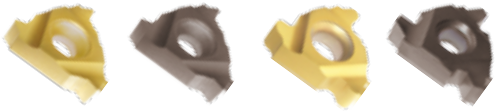
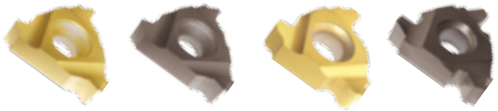
Gewindewerkzeuge
Threading Tools
6

... Qualität schafft Vertrauen

Inhaltsverzeichnis *Contents*

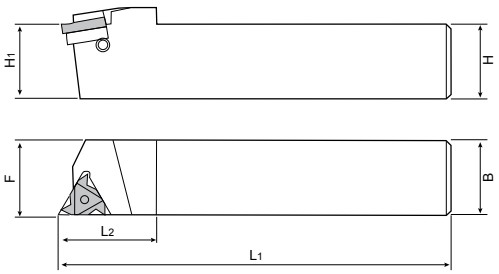
Gewindewerkzeuge
Threading Tools

	Seite *Page*
Klemmhalter zum Außen-Gewindedrehen *Toolholders for External Threading*	**6.04**
Klemmhalter zum Innen-Gewindedrehen *Toolholders for Internal Threading*	**6.05**
Wendeschneidplatten für Außen - Gewindedrehen *Indexable Inserts for External Threading* 	
Präzisions-Einstechen Außen/Innen *Grooving External/Internal*	**6.06**
Teilprofil, rechts und links, außen/innen **60°** *Partial Profile, right and left, external/internal 60°*	**6.07**
Teilprofil, rechts und links, außen/innen **55°** *Partial Profile, right and left, external/internal 55°*	**6.08**
Vollprofil, rechts und links, **ISO 60°** *Full Profile, right and left, ISO 60°*	**6.09**
Vollprofil, rechts und links, **BSW 55°** *Full Profile, right and left, BSW 55°*	**6.10**
Vollprofil, rechts und links, **UN 60°** *Full Profile, right and left, UN 60°*	**6.11**
Vollprofil, rechts und links, **RD DIN 405** *Full Profile, right and left, RD DIN 405*	**6.12**
Vollprofil, rechts und links, **TR DIN 103** *Full Profile, right and left, TR DIN 103*	**6.12**
Vollprofil, rechts und links, **ACME** *Full Profile, right and left, ACME*	**6.13**
Vollprofil, rechts und links, **NPT 60°** *Full Profile, right and left, NPT 60°*	**6.13**

	Seite *Page*
Wendeschneidplatten für Innen - Gewindedrehen *Indexable Inserts for Internal Threading* 	
Vollprofil, rechts und links, **ISO 60°** *Full Profile, right and left, ISO 60°*	**6.14**
Vollprofil, rechts und links, **BSW 55°** *Partial Profile, right and left, BSW 55°*	**6.16**
Vollprofil, rechts und links, **UN 60°** *Full Profile, right and left, UN 60°*	**6.17**
Vollprofil, rechts und links, **RD DIN 405** *Full Profile, right and left, RD DIN 405*	**6.18**
Vollprofil, rechts und links, **TR DIN 103** *Full Profile, right and left, TR DIN* 103	**6.18**
Vollprofil, rechts und links, **ACME** *Full Profile, right and left, ACME*	**6.19**
Vollprofil, rechts und links, **NPT 60°** *Full Profile, right and left, NPT 60°*	**6.19**
Anwendungshinweise *Applications Advices*	**6.20**
Schnittdaten-Empfehlungen Cutting Data Recommendations	**6.22**
Gewindebohrwerkzeuge *Machine Taps*	**6.23**
Gewindedrehen - Technische Information *Threading - Technical Information*	**6.21**
Unterschiede zwischen Voll- und Teilprofil-Gewindeschneidplatten *Differences between Full and Partial Profile Threading Inserts*	**6.22**

AL NL

zum Außen-Gewindedrehen ***for External Threading***

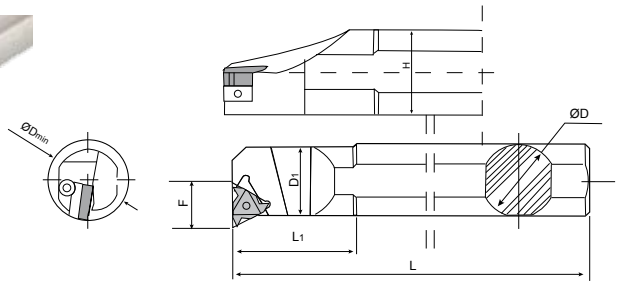


Bezeichnung *Part Number* Rechter Halter *RH-Holder*	Lager *Stock*	Bezeichnung *Part Number* Linke Halter *LH-Holder*	Lager *Stock*	Maße [mm] Dimensions $H_1 = H = B$	F	L_1	L_2		Ersatzteile Spare Parts				
NL 08 - 2	●	**NL 08 - 2 LH**	●	8	11	100	17	11 ER/EL	-		75.20.118	56.33.612	-
NL 10 - 2	●	**NL 10 - 2 LH**	○	10	11	100	17						
NL 12 - 3	●	**NL 12 - 3 LH**	○	12	16	100	22	16 ER/EL	-		75.20.119	75.20.618	-
AL 16 - 3	●	**AL 16 - 3 LH**	●	16	16	100	22		16 ER: 75.10.201 +1,5°(Standard) 16 EL: 75.20.201 +1,5°(Standard)	+4,5° +3,5° +2,5° Standard +0,5° -0,5° -1,5°	75.20.120		75.20.130
AL 20 - 3	●	**AL 20 - 3 LH**	●	20	20	125	30						
AL 25 - 3	●	**AL 25 - 3 LH**	●	25	25	150	30						
AL 32 - 3	●	**AL 32 - 3 LH**	○	32	32	170	30						
AL 25 - 4	●	**AL 25 - 4 LH**	○	25	25	150	36	22 ER/EL	22 ER: 75.10.203 +1,5°(Standard) 22 EL: 75.20.202 +1,5°(Standard)	+4,5° +3,5° +2,5° Standard +0,5° -0,5° -1,5°	75.20.122	56.33.614	75.20.129
AL 32 - 4	○	**AL 32 - 4 LH**	●	32	32	170	36						
AL 40 - 4	○	**AL 40 - 4 LH**	○	40	40	200	36						
AL 25 - 5	○	**AL 25 - 5 LH**	○	25	25	150	36	27 ER/EL	27 ER: 75.10.204 +1,5°(Standard) 27 EL: 75.20.203 +1,5°(Standard)	+4,5° +3,5° +2,5° Standard +0,5° -0,5° -1,5°	75.20.124	56.33.613	75.20.127
AL 32 - 5	○	**AL 32 - 5 LH**	○	32	32	170	40						
AL 40 - 5	○	**AL 40 - 5 LH**	○	40	40	200	40						

● JD-Lager / *JD-Stock* ○ begrenzte Lagerhaltung - auf Anfrage / *limited stock - upon request*

AVR NVR

zum Innen-Gewindedrehen ***for Internal Threading***



Bezeichnung *Part Number* Rechter Halter *RH-Holder*	Lager *Stock*	Bezeichnung *Part Number* Linke Halter *LH-Holder*	Lager *Stock*	Maße [mm] *Dimensions* D	D_1	L	L_1	F	D_{min}	H		Ersatzteile *Spare Parts*				
NVR 05 - 0	●	**NVR 05 - 0 LH**	○	12	5,1	100	12	4.3	6.0	11	06 IR/IL	-		75.20.102	75.20.621	-
NVR 07 - 1	●	**NVR 07 - 1 LH**	○	16	6,6	125	18	5.3	7.8	14	08 IR/IL	-		75.20.101		
NVR 10 - 2 IK	●	**NVR 10 - 2 IK LH**	○	16	10	125	25	7.4	12	14						
NVR 10 D - 2	●	**NVR 10 D - 2 LH**	○	10	9,6	100	25	7.4	12	9						
NVR 12 - 2 E	○	**NVR 12 - 2 E LH**		12	12	170	-	8.4	15	11	11 IR/IL	-		75.20.118	56.33.612	-
NVR 13 - 2 IK	●	**NVR 13 - 2 IK LH**	○	16	13	150	32	8.9	15	14						
NVR 13 - 3 IK	●	**NVR 13 - 3 IK LH**	○	16	13	150	32	10.2	16	14						
NVR 16 - 3 IK	●	**NVR 16 - 3 IK LH**	○	20	16	170	40	11.7	19	18		-		75.20.119		-
NVR 16 - 3 E	○	**NVR 16 - 3 E LH**		16	16	200	-	11.7	19	14						
AVR 20 - 3 IK	●	**AVR 20 - 3 IK LH**	●	20	20	170	-	13.7	24	18		16 IR: 75.20.201 +1,5°(Standard)	+4,5° +3,5° +2,5° Standard +0,5° -0,5° -1,5°			
AVR 20 - 3 E	○	**AVR 20 - 3 E LH**		20	20	250	-	13.7	23	18	16 IR/IL			75.20.120	75.20.618	75.20.130
AVR 25 D - 3 IK	●	**AVR 25 D - 3 IK LH**	●	25	25	200	-	16.2	29	22,5		16 IL: 75.10.201 +1,5°(Standard)				
AVR 32 - 3 IK	●	**AVR 32 - 3 IK LH**	●	32	32	250	-	19.7	36	29						
AVR 40 - 3	●	**AVR 40 - 3 LH**	●	40	40	300	-	23.7	44	36						
NVR 20 - 4	●	**NVR 20 - 4 LH**	○	20	20	170	-	15.6	24	18		-		75.20.121		-
AVR 25 - 4 IK	●	**AVR 25 - 4 IK LH**	○	25	25	200	-	18.1	29	22,5		22 IR: 75.20.202 +1,5°(Standard)	+4,5° +3,5° +2,5° Standard +0,5° -0,5° -1,5°			
AVR 32 - 4 IK	●	**AVR 32 - 4 IK LH**	○	32	32	250	-	21.5	39	29	22 IR/IL			75.20.122	56.33.614	75.20.129
AVR 40 - 4	●	**AVR 40 - 4 LH**	○	40	40	300	-	25.6	46	36		22 IL: 75.10.203 +1,5°(Standard)				
AVR 32 - 5	○	**AVR 32 - 5 LH**	○	32	32	250	-	22.6	40	29						
AVR 40 - 5	○	**AVR 40 - 5 LH**	○	40	40	300	-	26,6	48	36		27 IR: 75.20.203 +1,5°(Standard)	+4,5° +3,5° +2,5° Standard +0,5° -0,5° -1,5°			
AVR 50 - 5	○	**AVR 50 - 5 LH**	○	50	50	350	-	31,6	58	45	27 IR/IL			75.20.124	75.20.622	75.20.127
AVR 60 - 5	○	**AVR 60 - 5 LH**	○	60	60	400	-	36,6	68	54		27 IL: 75.10.204 +1,5°(Standard)				

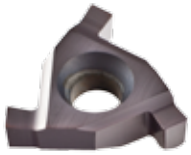
"E" = HM-Schaft mit Innenkühlung
Carbide Shank with Inner Coolant

"IK" = Innenkühlung
Inner Coolant

● JD-Lager / *JD-Stock* ○ begrenzte Lagerhaltung - auf Anfrage / *limited stock - upon request*

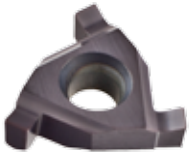
Präzisions-Einstechen Außen/Innen *Grooving External/Internal*

ER



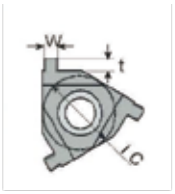
TU 5330

IR

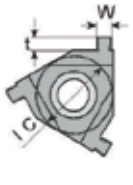


TU 5330

ER



IR



Bezeichnung *Part Number* Rechte WSP *RH Inserts*	Lager *Stock* TU 5330	Bezeichnung *Part Number* Linke WSP LH Inserts	Lager *Stock* TU 5330	IC mm	L mm	X mm	Y mm
60° außen / *external*		**60° außen / *external***					
16 ER -1.10 - T 1.30	●	**16 EL -1.10 - T 1.30**	○			1.10	1.30
16 ER -1.30 - T 1.50	●	**16 EL -1.30 - T 1.30**	○			1.30	1.50
16 ER -1.60 - T 1.85	●	**16 EL -1.60 - T 1.85**	○	9.525 (3/8")	16	1.60	1.85
16 ER -1.85 - T 2.00	●	**16 EL -1.85 - T 2.00**	○			1.85	2.00
16 ER -2.15 - T 2.50	●	**16 EL -2.15 - T 2.50**	○			2.15	2.25
60° außen / *external*		**60° außen / *external***					
16 IR -1.10 - T 1.30	●	**16 EL -1.10 - T 1.30**	○			1.10	1.30
16 IR -1.30 - T 1.30	●	**16 EL -1.30 - T 1.30**	○			1.30	1.50
16 IR -1.60 - T 1.85	●	**16 EL -1.60 - T 1.85**	○	9.525 (3/8")	16	1.60	1.85
16 IR -1.85 - T 2.00	●	**16 EL -1.85 - T 2.00**	○			1.85	2.00
16 IR -2.15 - T 2.50	●	**16 EL -2.15 - T 2.50**	○			2.15	2.25

Set Präzisions - Einstechen Grooving

16ER 1.10-2.15/TU 5330
oder *or*
16IR 1.10-2.15/TU 5330

bestehend aus:
consisting of:
je 2 Stechplatten in den Breiten
each 2 grooving inserts in size
1.10, 1.30, 1.60, 1.85, 2.15 mm

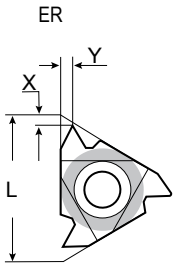
● JD-Lager / *JD-Stock* ○ begrenzte Lagerhaltung - auf Anfrage / *limited stock - upon request*

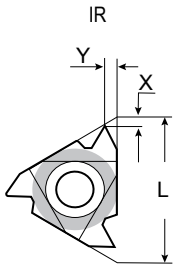
Außen- /Innengewinde / *External/Internal Thread*

Teilprofil 60° / *Partial Profile 60°*

TP 5130

TU 5330



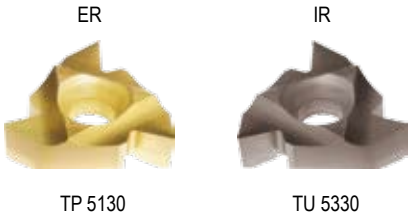


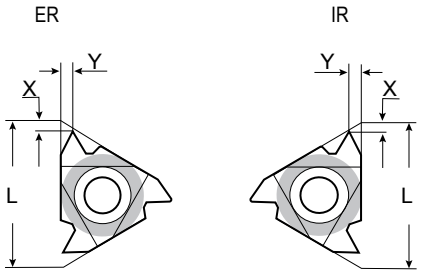
Bezeichnung *Part Number*	Lager *Stock*		Bezeichnung *Part Number*	Lager *Stock*		Steigung *Pitch*	L	X	Y
Rechte WSP *RH Inserts*	TP 5130	TU 5330	Linke WSP LH Inserts	TP 5130	TU 5330	mm	mm	mm	mm
60° außen / *external*			**60° außen / *external***						
11 ER -T- A 60	○		**11 EL -T- A 60**			0.5 - 1.5	11	0.8	0.9
16 ER -T- A 60	●		**16 EL -T- A 60**	○		0.5 - 1.5	16	0.8	0.9
16 ER -T- G 60	●		**16 EL -T- G 60**	●		1.75 - 3.0	16	1.2	1.7
16 ER -T- AG 60	●	●	**16 EL -T- AG 60**	●		0.5 - 3.0	16	1.2	1.7
22 ER -T- N 60	●		**22 EL -T- N 60**			3.5 - 5.0	22	1.7	2.5
27 ER -T- Q 60			**27 EL -T- Q 60**			5.5 - 6.0	27	2.1	3.1
60° innen / *internal*			**60° innen / *internal***						
06 IR -T- A 60	○		**06 IL -T- A 60**			0.5 - 1.25	6	0.6	06
08 IR -T- A 60	○		**08 IL -T- A 60**			0.5 - 1.5	8	0.6	0.7
11 IR -T- A 60	●		**11 IL -T- A 60**			0.5 - 1.5	11	0.8	0.9
16 IR -T- A 60	●		**16 IL -T- A 60**	○		0.5 - 1.5	16	0.8	0.9
16 IR -T- G 60	●		**16 IL -T- G 60**	○		1.75 - 3.0	16	1.2	1.7
16 IR -T- AG 60	●	●	**16 IL -T- AG 60**	○		0.5 - 3.0	16	1.2	1.7
22 IR -T- N 60	○		**22 IL -T- N 60**			3.5 - 5.0	22	1.7	2.5
27 IR -T- Q 60			**27 IL -T- Q 60**			5.5 - 6.0	27	1.8	2.7

● JD-Lager / *JD-Stock* ○ begrenzte Lagerhaltung - auf Anfrage / *limited stock - upon request*

Außen- /Innengewinde / *External/Internal Thread*

Teilprofil 55° / *Partial Profile 55°*





Bezeichnung *Part Number*	Lager *Stock*		Bezeichnung *Part Number*	Lager *Stock*		Steigung *Pitch*	L	X	Y
Rechte WSP *RH Inserts*	TP 5130	TU 5330	Linke WSP LH Inserts	TP 5130	TU 5330	mm	mm	mm	mm
55° außen / *external*			**55° außen / *external***						
11 ER -T- A 55	○		**11 EL -T- A 55**			48 - 16	11	0.8	0.9
16 ER -T- A 55	●		**16 EL -T- A 55**	●		48 - 16	16	0.8	0.9
16 ER -T- G 55	●		**16 EL -T- G 55**	○		14 - 8	16	1.2	1.7
16 ER -T- AG 55	●		**16 EL -T- AG 55**	●		48 - 168	16	1.2	1.7
22 ER -T- N 55	●		**22 EL -T- N 55**			7 - 5	22	1.7	2.5
27 ER -T- Q 55			**27 EL -T- Q 55**			4.5 - 4	27	2.0	2.9
55° innen / *internal*			**55° innen / *internal***						
06 IR -T- A 55	○		**06 IL -T- A 55**			48 - 20	6	0.6	0.6
08 IR -T- A 55	○		**08 IL -T- A 55**			48 - 16	8	0.6	0.7
11 IR -T- A 55	●		**11 IL -T- A 55**			48 - 16	11	0.8	0.9
16 IR -T- A 55	●		**16 IL -T- A 55**	●		48 - 16	16	0.8	0.9
16 IR -T- G 55	●		**16 IL -T- G 55**	○		14 - 8	16	1.2	1.7
16 IR -T- AG 55	●		**16 IL -T- AG 55**	●		48 - 8	16	1.2	1.7
22 IR -T- N 55			**22 IL -T- N 55**			7 - 5	22	1.7	2.5
27 IR -T- Q 55			**27 IL -T- Q 55**			4.5 - 4	27	2.0	2.9

● JD-Lager / *JD-Stock* ○ begrenzte Lagerhaltung - auf Anfrage / *limited stock - upon request*

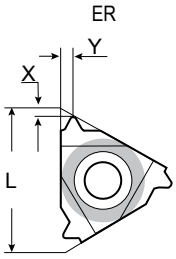
Außengewinde / *External Thread*

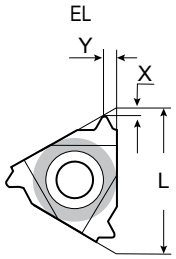
Vollprofil ISO 60° ***Full Profile ISO 60°***

ER

TP 5130

TU 5330





Bezeichnung *Part Number*	Lager *Stock*		Bezeichnung *Part Number*	Lager *Stock*		Steigung *Pitch*	L	X	Y
Rechte WSP *RH Inserts*	TP 5130	TU 5330	Linke WSP *LH Inserts*	TP 5130	TU 5330	mm	mm	mm	mm
11 ER - V - ISO 0.35			**11 EL - V - ISO 0.35**			0.35		0.8	0.4
11 ER - V - ISO 0.4			**11 EL - V - ISO 0.4**			0.4		0.7	0.4
11 ER - V - ISO 0.45			**11 EL - V - ISO 0.45**			0.45		0.7	0.4
11 ER - V - ISO 0.5	○		**11 EL - V - ISO 0.5**			0.5		0.6	0.6
11 ER - V - ISO 0.6	○		**11 EL - V - ISO 0.6**			0.6		0.6	0.6
11 ER - V - ISO 0.7	○		**11 EL - V - ISO 0.7**			0.7		0.6	0.6
11 ER - V - ISO 0.75	○		**11 EL - V - ISO 0.75**			0.75	11	0.6	0.6
11 ER - V - ISO 0.8	○		**11 EL - V - ISO 0.8**			0.8		0.6	0.6
11 ER - V - ISO 1.0	●		**11 EL - V - ISO 1.0**			1.0		0.7	0.7
11 ER - V - ISO 1.25	○		**11 EL - V - ISO 1.25**			1.25		0.8	0.9
11 ER - V - ISO 1.5	●		**11 EL - V - ISO 1.5**			1.5		0.8	1.0
11 ER - V - ISO 1.75	○		**11 EL - V - ISO 1.75**			1.75		0.8	1.1
16 ER - V - ISO 0.35			**16 EL - V - ISO 0.35**			0.35		0.8	0.4
16 ER - V - ISO 0.4			**16 EL - V - ISO 0.4**			0.4		0.7	0.4
16 ER - V - ISO 0.45			**16 EL - V - ISO 0.45**			0.45		0.7	0.4
16 ER - V - ISO 0.5	●		**16 EL - V - ISO 0.5**	●		0.5		0.6	0.6
16 ER - V - ISO 0.6	○		**16 EL - V - ISO 0.6**			0.6		0.6	0.6
16 ER - V - ISO 0.7	●		**16 EL - V - ISO 0.7**			0.7		0.6	0.6
16 ER - V - ISO 0.75	●	●	**16 EL - V - ISO 0.75**	●		0.75		0.6	0.6
16 ER - V - ISO 0.8	●	●	**16 EL - V - ISO 0.8**			0.8	16	0.6	0.6
16 ER - V - ISO 1.0	●	●	**16 EL - V - ISO 1.0**	●		1.0		0.7	0.7
16 ER - V - ISO 1.25	●	●	**16 EL - V - ISO 1.25**	●		1.25		0.8	0.9
16 ER - V - ISO 1.5	●	●	**16 EL - V - ISO 1.5**	●		1.5		0.8	1.0
16 ER - V - ISO 1.75	●	●	**16 EL - V - ISO 1.75**	●		1.75		0.9	1.2
16 ER - V - ISO 2.0	●	●	**16 EL - V - ISO 2.0**	●		2.0		1.0	1.3
16 ER - V - ISO 2.5	●	●	**16 EL - V - ISO 2.5**	●		2.5		1.1	1.5
16 ER - V - ISO 3.0	●	●	**16 EL - V - ISO 3.0**	●		3.0		1.2	1.6
16 ER - V - ISO 3.5	●	●	**16 EL - V - ISO 3.5**			3.5		1.2	1.7
22 ER - V - ISO 3.5	●		**22 EL - V - ISO 3.5**			3.5		1.6	2.3
22 ER - V - ISO 4.0	●		**22 EL - V - ISO 4.0**			4.0		1.6	2.3
22 ER - V - ISO 4.5	●		**22 EL - V - ISO 4.5**			4.5		1.7	2.4
22 ER - V - ISO 5.0	●		**22 EL - V - ISO 5.0**			5.0	22	1.7	2.5
22 ER - V - ISO 5.5	●		**22 EL - V - ISO 5.5**			5.5		1.7	2.6
22 ER - V - ISO 6.0	●		**22 EL - V - ISO 6.0**			6.0		1.9	2.7
27 ER - V - ISO 5.5	○		**27 EL - V - ISO 5.5**			5.5		1.9	2.7
27 ER - V - ISO 6.0	○		**27 EL - V - ISO 6.0**			6.0	27	2.0	2.9

● JD-Lager / *JD-Stock* ○ begrenzte Lagerhaltung - auf Anfrage / *limited stock - upon request*

Außengewinde / *External Thread*

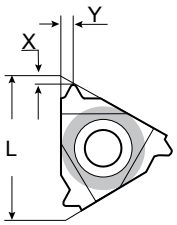
Vollprofil 55° ***Full Profile 55°***
BSW, BSF, BSP, BSB, Whitworth

ER

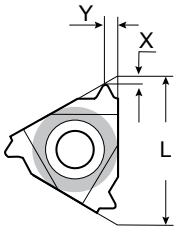
TP 5130

TU 5330

ER



EL



Bezeichnung *Part Number*	Lager *Stock*		Bezeichnung *Part Number*	Lager *Stock*		Steigung *Pitch*	L	X	Y
Rechte WSP *RH Inserts*	TP 5130	TU 5330	Linke WSP *LH Inserts*	TP 5130	TU 5330	TPI	mm	mm	mm
11 ER - V - BSW 40			**11 EL - V - BSW 40**			40		0.6	0.6
11 ER - V - BSW 36			**11 EL - V - BSW 36**			36		0.6	0.6
11 ER - V - BSW 32	○		**11 EL - V - BSW 32**			32		0.6	0.6
11 ER - V - BSW 28	○		**11 EL - V - BSW 28**			28		0.6	0.7
11 ER - V - BSW 26	○		**11 EL - V - BSW 26**			26		0.7	0.8
11 ER - V - BSW 24	○		**11 EL - V - BSW 24**			24	11	0.7	0.8
11 ER - V - BSW 22	○		**11 EL - V - BSW 22**			22		0.8	0.9
11 ER - V - BSW 20	○		**11 EL - V - BSW 20**			20		0.8	0.9
11 ER - V - BSW 19	○		**11 EL - V - BSW 19**			19		0.8	1.0
11 ER - V - BSW 18	○		**11 EL - V - BSW 18**			18		0.8	1.0
11 ER - V - BSW 16	○		**11 EL - V - BSW 16**			16		0.9	1.1
11 ER - V - BSW 14	○		**11 EL - V - BSW 14**			14		1.0	1.2
16 ER - V - BSW 40			**16 EL - V - BSW 40**			40		0.6	0.6
16 ER - V - BSW 36			**16 EL - V - BSW 36**			36		0.6	0.6
16 ER - V - BSW 32	○		**16 EL - V - BSW 32**			32		0.6	0.6
16 ER - V - BSW 28	●		**16 EL - V - BSW 28**			28		0.6	0.7
16 ER - V - BSW 26	○		**16 EL - V - BSW 26**			26		0.7	0.8
16 ER - V - BSW 24	●		**16 EL - V - BSW 24**			24		0.7	0.8
16 ER - V - BSW 22	○		**16 EL - V - BSW 22**			22		0.8	0.9
16 ER - V - BSW 20	○		**16 EL - V - BSW 20**			20		0.8	0.9
16 ER - V - BSW 19	●	●	**16 EL - V - BSW 19**	●		19	16	0.8	1.0
16 ER - V - BSW 18	●		**16 EL - V - BSW 18**			18		0.8	1.0
16 ER - V - BSW 16	●		**16 EL - V - BSW 16**			16		0.9	1.1
16 ER - V - BSW 14	●	●	**16 EL - V - BSW 14**	●		14		1.0	1.2
16 ER - V - BSW 12	●		**16 EL - V - BSW 12**			12		1.1	1.4
16 ER - V - BSW 11	●	●	**16 EL - V - BSW 11**	●		11		1.1	1.5
16 ER - V - BSW 10	●		**16 EL - V - BSW 10**			10		1.1	1.5
16 ER - V - BSW 9	●		**16 EL - V - BSW 9**			9		1.2	1.7
16 ER - V - BSW 8	●		**16 EL - V - BSW 8**			8		1.2	1.5
22 ER - V - BSW 7	○	○	**22 EL - V - BSW 7**			7		1.6	2.3
22 ER - V - BSW 6	○	○	**22 EL - V - BSW 6**			6	22	1.6	2.3
22 ER - V - BSW 5	○	○	**22 EL - V - BSW 5**			5		1.7	2.4
27 ER - V - BSW 4.5			**27 EL - V - BSW 4.5**			4.5	27	1.8	2.6
27 ER - V - BSW 4			**27 EL - V - BSW 4**			4		2.0	2.9

● JD-Lager / *JD-Stock* ○ begrenzte Lagerhaltung - auf Anfrage / *limited stock - upon request*

Außengewinde / *External Thread*

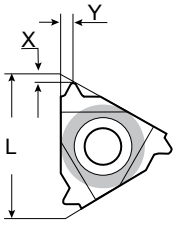
Vollprofil 60° *Full Profile* 60°
UN, UNC, UNEF, UNS

ER

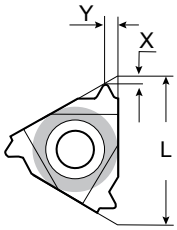
TP 5130

TU 5330

ER



EL



Bezeichnung *Part Number*	Lager *Stock*		Bezeichnung *Part Number*	Lager *Stock*		Steigung *Pitch*	L	X	Y
Rechte WSP *RH Inserts*	TP 5130	TU 5330	Linke WSP *LH Inserts*	TP 5130	TU 5330	TPI	mm	mm	mm
11 ER - V - UN 40			**11 EL - V - UN 40**			40		0.6	0.6
11 ER - V - UN 36			**11 EL - V - UN 36**			36		0.6	0.6
11 ER - V - UN 32	○		**11 EL - V - UN 32**			32		0.6	0.6
11 ER - V - UN 28	○		**11 EL - V - UN 28**			28		0.6	0.7
11 ER - V - UN 27	○		**11 EL - V - UN 27**			27		0.7	0.8
11 ER - V - UN 24	○		**11 EL - V - UN 24**			24	11	0.7	0.8
11 ER - V - UN 20	○		**11 EL - V - UN 20**			20		0.8	0.9
11 ER - V - UN 18	○		**11 EL - V - UN 18**			18		0.8	1.0
11 ER - V - UN 16	○		**11 EL - V - UN 16**			16		0.9	1.1
11 ER - V - UN 14	○		**11 EL - V - UN 14**			14		0.9	1.1
16 ER - V - UN 40	○		**16 EL - V - UN 40**			40		0.6	0.6
16 ER - V - UN 36	○		**16 EL - V - UN 36**			36		0.6	0.6
16 ER - V - UN 32	○		**16 EL - V - UN 32**			32		0.6	0.6
16 ER - V - UN 28	○		**16 EL - V - UN 28**			28		0.6	0.7
16 ER - V - UN 27	○		**16 EL - V - UN 27**			27		0.7	0.8
16 ER - V - UN 24	○		**16 EL - V - UN 24**			24		0.7	0.8
16 ER - V - UN 20	○		**16 EL - V - UN 20**			20		0.8	0.9
16 ER - V - UN 18	○		**16 EL - V - UN 18**			18		0.8	1.0
16 ER - V - UN 16	○		**16 EL - V - UN 16**			16	16	0.9	1.1
16 ER - V - UN 14	○		**16 EL - V - UN 14**			14		1.0	1.2
16 ER - V - UN 13	○		**16 EL - V - UN 13**			13		1.0	1.3
16 ER - V - UN 12	○		**16 EL - V - UN 12**			12		1.1	1.4
16 ER - V - UN 11	○		**16 EL - V - UN 11**			11		1.1	1.5
16 ER - V - UN 10	○		**16 EL - V - UN 10**			10		1.1	1.5
16 ER - V - UN 9	○		**16 EL - V - UN 9**			9		1.2	1.7
16 ER - V - UN 8	○		**16 EL - V - UN 8**			8		1.2	1.6
22 ER - V - UN 7	○		**22 EL - V - UN 7**			7		1.6	2.3
22 ER - V - UN 6	○		**22 EL - V - UN 6**			6	22	1.6	2.3
22 ER - V - UN 5	○		**22 EL - V - UN 5**			5		1.7	2.5
27 ER - V - UN 4.5			**27 EL - V - UN 4.5**			4.5	27	1.9	2.7
27 ER - V - UN 4			**27 EL - V - UN 4**			4		2.1	3.0

● JD-Lager / *JD-Stock* ○ begrenzte Lagerhaltung - auf Anfrage / *limited stock - upon request*

Außengewinde / *External Thread*

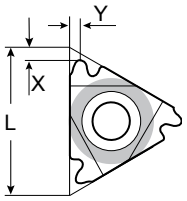
Vollprofil RD DIN 405 ***Full Profile RD DIN 405***

ER

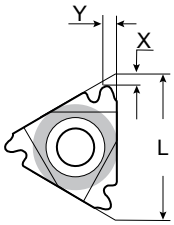
TP 5130

TU 5330

ER



EL



Bezeichnung *Part Number*	Lager *Stock*		Bezeichnung *Part Number*	Lager *Stock*		Steigung *Pitch*	L	X	Y
Rechte WSP *RH Inserts*	TP 5130	TU 5330	Linke WSP *LH Inserts*	TP 5130	TU 5330	TPI	mm	mm	mm
16 ER -V- RD 405/10	○		**16 EL -V- RD 405/10**			10		1.1	1.2
16 ER -V- RD 405/8	○		**16 EL -V- RD 405/8**			8	16	1.4	1.3
16 ER -V- RD 405/6	●		**16 EL -V- RD 405/6**			6		1.5	1.7
22 ER -V- RD 405/6	●		**22 EL -V- RD 405/6**			6	22	1.5	1.7
22 ER -V- RD 405/4	●		**22 EL -V- RD 405/4**			4		2.2	2.3
27 ER -V- RD 405/4			**27 EL -V- RD 405/4**			4	27	2.3	2.3

Außengewinde / *External Thread*

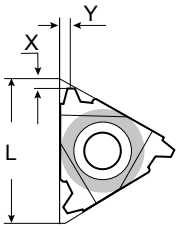
Vollprofil TR DIN 103 ***Full Profile TR DIN 103***

ER

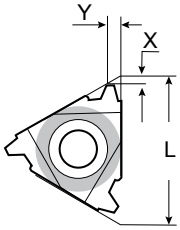
TP 5130

TU 5330

ER



EL



Bezeichnung *Part Number*	Lager *Stock*		Bezeichnung *Part Number*	Lager *Stock*		Steigung *Pitch*	L	X	Y
Rechte WSP *RH Inserts*	TP 5130	TU 5330	Linke WSP *LH Inserts*	TP 5130	TU 5330	mm	mm	mm	mm
11 ER -V- TR 103/1.5			**11 EL -V- TR 103/1.5**			1.5	11	0.8	0.9
16 ER -V- TR 103/1.5	○		**16 EL -V- TR 103/1.5**			1.5		1.0	1.1
16 ER -V- TR 103/2	●		**16 EL -V- TR 103/2**			2	16	1.0	1.3
16 ER -V- TR 103/3	●		**16 EL -V- TR 103/3**			3		1.3	1.5
22 ER -V- TR 103/4	●		**22 EL -V- TR 103/4**			4		1.7	1.9
22 ER -V- TR 103/5	●		**22 EL -V- TR 103/5**			5	22	2.1	2.5
22 ER -V- TR 103/6	●		**22 EL -V- TR 103/6**			6		2.3	2,7
27 ER -V- TR 103/6			**27 EL -V- TR 103/6**			6	27	2.3	2.7

● JD-Lager / *JD-Stock* ○ begrenzte Lagerhaltung - auf Anfrage / *limited stock - upon request*

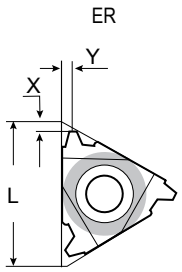
Außengewinde / *External Thread*

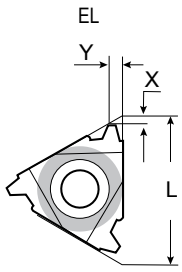
Vollprofil ACME ***Full Profile ACME***

ER

TP 5130

TU 5330



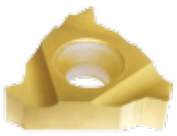


Bezeichnung *Part Number*	Lager *Stock*		Bezeichnung *Part Number*	Lager *Stock*		Steigung *Pitch*	L	X	Y
Rechte WSP *RH Inserts*	TP 5130	TU 5330	Linke WSP LH Inserts	TP 5130	TU 5330	TPI	mm	mm	mm
11 ER -V- ACME 16	○		**11 EL -V- ACME 16**			16	11	0.9	1.0
16 ER -V- ACME 16	○		**16 EL -V- ACME 16**			16		1.0	1.1
16 ER -V- ACME 14	○		**16 EL -V- ACME 14**			14		1.0	1.2
16 ER -V- ACME 12	○		**16 EL -V- ACME 12**			12	16	1.1	1.2
16 ER -V- ACME 10	●		**16 EL -V- ACME 10**			10		1.3	1.3
16 ER -V- ACME 8	○		**16 EL -V- ACME 8**			8		1.5	1.5
22 ER -V- ACME 6			**22 EL -V- ACME 6**			6	22	1.8	2.1
22 ER -V- ACME 5			**22 EL -V- ACME 5**			5		2.0	2.3
27 ER -V- ACME 4			**27 EL -V- ACME 4**			4	27	2.7	2.7

Außengewinde / *External Thread*

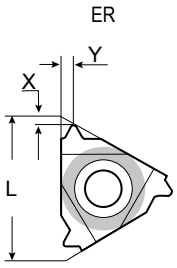
Vollprofil NPT 60° ***Full Profile NPT 60°***

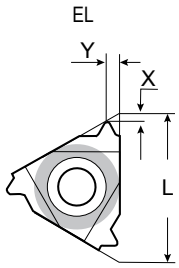
ER



TP 5130

TU 5330





Bezeichnung *Part Number*	Lager *Stock*		Bezeichnung *Part Number*	Lager *Stock*		Steigung *Pitch*	L	X	Y
Rechte WSP *RH Inserts*	TP 5130	TU 5330	Linke WSP LH Inserts	TP 5130	TU 5330	TPI	mm	mm	mm
11 ER -V- NPT 27	○		**11 EL -V- NPT 27**			27		0.7	0.8
11 ER -V- NPT 18	○		**11 EL -V- NPT 18**			18	11	0.8	1.0
11 ER -V- NPT 14	○		**11 EL -V- NPT 14**			14		0.8	1.0
16 ER -V- NPT 27	○		**16 EL -V- NPT 27**			27		0.7	0.8
16 ER -V- NPT 18	○		**16 EL -V- NPT 18**			18		0.8	1.0
16 ER -V- NPT 14	●		**16 EL -V- NPT 14**			14	16	0.9	1.2
16 ER -V- NPT 11.5	●		**16 EL -V- NPT 11.5**			11.5		1.1	1.5
16 ER -V- NPT 8	○		**16 EL -V- NPT 8**			8		1.3	1.8

● JD-Lager / *JD-Stock* ○ begrenzte Lagerhaltung - auf Anfrage / *limited stock - upon request*

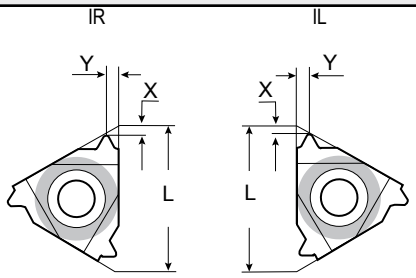
Innengewinde / *Internal Thread*

Vollprofil ISO 60° ***Full Profile ISO 60°***

IR

TP 5130

TU 5330

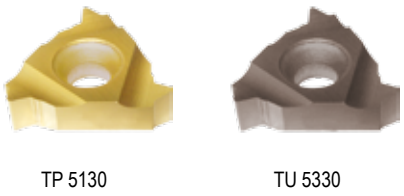


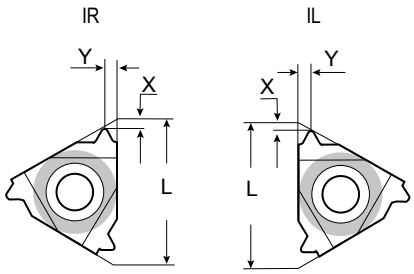
Bezeichnung *Part Number*	Lager *Stock*		Bezeichnung *Part Number*	Lager *Stock*		Steigung *Pitch*	L	X	Y
Rechte WSP *RH Inserts*	TP 5130	TU 5330	Linke WSP LH Inserts	TP 5130	TU 5330	TPI	mm	mm	mm
06 IR - V - ISO 0.5	○		**06 IL - V - ISO 0.5**			0.5		0.9	0.5
06 IR - V - ISO 0.75	○		**06 IL - V - ISO 0.75**			0.75		0.8	0.5
06 IR - V - ISO 1.0	○		**06 IL - V - ISO 1.0**			1.0	6	0.7	0.6
06 IR - V - ISO 1.25	○		**06 IL - V - ISO 1.25**			1.25		0.6	0.6
06 IR - V - ISO 1.5	○		**06 IL - V - ISO 1.5**			1.5		0.5	0.6
08 IR - V - ISO 0.5	○		**08 IL - V - ISO 0.5**			0.5		0.6	0.5
08 IR - V - ISO 0.75	○		**08 IL - V - ISO 0.75**			0.75		0.6	0.5
08 IR - V - ISO 1.0	○		**08 IL - V - ISO 1.0**			1.0	8	0.6	0.6
08 IR - V - ISO 1.25	○		**08 IL - V - ISO 1.25**			1.25		0.6	0.7
08 IR - V - ISO 1.5	○		**08 IL - V - ISO 1.5**			1.5		0.6	0.7
08 IR - V - ISO 1.75	○		**08 IL - V - ISO 1.75**			1.75		0.6	0.8
11 IR - V - ISO 0.35			**11 IL - V - ISO 0.35**			0.35		0.8	0.3
11 IR - V - ISO 0.4			**11 IL - V - ISO 0.4**			0.4		0.8	0.4
11 IR - V - ISO 0.45			**11 IL - V - ISO 0.45**			0.45		0.8	0.4
11 IR - V - ISO 0.5	○		**11 IL - V - ISO 0.5**			0.5		0.6	0.6
11 IR - V - ISO 0.6	○		**11 IL - V - ISO 0.6**			0.6		0.6	0.6
11 IR - V - ISO 0.7	○		**11 IL - V - ISO 0.7**			0.7		0.6	0.6
11 IR - V - ISO 0.75	●		**11 IL - V - ISO 0.75**			0.75	11	0.6	0.6
11 IR - V - ISO 0.8	○		**11 IL - V - ISO 0.8**			0.8		0.6	0.6
11 IR - V - ISO 1.0	●		**11 IL - V - ISO 1.0**			1.0		0.6	0.7
11 IR - V - ISO 1.25	●		**11 IL - V - ISO 1.25**			1.25		0.8	0.9
11 IR - V - ISO 1.5	●		**11 IL - V - ISO 1.5**			1.5		0.8	1.0
11 IR - V - ISO 1.75	●		**11 IL - V - ISO 1.75**			1.75		0.9	1.1
11 IR - V - ISO 2.0	●		**11 IL - V - ISO 2.0**			2.0		0.8	0.9
11 IR - V - ISO 2.5	●		**11 IL - V - ISO 2.5**			2.5		0.8	1.2

● JD-Lager / *JD-Stock* ○ begrenzte Lagerhaltung - auf Anfrage / *limited stock - upon request*

Innengewinde / *Internal Thread*

Vollprofil ISO 60° ***Full Profile ISO 60°***





Bezeichnung *Part Number*	Lager *Stock*		Bezeichnung *Part Number*	Lager *Stock*		Steigung *Pitch*	L	X	Y
Rechte WSP *RH Inserts*	TP 5130	TU 5330	Linke WSP LH Inserts	TP 5130	TU 5330	TPI	mm	mm	mm
16 IR - V - ISO 0.35			**16 IL - V - ISO 0.35**			0.35		0.8	0.3
16 IR - V - ISO 0.4			**16 IL - V - ISO 0.4**			0.4		0.8	0.4
16 IR - V - ISO 0.45			**16 IL - V - ISO 0.45**			0.45		0.8	0.4
16 IR - V - ISO 0.5	●		**16 IL - V - ISO 0.5**	○		0.5		0.6	0.6
16 IR - V - ISO 0.6	○		**16 IL - V - ISO 0.6**			0.6		0.6	0.6
16 IR - V - ISO 0.7	●		**16 IL - V - ISO 0.7**			0.7		0.6	0.6
16 IR - V - ISO 0.75	●		**16 IL - V - ISO 0.75**	○		0.75		0.6	0.6
16 IR - V - ISO 0.8	●		**16 IL - V - ISO 0.8**			0.8	16	0.6	0.6
16 IR - V - ISO 1.0	●	●	**16 IL - V - ISO 1.0**	●		1.0		0.6	0.7
16 IR - V - ISO 1.25	●	●	**16 IL - V - ISO 1.25**	○		1.25		0.8	0.9
16 IR - V - ISO 1.5	●	●	**16 IL - V - ISO 1.5**	●		1.5		0.8	1.0
16 IR - V - ISO 1.75	●	●	**16 IL - V - ISO 1.75**	●		1.75		0.9	1.2
16 IR - V - ISO 2.0	●	●	**16 IL - V - ISO 2.0**	●		2.0		1.0	1.3
16 IR - V - ISO 2.5	●	●	**16 IL - V - ISO 2.5**	●		2.5		1.1	1.5
16 IR - V - ISO 3.0	●	●	**16 IL - V - ISO 3.0**	●		3.0		1.1	1.5
16 IR - V - ISO 3.5	●	●	**16 IL - V - ISO 3.5**			3.5		1.2	1.7
22 IR - V - ISO 3.5	●		**22 IL - V - ISO 3.5**			3.5		1.6	2.3
22 IR - V - ISO 4.0	●		**22 IL - V - ISO 4.0**			4.0		1.6	2.3
22 IR - V - ISO 4.5	●		**22 IL - V - ISO 4.5**			4.5		1.6	2.4
22 IR - V - ISO 5.0	●		**22 IL - V - ISO 5.0**			5.0	22	1.6	2.3
22 IR - V - ISO 5.5	●		**22 IL - V - ISO 5.5**			5.5		1.6	2.3
22 IR - V - ISO 6.0	●		**22 IL - V - ISO 6.0**			6.0		1.6	2.4
27 IR - V - ISO 5.5	○		**27 IL - V - ISO 5.5**			5.5	27	1.6	2.3
27 IR - V - ISO 6.0	○		**27 IL - V - ISO 6.0**			6.0		1.8	2.5

● JD-Lager / *JD-Stock* ○ begrenzte Lagerhaltung - auf Anfrage / *limited stock - upon request*

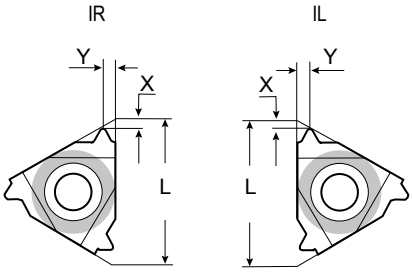
Innengewinde / *Internal Thread*

Vollprofil 55° *Full Profile 55°*
BSW, BSF, BSP, BSB, Whitworth

IR

TP 5130

TU 5330



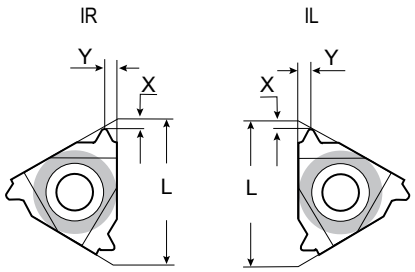
Bezeichnung *Part Number*	Lager *Stock*		Bezeichnung *Part Number*	Lager *Stock*		Steigung *Pitch*	L	X	Y
Rechte WSP *RH Inserts*	TP 5130	TU 5330	Linke WSP LH Inserts	TP 5130	TU 5330	TPI	mm	mm	mm
11 IR - V - BSW 40			**11 IL - V - BSW 40**			40		0.6	0.6
11 IR - V - BSW 36			**11 IL - V - BSW 36**			36		0.6	0.6
11 IR - V - BSW 32			**11 IL - V - BSW 32**			32		0.6	0.6
11 IR - V - BSW 28	○		**11 IL - V - BSW 28**			28		0.6	0.7
11 IR - V - BSW 26	○		**11 IL - V - BSW 26**			26		0.7	0.7
11 IR - V - BSW 24	○		**11 IL - V - BSW 24**			24	11	0.7	0.8
11 IR - V - BSW 22	○		**11 IL - V - BSW 22**			22		0.8	0.9
11 IR - V - BSW 20	○		**11 IL - V - BSW 20**			20		0.8	0.9
11 IR - V - BSW 19	●	○	**11 IL - V - BSW 19**			19		0.8	1.0
11 IR - V - BSW 18	○	○	**11 IL - V - BSW 18**			18		0.8	1.0
11 IR - V - BSW 16	○		**11 IL - V - BSW 16**			16		0.9	1.1
11 IR - V - BSW 14	●	○	**11 IL - V - BSW 14**			14		0.9	1.1
16 IR - V - BSW 40			**16 IL - V - BSW 40**			40		0.6	0.6
16 IR - V - BSW 36			**16 IL - V - BSW 36**			36		0.6	0.6
16 IR - V - BSW 32			**16 IL - V - BSW 32**			32		0.6	0.6
16 IR - V - BSW 28	○		**16 IL - V - BSW 28**			28		0.6	0.7
16 IR - V - BSW 26	●		**16 IL - V - BSW 26**			26		0.7	0.8
16 IR - V - BSW 24	○		**16 IL - V - BSW 24**			24		0.7	0.8
16 IR - V - BSW 22	○		**16 IL - V - BSW 22**			22		0.8	0.9
16 IR - V - BSW 20	●		**16 IL - V - BSW 20**			20		0.8	0.9
16 IR - V - BSW 19	●		**16 IL - V - BSW 19**			19	16	0.8	1.0
16 IR - V - BSW 18	●		**16 IL - V - BSW 18**			18		0.8	1.0
16 IR - V - BSW 16	●		**16 IL - V - BSW 16**			16		0.9	1.1
16 IR - V - BSW 14	●	●	**16 IL - V - BSW 14**			14		1.0	1.2
16 IR - V - BSW 12	○	○	**16 IL - V - BSW 12**			12		1.1	1.4
16 IR - V - BSW 11	●	●	**16 IL - V - BSW 11**			11		1.1	1.5
16 IR - V - BSW 10	●		**16 IL - V - BSW 10**			10		1.1	1.5
16 IR - V - BSW 9	●		**16 IL - V - BSW 9**			9		1.2	1.7
16 IR - V - BSW 8	●		**16 IL - V - BSW 8**			8		1.2	1.5
22 IR - V - BSW 7	○		**22 IL - V - BSW 7**			7		1.6	2.3
22 IR - V - BSW 6	○		**22 IL - V - BSW 6**			6	22	1.6	2.3
22 IR - V - BSW 5	○		**22 IL - V - BSW 5**			5		1.7	2.4
27 IR - V - BSW 4.5			**27 IL - V - BSW 4.5**			4.5	27	1.8	2.6
27 IR - V - BSW 4			**27 IL - V - BSW 4**			4		2.0	2.9

● JD-Lager / *JD-Stock* ○ begrenzte Lagerhaltung - auf Anfrage / *limited stock - upon request*

Innengewinde / *Internal Thread*

Vollprofil 60° ***Full Profile 60°***
UN, UNC, UNF, UNEF, UNS

TP 5130 TU 5330



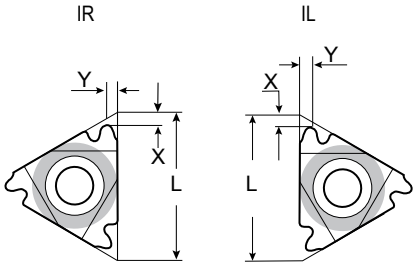
Bezeichnung *Part Number*	Lager *Stock*		Bezeichnung *Part Number*	Lager *Stock*		Steigung *Pitch*	L	X	Y
Rechte WSP *RH Inserts*	TP 5130	TU 5330	Linke WSP LH Inserts	TP 5130	TU 5330	TPI	mm	mm	mm
11 IR - V - UN 40			**11 IL - V - UN 40**			40		0.6	0.6
11 IR - V - UN 36			**11 IL - V - UN 36**			36		0.6	0.6
11 IR - V - UN 32	○		**11 IL - V - UN 32**			32		0.6	0.6
11 IR - V - UN 28	○		**11 IL - V - UN 28**			28		0.6	0.7
11 IR - V - UN 27	○		**11 IL - V - UN 27**			27	11	0.7	0.8
11 IR - V - UN 24	○		**11 IL - V - UN 24**			24		0.7	0.8
11 IR - V - UN 20	○		**11 IL - V - UN 20**			20		0.8	0.9
11 IR - V - UN 18	○		**11 IL - V - UN 18**			18		0.8	1.0
11 IR - V - UN 16	○		**11 IL - V - UN 16**			16		0.9	1.1
11 IR - V - UN 14	○		**11 IL - V - UN 14**			14		0.9	1.1
16 IR - V - UN 40			**16 IL - V - UN 40**			40		0.6	0.6
16 IR - V - UN 36			**16 IL - V - UN 36**			36		0.6	0.6
16 IR - V - UN 32	○		**16 IL - V - UN 32**			32		0.6	0.6
16 IR - V - UN 28	●		**16 IL - V - UN 28**			28		0.6	0.7
16 IR - V - UN 27	○		**16 IL - V - UN 27**			27		0.7	0.8
16 IR - V - UN 24	●		**16 IL - V - UN 24**			24		0.7	0.8
16 IR - V - UN 20	●		**16 IL - V - UN 20**			20		0.8	0.9
16 IR - V - UN 18	●		**16 IL - V - UN 18**			18		0.8	1.0
16 IR - V - UN 16	●		**16 IL - V - UN 16**			16	16	0.9	1.1
16 IR - V - UN 14	●		**16 IL - V - UN 14**			14		0.9	1.2
16 IR - V - UN 13	○		**16 IL - V - UN 13**			13		1.0	1.3
16 IR - V - UN 12	●		**16 IL - V - UN 12**			12		1.1	1.4
16 IR - V - UN 11	○		**16 IL - V - UN 11**			11		1.1	1.5
16 IR - V - UN 10	○		**16 IL - V - UN 10**			10		1.1	1.5
16 IR - V - UN 9	●		**16 IL - V - UN 9**			9		1.2	1.7
16 IR - V - UN 8	●		**16 IL - V - UN 8**			8		1.1	1.5
22 IR - V - UN 7	○		**22 IL - V - UN 7**			7		1.6	2.3
22 IR - V - UN 6	○		**22 IL - V - UN 6**			6	22	1.6	2.3
22 IR - V - UN 5	○		**22 IL - V - UN 5**			5		1.6	2.3
27 IR - V - UN 4.5			**27 IL - V - UN 4.5**			4.5	27	1.7	2.4
27 IR - V - UN 4			**27 IL - V - UN 4**			4		1.8	2.7

● JD-Lager / *JD-Stock* ○ begrenzte Lagerhaltung - auf Anfrage / *limited stock - upon request*

Innengewinde / *Internal Thread*

Vollprofil RD DIN 405 ***Full Profile RD DIN 405***

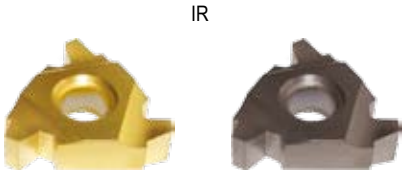
TP 5130 TU 5330



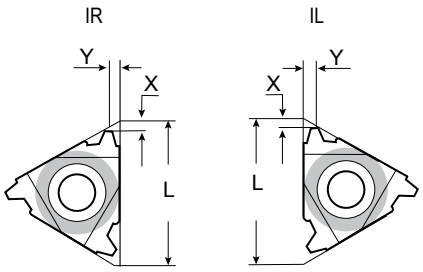
Bezeichnung *Part Number*	Lager *Stock*		Bezeichnung *Part Number*	Lager *Stock*		Steigung *Pitch*	L	X	Y
Rechte WSP *RH Inserts*	TP 5130	TU 5330	Linke WSP LH Inserts	TP 5130	TU 5330	TPI	mm	mm	mm
16 IR - V - RD 405 / 10	○		**16 IL - V - RD 405 / 10**			10		1.1	1.2
16 IR - V - RD 405 / 8	●		**16 IL - V - RD 405 / 8**			8	16	1.4	1.4
16 IR - V - RD 405 / 6	○		**16 IL - V - RD 405 / 6**			6		1.4	1.5
22 IR - V - RD 405 / 6	○		**22 IL - V - RD 405 / 6**			6	22	1.5	1.7
22 IR - V - RD 405 / 4	○		**22 IL - V - RD 405 / 4**			4		2.2	2.3
27 IR - V - RD 405 / 4			**27 IL - V - RD 405 / 4**			4	27	2.2	2.3

Innengewinde / *Internal Thread*

Vollprofil TR DIN 103 ***Full Profile TR DIN 103***



TP 5130 TU 5330



Bezeichnung *Part Number*	Lager *Stock*		Bezeichnung *Part Number*	Lager *Stock*		Steigung *Pitch*	L	X	Y
Rechte WSP *RH Inserts*	TP 5130	TU 5330	Linke WSP LH Inserts	TP 5130	TU 5330	TPI	mm	mm	mm
11 IR - V - TR 103 / 1.5			**11 IL - V - TR 103 / 1.5**			1.5	11	0.8	0.9
16 IR - V - TR 103 / 1.5	○		**16 IL - V - TR 103 / 1.5**			1.5		1.0	1.1
16 IR - V - TR 103 / 2	●		**16 IL - V - TR 103 / 2**			2	16	1.0	1.3
16 IR - V - TR 103 / 3	●		**16 IL - V - TR 103 / 3**			3		1.3	1.5
22 IR - V - TR 103 / 4	●		**22 IL - V - TR 103 / 4**			4		1.7	1.9
22 IR - V - TR 103 / 5	●		**22 IL - V - TR 103 / 5**			5	22	2.1	2.5
22 IR - V - TR 103 / 6	●		**22 IL - V - TR 103 / 6**			6		2.3	2,7
27 IR - V - TR 103 / 6			**27 IL - V - TR 103 / 6**			6	27	2.3	2,7

● JD-Lager / *JD-Stock* ○ begrenzte Lagerhaltung - auf Anfrage / *limited stock - upon request*

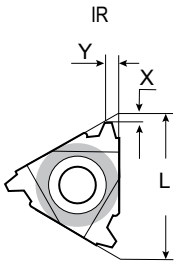
Innengewinde / *Internal Thread*

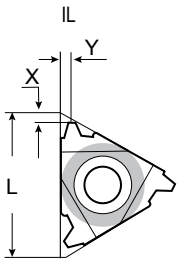
Vollprofil ACME ***Full Profile ACME***

IR

TP 5130

TU 5330

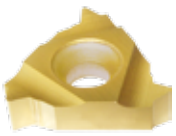




Bezeichnung *Part Number*	Lager *Stock*		Bezeichnung *Part Number*	Lager *Stock*		Steigung *Pitch*	L	X	Y
Rechte WSP *RH Inserts*	TP 5130	TU 5330	Linke WSP LH Inserts	TP 5130	TU 5330	TPI	mm	mm	mm
11 IR- V -ACME16	○		**11 IL - V -ACME16**			16	11	0.9	1.0
16 IR- V -ACME16	○		**16 IL - V -ACME16**			16		0.9	1.0
16 IR- V -ACME14	○		**16 IL - V -ACME14**			14		1.0	1.2
16 IR- V -ACME12	○		**16 IL - V -ACME12**			12	16	1.1	1.2
16 IR- V -ACME10	○		**16 IL - V -ACME10**			10		1.3	1.3
16 IR- V -ACME8	○		**16 IL - V -ACME8**			8		1.5	1.5
22 IR- V -ACME6	○		**22 IL - V -ACME6**			6		1.8	2.1
22 IR- V -ACME5	●		**22 IL - V -ACME5**			5	22	2.0	2.3
27 IR - V - ACME 4			**27 IL - V - ACME 4**			4	27	2.3	2.6

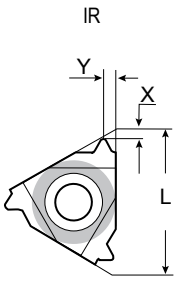
Innengewinde / *Internal Thread*

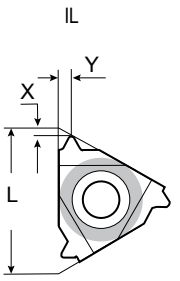
Vollprofil NPT 60° ***Full Profile NPT 60°***



TP 5130

TU 5330





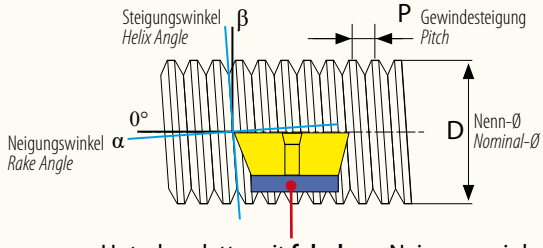
Bezeichnung *Part Number*	Lager *Stock*		Bezeichnung *Part Number*	Lager *Stock*		Steigung *Pitch*	L	X	Y
Rechte WSP *RH Inserts*	TP 5130	TU 5330	Linke WSP LH Inserts	TP 5130	TU 5330	TPI	mm	mm	mm
11 IR- V -NPT 27	○		**11 IL - V -NPT 27**			27		0.7	0.8
11 IR- V -NPT 18	○		**11 IL - V -NPT 18**			18	11	0.8	1.0
11 IR- V -NPT 14	○		**11 IL - V -NPT 14**			14		0.8	1.0
16 IR- V -NPT 27	○		**16 IL - V -NPT 27**			27		0.7	0.8
16 IR- V -NPT 18	●		**16 IL - V -NPT 18**			18		0.8	1.0
16 IR- V -NPT 14	●		**16 IL - V -NPT 14**			14	16	0.9	1.2
16 IR- V -NPT 11.5	●		**16 IL - V -NPT 11.5**			11.5		1.1	1.5
16 IR- V -NPT 8	●		**16 IL - V -NPT 8**			8		1.3	1.8

● JD-Lager / *JD-Stock* ○ begrenzte Lagerhaltung - auf Anfrage / *limited stock - upon request*

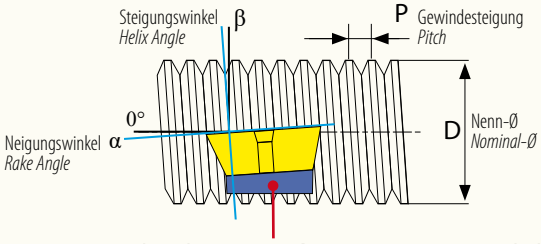
Gewindedrehen - Technische Information
Threading - Technical Information

Zugunsten einer größtmöglichen Profilgenauigkeit, bester Oberflächengüte sowie einem gleichmäßigen Verschleiß und der damit verbundenen längeren Standzeit der Wendeschneidplatte, muss der **Wendeplatten-Neigungswinkel** "α" mit dem **Gewinde-Steigungswinkel** "β" **möglichst exakt übereinstimmen**.

*In favor of high level on accuracy of the profile, best surface finish as well as simultaneously wear and longer tool life of the insert, the **rake angle** "α" of the insert and the **helix angle** "β" of the thread **have to agree**.*



Unterlegplatte mit **falschem** Neigungswinkel
*Shim with **incorrect** rake angle*

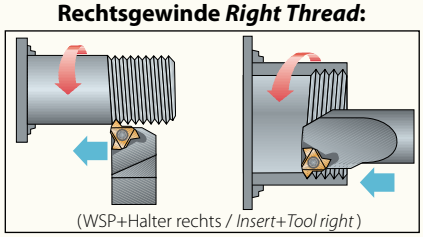


Unterlegplatte mit **richtigem** Neigungswinkel
*Shim with **correct** rake angle*

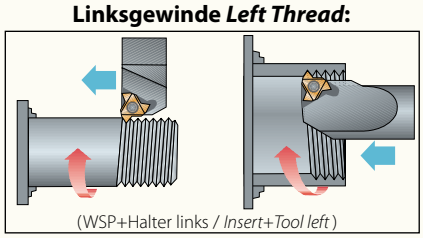
Steigungswinkeldiagramm zum Austausch der Unterlegplatten für metrisches Gewinde

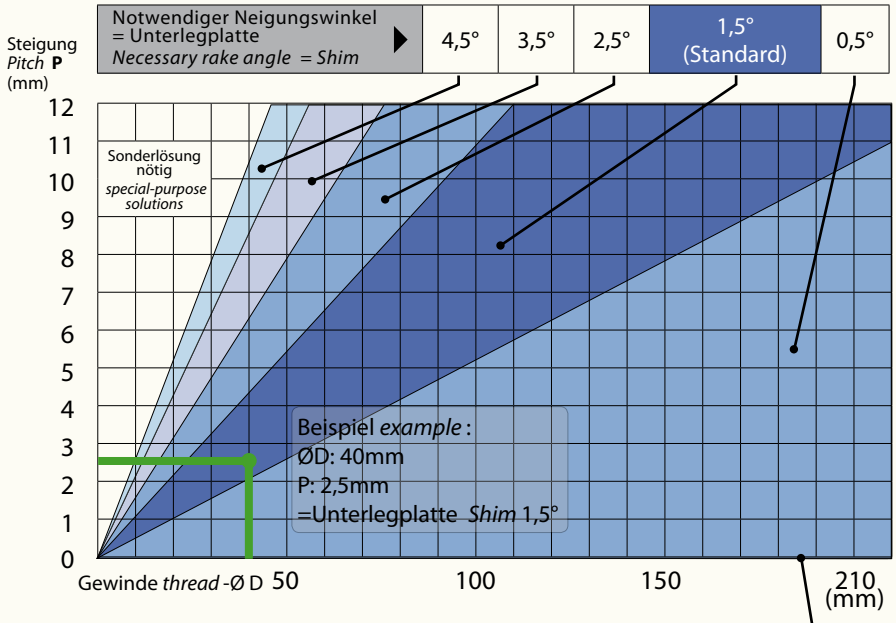
Vorschub in Richtung Futter
Movement to Chuck

Rechtsgewinde *Right Thread*:



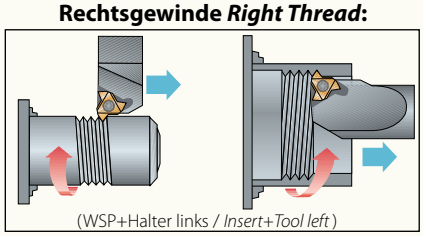
Linksgewinde *Left Thread*:



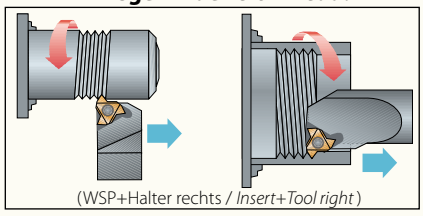


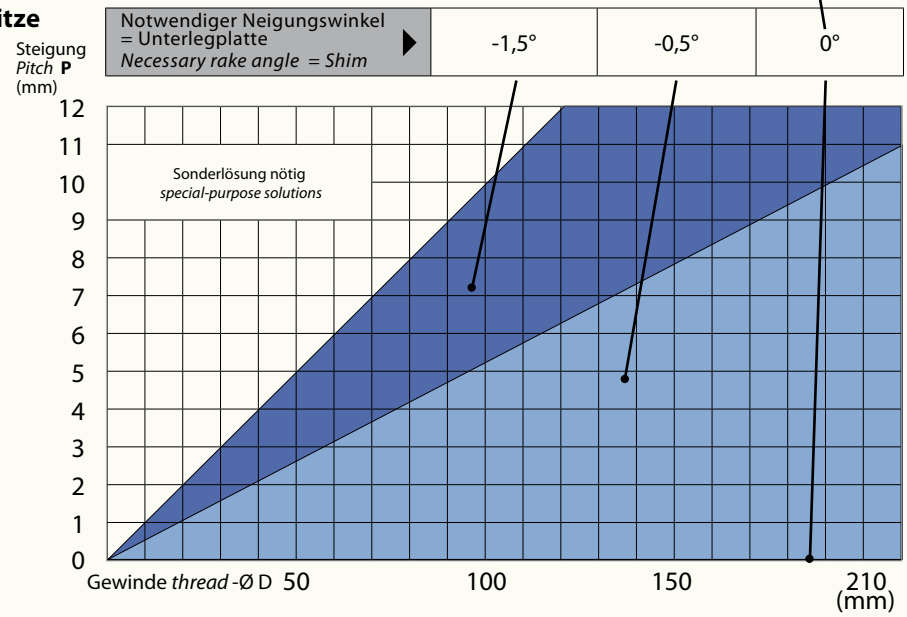
Vorschub in Richtung Drehbankspitze
Movement to Center

Rechtsgewinde *Right Thread*:



Linksgewinde *Left Thread*:

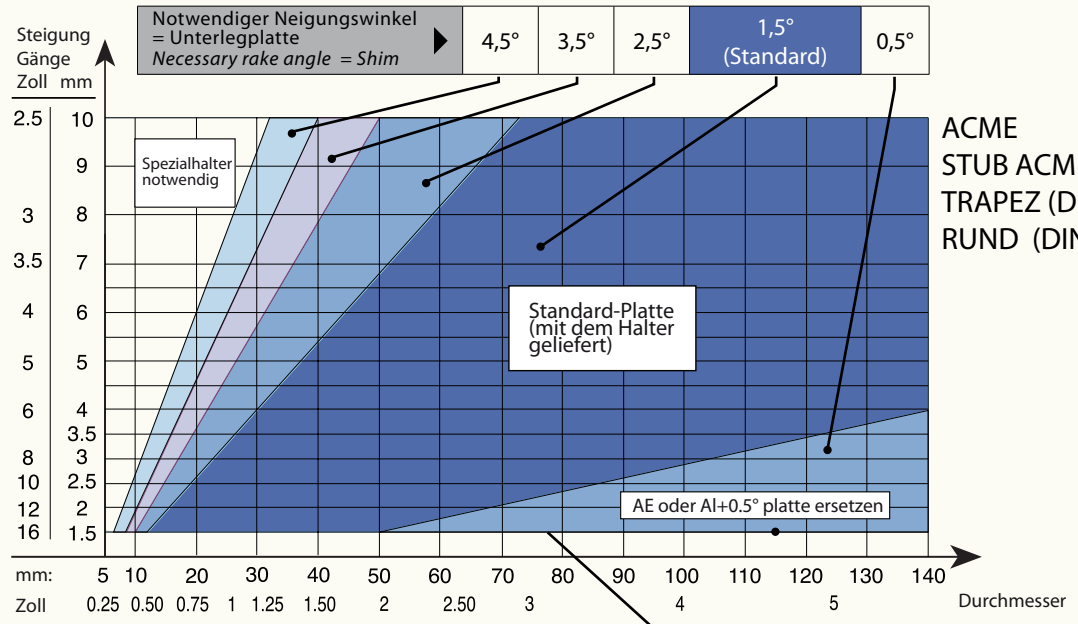




$$\lambda° = \frac{20 \cdot P}{D} \qquad tg\,\lambda = \frac{P}{3{,}14 \cdot D}$$

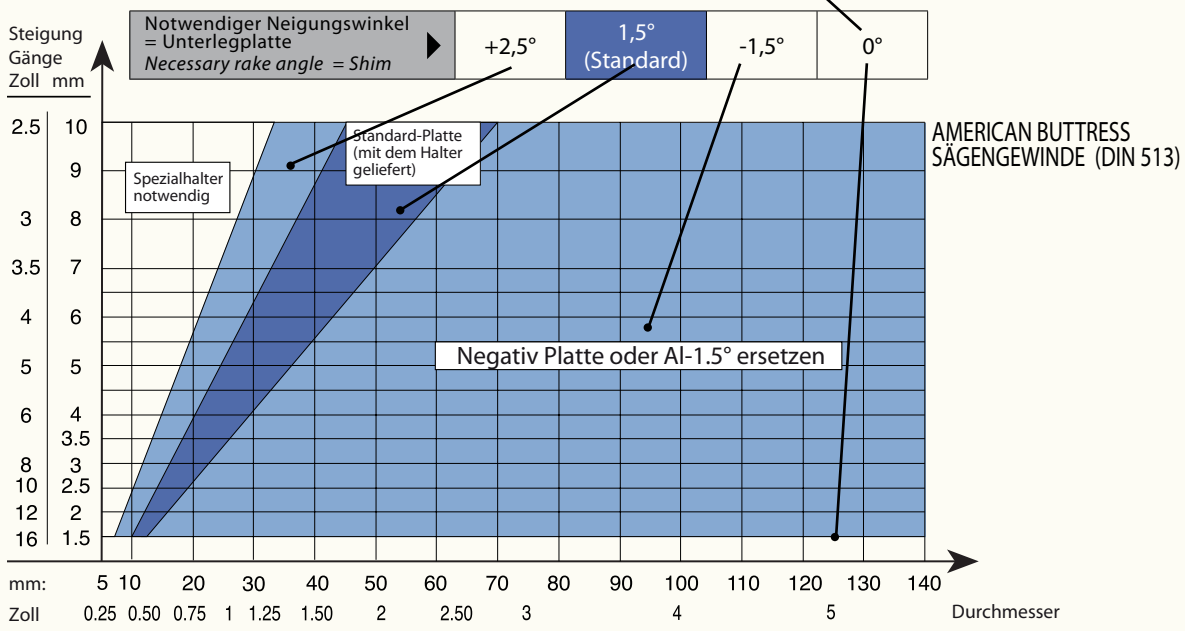
P = Steigung *Pitch* in mm **D** = Flankendurchmesser *Flank diameter* in mm **λ** = Steigungswinkel *Helix Angle*

Steigungswinkeldiagramm zum Austausch der Unterlegplatten



$$\lambda° = \frac{30 \cdot P}{2D}$$

P = Steigung *Pitch* in mm **D** = Flankendurchmesser *Flank diameter* in mm **λ** = Steigungswinkel *Helix Angle*



Richtwerte für die Anzahl der Gewindedurchgänge *
Guide Lines for the Number of Threading Passes *

Steigung *Pitch*	**mm**	0.5	0.75	1.0	1.25	1.5	1.75	2.0	2.5	3.0	4.0	5.0	6.0
	G/1" *TPI*	48	32	24	20	16	14	12	10	8	6	5	4
Zahl der Durchgänge No. of passes		4-6	4-7	4-8	5-9	6-10	7-12	7-12	8-14	10-16	11-18	12-20	12-20

*abhängig von Werkstoff und Schnittbedingungen *depends on material and cutting conditions*

Unterschiede zwischen Voll- und Teilprofil-Gewindeschneidplatten
Differences between Full and Partial Profile Threading Inserts

Vollprofil - Gewindeschneidplatte

Full Profile - Threading Insert

Vorteile / *Advantages*

Das gesamte Gewindeprofil einschließlich Gewindespitze wird normhaltig bearbeitet - für Serienfertigung geeignet.
The complete thread profile including tip of thread is machined complying with the norm - suitable for series production.
Die Gewindespitzen sind gratfrei.
The tips of thread are burr-free.

Nachteile / *Disadvantages*

Für jede Steigung wird eine andere Wendeschneidplatte benötigt.
For every pitch a different insert is required.

Teilprofil - Gewindeschneidplatte

Partial Profile - Threading Insert

Vorteile / *Advantages*

Mit wenigen Wendeschneidplatten können die meisten Steigungen gefertigt werden.

With only a few inserts it is possible to machine most of the different pitches.

Nachteile / *Disadvantages*

Das Gewindeprofil weicht geringfügig von der Norm ab.
The profile of thread differs slightly from the norm.
Die Gewindespitzen müssen häufig nachträglich entgratet werden.
The tips of thread often have to be de-burred.

Schnittdaten-Empfehlungen zum Gewindedrehen
Cutting Data Recommendations for Threading

Werkstückwerkstoff *Material*		Festigkeit *Tensile strength*	Schnittgeschwindigkeiten / *Cutting speeds* v_c [m/min] TP 5130 (P/M30/K20C)	Schnittgeschwindigkeiten / *Cutting speeds* v_c [m/min] TU 5330 (P30C)
A (P)	unlegierter Stahl *mild steel*	< 650 N/mm²	70 - 200	70 - 220
		650 - 850 N/mm²	70 - 160	70 - 160
	legierter Stahl *alloyed steel*	700 - 1000 N/mm²	90 - 160	90 - 180
		1000 - 1300 N/mm²	70 - 120	70 - 120
R (M)	rostfreier Stahl *stainless steel*	500 - 700 N/mm² (austenitisch /austenitic)	80 - 160	50 - 240
		500 - 900 N/mm² (ferritisch / ferritic)	100 - 160	50 - 200
F (K)	Grauguss *grey cast iron*	110 - 150 HB	150 - 220	60 - 230
		> 150 HB	100 - 160	60 - 160
N	Aluminium und Kupferlegierungen *aluminium and copper alloys*	50 - 160 HB	80 - 360	100 - 500

Symbolerklärung
Explanation of Symbols

M Metrisches ISO-Regelgewinde DIN 13
ISO Metric Coarse Thread DIN 13

SL Sackloch
Blind Hole

DL Durchgangsloch
Through Hole

Typ / Type N Für universellen Einsatz
For universal use

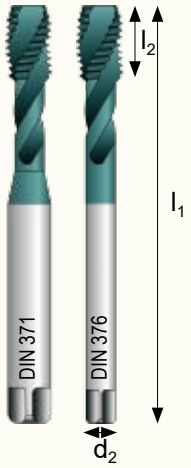
vapor. Vaporisiert
Steam treatment

Schnittdaten-Richtwerte (bei Verwendung von Emulsion / Schneidöl)
Cutting Data Recommendations (when using emulsion / cutting oil)

Werkstückwerkstoff *Material*		Festigkeit *Tensile strength*	**Schnittgeschwindigkeiten / *Cutting feeds* v_c [m/min]** **JD 4126 JD 4226**
A	Unlegierter Stahl *Mild steel*	< 650 N/mm^2	08 - 12
			10 - 15
		650 - 850 N/mm^2	08 - 10
			10 - 12
	Legierter Stahl *Alloyed steel*	700 - 1000 N/mm^2	06 - 08
			08 - 10
		1000 - 1300 N/mm^2	
R	Rostfreier Stahl *Stainless steel*	500 - 700 N/mm^2 (austenitisch /austenitic)	05 - 06
			06 - 08
		500 - 900 N/mm^2 (ferritisch / ferritic)	05 - 06
			06 - 08
F	Grauguss *Grey cast iron*	110 - 150 HB	10 - 12
			12 - 15
		> 150 HB	08 - 10
			10 - 12
N	Aluminium *Aluminium*		12 - 15
			15 - 18
	Kupferlegierungen *Copper alloys*		08 - 12
			08 - 15

Maschinengewindebohrer / *Machine Taps*

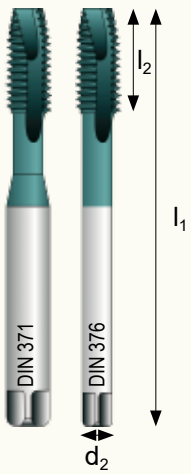
Typ *Type* UNI | DIN 371 376 | M | 40° | SL | Form C 2-3 | Tol. 6 H | HSS-E | vapor.



Bezeichnung *Part Number*	DIN	Nennmaß *Size*	Lager *Stock*	Maße [mm] *Dimensions* Steigung *Pitch*	l_1	l_2	d_2	a	Z
JD 4126 M3		M3	●	0.50	56	5	3.50	2.7	
JD 4126 M4		M4	●	0.70	63	7	4.50	3.4	
JD 4126 M5	371	M5	●	0.80	70	8	6.00	4.9	
JD 4126 M6		M6	●	1.00	80	10	6.00	4.9	3
JD 4126 M8		M8	●	1.25	90	13	8.00	6.2	
JD 4126 M10		M10	●	1.50	100	15	10.00	8.0	
JD 4126 M12		M12	●	1.75	110	18	9.00	7.0	
JD 4126 M14	376	M14	○	2.00	110	20	11.00	9.0	
JD 4126 M16		M16	○	2.00	110	20	12.00	9.0	4

Maschinengewindebohrer / *Machine Taps*

Typ *Type* VA | DIN 371 376 | M | | DL | Form C 3-5 | Tol. 6 H | HSS-E | vapor.



Bezeichnung *Part Number*	DIN	Nennmaß *Size*	Lager *Stock*	Maße [mm] *Dimensions* Steigung *Pitch*	l_1	l_2	d_2	a	Z
JD 4226 M3		M3	●	0.50	56	9	3.50	2.7	
JD 4226 M4		M4	●	0.70	63	12	4.50	3.4	
JD 4226 M5	371	M5	●	0.80	70	13	6.00	4.9	
JD 4226 M6		M6	●	1.00	80	15	6.00	4.9	
JD 4226 M8		M8	●	1.25	90	18	8.00	6.2	3
JD 4226 M10		M10	●	1.50	100	20	10.00	8.0	
JD 4226 M12		M12	●	1.75	110	23	9.00	7.0	
JD 4226 M14	376	M14	○	2.00	110	25	11.00	9.0	
JD 4226 M16		M16	●	2.00	110	25	12.00	9.0	

● JD-Lager / *JD-Stock* ○ begrenzte Lagerhaltung - auf Anfrage / *limited stock - upon request*