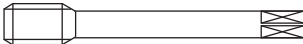
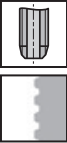
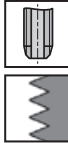
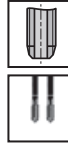
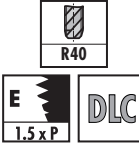
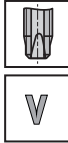
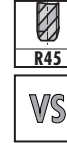


G

Directory — Machine taps G (BSP) DIN EN ISO 228

	N						
Merkmale Characteristics		 V	 TiN	 R40	 R40 V	 R40 TiN	 R40 V TiN
		 					
Lochart Hole type							
							
	N410-3	N420-4 N420V-4	N420TN-4	N460-3	N460V-3	N460TN-3	N462V-3
DIN lang DIN long	DIN 5156	204	205	205	206	206	206
DIN lang DIN long	~ DIN 376						
DIN kurz DIN short	DIN 5157						
LH Linksgewinde LH Left-hand thread	DIN 5156	204					

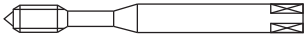
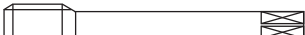
G Inhaltsverzeichnis — Maschinen- und Handgewindebohrer G (Rohr) DIN EN ISO 228 Directory — Machine and hand taps G (BSP) DIN EN ISO 228

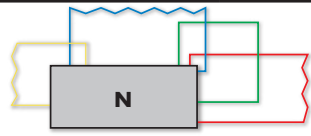
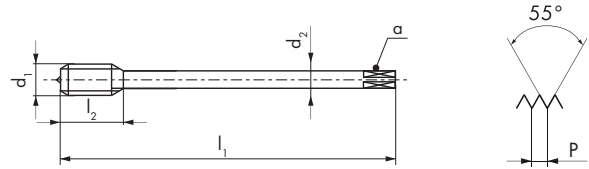
N			W		Z			
								
								
								
								
N210-1	N210-3	N210-S	W460-5	W460DL-5	Z420V-4	Z420VS-4	Z460V-3	Z470VS-3
			207	207	208	208	208	
								209
213	213	213						

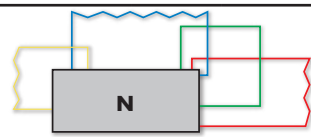
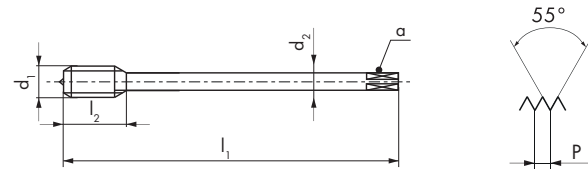
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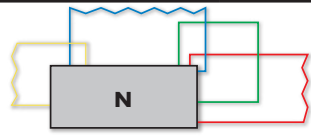
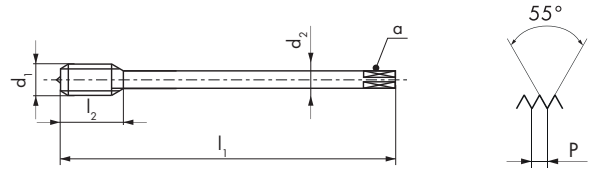
Directory — Machine taps G (BSP) DIN EN ISO 228

G

	N					
Merkmale Characteristics		 		 		HSS  
						
Lochart Hole type						
				N1110-3	N1120-4	
ISO kurz ISO short ISO 529				216 - 217	216	
W ISO 529				216 - 217	216	
SV ISO 529				217		
	N420-3	N410-3	D5800	N1210-3	N1220-4	N5120
DIN lang DIN long DIN 5156	214					
DIN lang DIN long DC		214	215			
ISO kurz ISO short ISO 529				216 - 217	216	
Rp DIN 5156	214					
Rc DC		214	215			
W ISO 529				216	216	
SV ISO 529 / DC				217		217

									N410-3	N410-3 LH		
N410-3  N410-3 LH  LH 31 62 73 74 91 31 62 73 74 91												
												
												
Ø" d ₁ G	P TPI	d ₁ mm	l ₁ mm	l ₂ mm	d ₂ mm	a mm			ID	ID		
1/8	28	9.72	90	22	7	5.5	3	8.75	● 101855			
1/4	19	13.15	100	20	11	9	3	11.6	● 101853	● 101854		
3/8	19	16.66	100	20	12	9	4	15.2	● 101861	● 101862		
1/2	14	20.95	125	22	16	12	4	18.9	● 101851	● 101852		
3/4	14	26.44	140	28	20	16	4	24.4	● 101859			
1	11	33.24	160	32	25	20	4	30.7	● 101857			
1 1/4	11	41.91	170	32	32	24	5	39.3	● 101850			
1 1/2	11	47.8	190	32	36	29	5	45.2	● 101849			

									N420-4	N420V-4	N420TN-4	
N420-4  626364727374 8191												
N420V-4  V 11123132												
N420TN-4  TiN 1112131432												
												
Ø" d ₁ G	P TPI	d ₁ mm	l ₁ mm	l ₂ mm	d ₂ mm	a mm			ID	ID	ID	
1/16	28	7.72	90	18	6	4.9	3	6.75	● 102045			
1/8	28	9.72	90	22	7	5.5	3	8.75	● 102048	● 102258	● 102236	
1/4	19	13.15	100	20	11	9	3	11.6	● 102047	● 102257	● 102235	
3/8	19	16.66	100	20	12	9	3	15.2	● 102053	● 102261	● 102238	
1/2	14	20.95	125	22	16	12	4	18.9	● 102046	● 102256	● 102234	
5/8	14	22.91	125	25	18	14.5	4	20.9	● 102054	● 144722		
3/4	14	26.44	140	28	20	16	4	24.4	● 102052	● 102260	● 102237	
1	11	33.24	160	32	25	20	4	30.7	● 102049	● 102259		
1 1/4	11	41.91	170	32	32	24	5	39.3	● 102043			
1 1/2	11	47.8	190	32	36	29	5	45.2	● 102042			
2	11	59.61	220	36	45	35	5	57	● 102051			
2 1/2	11	75.18	280	36	50	39	6	72.6	● 102050			

									N460-3	N460V-3	N460TN-3	N462V-3
N460-3  												
N460V-3   												
N460TN-3   												
N462V-3   												
												
Ø" d ₁ G	P TPI	d ₁ mm	l ₁ mm	l ₂ mm	d ₂ mm	a mm			ID	ID	ID	ID
1/16	28	7.72	90	12.5	6	4.9	3	6.75	● 102341			
1/8	28	9.72	90	14	7	5.5	3	8.75	● 102344	● 102457	● 102444	● 143687
1/4	19	13.15	100	14	11	9	3	11.6	● 102343	● 102456	● 102443	● 143600
3/8	19	16.66	100	14	12	9	4	15.2	● 102348	● 102460	● 102446	● 143431
1/2	14	20.95	125	20	16	12	4	18.9	● 102342	● 102455	● 102442	● 143921
5/8	14	22.91	125	20	18	14.5	4	20.9	● 102349	● 143711		
3/4	14	26.44	140	22	20	16	4	24.4	● 102347	● 102459	● 102445	● 143688
1	11	33.24	160	26	25	20	4	30.7	● 102345	● 102458		
1 1/4	11	41.91	170	30	32	24	5	39.3	● 102340	● 111608		
1 1/2	11	47.8	190	35	36	29	5	45.2	● 102339	● 111609		
2	11	59.61	220	41	45	35	6	57	● 102346	● 111503		

G DIN EN ISO 228 (BSP)

≤ Ø 25.4 > Ø 25.4

HSSE
W

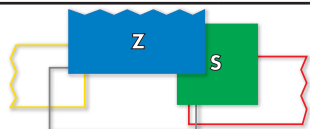
PM
H/GG

HSSE
H/GG



									W460-5	W460DL-5	H450-3	GG450NV-3
W460-5 71 72 81												
W460DL-5 71 72 73												
H450-3 15 16 62 64 82												
GG450NV-3 31												
Ø" d ₁ G	P TPI	d ₁ mm	l ₁ mm	l ₂ mm	d ₂ mm	a mm			ID	ID	ID	ID
1/8	28	9.72	90	14	7	5.5	3	8.75	● 119350	● 176728	● 101298	
1/4	19	13.15	100	14	11	9	* 4	11.6	● 119300	● 176729	● 101297	
3/8	19	16.66	100	14	12	9	4	15.2	● 119682	● 176730	● 101301	
1/2	14	20.95	125	20	16	12	4	18.9	● 119199	● 176731	● 101296	
3/4	14	26.44	140	22	20	16	4	24.4			● 101300	
1	11	33.24	160	26	25	20	4	30.7			● 101299	
* W460-5 = 3 * W460DL-5 = 3												
Ø" d ₁ G	P TPI	d ₁ mm	l ₁ mm	l ₂ mm	d ₂ mm	a mm			ID			
1/8	28	9.72	90	22	7	5.5	4	8.75			● 102309	
1/4	19	13.15	100	20	11	9	4	11.6			● 102308	
3/8	19	16.66	100	20	12	9	4	15.2			● 102312	
1/2	14	20.95	125	22	16	12	4	18.9			● 102307	
3/4	14	26.44	140	28	20	16	4	24.4			● 102311	
1	11	33.24	160	32	25	20	4	30.7			● 102310	

									Z420V-4	Z420VS-4	Z460V-3	
Z420V-4 V 11121321 32 Z420VS-4 VS 11121314 21222332 616394 Z460V-3 V 122132												
Ø" d ₁ G	P TPI	d ₁ mm	l ₁ mm	l ₂ mm	d ₂ mm	a mm			ID	ID		
1/8	28	9.72	90	22	7	5.5	3	8.75	● 142794	● 142800		
1/4	19	13.15	100	20	11	9	3	11.6	● 142795	● 119303		
3/8	19	16.66	100	20	12	9	3	15.2	● 142796	● 142802		
1/2	14	20.95	125	22	16	12	4	18.9	● 142797	● 142803		
3/4	14	26.44	140	28	20	16	4	24.4	● 142798			
1	11	33.24	160	32	25	20	4	30.7	● 142799			
Ø" d ₁ G	P TPI	d ₁ mm	l ₁ mm	l ₂ mm	d ₂ mm	a mm			ID			
1/8	28	9.72	90	14	7	5.5	3	8.75	● 104726			
1/4	19	13.15	100	14	11	9	3	11.6	● 104725			
3/8	19	16.66	100	14	12	9	4	15.2	● 104728			
1/2	14	20.95	125	20	16	12	4	18.9	● 104724			
3/4	14	26.44	140	22	20	16	4	24.4	● 104727			
1	11	33.24	160	26	25	20	4	30.7	● 105142			



Z470VS-3



VS



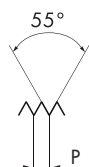
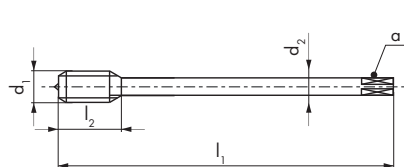
Z470VS-3



VS



Z470VS-3



Ø" d ₁ G	P TPI	d ₁ mm	l ₁ mm	l ₂ mm	d ₂ h ₆ mm	a mm		
1/8	28	9.72	100	14	* 8	* 6.2	3	8.75
1/4	19	13.15	110	14	* 12	* 9	4	11.6
3/8	19	16.66	110	18	12	9	4	15.2
1/2	14	20.95	125	20	16	12	4	18.9

* Norme DC / * DC Norm/ * Norma DC

ID

- 165198
- 165199
- 165200
- 165201

QTAP

Q420VS-4



VS

Q423VS-4



VS



Q420VS-4

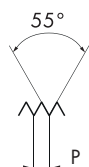
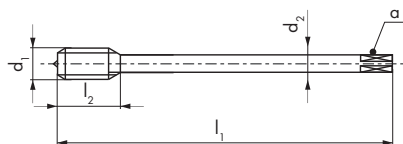
Q423VS-4



NEW



NEW



$\frac{\text{Ø}''}{G}$	d_1	P	d_1	l_1	l_2	d_2	a		
TPI	mm	mm	mm	mm	mm	mm	mm		
1/8	28	9.72	90	22	7	5.5	3	8.75	
1/4	19	13.15	100	20	11	9	3	11.6	
3/8	19	16.66	100	20	12	9	3	15.2	
1/2	14	20.95	125	22	16	12	4	18.9	

ID

ID

● 196312	● 197645
● 196313	● 197646
● 196314	● 197647
● 196315	● 197648

QTAP

Q460VS-3



VS

Q463VS-3



VS



Q460VS-3

Q463VS-3



NEW



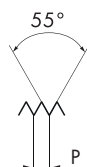
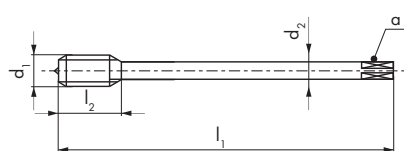
NEW



< 2.5 x D



< 2.5 x D



2.5 x P



2.5 x P

Ø" d ₁ G	P TPI	d ₁ mm	l ₁ mm	l ₂ mm	d ₂ mm	a mm		
1/8	28	9.72	90	14	7	5.5	3	8.75
1/4	19	13.15	100	14	11	9	3	11.6
3/8	19	16.66	100	14	12	9	4	15.2
1/2	14	20.95	125	20	16	12	4	18.9

ID

ID

● 196316	● 197649
● 196317	● 197650
● 196318	● 197651
● 196319	● 197652



Uniquement pour taraudage synchrone
Nur für Synchronbearbeitung
Only for rigid tapping
Solo per maschiatura sincrona
Solo para roscado sincronizado
Только для rigid tapping

PM



RTS

Rigid Tapping Synchro

RTS462VS-3



VS

RTS462VS-5

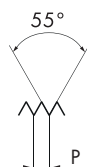
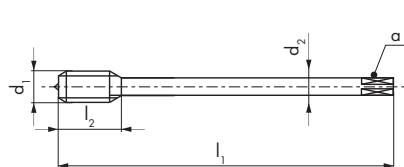


VS



RTS462VS-3

RTS462VS-5



Ø" d ₁ G	P TPI	d ₁ mm	l ₁ mm	l ₂ mm	d ₂ h6 mm	a mm		
1/8	28	9.72	100	14	* 8	* 6.2	3	8.75
1/4	19	13.15	110	14	* 12	* 9	3	11.6
3/8	19	16.66	110	18	12	9	4	15.2
1/2	14	20.95	125	20	16	12	4	18.9

* Norme DC / * DC Norm/ * Norma DC

ID

ID

- 151861 ● 170629
- 151868 ● 170631
- 151872 ● 170633
- 150685 ● 170635



sur demande
auf Anfrage
on request
su richiesta
sobre pedido
по запросу

G DIN EN ISO 228 (BSP)

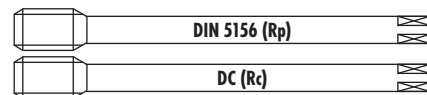
HSSE

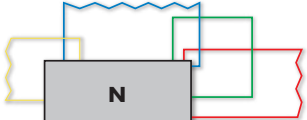
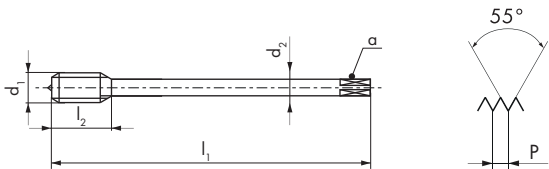


										N210-1	N210-3	N210-S	
N210-1													
N210-3													
N210-S													
$\frac{\text{Ø''}}{G}$	P TPI	d_1 mm	l_1 mm	l_2 mm	d_2 mm	a mm				ID	ID	ID	
1/16	28	7.72	63	18	6	4.9	3	6.75		● 101418			
1/8	28	9.72	63	22	7	5.5	3	8.75	● 101404	● 101421	● 119386		
1/4	19	13.15	70	20	11	9	3	11.6	● 101403	● 101420	● 119336		
3/8	19	16.66	70	20	12	9	4	15.2	● 101409	● 101427	● 110938		
1/2	14	20.95	80	22	16	12	4	18.9	● 101402	● 101419	● 119264		
5/8	14	22.91	80	25	18	14.5	4	20.9	● 101411	● 105140	● 110940		
3/4	14	26.44	90	28	20	16	4	24.4	● 101408	● 101426	● 110937		
1	11	33.24	100	32	25	20	4	30.7	● 101405	● 101422	● 110933		
1 1/8	11	37.89	125	32	28	22	4	35.3		● 101415			
1 1/4	11	41.91	125	32	32	24	5	39.3	● 101400	● 101414	● 111425		
1 1/2	11	47.8	140	32	36	29	5	45.2	● 101399	● 101413	● 110934		
2	11	59.61	160	36	45	35	5	57	● 101407	● 101425	● 110935		
2 1/2	11	75.18	160	36	50	39	6	72.6		● 101423			

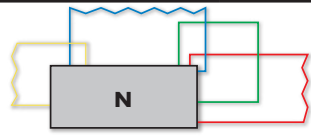
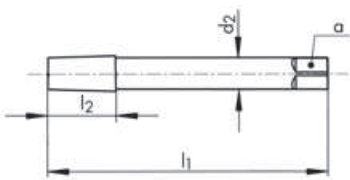
Rp, Rc DIN EN 10226

HSSE



										N420-3			N410-3	
N420-3  626364727374 8191														
N410-3  316274														  1:16
										 2.5 x P				 2 x P
Ø" d ₁ Rp	P TPI	d ₁ mm	l ₁ mm	l ₂ mm	d ₂ mm	a mm			ID					
1/8	28	9.72	90	22	7	5.5	3	8.6	● 104911					
1/4	19	13.15	100	20	11	9	3	11.5	● 104912					
3/8	19	16.66	100	20	12	9	3	15	● 104913					
1/2	14	20.95	125	22	16	12	4	18.5	● 104914					
3/4	14	26.44	140	28	20	16	4	24	● 104915					
1	11	33.24	160	32	25	20	4	30.25	● 104916					
Ø" d ₁ Rc	P TPI	d ₁ mm	l ₁ mm	l ₂ mm	d ₂ mm	a mm			ID					
1/8	28	9.72	71	13	8	6.2	5		● 104917					
1/4	19	13.15	80	20	11	9	5		● 104918					
3/8	19	16.66	90	20	12	9	5		● 104919					
1/2	14	20.95	100	26	16	12	5		● 104920					
3/4	14	26.44	110	26	20	16	5		● 104921					
1	11	33.24	125	32	25	20	5		● 104922					

Vc (m/min) Ø d1 - Guide Line				
Rc	1/16" - 1/4"	3/8" - 1/2"	3/4" - 1"	1.1/4" - 2"
	10	8	7	5
	18	15	13	10

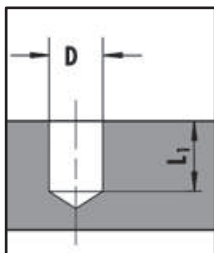
					D5800			
D5800 								
								
Ø" Rc	l ₁ mm	l ₂ mm	d ₂ mm	a mm	ID			
1/16	70	17	6	4.9	● 118701			
1/8	70	17	8	6.2	● 110531			
1/4	80	27	10	8	● 110530			
3/8	85	27	12	9	● 110535			
1/2	95	35	16	12	● 110529			
3/4	105	35	20	16	● 110534			
1	130	43	25	20	● 110532			

Kernloch-Durchmesser für kegeliges Rohrgewinde nach DIN EN 10226

Core hole diameters for tapered pipe thread to DIN EN 10226

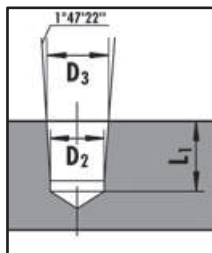
Bohrung zylindrisch
Vermeiden, da schnellere
Abnutzung des Gewindebohrers
und Klemmen

Parallel hole
Increased tap wear,
not recommended



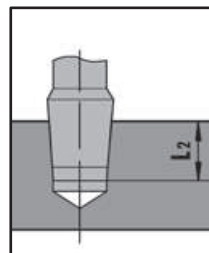
Bohrung konisch 1:16
Zylindrisch bohren nach Ø D₂
und konisch aufreiben auf Ø D₃

Tapered hole 1:16
Pre-drill at Ø D₂
and taper-ream to Ø D₃



Gewindeschneiden
Gewindebohrer auf Nennmass
L₂ eindrehen

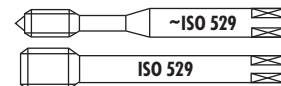
Tapped hole
Engage tap to hole depth
L₂ = nominal Ø



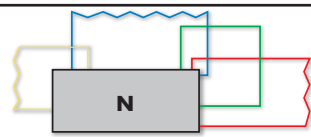
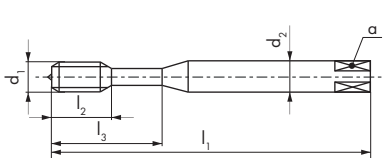
Ø" Rc	l ₁ min. mm	D ₁ mm	D ₂ mm	D ₃ mm	l ₂ mm
1/16	11.9	6.2	6.1	6.56	10.6
1/8	11.9	8.2	8.1	8.57	10.6
1/4	17.7	11	10.75	11.45	15.7
3/8	18.1	14.5	14.25	14.95	16.1
1/2	24	18	17.75	18.63	21.4
3/4	25.3	23.5	23	24.12	21.5
1	30.6	29.5	29	30.29	26.3

W BS 84 (BSW)

HSS



										N1110-3	N1210-3	N1120-4	N1220-4
N1110-3 31 62 73 74 91													
N1210-3 31 62 73 74 91													
N1120-4 62 63 64 72 73 74 81 91													
N1220-4 62 63 64 72 73 74 81 91													
Ø" d ₁ W	P TPI	d ₁ mm	l ₁ mm	l ₂ mm	l ₃ mm	d ₂ mm	a mm			ID	ID	ID	ID
1/8	40	3.17	48	11	18	3.15	2.5	3	2.5	• 103025		• 103126	
5/32	32	3.96	53	13	21	4	3.15	3	3.1	• 103031		• 103130	
3/16	24	4.76	58	16	25	5	4	3	3.6	• 103026		• 103127	
1/4	20	6.35	66	19	30	6.3	5	3	4.9	• 103024		• 103125	
5/16	18	7.93	72	22	35	8	6.3	3	6.4	• 103030		• 103129	
3/8	16	9.52	80	24	39	10	8	3	7.7	• 103028		• 103128	
7/16	14	11.11	85	22		8	6.3	3	9.1		• 103642		• 103771
1/2	12	12.7	89	24		9	7.1	3	10.3		• 103634		• 103767
5/8	11	15.87	102	32		12.5	10	3	13.3		• 103641		• 103770
3/4	10	19.05	112	33		14	11.2	3	16.2		• 103640		• 103769

										N1110-3		N1210-3		N5120			
N1110-3  31 62 73 74 91 N1210-3  31 62 73 74 91 N5120  ≥ Ø 3 11 12																	
										 < 1.5 x D		 < 1.5 x D					
 W = 55° SV = 45°/5°										 C 2 x P		 C 2 x P		 1.75 x P			
Ø d₁ W P TPI/mm B6 58 16 25 d₂ mm 4 mm   4.3*										ID							
5										● 103029							
6.82										● 111143							
Ø d₁ SV P mm W10 80 24 39 d₂ mm 8 mm   * 8.9										ID		ID					
10										● 130429							
12												● 103591					
15												● 103592					
20												● 103593					
25												● 103594					