

15110

Hexagon Rethreading Dies DIN 382

M **6g** **HSS** 











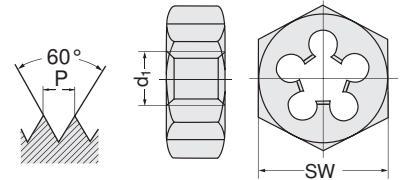
Type
Right-hand cut, starting taper approx. 1,75 turns.
Use
For metric ISO coarse-pitch thread DIN 13. Mainly

for recutting and dressing of damaged threads.
For materials to approx. 800 N/mm² strength.
Quality
HSS.

15110

d ₁	P mm	AF mm	15110	...
M 3	0,50	18		101
M 4	0,70	18		103
M 5	0,80	18		104
M 6	1,00	18		105
M 8	1,25	21		106
M 10	1,50	27		107
M 12	1,75	36		108
M 14	2,00	36		109
M 16	2,00	41		110

d ₁	P mm	AF mm	15110	...
M 18	2,50	41		111
M 20	2,50	41		112
M 22	2,50	50		113
M 24	3,00	50		114
M 27	3,00	60		115
M 30	3,50	60		116
M 33	3,50	60		117
M 36	4,00	60		118



15112

Hexagon Rethreading Dies DIN 382







G **6g** **HSS** 








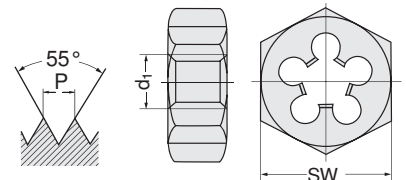
Type
Right-hand cut, starting taper approx. 1,75 turns.
Use
For cylindrical Whitworth pipe threads DIN ISO 228.

Mainly for recutting and dressing of damaged threads. For materials to approx. 800 N/mm² strength.
Quality
HSS.

15112

d ₁	P tpi	AF mm	15112	...
G 1/8	28	27		101
G 1/4	19	36		102
G 3/8	19	41		103
G 1/2	14	41		104
G 3/4	14	50		106
G 1	11	60		108

d ₁	P tpi	AF mm	15112	...
G 1.1/8	11	70		109
G 1.1/4	11	70		110
G 1.1/2	11	85		112
G 1.3/4	11	100		114
G 2	11	100		116



15203 - 15204

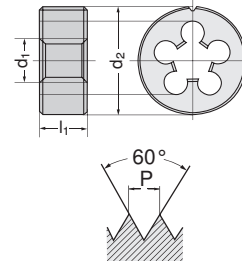
Round Dies DIN EN 22 568

M **6g** **HSS** 






Type
Solid type (pre-slit), starting at M3 with curling cut chamfer for an especially easy, clean cut and an improved surface quality. Right-hand cut. **Tolerance zone: up to M 1,4 6h, above that 6g, above that 6g.** Rake angle 15 - 20°, chamfer approx. 1,75 turns.
Use
For metric ISO coarse-pitch thread DIN 13. For machining standard-duty materials with a strength of up to approx. 800 N/mm².
Quality
HSS.

























15203
ATORN®
15203 501-507
With same outside diameter (25 x 9 mm).
For tap and die set cat. no. 14960 101.

15203



15204
H+W

d ₁	P mm	d ₂ x l ₁ mm	15203	...	15204	...
M 1	0,25	16 x 5		201		
M 1,1	0,25	16 x 5		202		
M 1,2	0,25	16 x 5		203		
M 1,4	0,30	16 x 5		204		
M 1,6	0,35	16 x 5		205		
M 1,8	0,35	16 x 5		207		
M 2	0,40	16 x 5		208		
M 2,2	0,45	16 x 5		209		
M 2,5	0,45	16 x 5		211		
M 3	0,50	20 x 5		213		103
M 3,5	0,60	20 x 5		214		
M 4	0,70	20 x 5		215		104
M 4,5	0,75	20 x 7		216		
M 5	0,80	20 x 7		217		105
M 6	1,00	20 x 7		218		106
M 7	1,00	25 x 9		219		
M 8	1,25	25 x 9		220		107
M 9	1,25	25 x 9		221		
M 10	1,50	30 x 11		222		108
M 11	1,50	30 x 11		223		

d ₁	P mm	d ₂ x l ₁ mm	15203	...	15204	...
M 12	1,75	38 x 14		224		109
M 14	2,00	38 x 14		225		110
M 16	2,00	45 x 18		226		111
M 18	2,50	45 x 18		227		112
M 20	2,50	45 x 18		228		113
M 22	2,50	55 x 22		229		
M 24	3,00	55 x 22		230		
M 27	3,00	65 x 25		231		
M 30	3,50	65 x 25		232		
M 33	3,50	65 x 25		233		
M 36	4,00	65 x 25		234		
M 39	4,00	75 x 30		235		
M 42	4,50	75 x 30		236		
M 3	0,50	25 x 9		501		
M 4	0,70	25 x 9		502		
M 5	0,80	25 x 9		503		
M 6	1,00	25 x 9		504		
M 10	1,50	25 x 9		506		
M 12	1,75	25 x 9		507		

Round dies

15205 Thread-Cutting Die Set

M 6g HSS $\leq 750 \text{ N/mm}^2$



Type
 Contents: 7 round dies metric M 3 - M 12 (25 x 9),
 1 round die holder in compliance with DIN 225 with
 chrome-plated handles. In lacquered metal box.
Use
 For metric ISO coarse-pitch thread DIN 13.

Quality
 HSS.



15205

Contents	15205	...
8-part		101

15206 Round Dies DIN EN 22 568

M 6g HSS $\leq 850 \text{ N/mm}^2$



Type
 Solid type (pre-slit), with curling cut chamfer for
 an especially easy, clean cut and an improved
 surface quality. Right-hand cut. **Tolerance zone**
ISO 6g. Chamfer approx. 1.1/2 turns.

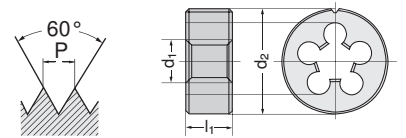
Use
 For metric ISO coarse-pitch thread DIN 13.
 For materials to approx. 850 N/mm² strength.
Quality
 HSS.

d ₁	P mm	d ₂ x l ₁ mm	15206	...
M 3	0,50	20 x 5		213
M 4	0,70	20 x 5		215
M 5	0,80	20 x 7		217
M 6	1,00	20 x 7		218
M 8	1,25	25 x 9		220

d ₁	P mm	d ₂ x l ₁ mm	15206	...
M 10	1,50	30 x 11		222
M 12	1,75	38 x 14		224
M 16	2,00	45 x 18		226
M 20	2,50	45 x 18		228



15206

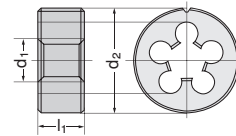


15207 - 15208 Round Dies DIN EN 22 568

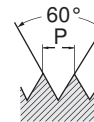
M 6g HSS-E $\leq 1200 \text{ N/mm}^2$ $\leq 1100 \text{ N/mm}^2$

Type
 Solid type (pre-slit), with curling cut chamfer for
 an especially easy, clean cut and an improved
 surface quality. Right-hand cut.
Tolerance zone ISO 6g. Chamfer approx. 2 turns.
Use
 For metric ISO coarse-pitch thread DIN 13.
 For materials that are difficult to machine to
 approx. 850-1200 N/mm² strength, rust-resistant
 and acid-resistant steels (VA-steel).
Quality
 HSS-E (cat.-no. 15207, starting at M3, nitrided).

15207
ATORN[®]
 Swarf angle 10 - 15°.
 15208
EMUGE



15207



d ₁	P mm	d ₂ x l ₁ mm	ATORN [®]		EMUGE	
			15207	...	15208	...
M 2	0,40	16 x 5		101		
M 2,5	0,45	16 x 5		104		
M 3	0,50	20 x 5		106		106
M 4	0,70	20 x 5		108		108
M 5	0,80	20 x 7		109		109
M 6	1,00	20 x 7		110		110

d ₁	P mm	d ₂ x l ₁ mm	ATORN [®]		EMUGE	
			15207	...	15208	...
M 8	1,25	25 x 9		112		112
M 10	1,50	30 x 11		113		113
M 12	1,75	38 x 14		114		114
M 16	2,00	45 x 18		116		116
M 20	2,50	45 x 18		118		
M 24	3,00	55 x 22		120		

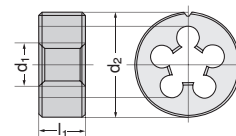
15211 Round Dies, Left-Hand Cutting DIN EN 22 568

M 6g HSS $\leq 800 \text{ N/mm}^2$

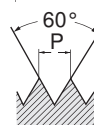


Type
 Solid type (pre-slit), with curling cut chamfer for
 an especially easy, clean cut and an improved
 surface quality. **Tolerance zone 6g**. Rake angle
 approx. 15° - 20°, chamfer approx. 1,75 turns.
Use
 For metric ISO coarse-pitch thread DIN 13.
 For materials to approx. 800 N/mm².

Quality
 HSS.



15211



d ₁	P mm	d ₂ x l ₁ mm	15211	...
M 3	0,50	20 x 5		101
M 4	0,70	20 x 5		102
M 5	0,80	20 x 7		103
M 6	1,00	20 x 7		104
M 8	1,25	25 x 9		105

d ₁	P mm	d ₂ x l ₁ mm	15211	...
M 10	1,50	30 x 11		106
M 12	1,75	38 x 14		107
M 14	2,00	38 x 14		108
M 16	2,00	45 x 18		109
M 18	2,50	45 x 18		110

d ₁	P mm	d ₂ x l ₁ mm	15211	...
M 20	2,50	45 x 18		111
M 22	2,50	55 x 22		112
M 24	3,00	55 x 22		113



15219 - 15221

Round Dies DIN EN 22 568



Type
Solid type (pre-slit), with curling cut chamfer for an especially easy, clean cut and an improved surface quality. Right-hand cut.

Tolerance zone 6g. Rake angle 15 - 20°, chamfer 1,75 turns.

Use
For metric ISO fine threads DIN 13.

15221
HFW
For materials, steel with a strength of up to approx. 800 N/mm².

Quality
HSS.



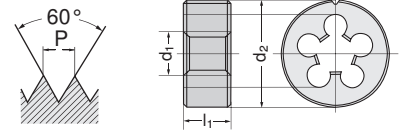
15220

15220
ATORN®
For materials to approx. 800 N/mm² strength.

Quality
HSS.

15219
ATORN®
For materials that are difficult to machine to approx. 850-1200 N/mm² strength, rust-resistant and acid-resistant steels (VA-steel).

Quality
HSS-E.



d ₁ x P mm	d ₂ x l ₁ mm	ATORN®		HFW		ATORN®	
		15220	...	15221	...	15219	...
M 3 x 0,35	20 x 5	104					
M 3,5 x 0,35	20 x 5	105					
M 4 x 0,35	20 x 5	106					
M 4 x 0,50	20 x 5	107					
M 5 x 0,50	20 x 5	108					108
M 6 x 0,50	20 x 5	109					
M 6 x 0,75	20 x 7	110					110
M 7 x 0,75	25 x 9	111					
M 8 x 0,50	25 x 9	112					
M 8 x 0,75	25 x 9	113					113
M 8 x 1,00	25 x 9	114		214			
M 9 x 1,00	25 x 9	115					
M 10 x 0,75	30 x 11	116					
M 10 x 1,00	30 x 11	117		217			117
M 10 x 1,25	30 x 11	118		218			
M 11 x 1,00	30 x 11	119					
M 12 x 1,00	38 x 10	120		220			120
M 12 x 1,25	38 x 10	121		221			
M 12 x 1,50	38 x 10	122		222			121
M 14 x 1,00	38 x 10	123		223			
M 14 x 1,25	38 x 10	124		224			
M 14 x 1,50	38 x 10	125		225			125
M 15 x 1,00	38 x 10	126					
M 15 x 1,50	38 x 10	127					
M 16 x 1,00	45 x 14	128		228			
M 16 x 1,50	45 x 14	129		229			129
M 18 x 1,00	45 x 14	130					
M 18 x 1,50	45 x 14	131		231			131
M 18 x 2,00	45 x 14	132					
M 20 x 1,00	45 x 14	133		233			

d ₁ x P mm	d ₂ x l ₁ mm	ATORN®		HFW		ATORN®	
		15220	...	15221	...	15219	...
M 20 x 1,50	45 x 14	134		234			134
M 20 x 2,00	45 x 14	135					
M 22 x 1,00	55 x 16	136					
M 22 x 1,50	55 x 16	137		237			137
M 22 x 2,00	55 x 16	138					
M 24 x 1,00	55 x 16	139					
M 24 x 1,50	55 x 16	140		240			140
M 24 x 2,00	55 x 16	141					
M 25 x 1,50	55 x 16	142					
M 26 x 1,50	55 x 16	143					
M 27 x 1,50	65 x 18	144					
M 27 x 2,00	65 x 18	145					
M 28 x 1,50	65 x 18	146					
M 30 x 1,00	65 x 18	147					
M 30 x 1,50	65 x 18	148					148
M 30 x 2,00	65 x 18	149					
M 32 x 1,50	65 x 18	150					
M 33 x 1,50	65 x 18	151					
M 33 x 2,00	65 x 18	152					
M 34 x 1,50	65 x 18	153					
M 36 x 1,50	65 x 18	154					
M 36 x 2,00	65 x 18	155					
M 36 x 3,00	65 x 25	156					
M 38 x 1,50	75 x 20	157					
M 40 x 1,50	75 x 20	158					
M 42 x 1,50	75 x 20	159					
M 45 x 1,50	90 x 22	160					
M 48 x 1,50	90 x 22	161					
M 50 x 1,50	90 x 22	162					
M 52 x 1,50	90 x 22	163					

15222

Round Dies DIN EN 22 568



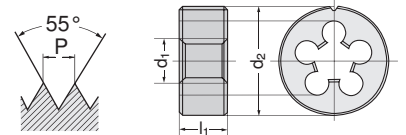
ATORN®
Type
Solid type (pre-slit), with curling cut chamfer for an especially easy, clean cut and an improved surface quality. Right-hand cut, starting taper approx. 1,75 turns.

Use
For Whitworth threads BS 84. For materials, steel with a strength of up to approx. 800 N/mm².

Quality
HSS.



15222



d ₁	P tpi	d ₂ x l ₁ mm	15222	...
BSW 1/8	40	20 x 5	101	
BSW 3/16	24	20 x 7	102	
BSW 1/4	20	20 x 7	103	
BSW 5/16	18	25 x 9	104	

d ₁	P tpi	d ₂ x l ₁ mm	15222	...
BSW 3/8	16	30 x 11	105	
BSW 1/2	12	38 x 14	106	
BSW 5/8	11	45 x 18	107	
BSW 3/4	10	45 x 18	108	

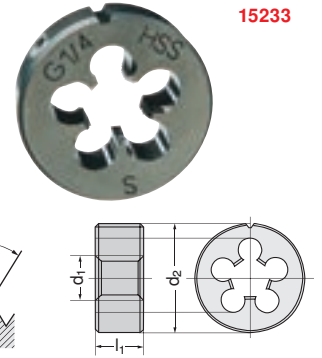
d ₁	P tpi	d ₂ x l ₁ mm	15222	...
BSW 7/8	9	55 x 22	109	
BSW 1	8	55 x 22	110	

Round dies

15233 - 15234 Round Dies DIN EN 24 231 G HSS $\leq 800 \text{ N/mm}^2$

Type
Solid type (pre-slit), with curling cut chamfer for an especially easy, clean cut and an improved surface quality. Right-hand cut, starting taper approx. 1,75 turns.

Use
For cylindrical Whitworth pipe threads DIN ISO 228. For materials to approx. 800 N/mm² strength.
Quality
HSS.



d ₁	P tpi	d ₂ x l ₁ mm	ATORN [®]		HFW	
			15233	...	15234	...
G 1/8	28	30 x 11		101		101
G 1/4	19	38 x 10		102		102
G 3/8	19	45 x 14		103		103
G 1/2	14	45 x 14		104		104
G 5/8	14	55 x 16		105		

d ₁	P tpi	d ₂ x l ₁ mm	ATORN [®]		HFW	
			15233	...	15234	...
G 3/4	14	55 x 16		106		106
G 7/8	14	65 x 18		107		
G 1	11	65 x 18		108		108
G 1.1/4	11	75 x 20		109		
G 1.1/2	11	90 x 22		111		

15314 - 15316 Round Dies DIN EN 22 568 UNC UNF HSS $\leq 800 \text{ N/mm}^2$

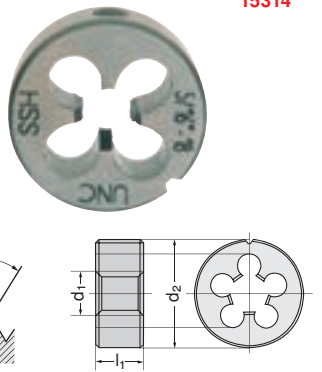
ATORN[®]

Type
Solid type (pre-slit), starting at UNC/UNF no. 5 with curling cut chamfer for an especially easy, clean cut and an improved surface quality. Right-hand cut. Chamfer approx. 1,75 turns.

Use
For unified coarse threads UNC and unified fine threads UNF. For materials to approx. 800 N/mm² strength.
Quality
HSS.

15314
Type
Unified coarse threads UNC.

15316
Type
Unified fine threads UNF.



d ₁	P tpi	d ₂ x l ₁ mm	UNC	
			15314	...
No. 1	64	16 x 5		102
No. 2	56	16 x 5		103
No. 3	48	16 x 5		104
No. 4	40	16 x 5		105
No. 5	40	20 x 5		106
No. 6	32	20 x 7		107
No. 8	32	20 x 7		108
No. 10	24	20 x 7		109
No. 12	24	20 x 7		110
1/4	20	20 x 7		111
5/16	18	25 x 9		112
3/8	16	30 x 11		113
7/16	14	30 x 11		114
1/2	13	38 x 14		115
9/16	12	38 x 14		116
5/8	11	45 x 18		117
3/4	10	45 x 18		118
7/8	9	55 x 22		119
1	8	55 x 22		120

d ₁	P tpi	d ₂ x l ₁ mm	UNF	
			15316	...
No. 0	80	16 x 5		101
No. 1	72	16 x 5		102
No. 2	64	16 x 5		103
No. 3	56	16 x 5		104
No. 4	48	16 x 5		105
No. 5	44	20 x 5		106
No. 6	40	20 x 7		107
No. 8	36	20 x 7		108
No. 10	32	20 x 7		109
No. 12	28	20 x 7		110
1/4	28	20 x 7		111
5/16	24	25 x 9		112
3/8	24	30 x 11		113
7/16	20	30 x 11		114
1/2	20	38 x 10		115
9/16	18	38 x 10		116
5/8	18	45 x 14		117
3/4	16	45 x 14		118
7/8	14	55 x 16		119
1	12	55 x 16		120