0	1,00	*100,66*	125	24	12,00	16,0
M20,0	1,50	*106,62*	125	25	12,00	16,0
M20,0	**2,50**	*99,05*	**140**	**34**	**12,00**	**16,0**
M22,0	1,00	*136,61*	125	25	14,50	18,0
M22,0	1,50	*133,40*	125	25	14,50	18,0
M22,0	**2,50**	*133,45*	**140**	**34**	**14,50**	**18,0**
M24,0	1,50	*145,19*	140	27	14,50	18,0
M24,0	2,00	*159,32*	140	27	14,50	18,0
M24,0	**3,00**	*136,55*	**160**	**38**	**14,50**	**18,0**

P Aceros / Aciers / Steels
M Aceros Inox / Aciers Inox / Stainless Steels
K Fundicion / Fonte / Cast Iron
N Metales no ferrosos / Métal non Ferraux / Non Ferrous metals
S Titanio y Superaleaciones / Titanium et Supealliages / Titanium and Superalloys
H Materiales Duros / Materiels Durs / Hard materials

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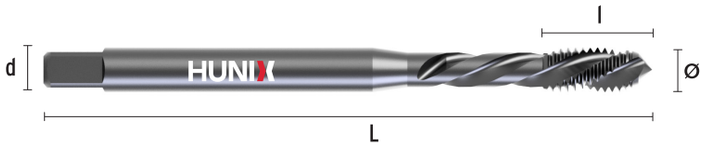
2252 HSSE DIN 371

M DIN 13 | Form. C | Tol. 6H | 35° | 3XD | R | VAP

P				M		K			N				S		H		
<800	<1.000	<1.200	<1.400	<950	<1.200	<500	<800	<1.400	Al	Cu	Mg/Zn	Plastic	Ti	Ni	50 HRC	55 HRC	60 HRC
● 10-25	○ 10-15			● 5-10	○ 5-8		○ 10-15			● 10-20		○ 10-15					

Vc (m/min). ● Optima / Optimun ○ Alternativo / Alternative

MICRO FINISH THREADING TECHNOLOGY



Ø	P	€	L mm	l mm	☒ mm	d mm
M2,0	**0,40**	*29,21*	**45**	**5**	**2,10**	**2,8**
M2,5	**0,45**	*29,21*	**50**	**5**	**2,10**	**2,8**
M3,0	**0,50**	*16,21*	**56**	**6**	**2,70**	**3,5**
M3,5	**0,60**	*19,44*	**56**	**6**	**3,00**	**4,0**
M4,0	**0,70**	*16,48*	**63**	**7**	**3,40**	**4,5**

Ø	P	€	L mm	l mm	☒ mm	d mm
M5,0	**0,80**	*17,41*	**70**	**8**	**4,90**	**6,0**
M6,0	**1,00**	*17,41*	**80**	**10**	**4,90**	**6,0**
M8,0	**1,25**	*20,24*	**90**	**14**	**6,20**	**8,0**
M10,0	**1,50**	*25,90*	**100**	**16**	**8,00**	**10,0**

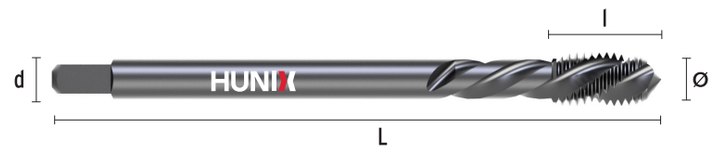
2253 HSSE DIN 376/374

M-MF DIN13 | Form. C | Tol. 6H | 35° | 3XD | D | VAP

P				M		K			N				S		H		
<800	<1.000	<1.200	<1.400	<950	<1.200	<500	<800	<1.400	Al	Cu	Mg/Zn	Plastic	Ti	Ni	50 HRC	55 HRC	60 HRC
● 10-25	○ 10-15			● 5-10	○ 5-8		○ 10-15			● 10-20		○ 10-15					

Vc (m/min). ● Optima / Optimun ○ Alternativo / Alternative

MICRO FINISH THREADING TECHNOLOGY



Ø	P	€	L mm	l mm	☒ mm	d mm
M3,0	**0,50**	*18,59*	**56**	**5**	**2,00**	**2,2**
M4,0	**0,70**	*18,99*	**63**	**7**	**2,10**	**2,8**
M5,0	**0,80**	*19,97*	**70**	**8**	**2,70**	**3,5**
M6,0	**1,00**	*19,97*	**80**	**10**	**3,40**	**4,5**
M8,0	1,00	*30,26*	90	10	4,90	6,0
M8,0	**1,25**	*23,27*	**90**	**14**	**4,90**	**6,0**
M10,0	1,00	*34,22*	90	10	5,50	7,0
M10,0	1,25	*39,88*	100	15	5,50	7,0
M10,0	**1,50**	*28,53*	**100**	**16**	**5,50**	**7,0**
M12,0	1,00	*44,04*	100	10	7,00	9,0
M12,0	1,25	*47,80*	100	15	7,00	9,0
M12,0	1,50	*44,04*	100	15	7,00	9,0
M12,0	**1,75**	*36,73*	**110**	**18**	**7,00**	**9,0**
M14,0	1,00	*60,13*	100	10	9,00	11,0
M14,0	1,25	*55,19*	100	15	9,00	11,0
M14,0	1,50	*60,13*	100	15	9,00	11,0

Ø	P	€	L mm	l mm	☒ mm	d mm
M14,0	**2,00**	*50,18*	**110**	**20**	**9,00**	**11,0**
M16,0	1,00	*69,70*	100	10	9,00	12,0
M16,0	1,50	*61,70*	100	15	9,00	12,0
M16,0	**2,00**	*53,66*	**110**	**20**	**9,00**	**12,0**
M18,0	1,00	*95,80*	110	13	11,00	14,0
M18,0	1,50	*73,70*	110	20	11,00	14,0
M18,0	**2,50**	*73,70*	**125**	**25**	**11,00**	**14,0**
M20,0	1,00	*93,67*	125	13	12,00	16,0
M20,0	1,50	*85,83*	125	20	12,00	16,0
M20,0	**2,50**	*78,06*	**140**	**25**	**12,00**	**16,0**
M22,0	1,00	*157,00*	125	13	14,50	18,0
M22,0	1,50	*111,21*	125	17	14,50	18,0
M22,0	**2,50**	*111,21*	**140**	**27**	**14,50**	**18,0**
M24,0	1,50	*113,39*	140	20	14,50	18,0
M24,0	2,00	*123,68*	140	20	14,50	18,0
M24,0	**3,00**	*103,04*	**160**	**30**	**14,50**	**18,0**

P Aceros / Aciers / Steels
M Aceros Inox / Aciers Inox / Stainless Steels
K Fundicion / Fonte / Cast Iron
N Metales no ferrosos / Métal non Ferraux / Non Ferrous metals
S Titanio y Superaleaciones / Titanium et Supealliages / Titanium and Superalloys
H Materiales Duros / Materiels Durs / Hard materials

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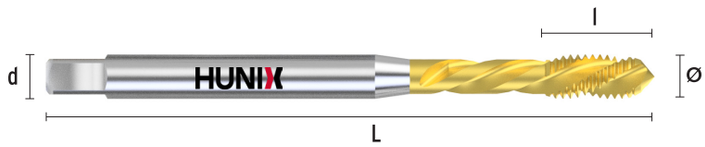
2118 HSSE DIN 371

M DIN 13 | Form. C | Tol. 6H | 35° | 3XD | R | TIN+

P				M		K			N				S		H		
<800	<1.000	<1.200	<1.400	<950	<1.200	<500	<800	<1.400	Al	Cu	Mg/Zn	Plastic	Ti	Ni	50 HRC	55 HRC	60 HRC
● 10-25	● 12-18	○ 8-12		● 6-12	○ 6-10		● 15-20			● 15-25		○ 12-18					

Vc (m/min). ● Optima / Optimun ○ Alternativo / Alternative

MICRO FINISH THREADING TECHNOLOGY



Ø	P	€	L mm	l mm	☐ mm	d mm
M2,0	**0,40**	*31,41*	**45**	**5**	**2,10**	**2,8**
M2,5	**0,45**	*31,41*	**50**	**5**	**2,10**	**2,8**
M3,0	**0,50**	*19,52*	**56**	**6**	**2,70**	**3,5**
M3,5	**0,60**	*24,80*	**56**	**6**	**3,00**	**4,0**
M4,0	**0,70**	*19,68*	**63**	**7**	**3,40**	**4,5**

Ø	P	€	L mm	l mm	☐ mm	d mm
M5,0	**0,80**	*21,44*	**70**	**8**	**4,90**	**6,0**
M6,0	**1,00**	*22,19*	**80**	**10**	**4,90**	**6,0**
M8,0	**1,25**	*26,67*	**90**	**14**	**6,20**	**8,0**
M10,0	**1,50**	*35,04*	**100**	**16**	**8,00**	**10,0**

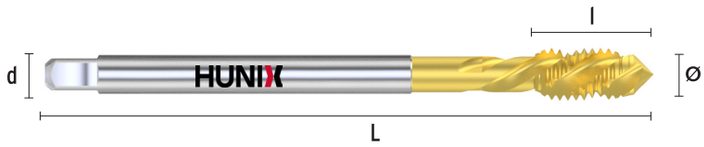
2117 HSSE DIN 376/374

M-MF DIN 13 | Form. C | Tol. 6H | 35° | 3XD | D | TIN+

P				M		K			N				S		H		
<800	<1.000	<1.200	<1.400	<950	<1.200	<500	<800	<1.400	Al	Cu	Mg/Zn	Plastic	Ti	Ni	50 HRC	55 HRC	60 HRC
● 10-25	● 12-18	○ 8-12		● 6-12	○ 6-10		● 15-20			● 15-25		○ 12-18					

Vc (m/min). ● Optima / Optimun ○ Alternativo / Alternative

MICRO FINISH THREADING TECHNOLOGY



Ø	P	€	L mm	l mm	☐ mm	d mm
M3,0	**0,50**	*21,03*	**56**	**5**	**2,00**	**2,2**
M4,0	**0,70**	*24,11*	**63**	**7**	**2,10**	**2,8**
M5,0	**0,80**	*26,08*	**70**	**8**	**2,70**	**3,5**
M6,0	**1,00**	*26,88*	**80**	**10**	**3,40**	**4,5**
M8,0	1,00	*41,50*	90	10	4,90	6,0
M8,0	**1,25**	*32,11*	**90**	**14**	**4,90**	**6,0**
M10,0	1,00	*48,65*	90	10	5,50	7,0
M10,0	1,25	*53,23*	100	15	5,50	7,0
M10,0	**1,50**	*40,54*	**100**	**16**	**5,50**	**7,0**
M12,0	1,00	*60,49*	100	10	7,00	9,0
M12,0	1,25	*67,31*	100	15	7,00	9,0
M12,0	1,50	*57,98*	100	15	7,00	9,0
M12,0	**1,75**	*50,14*	**110**	**18**	**7,00**	**9,0**
M14,0	1,00	*80,17*	100	10	9,00	11,0
M14,0	1,25	*74,51*	100	15	9,00	11,0
M14,0	1,50	*77,07*	100	15	9,00	11,0

Ø	P	€	L mm	l mm	☐ mm	d mm
M14,0	**2,00**	*66,30*	**110**	**20**	**9,00**	**11,0**
M16,0	1,00	*92,76*	100	10	9,00	12,0
M16,0	1,50	*80,49*	100	15	9,00	12,0
M16,0	**2,00**	*71,85*	**110**	**20**	**9,00**	**12,0**
M18,0	1,00	*110,61*	110	13	11,00	14,0
M18,0	1,50	*101,88*	110	20	11,00	14,0
M18,0	**2,50**	*97,61*	**125**	**25**	**11,00**	**14,0**
M20,0	1,00	*108,61*	125	13	12,00	16,0
M20,0	1,50	*114,95*	125	20	12,00	16,0
M20,0	**2,50**	*106,62*	**140**	**25**	**12,00**	**16,0**
M22,0	1,00	*148,01*	125	13	14,50	18,0
M22,0	1,50	*144,17*	125	17	14,50	18,0
M22,0	**2,50**	*144,12*	**140**	**27**	**14,50**	**18,0**
M24,0	1,50	*156,12*	140	20	14,50	18,0
M24,0	2,00	*181,30*	140	20	14,50	18,0
M24,0	**3,00**	*146,52*	**160**	**30**	**14,50**	**18,0**

P Aceros / Aciers / Steels
M Aceros Inox / Aciers Inox / Stainless Steels
K Fundicion / Fonte / Cast Iron
N Metales no ferrosos / Métal non Ferraux / Non Ferrous metals
S Titanio y Superaleaciones / Titanium et Supealliages / Titanium and Superalloys
H Materiales Duros / Materiels Durs / Hard materials

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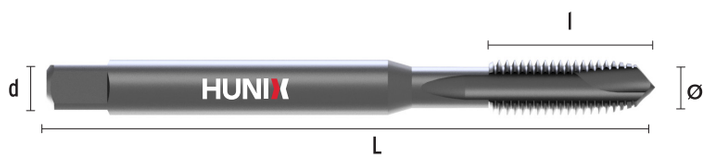
2262 HSSE DIN 371

UNC ANSI/ASME B1.1 | Form. B "Gun" | Tol. 2B | R | 3XD | VAP

P				M		K			N				S		H		
<800	<1.000	<1.200	<1.400	<950	<1.200	<500	<800	<1.400	Al	Cu	Mg/Zn	Plastic	Ti	Ni	50 HRC	55 HRC	60 HRC
● 10-25	○ 10-15			● 5-10	○ 5-8		○ 10-15		○ 10-15	● 10-20		○ 10-15					

Vc (m/min). ● Optima / Optimun ○ Alternativo / Alternative

MICRO FINISH THREADING TECHNOLOGY



Ø	P	€	L mm	l mm	⊠ mm	d mm
Nº4	40,00	*24,36*	56	10	2,70	3,5
Nº5	40,00	*22,71*	56	10	2,70	3,5
Nº6	32,00	*22,71*	56	12	3,00	4,0
Nº8	32,00	*22,71*	63	12	3,40	4,5
Nº10	24,00	*22,98*	70	14	4,90	6,0

Ø	P	€	L mm	l mm	⊠ mm	d mm
Nº12	24,00	*24,31*	80	18	4,90	6,0
1/4	20,00	*24,31*	80	18	5,50	7,0
5/16	18,00	*26,26*	90	20	6,20	8,0
3/8	16,00	*31,03*	100	20	8,00	10,0

2263 HSSE DIN 376

UNC ANSI/ASME B1.1 | Form. B "Gun" | Tol. 2B | D | 3XD | VAP

P				M		K			N				S		H		
<800	<1.000	<1.200	<1.400	<950	<1.200	<500	<800	<1.400	Al	Cu	Mg/Zn	Plastic	Ti	Ni	50 HRC	55 HRC	60 HRC
● 10-25	○ 10-15			● 5-10	○ 5-8		○ 10-15		○ 10-15	● 10-20		○ 10-15					

Vc (m/min). ● Optima / Optimun ○ Alternativo / Alternative

MICRO FINISH THREADING TECHNOLOGY



Ø	P	€	L mm	l mm	⊠ mm	d mm
7/16	14,00	*44,09*	100	22	6,20	8,0
1/2	13,00	*44,09*	110	24	7,00	9,0
9/16	12,00	*60,19*	110	25	9,00	11,0
5/8	11,00	*59,03*	110	32	9,00	12,0

Ø	P	€	L mm	l mm	⊠ mm	d mm
3/4	10,00	*85,87*	125	32	11,00	14,0
7/8	9,00	*122,33*	140	32	14,50	18,0
1"	8,00	*113,34*	160	38	16,00	20,0

P Aceros / Aciers / Steels
M Aceros Inox / Aciers Inox / Stainless Steels
K Fundicion / Fonte / Cast Iron
N Metales no ferrosos / Métal non Ferraux / Non Ferrous metals
S Titanio y Superaleaciones / Titanium et Supealliages / Titanium and Superalloys
H Materiales Duros / Materiels Durs / Hard materials

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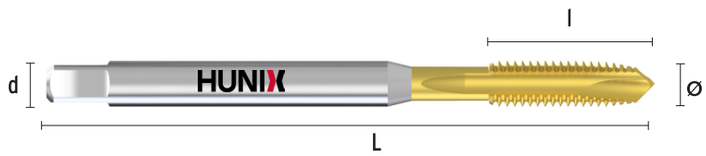
2234 HSSE DIN 371

UNC ANSI/ASME B1.1 | Form. B "Gun" | Tol. 2B | R | 3XD | TIN+

P				M		K			N				S		H		
<800	<1.000	<1.200	<1.400	<950	<1.200	<500	<800	<1.400	Al	Cu	Mg/Zn	Plastic	Ti	Ni	50 HRC	55 HRC	60 HRC
● 15-30	● 12-18	○ 8-12		● 6-12	○ 6-10	● 10-15	● 15-20		● 15-25	● 15-25		○ 12-18					

Vc (m/min). ● Optima / Optimun ○ Alternativo / Alternative

MICRO FINISH THREADING TECHNOLOGY



Ø	P	€	L mm	l mm	☐ mm	d mm
Nº4	40,00	*33,28*	56	10	2,70	3,5
Nº5	40,00	*30,02*	56	10	2,70	3,5
Nº6	32,00	*30,02*	56	12	3,00	4,0
Nº8	32,00	*30,02*	63	12	3,40	4,5
Nº10	24,00	*32,26*	70	14	4,90	6,0

Ø	P	€	L mm	l mm	☐ mm	d mm
Nº12	24,00	*33,73*	80	18	4,90	6,0
1/4	20,00	*33,73*	80	18	5,50	7,0
5/16	18,00	*37,83*	90	20	6,20	8,0
3/8	16,00	*46,47*	100	20	8,00	10,0

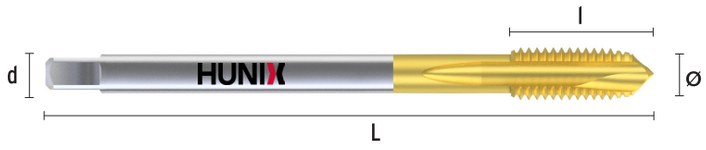
2235 HSSE DIN 376

UNC ANSI/ASME B1.1 | Form. B "Gun" | Tol. 2B | D | 3XD | TIN+

P				M		K			N				S		H		
<800	<1.000	<1.200	<1.400	<950	<1.200	<500	<800	<1.400	Al	Cu	Mg/Zn	Plastic	Ti	Ni	50 HRC	55 HRC	60 HRC
● 15-30	● 12-18	○ 8-12		● 6-12	○ 6-10	● 10-15	● 15-20		● 15-25	● 15-25		○ 12-18					

Vc (m/min). ● Optima / Optimun ○ Alternativo / Alternative

MICRO FINISH THREADING TECHNOLOGY



Ø	P	€	L mm	l mm	☐ mm	d mm
7/16	14,00	*64,97*	100	22	6,20	8,0
1/2	13,00	*66,95*	110	24	7,00	9,0
9/16	12,00	*91,40*	110	25	9,00	11,0
5/8	11,00	*86,66*	110	32	9,00	12,0

Ø	P	€	L mm	l mm	☐ mm	d mm
3/4	10,00	*127,89*	125	32	11,00	14,0
7/8	9,00	*191,64*	140	32	14,50	18,0
1"	8,00	*176,85*	160	38	16,00	20,0

P Aceros Aciers Steels
M Aceros Inox Aciers Inox Stainless Steels
K Fundicion Fonte Cast Iron
N Metales no ferrosos Métal non Ferraux Non Ferrous metals
S Titanio y Superaleaciones Titanium et Supealliages Titanium and Superalloys
H Materiales Duros Materiels Durs Hard materials

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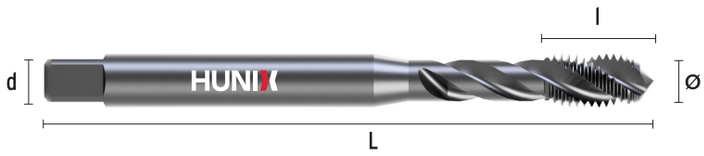
2264 HSSE DIN 371

UNC ANSI/ASME B1.1 | Form. C | Tol. 2B | 35° | R | 3XD | VAP

P				M		K			N				S		H		
<800	<1.000	<1.200	<1.400	<950	<1.200	<500	<800	<1.400	Al	Cu	Mg/Zn	Plastic	Ti	Ni	50 HRC	55 HRC	60 HRC
● 10-25	○ 10-15			● 5-10	○ 5-8		○ 10-15			● 10-20		○ 10-15					

Vc (m/min). ● Optima / Optimun ○ Alternativo / Alternative

MICRO FINISH THREADING TECHNOLOGY



Ø	P	€	L mm	l mm	☐ mm	d mm
Nº4	40,00	*26,84*	56	5	2,70	3,5
Nº5	40,00	*24,94*	56	7	2,70	3,5
Nº6	32,00	*24,94*	56	6	3,00	4,0
Nº8	32,00	*24,94*	63	7	3,40	4,5
Nº10	24,00	*25,38*	70	8	4,90	6,0

Ø	P	€	L mm	l mm	☐ mm	d mm
Nº12	24,00	*26,76*	80	10	4,90	6,0
1/4	20,00	*26,76*	80	13	5,50	7,0
5/16	18,00	*28,94*	90	13	6,20	8,0
3/8	16,00	*34,14*	100	15	8,00	10,0

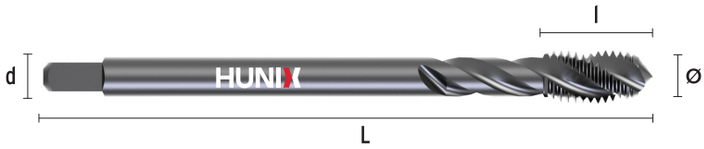
2265 HSSE DIN 376

UNC ANSI/ASME | Form. C | Tol. 2B | 35° | D | 3XD | VAP

P				M		K			N				S		H		
<800	<1.000	<1.200	<1.400	<950	<1.200	<500	<800	<1.400	Al	Cu	Mg/Zn	Plastic	Ti	Ni	50 HRC	55 HRC	60 HRC
● 10-25	○ 10-15			● 5-10	○ 5-8		○ 10-15			● 10-20		○ 10-15					

Vc (m/min). ● Optima / Optimun ○ Alternativo / Alternative

MICRO FINISH THREADING TECHNOLOGY



Ø	P	€	L mm	l mm	☐ mm	d mm
7/16	14,00	*48,45*	100	15	6,20	8,0
1/2	13,00	*48,45*	110	18	7,00	9,0
9/16	12,00	*66,14*	110	20	9,00	11,0
5/8	11,00	*64,98*	110	22	9,00	12,0

Ø	P	€	L mm	l mm	☐ mm	d mm
3/4	10,00	*94,41*	125	25	11,00	14,0
7/8	9,00	*134,54*	140	30	14,50	18,0
1"	8,00	*124,72*	160	30	16,00	20,0

P Aceros / Aciers / Steels
M Aceros Inox / Aciers Inox / Stainless Steels
K Fundicion / Fonte / Cast Iron
N Metales no ferrosos / Métal non Ferraux / Non Ferrous metals
S Titanio y Superaleaciones / Titanium et Supealliages / Titanium and Superalloys
H Materiales Duros / Materiels Durs / Hard materials

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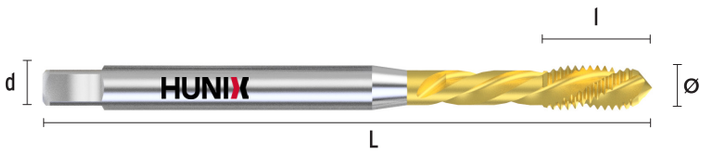
2236 HSSE DIN 371

UNC ANSI/ASME B1.1 | Form. C | Tol. 2B | 35° | R | 3XD | TIN+

P				M		K			N				S		H		
<800	<1.000	<1.200	<1.400	<950	<1.200	<500	<800	<1.400	Al	Cu	Mg/Zn	Plastic	Ti	Ni	50 HRC	55 HRC	60 HRC
● 10-25	● 12-18	○ 8-12		● 6-12	○ 6-10		● 15-20			● 15-25		○ 12-18					

Vc (m/min). ● Optima / Optimun ○ Alternativo / Alternative

MICRO FINISH THREADING TECHNOLOGY



Ø	P	€	L mm	l mm	☐ mm	d mm
Nº4	40,00	*33,28*	56	5	2,70	3,5
Nº5	40,00	*33,28*	56	7	2,70	3,5
Nº6	32,00	*32,64*	56	6	3,00	4,0
Nº8	32,00	*32,64*	63	7	3,40	4,5
Nº10	24,00	*34,95*	70	8	4,90	6,0

Ø	P	€	L mm	l mm	☐ mm	d mm
Nº12	24,00	*36,61*	80	10	4,90	6,0
1/4	20,00	*36,61*	80	13	5,50	7,0
5/16	18,00	*40,84*	90	13	6,20	8,0
3/8	16,00	*50,12*	100	15	8,00	10,0

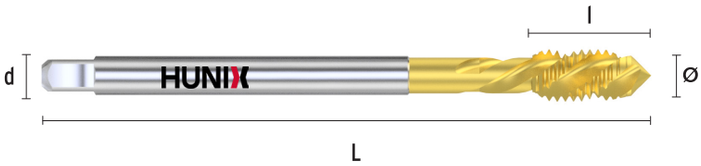
2237 HSSE DIN 376

UNC ANSI/ASME B1.1 | Form. C | Tol. 2B | 35° | D | 3XD | TIN+

P				M		K			N				S		H		
<800	<1.000	<1.200	<1.400	<950	<1.200	<500	<800	<1.400	Al	Cu	Mg/Zn	Plastic	Ti	Ni	50 HRC	55 HRC	60 HRC
● 10-25	● 12-18	○ 8-12		● 6-12	○ 6-10		● 15-20			● 15-25		○ 12-18					

Vc (m/min). ● Optima / Optimun ○ Alternativo / Alternative

MICRO FINISH THREADING TECHNOLOGY



Ø	P	€	L mm	l mm	☐ mm	d mm
7/16	14,00	*70,09*	100	15	6,20	8,0
1/2	13,00	*72,14*	110	18	7,00	9,0
9/16	12,00	*98,76*	110	20	9,00	11,0
5/8	11,00	*93,45*	110	22	9,00	12,0

Ø	P	€	L mm	l mm	☐ mm	d mm
3/4	10,00	*137,93*	125	25	11,00	14,0
7/8	9,00	*206,61*	140	30	14,50	18,0
1"	8,00	*190,04*	160	30	16,00	20,0

P Aceros Aciers Steels
M Aceros Inox Aciers Inox Stainless Steels
K Fundicion Fonte Cast Iron
N Metales no ferrosos Métal non Ferraux Non Ferrous metals
S Titanio y Superaleaciones Titanium et Supealliages Titanium and Superalloys
H Materiales Duros Materiels Durs Hard materials

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2276 HSSE DIN 371

UNF ANSI/ASME B1.1 | Form. B "Gun" | Tol. 2B | 3XD | R | VAP

P				M		K			N				S		H		
<800	<1.000	<1.200	<1.400	<950	<1.200	<500	<800	<1.400	Al	Cu	Mg/Zn	Plastic	Ti	Ni	50 HRC	55 HRC	60 HRC
● 10-25	○ 10-15			● 5-10	○ 5-8		○ 10-15		○ 10-15	● 10-20		○ 10-15					

Vc (m/min). ● Optima / Optimun ○ Alternativo / Alternative

MICRO FINISH THREADING TECHNOLOGY



Ø	P	€	L mm	l mm	☒ mm	d mm
Nº4	48,00	*25,69*	56	11	2,70	3,5
Nº5	44,00	*25,68*	56	11	2,70	3,5
Nº6	40,00	*25,88*	56	12	3,00	4,0
Nº8	36,00	*26,10*	63	12	3,40	4,5
Nº10	32,00	*26,54*	70	14	4,90	6,0

Ø	P	€	L mm	l mm	☒ mm	d mm
Nº12	28,00	*27,86*	80	18	4,90	6,0
1/4	20,00	*29,16*	80	18	5,50	7,0
5/16	24,00	*30,23*	90	20	6,20	8,0
3/8	24,00	*35,82*	100	20	8,00	10,0

2277 HSSE DIN 374

UNF ANSI/ASME B1.1 | Form. B "Gun" | Tol. 2B | 3XD | D | VAP

P				M		K			N				S		H		
<800	<1.000	<1.200	<1.400	<950	<1.200	<500	<800	<1.400	Al	Cu	Mg/Zn	Plastic	Ti	Ni	50 HRC	55 HRC	60 HRC
● 10-25	○ 10-15			● 5-10	○ 5-8		○ 10-15		○ 10-15	● 10-20		○ 10-15					

Vc (m/min). ● Optima / Optimun ○ Alternativo / Alternative

MICRO FINISH THREADING TECHNOLOGY



Ø	P	€	L mm	l mm	☒ mm	d mm
7/16	20,00	*50,68*	100	20	6,20	8,0
1/2	20,00	*50,68*	100	20	7,00	9,0
9/16	18,00	*69,11*	100	20	9,00	11,0
5/8	18,00	*67,87*	100	20	9,00	12,0

Ø	P	€	L mm	l mm	☒ mm	d mm
3/4	16,00	*98,77*	110	24	11,00	14,0
7/8	14,00	*140,68*	125	24	14,50	18,0
1"	12,00	*130,46*	140	27	14,50	18,0

P Aceros Aciers Steels | M Aceros Inox Aciers Inox Stainless Steels | K Fundicion Fonte Cast Iron | N Metales no ferrosos Métal non Ferraux Non Ferrous metals | S Titanio y Superaleaciones Titanium et Supealliages Titanium and Superalloys | H Materiales Duros Materiels Durs Hard materials

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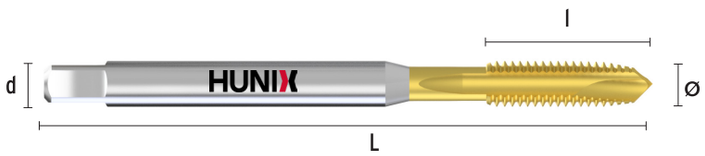
2280 HSSE DIN 371

UNF ANSI/ASME B1.1 | Form. B "Gun" | Tol. 2B | 3XD | R | TIN+

P				M		K			N				S		H		
<800	<1.000	<1.200	<1.400	<950	<1.200	<500	<800	<1.400	Al	Cu	Mg/Zn	Plastic	Ti	Ni	50 HRC	55 HRC	60 HRC
● 15-30	● 12-18	○ 8-12		● 6-12	○ 6-10	● 10-15	● 15-20		● 15-25	● 15-25		○ 12-18					

Vc (m/min). ● Optima / Optimun ○ Alternativo / Alternative

MICRO FINISH THREADING TECHNOLOGY



Ø	P	€	L mm	l mm	☐ mm	d mm
Nº4	48,00	*37,93*	56	11	2,70	3,5
Nº5	44,00	*34,22*	56	11	2,70	3,5
Nº6	40,00	*34,22*	56	12	3,00	4,0
Nº8	36,00	*34,22*	63	12	3,40	4,5
Nº10	32,00	*36,48*	70	14	4,90	6,0

Ø	P	€	L mm	l mm	☐ mm	d mm
Nº12	28,00	*38,15*	80	18	4,90	6,0
1/4	20,00	*38,15*	80	18	5,50	7,0
5/16	24,00	*43,20*	90	20	6,20	8,0
3/8	24,00	*53,77*	100	20	8,00	10,0

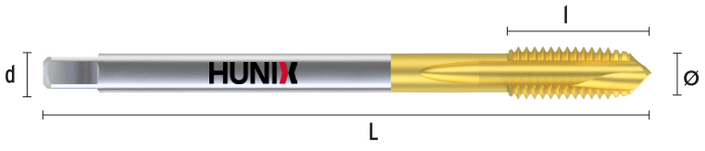
2281 HSSE DIN 374

UNF ANSI/ASME B1.1 | Form. B "Gun" | Tol. 2B | 3XD | D | TIN+

P				M		K			N				S		H		
<800	<1.000	<1.200	<1.400	<950	<1.200	<500	<800	<1.400	Al	Cu	Mg/Zn	Plastic	Ti	Ni	50 HRC	55 HRC	60 HRC
● 15-30	● 12-18	○ 8-12		● 6-12	○ 6-10	● 10-15	● 15-20		● 15-25	● 15-25		○ 12-18					

Vc (m/min). ● Optima / Optimun ○ Alternativo / Alternative

MICRO FINISH THREADING TECHNOLOGY



Ø	P	€	L mm	l mm	☐ mm	d mm
7/16	20,00	*73,35*	100	20	6,20	8,0
1/2	20,00	*77,06*	100	20	7,00	9,0
9/16	18,00	*105,10*	100	20	9,00	11,0
5/8	18,00	*99,59*	100	20	9,00	12,0

Ø	P	€	L mm	l mm	☐ mm	d mm
3/4	16,00	*147,22*	110	24	11,00	14,0
7/8	14,00	*216,21*	125	24	14,50	18,0
1"	12,00	*203,03*	140	27	14,50	18,0

P Aceros Aciers Steels
M Aceros Inox Aciers Inox Stainless Steels
K Fundicion Fonte Cast Iron
N Metales no ferrosos Métal non Ferraux Non Ferrous metals
S Titanio y Superaleaciones Titanium et Supealliages Titanium and Superalloys
H Materiales Duros Materiels Durs Hard materials

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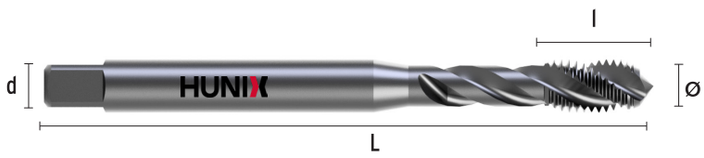
2278 HSSE DIN 371

UNF ANSI/ASME B1.1 | Form. C | Tol. 2B | 35° | 3XD | R | VAP

P				M		K			N				S		H		
<800	<1.000	<1.200	<1.400	<950	<1.200	<500	<800	<1.400	Al	Cu	Mg/Zn	Plastic	Ti	Ni	50 HRC	55 HRC	60 HRC
● 10-25	○ 10-15			● 5-10	○ 5-8		○ 10-15			● 10-20		○ 10-15					

Vc (m/min). ● Optima / Optimun ○ Alternativo / Alternative

MICRO FINISH THREADING TECHNOLOGY



Ø	P	€	L mm	l mm	⊠ mm	d mm
Nº4	48,00	*28,27*	56	5	2,70	3,5
Nº5	44,00	*28,27*	56	5	2,70	3,5
Nº6	40,00	*28,63*	56	6	3,00	4,0
Nº8	36,00	*28,80*	63	7	3,40	4,5
Nº10	32,00	*29,16*	70	8	4,90	6,0

Ø	P	€	L mm	l mm	⊠ mm	d mm
Nº12	28,00	*30,67*	80	10	4,90	6,0
1/4	28,00	*32,13*	80	10	5,50	7,0
5/16	24,00	*33,29*	90	13	6,20	8,0
3/8	24,00	*39,46*	100	15	8,00	10,0

2279 HSSE DIN 374

UNF ANSI/ASME B1.1 | Form. C | Tol. 2B | 35° | 3XD | D | VAP

P				M		K			N				S		H		
<800	<1.000	<1.200	<1.400	<950	<1.200	<500	<800	<1.400	Al	Cu	Mg/Zn	Plastic	Ti	Ni	50 HRC	55 HRC	60 HRC
● 10-25	○ 10-15			● 5-10	○ 5-8		○ 10-15			● 10-20		○ 10-15					

Vc (m/min). ● Optima / Optimun ○ Alternativo / Alternative

MICRO FINISH THREADING TECHNOLOGY



Ø	P	€	L mm	l mm	⊠ mm	d mm
7/16	20,00	*55,78*	100	20	6,20	8,0
1/2	20,00	*55,78*	100	20	7,00	9,0
9/16	18,00	*76,22*	100	20	9,00	11,0
5/8	18,00	*74,71*	100	20	9,00	12,0

Ø	P	€	L mm	l mm	⊠ mm	d mm
3/4	16,00	*108,63*	110	24	11,00	14,0
7/8	14,00	*154,82*	125	24	14,50	18,0
1"	12,00	*143,44*	140	27	14,50	18,0

P Aceros / Aciers / Steels
M Aceros Inox / Aciers Inox / Stainless Steels
K Fundicion / Fonte / Cast Iron
N Metales no ferrosos / Métal non Ferraux / Non Ferrous metals
S Titanio y Superaleaciones / Titanium et Supealliages / Titanium and Superalloys
H Materiales Duros / Materiels Durs / Hard materials

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2282 HSSE DIN 371

UNF ANSI/ASME B1.1 | Form. C | Tol. 2B | 35° | 3XD | R | TIN+

P				M		K			N				S		H		
<800	<1.000	<1.200	<1.400	<950	<1.200	<500	<800	<1.400	Al	Cu	Mg/Zn	Plastic	Ti	Ni	50 HRC	55 HRC	60 HRC
● 10-25	● 12-18	○ 8-12		● 6-12	○ 6-10		● 15-20			● 15-25		○ 12-18					

Vc (m/min). ● Optima / Optimun ○ Alternativo / Alternative

MICRO FINISH THREADING TECHNOLOGY



Ø	P	€	L mm	l mm	☐ mm	d mm
Nº4	48,00	*41,83*	56	5	2,70	3,5
Nº5	44,00	*37,60*	56	5	2,70	3,5
Nº6	40,00	*37,60*	56	6	3,00	4,0
Nº8	36,00	*37,60*	63	7	3,40	4,5
Nº10	32,00	*39,56*	70	8	4,90	6,0

Ø	P	€	L mm	l mm	☐ mm	d mm
Nº12	28,00	*41,35*	80	10	4,90	6,0
1/4	28,00	*41,35*	80	10	5,50	7,0
5/16	24,00	*46,72*	90	13	6,20	8,0
3/8	24,00	*57,61*	100	15	8,00	10,0

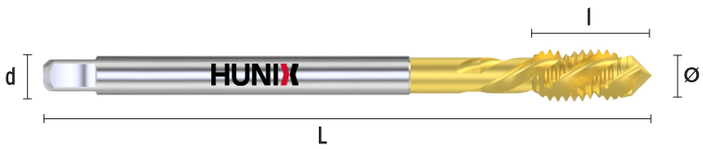
2283 HSSE DIN 374

UNF ANSI/ASME B1.1 | Form. C | Tol. 2B | 35° | 3XD | D | TIN+

P				M		K			N				S		H		
<800	<1.000	<1.200	<1.400	<950	<1.200	<500	<800	<1.400	Al	Cu	Mg/Zn	Plastic	Ti	Ni	50 HRC	55 HRC	60 HRC
● 10-25	● 12-18	○ 8-12		● 6-12	○ 6-10		● 15-20			● 15-25		○ 12-18					

Vc (m/min). ● Optima / Optimun ○ Alternativo / Alternative

MICRO FINISH THREADING TECHNOLOGY



Ø	P	€	L mm	l mm	☐ mm	d mm
7/16	20,00	*79,18*	100	15	6,20	8,0
1/2	20,00	*82,95*	100	15	7,00	9,0
9/16	18,00	*113,61*	100	15	9,00	11,0
5/8	18,00	*106,44*	100	15	9,00	12,0

Ø	P	€	L mm	l mm	☐ mm	d mm
3/4	16,00	*158,61*	110	17	11,00	14,0
7/8	14,00	*233,37*	125	17	14,50	18,0
1"	12,00	*217,56*	140	20	14,50	18,0

P Aceros Aciers Steels
M Aceros Inox Aciers Inox Stainless Steels
K Fundicion Fonte Cast Iron
N Metales no ferrosos Métal non Ferraux Non Ferrous metals
S Titanio y Superaleaciones Titanium et Supealliages Titanium and Superalloys
H Materiales Duros Materiels Durs Hard materials

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2284 HSSE DIN 5156

G ISO 228 | Form. B "Gun" | 3XD | D | VAP

P				M		K			N				S		H		
<800	<1.000	<1.200	<1.400	<950	<1.200	<500	<800	<1.400	Al	Cu	Mg/Zn	Plastic	Ti	Ni	50 HRC	55 HRC	60 HRC
● 10-25	○ 10-15			● 5-10	○ 5-10		○ 10-15		○ 10-15	● 10-20		○ 10-15					

Vc (m/min). ● Optima / Optimun ○ Alternativo / Alternative

MICRO FINISH THREADING TECHNOLOGY



Ø	P	€	L mm	l mm	☐ mm	d mm
1/8	28,00	*36,32*	90	20	5,50	7,0
1/4	19,00	*65,20*	100	22	9,00	11,0
3/8	19,00	*64,32*	100	22	9,00	12,0
1/2	14,00	*85,87*	125	25	12,00	16,0

Ø	P	€	L mm	l mm	☐ mm	d mm
5/8	14,00	*133,43*	125	25	14,50	18,0
3/4	14,00	*151,79*	140	28	16,00	20,0
7/8	14,00	*193,98*	150	30	18,00	22,0
1"	11,00	*285,58*	160	32	20,00	25,0

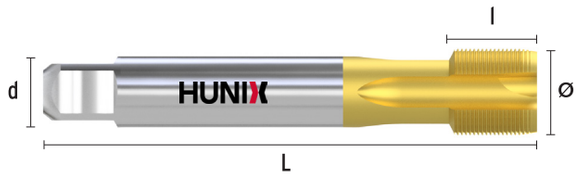
2286 HSSE DIN 5156

G ISO 228 | Form. B "Gun" | 3XD | D | TIN+

P				M		K			N				S		H		
<800	<1.000	<1.200	<1.400	<950	<1.200	<500	<800	<1.400	Al	Cu	Mg/Zn	Plastic	Ti	Ni	50 HRC	55 HRC	60 HRC
● 15-30	● 12-18	○ 8-12		● 6-12	○ 6-10	● 10-15	● 15-20		● 15-25	● 15-25		○ 12-18					

Vc (m/min). ● Optima / Optimun ○ Alternativo / Alternative

MICRO FINISH THREADING TECHNOLOGY



Ø	P	€	L mm	l mm	☐ mm	d mm
1/8	28,00	*55,88*	90	20	5,50	7,0
1/4	19,00	*91,34*	100	22	9,00	11,0
3/8	19,00	*102,79*	100	22	9,00	12,0
1/2	14,00	*130,57*	125	25	12,00	16,0

Ø	P	€	L mm	l mm	☐ mm	d mm
5/8	14,00	*197,46*	125	25	14,50	18,0
3/4	14,00	*221,53*	140	28	16,00	20,0
7/8	14,00	*291,04*	150	30	18,00	22,0
1"	11,00	*397,16*	160	32	20,00	25,0

P Aceros / Aciers / Steels
M Aceros Inox / Aciers Inox / Stainless Steels
K Fundicion / Fonte / Cast Iron
N Metales no ferrosos / Métal non Ferraux / Non Ferrous metals
S Titanio y Superaleaciones / Titanium et Supealliages / Titanium and Superalloys
H Materiales Duros / Materiels Durs / Hard materials

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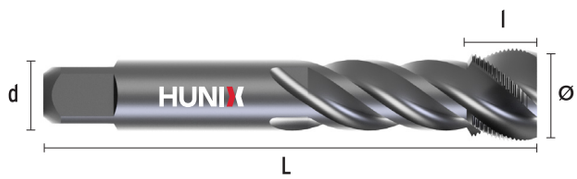
2285 HSSE DIN 5156

G ISO 228 | Form. C | 35° | 3XD | D | VAP

P				M		K			N				S		H		
<800	<1.000	<1.200	<1.400	<950	<1.200	<500	<800	<1.400	Al	Cu	Mg/Zn	Plastic	Ti	Ni	50 HRC	55 HRC	60 HRC
● 10-25	○ 10-15			● 5-10	○ 5-8		○ 10-15			● 10-20		○ 10-15					

Vc (m/min). ● Optima / Optimun ○ Alternativo / Alternativo

MICRO FINISH THREADING TECHNOLOGY



Ø	P	€	L mm	l mm	☐ mm	d mm
1/8	28,00	*39,82*	90	10	5,50	7,0
1/4	19,00	*71,73*	100	14	9,00	11,0
3/8	19,00	*70,85*	100	15	9,00	12,0
1/2	14,00	*94,41*	125	17	12,00	16,0

Ø	P	€	L mm	l mm	☐ mm	d mm
5/8	14,00	*146,77*	125	20	14,50	18,0
3/4	14,00	*166,94*	140	20	16,00	20,0
7/8	14,00	*213,49*	150	22	18,00	22,0
1"	11,00	*314,07*	160	24	20,00	25,0

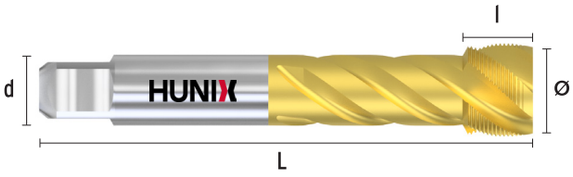
2287 HSSE DIN 5156

G ISO 228 | Form. C | 35° | 3XD | D | TIN+

P				M		K			N				S		H		
<800	<1.000	<1.200	<1.400	<950	<1.200	<500	<800	<1.400	Al	Cu	Mg/Zn	Plastic	Ti	Ni	50 HRC	55 HRC	60 HRC
● 10-25	● 12-18	○ 8-12		● 6-12	○ 6-10		● 15-20			● 15-25		○ 12-18					

Vc (m/min). ● Optima / Optimun ○ Alternativo / Alternativo

MICRO FINISH THREADING TECHNOLOGY



Ø	P	€	L mm	l mm	☐ mm	d mm
1/8	28,00	*60,17*	90	10	5,50	7,0
1/4	19,00	*98,95*	100	14	9,00	11,0
3/8	19,00	*113,10*	100	15	9,00	12,0
1/2	14,00	*140,62*	125	17	12,00	16,0

Ø	P	€	L mm	l mm	☐ mm	d mm
5/8	14,00	*213,01*	125	20	14,50	18,0
3/4	14,00	*236,38*	140	20	16,00	20,0
7/8	14,00	*313,50*	150	22	18,00	22,0
1"	11,00	*430,25*	160	24	20,00	25,0

TABLA DE APLICACIONES / GUIDE D'APPLICATION / APPLICATION GUIDE

$$r.p.m.= \frac{Vc \times 1.000}{\pi x Ø}$$



Ref./ Réf. / Ref.		2250	2251	2116	2115	2252	2253	2118	2117	2262	2263	2234	2235	2264	2265	2236	2237
Rosca/ Filetage/Thread		M-MF	M-MF	M-MF	M-MF	M-MF	M-MF	M-MF	M-MF	UNC	UNC	UNC	UNC	UNC	UNC	UNC	UNC
DIN		371	374 376	371	374 376	371	374 376	371	374 376	371	376	371	376	371	376	371	376
Form.		B(3,5-5)	B(3,5-5)	B(3,5-5)	B(3,5-5)	C(2-3)	C(2-3)	C(2-3)	C(2-3)	B(3,5-5)	B(3,5-5)	B(3,5-5)	B(3,5-5)	C(2-3)	C(2-3)	C(2-3)	C(2-3)
Ejec./Exéc./Exec.						R35°	R35°	R35°	R35°					R35°	R35°	R35°	R35°
Tol.		6H	6H	6H	6H	6H	6H	6H	6H	2B	2B	2B	2B	2B	2B	2B	2B
Mat.		HSSE	HSSE	HSSE	HSSE	HSSE	HSSE	HSSE	HSSE	HSSE	HSSE	HSSE	HSSE	HSSE	HSSE	HSSE	HSSE
Rec./Rev./Coat.		VAP	VAP	TIN+	TIN+	VAP	VAP	TIN+	TIN+	VAP	VAP	TIN+	TIN+	VAP	VAP	TIN+	TIN+
Prof./ Depth		3xD	3xD	3xD	3xD	2,5xD	2,5xD	2,5xD	2,5xD	3xD	3xD	3xD	3xD	2,5xD	2,5xD	2,5xD	2,5xD
Gama/Gamme/Range		2-10	3-24	2-10	3-24	M2-M10	M3-M24	M2-M10	M3-M24	N.4-3/8	7/16-1"	N.4-3/8	7/16-1"	N.4-3/8	7/16-1"	N.4-3/8	7/16-1"
Pag.		150	150	151	151	165	165	166	166	186	186	187	187	189	189	190	190
Mat.																	
P.1	<600	● 15-25	● 15-25	● 20-30	● 20-30	● 15-25	● 15-25	● 20-30	● 20-30	● 15-25	● 15-25	● 20-30	● 20-30	● 15-25	● 15-25	● 20-30	● 20-30
P.2	<800	● 10-20	● 10-20	● 15-25	● 15-25	● 10-20	● 10-20	● 15-25	● 15-25	● 10-20	● 10-20	● 15-25	● 15-25	● 10-20	● 10-20	● 15-25	● 15-25
P.3	<1000	○ 10-15	○ 10-15	● 12-18	● 12-18	○ 10-15	○ 10-15	● 12-18	● 12-18	○ 10-15	○ 10-15	● 12-18	● 12-18	○ 10-15	○ 10-15	● 12-18	● 12-18
P.4	<1200			○ 8-12	○ 8-12			● 8-12	● 8-12			○ 8-12	○ 8-12			8-12	8-12
P.5	<1400																
M.1	<950	● 7-10	● 7-10	● 9-12	● 9-12	● 7-10	● 7-10	● 9-12	● 9-12	● 7-10	● 7-10	● 9-12	● 9-12	● 7-10	● 7-10	● 9-12	● 9-12
M.2	<950	● 5-8	● 5-8	● 6-10	● 6-10	● 5-8	● 5-8	● 6-10	● 6-10	● 5-8	● 5-8	● 6-10	● 6-10	● 5-8	● 5-8	● 6-10	● 6-10
M.3	<1200	○ 5-8	○ 5-8	○ 6-10	○ 6-10	○ 5-8	○ 5-8	○ 6-10	○ 6-10	○ 5-8	○ 5-8	○ 6-10	○ 6-10	○ 5-8	○ 5-8	○ 6-10	○ 6-10
M.4	<1200																
K.1	<500			● 10-15	● 10-15							● 10-15	● 10-15				
K.2	<500			● 10-15	● 10-15							● 10-15	● 10-15				
K.3	<800			● 15-20	● 15-20			● 15-20	● 15-20			● 15-20	● 15-20			● 15-20	● 15-20
K.4.1	<800	○ 10-15	○ 10-15	● 15-20	● 15-20	○ 10-15	○ 10-15	● 15-20	● 15-20	○ 10-15	○ 10-15	● 15-20	● 15-20	○ 10-15	○ 10-15	● 15-20	● 15-20
K.4.2	<1400																
N.1.1	Al			● 15-25	● 15-25							● 15-25	● 15-25				
N.1.2	Al	○ 10-15	○ 10-15	● 15-25	● 15-25					○ 10-15	○ 10-15	● 15-25	● 15-25				
N.1.3	Al			● 15-25	● 15-25							● 15-25	● 15-25				
N.2.1	Cu			● 15-25	● 15-25			● 15-25	● 15-25			● 15-25	● 15-25			● 15-25	● 15-25
N.2.2	Cu																
N.2.3	Cu	● 10-20	● 10-20	● 15-25	● 15-25	● 10-20	● 10-20	● 15-25	● 15-25	● 10-20	● 10-20	● 15-25	● 15-25	● 10-20	● 10-20	● 15-25	● 15-25
N.2.4	Cu																
N.3.1	Mg/Zn																
N.4.1	Plastic	○ 10-15	○ 10-15	○ 12-18	○ 12-18	○ 10-15	○ 10-15	○ 12-18	○ 12-18	○ 10-15	○ 10-15	○ 12-18	○ 12-18	○ 10-15	○ 10-15	○ 12-18	○ 12-18
N.4.2	Plastic																
N.4.3	Plastic																
S.1.1	Ni																
S.1.2	Ni																
S.2.1	Ti																
S.2.2	Ti																
S.2.3	Ti																
H.1	50 HRC																
H.2	55 HRC																
H.3	60 HRC																

● Optima / Optimun ○ Alternativo / Alternative

P	Aceros Aciers Steels	M	Aceros Inox Aciers Inox Stainless Steels	K	Fundicion Fonte Cast Iron	N	Metales no ferrosos Métal non Ferraux Non Ferrous metals	S	Titanio y Superaleaciones Titanium et Supealliages Titanium and Superalloys	H	Materiales Duros Materiels Durs Hard materials
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2276	2277	2280	2281	2278	2279	2282	2283	2284	2286	2285	2287
UNF	UNF	UNF	UNF	UNF	UNF	UNF	UNF	G	G	G	G
371	374	371	374	371	374	371	374	5156	5156	5156	5156
B(3,5-5)	B(3,5-5)	B(3,5-5)	B(3,5-5)	C(2-3)	C(2-3)	C(2-3)	C(2-3)	B(3,5-5)	B(3,5-5)	C(2-3)	C(2-3)
				R35°	R35°	R35°	R35°			R35°	R35°
2B	2B	2B	2B	2B	2B	2B	2B	Med	Med	Med	Med
HSSE	HSSE	HSSE	HSSE	HSSE	HSSE	HSSE	HSSE	HSSE	HSSE	HSSE	HSSE
VAP	VAP	TIN+	TIN+	VAP	VAP	TIN+	TIN+	VAP	TIN+	VAP	TIN+
3xD	3xD	3xD	3xD	2,5xD	2,5xD	2,5xD	2,5xD	3xD	3xD	2,5xD	2,5xD
N.4-3/8	7/16-1"	N.4-3/8	7/16-1"	N.4-3/8	7/16-1"	N.4-3/8	7/16-1"	1/8-1"	1/8-1"	1/8-1"	1/8-1"
194	194	195	195	197	197	198	198	207	208	209	209
● 15-25	● 15-25	● 20-30	● 20-30	● 15-25	● 15-25	● 20-30	● 20-30	● 15-25	● 20-30	● 15-25	● 20-30
● 10-20	● 10-20	● 15-25	● 15-25	● 10-20	● 10-20	● 15-25	● 15-25	● 10-20	● 15-25	● 10-20	● 15-25
o 10-15	o 10-15	● 12-18	● 12-18	o 10-15	o 10-15	● 12-18	● 12-18	o 10-15	● 12-18	o 10-15	● 12-18
		o 8-12	o 8-12			8-12	8-12		o 8-12		8-12
● 7-10	● 7-10	● 9-12	● 9-12	● 7-10	● 7-10	● 9-12	● 9-12	● 7-10	● 9-12	● 7-10	● 9-12
● 5-8	● 5-8	● 6-10	● 6-10	● 5-8	● 5-8	● 6-10	● 6-10	● 5-8	● 6-10	● 5-8	● 6-10
o 5-8	o 5-8	o 6-10	o 6-10	o 5-8	o 5-8	o 6-10	o 6-10	o 5-8	o 6-10	o 5-8	o 6-10
		● 10-15	● 10-15						● 10-15		
		● 10-15	● 10-15						● 10-15		
		● 15-20	● 15-20			● 15-20	● 15-20		● 15-20		15-20
o 10-15	o 10-15	● 15-20	● 15-20	o 10-15	o 10-15	● 15-20	● 15-20	o 10-15	● 15-20	o 10-15	15-20
		● 15-25	● 15-25						● 15-25		
o 10-15	o 10-15	● 15-25	● 15-25					o 10-15	● 15-25		
		● 15-25	● 15-25						● 15-25		
		● 15-25	● 15-25			● 15-25	● 15-25		● 15-25		● 15-25
● 10-20	● 10-20	● 15-25	● 15-25	● 10-20	● 10-20	● 15-25	● 15-25	● 10-20	● 15-25	● 10-20	● 15-25
o 10-15	o 10-15	o 12-18	o 12-18	o 10-15	o 10-15	o 12-18	o 12-18	o 10-15	o 12-18	o 10-15	o 12-18

● Optima / Optimun ○ Alternativo / Alternative

P	Aceros Aciers Steels	M	Aceros Inox Aciers Inox Stainless Steels	K	Fundicion Fonte Cast Iron	N	Metales no ferrosos Métal non Ferraux Non Ferrous metals	S	Titanio y Superaleaciones Titanium et Supealliages Titanium and Superalloys	H	Materiales Duros Materiels Durs Hard materials

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TABLA DE MATERIALES / TABLEAU DE MATÉRIAUX / TABLE OF MATERIALS

		Material	Matières
P Aceros / Aciers / Steels	P.1	Aceros blandos fácil mecanización	Aciers de décolletage
	P.2	Aceros de construcción	Aciers de construction
	P.3	Aceros baja aleación y cementación	Aciers de bas alliage et cementés
	P.4	Aceros aleados tratados o nitrurados	Aciers alliés traités et nitrurés
	P.5	Aceros tratados de alta aleación	Aciers traité du haute alliage
M Acero inoxidable / Acier inoxydable / Stainless steel	M.1	Ferríticos y martensíticos	Ferritiques et mastensitiques
	M.2	Austeníticos	Austénitiques
	M.3	Austeníticos- ferríticos (Dúplex)	Austénitiques-ferritiques (Dúplex)
	M.4	Austeníticos- ferríticos resistente a la calor (Super Dúplex)	Austénitiques-ferritiques résistants à la chaleur (Super Dúplex)
K Fundición / Fonte / Cast iron	K.1	Fundición gris con grafito laminar (GJL)	Fontes à graphite lamellaire (GJL)
	K.2	Fundición gris con grafito vermicular (GJV)	Fontes à graphite vermiculaire (GJV)
	K.3	Fundición gris maleable (GTMW,GJMB)	Fontes à malleábles (GTMW,GJMB)
	K.4.1	Fundición gris con grafito nodular (GJS)	Fontes à graphite sphéroïdal (GJS)
	K.4.2	Fundición gris tratada con grafito nodular (GJH,GJS-ADI)	Fontes traités à graphite sphéroidal (GJH,GJS-ADI)
N Materiales no férreos / Matériaux non ferreux / Non-ferrous materials	N.1.1	Aluminio no aleado y aleaciones forjables	Aluminium non allié et alliages corroyés
	N.1.2	Fundición de aluminio Si <12%	Fontes d'aluminium à Si<12%
	N.1.3	Fundición de aluminio Si >12%	Fontes d'aluminium à Si>12%
	N.2.1	Cobre puro o poco aleado	Cuivre pur et faiblement allié
	N.2.2	Aleaciones de cobre de viruta corta	Alliages de cuivre - copeau curt
	N.2.3	Aleaciones de cobre de viruta larga	Alliages de cuivre - copeau long
	N.2.4	Aleaciones de cobre de alta resistencia	Alliages de cuivre du haute résistance
	N.3.1	Aleaciones de magnesio y zinc	Alliages de magnésium et zinc
	N.4.1	Termoplásticos	Termoplastiques
	N.4.2	Duroplásticos	Duroplastiques
	N.4.3	Plásticos reforzados con fibras	Plastiques chargées en fibres
S Súper aleaciones / Super alliages / Super-alloys	S.1.1	Aleaciones de níquel y hierro	Alliages de nickel et fer
	S.1.2	Aleaciones de níquel y hierro	Alliages de nickel et fer
	S.2.1	Titanio puro	Titane pur
	S.2.2	Aleaciones de titanio tipo ∂	Alliages de titane ∂ type
	S.2.3	Aleaciones de titanio tipo ß	Alliages de titane ß type
H Materiales duros / Matiérs durs / Hardened steels	H.1	Aceros templados <50 HRc	Aciers traités <50 HRc
	H.2	Aceros templados <55 HRc	Aciers traités <55 HRc
	H.3	Aceros templados <60 HRc	Aciers traités <60 HRc

Materiales según norma ISO / Matériaux conformes à la norme ISO / Materials as per ISO

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Material	(N/mm2)	HB 30	HRC	Mat-Nr	DIN	AISI	UNE	Brand name
Free-machining steels	<600	<175		1.0722	10SPb20	1108	10S20	
Construction steels	<800	<240		1.0503	C45	1045	F114	
Low alloyed and case hardening steels	<1000	<300	<30	1.7225	42CrMo4	4140	F-1252	
Alloyed heat-treatable and nitriding steels	<1200	<360	<38	1.8159	51CrV4	6150	51CrV4	
High alloyed hardened steels	<1400	<430	<44	1.8523	40CrMoV13-9			
Ferritics and martensitics	<950	<285		1.4104	X14CrMoS17	430 F	F-3431	
Austenitics	<950	<285		1.4301	X5CrNi18-10	304	F-3551	
Austenitics-ferritics (Dúplex)	<1000	<300		1.4462	X2CrNiMoN22-5-3	2205		
Heat resistant austenitics-ferritics (Super Dúplex)	<1200	<360	<38	1.4410	X2CrNiMoN25-7-4	2507		
Cast iron with lamellar graphite (GJL)	<450	<130		0.6010	EN-GJL-100	A48-20 B	GG 10	
Cast iron with vermicular graphite (GJV)	<500	<150			EN-GJV-400			GGV 400
Malleable cast iron (GTMW,GJMB)	<800	<240		0.8045	EN-GJMW-450-7	MB 450-7	GTW 45	
Cast iron with nodular graphite (GJS)	<700	<210		0.7040	EN-GJS-400-15	60-40-18	GGG 40	GGG 40
Hardened cast iron with nodular graphite (GJS)	<1400	<430	<44		EN-GJS-1200-2			ADI 1200
Aluminium non alloyed and wrought alloys	<500	<150		3.2315	AlMgSi1		L-3451	ENAW-6082
Cast aluminium alloys Si<12%	<350	<100		3.2581	G-AlSi12	A 413.2		ENAC-44200
Cast aluminium alloys Si>12%	<450	<130			G-AlSi17Cu4Mg			ENAC-48100
Pure and low alloyed cooper	<400	<120		2.0065	E-Cu58			Cu-ETP
Cooper alloys - short chipping	<400	<120		2.0402	CuZn40Pb2 (Ms58)	C38500		Ms58
Cooper alloys - long chipping	<700	<210		2.0321	CuZn37 (Ms63)	C27200		Ms63
High strength cooper alloys	<1000	<300						AMPCO 45
Magnesium and zinc alloys	<500	<150			ZnAl4 (Z400)	AG40A		ZAMAK
Termoplastiques	<50							PVC
Hard plastics	<80							Baquelita
Fibre reinforced plastics	<200			GFK				GFK
Nickel and Iron alloys	<850	<255		2.4360	NiCu30Fe			Monel 400
Nickel and Iron alloys	<1400	<430	<44	2.4668	NiCr19FeNbMo			Inconel 718
Pure titanium	<700	<200		3.7025	Ti99.8			
Titanium alloys ∂ type	<900	<270		3.7165	Ti-6Al-4V	R56400		T-A6V
Titanium alloys ß type	<1200	<360	<38		Ti-10V-2Fe-3AL			
Hardened steel <50 HRc			<50					Hardox 500
Hardened steel <55 HRc			<55					Hardox 550
Hardened steel <60 HRc			<60					Hardox 600

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