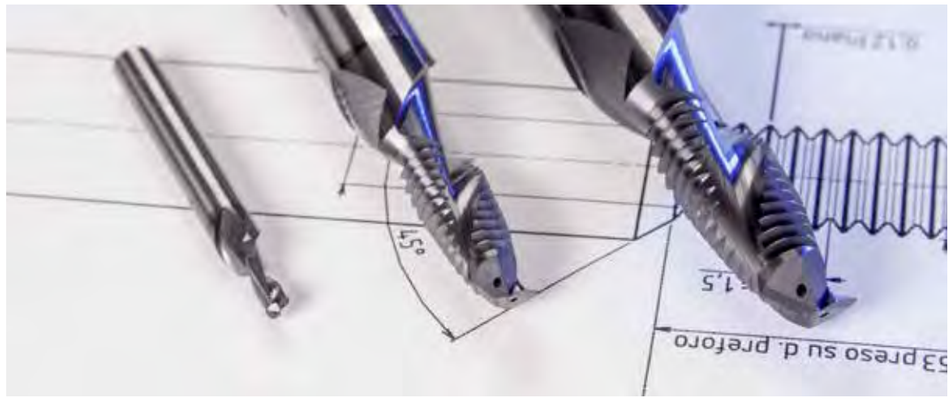
CUTWEL PRO THREAD MILLS

ITALIAN **THREADING TECHNOLOGY**



Con le frese per filettare FIL di IGUTENSILI le lavorazioni di filettatura vengono eseguite rapidamente e in modo produttivo senza rinunciare alla qualità della lavorazione. Questi utensili sono impiegabili su di una vastissima gamma di macchinari a controllo numerico come CENTRI di LAVORO, CENTRI di TORNITURA, TRANSFER ed anche su LINEE DI PRODUZIONE AVANZATA ove è possibile abbattere sia i tempi di lavorazione che di attrezzaggio, gli utensili FIL possono essere utilizzati su macchinari con almeno 3 assi in movimento. L'utensile FIL-Frese per filettare è une conseguenza di questo impegno nel realizzare filettature in modo VELOCE e con la massima EFFICACIA.

Con la sintesi di più strumenti e, di conseguenza, di più lavorazioni accorpate con unico utensile, si offrono ampi margini di risparmio, tempi macchina ridotti, gestione utensileria semplificata. Nel FIL sono presenti diverse tipologie di utensile dalla fresa per la sola filettatura fino ad utensile che FORA-SMUSSA-FILETTA in unica soluzione, anche su materiali con durezze pari a 65 HRC, la gamma di utensili FIL è dotata di REFRIGERAZIONE forzata INTERNA sia alla TESTA che RADIALE, garantendo in questo modo un'ottima lubrificazione nel punto di taglio ed una eccellente evacuazione del truciolo. Esse assicurano rugosità ridotte, massima precisione dimensionale, riducendo al minimo la produzione di bave eliminando così successive operazioni di pulizia / sbavatura.

Gli utensili FIL-Frese per FIlettare, sono rivestiti TNF o LTM in funzione del materiale da lavorare, raggiungono alti valori di taglio e lunga durata, garantendo sempre la massima stabilità del ciclo produttivo, inoltre i FIL, nonostante la complessa tecnologia costruttiva, permettono le operazioni di affilatura e rivestimento, donando all'utensile stesso nuova vita con rendimenti eccellenti. Da non sottovalutare la possibilità di produrre Frese per Filettare FIL speciali a disegno, IGUTENSILI è in grado di sviluppare un'infinita gamma di filettature per le più svariate applicazioni, di seguito alcuni esempi, MJ DIN ISO 5855, NPSFR ANSI B1.20.3, W keg DIN 477, W zyl DIN 477, EG M DIN 8140-2, LK-M, Tr DIN 103, Tr-F DIN 103, Rd DIN 405...

With the FIL threading mills by IGUTENSILI the threading operations are performed quickly and productively without sacrificing the quality of the processing.
These tools can be used on a very wide range of CNC machines such as WORK CENTRES, TURNING CENTRES, TRANSFER and also on ADVANCED PRODUCTION LINES where it is possible to reduce both processing and tooling time; the FIL tools can be used on machines with at least 3 moving axes. The FIL-Threading mill is a consequence of this commitment in making threads in a FAST way and with the maximum EFFECTIVENESS.

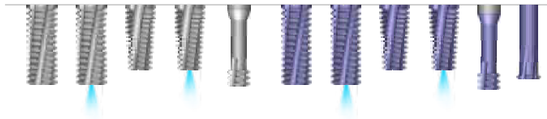
The union of the two tools and, consequently, two machining processes merged into a single tool, offer significant savings, reduced machine times and simplified tool management. The FIL range includes different types of tools from the mill for threading only up to the tool that DRILL-TAPER-THREAD in a single solution, even on materials with hardness equal to 65 HRC, the FIL range of tools is equipped with INTERNAL HEAD and RADIAL forced COOLANT, guaranteeing in this way an excellent lubrication at the cutting point and an excellent chip evacuation.
These tools ensure reduced roughness, maximum dimensional accuracy, reducing burr production to a minimum, thus eliminating subsequent cleaning/deburring operations.

The FIL-Threading tools are TNF or LTM coated according to the material to be processed, reaching high cutting values and long life, always guaranteeing the maximum stability of the production cycle; also, FIL, despite the complex manufacturing technology, allow sharpening and coating operations, giving the tool a new lease of life with excellent yields.
Not to underestimate the possibility of producing special FIL Threading Mills with special designs, IGUTENSILI is able to develop an infinite range of threads for the most varied applications, below some examples, MJ DIN ISO 5855, NPSFR ANSI B1.20.3, W keg DIN 477, W zyl DIN 477, EG M DIN 8140-2, LK-M, Tr DIN 103, Tr-F DIN 103, Rd DIN 405...

The cutting speeds (vc in m/min) listed in the respective columns are standard values which have to be adjusted to individual work conditions (material, lubrication, machine etc.). International comparison of materials, see page Z • 21

Vc = Velocità di taglio (m/min)
Fz = Avanzamento per dente (mm)

Vc = Cuttind speed (m/min)
Fz = Feed for tooth (mm)



							M	4D 17, 4D 19, 4D 65, 4D 67	4D 17, 4D 19, 4D 65, 4D 67, 4D 73				M
							MF	4D 17, 4D 19	4D 17, 4D 19				MF
							UNC	4D 21, 4D 23, 4D 69, 4D 71	4D 21, 4D 23, 4D 69, 4D 71				UNC
							UNF	4D 21, 4D 23, 4D 69, 4D 71	4D 21, 4D 23, 4D 69, 4D 71				UNF
							G, RP, W	4D 25, 4D 27	4D 25, 4D 27				G, RP, W
							BSW,BSF	4D 29	4D 29				BSW,BSF
							NPT	4D 51, 4D 53	4D 51, 4D 53				NPT
							NPTF	4D 55, 4D 57	4D 55, 4D 57				NPTF
							BSPT	4D 59, 4D 61	4D 59, 4D 61				BSPT
							MJ	4D 75, 4D 77, 4D 83, 4D 85	4D 75, 4D 77, 4D 83, 4D 85				MJ
							UNJ	4D 79, 4D 81, 4D 87, 4D 89	4D 79, 4D 81, 4D 87, 4D 89				UNJ
							M-EXT, MJ-EXT	4D 91, 4D 93, 4D 95, 4D 97, 4D 99, 4D 101	4D 91, 4D 93, 4D 95, 4D 97, 4D 99, 4D 101				M-EXT, MJ-EXT
							PG	4D 117	4D 117				PG
							EGM	4D 103, 4D 105	4D 103, 4D 105				EGM
		Materiale	Material		Material examples	Mat. numbers		Vc Uncoated	Vc Coated TNF	f z ø d1 ≤ 4 mm	f z ø d1 ≤ 8 mm	f z ø d1 > 8 mm		
P		Acciai	Steel materials											P
	1.1	Acciai estrusi a freddo	Cold-extrusion steel	≤ 600 N/mm2	Cq15	1.1132		40 - 100	80 - 250	0,005 - 0,04	0,04 - 0,07	0,05 - 0,15		1.1
		Acciai da costruzione	Costruction steels		S235JR (St37-2)	1.0037								
		Acciai alta velocità	Free-cutting steel, etc.		10SPb20	1.0722								
	2.1	Acciai da costruzione	Costruction steels	≤ 800 N/mm2	E360 (St70-2)	1.0070		30 - 80	60 - 150	0,005 - 0,04	0,04 - 0,07	0,05 - 0,15		2.1
		Acciai da cementazione	Cementation steel		16MnCr5	1.7131								
		Fusione d'acciaio, ecc.	Steel casting, etc.		GS-25CrMo4	1.7218								
	3.1	Acciai da cementazione	Cementation steel	≤ 1000 N/mm2	20MoCr3	1.7320		20 - 60	40 - 120	0,005 - 0,03	0,03 - 0,05	0,04 - 0,12		3.1
		Acciai da bonifica	Heat-treatable steels		42CrMo4	1.7225								
		Acciai per lavorazioni a freddo, ecc.	Cold work steels, etc.		102Cr6	1.2067								
	4.1	Acciai da bonifica	Heat-treatable steels	≤ 1200 N/mm2	50CrMo4	1.7228		20 - 60	40 - 120	0,003 - 0,02	0,02 - 0,05	0,04 - 0,12		4.1
		Acciai per lavorazioni a freddo	Cold work steels		X45NiCrMo4	1.2767								
		Acciai da nitrurazione, ecc.	Nitriding steels, etc.		31CrMo12	1.8515								
	5.1	Acciai fortemente legati	High-alloyed steels	≤ 1400 N/mm2	X38CrMoV5-3	1.2367		20 - 60	40 - 120	0,003 - 0,02	0,02 - 0,05	0,04 - ,12		5.1
		Acciai per lavorazioni a freddo	Cold work steels		X100CrMoV8-1-1	1.2990								
		Acciai per lavorazioni a caldo, ecc.	Hot work steels, etc.		X40CrMoV5-1	1.2344								
M		Acciai inossidabili	Stainless steel materials											M
	1.1	Ferritici, martensitici	Ferritic, martensitic	≤ 950 N/mm2	X2CrTi12	1.4512			40 - 120	0,003 - 0,03	0,03 - 0,05	0,04 - 0,12		1.1
	2.1	Austenitici	Austenitic	≤ 950 N/mm2	X6CrNiMoTi17-12-2	1.4571			40 - 120	0,003 - 0,03	0,03 - 0,05	0,04 - 0,12		2.1
	3.1	Austenitici-ferritici (Duplex)	Austenitic-ferritic (Duplex)	≤ 1100 N/mm2	X2CrNiMoN22-5-3	1.4462			30 - 80	0,003 - 0,02	0,02 - 0,05	0,04 - 0,10		3.1
	4.1	Austenitici-ferritici resistenti al calore (Super Duplex)	Austenitic-ferritic heat-resistant (Super Duplex)	≤ 1250 N/mm2	X2CrNiMoN25-7-4	1.4410			30 - 60	0,003 - 0,02	0,02 - 0,04	0,03 - 0,08		4.1
K		Ghise	Cast materials											K
	1.1	Ghise con grafite lamellare (GJL)	Cast iron with lamellar graphite (GJL)	100-250 N/mm2	EN-GJL-200 (GG20)	EN-JL-1030		80 - 140	100 - 200		0,04 - 0,07	0,05 - 0,15		1.1
	1.2			250-450 N/mm2	EN-GJL-300 (GG30)	EN-JL-1050		80 - 140	100 - 200		0,04 - 0,07	0,05 - 0,15		1.2
	2.1	Ghise con grafite nodulare (GJS)	Cast iron with nodular graphite (GJS)	350-500 N/mm2	EN-GJS-400-15 (GGG40)	EN-JS-1030		60 - 120	80 - 200		0,04 - 0,07	0,05 - 0,15		2.1
	2.2			500-900 N/mm2	EN-GJS-700-2 (GGG70)	EN-JS-1070		60 - 120	80 - 200		0,04 - 0,07	0,05 - 0,15		2.2
	3.1	Ghise con grafite vermicolare (GJV)	Cast iron with vermicular graphite (GJV)	300-400 N/mm2	GJV 300			60 - 120	80 - 200		0,04 - 0,07	0,05 - 0,15		3.1
	3.2			400-500 N/mm2	GJV 450			60 - 120	80 - 200		0,04 - 0,07	0,05 - 0,15		3.2
	4.1	Ghise malleabili (GTMW, GTMB)	Malleable cast iron (GTMW, GTMB)	250-500 N/mm2	EN-GJMW-350-4 (GTW-35)	EN-JM-1010		60 - 120	80 - 200		0,04 - 0,07	0,05 - 0,15		4.1
	4.2			500-800 N/mm2	EN-GJMB-450-6 (GTS-45)	EN-JM-1140		60 - 120	80 - 200		0,04 - 0,07	0,05 - 0,15		4.2
N		Materiali non ferrosi	Non ferrous materials											N
		Leghe di alluminio	Aluminium alloys											
	1.1	Leghe di alluminio malleabili	Aluminium wrought alloys	≤ 200 N/mm2	EN AW-AlMn1	EN AW-3103		100 - 250	150 - 400	0,01 - 0,05	0,05 - 0,08	0,07 - 0,20		1.1
	1.2			≤ 350 N/mm2	EN AW-AlMgSi	EN AW-6060		100 - 250	150 - 400	0,01 - 0,05	0,05 - 0,08	0,07 - 0,20		1.2
	1.3			≤ 550 N/mm2	EN AW-AlZn5Mg3Cu	EN AW-7022		100 - 250	150 - 400	0,01 - 0,05	0,05 - 0,08	0,07 - 0,20		1.3
	1.4	Leghe fuse di alluminio	Aluminium cast alloys	Si ≤ 7%	EN AC-AlMg5	EN AC-51300		150 - 250	150 - 400	0,01 - 0,05	0,05 - 0,08	0,07 - 0,20		1.4
	1.5			7% < Si ≤ 12%	EN AC-AlSi9Cu3	EN AC-46500		150 - 250	150 - 400	0,01 - 0,05	0,05 - 0,08	0,07 - 0,20		1.5
	1.6			12% < Si ≤ 17%	GD-AlSi17Cu4FeMg				100 - 200	0,01 - 0,05	0,05 - 0,08	0,07 - 0,20		1.6
		Leghe di rame	Copper alloys											
	2.1	Rame puro, Rame poco legato	Pure copper, low-alloyed copper	≤ 400 N/mm2	E-Cu 57	EN CW 004 A		100 - 250	150 - 400	0,008 - 0,05	0,05 - 0,08	0,07 - 0,20		2.1
	2.2	Leghe rame-zinco (ottone, truciolo lungo)	Copper-zinc alloys (brass, long-chipping)	≤ 550 N/mm2	CuZn37 (Ms63)	EN CW 508 L		100 - 250	150 - 400	0,008 - 0,05	0,05 - 0,08	0,07 - 0,20		2.2
	2.3	Leghe rame-zinco (ottone, truciolo corto)	Copper-zinc alloys (brass, short-chipping)	≤ 550 N/mm2	CuZn36Pb3 (Ms58)	EN CW 603 N		100 - 250	150 - 400	0,008 - 0,05	0,05 - 0,08	0,07 - 0,20		2.3
	2.4	Leghe rame-alluminio (alubronzo, truciolo lungo)	Copper-aluminium alloys (alu bronze, long-chipping)	≤ 800 N/mm2	CuAl10Ni5Fe4	EN CW 307 G		60 - 150	100 - 250	0,008 - 0,04	0,04 - 0,07	0,05 - 0,15		2.4
	2.5	Leghe rame-stagno (bronzo, truciolo lungo)	Copper-tin alloys (tin bronze, long-chipping)	≤ 700 N/mm2	CuSn8P	EN CW 459 K		60 -150	100 - 250	0,008 - 0,04	0,04 - 0,07	0,05 - 0,15		2.5
	2.6	Leghe rame-stagno (bronzo, truciolo corto)	Copper-tin alloys (tin bronze, short-chipping)	≤ 400 N/mm2	CuSn7 ZnPb (Rg7)	2.1090		80 - 200	100 - 250	0,008 - 0,04	0,04 - 0,07	0,05 - 0,15		2.6
	2.7	Leghe di rame speciali	Special copper alloys	≤ 600 N/mm2	(AMPCO® 8)				40 - 80	0,003 - 0,02	0,02 - 0,04	0,04 - 0,15		2.7
	2.8			≤ 1400 N/mm2	(AMPCO® 45)									
		Leghe di magnesio	Magnesium alloys											
	3.1	Leghe di magnesio malleabili	Magnesium wrought alloys	≤ 500 N/mm2	MgAl6Zn	3.5612		150 - 250	150 - 400	0,01 - 0,05	0,05 - 0,08	0,07 - 0,20		3.1
	3.2	Leghe per getti di magnesio	Magnesium cast alloys	≤ 500 N/mm2	EN-MCMgAl9Zn1	EN-MC21120		150 - 250	150 - 400	0,01 - 0,05	0,05 - 0,08	0,07 - 0,20		3.2
		Materie plastiche	Synthetics											
	4.1	Materie plastiche termoindurenti (truciolo corto)	Duroplastics (short-chipping)		Bakelit, Pertinax			60 - 150		0,01 - 0,05	0,05 - 0,10	0,08 - 0,25		4.1
	4.2	Resine termoplastiche (truciolo lungo)	Thermoplastics (long-chipping)		PMMA, POM, PVC			60 - 150		0,01 - 0,05	0,05 - 0,10	0,08 - 0,25		4.2
	4.3	Resine epossidiche (percentuale di fibre ≤ 30%)	Fibre-reinforced synthetics (fibre content ≤ 30%)		GFK, CFK, AFK				80 - 120	0,01 - 0,05	0,05 - 0,10	0,08 - 0,25		4.3
	4.4	Resine epossidiche (percentuale di fibre > 30%)	Fibre-reinforced synthetics (fibre content > 30%)		GFK, CFK, AFK				80 - 120	0,01 - 0,05	0,05 - 0,10	0,08 - 0,25		4.4
		Materiali speciali	Special materials											
	5.1	Grafite	Graphite		C 8000				100 - 200		0,04 - 0,07	0,08 - 0,25		5.1
	5.2	Leghe tungsteno-rame	Tungsten-copper alloys		W-Cu 80/20			15 - 40	30 - 60		0,02 - 0,04	0,08 - 0,25		5.2
	5.3	Materiali compositi	Composite materials		Hylite, Alucobond							0,08 - 0,25		5.3
S		Materiali speciali	Special materials											S
		Leghe di titanio	Titanium alloys											
	1.1	Titanio puro	Pure titanium	≤ 450 N/mm2	Ti1	3.7025		15 - 50	30 - 80	0,003 - 0,03	0,03 - 0,05	0,04 - 0,10		1.1
	1.2	Leghe di titanio	Titanium alloys	≤ 900 N/mm2	TiAl6V4	3.7165		15 - 50	30 - 80	0,003 - 0,03	0,03 - 0,05	0,04 - 0,10		1.2
	1.3			≤ 1250 N/mm2	TiAl4Mo4Sn2	3.7185		15 - 40	30 - 60	0,003 - 0,02	0,02 - 0,04	0,03 - 0,08		1.3
		Leghe di nichel, cobalto e ferro	Nickel alloys, cobalt alloys and iron alloys											
	2.1	Nichel puro	Pure nickel	≤ 600 N/mm2	Ni 99,6	2.4060			30 - 60	0,003 - 0,02	0,02 - 0,04	0,03 - 0,08		2.1
	2.2	Leghe base nichel	Nickel-base alloys	≤ 1000 N/mm2	Monel 400	2.4360			30 - 60	0,003 - 0,02	0,02 - 0,04	0,03 - 0,08		2.2
	2.3			≤ 1600 N/mm2	Inconel 718	2.4668								2.3
	2.4	Leghe base cobalto	Cobalt-base alloys	≤ 1000 N/mm2	Udimet 605				30 - 40	0,003 - 0,02	0,02 - 0,04	0,03 - 0,08		2.4
	2.5			≤ 1600 N/mm2	Haynes 25	2.4964								2.5
	2.6	Leghe base ferro	Iron-base alloys	≤ 1500 N/mm2	Incoloy 800	1.4958			30 - 40	0,003 - 0,02	0,02 - 0,04	0,03 - 0,08		2.6
H		Materiali duri	Hard materials											H
	1.1	"Acciai ad alta resistenza, Acciai temprati, Ghise in conchiglia	High strength steels, hardened steels, hard castings"	44 - 50 HRC	Weldox 1100				30 - 60		0,015 - 0,03	0,03 - 0,08		1.1
	1.2			50 - 55 HRC	Hardox 550				30 - 60		0,015 - 0,03	0,03 - 0,08		1.2
	1.3			55 - 60 HRC	Armox 600T									1.3
	1.4			60 - 63 HRC	Ferro-Titanit									1.4
	1.5			63 - 66 HRC	HSSE									1.5

FIL

FIL

The cutting speeds (vc in m/min) listed in the respective columns are standard values which have to be adjusted to individual work conditions (material, lubrication, machine etc.). International comparison of materials, see page Z • 21

Vc = Velocità di taglio (m/min) — Vc = Cuttind speed (m/min)
Fz = Avanzamento per dente (mm) — Fz = Feed for tooth (mm)
Fb = Avanzamento di foratura (mm/giro) — Fb = Drilling feed (mm/U)

													M
													MF
													UNC
													UNF
													G, RP, W
													BSW,BSF
													NPT
													NPTF
													BSPT
													MJ
													UNJ
													M-EXT, MJ-EXT
													PG
													EGM

		Materiale	Material		Material examples	Mat. numbers	Vc Uncoated	Vc Coated TNF	f b ø d1 ≤ 8 mm	f b ø d1 > 8 mm	f z ø d1 ≤ 8 mm	f z ø d1 > 8 mm		
P		Acciai	Steel materials				4D 31, 4D 33, 4D 35	4D 31, 4D 33, 4D 35, 4D 49						P
		Acciai estrusi a freddo	Cold-extrusion steel		Cq15	1.1132	4D 31, 4D 33, 4D 35	4D 31, 4D 33, 4D 35, 4D 49						
	1.1	Acciai da costruzione	Costruction steels	≤ 600 N/mm2	S235JR (St37-2)	1.0037	4D 37, 4D 39, 4D 41	4D 37, 4D 39, 4D 41						
		Acciai alta velocità	Free-cutting steel, etc.		10SPb20	1.0722	4D 37, 4D 39, 4D 41	4D 37, 4D 39, 4D 41						
		Acciai da costruzione	Costruction steels		E360 (St70-2)	1.0070	4D 43, 4D 45, 4D 47	4D 43, 4D 45, 4D 47						
	2.1	Acciai da cementazione	Cementation steel	≤ 800 N/mm2	16MnCr5	1.7131								
		Fusione d'acciaio, ecc.	Steel casting, etc.		GS-25CrMo4	1.7218								
		Acciai da cementazione	Cementation steel		20MoCr3	1.7320								
	3.1	Acciai da bonifica	Heat-treatable steels	≤ 1000 N/mm2	42CrMo4	1.7225								
		Acciai per lavorazioni a freddo, ecc.	Cold work steels, etc.		102Cr6	1.2067								
		Acciai da bonifica	Heat-treatable steels		50CrMo4	1.7228								
	4.1	Acciai per lavorazioni a freddo	Cold work steels	≤ 1200 N/mm2	X45NiCrMo4	1.2767								
		Acciai da nitrurazione, ecc.	Nitriding steels, etc.		31CrMo12	1.8515								
		Acciai fortemente legati	High-alloyed steels		X38CrMoV5-3	1.2367								
	5.1	Acciai per lavorazioni a freddo	Cold work steels	≤ 1400 N/mm2	X100CrMoV8-1-1	1.2990								
		Acciai per lavorazioni a caldo, ecc.	Hot work steels, etc.		X40CrMoV5-1	1.2344								
M		Acciai inossidabili	Stainless steel materials											M
	1.1	Ferritici, martensitici	Ferritic, martensitic	≤ 950 N/mm2	X2CrTi12	1.4512							1.1	
	2.1	Austenitici	Austenitic	≤ 950 N/mm2	X6CrNiMoTi17-12-2	1.4571							2.1	
	3.1	Austenitici-ferritici (Duplex)	Austenitic-ferritic (Duplex)	≤ 1100 N/mm2	X2CrNiMoN22-5-3	1.4462							3.1	
	4.1	Austenitici-ferritici resistenti al calore (Super Duplex)	Austenitic-ferritic heat-resistant (Super Duplex)	≤ 1250 N/mm2	X2CrNiMoN25-7-4	1.4410							4.1	
K		Ghise	Cast materials											K
	1.1	Ghise con grafite lamellare (GJL)	Cast iron with lamellar graphite (GJL)	100-250 N/mm2	EN-GJL-200 (GG20)	EN-JL-1030	80 - 140	80 - 160	0,10 - 0,25	0,20 - 0,40	0,04 - 0,07	0,05 - 0,12	1.1	
	1.2			250-450 N/mm2	EN-GJL-300 (GG30)	EN-JL-1050	80 - 140	80 - 160	0,10 - 0,25	0,20 - 0,40	0,04 - 0,07	0,05 - 0,12	1.2	
	2.1	Ghise con grafite nodulare (GJS)	Cast iron with nodular graphite (GJS)	350-500 N/mm2	EN-GJS-400-15 (GGG40)	EN-JS-1030	80 - 140	80 - 160	0,10 - 0,25	0,15 - 0,25	0,04 - 0,07	0,05 - 0,12	2.1	
	2.2			500-900 N/mm2	EN-GJS-700-2 (GGG70)	EN-JS-1070	80 - 140	80 - 160	0,10 - 0,25	0,15 - 0,25	0,04 - 0,07	0,05 - 0,12	2.2	
	3.1	Ghise con grafite vermicolare (GJV)	Cast iron with vermicular graphite (GJV)	300-400 N/mm2	GJV 300		80 - 140	80 - 160	0,10 - 0,25	0,20 - 0,40	0,04 - 0,07	0,05 - 0,12	3.1	
	3.2			400-500 N/mm2	GJV 450		80 - 140	80 - 160	0,10 - 0,25	0,20 - 0,40	0,04 - 0,07	0,05 - 0,12	3.2	
	4.1	Ghise malleabili (GTMW, GTMB)	Malleable cast iron (GTMW, GTMB)	250-500 N/mm2	EN-GJMW-350-4 (GTW-35)	EN-JM-1010							4.1	
	4.2			500-800 N/mm2	EN-GJMB-450-6 (GTS-45)	EN-JM-1140							4.2	
N		Materiali non ferrosi	Non ferrous materials											N
		Leghe di alluminio	Aluminium alloys											
	1.1	Leghe di alluminio malleabili	Aluminium wrought alloys	≤ 200 N/mm2	EN AW-AlMn1	EN AW-3103	100 - 250	150 - 250	0,08 - 0,15	0,15 - 0,25	0,04 - 0,08	0,07 -0,15	1.1	
	1.2			≤ 350 N/mm2	EN AW-AlMgSi	EN AW-6060	100 - 250	150 - 250	0,08 - 0,15	0,15 - 0,25	0,04 - 0,08	0,07 -0,15	1.2	
	1.3			≤ 550 N/mm2	EN AW-AlZn5Mg3Cu	EN AW-7022	100 - 250	150 - 250	0,08 - 0,15	0,15 - 0,25	0,04 - 0,08	0,07 -0,15	1.3	
	1.4	Leghe fuse di alluminio	Aluminium cast alloys	Si ≤ 7%	EN AC-AlMg5	EN AC-51300	150 - 250	150 - 400	0,15 - 0,25	0,20 - 0,40	0,04 - 0,08	0,07 -0,15	1.4	
	1.5			7% < Si ≤ 12%	EN AC-AlSi9Cu3	EN AC-46500	150 - 250	150 - 400	0,15 - 0,25	0,20 - 0,40	0,04 - 0,08	0,07 -0,15	1.5	
	1.6			12% < Si ≤ 17%	GD-AlSi17Cu4FeMg			100 - 200	0,15 - 0,25	0,20 - 0,40	0,04 - 0,08	0,07 -0,15	1.6	
		Leghe di rame	Copper alloys											
	2.1	Rame puro, Rame poco legato	Pure copper, low-alloyed copper	≤ 400 N/mm2	E-Cu 57	EN CW 004 A							2.1	
	2.2	Leghe rame-zinco (ottone, truciolo lungo)	Copper-zinc alloys (brass, long-chipping)	≤ 550 N/mm2	CuZn37 (Ms63)	EN CW 508 L	100 - 250	150 - 400	0,10 - 0,20	0,15 - 0,30	0,05 - 0,08	0,07 - 0,15	2.2	
	2.3	Leghe rame-zinco (ottone, truciolo corto)	Copper-zinc alloys (brass, short-chipping)	≤ 550 N/mm2	CuZn36Pb3 (Ms58)	EN CW 603 N	100 - 250	150 - 400	0,10 - 0,20	0,15 - 0,30	0,05 - 0,08	0,07 - 0,15	2.3	
	2.4	Leghe rame-alluminio (alubronzo, truciolo lungo)	Copper-aluminium alloys (alu bronze, long-chipping)	≤ 800 N/mm2	CuAl10Ni5Fe4	EN CW 307 G							2.4	
	2.5	Leghe rame-stagno (bronzo, truciolo lungo)	Copper-tin alloys (tin bronze, long-chipping)	≤ 700 N/mm2	CuSn8P	EN CW 459 K							2.5	
	2.6	Leghe rame-stagno (bronzo, truciolo corto)	Copper-tin alloys (tin bronze, short-chipping)	≤ 400 N/mm2	CuSn7 ZnPb (Rg7)	2.1090	80 - 200	100 - 250	0,10 - 0,25	0,20 - 0,40	0,04 - 0,07	0,05 - 0,12	2.6	
	2.7	Leghe di rame speciali	Special copper alloys	≤ 600 N/mm2	(AMPCO® 8)								2.7	
	2.8			≤ 1400 N/mm2	(AMPCO® 45)									
		Leghe di magnesio	Magnesium alloys											
	3.1	Leghe di magnesio malleabili	Magnesium wrought alloys	≤ 500 N/mm2	MgAl6Zn	3.5612	100 - 250	150 - 400	0,10 - 0,20	0,15 - 0,30	0,04 - 0,08	0,07 - 0,15	3.1	
	3.2	Leghe per getti di magnesio	Magnesium cast alloys	≤ 500 N/mm2	EN-MCMgAl9Zn1	EN-MC21120	100 - 250	150 - 400	0,15 - 0,30	0,20 - 0,40	0,4 - 0,08	0,07 - 0,15	3.2	
		Materie plastiche	Synthetics											
	4.1	Materie plastiche termoindurenti (truciolo corto)	Duroplastics (short-chipping)		Bakelit, Pertinax		60 - 150	100 - 400	0,15 - 0,30	0,20 - 0,40	0,05 - 0,10	0,08 - 0,20	4.1	
	4.2	Resine termoplastiche (truciolo lungo)	Thermoplastics (long-chipping)		PMMA, POM, PVC								4.2	
	4.3	Resine epossidiche (percentuale di fibre ≤ 30%)	Fibre-reinforced synthetics (fibre content ≤ 30%)		GFK, CFK, AFK								4.3	
	4.4	Resine epossidiche (percentuale di fibre > 30%)	Fibre-reinforced synthetics (fibre content > 30%)		GFK, CFK, AFK								4.4	
		Materiali speciali	Special materials											
	5.1	Grafite	Graphite		C 8000								5.1	
	5.2	Leghe tungsteno-rame	Tungsten-copper alloys		W-Cu 80/20								5.2	
	5.3	Materiali compositi	Composite materials		Hylite, Alucobond								5.3	
S		Materiali speciali	Special materials											S
		Leghe di titanio	Titanium alloys											
	1.1	Titanio puro	Pure titanium	≤ 450 N/mm2	Ti1	3.7025							1.1	
	1.2	Leghe di titanio	Titanium alloys	≤ 900 N/mm2	TiAl6V4	3.7165							1.2	
	1.3			≤ 1250 N/mm2	TiAl4Mo4Sn2	3.7185							1.3	
		Leghe di nichel, cobalto e ferro	Nickel alloys, cobalt alloys and iron alloys											
	2.1	Nichel puro	Pure nickel	≤ 600 N/mm2	Ni 99,6	2.4060							2.1	
	2.2	Leghe base nichel	Nickel-base alloys	≤ 1000 N/mm2	Monel 400	2.4360							2.2	
	2.3			≤ 1600 N/mm2	Inconel 718	2.4668							2.3	
	2.4	Leghe base cobalto	Cobalt-base alloys	≤ 1000 N/mm2	Udimet 605								2.4	
	2.5			≤ 1600 N/mm2	Haynes 25	2.4964							2.5	
	2.6	Leghe base ferro	Iron-base alloys	≤ 1500 N/mm2	Incoloy 800	1.4958							2.6	
H		Materiali duri	Hard materials											H
	1.1	"Acciai ad alta resistenza, Acciai temprati, Ghise in conchiglia	High strength steels, hardened steels, hard castings"	44 - 50 HRC	Weldox 1100								1.1	
	1.2			50 - 55 HRC	Hardox 550								1.2	
	1.3			55 - 60 HRC	Armox 600T								1.3	
	1.4			60 - 63 HRC	Ferro-Titanit								1.4	
	1.5			63 - 66 HRC	HSSE								1.5	

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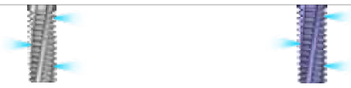
The cutting speeds (vc in m/min) listed in the respective columns are standard values which have to be adjusted to individual work conditions (material, lubrication, machine etc.). International comparison of materials, see page Z • 21

Vc = Velocità di taglio (m/min)
Fz = Avanzamento per dente (mm)

Vc = Cuttind speed (m/min)
Fz = Feed for tooth (mm)



								4D 17, 4D 19	4D 17, 4D 19				M
								4D 17, 4D 19	4D 17, 4D 19				MF
								4D 21, 4D 23	4D 21, 4D 23				UNC
								4D 21, 4D 23	4D 21, 4D 23				UNF
								4D 25, 4D 27	4D 25, 4D 27				G, RP, W
													BSW,BSF
													NPT
													NPTF
													BSPT
													MJ
													UNJ
													M-EXT, MJ-EXT
													PG
													EGM
		Materiale	Material		Material examples	Mat. numbers		Vc Uncoated	Vc Coated TNF	f z ø d1 ≤ 4 mm	f z ø d1 ≤ 8 mm	f z ø d1 > 8 mm			
P		Acciai	Steel materials												P
	1.1	Acciai estrusi a freddo	Cold-extrusion steel		Cq15	1.1132									
		Acciai da costruzione	Costruction steels	≤ 600 N/mm2	S235JR (St37-2)	1.0037		40 - 100	80 - 250	0,005 - 0,04	0,04 - 0,07	0,05 - 0,15		1.1	
		Acciai alta velocità	Free-cutting steel, etc.		10SPb20	1.0722									
	2.1	Acciai da costruzione	Costruction steels		E360 (St70-2)	1.0070									
		Acciai da cementazione	Cementation steel	≤ 800 N/mm2	16MnCr5	1.7131		30 - 80	60 - 150	0,005 - 0,04	0,04 - 0,07	0,05 - 0,15		2.1	
		Fusione d'acciaio, ecc.	Steel casting, etc.		GS-25CrMo4	1.7218									
	3.1	Acciai da cementazione	Cementation steel		20MoCr3	1.7320									
		Acciai da bonifica	Heat-treatable steels	≤ 1000 N/mm2	42CrMo4	1.7225		20 - 60	40 - 120	0,005 - 0,03	0,03 - 0,05	0,04 - 0,12		3.1	
		Acciai per lavorazioni a freddo, ecc.	Cold work steels, etc.		102Cr6	1.2067									
	4.1	Acciai da bonifica	Heat-treatable steels		50CrMo4	1.7228									
		Acciai per lavorazioni a freddo	Cold work steels	≤ 1200 N/mm2	X45NiCrMo4	1.2767		20 - 60	40 - 120	0,003 - 0,02	0,02 - 0,05	0,04 - 0,12		4.1	
		Acciai da nitrurazione, ecc.	Nitriding steels, etc.		31CrMo12	1.8515									
	5.1	Acciai fortemente legati	High-alloyed steels		X38CrMoV5-3	1.2367									
		Acciai per lavorazioni a freddo	Cold work steels	≤ 1400 N/mm2	X100CrMoV8-1-1	1.2990		20 - 60	40 - 120	0,003 - 0,02	0,02 - 0,05	0,04 - ,12		5.1	
		Acciai per lavorazioni a caldo, ecc.	Hot work steels, etc.		X40CrMoV5-1	1.2344									
M		Acciai inossidabili	Stainless steel materials												M
	1.1	Ferritici, martensitici	Ferritic, martensitic	≤ 950 N/mm2	X2CrTi12	1.4512			40 - 120	0,003 - 0,03	0,03 - 0,05	0,04 - 0,12		1.1	
	2.1	Austenitici	Austenitic	≤ 950 N/mm2	X6CrNiMoTi17-12-2	1.4571			40 - 120	0,003 - 0,03	0,03 - 0,05	0,04 - 0,12		2.1	
	3.1	Austenitici-ferritici (Duplex)	Austenitic-ferritic (Duplex)	≤ 1100 N/mm2	X2CrNiMoN22-5-3	1.4462			30 - 80	0,003 - 0,02	0,02 - 0,05	0,04 - 0,10		3.1	
	4.1	Austenitici-ferritici resistenti al calore (Super Duplex)	Austenitic-ferritic heat-resistant (Super Duplex)	≤ 1250 N/mm2	X2CrNiMoN25-7-4	1.4410			30 - 60	0,003 - 0,02	0,02 - 0,04	0,03 - 0,08		4.1	
K		Ghise	Cast materials												K
	1.1	Ghise con grafite lamellare (GJL)	Cast iron with lamellar graphite (GJL)	100-250 N/mm2	EN-GJL-200 (GG20)	EN-JL-1030		80 - 140	100 - 200		0,04 - 0,07	0,05 - 0,15		1.1	
	1.2			250-450 N/mm2	EN-GJL-300 (GG30)	EN-JL-1050		80 - 140	100 - 200		0,04 - 0,07	0,05 - 0,15		1.2	
	2.1	Ghise con grafite nodulare (GJS)	Cast iron with nodular graphite (GJS)	350-500 N/mm2	EN-GJS-400-15 (GGG40)	EN-JS-1030		60 - 120	80 - 200		0,04 - 0,07	0,05 - 0,15		2.1	
	2.2			500-900 N/mm2	EN-GJS-700-2 (GGG70)	EN-JS-1070		60 - 120	80 - 200		0,04 - 0,07	0,05 - 0,15		2.2	
	3.1	Ghise con grafite vermicolare (GJV)	Cast iron with vermicular graphite (GJV)	300-400 N/mm2	GJV 300			60 - 120	80 - 200		0,04 - 0,07	0,05 - 0,15		3.1	
	3.2			400-500 N/mm2	GJV 450			60 - 120	80 - 200		0,04 - 0,07	0,05 - 0,15		3.2	
	4.1	Ghise malleabili (GTMW, GTMB)	Malleable cast iron (GTMW, GTMB)	250-500 N/mm2	EN-GJMW-350-4 (GTW-35)	EN-JM-1010		60 - 120	80 - 200		0,04 - 0,07	0,05 - 0,15		4.1	
	4.2			500-800 N/mm2	EN-GJMB-450-6 (GTS-45)	EN-JM-1140		60 - 120	80 - 200		0,04 - 0,07	0,05 - 0,15		4.2	
N		Materiali non ferrosi	Non ferrous materials												N
		Leghe di alluminio	Aluminium alloys												
	1.1	Leghe di alluminio malleabili	Aluminium wrought alloys	≤ 200 N/mm2	EN AW-AlMn1	EN AW-3103		100 - 250	150 - 400	0,01 - 0,05	0,05 - 0,08	0,07 - 0,20		1.1	
	1.2			≤ 350 N/mm2	EN AW-AlMgSi	EN AW-6060		100 - 250	150 - 400	0,01 - 0,05	0,05 - 0,08	0,07 - 0,20		1.2	
	1.3			≤ 550 N/mm2	EN AW-AlZn5Mg3Cu	EN AW-7022		100 - 250	150 - 400	0,01 - 0,05	0,05 - 0,08	0,07 - 0,20		1.3	
	1.4	Leghe fuse di alluminio	Aluminium cast alloys	Si ≤ 7%	EN AC-AlMg5	EN AC-51300		150 - 250	150 - 400	0,01 - 0,05	0,05 - 0,08	0,07 - 0,20		1.4	
	1.5			7% < Si ≤ 12%	EN AC-AlSi9Cu3	EN AC-46500		150 - 250	150 - 400	0,01 - 0,05	0,05 - 0,08	0,07 - 0,20		1.5	
	1.6			12% < Si ≤ 17%	GD-AlSi17Cu4FeMg				100 - 200	0,01 - 0,05	0,05 - 0,08	0,07 - 0,20		1.6	
		Leghe di rame	Copper alloys												
	2.1	Rame puro, Rame poco legato	Pure copper, low-alloyed copper	≤ 400 N/mm2	E-Cu 57	EN CW 004 A		100 - 250	150 - 400	0,008 - 0,05	0,05 - 0,08	0,07 - 0,20		2.1	
	2.2	Leghe rame-zinco (ottone, truciolo lungo)	Copper-zinc alloys (brass, long-chipping)	≤ 550 N/mm2	CuZn37 (Ms63)	EN CW 508 L		100 - 250	150 - 400	0,008 - 0,05	0,05 - 0,08	0,07 - 0,20		2.2	
	2.3	Leghe rame-zinco (ottone, truciolo corto)	Copper-zinc alloys (brass, short-chipping)	≤ 550 N/mm2	CuZn36Pb3 (Ms58)	EN CW 603 N		100 - 250	150 - 400	0,008 - 0,05	0,05 - 0,08	0,07 - 0,20		2.3	
	2.4	Leghe rame-alluminio (alubronzo, truciolo lungo)	Copper-aluminium alloys (alu bronze, long-chipping)	≤ 800 N/mm2	CuAl10Ni5Fe4	EN CW 307 G		60 - 150	100 - 250	0,008 - 0,04	0,04 - 0,07	0,05 - 0,15		2.4	
	2.5	Leghe rame-stagno (bronzo, truciolo lungo)	Copper-tin alloys (tin bronze, long-chipping)	≤ 700 N/mm2	CuSn8P	EN CW 459 K		60 -150	100 - 250	0,008 - 0,04	0,04 - 0,07	0,05 - 0,15		2.5	
	2.6	Leghe rame-stagno (bronzo, truciolo corto)	Copper-tin alloys (tin bronze, short-chipping)	≤ 400 N/mm2	CuSn7 ZnPb (Rg7)	2.1090		80 - 200	100 - 250	0,008 - 0,04	0,04 - 0,07	0,05 - 0,15		2.6	
	2.7	Leghe di rame speciali	Special copper alloys	≤ 600 N/mm2	(AMPCO® 8)				40 - 80	0,003 - 0,02	0,02 - 0,04	0,04 - 0,15		2.7	
	2.8			≤ 1400 N/mm2	(AMPCO® 45)									2.8	
		Leghe di magnesio	Magnesium alloys												
	3.1	Leghe di magnesio malleabili	Magnesium wrought alloys	≤ 500 N/mm2	MgAl6Zn	3.5612		150 - 250	150 - 400	0,01 - 0,05	0,05 - 0,08	0,07 - 0,20		3.1	
	3.2	Leghe per getti di magnesio	Magnesium cast alloys	≤ 500 N/mm2	EN-MCMgAl9Zn1	EN-MC21120		150 - 250	150 - 400	0,01 - 0,05	0,05 - 0,08	0,07 - 0,20		3.2	
		Materie plastiche	Synthetics												
	4.1	Materie plastiche termoindurenti (truciolo corto)	Duroplastics (short-chipping)		Bakelit, Pertinax			60 - 150		0,01 - 0,05	0,05 - 0,10	0,08 - 0,25		4.1	
	4.2	Resine termoplastiche (truciolo lungo)	Thermoplastics (long-chipping)		PMMA, POM, PVC			60 - 150		0,01 - 0,05	0,05 - 0,10	0,08 - 0,25		4.2	
	4.3	Resine epossidiche (percentuale di fibre ≤ 30%)	Fibre-reinforced synthetics (fibre content ≤ 30%)		GFK, CFK, AFK				80 - 120	0,01 - 0,05	0,05 - 0,10	0,08 - 0,25		4.3	
	4.4	Resine epossidiche (percentuale di fibre > 30%)	Fibre-reinforced synthetics (fibre content > 30%)		GFK, CFK, AFK				80 - 120	0,01 - 0,05	0,05 - 0,10	0,08 - 0,25		4.4	
		Materiali speciali	Special materials												
	5.1	Grafite	Graphite		C 8000				100 - 200		0,04 - 0,07	0,08 - 0,25		5.1	
	5.2	Leghe tungsteno-rame	Tungsten-copper alloys		W-Cu 80/20			15 - 40	30 - 60		0,02 - 0,04	0,08 - 0,25		5.2	
	5.3	Materiali compositi	Composite materials		Hylite, Alucobond							0,08 - 0,25		5.3	
S		Materiali speciali	Special materials												S
		Leghe di titanio	Titanium alloys												
	1.1	Titanio puro	Pure titanium	≤ 450 N/mm2	Ti1	3.7025		15 - 50	30 - 80	0,003 - 0,03	0,03 - 0,05	0,04 - 0,10		1.1	
	1.2	Leghe di titanio	Titanium alloys	≤ 900 N/mm2	TiAl6V4	3.7165		15 - 50	30 - 80	0,003 - 0,03	0,03 - 0,05	0,04 - 0,10		1.2	
	1.3			≤ 1250 N/mm2	TiAl4Mo4Sn2	3.7185		15 - 40	30 - 60	0,003 - 0,02	0,02 - 0,04	0,03 - 0,08		1.3	
		Leghe di nichel, cobalto e ferro	Nickel alloys, cobalt alloys and iron alloys												
	2.1	Nichel puro	Pure nickel	≤ 600 N/mm2	Ni 99,6	2.4060			30 - 60	0,003 - 0,02	0,02 - 0,04	0,03 - 0,08		2.1	
	2.2	Leghe base nichel	Nickel-base alloys	≤ 1000 N/mm2	Monel 400	2.4360			30 - 60	0,003 - 0,02	0,02 - 0,04	0,03 - 0,08		2.2	
	2.3			≤ 1600 N/mm2	Inconel 718	2.4668								2.3	
	2.4	Leghe base cobalto	Cobalt-base alloys	≤ 1000 N/mm2	Udimet 605				30 - 40	0,003 - 0,02	0,02 - 0,04	0,03 - 0,08		2.4	
	2.5			≤ 1600 N/mm2	Haynes 25	2.4964								2.5	
	2.6	Leghe base ferro	Iron-base alloys	≤ 1500 N/mm2	Incoloy 800	1.4958			30 - 40	0,003 - 0,02	0,02 - 0,04	0,03 - 0,08		2.6	
H		Materiali duri	Hard materials												H
	1.1	"Acciai ad alta resistenza, Acciai temprati, Ghise in conchiglia	High strength steels, hardened steels, hard castings"	44 - 50 HRC	Weldox 1100				30 - 60		0,015 - 0,03	0,03 - 0,08		1.1	
	1.2			50 - 55 HRC	Hardox 550				30 - 60		0,015 - 0,03	0,03 - 0,08		1.2	
	1.3			55 - 60 HRC	Armox 600T									1.3	
	1.4			60 - 63 HRC	Ferro-Titanit									1.4	
	1.5			63 - 66 HRC	HSSE									1.5	

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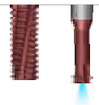
The cutting speeds (vc in m/min) listed in the respective columns are standard values which have to be adjusted to individual work conditions (material, lubrication, machine etc.). International comparison of materials, see page Z • 21

Vc = Velocità di taglio (m/min)
Fz = Avanzamento per dente (mm)

Vc = Cuttind speed (m/min)
Fz = Feed for tooth (mm)



												M
								4D 17, 4D 19, 4D 65, 4D 67				MF
								4D 17, 4D 19				UNC
												UNF
												G, RP, W
												BSW,BSF
												NPT
												NPTF
												BSPT
								4D 83, 4D 85				MJ
								4D 87, 4D 89				UNJ
												M-EXT, MJ-EXT
												PG
												EGM

		Materiale	Material		Material examples	Mat. numbers	Vc Uncoated	Vc Coated LTM	f z ø d1 ≤ 4 mm	f z ø d1 ≤ 8 mm	f z ø d1 > 8 mm		
P		Acciai	Steel materials										P
		Acciai estrusi a freddo	Cold-extrusion steel		Cq15	1.1132							
	1.1	Acciai da costruzione	Costruction steels	≤ 600 N/mm2	S235JR (St37-2)	1.0037						1.1	
		Acciai alta velocità	Free-cutting steel, etc.		10SPb20	1.0722							
		Acciai da costruzione	Costruction steels		E360 (St70-2)	1.0070							
	2.1	Acciai da cementazione	Cementation steel	≤ 800 N/mm2	16MnCr5	1.7131						2.1	
		Fusione d'acciaio, ecc.	Steel casting, etc.		GS-25CrMo4	1.7218							
		Acciai da cementazione	Cementation steel		20MoCr3	1.7320							
	3.1	Acciai da bonifica	Heat-treatable steels	≤ 1000 N/mm2	42CrMo4	1.7225						3.1	
		Acciai per lavorazioni a freddo, ecc.	Cold work steels, etc.		102Cr6	1.2067							
		Acciai da bonifica	Heat-treatable steels		50CrMo4	1.7228							
	4.1	Acciai per lavorazioni a freddo	Cold work steels	≤ 1200 N/mm2	X45NiCrMo4	1.2767						4.1	
		Acciai da nitrurazione, ecc.	Nitriding steels, etc.		31CrMo12	1.8515							
		Acciai fortemente legati	High-alloyed steels		X38CrMoV5-3	1.2367							
	5.1	Acciai per lavorazioni a freddo	Cold work steels	≤ 1400 N/mm2	X100CrMoV8-1-1	1.2990						5.1	
		Acciai per lavorazioni a caldo, ecc.	Hot work steels, etc.		X40CrMoV5-1	1.2344							
M		Acciai inossidabili	Stainless steel materials										M
	1.1	Ferritici, martensitici	Ferritic, martensitic	≤ 950 N/mm2	X2CrTi12	1.4512						1.1	
	2.1	Austenitici	Austenitic	≤ 950 N/mm2	X6CrNiMoTi17-12-2	1.4571						2.1	
	3.1	Austenitici-ferritici (Duplex)	Austenitic-ferritic (Duplex)	≤ 1100 N/mm2	X2CrNiMoN22-5-3	1.4462						3.1	
	4.1	Austenitici-ferritici resistenti al calore (Super Duplex)	Austenitic-ferritic heat-resistant (Super Duplex)	≤ 1250 N/mm2	X2CrNiMoN25-7-4	1.4410						4.1	
K		Ghise	Cast materials										K
	1.1	Ghise con grafite lamellare (GJL)	Cast iron with lamellar graphite (GJL)	100-250 N/mm2	EN-GJL-200 (GG20)	EN-JL-1030						1.1	
	1.2			250-450 N/mm2	EN-GJL-300 (GG30)	EN-JL-1050						1.2	
	2.1	Ghise con grafite nodulare (GJS)	Cast iron with nodular graphite (GJS)	350-500 N/mm2	EN-GJS-400-15 (GGG40)	EN-JS-1030						2.1	
	2.2			500-900 N/mm2	EN-GJS-700-2 (GGG70)	EN-JS-1070						2.2	
	3.1	Ghise con grafite vermicolare (GJV)	Cast iron with vermicular graphite (GJV)	300-400 N/mm2	GJV 300							3.1	
	3.2			400-500 N/mm2	GJV 450							3.2	
	4.1	Ghise malleabili (GTMW, GTMB)	Malleable cast iron (GTMW, GTMB)	250-500 N/mm2	EN-GJMW-350-4 (GTW-35)	EN-JM-1010						4.1	
	4.2			500-800 N/mm2	EN-GJMB-450-6 (GTS-45)	EN-JM-1140						4.2	
N		Materiali non ferrosi	Non ferrous materials										N
		Leghe di alluminio	Aluminium alloys										
	1.1	Leghe di alluminio malleabili	Aluminium wrought alloys	≤ 200 N/mm2	EN AW-AlMn1	EN AW-3103						1.1	
	1.2			≤ 350 N/mm2	EN AW-AlMgSi	EN AW-6060						1.2	
	1.3			≤ 550 N/mm2	EN AW-AlZn5Mg3Cu	EN AW-7022						1.3	
	1.4	Leghe fuse di alluminio	Aluminium cast alloys	Si ≤ 7%	EN AC-AlMg5	EN AC-51300						1.4	
	1.5			7% < Si ≤ 12%	EN AC-AlSi9Cu3	EN AC-46500						1.5	
	1.6			12% < Si ≤ 17%	GD-AlSi17Cu4FeMg							1.6	
		Leghe di rame	Copper alloys										
	2.1	Rame puro, Rame poco legato	Pure copper, low-alloyed copper	≤ 400 N/mm2	E-Cu 57	EN CW 004 A						2.1	
	2.2	Leghe rame-zinco (ottone, truciolo lungo)	Copper-zinc alloys (brass, long-chipping)	≤ 550 N/mm2	CuZn37 (Ms63)	EN CW 508 L						2.2	
	2.3	Leghe rame-zinco (ottone, truciolo corto)	Copper-zinc alloys (brass, short-chipping)	≤ 550 N/mm2	CuZn36Pb3 (Ms58)	EN CW 603 N						2.3	
	2.4	Leghe rame-alluminio (alubronzo, truciolo lungo)	Copper-aluminium alloys (alu bronze, long-chipping)	≤ 800 N/mm2	CuAl10Ni5Fe4	EN CW 307 G						2.4	
	2.5	Leghe rame-stagno (bronzo, truciolo lungo)	Copper-tin alloys (tin bronze, long-chipping)	≤ 700 N/mm2	CuSn8P	EN CW 459 K						2.5	
	2.6	Leghe rame-stagno (bronzo, truciolo corto)	Copper-tin alloys (tin bronze, short-chipping)	≤ 400 N/mm2	CuSn7 ZnPb (Rg7)	2.1090						2.6	
	2.7	Leghe di rame speciali	Special copper alloys	≤ 600 N/mm2	(AMPCO® 8)			40 - 60	0,006 - 0,03	0,006 - 0,03	0,006 - 0,03	2.7	
	2.8			≤ 1400 N/mm2	(AMPCO® 45)								
		Leghe di magnesio	Magnesium alloys										
	3.1	Leghe di magnesio malleabili	Magnesium wrought alloys	≤ 500 N/mm2	MgAl6Zn	3.5612						3.1	
	3.2	Leghe per getti di magnesio	Magnesium cast alloys	≤ 500 N/mm2	EN-MCMgAl9Zn1	EN-MC21120						3.2	
		Materie plastiche	Synthetics										
	4.1	Materie plastiche termoindurenti (truciolo corto)	Duroplastics (short-chipping)		Bakelit, Pertinax							4.1	
	4.2	Resine termoplastiche (truciolo lungo)	Thermoplastics (long-chipping)		PMMA, POM, PVC							4.2	
	4.3	Resine epossidiche (percentuale di fibre ≤ 30%)	Fibre-reinforced synthetics (fibre content ≤ 30%)		GFK, CFK, AFK							4.3	
	4.4	Resine epossidiche (percentuale di fibre > 30%)	Fibre-reinforced synthetics (fibre content > 30%)		GFK, CFK, AFK							4.4	
		Materiali speciali	Special materials										
	5.1	Grafite	Graphite		C 8000							5.1	
	5.2	Leghe tungsteno-rame	Tungsten-copper alloys		W-Cu 80/20							5.2	
	5.3	Materiali compositi	Composite materials		Hylite, Alucobond							5.3	
S		Materiali speciali	Special materials										S
		Leghe di titanio	Titanium alloys										
	1.1	Titanio puro	Pure titanium	≤ 450 N/mm2	Ti1	3.7025						1.1	
	1.2	Leghe di titanio	Titanium alloys	≤ 900 N/mm2	TiAl6V4	3.7165						1.2	
	1.3			≤ 1250 N/mm2	TiAl4Mo4Sn2	3.7185						1.3	
		Leghe di nichel, cobalto e ferro	Nickel alloys, cobalt alloys and iron alloys										
	2.1	Nichel puro	Pure nickel	≤ 600 N/mm2	Ni 99,6	2.4060						2.1	
	2.2	Leghe base nichel	Nickel-base alloys	≤ 1000 N/mm2	Monel 400	2.4360						2.2	
	2.3			≤ 1600 N/mm2	Inconel 718	2.4668						2.3	
	2.4	Leghe base cobalto	Cobalt-base alloys	≤ 1000 N/mm2	Udimet 605							2.4	
	2.5			≤ 1600 N/mm2	Haynes 25	2.4964						2.5	
	2.6	Leghe base ferro	Iron-base alloys	≤ 1500 N/mm2	Incoloy 800	1.4958						2.6	
H		Materiali duri	Hard materials										H
	1.1	"Acciai ad alta resistenza, Acciai temprati, Ghise in conchiglia	High strength steels, hardened steels, hard castings"	44 - 50 HRC	Weldox 1100							1.1	
	1.2			50 - 55 HRC	Hardox 550							1.2	
	1.3			55 - 60 HRC	Armox 600T			40 - 60	0,005 - 0,05	0,005 - 0,05	0,005 - 0,05	1.3	
	1.4			60 - 63 HRC	Ferro-Titanit							1.4	
	1.5			63 - 66 HRC	HSSE							1.5	

FIL

IGUTENSILI

FIL

The cutting speeds (vc in m/min) listed in the respective columns are standard values which have to be adjusted to individual work conditions (material, lubrication, machine etc.). International comparison of materials, see page Z • 21

Vc = Velocità di taglio (m/min) Vc = Cuttind speed (m/min)
Fz = Avanzamento per dente (mm) Fz = Feed for tooth (mm)

					M
					MF
					UNC
					UNF
					G, RP, W
					BSW,BSF
					NPT
					NPTF
					BSPT
					MJ
					UNJ
					M-EXT, MJ-EXT
					EG-UN
					EGM

		Materiale	Material		Material examples	Mat. numbers
P		Acciai	Steel materials			
	1.1	Acciai estrusi a freddo	Cold-extrusion steel		Cq15	1.1132
		Acciai da costruzione	Costruction steels	≤ 600 N/mm2	S235JR (St37-2)	1.0037
		Acciai alta velocità	Free-cutting steel, etc.		10SPb20	1.0722
		Acciai da costruzione	Costruction steels		E360 (St70-2)	1.0070
	2.1	Acciai da cementazione	Cementation steel	≤ 800 N/mm2	16MnCr5	1.7131
		Fusione d'acciaio, ecc.	Steel casting, etc.		GS-25CrMo4	1.7218
		Acciai da cementazione	Cementation steel		20MoCr3	1.7320
	3.1	Acciai da bonifica	Heat-treatable steels	≤ 1000 N/mm2	42CrMo4	1.7225
		Acciai per lavorazioni a freddo, ecc.	Cold work steels, etc.		102Cr6	1.2067
		Acciai da bonifica	Heat-treatable steels		50CrMo4	1.7228
	4.1	Acciai per lavorazioni a freddo	Cold work steels	≤ 1200 N/mm2	X45NiCrMo4	1.2767
		Acciai da nitrurazione, ecc.	Nitriding steels, etc.		31CrMo12	1.8515
		Acciai fortemente legati	High-alloyed steels		X38CrMoV5-3	1.2367
	5.1	Acciai per lavorazioni a freddo	Cold work steels	≤ 1400 N/mm2	X100CrMoV8-1-1	1.2990
		Acciai per lavorazioni a caldo, ecc.	Hot work steels, etc.		X40CrMoV5-1	1.2344
M		Acciai inossidabili	Stainless steel materials			
	1.1	Ferritici, martensitici	Ferritic, martensitic	≤ 950 N/mm2	X2CrTi12	1.4512
	2.1	Austenitici	Austenitic	≤ 950 N/mm2	X6CrNiMoTi17-12-2	1.4571
	3.1	Austenitici-ferritici (Duplex)	Austenitic-ferritic (Duplex)	≤ 1100 N/mm2	X2CrNiMoN22-5-3	1.4462
	4.1	Austenitici-ferritici resistenti al calore (Super Duplex)	Austenitic-ferritic heat-resistant (Super Duplex)	≤ 1250 N/mm2	X2CrNiMoN25-7-4	1.4410
K		Ghise	Cast materials			
	1.1	Ghise con grafite lamellare (GJL)	Cast iron with lamellar graphite (GJL)	100-250 N/mm2	EN-GJL-200 (GG20)	EN-JL-1030
	1.2			250-450 N/mm2	EN-GJL-300 (GG30)	EN-JL-1050
	2.1	Ghise con grafite nodulare (GJS)	Cast iron with nodular graphite (GJS)	350-500 N/mm2	EN-GJS-400-15 (GGG40)	EN-JS-1030
	2.2			500-900 N/mm2	EN-GJS-700-2 (GGG70)	EN-JS-1070
	3.1	Ghise con grafite vermicolare (GJV)	Cast iron with vermicular graphite (GJV)	300-400 N/mm2	GJV 300	
	3.2			400-500 N/mm2	GJV 450	
	4.1	Ghise malleabili (GTMW, GTMB)	Malleable cast iron (GTMW, GTMB)	250-500 N/mm2	EN-GJMW-350-4 (GTW-35)	EN-JM-1010
	4.2			500-800 N/mm2	EN-GJMB-450-6 (GTS-45)	EN-JM-1140
N		Materiali non ferrosi	Non ferrous materials			
		Leghe di alluminio	Aluminium alloys			
	1.1	Leghe di alluminio malleabili	Aluminium wrought alloys	≤ 200 N/mm2	EN AW-AlMn1	EN AW-3103
	1.2			≤ 350 N/mm2	EN AW-AlMgSi	EN AW-6060
	1.3			≤ 550 N/mm2	EN AW-AlZn5Mg3Cu	EN AW-7022
	1.4	Leghe fuse di alluminio	Aluminium cast alloys	Si ≤ 7%	EN AC-AlMg5	EN AC-51300
	1.5			7% < Si ≤ 12%	EN AC-AlSi9Cu3	EN AC-46500
	1.6			12% < Si ≤ 17%	GD-AlSi17Cu4FeMg	
		Leghe di rame	Copper alloys			
	2.1	Rame puro, Rame poco legato	Pure copper, low-alloyed copper	≤ 400 N/mm2	E-Cu 57	EN CW 004 A
	2.2	Leghe rame-zinco (ottone, truciolo lungo)	Copper-zinc alloys (brass, long-chipping)	≤ 550 N/mm2	CuZn37 (Ms63)	EN CW 508 L
	2.3	Leghe rame-zinco (ottone, truciolo corto)	Copper-zinc alloys (brass, short-chipping)	≤ 550 N/mm2	CuZn36Pb3 (Ms58)	EN CW 603 N
	2.4	Leghe rame-alluminio (alubronzo, truciolo lungo)	Copper-aluminium alloys (alu bronze, long-chipping)	≤ 800 N/mm2	CuAl10Ni5Fe4	EN CW 307 G
	2.5	Leghe rame-stagno (bronzo, truciolo lungo)	Copper-tin alloys (tin bronze, long-chipping)	≤ 700 N/mm2	CuSn8P	EN CW 459 K
	2.6	Leghe rame-stagno (bronzo, truciolo corto)	Copper-tin alloys (tin bronze, short-chipping)	≤ 400 N/mm2	CuSn7 ZnPb (Rg7)	2.1090
	2.7	Leghe di rame speciali	Special copper alloys	≤ 600 N/mm2	(AMPCO® 8)	
	2.8			≤ 1400 N/mm2	(AMPCO® 45)	
		Leghe di magnesio	Magnesium alloys			
	3.1	Leghe di magnesio malleabili	Magnesium wrought alloys	≤ 500 N/mm2	MgAl6Zn	3.5612
	3.2	Leghe per getti di magnesio	Magnesium cast alloys	≤ 500 N/mm2	EN-MCMgAl9Zn1	EN-MC21120
		Materie plastiche	Synthetics			
	4.1	Materie plastiche termoindurenti (truciolo corto)	Duroplastics (short-chipping)		Bakelit, Pertinax	
	4.2	Resine termoplastiche (truciolo lungo)	Thermoplastics (long-chipping)		PMMA, POM, PVC	
	4.3	Resine epossidiche (percentuale di fibre ≤ 30%)	Fibre-reinforced synthetics (fibre content ≤ 30%)		GFK, CFK, AFK	
	4.4	Resine epossidiche (percentuale di fibre > 30%)	Fibre-reinforced synthetics (fibre content > 30%)		GFK, CFK, AFK	
		Materiali speciali	Special materials			
	5.1	Grafite	Graphite		C 8000	
	5.2	Leghe tungsteno-rame	Tungsten-copper alloys		W-Cu 80/20	
	5.3	Materiali compositi	Composite materials		Hylite, Alucobond	
S		Materiali speciali	Special materials			
		Leghe di titanio	Titanium alloys			
	1.1	Titanio puro	Pure titanium	≤ 450 N/mm2	Ti1	3.7025
	1.2	Leghe di titanio	Titanium alloys	≤ 900 N/mm2	TiAl6V4	3.7165
	1.3			≤ 1250 N/mm2	TiAl4Mo4Sn2	3.7185
		Leghe di nichel, cobalto e ferro	Nickel alloys, cobalt alloys and iron alloys			
	2.1	Nichel puro	Pure nickel	≤ 600 N/mm2	Ni 99,6	2.4060
	2.2	Leghe base nichel	Nickel-base alloys	≤ 1000 N/mm2	Monel 400	2.4360
	2.3			≤ 1600 N/mm2	Inconel 718	2.4668
	2.4	Leghe base cobalto	Cobalt-base alloys	≤ 1000 N/mm2	Udimet 605	
	2.5			≤ 1600 N/mm2	Haynes 25	2.4964
	2.6	Leghe base ferro	Iron-base alloys	≤ 1500 N/mm2	Incoloy 800	1.4958
H		Materiali duri	Hard materials			
	1.1	"Acciai ad alta resistenza, Acciai temprati, Ghise in conchiglia	High strength steels, hardened steels, hard castings"	44 - 50 HRC	Weldox 1100	
	1.2			50 - 55 HRC	Hardox 550	
	1.3			55 - 60 HRC	Armox 600T	
	1.4			60 - 63 HRC	Ferro-Titanit	
	1.5			63 - 66 HRC	HSSE	

4D 111, 4D 113, 4D 115											M
4D 111, 4D 113, 4D 115											MF
4D 117, 4D 119, 4D 121											UNC
4D 117, 4D 119, 4D 121											UNF
4D 123											G, RP, W
											BSW,BSF
											NPT
											NPTF
											BSPT
4D 137, 4D 139, 4D 141											MJ
4D 131, 4D 133, 4D 135											UNJ
											M-EXT, MJ-EXT
4D 125, 4D 127, 4D 129											PG
											EGM

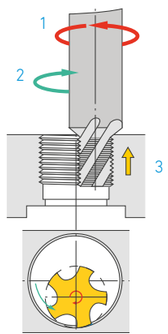
Vc Coated HDM		f z ø d1 ≤ 2,4 mm	f z ø d2,41 ≤ 3,1 mm	f z ø d3,2 ≤ 3,8 mm	f z ø d3,9 ≤ 4,6 mm	f z ø d4,7 ≤ 6,2 mm	f z ø d6,3 ≤ 7,5 mm	f z ø d7,6 ≤ 9 mm	f z ø d9,1 ≤ 11,5 mm		
											P
85	65	0,011	0,015	0,018	0,0229	0,0309	0,0379	0,0449	0,0549	1.1	
85	65	0,011	0,015	0,018	0,0229	0,0309	0,0379	0,0449	0,0549	2.1	
85	65	0,011	0,015	0,018	0,0229	0,0309	0,0379	0,0449	0,0549	3.1	
85	65	0,011	0,015	0,018	0,0229	0,0309	0,0379	0,0449	0,0549	4.1	
85	65	0,011	0,015	0,018	0,0229	0,0309	0,0379	0,0449	0,0549	5.1	
											M
85	65	0,0092	0,0126	0,0151	0,0193	0,0260	0,0319	0,0378	0,0462	1.1	
										2.1	
										3.1	
										4.1	
											K
85	65	0,0116	0,0158	0,0189	0,0242	0,0326	0,0399	*0,0473*	0,0578	1.1	
										1.2	
										2.1	
										2.2	
										3.1	
										3.2	
										4.1	
										4.2	
											N
85	65	0,0116	0,0158	0,0189	0,0242	*0,0326*	0,0399	0,0473	0,0578	1.1	
										1.2	
										1.3	
										1.4	
										1.5	
										1.6	
85	65	0,0116	0,0158	0,0189	0,0242	0,0326	0,0399	0,0473	0,0578	2.1	
										2.2	
										2.3	
										2.4	
										2.5	
										2.6	
										2.7	
85	65	0,0116	0,0158	0,0189	0,0242	0,0326	0,0399	0,0473	0,0578	3.1	
										3.2	
85	65	0,0116	0,0158	0,0189	0,0242	0,0326	0,0399	0,0473	0,0578	4.1	
										4.2	
										4.3	
										4.4	
85	65	0,0116	0,0158	0,0189	0,0242	0,0326	0,0399	0,0473	0,0578	5.1	
										5.2	
										5.3	
											S
85	65	0,0092	0,0126	0,0151	0,0193	0,0260	0,0319	0,0378	0,0462	1.1	
										1.2	
										1.3	
										2.1	
										2.2	
										2.3	
										2.4	
										2.5	
										2.6	
											H
85	65	0,0098	0,0134	0,0161	0,0205	0,0277	0,0339	0,0402	0,0491	1.1	
										1.2	
		0,0087	0,0118	0,0142	0,0181	0,0244	0,0299	0,0354	0,0433	1.3	
										1.4	
		0,0075	0,0102	0,0123	0,0157	0,0212	0,0259	0,0307	0,0375	1.5	

THREAD MILLING PROCEDURES

Fresatura in concordanza

Caratteristiche:
1. Rotazione dell'utensile in senso orario
2. Avanzamento utensile in senso anti-orario
3. Direzione di lavorazione: dal fondo verso l'esterno

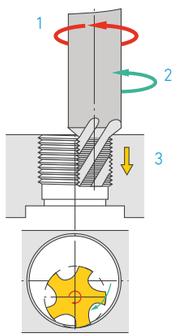
Filetto destro



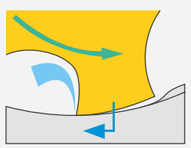
Fresatura in discordanza

Caratteristiche:
1. Rotazione dell'utensile in senso orario
2. Avanzamento utensile in senso orario
3. Direzione di lavorazione: dal fondo verso il fondo

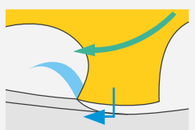
Filetto destro



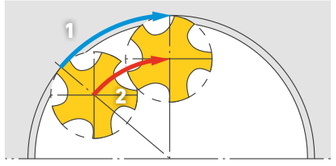
Nella fresatura in concordanza si ha lo spessore del truciolo 0 (h = 0) all'uscita del tagliente dal materiale



Nella fresatura in discordanza lo spessore massimo del truciolo (h = max) si ha all'uscita del tagliente dal materiale



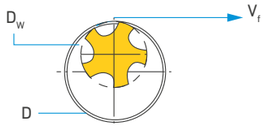
Calcolo dell' avanzamento



1. Avanzamento sul profilo (vf)
2. "Avanzamento della traiettoria del centro fresa vfm"

Avanzamento sul profilo fresa (vf)

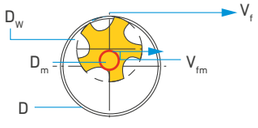
$$v_f = n \cdot f_z \cdot z$$ mm/min



Dw = diametro effettivo dell'utensile (mm)
N = numero di giri (min -1)
fz = avanzamento per dente (mm)

Avanzamento della traiettoria del centro fresa vfm

$$v_{fm} = \frac{V_f \cdot (D - D_w)}{D}$$ mm/min



z = numero dei taglienti
D = Diametro nominale del filetto = Diametro profilo esterno (mm)
Dm = Diametro della traiettoria del centro fresa (D – DW) in mm

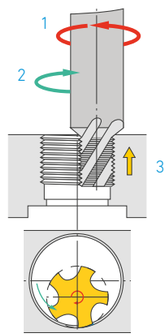
Consigli per l'operatore

Nella fresatura di filetti, l'avanzamento dell'utensile può essere programmato in due modi:
O sul profilo utensile oppure al centro utensile, in funzione del tipo di controllo.
Per sapere con quale avanzamento lavora la macchina, è necessario:
1. Inserire il programma per la fresatura dei filetti.
2. Eseguire il ciclo "a vuoto".
3. Cronometrare il tempo di lavorazione.
4. Comparare il valore rilevato con il valore teorico.
Se il tempo rilevato è maggiore del tempo calcolato occorre lavorare con l'avanzamento al centro utensile.
Se il tempo di lavorazione rilevato è minore del tempo calcolato occorre lavorare con l'avanzamento sul profilo utensile.

Climb milling

Characteristics:
1. Tool rotation direction "right"
2. Toolpath counter clockwise
3. Feed direction "outwards"

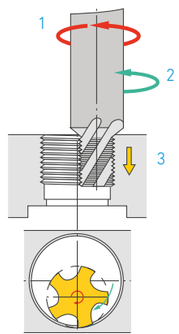
Right hand thread



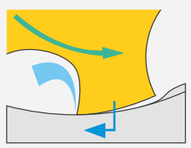
Conventional milling

Characteristics:
1. Tool rotation direction "right"
2. Toolpath clockwise
3. Feed direction "inwards"

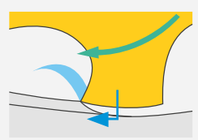
Right hand thread



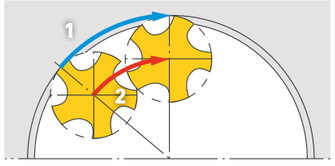
When climb milling, the chip thickness at the end of cut is always 0 (h=0)



When conventional milling, the chip thickness at the end of cut is always at maximum (h=max)



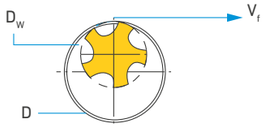
Feed rate calculation



1. Peripheral feedrate (vf)
2. Centerline feedrate vfm

Peripheral feedrate (vf)

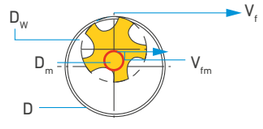
$$v_f = n \cdot f_z \cdot z$$ mm/min



Dw = Effective diameter in mm
N = RPM in min-1
fz = Feed per tooth in mm

Centerline feedrate vfm

$$v_{fm} = \frac{V_f \cdot (D - D_w)}{D}$$ mm/min



z = Number of cutting edges (radial)
D = Nominal thread diameter = external profile diameter in mm
Dm = Centre path diameter (D – DW) in mm

Tips for the User

With thread milling there are two different programme possibilities with the feed motion of the tool:
On the one hand the machine controls the feed at the diameter of the tool, on the other hand the feed control is the tool center line.
In order to ascertain which method the machine control uses, the following method should be employed:
1. Enter the thread milling routine into the control.
2. Enter a safety margin into the program, so that the tool runs in air.
3. Run the program through and check the operating time.
4. Compare the actual time with the calculated theoretical time.
If the time is longer than the calculated time the feed is controlling the tool center line.
If the time is shorter than the calculated time the feed is controlling the diameter of the tool.

NUMERIC CALCULATION OF CUTTING DATA FOR THREAD MILLING

$$n = \frac{v_c \cdot 1000}{d \cdot \pi} \qquad v_c = \frac{d \cdot \pi \cdot n}{1000} \qquad v_f = f_z \cdot z \cdot n \qquad n = \frac{v_f}{f_z \cdot z} \qquad f_z = \frac{v_f}{z \cdot n}$$

FIL

Fresatura – profilo esterno

$$v_{fm} = \frac{v_f \cdot (D + d)}{D} \qquad v_f = \frac{D \cdot v_{fm}}{(D + d)}$$

Fresatura – profilo interno

$$v_{fm} = \frac{v_f \cdot (D - d)}{D} \qquad v_f = \frac{D \cdot v_{fm}}{(D - d)}$$

Penetrazione diritta

$$U_{pen.} = 0{,}25 \cdot v_{fm}$$

n = numero di giri del mandrino g./min
Vc = Velocità di taglio m/min
d = diametro fresa mm
D = Ø nominale del filetto mm
Vf = avanzamento sul diametro periferico mm/min

Penetrazione sulla traiettoria circolare

$$U_{pen.} = v_{fm}$$

Vfm = avanzamento al centro mm/min
U pen. = avanzamento di penetrazione consigliato mm/min
Fz = Avanzamento per dente mm
Z = numero di taglienti per fresa Quantità

Valori di correzione per la filettatura interna

È possibile calcolare la dimensione media del tagliente della fresa, che viene digitata nel comando della macchina, come segue:
Diametro nominale della fresa meno (0,05 x passo P)

Esempio: M30x3
Ø fresa: 20 mm

$$Ø\,\frac{20}{2} - (0{,}05 \cdot 3) = \underline{9{,}85\ mm}$$

9,85 mm viene inserito come dimensione del tagliente nel comando della macchina!

$$n = \frac{v_c \cdot 1000}{d \cdot \pi} \qquad v_c = \frac{d \cdot \pi \cdot n}{1000} \qquad v_f = f_z \cdot z \cdot n \qquad n = \frac{v_f}{f_z \cdot z} \qquad f_z = \frac{v_f}{z \cdot n}$$

FIL

Milling - external contour

$$v_{fm} = \frac{v_f \cdot (D + d)}{D} \qquad v_f = \frac{D \cdot v_{fm}}{(D + d)}$$

Milling - internal contour

$$v_{fm} = \frac{v_f \cdot (D - d)}{D} \qquad v_f = \frac{D \cdot v_{fm}}{(D - d)}$$

Helical plunging

$$U_{arc} = 0{,}25 \cdot v_{fm}$$

n = rpm U/min
Vc = Cutting speed U/min
d = Tool diameter mm
D = Nominal thread-Ø
Vf = Feed rate at the diameter mm/min

Ramping in the arc

$$U_{arc} = v_{fm}$$

Vfm = Feed rate at the centre mm/min
U arc = programmed ramping feed rate mm/min
Fz = Feed per tooth mm
Z = number of cutting edges of the cutter piece

Correction values for the internal thread milling

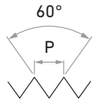
The cutting edge diameter of the thread milling cutter which is entered into the machine control, can be calculated as follows:
half the cutter Ø - 0.05 x pitch p

Example: M30x3
Cutter-Ø: 20 mm

$$Ø\,\frac{20}{2} - (0{,}05 \cdot 3) = \underline{9{,}85\ mm}$$

9,85 mm is the cutting radius to be entered into the machine control

INTERNAL 1,5xD

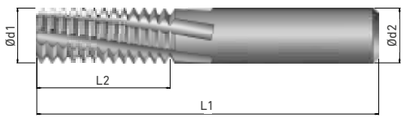


M, MF

DIN13

VHM | e8 | 1,5xD
R 10° | R9°-R11° | RH-LH
DIN 6535 HA
INTERNO INTERNAL

ESECUZIONI SPECIALI A DISEGNO
CUSTOMIZED DESIGN ON REQUEST



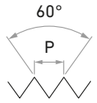
	ELICA DX - RH HELIX	ELICA DX - RH HELIX
TRATTAMENTO SUPERFICIALE SURFACE TREATMENT	Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc
MATERIALI LAVORABILI WORKING MATERIALS page 4D • 3	P1.1-P5.1 K1.1-K4.2 S1.1-S1.3 N1.1-N1.5 N2.1-N2.6 N3.1-N4.2	P1.1-P5.1 S1.1-S2.6 N1.1-N5.2 M1.1-M4.1 H1.1-H1.2
DATI TECNICI TECHNICAL DATA		

Filetto - Thread	Pitch mm	d1	L1	L2	d2	Z	Z type TX		
M 4	0.70	3.1	51	5	6.0	3		FIGMET50N	FIGMET50T
M 5	0.80	4.0	48	6	6.0	3	4	FIGMET52N	FIGMET52T
MF 6	0.50	4.5	49	7	6.0	3		FIGMET54N	FIGMET54T
MF 6	0.75	4.5	49	7	6.0	3	4	FIGMET56N	FIGMET56T
M 6 M 7	1.00	4.5	49	7	6.0	3	4	FIGMET58N	FIGMET58T
MF 8	0.50	6.0	51	9	6.0	3		FIGMET60N	FIGMET60T
MF 8	0.75	6.0	48	9	6.0	3	4	FIGMET62N	FIGMET62T
MF 8	1.00	6.0	48	9	6.0	3	4	FIGMET64N	FIGMET64T
M 8 M 9 MF 10	1.25	6.0	48	9	6.0	3	4	FIGMET66N	FIGMET66T
MF 10	0.50	8.0	57	12	8.0	3		FIGMET68N	FIGMET68T
MF 10 MF 12	0.75	8.0	57	12	8.0	3	4	FIGMET70N	FIGMET70T
MF 10 MF 12	1.00	8.0	57	12	8.0	3	4	FIGMET72N	FIGMET72T
MF 10 MF 12	1.25	8.0	57	12	8.0	3	4	FIGMET74N	FIGMET74T
M 10 M 11 MF 12	1.50	8.0	57	12	8.0	3	4	FIGMET76N	FIGMET76T
M 12	1.75	8.0	57	12	8.0	3	4	FIGMET78N	FIGMET78T
MF 12	0.50	10.0	70	15	10.0	4		FIGMET80N	FIGMET80T
M 12	1.00	10.0	70	15	10.0	4	5	FIGMET82N	FIGMET82T
MF 14	1.25	10.0	70	15	10.0	4	5	FIGMET84N	FIGMET84T
MF 14	1.50	10.0	70	15	10.0	4	5	FIGMET86N	FIGMET86T
M 14	2.00	10.0	70	15	10.0	4	5	FIGMET88N	FIGMET88T
MF 14	0.50	12.0	70	18	12.0	4		FIGMET90N	FIGMET90T
MF 14	1.00	12.0	70	18	12.0	4	5	FIGMET92N	FIGMET92T
MF 16	1.50	12.0	70	18	12.0	4	5	FIGMET94N	FIGMET94T
M 16	2.00	12.0	70	18	12.0	4	5	FIGMET96N	FIGMET96T
MF 16	1.00	14.0	86	21	14.0	4	5	FIGMET98N	FIGMET98T
MF 18	1.50	14.0	86	21	14.0	4	5	FIGMET100N	FIGMET100T
MF 18	2.00	14.0	86	21	14.0	4	5	FIGMET102N	FIGMET102T
M 18	2.50	14.0	86	21	14.0	4	5	FIGMET104N	FIGMET104T
MF 18 MF 20	1.00	16.0	84	24	16.0	5	6	FIGMET106N	FIGMET106T
MF 20 MF 22	1.50	16.0	84	24	16.0	5	6	FIGMET108N	FIGMET108T
MF 20 MF 22	2.00	16.0	84	24	16.0	5	6	FIGMET110N	FIGMET110T
M 20 M 22	2.50	16.0	84	24	16.0	5	6	FIGMET112N	FIGMET112T
MF 22>	1.00	20.0	100	30	20.0	5	6	FIGMET114N	FIGMET114T
MF 24>	1.50	20.0	100	30	20.0	5	6	FIGMET116N	FIGMET116T
MF 24>	2.00	20.0	100	30	20.0	5	6	FIGMET118N	FIGMET118T
MF 24>	3.00	20.0	100	30	20.0	5	6	FIGMET120N	FIGMET120T
M 30 M 33	3.50	25.0	135	58	25.0	5		FIGMET122N	FIGMET122T
M 36 ≥ M 42	4.00	25.0	135	58	25.0	5		FIGMET124N	FIGMET124T

ELICA DX - RH HELIX	ELICA DX - RH HELIX	ELICA DX - RH HELIX	ELICA DX - RH HELIX	ELICA DX - RH HELIX
Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc	Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc	Coated LTM ≥45Hrc ≤60Hrc
P1.1-P5.1 K1.1-K4.2 S1.1-S1.3 N1.1-N1.5 N2.1-N2.6 N3.1-N4.2	P1.1-P5.1 M1.1-M4.1 N1.1-N5.2 S1.1-S2.6 H1.1-H1.2	P1.1-P5.1 K1.1-K4.2 S1.1-S1.3 N1.1-N1.5 N2.1-N2.6 N3.1-N4.2	P1.1-P5.1 M1.1-M4.1 N1.1-N5.2 S1.1-S2.6 H1.1-H1.2	N2.7-N2.8 H1.3-H1.5

FIGMET52NF	FIGMET52F			FIGMET50TX
FIGMET54NF	FIGMET54F			
FIGMET56NF	FIGMET56F			FIGMET52TX
FIGMET58NF	FIGMET58F			FIGMET54TX
FIGMET60NF	FIGMET60F			
FIGMET62NF	FIGMET62F	FIGMET62NG	FIGMET62TG	FIGMET56TX
FIGMET64NF	FIGMET64F	FIGMET64NG	FIGMET64TG	FIGMET58TX
FIGMET66NF	FIGMET66F	FIGMET66NG	FIGMET66TG	FIGMET60TX
FIGMET68NF	FIGMET68F			
FIGMET70NF	FIGMET70F	FIGMET70NG	FIGMET70TG	FIGMET62TX
FIGMET72NF	FIGMET72F	FIGMET72NG	FIGMET72TG	FIGMET64TX
FIGMET74NF	FIGMET74F	FIGMET74NG	FIGMET74TG	FIGMET66TX
FIGMET76NF	FIGMET76F	FIGMET78NG	FIGMET78TG	FIGMET68TX
FIGMET78NF	FIGMET78F	FIGMET78NG	FIGMET78TG	FIGMET70TX
FIGMET80NF	FIGMET80F			
FIGMET82NF	FIGMET82F	FIGMET82NG	FIGMET82TG	FIGMET72TX
FIGMET84NF	FIGMET84F	FIGMET84NG	FIGMET84TG	FIGMET74TX
FIGMET86NF	FIGMET86F	FIGMET86NG	FIGMET86TG	FIGMET76TX
FIGMET88NF	FIGMET88F	FIGMET88NG	FIGMET88TG	FIGMET78TX
FIGMET90NF	FIGMET90F			
FIGMET92NF	FIGMET92F	FIGMET92NG	FIGMET92TG	FIGMET80TX
FIGMET94NF	FIGMET94F	FIGMET94NG	FIGMET94TG	FIGMET82TX
FIGMET96NF	FIGMET96F	FIGMET96NG	FIGMET96TG	FIGMET84TX
FIGMET98NF	FIGMET98F	FIGMET98NG	FIGMET98TG	FIGMET86TX
FIGMET100NF	FIGMET100F	FIGMET100NG	FIGMET100TG	FIGMET88TX
FIGMET102NF	FIGMET102F	FIGMET102NG	FIGMET102TG	FIGMET90TX
FIGMET104NF	FIGMET104F	FIGMET104NG	FIGMET104TG	FIGMET92TX
FIGMET106NF	FIGMET106F	FIGMET106NG	FIGMET106TG	FIGMET94TX
FIGMET108NF	FIGMET108F	FIGMET108NG	FIGMET108TG	FIGMET96TX
FIGMET110NF	FIGMET110F	FIGMET110NG	FIGMET110TG	FIGMET98TX
FIGMET112NF	FIGMET112F	FIGMET111NG	FIGMET111TG	FIGMET100TX
FIGMET114NF	FIGMET114F	FIGMET114NG	FIGMET114TG	FIGMET102TX
FIGMET116NF	FIGMET116F	FIGMET116NG	FIGMET116TG	FIGMET104TX
FIGMET118NF	FIGMET118F	FIGMET118NG	FIGMET118TG	FIGMET106TX
FIGMET120NF	FIGMET120F	FIGMET120NG	FIGMET120TG	FIGMET108TX
FIGMET122NF	FIGMET122F			
FIGMET124NF	FIGMET124F			

INTERNAL 2xD

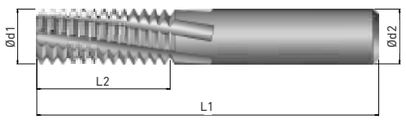


M, MF

DIN13

VHM | e8 | 2xD | R 10° | R9°-R11° | RH-LH | DIN 6535 HA | INTERNO INTERNAL

ESECUZIONI SPECIALI A DISEGNO
CUSTOMIZED DESIGN ON REQUEST



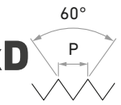
	ELICA DX - RH HELIX	ELICA DX - RH HELIX
TRATTAMENTO SUPERFICIALE SURFACE TREATMENT	Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc
MATERIALI LAVORABILI WORKING MATERIALS page 4D • 3	P1.1-P5.1 K1.1-K4.2 S1.1-S1.3 N1.1-N1.5 N2.1-N2.6 N3.1-N4.2	P1.1-P5.1 S1.1-S2.6 N1.1-N5.2 M1.1-M4.1 H1.1-H1.2
DATI TECNICI TECHNICAL DATA		

Filetto - Thread	Pitch mm	d1	L1	L2	d2	Z	Z type TX		
M 4	0.7	3.1	54	8	6.0	3		FIGMET03N	FIGMET03T
M 5	0.80	4.0	54	12	6.0	3	4	FIGMET00N	FIGMET00T
MF 6	0.50	4.5	54	12	6.0	3		FIGMET27N	FIGMET27T
MF 6	0.75	4.5	54	12	6.0	3	4	FIGMET01N	FIGMET01T
M 6 M7	1.00	4.5	54	12	6.0	3	4	FIGMET02N	FIGMET02T
MF 8	0.50	6.0	54	12	6.0	3		FIGMET07N	FIGMET07T
MF 8	0.75	6.0	54	15	6.0	3	4	FIGMET04N	FIGMET04T
MF 8	1.25	6.0	54	15	6.0	3	4	FIGMET06N	FIGMET06T
MF 10	0.50	8.0	65	20	8.0	3		FIGMET13N	FIGMET13T
MF 10 MF12	0.75	8.0	65	20	8.0	3	4	FIGMET08N	FIGMET08T
MF 10 MF 12	1.00	8.0	65	20	8.0	3	4	FIGMET09N	FIGMET09T
MF 10 MF 12	1.25	8.0	65	20	8.0	3	4	FIGMET10N	FIGMET10T
M 10 M11 MF 12	1.50	8.0	65	20	8.0	3	4	FIGMET11N	FIGMET11T
M 12	1.75	8.0	65	20	8.0	3	4	FIGMET12N	FIGMET12T
MF 12	0.50	10.0	80	25	10.0	4		FIGMET18N	FIGMET18T
M 12	1.00	10.0	80	25	10.0	4	5	FIGMET14N	FIGMET14T
MF 14	1.25	10.0	80	25	10.0	4	5	FIGMET15N	FIGMET15T
MF 14	1.50	10.0	80	25	10.0	4	5	FIGMET16N	FIGMET16T
M 14	2.00	10.0	80	25	10.0	4	5	FIGMET17N	FIGMET17T
MF 14	0.50	12.0	82	30	12.0	4		FIGMET22N	FIGMET22T
MF 14	1.00	12.0	82	30	12.0	4	5	FIGMET19N	FIGMET19T
MF 16	1.50	12.0	82	30	12.0	4	5	FIGMET20N	FIGMET20T
M 16	2.00	12.0	82	30	12.0	4	5	FIGMET21N	FIGMET21T
MF 16	1.00	14.0	100	35	14.0	4	5	FIGMET23N	FIGMET23T
MF 18	1.50	14.0	100	35	14.0	4	5	FIGMET24N	FIGMET24T
MF 18	2.00	14.0	100	35	14.0	4	5	FIGMET25N	FIGMET25T
M 18	2.50	14.0	100	35	14.0	4	5	FIGMET26N	FIGMET26T
MF 18 MF 20	1.00	16.0	100	40	16.0	5	6	FIGMET28N	FIGMET28T
MF 20 MF 22	1.50	16.0	100	40	16.0	5	6	FIGMET29N	FIGMET29T
MF 20 MF 22	2.00	16.0	100	40	16.0	5	6	FIGMET30N	FIGMET30T
M 20 M22	2.50	16.0	100	40	16.0	5	6	FIGMET31N	FIGMET31T
MF 22>	1.00	20.0	110	40	20.0	5	6	FIGMET33N	FIGMET33T
MF 24>	1.50	20.0	110	40	20.0	5	6	FIGMET34N	FIGMET34T
MF 24>	2.00	20.0	110	40	20.0	5	6	FIGMET35N	FIGMET35T
MF 24>	3.00	20.0	110	40	20.0	5	6	FIGMET36N	FIGMET36T
M 30 33	3.50	25.0	155	78	25.0	5		FIGMET40N	FIGMET40T
M 36 ≥ M 42	4.00	25.0	155	78	25.0	5		FIGMET38N	FIGMET38T

ELICA DX - RH HELIX	ELICA DX - RH HELIX	ELICA DX - RH HELIX	ELICA DX - RH HELIX	ELICA DX - RH HELIX
Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc	Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc	Coated LTM ≥45Hrc ≤60Hrc
P1.1-P5.1 K1.1-K4.2 S1.1-S1.3 N1.1-N1.5 N2.1-N2.6 N3.1-N4.2	P1.1-P5.1 M1.1-M4.1 N1.1-N5.2 S1.1-S2.6 H1.1-H1.2	P1.1-P5.1 K1.1-K4.2 S1.1-S1.3 N1.1-N1.5 N2.1-N2.6 N3.1-N4.2	P1.1-P5.1 M1.1-M4.1 N1.1-N5.2 S1.1-S2.6 H1.1-H1.2	N2.7-N2.8 H1.3-H1.5

FIGMET00NF	FIGMET00F			FIGMET00TX
FIGMET27NF	FIGMET27F			
FIGMET01NF	FIGMET01F			FIGMET01TX
FIGMET02NF	FIGMET02F			FIGMET02TX
FIGMET07NF	FIGMET07F			
FIGMET04NF	FIGMET04F	FIGMET04NG	FIGMET04TG	FIGMET04TX
FIGMET05NF	FIGMET05F	FIGMET05NG	FIGMET05TG	FIGMET05TX
FIGMET06NF	FIGMET06F	FIGMET06NG	FIGMET06TG	FIGMET06TX
FIGMET13NF	FIGMET13F			
FIGMET08NF	FIGMET08F	FIGMET08NG	FIGMET08TG	FIGMET08TX
FIGMET09NF	FIGMET09F	FIGMET09NG	FIGMET09TG	FIGMET09TX
FIGMET10NF	FIGMET10F	FIGMET10NG	FIGMET10TG	FIGMET10TX
FIGMET11NF	FIGMET11F	FIGMET11NG	FIGMET11TG	FIGMET11TX
FIGMET12NF	FIGMET12F	FIGMET12NG	FIGMET12TG	FIGMET12TX
FIGMET18NF	FIGMET18F			
FIGMET14NF	FIGMET14F	FIGMET14NG	FIGMET14TG	FIGMET14TX
FIGMET15NF	FIGMET15F	FIGMET15NG	FIGMET15TG	FIGMET15TX
FIGMET16NF	FIGMET16F	FIGMET16NG	FIGMET16TG	FIGMET16TX
FIGMET17NF	FIGMET17F	FIGMET17NG	FIGMET17TG	FIGMET17TX
FIGMET22NF	FIGMET22F			
FIGMET19NF	FIGMET19F	FIGMET19NG	FIGMET19TG	FIGMET19TX
FIGMET20NF	FIGMET20F	FIGMET20NG	FIGMET20TG	FIGMET20TX
FIGMET21NF	FIGMET21F	FIGMET21NG	FIGMET21TG	FIGMET21TX
FIGMET23NF	FIGMET23F	FIGMET23NG	FIGMET23TG	FIGMET23TX
FIGMET24NF	FIGMET24F	FIGMET24NG	FIGMET24TG	FIGMET24TX
FIGMET25NF	FIGMET25F	FIGMET25NG	FIGMET25TG	FIGMET25TX
FIGMET26NF	FIGMET26F	FIGMET26NG	FIGMET26TG	FIGMET26TX
FIGMET28NF	FIGMET28F	FIGMET28NG	FIGMET28TG	FIGMET28TX
FIGMET29NF	FIGMET29F	FIGMET29NG	FIGMET29TG	FIGMET29TX
FIGMET30NF	FIGMET30F	FIGMET30NG	FIGMET30TG	FIGMET30TX
FIGMET31NF	FIGMET31F	FIGMET31NG	FIGMET31TG	FIGMET31TX
FIGMET33NF	FIGMET33F	FIGMET33NG	FIGMET33TG	FIGMET33TX
FIGMET34NF	FIGMET34F	FIGMET34NG	FIGMET34TG	FIGMET34TX
FIGMET35NF	FIGMET35F	FIGMET35NG	FIGMET35TG	FIGMET35TX
FIGMET36NF	FIGMET36F	FIGMET36NG	FIGMET36TG	FIGMET36TX
FIGMET40NF	FIGMET40F			
FIGMET38NF	FIGMET38F			

INTERNAL 1,5xD

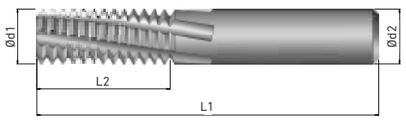


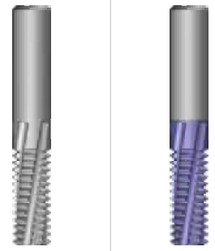
UNC, UNF

ASME B1.1

VHM | e8 | 1,5xD
R 10° | R9°-R11° | RH-LH
DIN 6535 HA
INTERNO INTERNAL

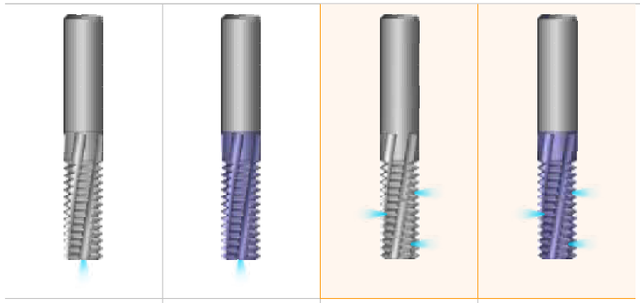
ESECUZIONI SPECIALI A DISEGNO
CUSTOMIZED DESIGN ON REQUEST





	ELICA DX - RH HELIX	ELICA DX - RH HELIX
TRATTAMENTO SUPERFICIALE SURFACE TREATMENT	Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc
MATERIALI LAVORABILI WORKING MATERIALS page 4D • 3	P1.1-P5.1 K1.1-K4.2 S1.1-S1.3 N1.1-N1.5 N2.1-N2.6 N3.1-N4.2	P1.1-P5.1 S1.1-S2.6 N1.1-N5.2 M1.1-M4.1 H1.1-H1.2
DATI TECNICI TECHNICAL DATA		

Filetto - Thread	(TPI)	d1	L1	L2	d2	Z		
1/4" UNC	20	4.5	49	7	6.0	3	FIGUNC50N	FIGUNC50T
1/4" UNF	28	4.5	49	7	6.0	3	FIGUNC52N	FIGUNC52T
5/16" UNC	18	5.5	48	9	6.0	3	FIGUNC54N	FIGUNC54T
5/16" UNF	24	5.5	48	9	6.0	3	FIGUNC56N	FIGUNC56T
3/8" UNC	16	7.5	57	12	8.0	3	FIGUNC58N	FIGUNC58T
7/16" UNC	14	8.0	57	12	8.0	3	FIGUNC60N	FIGUNC60T
7/16" UNF	20	8.0	57	12	8.0	3	FIGUNC62N	FIGUNC62T
3/8" UNC	24	8.0	57	12	8.0	3	FIGUNC64N	FIGUNC64T
9/16" UNC	12	10.0	70	15	10.0	4	FIGUNC66N	FIGUNC66T
1/2" UNC	13	10.0	70	15	10.0	4	FIGUNC68N	FIGUNC68T
5/8" UNF 9/16" UNF	18	10.0	70	15	10.0	4	FIGUNC70N	FIGUNC70T
1/2" UNF	20	10.0	70	15	10.0	4	FIGUNC72N	FIGUNC72T
5/8" UNF 9/16" UNF	18	12.0	70	18	12.0	4	FIGUNC74N	FIGUNC74T
5/8" UNC	11	12.0	70	18	12.0	4	FIGUNC76N	FIGUNC76T
3/4" UNF	16	15.5	84	24	16.0	5	FIGUNC78N	FIGUNC78T
3/4" UNC	10	15.5	84	24	16.0	5	FIGUNC80N	FIGUNC80T
7/8" UNF	14	15.5	84	24	16.0	5	FIGUNC82N	FIGUNC82T
7/8" UNC	9	18.0	97	27	18.0	5	FIGUNC84N	FIGUNC84T
7/8" UNF	14	18.0	97	27	18.0	5	FIGUNC86N	FIGUNC86T
1" UNC	8	20.0	100	30	20.0	5	FIGUNC88N	FIGUNC88T
1" UNF	12	20.0	100	30	20.0	5	FIGUNC90N	FIGUNC90T



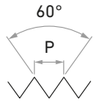
ELICA DX - RH HELIX	ELICA DX - RH HELIX	ELICA DX - RH HELIX	ELICA DX - RH HELIX
Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc	Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc
P1.1-P5.1 K1.1-K4.2 S1.1-S1.3 N1.1-N1.5 N2.1-N2.6 N3.1-N4.2	P1.1-P5.1 M1.1-M4.1 N1.1-N5.2 S1.1-S2.6 H1.1-H1.2	P1.1-P5.1 K1.1-K4.2 S1.1-S1.3 N1.1-N1.5 N2.1-N2.6 N3.1-N4.2	P1.1-P5.1 M1.1-M4.1 N1.1-N5.2 S1.1-S2.6 H1.1-H1.2

FIGUNC50NF	FIGUNC50F		
FIGUNC52NF	FIGUNC52F		
FIGUNC54NF	FIGUNC54F	FIGUNC54NG	FIGUNC54TG
FIGUNC56NF	FIGUNC56F	FIGUNC56NG	FIGUNC56TG
FIGUNC58NF	FIGUNC58F	FIGUNC58NG	FIGUNC58TG
FIGUNC60NF	FIGUNC60F	FIGUNC60NG	FIGUNC60TG
FIGUNC62NF	FIGUNC62F	FIGUNC62NG	FIGUNC62TG
FIGUNC64NF	FIGUNC64F	FIGUNC64NG	FIGUNC64TG
FIGUNC66NF	FIGUNC66F	FIGUNC66NG	FIGUNC66TG
FIGUNC68NF	FIGUNC68F	FIGUNC68NG	FIGUNC68TG
FIGUNC70NF	FIGUNC70F	FIGUNC70NG	FIGUNC70TG
FIGUNC72NF	FIGUNC72F	FIGUNC72NG	FIGUNC72TG
FIGUNC74NF	FIGUNC74F	FIGUNC74NG	FIGUNC74TG
FIGUNC76NF	FIGUNC76F	FIGUNC76NG	FIGUNC76TG
FIGUNC78NF	FIGUNC78F	FIGUNC78NG	FIGUNC78TG
FIGUNC80NF	FIGUNC80F	FIGUNC80NG	FIGUNC80TG
FIGUNC82NF	FIGUNC82F	FIGUNC82NG	FIGUNC82TG
FIGUNC84NF	FIGUNC84F	FIGUNC84NG	FIGUNC84TG
FIGUNC86NF	FIGUNC86F	FIGUNC86NG	FIGUNC86TG
FIGUNC88NF	FIGUNC88F	FIGUNC88NG	FIGUNC88TG
FIGUNC90NF	FIGUNC90F	FIGUNC90NG	FIGUNC90TG

INTERNAL 2xD

UNC, UNF

ASME B1.1



VHM | e8 | 2xD

R 10° | R9°-R11° | RH-LH

DIN 6535 HA

INTERNO INTERNAL

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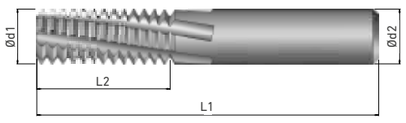
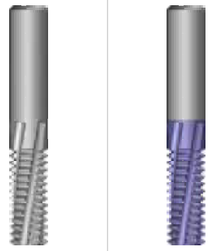
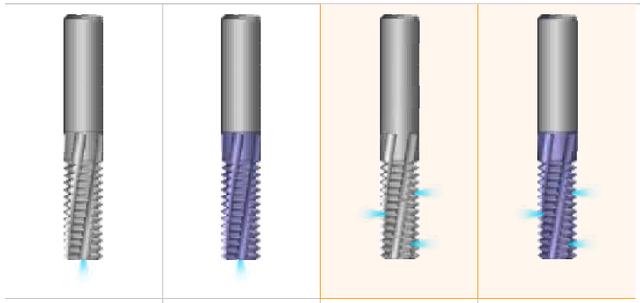
CUSTOMIZED DESIGN ON REQUEST





	ELICA DX - RH HELIX	ELICA DX - RH HELIX
TRATTAMENTO SUPERFICIALE SURFACE TREATMENT	Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc
MATERIALI LAVORABILI WORKING MATERIALS page 4D • 3	P1.1-P5.1 K1.1-K4.2 S1.1-S1.3 N1.1-N1.5 N2.1-N2.6 N3.1-N4.2	P1.1-P5.1 S1.1-S2.6 N1.1-N5.2 M1.1-M4.1 H1.1-H1.2
DATI TECNICI TECHNICAL DATA		

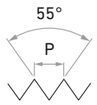
Filetto - Thread	(TPI)	d1	L1	L2	d2	Z		
1/4" UNC	20	4.5	54	12	6.0	3	FIGUNC01N	FIGUNC01T
1/4" UNF	28	4.5	54	12	6.0	3	FIGUNC03N	FIGUNC03T
5/16" UNC	18	5.5	54	15	6.0	3	FIGUNC07N	FIGUNC07T
5/16" UNF	24	5.5	54	15	6.0	3	FIGUNC09N	FIGUNC09T
3/8" UNC	16	7.5	65	20	8.0	3	FIGUNC05N	FIGUNC05T
7/16" UNC	14	8.0	65	20	8.0	3	FIGUNC11N	FIGUNC11T
7/16" UNF	20	8.0	65	20	8.0	3	FIGUNC13N	FIGUNC13T
3/8" UNC	24	8.0	65	20	8.0	3	FIGUNC15N	FIGUNC15T
9/16" UNC	12	10.0	80	25	10.0	4	FIGUNC17N	FIGUNC17T
1/2" UNC	13	10.0	80	25	10.0	4	FIGUNC19N	FIGUNC19T
5/8" UNF 9/16" UNF	18	10.0	80	25	10.0	4	FIGUNC21N	FIGUNC21T
1/2" UNF	20	10.0	80	25	10.0	4	FIGUNC23N	FIGUNC23T
5/8" UNF 9/16" UNF	18	12.0	82	30	12.0	4	FIGUNC25N	FIGUNC25T
5/8" UNC	11	12.0	82	30	12.0	4	FIGUNC27N	FIGUNC27T
3/4" UNF	16	15.5	100	40	16.0	5	FIGUNC29N	FIGUNC29T
3/4" UNC	10	15.5	100	40	16.0	5	FIGUNC31N	FIGUNC31T
7/8" UNF	14	15.5	100	40	16.0	5	FIGUNC33N	FIGUNC33T
7/8" UNC	9	18.0	110	40	18.0	5	FIGUNC35N	FIGUNC35T
7/8" UNF	14	18.0	110	40	18.0	5	FIGUNC37N	FIGUNC37T
1" UNC	8	20.0	110	40	20.0	5	FIGUNC39N	FIGUNC39T
1" UNF	12	20.0	110	40	20.0	5	FIGUNC41N	FIGUNC41T



ELICA DX - RH HELIX	ELICA DX - RH HELIX	ELICA DX - RH HELIX	ELICA DX - RH HELIX
Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc	Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc
P1.1-P5.1 K1.1-K4.2 S1.1-S1.3 N1.1-N1.5 N2.1-N2.6 N3.1-N4.2	P1.1-P5.1 M1.1-M4.1 N1.1-N5.2 S1.1-S2.6 H1.1-H1.2	P1.1-P5.1 K1.1-K4.2 S1.1-S1.3 N1.1-N1.5 N2.1-N2.6 N3.1-N4.2	P1.1-P5.1 M1.1-M4.1 N1.1-N5.2 S1.1-S2.6 H1.1-H1.2

FIGUNC01NF	FIGUNC01F		
FIGUNC03NF	FIGUNC03F		
FIGUNC07NF	FIGUNC07F	FIGUNC07NG	FIGUNC07TG
FIGUNC09NF	FIGUNC09F	FIGUNC09NG	FIGUNC09TG
FIGUNC05NF	FIGUNC05F	FIGUNC05NG	FIGUNC05TG
FIGUNC11NF	FIGUNC11F	FIGUNC11NG	FIGUNC11TG
FIGUNC13NF	FIGUNC13F	FIGUNC13NG	FIGUNC13TG
FIGUNC15NF	FIGUNC15F	FIGUNC15NG	FIGUNC15TG
FIGUNC17NF	FIGUNC17F	FIGUNC17NG	FIGUNC17TG
FIGUNC19NF	FIGUNC19F	FIGUNC19NG	FIGUNC19TG
FIGUNC21NF	FIGUNC21F	FIGUNC21NG	FIGUNC21TG
FIGUNC23NF	FIGUNC23F	FIGUNC23NG	FIGUNC23TG
FIGUNC25NF	FIGUNC25F	FIGUNC25NG	FIGUNC25TG
FIGUNC27NF	FIGUNC27F	FIGUNC27NG	FIGUNC27TG
FIGUNC29NF	FIGUNC29F	FIGUNC29NG	FIGUNC29TG
FIGUNC31NF	FIGUNC31F	FIGUNC31NG	FIGUNC31TG
FIGUNC33NF	FIGUNC33F	FIGUNC33NG	FIGUNC33TG
FIGUNC35NF	FIGUNC35F	FIGUNC35NG	FIGUNC35TG
FIGUNC37NF	FIGUNC37F	FIGUNC37NG	FIGUNC37TG
FIGUNC39NF	FIGUNC39F	FIGUNC39NG	FIGUNC39TG
FIGUNC41NF	FIGUNC41F	FIGUNC41NG	FIGUNC41TG

INT/EXT 1,5xD

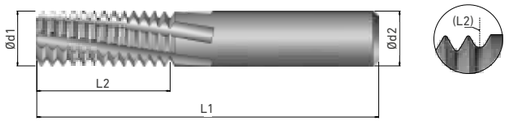


G(BSP), RP(BSPP), W

DIN EN ISO 228, DIN EN 10226-1, ISO 7/1, BS 84

ESECUZIONI SPECIALI A DISEGNO
CUSTOMIZED DESIGN ON REQUEST

VHM | e8 | 1,5xD
R 10° | R9°-R11° | RH-LH
DIN 6535 HA
INTERNO INTERNAL | ESTERNO EXTERNAL



	ELICA DX - RH HELIX	ELICA DX - RH HELIX
TRATTAMENTO SUPERFICIALE SURFACE TREATMENT	Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc
MATERIALI LAVORABILI WORKING MATERIALS page 4D • 3	P1.1-P5.1 K1.1-K4.2 S1.1-S1.3 N1.1-N1.5 N2.1-N2.6 N3.1-N4.2	P1.1-P5.1 S1.1-S2.6 N1.1-N5.2 M1.1-M4.1 H1.1-H1.2
DATI TECNICI TECHNICAL DATA		

Filetto - Thread	(TPI)	d1	L1	L2	d2	Z		
1/8"BSP	28	8.0	57	12	8.0	3	FIGGAW15N	FIGGAW15T
1/4"BSP	19	10.0	70	15	10.0	4	FIGGAW17N	FIGGAW17T
3/8"BSP	19	14.0	86	21	14.0	4	FIGGAW19N	FIGGAW19T
1/2"BSP	14	16.0	84	24	16.0	5	FIGGAW21N	FIGGAW21T
5/8"BSP 3/4"BSP 7/8"BSP	14	20.0	100	30	20.0	5	FIGGAW23N	FIGGAW23T
1" >BSP	11	20.0	100	30	20.0	5	FIGGAW25N	FIGGAW25T

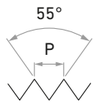
FIL

ELICA DX - RH HELIX	ELICA DX - RH HELIX	ELICA DX - RH HELIX	ELICA DX - RH HELIX
Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc	Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc
P1.1-P5.1 K1.1-K4.2 S1.1-S1.3 N1.1-N1.5 N2.1-N2.6 N3.1-N4.2	P1.1-P5.1 M1.1-M4.1 N1.1-N5.2 S1.1-S2.6 H1.1-H1.2	P1.1-P5.1 K1.1-K4.2 S1.1-S1.3 N1.1-N1.5 N2.1-N2.6 N3.1-N4.2	P1.1-P5.1 M1.1-M4.1 N1.1-N5.2 S1.1-S2.6 H1.1-H1.2

FIGGAW15NF	FIGGAW15F	FIGGAW15NG	FIGGAW15TG
FIGGAW17NF	FIGGAW17F	FIGGAW17NG	FIGGAW17TG
FIGGAW19NF	FIGGAW19F	FIGGAW19NG	FIGGAW19TG
FIGGAW21NF	FIGGAW21F	FIGGAW21NG	FIGGAW21TG
FIGGAW23NF	FIGGAW23F	FIGGAW23NG	FIGGAW23TG
FIGGAW25NF	FIGGAW25F	FIGGAW25NG	FIGGAW25TG

FIL

INT/EXT 2xD

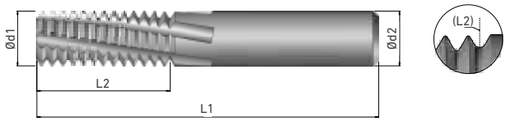


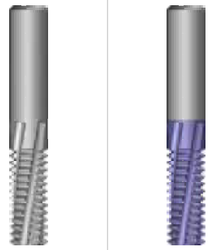
G(BSP), RP(BSPP), W

DIN EN ISO 228, DIN EN 10226-1, ISO 7/1, BS 84

ESECUZIONI SPECIALI A DISEGNO
CUSTOMIZED DESIGN ON REQUEST

VHM | e8 | 2xD
R 10° | R9°-R11° | RH-LH
DIN 6535 HA
INTERNO INTERNAL | ESTERNO EXTERNAL

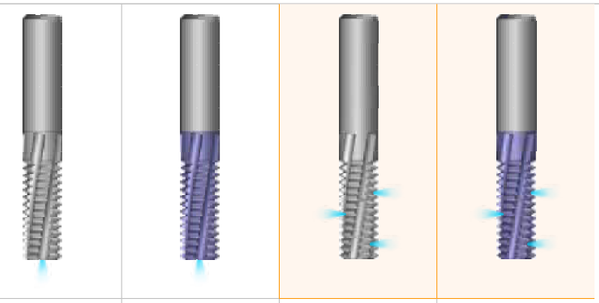




	ELICA DX - RH HELIX	ELICA DX - RH HELIX
TRATTAMENTO SUPERFICIALE / SURFACE TREATMENT	Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc
MATERIALI LAVORABILI / WORKING MATERIALS page 4D • 3	P1.1-P5.1 K1.1-K4.2 N1.1-N1.5 N2.1-N2.6 N3.1-N4.2 S1.1-S1.3	P1.1-P5.1 M1.1-M4.1 N1.1-N5.2 S1.1-S2.6 H1.1-H1.2
DATI TECNICI / TECHNICAL DATA		

Filetto - Thread	(TPI)	d1	L1	L2	d2	Z		
1/8"BSP	28	8.0	65	20	8.0	3	FIGGAW01N	FIGGAW01T
1/4"BSP	19	10.0	80	25	10.0	4	FIGGAW03N	FIGGAW03T
3/8"BSP	19	14.0	100	35	14.0	4	FIGGAW05N	FIGGAW05T
1/2"BSP	14	16.0	100	40	16.0	5	FIGGAW07N	FIGGAW07T
5/8"BSP 3/4"BSP 7/8"BSP	14	20.0	110	40	20.0	5	FIGGAW09N	FIGGAW09T
1" >BSP	11	20.0	110	40	20.0	5	FIGGAW11N	FIGGAW11T

FIL

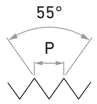


ELICA DX - RH HELIX	ELICA DX - RH HELIX	ELICA DX - RH HELIX	ELICA DX - RH HELIX
Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc	Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc
P1.1-P5.1 K1.1-K4.2 N1.1-N1.5 N2.1-N2.6 N3.1-N4.2 S1.1-S1.3	P1.1-P5.1 M1.1-M4.1 N1.1-N5.2 S1.1-S2.6 H1.1-H1.2	P1.1-P5.1 K1.1-K4.2 N1.1-N1.5 N2.1-N2.6 N3.1-N4.2 S1.1-S1.3	P1.1-P5.1 M1.1-M4.1 N1.1-N5.2 S1.1-S2.6 H1.1-H1.2

FIGGAW01NF	FIGGAW01F	FIGGAW01NG	FIGGAW01TG
FIGGAW03NF	FIGGAW03F	FIGGAW03NG	FIGGAW03TG
FIGGAW05NF	FIGGAW05F	FIGGAW05NG	FIGGAW05TG
FIGGAW07NF	FIGGAW07F	FIGGAW07NG	FIGGAW07TG
FIGGAW09NF	FIGGAW09F	FIGGAW09NG	FIGGAW09TG
FIGGAW11NF	FIGGAW11F	FIGGAW11NG	FIGGAW11TG

FIL

INT/EXT 2xD

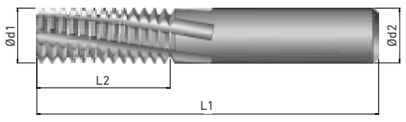


BSW, BSF

B.S.84:1956, DIN 259, ISO228/1:1982

ESECUZIONI SPECIALI A DISEGNO
CUSTOMIZED DESIGN ON REQUEST

VHM | e8 | 2xD
R 10° | RH-LH
DIN 6535 HA
INTERNO INTERNAL | ESTERNO EXTERNAL



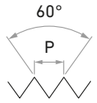
	ELICA DX - RH HELIX	ELICA DX - RH HELIX
TRATTAMENTO SUPERFICIALE SURFACE TREATMENT	Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc
MATERIALI LAVORABILI WORKING MATERIALS page 4D • 3	P1.1-P5.1 K1.1-K4.2 N1.1-N1.5 N2.1-N2.6 N3.1-N4.2 S1.1-S1.3	P1.1-P5.1 M1.1-M4.1 N1.1-N5.2 S1.1-S2.6 H1.1-H1.2

Filetto - Thread	(TPI)	d1	L1	L2	d2	Z		
1/4"BSF	26	5.00	57	12.7	6.0	3	**FIGBSW01N**	**FIGBSW01T**
5/16"BSF	22	6.35	61	16.2	8.0	3	**FIGBSW03N**	**FIGBSW03T**
1/4"BSW 3/8"BSF	20	4.45	57	12.7	6.0	3	**FIGBSW05N**	**FIGBSW05T**
3/8"BSF	20	7.65	61	19.0	8.0	3	**FIGBSW07N**	**FIGBSW07T**
5/16"BSW 7/16"BSF	18	5.85	57	15.5	6.0	3	**FIGBSW09N**	**FIGBSW09T**
7/16"BSF	18	9.20	73	22.6	10.0	3	**FIGBSW11N**	**FIGBSW11T**
3/8"BSW 1/2"BSF 9/16"BSF	16	7.20	61	19.0	8.0	3	**FIGBSW13N**	**FIGBSW13T**
1/2"BSF 9/16"BSF	16	10.50	80	25.4	12.0	4	**FIGBSW15N**	**FIGBSW15T**
9/16"BSF	16	12.15	92	28.6	14.0	4	**FIGBSW17N**	**FIGBSW17T**
7/16"BSW 5/8"BSF 11/16"BSF	14	8.50	73	21.8	10.0	3	**FIGBSW19N**	**FIGBSW19T**
5/8"BSF 11/16"BSF	14	13.40	92	30.8	14.0	4	**FIGBSW21N**	**FIGBSW21T**
11/16"BSF	14	15.00	92	34.5	16.0	4	**FIGBSW23N**	**FIGBSW23T**
1/2"BSW 3/4"BSF	12	9.65	73	25.4	10.0	3	**FIGBSW25N**	**FIGBSW25T**
9/16"BSW 3/4"BSF	12	11.25	80	27.5	12.0	4	**FIGBSW27N**	**FIGBSW27T**
3/4"BSF	12	16.20	102	38.1	18.0	4	**FIGBSW29N**	**FIGBSW29T**
5/8"BSW 7/8"BSF	11	12.60	92	32.3	14.0	4	**FIGBSW31N**	**FIGBSW31T**
11/16"BSW	11	14.20	92	34.6	16.0	4	**FIGBSW33N**	**FIGBSW33T**

ELICA DX - RH HELIX	ELICA DX - RH HELIX
Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc
P1.1-P5.1 K1.1-K4.2 N1.1-N1.5 N2.1-N2.6 N3.1-N4.2 S1.1-S1.3	P1.1-P5.1 M1.1-M4.1 N1.1-N5.2 S1.1-S2.6 H1.1-H1.2

FIGBSW01NF	**FIGBSW01F**
FIGBSW03NF	**FIGBSW03F**
FIGBSW05NF	**FIGBSW05F**
FIGBSW07NF	**FIGBSW07F**
FIGBSW09NF	**FIGBSW09F**
FIGBSW11NF	**FIGBSW11F**
FIGBSW13NF	**FIGBSW13F**
FIGBSW15NF	**FIGBSW15F**
FIGBSW17NF	**FIGBSW17F**
FIGBSW19NF	**FIGBSW19F**
FIGBSW21NF	**FIGBSW21F**
FIGBSW23NF	**FIGBSW23F**
FIGBSW25NF	**FIGBSW25F**
FIGBSW27NF	**FIGBSW27F**
FIGBSW29NF	**FIGBSW29F**
FIGBSW31NF	**FIGBSW31F**
FIGBSW33NF	**FIGBSW33F**

INTERNAL 1,5xD THRILLER

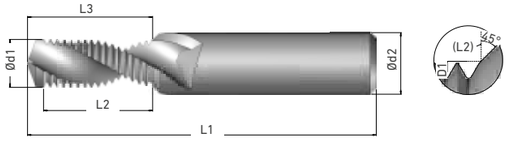


M, MF

DIN 13

ESECUZIONI SPECIALI A DISEGNO
CUSTOMIZED DESIGN ON REQUEST

VHM | e8 | 1,5xD | R 40° | RH | DIN 6535 HA | 140° | INTERNO INTERNAL



	ELICA DX - RH HELIX	ELICA DX - RH HELIX
TRATTAMENTO SUPERFICIALE SURFACE TREATMENT	Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc
MATERIALI LAVORABILI WORKING MATERIALS page 4D • 4	P1.1-P5.1 K1.1-K4.2 N1.1-N1.5 N2.1-N2.6 N3.1-N4.2 S1.1-S1.3	P1.1-P5.1 M1.1-M4.1 N1.1-N5.2 S1.1-S2.6 H1.1-H1.2

Filetto - Thread	Pitch mm	d1	L1	L2	L3	d2	Z		
MF4	0.50	3.50	49	5.05	7.20	6.0	2	**FIGMFF12N**	**FIGMFF12T**
M4	0.70	3.30	49	5.64	6.90	6.0	2	**FIGMFF14N**	**FIGMFF14T**
MF5	0.50	4.50	55	7.56	8.90	6.0	2	**FIGMFF16N**	**FIGMFF16T**
M5	0.80	4.20	55	7.25	8.85	6.0	2	**FIGMFF18N**	**FIGMFF18T**
MF6	0.75	5.25	62	9.07	10.77	8.0	2	**FIGMFF20N**	**FIGMFF20T**
M6	1.00	5.00	62	9.06	10.95	8.0	2	**FIGMFF22N**	**FIGMFF22T**
MF8	1.00	7.00	74	12.09	14.45	10.0	2	**FIGMFF24N**	**FIGMFF24T**
M8	1.25	6.75	74	11.33	13.82	10.0	2	**FIGMFF26N**	**FIGMFF26T**
MF10	1.00	9.00	79	15.11	17.75	12.0	2	**FIGMFF28N**	**FIGMFF28T**
MF10	1.25	8.75	79	15.11	18.12	12.0	2	**FIGMFF30N**	**FIGMFF30T**
M10	1.50	8.50	79	15.90	18.20	12.0	2	**FIGMFF32N**	**FIGMFF32T**
MF12	1.00	11.00	89	17.14	20.15	14.0	2	**FIGMFF34N**	**FIGMFF34T**
MF12	1.25	10.75	89	18.88	22.22	14.0	2	**FIGMFF36N**	**FIGMFF36T**
MF12	1.50	10.50	89	18.12	21.60	14.0	2	**FIGMFF38N**	**FIGMFF38T**
M12	1.75	10.25	89	17.61	21.22	14.0	2	**FIGMFF40N**	**FIGMFF40T**
M14	2.00	12.00	102	20.12	24.35	16.0	2	**FIGMFF42N**	**FIGMFF42T**
MF14	1.50	12.50	102	21.14	24.90	16.0	2	**FIGMFF44N**	**FIGMFF44T**
MF16	1.50	14.50	102	24.15	28.40	18.0	2	**FIGMFF46N**	**FIGMFF46T**
M16	2.00	14.00	102	24.13	28.75	18.0	2	**FIGMFF48N**	**FIGMFF48T**

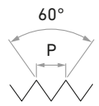
	ELICA DX - RH HELIX	ELICA DX - RH HELIX
	Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc
	P1.1-P5.1 K1.1-K4.2 N1.1-N1.5 N2.1-N2.6 N3.1-N4.2 S1.1-S1.3	P1.1-P5.1 M1.1-M4.1 N1.1-N5.2 S1.1-S2.6 H1.1-H1.2

FIGMFF12NF	**FIGMFF12F**
FIGMFF14NF	**FIGMFF14F**
FIGMFF16NF	**FIGMFF16F**
FIGMFF18NF	**FIGMFF18F**
FIGMFF20NF	**FIGMFF20F**
FIGMFF22NF	**FIGMFF22F**
FIGMFF24NF	**FIGMFF24F**
FIGMFF26NF	**FIGMFF26F**
FIGMFF28NF	**FIGMFF28F**
FIGMFF30NF	**FIGMFF30F**
FIGMFF32NF	**FIGMFF32F**
FIGMFF34NF	**FIGMFF34F**
FIGMFF36NF	**FIGMFF36F**
FIGMFF38NF	**FIGMFF38F**
FIGMFF40NF	**FIGMFF40F**
FIGMFF42NF	**FIGMFF42F**
FIGMFF44NF	**FIGMFF44F**
FIGMFF46NF	**FIGMFF46F**
FIGMFF48NF	**FIGMFF48F**

INTERNAL 2xD THRILLER

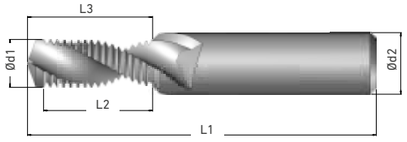
M, MF

DIN 13



VHM | e8 | 2xD | R 40° | RH | DIN 6535 HA | 140° | INTERNO INTERNAL

ESECUZIONI SPECIALI A DISEGNO
CUSTOMIZED DESIGN ON REQUEST



	ELICA DX - RH HELIX	ELICA DX - RH HELIX
TRATTAMENTO SUPERFICIALE SURFACE TREATMENT	Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc
MATERIALI LAVORABILI WORKING MATERIALS page 4D • 4	P1.1-P5.1 K1.1-K4.2 N1.1-N1.5 N2.1-N2.6 N3.1-N4.2 S1.1-S1.3	P1.1-P5.1 M1.1-M4.1 N1.1-N5.2 S1.1-S2.6 H1.1-H1.2

Filetto - Thread	Pitch mm	d1	L1	L2	L3	d2	Z		
MF 4	0.50	3.50	55	7.95	9.20	6.0	2	**FIGMFF50N**	**FIGMFF50T**
M 4	0.70	3.30	55	7.65	9.00	6.0	2	**FIGMFF51N**	**FIGMFF51T**
MF 5	0.50	4.50	55	9.95	11.40	6.0	2	**FIGMFF52N**	**FIGMFF52T**
M 5	0.80	4.20	55	9.55	11.25	6.0	2	**FIGMFF53N**	**FIGMFF53T**
MF 6	0.75	5.25	62	11.95	13.82	8.0	2	**FIGMFF54N**	**FIGMFF54T**
M 6	1.00	5.00	62	12.05	13.95	8.0	2	**FIGMFF56N**	**FIGMFF56T**
MF 8	1.00	7.00	74	15.90	18.45	10.0	2	**FIGMFF58N**	**FIGMFF58T**
M 8	1.25	6.75	74	15.07	17.52	10.0	2	**FIGMFF60N**	**FIGMFF60T**
MF 10	1.00	9.00	79	20.10	22.75	12.0	2	**FIGMFF62N**	**FIGMFF62T**
MF 10	1.25	8.75	79	20.10	23.12	12.0	2	**FIGMFF64N**	**FIGMFF64T**
M 10	1.50	8.50	79	19.58	22.70	12.0	2	**FIGMFF66N**	**FIGMFF66T**
MF 12	1.00	11.00	89	23.90	27.15	14.0	2	**FIGMFF68N**	**FIGMFF68T**
MF 12	1.25	10.75	89	23.90	27.22	14.0	2	**FIGMFF70N**	**FIGMFF70T**
MF 12	1.50	10.50	89	24.10	27.60	14.0	2	**FIGMFF72N**	**FIGMFF72T**
M 12	1.75	10.25	89	22.85	26.47	14.0	2	**FIGMFF74N**	**FIGMFF74T**
M 14	2.00	12.00	102	28.11	32.35	16.0	2	**FIGMFF75N**	**FIGMFF75T**
MF 14	1.50	12.50	102	27.12	31.00	16.0	2	**FIGMFF76N**	**FIGMFF76T**
MF 16	1.50	14.50	102	31.65	35.90	18.0	2	**FIGMFF78N**	**FIGMFF78T**
M 16	2.00	14.00	102	32.11	36.75	18.0	2	**FIGMFF80N**	**FIGMFF80T**

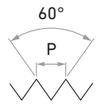
	ELICA DX - RH HELIX	ELICA DX - RH HELIX
	Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc
	P1.1-P5.1 K1.1-K4.2 N1.1-N1.5 N2.1-N2.6 N3.1-N4.2 S1.1-S1.3	P1.1-P5.1 M1.1-M4.1 N1.1-N5.2 S1.1-S2.6 H1.1-H1.2

FIGMFF50NF	**FIGMFF50F**
FIGMFF51NF	**FIGMFF51F**
FIGMFF52NF	**FIGMFF52F**
FIGMFF53NF	**FIGMFF53F**
FIGMFF54NF	**FIGMFF54F**
FIGMFF56NF	**FIGMFF56F**
FIGMFF58NF	**FIGMFF58F**
FIGMFF60NF	**FIGMFF60F**
FIGMFF62NF	**FIGMFF62F**
FIGMFF64NF	**FIGMFF64F**
FIGMFF66NF	**FIGMFF66F**
FIGMFF68NF	**FIGMFF68F**
FIGMFF70NF	**FIGMFF70F**
FIGMFF72NF	**FIGMFF72F**
FIGMFF74NF	**FIGMFF74F**
FIGMFF75NF	**FIGMFF75F**
FIGMFF76NF	**FIGMFF76F**
FIGMFF78NF	**FIGMFF78F**
FIGMFF80NF	**FIGMFF80F**

INTERNAL 2,5xD THRILLER

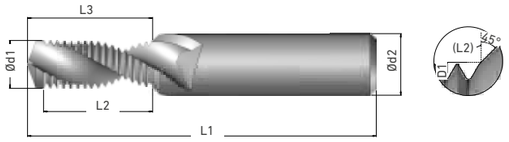
M, MF

DIN 13



VHM | e8 | 2,5xD | R 40° | RH | DIN 6535 HA | 140° | INTERNO INTERNAL

ESECUZIONI SPECIALI A DISEGNO
CUSTOMIZED DESIGN ON REQUEST



	ELICA DX - RH HELIX	ELICA DX - RH HELIX
TRATTAMENTO SUPERFICIALE SURFACE TREATMENT	Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc
MATERIALI LAVORABILI WORKING MATERIALS page 4D • 4	P1.1-P5.1 K1.1-K4.2 N1.1-N1.5 N2.1-N2.6 N3.1-N4.2 S1.1-S1.3	P1.1-P5.1 M1.1-M4.1 N1.1-N5.2 S1.1-S2.6 H1.1-H1.2

Filetto - Thread	Pitch mm	d1	L1	L2	L3	d2	Z		
M 6	1.00	5.00	65	15.10	16.95	8.0	2	FIGMFF82N	FIGMFF82T
M 8	1.25	6.75	80	20.08	22.52	10.0	2	FIGMFF84N	FIGMFF84T
M 10	1.50	8.50	85	25.59	28.70	12.0	2	FIGMFF86N	FIGMFF86T
M 12	1.75	10.25	95	29.86	33.47	14.0	2	FIGMFF88N	FIGMFF88T
M 14	2.00	12.00	110	36.12	40.35	16.0	2	FIGMFF90N	FIGMFF90T
M 16	2.00	14.00	110	40.13	44.75	18.0	2	FIGMFF92N	FIGMFF92T

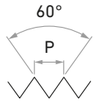
FIL

	ELICA DX - RH HELIX	ELICA DX - RH HELIX
	Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc
	P1.1-P5.1 K1.1-K4.2 N1.1-N1.5 N2.1-N2.6 N3.1-N4.2 S1.1-S1.3	P1.1-P5.1 M1.1-M4.1 N1.1-N5.2 S1.1-S2.6 H1.1-H1.2

FIGMFF82NF	FIGMFF82F
FIGMFF84NF	FIGMFF84F
FIGMFF86NF	FIGMFF86F
FIGMFF88NF	FIGMFF88F
FIGMFF90NF	FIGMFF90F
FIGMFF92NF	FIGMFF92F

FIL

INTERNAL 1,5xD THRILLER

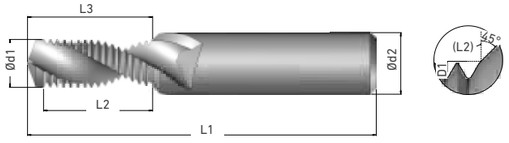


UNC, UNF

ASME B1.1

ESECUZIONI SPECIALI A DISEGNO
CUSTOMIZED DESIGN ON REQUEST

VHM | e8 | 1,5xD | R 40° | RH | DIN 6535 HA | 140° | INTERNO INTERNAL



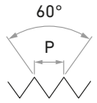
	ELICA DX - RH HELIX	ELICA DX - RH HELIX
TRATTAMENTO SUPERFICIALE SURFACE TREATMENT	Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc
MATERIALI LAVORABILI WORKING MATERIALS page 4D • 4	P1.1-P5.1 K1.1-K4.2 N1.1-N1.5 N2.1-N2.6 N3.1-N4.2 S1.1-S1.3	P1.1-P5.1 M1.1-M4.1 N1.1-N5.2 S1.1-S2.6 H1.1-H1.2

Filetto - Thread	(TPI)	d1	L1	L2	L3	d2	Z		
No. 10 UNF	32	4.10	55	7.24	8.77	6.0	2	**FIGUFF12N**	**FIGUFF12T**
No. 10 UNC	24	4.50	62	7.50	9.35	8.0	2	**FIGUFF14N**	**FIGUFF14T**
No. 12 UNF	28	4.65	62	8.27	10.02	8.0	2	**FIGUFF16N**	**FIGUFF16T**
1/4" UNC	20	5.20	62	8.99	11.27	8.0	2	**FIGUFF18N**	**FIGUFF18T**
1/4" UNF	28	5.50	62	9.16	11.02	8.0	2	**FIGUFF20N**	**FIGUFF20T**
5/16" UNC	18	6.60	74	11.39	14.07	10.0	2	**FIGUFF22N**	**FIGUFF22T**
5/16" UNF	24	6.90	74	11.74	14.02	10.0	2	**FIGUFF24N**	**FIGUFF24T**
3/8" UNC	16	8.00	79	14.40	17.48	12.0	2	**FIGUFF26N**	**FIGUFF26T**
3/8" UNF	24	8.50	79	13.87	16.52	12.0	2	**FIGUFF28N**	**FIGUFF28T**
7/16" UNC	14	9.40	79	16.45	19.98	12.0	2	**FIGUFF30N**	**FIGUFF30T**
7/16" UNF	20	9.90	79	17.91	20.95	12.0	2	**FIGUFF32N**	**FIGUFF32T**
1/2" UNC	13	10.75	89	17.71	21.67	14.0	2	**FIGUFF34N**	**FIGUFF34T**
1/2" UNF	20	11.50	89	19.20	22.55	14.0	2	**FIGUFF36N**	**FIGUFF36T**
9/16" UNC	12	12.25	102	21.31	25.72	16.0	2	**FIGUFF38N**	**FIGUFF38T**
9/16" UNF	18	12.90	102	21.32	25.05	16.0	2	**FIGUFF40N**	**FIGUFF40T**
5/8" UNC	11	13.50	102	23.21	27.96	18.0	2	**FIGUFF42N**	**FIGUFF42T**
5/8" UNF	18	14.50	102	22.74	26.75	18.0	2	**FIGUFF44N**	**FIGUFF44T**
3/4" UNC	10	16.50	115	28.10	33.67	20.0	2	**FIGUFF46N**	**FIGUFF46T**
3/4" UNF	16	17.50	115	28.78	33.55	20.0	2	**FIGUFF48N**	**FIGUFF48T**

	ELICA DX - RH HELIX	ELICA DX - RH HELIX
	Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc
	P1.1-P5.1 K1.1-K4.2 N1.1-N1.5 N2.1-N2.6 N3.1-N4.2 S1.1-S1.3	P1.1-P5.1 M1.1-M4.1 N1.1-N5.2 S1.1-S2.6 H1.1-H1.2

FIGUFF12NF	**FIGUFF12F**
FIGUFF14NF	**FIGUFF14F**
FIGUFF16NF	**FIGUFF16F**
FIGUFF18NF	**FIGUFF18F**
FIGUFF20NF	**FIGUFF20F**
FIGUFF22NF	**FIGUFF22F**
FIGUFF24NF	**FIGUFF24F**
FIGUFF26NF	**FIGUFF26F**
FIGUFF28NF	**FIGUFF28F**
FIGUFF30NF	**FIGUFF30F**
FIGUFF32NF	**FIGUFF32F**
FIGUFF34NF	**FIGUFF34F**
FIGUFF36NF	**FIGUFF36F**
FIGUFF38NF	**FIGUFF38F**
FIGUFF40NF	**FIGUFF40F**
FIGUFF42NF	**FIGUFF42F**
FIGUFF44NF	**FIGUFF44F**
FIGUFF46NF	**FIGUFF46F**
FIGUFF48NF	**FIGUFF48F**

INTERNAL 2xD THRILLER

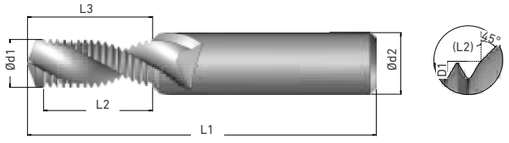


UNC, UNF

ASME B1.1

VHM | e8 | 2xD | R 40° | RH | DIN 6535 HA | 140° | INTERNO INTERNAL

ESECUZIONI SPECIALI A DISEGNO
CUSTOMIZED DESIGN ON REQUEST



	ELICA DX - RH HELIX	ELICA DX - RH HELIX
TRATTAMENTO SUPERFICIALE SURFACE TREATMENT	Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc
MATERIALI LAVORABILI WORKING MATERIALS page 4D • 4	P1.1-P5.1 K1.1-K4.2 N1.1-N1.5 N2.1-N2.6 N3.1-N4.2 S1.1-S1.3	P1.1-P5.1 M1.1-M4.1 N1.1-N5.2 S1.1-S2.6 H1.1-H1.2

Filetto - Thread	(TPI)	d1	L1	L2	L3	d2	Z		
No. 10 UNF	32	4.10	55	9.60	11.17	6.0	2	**FIGUFF50N**	**FIGUFF50T**
No. 10 UNC	24	4.50	62	10.65	12.55	8.0	2	**FIGUFF52N**	**FIGUFF52T**
No. 12 UNF	28	4.65	62	10.95	12.72	8.0	2	**FIGUFF54N**	**FIGUFF54T**
1/4" UNC	20	5.20	62	12.75	15.07	8.0	2	**FIGUFF56N**	**FIGUFF56T**
1/4" UNF	28	5.50	62	12.75	14.72	8.0	2	**FIGUFF58N**	**FIGUFF58T**
5/16" UNC	18	6.60	74	15.60	18.27	10.0	2	**FIGUFF60N**	**FIGUFF60T**
5/16" UNF	24	6.90	74	15.95	18.32	10.0	2	**FIGUFF62N**	**FIGUFF62T**
3/8" UNC	16	8.00	80	19.15	22.28	12.0	2	**FIGUFF64N**	**FIGUFF64T**
3/8" UNF	24	8.50	80	19.15	21.82	12.0	2	**FIGUFF66N**	**FIGUFF66T**
7/16" UNC	14	9.40	80	21.85	25.48	12.0	2	**FIGUFF68N**	**FIGUFF68T**
7/16" UNF	20	9.90	80	21.70	24.85	12.0	2	**FIGUFF70N**	**FIGUFF70T**
1/2" UNC	13	10.75	89	25.50	29.47	14.0	2	**FIGUFF72N**	**FIGUFF72T**
1/2" UNF	20	11.50	89	25.55	29.05	14.0	2	**FIGUFF74N**	**FIGUFF74T**
9/16" UNC	12	12.25	102	27.65	32.12	16.0	2	**FIGUFF76N**	**FIGUFF76T**
9/16" UNF	18	12.90	102	28.35	32.25	16.0	2	**FIGUFF78N**	**FIGUFF78T**
5/8" UNC	11	13.50	102	30.15	34.96	18.0	2	**FIGUFF80N**	**FIGUFF80T**
5/8" UNF	18	14.50	102	31.20	35.35	18.0	2	**FIGUFF82N**	**FIGUFF82T**
3/4" UNC	10	16.50	115	38.25	43.87	20.0	2	**FIGUFF84N**	**FIGUFF84T**
3/4" UNC	16	17.50	115	38.30	43.15	20.0	2	**FIGUFF86N**	**FIGUFF86T**

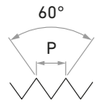
	ELICA DX - RH HELIX	ELICA DX - RH HELIX
	Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc
	P1.1-P5.1 K1.1-K4.2 N1.1-N1.5 N2.1-N2.6 N3.1-N4.2 S1.1-S1.3	P1.1-P5.1 M1.1-M4.1 N1.1-N5.2 S1.1-S2.6 H1.1-H1.2

FIGUFF50NF	**FIGUFF50F**
FIGUFF52NF	**FIGUFF52F**
FIGUFF54NF	**FIGUFF54F**
FIGUFF56NF	**FIGUFF56F**
FIGUFF58NF	**FIGUFF58F**
FIGUFF60NF	**FIGUFF60F**
FIGUFF62NF	**FIGUFF62F**
FIGUFF64NF	**FIGUFF64F**
FIGUFF66NF	**FIGUFF66F**
FIGUFF68NF	**FIGUFF68F**
FIGUFF70NF	**FIGUFF70F**
FIGUFF72NF	**FIGUFF72F**
FIGUFF74NF	**FIGUFF74F**
FIGUFF76NF	**FIGUFF76F**
FIGUFF78NF	**FIGUFF78F**
FIGUFF80NF	**FIGUFF80F**
FIGUFF82NF	**FIGUFF82F**
FIGUFF84NF	**FIGUFF84F**
FIGUFF86NF	**FIGUFF86F**

INTERNAL 2,5xD THRILLER

UNC

ASME B1.1



VHM | e8 | 2,5xD | R 40° | RH | DIN 6535 HA | 140° | INTERNO INTERNAL

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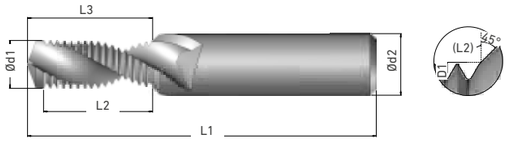
CUSTOMIZED DESIGN ON REQUEST



	ELICA DX - RH HELIX	ELICA DX - RH HELIX
TRATTAMENTO SUPERFICIALE SURFACE TREATMENT	Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc
MATERIALI LAVORABILI WORKING MATERIALS page 4D • 4	P1.1-P5.1 K1.1-K4.2 N1.1-N1.5 N2.1-N2.6 N3.1-N4.2 S1.1-S1.3	P1.1-P5.1 M1.1-M4.1 N1.1-N5.2 S1.1-S2.6 H1.1-H1.2

Filetto - Thread	(TPI)	d1	L1	L2	L3	d2	Z		
3/8" UNC	16	8.00	85	23.93	26.98	12.0	2	FIGUFF90N	FIGUFF90T
7/16" UNC	14	9.40	85	27.33	30.88	12.0	2	FIGUFF92N	FIGUFF92T
1/2" UNC	13	10.75	95	31.39	35.37	14.0	2	FIGUFF94N	FIGUFF94T
9/16" UNC	12	12.25	110	34.01	38.42	16.0	2	FIGUFF96N	FIGUFF96T
5/8" UNC	11	13.50	110	39.38	44.16	18.0	2	FIGUFF98N	FIGUFF98T
3/4" UNC	10	16.50	125	45.88	51.47	20.0	2	FIGUFF100N	FIGUFF100T

FIL

ELICA DX - RH HELIX	ELICA DX - RH HELIX
Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc
P1.1-P5.1 K1.1-K4.2 N1.1-N1.5 N2.1-N2.6 N3.1-N4.2 S1.1-S1.3	P1.1-P5.1 M1.1-M4.1 N1.1-N5.2 S1.1-S2.6 H1.1-H1.2

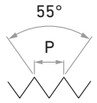
FIGUFF90NF	FIGUFF90F
FIGUFF92NF	FIGUFF92F
FIGUFF94NF	FIGUFF94F
FIGUFF96NF	FIGUFF96F
FIGUFF98NF	FIGUFF98F
FIGUFF100NF	FIGUFF100F

FIL

INTERNAL 1,5xD THRILLER

G

DIN EN ISO 228



VHM | e8 | 1,5xD

R 40° | RH

DIN 6535 HA

140° | INTERNO INTERNAL

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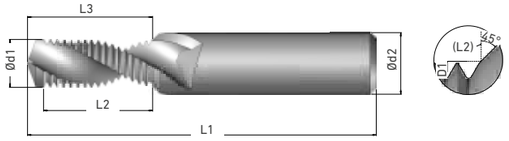
CUSTOMIZED DESIGN ON REQUEST



	ELICA DX - RH HELIX	ELICA DX - RH HELIX
TRATTAMENTO SUPERFICIALE SURFACE TREATMENT	Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc
MATERIALI LAVORABILI WORKING MATERIALS page 4D • 4	P1.1-P5.1 K1.1-K4.2 N1.1-N1.5 N2.1-N2.6 N3.1-N4.2 S1.1-S1.3	P1.1-P5.1 M1.1-M4.1 N1.1-N5.2 S1.1-S2.6 H1.1-H1.2

Filetto - Thread	(TPI)	d1	L1	L2	L3	d2	Z		
1/8"	28	8.80	79	14.56	17.10	12.0	2	FIGGFF20N	FIGGFF20T
1/4"	19	11.80	102	18.77	22.25	16.0	2	FIGGFF22N	FIGGFF22T
3/8"	19	15.25	102	25.46	29.62	18.0	2	FIGGFF24N	FIGGFF24T

ELICA DX - RH HELIX	ELICA DX - RH HELIX
Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc
P1.1-P5.1 K1.1-K4.2 N1.1-N1.5 N2.1-N2.6 N3.1-N4.2 S1.1-S1.3	P1.1-P5.1 M1.1-M4.1 N1.1-N5.2 S1.1-S2.6 H1.1-H1.2

FIGGFF20NF	FIGGFF20F
FIGGFF22NF	FIGGFF22F
FIGGFF24NF	FIGGFF24F

INTERNAL 2xD THRILLER

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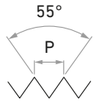
DIN EN ISO 228



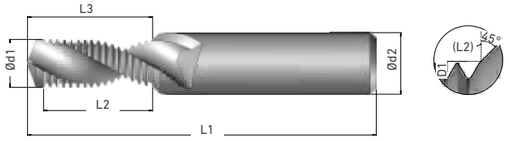
VHM | e8 | 2xD

R 40° | RH

DIN 6535 HA

140° | INTERNO INTERNAL

ESECUZIONI SPECIALI A DISEGNO
CUSTOMIZED DESIGN ON REQUEST



	ELICA DX - RH HELIX	ELICA DX - RH HELIX
TRATTAMENTO SUPERFICIALE SURFACE TREATMENT	Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc
MATERIALI LAVORABILI WORKING MATERIALS page 4D • 4	P1.1-P5.1 K1.1-K4.2 N1.1-N1.5 N2.1-N2.6 N3.1-N4.2 S1.1-S1.3	P1.1-P5.1 M1.1-M4.1 N1.1-N5.2 S1.1-S2.6 H1.1-H1.2

Filetto - Thread	(TPI)	d1	L1	L2	L3	d2	Z		
1/8"	28	8.80	79	18.98	21.80	12.0	2	FIGGFF50N	FIGGFF50T
1/4"	19	11.80	102	25.30	28.45	16.0	2	FIGGFF52N	FIGGFF52T
3/8"	19	15.25	102	37.40	41.82	18.0	2	FIGGFF54N	FIGGFF54T

FIL

	ELICA DX - RH HELIX	ELICA DX - RH HELIX
	Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc
	P1.1-P5.1 K1.1-K4.2 N1.1-N1.5 N2.1-N2.6 N3.1-N4.2 S1.1-S1.3	P1.1-P5.1 M1.1-M4.1 N1.1-N5.2 S1.1-S2.6 H1.1-H1.2

FIGGFF50NF	FIGGFF50F
FIGGFF52NF	FIGGFF52F
FIGGFF54NF	FIGGFF54F

FIL

INTERNAL 2,5xD THRILLER

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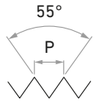
DIN EN ISO 228



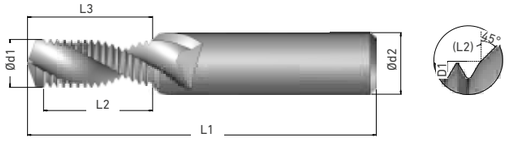
VHM | e8 | 2,5xD

R 40° | RH

DIN 6535 HA

140° | INTERNO INTERNAL

ESECUZIONI SPECIALI A DISEGNO
CUSTOMIZED DESIGN ON REQUEST



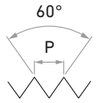
	ELICA DX - RH HELIX	ELICA DX - RH HELIX
TRATTAMENTO SUPERFICIALE SURFACE TREATMENT	Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc
MATERIALI LAVORABILI WORKING MATERIALS page 4D • 4	P1.1-P5.1 K1.1-K4.2 N1.1-N1.5 N2.1-N2.6 N3.1-N4.2 S1.1-S1.3	P1.1-P5.1 M1.1-M4.1 N1.1-N5.2 S1.1-S2.6 H1.1-H1.2

Filetto - Thread	(TPI)	d1	L1	L2	L3	d2	Z		
1/8"	28	8.80	79	23.32	26.40	12.0	2	FIGGFF70N	FIGGFF70T
1/4"	19	11.80	102	31.27	35.40	16.0	2	FIGGFF72N	FIGGFF72T
3/8"	19	15.25	102	40.41	47.27	18.0	2	FIGGFF74N	FIGGFF74T

	ELICA DX - RH HELIX	ELICA DX - RH HELIX
	Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc
	P1.1-P5.1 K1.1-K4.2 N1.1-N1.5 N2.1-N2.6 N3.1-N4.2 S1.1-S1.3	P1.1-P5.1 M1.1-M4.1 N1.1-N5.2 S1.1-S2.6 H1.1-H1.2

FIGGFF70NF	FIGGFF70F
FIGGFF72NF	FIGGFF72F
FIGGFF74NF	FIGGFF74F

INTERNAL WITH CHAMFER 2xD

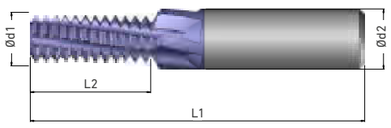


M, MF

DIN 13

VHM | e8 | 2xD | R 10° | RH-LH | DIN 6535 HA | INTERNO INTERNAL

ESECUZIONI SPECIALI A DISEGNO
CUSTOMIZED DESIGN ON REQUEST



ELICA DX - RH HELIX

TRATTAMENTO SUPERFICIALE
SURFACE TREATMENT: Coated TNF ≤45 Hrc

MATERIALI LAVORABILI
WORKING MATERIALS
page 4D • 4

- P1.1-P5.1
- M1.1-M4.1
- N1.1-N5.2
- S1.1-S2.6
- H1.1-H1.2

Filetto - Thread	Pitch mm	d1	L1	L2	d2	Z	
M 5	0.80	4.0	55	10.75	6.0	3	**FIGMSF50T**
MF 6	0.75	5.0	62	12.30	8.0	3	**FIGMSF52T**
M 6	1.00	4.8	62	12.40	8.0	3	**FIGMSF54T**
MF 8	1.00	6.7	74	16.40	10.0	3	**FIGMSF56T**
M 8	1.25	6.5	74	16.80	10.0	3	**FIGMSF58T**
MF 10	1.00	8.7	80	20.40	12.0	3	**FIGMSF60T**
MF 10	1.25	8.4	80	20.80	12.0	3	**FIGMSF62T**
M 10	1.50	8.2	80	20.15	12.0	3	**FIGMSF64T**
MF 12	1.25	10.4	90	24.30	14.0	4	**FIGMSF68T**
MF 12	1.50	10.1	90	24.65	14.0	4	**FIGMSF70T**

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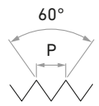
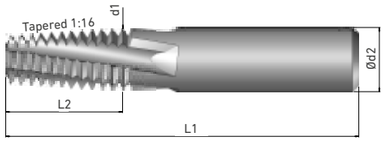
ANSI B1.20.3



VHM | e8 | R 15° | RH-LH | DIN 6535 HA | INTERNO INTERNAL | ESTERNO EXTERNAL

ESECUZIONI SPECIALI A DISEGNO
CUSTOMIZED DESIGN ON REQUEST



	ELICA DX - RH HELIX	ELICA DX - RH HELIX
TRATTAMENTO SUPERFICIALE / SURFACE TREATMENT	Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc
MATERIALI LAVORABILI / WORKING MATERIALS page 4D • 3	P1.1-P5.1 K1.1-K4.2 N1.1-N1.5 N2.1-N2.6 N3.1-N4.2 S1.1-S1.3	P1.1-P5.1 M1.1-M4.1 N1.1-N5.2 S1.1-S2.6 H1.1-H1.2

Filetto - Thread	(TPI)	d1	L1	L2	d2	Z		
1/16"	27	5.90	55	9.88	8.0	3	FIGNPT01N	FIGNPT01T
1/8"	27	7.65	55	9.88	8.0	3	FIGNPT03N	FIGNPT03T
1/4"	18	10.15	75	14.82	12.0	4	FIGNPT05N	FIGNPT05T
3/8"	18	11.15	75	14.82	12.0	4	FIGNPT07N	FIGNPT07T
1/2" 3/4"	14	14.25	80	19.05	16.0	4	FIGNPT09N	FIGNPT09T
1", 1" 3/4, 1" 1/2, 2"	11 1/2	19.60	90	23.19	20.0	5	FIGNPT11N	FIGNPT11T

	ELICA DX - RH HELIX	ELICA DX - RH HELIX
	Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc
	P1.1-P5.1 K1.1-K4.2 N1.1-N1.5 N2.1-N2.6 N3.1-N4.2 S1.1-S1.3	P1.1-P5.1 M1.1-M4.1 N1.1-N5.2 S1.1-S2.6 H1.1-H1.2

FIGNPT01NF	FIGNPT01F
FIGNPT03NF	FIGNPT03F
FIGNPT05NF	FIGNPT05F
FIGNPT07NF	FIGNPT07F
FIGNPT09NF	FIGNPT09F
FIGNPT11NF	FIGNPT11F

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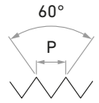
ANSI B1.20.3



VHM | e8 | XL
R 15° | RH-LH
DIN 6535 HA
INTERNO INTERNAL | ESTERNO EXTERNAL

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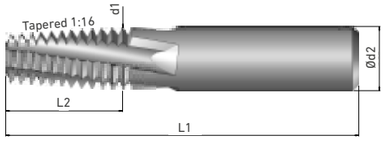
CUSTOMIZED DESIGN ON REQUEST



	ELICA DX - RH HELIX	ELICA DX - RH HELIX	ELICA DX - RH HELIX	ELICA DX - RH HELIX
TRATTAMENTO SUPERFICIALE SURFACE TREATMENT	Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc	Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc
MATERIALI LAVORABILI WORKING MATERIALS page 4D • 3	P1.1-P5.1 K1.1-K4.2 N1.1-N1.5 N2.1-N2.6 N3.1-N4.2 S1.1-S1.3	P1.1-P5.1 M1.1-M4.1 N1.1-N5.2 S1.1-S2.6 H1.1-H1.2	P1.1-P5.1 K1.1-K4.2 N1.1-N1.5 N2.1-N2.6 N3.1-N4.2 S1.1-S1.3	P1.1-P5.1 M1.1-M4.1 N1.1-N5.2 S1.1-S2.6 H1.1-H1.2

Filetto - Thread	(TPI)	d1	L1	L2	d2	Z				
1/16"	27	5.90	60	13.63	8.0	3	FIGNPT13N	FIGNPT13T	FIGNPT13NF	FIGNPT13F
1/8"	27	7.65	60	13.63	8.0	3	FIGNPT15N	FIGNPT15T	FIGNPT15NF	FIGNPT15F
1/4"	18	10.15	80	20.44	12.0	4	FIGNPT17N	FIGNPT17T	FIGNPT17NF	FIGNPT17F
3/8"	18	11.15	80	20.44	12.0	4	FIGNPT19N	FIGNPT19T	FIGNPT19NF	FIGNPT19F
1/2" 3/4"	14	14.25	88	26.27	16.0	4	FIGNPT21N	FIGNPT21T	FIGNPT21NF	FIGNPT21F
1", 1" 1/4, 1" 1/2 , 2"	11 1/2	19.60	100	31.98	20.0	5	FIGNPT23N	FIGNPT23T	FIGNPT23NF	FIGNPT23F
2" 1/2	8	19.88	110	36.51	20.0	4	FIGNPT25N	FIGNPT25T	FIGNPT25NF	FIGNPT25F

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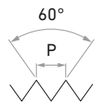
NPTF

ANSI B1.20.3



VHM | e8 | R 15° | RH-LH | DIN 6535 HA | INTERNO INTERNAL | ESTERNO EXTERNAL

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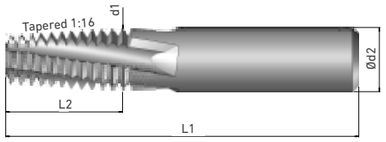
CUSTOMIZED DESIGN ON REQUEST



	ELICA DX - RH HELIX	ELICA DX - RH HELIX
TRATTAMENTO SUPERFICIALE / SURFACE TREATMENT	Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc
MATERIALI LAVORABILI / WORKING MATERIALS page 4D • 3	P1.1-P5.1 K1.1-K4.2 N1.1-N1.5 N2.1-N2.6 N3.1-N4.2 S1.1-S1.3	P1.1-P5.1 M1.1-M4.1 N1.1-N5.2 S1.1-S2.6 H1.1-H1.2

Filetto - Thread	(TPI)	d1	L1	L2	d2	Z		
1/16"	27	5.90	55	9.88	8.0	3	FIGNPTF01N	FIGNPTF01T
1/8"	27	7.65	55	9.88	8.0	3	FIGNPTF03N	FIGNPTF03T
1/4"	18	10.15	75	14.82	12.0	4	FIGNPTF05N	FIGNPTF05T
3/8"	18	11.15	75	14.82	12.0	4	FIGNPTF07N	FIGNPTF07T
1/2" 3/4"	14	14.25	80	19.05	16.0	4	FIGNPTF09N	FIGNPTF09T
1", 1" 1/4, 1" 1/2 , 2"	11 1/2	19.60	90	23.19	20.0	5	FIGNPTF11N	FIGNPTF11T

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	ELICA DX - RH HELIX	ELICA DX - RH HELIX
	Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc
	P1.1-P5.1 K1.1-K4.2 N1.1-N1.5 N2.1-N2.6 N3.1-N4.2 S1.1-S1.3	P1.1-P5.1 M1.1-M4.1 N1.1-N5.2 S1.1-S2.6 H1.1-H1.2

FIGNPTF01NF	FIGNPTF01F
FIGNPTF03NF	FIGNPTF03F
FIGNPTF05NF	FIGNPTF05F
FIGNPTF07NF	FIGNPTF07F
FIGNPTF09NF	FIGNPTF09F
FIGNPTF11NF	FIGNPTF11F

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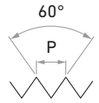

VHM | e8 | XL
R 15° | RH-LH
DIN 6535 HA
INTERNO INTERNAL | ESTERNO EXTERNAL

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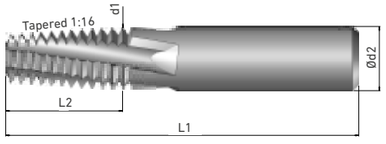
CUSTOMIZED DESIGN ON REQUEST



	ELICA DX - RH HELIX	ELICA DX - RH HELIX	ELICA DX - RH HELIX	ELICA DX - RH HELIX
TRATTAMENTO SUPERFICIALE / SURFACE TREATMENT	Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc	Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc
MATERIALI LAVORABILI / WORKING MATERIALS page 4D • 3	P1.1-P5.1, K1.1-K4.2, N1.1-N1.5, N2.1-N2.6, N3.1-N4.2, S1.1-S1.3	P1.1-P5.1, M1.1-M4.1, N1.1-N5.2, S1.1-S2.6, H1.1-H1.2	P1.1-P5.1, K1.1-K4.2, N1.1-N1.5, N2.1-N2.6, N3.1-N4.2, S1.1-S1.3	P1.1-P5.1, M1.1-M4.1, N1.1-N5.2, S1.1-S2.6, H1.1-H1.2

Filetto - Thread	(TPI)	d1	L1	L2	d2	Z				
1/16"	27	5.90	60	13.63	8.0	3	FIGNPTF13N	FIGNPTF13T	FIGNPTF13NF	FIGNPTF13F
1/8"	27	7.65	60	13.63	8.0	3	FIGNPTF15N	FIGNPTF15T	FIGNPTF15NF	FIGNPTF15F
1/4"	18	10.15	80	20.44	12.0	4	FIGNPTF17N	FIGNPTF17T	FIGNPTF17NF	FIGNPTF17F
3/8"	18	11.15	80	20.44	12.0	4	FIGNPTF19N	FIGNPTF19T	FIGNPTF19NF	FIGNPTF19F
1/2" 3/4"	14	14.25	88	26.27	16.0	4	FIGNPTF21N	FIGNPTF21T	FIGNPTF21NF	FIGNPTF21F
1", 1" 1/4, 1" 1/2, 2"	11 1/2	19.60	100	31.98	20.0	5	FIGNPTF23N	FIGNPTF23T	FIGNPTF23NF	FIGNPTF23F
2" 1/2	8	19.88	110	36.51	20.0	4	FIGNPTF25N	FIGNPTF25T	FIGNPTF25NF	FIGNPTF25F

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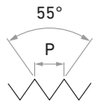
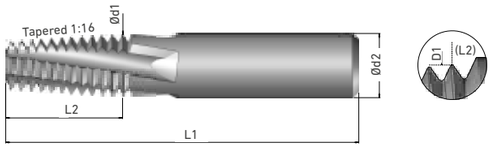


BSPT

DIN EN 10226-2 ISO 7-1

VHM | e8 | R 15° | RH-LH | DIN 6535 HA | INTERNO INTERNAL | ESTERNO EXTERNAL



	ELICA DX - RH HELIX	ELICA DX - RH HELIX
TRATTAMENTO SUPERFICIALE SURFACE TREATMENT	Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc
MATERIALI LAVORABILI WORKING MATERIALS page 4D • 3	P1.1-P5.1 K1.1-K4.2 N1.1-N1.5 N2.1-N2.6 N3.1-N4.2 S1.1-S1.3	P1.1-P5.1 M1.1-M4.1 N1.1-N5.2 S1.1-S2.6 H1.1-H1.2

Filetto - Thread	(TPI)	d1	L1	L2	d2	Z		
1/16"	28	5.90	57	9.50	6.0	3	FIGBSPT03N	FIGBSPT03T
1/8"	28	7.65	61	9.50	8.0	3	FIGBSPT05N	FIGBSPT05T
1/4"	19	9.90	73	14.00	10.0	3	FIGBSPT07N	FIGBSPT07T
3/8"	19	11.15	73	14.00	16.0	4	FIGBSPT09N	FIGBSPT09T
1/2", 3/4"	14	14.25	92	20.83	16.0	4	FIGBSPT11N	FIGBSPT11T
1",1 1/2",2",2" 1/2	11	19.60	102	26.51	20.0	4	FIGBSPT13N	FIGBSPT13T

	ELICA DX - RH HELIX	ELICA DX - RH HELIX
	Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc
	P1.1-P5.1 K1.1-K4.2 N1.1-N1.5 N2.1-N2.6 N3.1-N4.2 S1.1-S1.3	P1.1-P5.1 M1.1-M4.1 N1.1-N5.2 S1.1-S2.6 H1.1-H1.2

FIGBSPT03NF	FIGBSPT03F
FIGBSPT05NF	FIGBSPT05F
FIGBSPT07NF	FIGBSPT07F
FIGBSPT09NF	FIGBSPT09F
FIGBSPT11NF	FIGBSPT11F
FIGBSPT13NF	FIGBSPT13F

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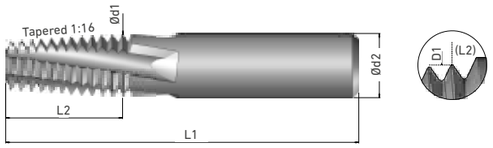
BSPT

DIN EN 10226-2 ISO 7-1

VHM | e8 | XL
R 15° | RH-LH
DIN 6535 HA
INTERNO INTERNAL | ESTERNO EXTERNAL



	ELICA DX - RH HELIX	ELICA DX - RH HELIX
TRATTAMENTO SUPERFICIALE SURFACE TREATMENT	Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc
MATERIALI LAVORABILI WORKING MATERIALS page 4D • 3	P1.1-P5.1 K1.1-K4.2 N1.1-N1.5 N2.1-N2.6 N3.1-N4.2 S1.1-S1.3	P1.1-P5.1 M1.1-M4.1 N1.1-N5.2 S1.1-S2.6 H1.1-H1.2

Filetto - Thread	(TPI)	d1	L1	L2	d2	Z		
1/16"	28	5.80	57	15.85	6.0	3	FIGBSPT20N	FIGBSPT20T
1/8"	28	7.70	63	19.48	8.0	3	FIGBSPT22N	FIGBSPT22T
1/4"	19	9.90	73	26.03	10.0	4	FIGBSPT24N	FIGBSPT24T
3/8"	19	13.40	92	32.72	12.0	4	FIGBSPT26N	FIGBSPT26T
1/2", 3/4"	14	15.70	92	42.60	16.0	5	FIGBSPT28N	FIGBSPT28T
1",1 1/2",2",2" 1/2	11	19.90	104	40.35	20.0	5	FIGBSPT30N	FIGBSPT30T

	ELICA DX - RH HELIX	ELICA DX - RH HELIX
	Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc
	P1.1-P5.1 K1.1-K4.2 N1.1-N1.5 N2.1-N2.6 N3.1-N4.2 S1.1-S1.3	P1.1-P5.1 M1.1-M4.1 N1.1-N5.2 S1.1-S2.6 H1.1-H1.2

FIGBSPT20NF	FIGBSPT20F
FIGBSPT22NF	FIGBSPT22F
FIGBSPT24NF	FIGBSPT24F
FIGBSPT26NF	FIGBSPT26F
FIGBSPT28NF	FIGBSPT28F
FIGBSPT30NF	FIGBSPT30F

1:16 TAPER END MILL

NPT, NPFT, BSPT

Fresa per preparazione filetto conico 1:16
Conical thread preparation cutter 1:16

VHM | e8 | R 30° | RH | DIN 6535 HA | INTERNO INTERNAL | ESTERNO EXTERNAL

ELICA DX - RH HELIX

TRATTAMENTO SUPERFICIALE
SURFACE TREATMENT: Coated TNF ≤45 Hrc

MATERIALI LAVORABILI
WORKING MATERIALS
page 4D • 3

- K
- M1.1-M4.1
- N1.1-N5.2
- S1.1-S2.6
- H1.1-H1.2

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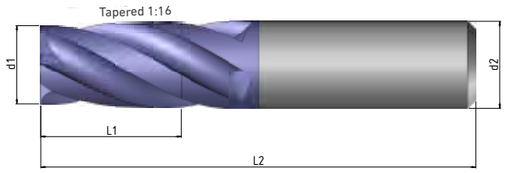
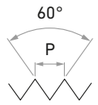
CUSTOMIZED DESIGN ON REQUEST



d1	L1	L2	d2	Z	
5.3	11.26	55	6.0	3	**FIGPRE01T**
7.3	11.26	55	8.0	3	**FIGPRE03T**
8.8	19.30	75	10.0	4	**FIGPRE05T**
10.8	19.30	75	12.0	4	**FIGPRE07T**
12.5	24.15	80	14.0	4	**FIGPRE09T**
18.0	32.20	90	20.0	4	**FIGPRE11T**

MICRO INT 2xD

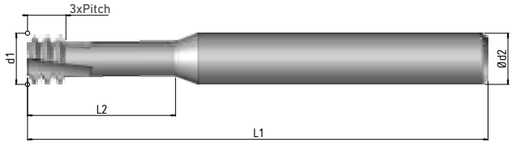


M

DIN 13

VHM | e8 | 2xD | R 10° | RH-LH | DIN 6535 HA | INTERNO INTERNAL

ESECUZIONI SPECIALI A DISEGNO
CUSTOMIZED DESIGN ON REQUEST



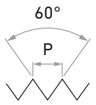
	ELICA DX - RH HELIX
TRATTAMENTO SUPERFICIALE / SURFACE TREATMENT	Uncoated ≤45 Hrc
MATERIALI LAVORABILI / WORKING MATERIALS page 4D • 3	P1.1-P5.1, K1.4 - K4.2, N1.1-N1.5, N2.1-N2.6, N3.1-N4.2, S1.1-S1.3

Filetto - Thread	Pitch mm	d1	L1	L2	d2	Z	Z type TX	FIGMETMIC01N
M 1.2	0.25	0.90	39	3.0	3.0	3		FIGMETMIC01N
M 1.4	0.30	1.05	39	3.0	3.0	3		FIGMETMIC02N
M 1.6	0.35	1.20	39	4.5	3.0	3		FIGMETMIC04N
M 2	0.40	1.55	39	4.5	3.0	3		FIGMETMIC03N
M 2.2	0.45	1.65	54	5.0	6.0	3		FIGMETMIC05N
M 2.5	0.45	1.95	54	5.5	6.0	3		FIGMETMIC07N
M 3	0.50	2.35	54	6.5	6.0	3	4	FIGMETMIC09N
M 3.5	0.60	2.75	54	7.5	6.0	3	4	FIGMETMIC11N
M 4	0.70	3.10	54	9.0	6.0	3	4	FIGMETMIC13N
M 4.5	0.75	3.40	54	10.5	6.0	3	4	FIGMETMIC14N
M 5	0.80	3.80	54	12.5	6.0	3	4	FIGMETMIC15N
M 6	1.00	4.65	54	14.0	6.0	3	4	FIGMETMIC17N
M 8	1.25	5.95	54	18.0	6.0	3	4	FIGMETMIC19N
M 10	1.50	7.80	64	23.0	8.0	3	4	FIGMETMIC21N
M 12	1.75	9.00	73	26.0	10.0	3	4	FIGMETMIC23N
M 16	2.00	11.80	80	35.0	12.0	4	5	FIGMETMIC25N
M 20	2.50	15.00	100	43.0	16.0	5	6	FIGMETMIC27N

	ELICA DX - RH HELIX	ELICA SX - LH HELIX
	Uncoated ≤45 Hrc	Coated LTM ≥ 45 Hrc ≤60 Hrc
	P1.1-P5.1, M1.1-M4.1, N1.1-N5.2, S1.1-S2.6, H1.1-H1.2	N2.7-N2.8, H1.3-H1.5

FIGMETMIC01T		
FIGMETMIC02T		
FIGMETMIC04T		
FIGMETMIC03T		
FIGMETMIC05T		
FIGMETMIC07T		
FIGMETMIC09T	FIGMETMIC09TX-SX	
FIGMETMIC11T	FIGMETMIC11TX-SX	
FIGMETMIC13T	FIGMETMIC13TX-SX	
FIGMETMIC14T	FIGMETMIC14TX-SX	
FIGMETMIC15T	FIGMETMIC15TX-SX	
FIGMETMIC17T	FIGMETMIC17TX-SX	
FIGMETMIC19T	FIGMETMIC19TX-SX	
FIGMETMIC21T	FIGMETMIC21TX-SX	
FIGMETMIC23T	FIGMETMIC23TX-SX	
FIGMETMIC25T	FIGMETMIC25TX-SX	
FIGMETMIC27T	FIGMETMIC27TX-SX	

MICRO INT 3xD

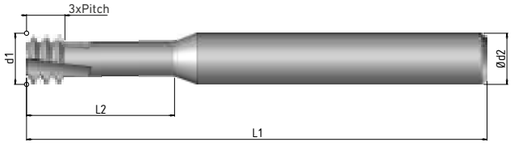


VHM | e8 | 3xD
R 10° | RH-LH
DIN 6535 HA
INTERNO INTERNAL

M

DIN13

ESECUZIONI SPECIALI A DISEGNO
CUSTOMIZED DESIGN ON REQUEST



	ELICA DX - RH HELIX	ELICA DX - RH HELIX	ELICA SX - LH HELIX
TRATTAMENTO SUPERFICIALE SURFACE TREATMENT	Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc	Coated LTM ≥45 Hrc ≤60Hrc
MATERIALI LAVORABILI WORKING MATERIALS page 4D • 3	P1.1-P5.1 K1.1-K4.2 N1.1-N1.5 N2.1-N2.6 N3.1-N4.2 S1.1-S1.3	P1.1-P5.1 M1.1-M4.1 N1.1-N5.2 S1.1-S2.6 H1.1-H1.2	N2.7-N2.8 H1.3-H1.5

Filetto - Thread	Pitch mm	d1	L1	L2	d2	Z	Z type TX			
M 1.2	0.25	0.90	39	4.0	3.0	3		FIGMETMIC28N	FIGMETMIC28T	
M 1.4	0.30	1.05	39	4.0	3.0	3		FIGMETMIC29N	FIGMETMIC29T	
M 1.6	0.35	1.20	39	5.0	3.0	3		FIGMETMIC31N	FIGMETMIC31T	
M 2	0.40	1.55	39	6.0	3.0	3		FIGMETMIC33N	FIGMETMIC33T	
M 2.2	0.45	1.65	54	6.0	6.0	3		FIGMETMIC34N	FIGMETMIC34T	
M 2.5	0.45	1.95	54	7.5	6.0	3		FIGMETMIC35N	FIGMETMIC35T	
M 3	0.50	2.35	54	9.5	6.0	3	4	FIGMETMIC37N	FIGMETMIC37T	FIGMETMIC37TX-SX
M 3.5	0.60	2.75	54	10.0	6.0	3		FIGMETMIC38N	FIGMETMIC38T	
M 4	0.70	3.10	54	12.5	6.0	3	4	FIGMETMIC39N	FIGMETMIC39T	FIGMETMIC39TX-SX
M 4.5	0.75	3.40	54	14.0	6.0	3	4	FIGMETMIC40N	FIGMETMIC40T	FIGMETMIC41TX-SX
M 5	0.80	3.80	54	16.0	6.0	3	4	FIGMETMIC41N	FIGMETMIC41T	FIGMETMIC43TX-SX
M 6	1.00	4.65	54	20.0	6.0	3	4	FIGMETMIC43N	FIGMETMIC43T	FIGMETMIC45TX-SX
M 8	1.25	5.95	54	24.0	6.0	3	4	FIGMETMIC45N	FIGMETMIC45T	FIGMETMIC47TX-SX

MICRO INT 2xD

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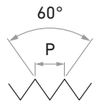

VHM | e8 | 2xD | R 10° | RH-LH | DIN 6535 HA | INTERNO INTERNAL

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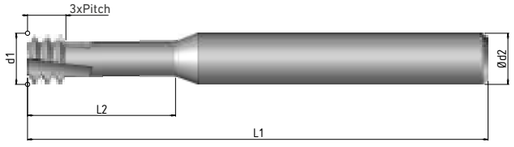
CUSTOMIZED DESIGN ON REQUEST



	ELICA DX - RH HELIX	ELICA DX - RH HELIX
TRATTAMENTO SUPERFICIALE SURFACE TREATMENT	Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc
MATERIALI LAVORABILI WORKING MATERIALS page 4D • 3	P1.1-P5.1 K1.1-K4.2 N1.1-N1.5 N2.1-N2.6 N3.1-N4.2 S1.1-S1.3	P1.1-P5.1 M1.1-M4.1 N1.1-N5.2 S1.1-S2.6 H1.1-H1.2

Filetto - Thread	(TPI)	d1	L1	L2	d2	Z		
Nr. 1 UNF	72	1.45	39	3.7	3.0	3	**FIGUNMIC01N**	**FIGUNMIC01T**
Nr. 1 UNC Nr. 2 UNF	64	1.40	39	3.8	3.0	3	**FIGUNMIC03N**	**FIGUNMIC03T**
Nr. 2 UNC Nr. 3 UNF	56	1.65	54	4.4	6.0	3	**FIGUNMIC05N**	**FIGUNMIC05T**
Nr. 3 UNC Nr. 3 UNF	48	1.90	54	5.2	6.0	3	**FIGUNMIC07N**	**FIGUNMIC07T**
Nr. 4 UNC	40	2.10	54	6.3	6.0	3	**FIGUNMIC09N**	**FIGUNMIC09T**
Nr. 5 UNC Nr. 6 UNF	40	2.45	54	7.0	6.0	3	**FIGUNMIC11N**	**FIGUNMIC11T**
Nr. 8 UNF	36	3.30	54	9.0	6.0	3	**FIGUNMIC13N**	**FIGUNMIC13T**
Nr. 6 UNC	32	2.55	54	7.1	6.0	3	**FIGUNMIC15N**	**FIGUNMIC15T**
Nr. 8 UNC	32	3.20	54	9.5	6.0	3	**FIGUNMIC17N**	**FIGUNMIC17T**
Nr. 10 UNF	32	3.70	54	10.5	6.0	3	**FIGUNMIC19N**	**FIGUNMIC19T**
Nr. 12 UNF	28	4.20	54	11.0	6.0	3	**FIGUNMIC21N**	**FIGUNMIC21T**
1/4" UNF	28	5.00	54	14.5	6.0	3	**FIGUNMIC23N**	**FIGUNMIC23T**
10" UNC 12" UNC	24	3.50	54	10.6	6.0	3	**FIGUNMIC25N**	**FIGUNMIC25T**
5/16" UNF 3/8" UNF	24	6.60	64	17.0	8.0	3	**FIGUNMIC27N**	**FIGUNMIC27T**
1/4" UNC	20	4.75	54	14.0	6.0	3	**FIGUNMIC29N**	**FIGUNMIC29T**
7/16" UNF	20	8.00	64	25.0	8.0	3	**FIGUNMIC31N**	**FIGUNMIC31T**
5/16" UNC	18	6.00	54	17.0	6.0	3	**FIGUNMIC33N**	**FIGUNMIC33T**
5/8" UNF	18	12.00	80	35.0	12.0	4	**FIGUNMIC35N**	**FIGUNMIC35T**
3/8" UNC	16	6.70	64	22.0	8.0	3	**FIGUNMIC37N**	**FIGUNMIC37T**
7/16" UNC	14	7.70	64	25.0	8.0	3	**FIGUNMIC39N**	**FIGUNMIC39T**
1/2" UNC	13	9.20	73	27.5	10.0	4	**FIGUNMIC41N**	**FIGUNMIC41T**
9/16" UNC	12	10.50	80	31.5	12.0	4	**FIGUNMIC43N**	**FIGUNMIC43T**
5/8" UNC	11	11.40	80	34.5	12.0	4	**FIGUNMIC45N**	**FIGUNMIC45T**
3/4" UNC	10	14.40	100	41.5	16.0	4	**FIGUNMIC47N**	**FIGUNMIC47T**

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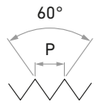

VHM | e8 | 3xD | R 10° | RH-LH | DIN 6535 HA | INTERNO INTERNAL

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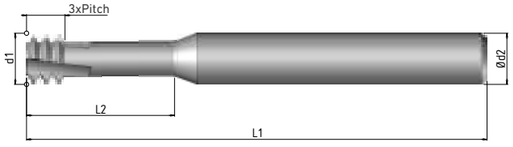
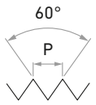
CUSTOMIZED DESIGN ON REQUEST



	ELICA DX - RH HELIX	ELICA DX - RH HELIX
TRATTAMENTO SUPERFICIALE SURFACE TREATMENT	Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc
MATERIALI LAVORABILI WORKING MATERIALS page 4D • 3	P1.1-P5.1 K1.1-K4.2 N1.1-N1.5 N2.1-N2.6 N3.1-N4.2 S1.1-S1.3	P1.1-P5.1 M1.1-M4.1 N1.1-N5.2 S1.1-S2.6 H1.1-H1.2

Filetto - Thread	(TPI)	d1	L1	L2	d2	Z		
Nr. 0 UNF	80	1.15	39	4.0	3.0	3	**FIGUNMIC49N**	**FIGUNMIC49T**
Nr. 1 UNF	72	1.45	39	6.0	3.0	3	**FIGUNMIC51N**	**FIGUNMIC51T**
Nr. 2 UNC Nr. 3 UNF	56	1.65	54	6.6	6.0	3	**FIGUNMIC53N**	**FIGUNMIC53T**
Nr. 4 UNC	40	2.10	54	8.0	6.0	3	**FIGUNMIC55N**	**FIGUNMIC55T**
Nr. 5 UNC Nr. 6 UNF	40	2.45	54	9.6	6.0	3	**FIGUNMIC57N**	**FIGUNMIC57T**
Nr. 6 UNC	32	2.55	54	10.5	6.0	3	**FIGUNMIC59N**	**FIGUNMIC59T**
Nr. 8 UNC	32	3.20	54	12.5	6.0	3	**FIGUNMIC61N**	**FIGUNMIC61T**
Nr. 10 UNF	32	3.70	54	15.0	6.0	3	**FIGUNMIC63N**	**FIGUNMIC63T**
1/4" UNF	28	5.00	54	19.0	6.0	3	**FIGUNMIC65N**	**FIGUNMIC65T**
5/16" UNF 3/8" UNF	24	6.60	64	24.0	8.0	3	**FIGUNMIC67N**	**FIGUNMIC67T**
1/4" UNC	20	4.75	54	19.0	6.0	3	**FIGUNMIC69N**	**FIGUNMIC69T**
5/16" UNC	18	6.00	54	23.0	6.0	3	**FIGUNMIC71N**	**FIGUNMIC71T**

MICRO 1 TOOTH 3xD



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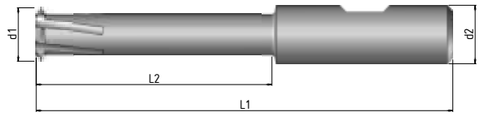
VHM | e8 | 3xD | R 10° | RH LH | DIN 6535 HA | INTERNO INTERNAL



ELICA DX - RH HELIX

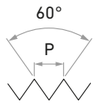
TRATTAMENTO SUPERFICIALE
SURFACE TREATMENT: Coated TNF ≤45 Hrc

MATERIALI LAVORABILI
WORKING MATERIALS
page 4D • 3

- P1.1-P5.1
- M1.1-M4.1
- N1.1-N5.2
- S1.1-S2.6
- H1.1-H1.2

Filetto - Thread	Pitch mm	d1	L1	L2	d2	Z	
M 6	1.00	4.1	63	19	8.0	3	**FIGMETMONO03T**
M 8	1.25	5.8	73	26	10.0	3	**FIGMETMONO05T**
M 10	1.50	7.7	73	32	10.0	3	**FIGMETMONO07T**
M 12	1.50	9.4	83	38	12.0	4	**FIGMETMONO09T**
M 12	1.75	8.7	83	38	12.0	4	**FIGMETMONO11T**
M 14	2.00	10.2	92	44	16.0	4	**FIGMETMONO13T**
M 16	2.00	12.2	100	50	16.0	4	**FIGMETMONO15T**
M 18	2.50	12.9	108	57	16.0	5	**FIGMETMONO17T**
M 20	2.50	14.8	114	63	16.0	5	**FIGMETMONO19T**

INTERNAL 1,5xD



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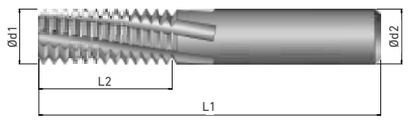
CUSTOMIZED DESIGN ON REQUEST

VHM | e8 | 1,5xD | R 10° | RH-LH | DIN 6535 HA | INTERNO INTERNAL



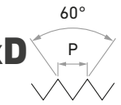
	ELICA DX - RH HELIX	ELICA DX - RH HELIX
TRATTAMENTO SUPERFICIALE SURFACE TREATMENT	Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc
MATERIALI LAVORABILI WORKING MATERIALS page 4D • 3	P1.1-P5.1 K1.1-K4.2 N1.1-N1.5 N2.1-N2.6 N3.1-N4.2 S1.1-S1.3	P1.1-P5.1 M1.1-M4.1 N1.1-N5.2 S1.1-S2.6 H1.1-H1.2

Filetto - Thread	Pitch mm	d1	L1	L2	d2	Z		
MJ 4	0.70	3.1	52	5	6.0	3	**FIGMJ40N**	**FIGMJ40T**
MJ 5	0.80	4.0	49	6	6.0	3	**FIGMJ42N**	**FIGMJ42T**
MJ 6 MJ 7	1.00	4.5	50	7	6.0	3	**FIGMJ44N**	**FIGMJ44T**
MJ 8	1.00	6.0	49	9	6.0	3	**FIGMJ46N**	**FIGMJ46T**
MJ 10 MJ 12	1.25	8.0	57	12	8.0	3	**FIGMJ48N**	**FIGMJ48T**
MJ 14	1.50	10.0	70	15	10.0	4	**FIGMJ50N**	**FIGMJ50T**
MJ 16	1.50	12.0	70	18	12.0	4	**FIGMJ52N**	**FIGMJ52T**
MJ 18	1.50	14.0	86	21	14.0	4	**FIGMJ54N**	**FIGMJ54T**
MJ 20 MJ 22	1.50	16.0	84	24	16.0	5	**FIGMJ56N**	**FIGMJ56T**
MJ 24 >	2.00	20.0	100	30	20.0	5	**FIGMJ58N**	**FIGMJ58T**

	ELICA DX - RH HELIX	ELICA DX - RH HELIX
	Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc
	P1.1-P5.1 K1.1-K4.2 N1.1-N1.5 N2.1-N2.6 N3.1-N4.2 S1.1-S1.3	P1.1-P5.1 M1.1-M4.1 N1.1-N5.2 S1.1-S2.6 H1.1-H1.2

	FIGMJ42NF	**FIGMJ42F**
	FIGMJ44NF	**FIGMJ44F**
	FIGMJ46NF	**FIGMJ46F**
	FIGMJ48NF	**FIGMJ48F**
	FIGMJ50NF	**FIGMJ50F**
	FIGMJ52NF	**FIGMJ52F**
	FIGMJ54NF	**FIGMJ54F**
	FIGMJ56NF	**FIGMJ56F**
	FIGMJ58NF	**FIGMJ58F**

INTERNAL 2xD



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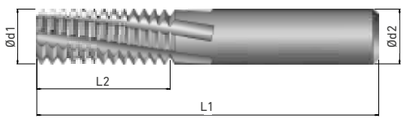
CUSTOMIZED DESIGN ON REQUEST

VHM | e8 | 2xD | R 10° | RH-LH | DIN 6535 HA | INTERNO INTERNAL



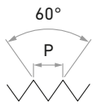
	ELICA DX - RH HELIX	ELICA DX - RH HELIX
TRATTAMENTO SUPERFICIALE SURFACE TREATMENT	Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc
MATERIALI LAVORABILI WORKING MATERIALS page 4D • 3	P1.1-P5.1 K1.1-K4.2 N1.1-N1.5 N2.1-N2.6 N3.1-N4.2 S1.1-S1.3	P1.1-P5.1 M1.1-M4.1 N1.1-N5.2 S1.1-S2.6 H1.1-H1.2

Filetto - Thread	Pitch mm	d1	L1	L2	d2	Z		
MJ 4	0.70	3.1	54	8	6.0	3	**FIGMJ03N**	**FIGMJ03T**
MJ 5	0.80	4.0	54	12	6.0	3	**FIGMJ00N**	**FIGMJ00T**
MJ 6 MJ 7	1.00	4.5	54	12	6.0	3	**FIGMJ02N**	**FIGMJ02T**
MJ 8	1.00	6.0	54	15	6.0	3	**FIGMJ05N**	**FIGMJ05T**
MJ 10 MJ 12	1.25	8.0	66	20	8.0	3	**FIGMJ10N**	**FIGMJ10T**
MJ 14	1.50	10.0	80	25	10.0	4	**FIGMJ16N**	**FIGMJ16T**
MJ 16	1.50	12.0	82	30	12.0	4	**FIGMJ20N**	**FIGMJ20T**
MJ 18	1.50	14.0	100	35	14.0	4	**FIGMJ24N**	**FIGMJ24T**
MJ 20 MJ 22	1.50	16.0	100	40	16.0	5	**FIGMJ29N**	**FIGMJ29T**
MJ 24 >	2.00	20.0	110	40	20.0	5	**FIGMJ35N**	**FIGMJ35T**

	ELICA DX - RH HELIX	ELICA DX - RH HELIX
	Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc
	P1.1-P5.1 K1.1-K4.2 N1.1-N1.5 N2.1-N2.6 N3.1-N4.2 S1.1-S1.3	P1.1-P5.1 M1.1-M4.1 N1.1-N5.2 S1.1-S2.6 H1.1-H1.2

FIGMJ00NF	**FIGMJ00F**
FIGMJ02NF	**FIGMJ02F**
FIGMJ05NF	**FIGMJ05F**
FIGMJ10NF	**FIGMJ10F**
FIGMJ16NF	**FIGMJ16F**
FIGMJ20NF	**FIGMJ20F**
FIGMJ24NF	**FIGMJ24F**
FIGMJ29NF	**FIGMJ29F**
FIGMJ35NF	**FIGMJ35F**

INTERNAL 1,5xD



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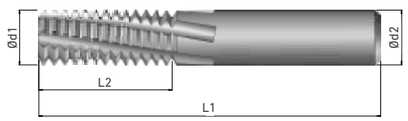
CUSTOMIZED DESIGN ON REQUEST

VHM | e8 | 1,5xD
R 10° | RH-LH
DIN 6535 HA
INTERNO INTERNAL



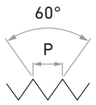
	ELICA DX - RH HELIX	ELICA DX - RH HELIX
TRATTAMENTO SUPERFICIALE SURFACE TREATMENT	Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc
MATERIALI LAVORABILI WORKING MATERIALS page 4D • 3	P1.1-P5.1 K1.1-K4.2 N1.1-N1.5 N2.1-N2.6 N3.1-N4.2 S1.1-S1.3	P1.1-P5.1 M1.1-M4.1 N1.1-N5.2 S1.1-S2.6 H1.1-H1.2

Filetto - Thread	(TPI)	d1	L1	L2	d2	Z		
5/16" UNJ 3/8" UNJ	24	6.0	49	9	6.0	3	FIGUNJ58N	FIGUNJ58T
5/16" UNJ	18	6.0	49	9	6.0	3	FIGUNJ60N	FIGUNJ60T
3/8" UNJ 7/16" UNJ	16	6.0	49	9	6.0	3	FIGUNJ62N	FIGUNJ62T
7/16" UNJ 1/2" UNJ	28	8.0	58	12	8.0	3	FIGUNJ64N	FIGUNJ64T
7/16" UNJ 1/2" UNJ	20	8.0	58	12	8.0	3	FIGUNJ66N	FIGUNJ66T
1/2" UNJ 9/16" UNJ	16	8.0	58	12	8.0	3	FIGUNJ68N	FIGUNJ68T
7/16" UNJ	14	8.0	58	12	8.0	3	FIGUNJ70N	FIGUNJ70T
1/2" UNJ	13	8.0	58	12	8.0	3	FIGUNJ72N	FIGUNJ72T
9/16" UNJ 11/16" UNJ	24	10.0	70	15	10.0	4	FIGUNJ74N	FIGUNJ74T
9/16" UNJ 5/8" UNJ	18	10.0	70	15	10.0	4	FIGUNJ76N	FIGUNJ76T
9/16" UNJ	12	10.0	70	15	10.0	4	FIGUNJ78N	FIGUNJ78T
5/8" UNJ 13/16" UNJ	16	12.0	70	18	12.0	4	FIGUNJ80N	FIGUNJ80T
5/8" UNJ 13/16" UNJ	12	12.0	70	18	12.0	4	FIGUNJ82N	FIGUNJ82T
5/8" UNJ	11	12.0	70	18	12.0	4	FIGUNJ84N	FIGUNJ84T
3/4" UNJ	10	12.0	70	18	12.0	4	FIGUNJ86N	FIGUNJ86T
3/4" UNJ 1" UNJ	20	16.0	84	24	16.0	5	FIGUNJ88N	FIGUNJ88T
7/8" UNJ 1" UNJ	16	15.5	84	24	16.0	5	FIGUNJ90N	FIGUNJ90T
7/8" UNJ	14	15.5	84	24	16.0	5	FIGUNJ92N	FIGUNJ92T
7/8" UNJ 1" UNJ	12	16.0	84	24	16.0	5	FIGUNJ94N	FIGUNJ94T
11/16" UNJ 1 11/16" UNJ	18	20.0	100	30	20.0	5	FIGUNJ96N	FIGUNJ96T
1 1/16" UNJ 2 1/2" UNJ	16	20.0	100	30	20.0	5	FIGUNJ98N	FIGUNJ98T
1 1/16" UNJ 2 1/2" UNJ	12	20.0	100	30	20.0	5	FIGUNJ100N	FIGUNJ100T

	ELICA DX - RH HELIX	ELICA DX - RH HELIX
	Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc
	P1.1-P5.1 K1.1-K4.2 N1.1-N1.5 N2.1-N2.6 N3.1-N4.2 S1.1-S1.3	P1.1-P5.1 M1.1-M4.1 N1.1-N5.2 S1.1-S2.6 H1.1-H1.2

FIGUNJ58NF	FIGUNJ58F
FIGUNJ60NF	FIGUNJ60F
FIGUNJ62NF	FIGUNJ62F
FIGUNJ64NF	FIGUNJ64F
FIGUNJ66NF	FIGUNJ66F
FIGUNJ68NF	FIGUNJ68F
FIGUNJ70NF	FIGUNJ70F
FIGUNJ72NF	FIGUNJ72F
FIGUNJ74NF	FIGUNJ74F
FIGUNJ76NF	FIGUNJ76F
FIGUNJ78NF	FIGUNJ78F
FIGUNJ80NF	FIGUNJ80F
FIGUNJ82NF	FIGUNJ82F
FIGUNJ84NF	FIGUNJ84F
FIGUNJ86NF	FIGUNJ86F
FIGUNJ88NF	FIGUNJ88F
FIGUNJ90NF	FIGUNJ90F
FIGUNJ92NF	FIGUNJ92F
FIGUNJ94NF	FIGUNJ94F
FIGUNJ96NF	FIGUNJ96F
FIGUNJ98NF	FIGUNJ98F
FIGUNJ100NF	FIGUNJ100F

INTERNAL 2xD



UNJ

ASME B1.15

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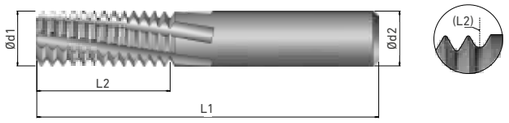
CUSTOMIZED DESIGN ON REQUEST

VHM | e8 | 2xD
R 10° | RH-LH
DIN 6535 HA
INTERNO INTERNAL



	ELICA DX - RH HELIX	ELICA DX - RH HELIX
TRATTAMENTO SUPERFICIALE SURFACE TREATMENT	Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc
MATERIALI LAVORABILI WORKING MATERIALS page 4D • 3	P1.1-P5.1 K1.1-K4.2 N1.1-N1.5 N2.1-N2.6 N3.1-N4.2 S1.1-S1.3	P1.1-P5.1 M1.1-M4.1 N1.1-N5.2 S1.1-S2.6 H1.1-H1.2

Filetto - Thread	(TPI)	d1	L1	L2	d2	Z		
5/16" UNJ 3/8" UNJ	24	6.0	54	15	6.0	3	FIGUNJ04N	FIGUNJ04T
5/16" UNJ	18	6.0	54	15	6.0	3	FIGUNJ06N	FIGUNJ06T
3/8" UNJ 7/16" UNJ	16	6.0	54	15	6.0	3	FIGUNJ08N	FIGUNJ08T
7/16" UNJ 1/2" UNJ	28	8.0	66	20	8.0	3	FIGUNJ10N	FIGUNJ10T
7/16" UNJ 1/2" UNJ	20	8.0	66	20	8.0	3	FIGUNJ12N	FIGUNJ12T
1/2" UNJ 9/16" UNJ	16	8.0	66	20	8.0	3	FIGUNJ14N	FIGUNJ14T
7/16" UNJ	14	8.0	66	20	8.0	3	FIGUNJ16N	FIGUNJ16T
1/2" UNJ	13	8.0	66	20	8.0	3	FIGUNJ18N	FIGUNJ18T
9/16" UNJ 11/16" UNJ	24	10.0	80	25	10.0	4	FIGUNJ20N	FIGUNJ20T
9/16" UNJ 5/8" UNJ	18	10.0	80	25	10.0	4	FIGUNJ22N	FIGUNJ22T
9/16" UNJ	12	10.0	80	25	10.0	4	FIGUNJ24N	FIGUNJ24T
5/8" UNJ 13/16" UNJ	16	12.0	82	30	12.0	4	FIGUNJ26N	FIGUNJ26T
5/8" UNJ 13/16" UNJ	12	12.0	82	30	12.0	4	FIGUNJ28N	FIGUNJ28T
5/8" UNJ	11	12.0	82	30	12.0	4	FIGUNJ30N	FIGUNJ30T
3/4" UNJ	10	12.0	82	30	12.0	4	FIGUNJ32N	FIGUNJ32T
3/4" UNJ 1" UNJ	20	16.0	100	40	16.0	5	FIGUNJ34N	FIGUNJ34T
7/8" UNJ 1" UNJ	16	15.5	100	40	16.0	5	FIGUNJ36N	FIGUNJ36T
7/8" UNJ	14	15.5	100	40	16.0	5	FIGUNJ38N	FIGUNJ38T
7/8" UNJ 1" UNJ	12	16.0	100	40	16.0	5	FIGUNJ40N	FIGUNJ40T
11/16" UNJ 1 11/16" UNJ	18	20.0	110	45	20.0	5	FIGUNJ42N	FIGUNJ42T
1 1/16" UNJ 2 1/2" UNJ	16	20.0	110	45	20.0	5	FIGUNJ44N	FIGUNJ44T
1 1/16" UNJ 2 1/2" UNJ	12	20.0	110	45	20.0	5	FIGUNJ46N	FIGUNJ46T

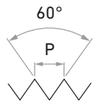
	ELICA DX - RH HELIX	ELICA DX - RH HELIX
	Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc
	P1.1-P5.1 K1.1-K4.2 N1.1-N1.5 N2.1-N2.6 N3.1-N4.2 S1.1-S1.3	P1.1-P5.1 M1.1-M4.1 N1.1-N5.2 S1.1-S2.6 H1.1-H1.2

FIGUNJ04NF	FIGUNJ04F
FIGUNJ06NF	FIGUNJ06F
FIGUNJ08NF	FIGUNJ08F
FIGUNJ10NF	FIGUNJ10F
FIGUNJ12NF	FIGUNJ12F
FIGUNJ14NF	FIGUNJ14F
FIGUNJ16NF	FIGUNJ16F
FIGUNJ18NF	FIGUNJ18F
FIGUNJ20NF	FIGUNJ20F
FIGUNJ22NF	FIGUNJ22F
FIGUNJ24NF	FIGUNJ24F
FIGUNJ26NF	FIGUNJ26F
FIGUNJ28NF	FIGUNJ28F
FIGUNJ30NF	FIGUNJ30F
FIGUNJ32NF	FIGUNJ32F
FIGUNJ34NF	FIGUNJ34F
FIGUNJ36NF	FIGUNJ36F
FIGUNJ38NF	FIGUNJ38F
FIGUNJ40NF	FIGUNJ40F
FIGUNJ42NF	FIGUNJ42F
FIGUNJ44NF	FIGUNJ44F
FIGUNJ46NF	FIGUNJ46F

MICRO INTERNAL 2xD

MJ

DIN ISO 5855



VHM | e8 | 2xD | R 10° | RH-LH | DIN 6535 HA | INTERNO INTERNAL

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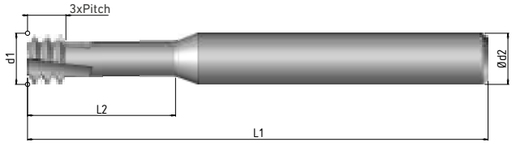
CUSTOMIZED DESIGN ON REQUEST

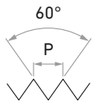


	ELICA DX - RH HELIX	ELICA DX - RH HELIX
TRATTAMENTO SUPERFICIALE SURFACE TREATMENT	Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc
MATERIALI LAVORABILI WORKING MATERIALS page 4D • 3	P1.1-P5.1 K1.1-K4.2 N1.1-N1.5 N2.1-N2.6 N3.1-N4.2 S1.1-S1.3	P1.1-P5.1 M1.1-M4.1 N1.1-N5.2 S1.1-S2.6 H1.1-H1.2

ELICA SX - LH HELIX
Coated LTM ≥45 Hrc ≤60Hrc
N2.7-N2.8
H1.3-H1.5

Filetto - Thread	Pitch mm	d1	L1	L2	d2	Z	Z type TX			
MJ 3	0.50	2.35	54	6.50	6.0	3	4	FIGMJMIC01N	FIGMJMIC01T	FIGMJMIC09TX-SX
MJ 3.5	0.60	2.75	54	7.50	6.0	3	4	FIGMJMIC03N	FIGMJMIC03T	FIGMJMIC11TX-SX
MJ 4	0.70	3.10	54	9.00	6.0	3	4	FIGMJMIC05N	FIGMJMIC05T	FIGMJMIC13TX-SX
MJ 5	0.80	3.80	54	12.50	6.0	3	4	FIGMJMIC07N	FIGMJMIC07T	FIGMJMIC15TX-SX
MJ 6	1.00	4.65	54	14.00	6.0	3	4	FIGMJMIC09N	FIGMJMIC09T	FIGMJMIC17TX-SX
MJ 8	1.25	5.95	54	18.00	6.0	3	4	FIGMJMIC11N	FIGMJMIC11T	FIGMJMIC19TX-SX
MJ 10	1.50	7.80	64	23.00	8.0	3	4	FIGMJMIC13N	FIGMJMIC13T	FIGMJMIC21TX-SX
MJ 12	1.75	9.00	73	26.00	10.0	3	4	FIGMJMIC15N	FIGMJMIC15T	FIGMJMIC23TX-SX
MJ 14	2.00	10.40	80	35.00	12.0	4		FIGMJMIC17N	FIGMJMIC17T	
MJ 16	2.00	11.80	80	35.00	12.0		5			FIGMJMIC25TX-SX
MJ	2.50	15.00	100	43.00	16.0	4	6	FIGMJMIC19N	FIGMJMIC19T	FIGMJMIC27TX-SX

INTERNAL 3xD



VHM | e8 | 3xD | R 10° | RH-LH | DIN 6535 HA | INTERNO INTERNAL

MJ

DIN ISO 5855

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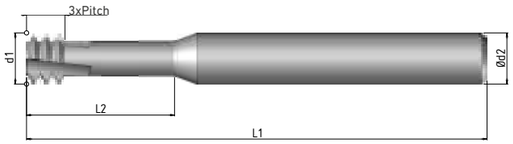
CUSTOMIZED DESIGN ON REQUEST



	ELICA DX - RH HELIX	ELICA DX - RH HELIX
TRATTAMENTO SUPERFICIALE SURFACE TREATMENT	Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc
MATERIALI LAVORABILI WORKING MATERIALS page 4D • 3	P1.1-P5.1 K1.1-K4.2 N1.1-N1.5 N2.1-N2.6 N3.1-N4.2 S1.1-S1.3	P1.1-P5.1 M1.1-M4.1 N1.1-N5.2 S1.1-S2.6 H1.1-H1.2

	ELICA SX - LH HELIX
TRATTAMENTO SUPERFICIALE SURFACE TREATMENT	Coated LTM ≥45 Hrc ≤60Hrc
MATERIALI LAVORABILI WORKING MATERIALS page 4D • 3	N2.7-N2.8 H1.3-H1.5

Filetto - Thread	Pitch mm	d1	L1	L2	d2	Z	Z type TX		
MJ 3	0.50	2.35	54	9.50	6.0	3	4	FIGMJMIC30N	FIGMJMIC30T
MJ 3.5	0.60	2.75	54	10.00	6.0	3		FIGMJMIC32N	FIGMJMIC32T
MJ 4	0.70	3.10	54	12.50	6.0	3	4	FIGMJMIC34N	FIGMJMIC34T
MJ 5	0.80	3.80	54	16.00	6.0	3	4	FIGMJMIC36N	FIGMJMIC36T
MJ 6	1.00	4.65	54	20.00	6.0	3	4	FIGMJMIC38N	FIGMJMIC38T
MJ 8	1.25	5.95	54	24.00	6.0	3	4	FIGMJMIC40N	FIGMJMIC40T

	FIGMJMIC37TX-SX
	FIGMJMIC39TX-SX
	FIGMJMIC41TX-SX
	FIGMJMIC43TX-SX
	FIGMJMIC45TX-SX

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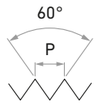
MICRO 2xD

UNJ,UNJF,UNJC



VHM | e8 | 2xD

R 10° | RH-LH

DIN 6535 HA

INTERNO INTERNAL

ASME B1.15

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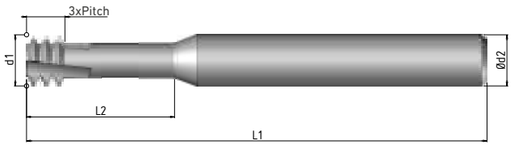
CUSTOMIZED DESIGN ON REQUEST



	ELICA DX - RH HELIX	ELICA DX - RH HELIX
TRATTAMENTO SUPERFICIALE SURFACE TREATMENT	Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc
MATERIALI LAVORABILI WORKING MATERIALS page 4D • 3	P1.1-P5.1 K1.1-K4.2 N1.1-N1.5 N2.1-N2.6 N3.1-N4.2 S1.1-S1.3	P1.1-P5.1 M1.1-M4.1 N1.1-N5.2 S1.1-S2.6 H1.1-H1.2

	ELICA SX - LH HELIX
TRATTAMENTO SUPERFICIALE SURFACE TREATMENT	Coated LTM ≥45 Hrc ≤60Hrc
MATERIALI LAVORABILI WORKING MATERIALS page 4D • 3	N2.7-N2.8 H1.3-H1.5

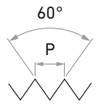
Filetto - Thread	(TPI)	d1	L1	L2	d2	Z	Z type TX		
Nr. 4 UNJ	40	2.10	54	6.3	6.0	3		FIGUNJMIC02N	FIGUNJMIC02T
Nr. 5 UNJ	44	2.10	54	6.3	6.0	3		FIGUNJMIC03N	FIGUNJMIC03T
Nr. 6 UNJ	40	2.45	54	7.0	6.0	3		FIGUNJMIC04N	FIGUNJMIC04T
Nr. 6 UNJ 1/4" UNJ	32	2.55	54	7.0	6.0	3		FIGUNJMIC05N	FIGUNJMIC05T
Nr. 8 UNJ	36	3.30	54	9.0	6.0	3		FIGUNJMIC07N	FIGUNJMIC07T
Nr. 10 UNJ Nr. 12 UNJ	24	3.50	54	9.0	6.0	3		FIGUNJMIC09N	FIGUNJMIC09T
Nr. 8" UNJC Nr. 10"UNJF	32	3.70	54	9.0	6.0		4		FIGUNJMIC03TX-SX
Nr. 12 UNJ 1/4" UNJ	28	4.20	54	11.0	6.0	3		FIGUNJMIC11N	FIGUNJMIC11T
1/4" UNJC	20	4.75	54	14.5	6.0		4		FIGUNJMIC09TX-SX
1/4" UNJ	20	4.75	54	14.5	6.0	3		FIGUNJMIC13N	FIGUNJMIC13T
1/4" UNJF	28	5.00	54	14.0	6.0		4		FIGUNJMIC05TX-SX
5/16" UNJC 9/16" UNJF	18	6.00	64	23.0	8.0		4		FIGUNJMIC13TX-SX
5/16" UNJ 9/16" UNJ	18	6.00	64	17.0	8.0	3		FIGUNJMIC15N	FIGUNJMIC15T
5/16" UNJ 5/16" UJNF 3/8" UNJF	24	6.60	64	22.0	8.0		4	FIGUNJMIC17N	FIGUNJMIC17T
3/8" UNJC	16	6.70	64	23.0	8.0		4		FIGUNJMIC07TX-SX
3/8" UNJ	16	6.70	64	25.0	8.0	3		FIGUNJMIC19N	FIGUNJMIC19T
7/16" UNJC	14	7.70	64	23.0	8.0		4		FIGUNJMIC15TX-SX
7/16" UNJF	20	8.00	64	23.0	8.0		4		FIGUNJMIC17TX-SX
7/16" UNJ	14	7.70	73	27.5	10.0	4		FIGUNJMIC21N	FIGUNJMIC21T
7/16" UNJ	20	8.00	73	27.5	10.0	4		FIGUNJMIC23N	FIGUNJMIC23T
1/2" UNJ	13	9.20	73	27.5	10.0	4		FIGUNJMIC25N	FIGUNJMIC25T
3/4" UNJ	16	12.00	80	35.0	12.0	4		FIGUNJMIC27N	FIGUNJMIC27T

FIL

MICRO 3xD

UNJ,UNJF,UNJC

ASME B1.15



VHM | e8 | 3xD
R 10° | RH-LH
DIN 6535 HA
INTERNO INTERNAL

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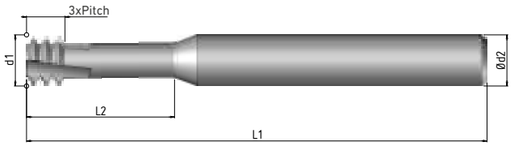
CUSTOMIZED DESIGN ON REQUEST



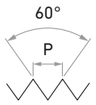
	ELICA DX - RH HELIX	ELICA DX - RH HELIX
TRATTAMENTO SUPERFICIALE SURFACE TREATMENT	Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc
MATERIALI LAVORABILI WORKING MATERIALS page 4D • 3	P1.1-P5.1 K1.1-K4.2 N1.1-N1.5 N2.1-N2.6 N3.1-N4.2 S1.1-S1.3	P1.1-P5.1 M1.1-M4.1 N1.1-N5.2 S1.1-S2.6 H1.1-H1.2

Filetto - Thread	(TPI)	d1	L1	L2	d2	Z	Z type TX		
Nr. 4 UNJ+A31:C50	40	2.10	54	8.0	6.0	3		FIGUNJMIC50N	FIGUNJMIC50T
Nr. 5 UNJ	44	2.10	54	8.0	6.0	3		FIGUNJMIC51N	FIGUNJMIC51T
Nr. 6 UNJ	40	2.45	54	9.6	6.0	3		FIGUNJMIC52N	FIGUNJMIC52T
Nr. 6 UNJ 1/4" UNJ	32	2.60	54	10.5	6.0	3		FIGUNJMIC53N	FIGUNJMIC53T
Nr. 8 UNJ	36	3.00	54	12.5	6.0	3		FIGUNJMIC55N	FIGUNJMIC55T
Nr. 10 UNJ Nr. 12 UNJ	24	3.00	54	12.5	6.0	3		FIGUNJMIC57N	FIGUNJMIC57T
8" UNJC 10" UNJF	32	3.30	54	12.50	6.0		4		
Nr. 12 UNJ 1/4" UNJ	28	4.00	54	15.0	6.0	3		FIGUNJMIC59N	FIGUNJMIC59T
1/4" UNJC	20	4.90	54	20.0	6.0		4		
1/4" UNJ	20	5.00	54	19.0	6.0	3		FIGUNJMIC61N	FIGUNJMIC61T
1/4" UNJF	28	5.10	54	14.0	6.0		4		
5/16" UNJC 9/16" UNJF	18	6.15	64	28.0	8.0		4		
5/16" UNJ 9/16" UNJ	18	6.40	64	24.0	8.0	3		FIGUNJMIC63N	FIGUNJMIC63T
3/8" UNJC	16	6.90	64	28.0	8.0		4		
5/16" UNJ 5/16" UJNF 3/8" UNJF	24	6.70	64	24.0	8.0	3	4	FIGUNJMIC65N	FIGUNJMIC65T
7/16" UNJC	14	7.90	64	28.0	8.0		4		
3/8" UNJ 3/4" UNJ	16	7.70	64	28.9	8.0	3		FIGUNJMIC67N	FIGUNJMIC67T
7/16" UNJF	20	8.00	64	28.0	8.0		4		
7/16" UNJ	14	9.20	73	34.5	10.0	4		FIGUNJMIC69N	FIGUNJMIC69T
7/16" UNJ	20	9.60	73	36.0	10.0	4		FIGUNJMIC71N	FIGUNJMIC71T
1/2" UNJ	13	9.90	73	37.0	10.0	4		FIGUNJMIC73N	FIGUNJMIC73T

	ELICA SX - LH HELIX
	Coated LTM ≤45 Hrc ≤60Hrc
	N2.7-N2.8 H1.3-H1.5

Z type TX	
FIGUNJMIC31TX-SX	
FIGUNJMIC37TX-SX	
FIGUNJMIC33TX-SX	
FIGUNJMIC41TX-SX	
FIGUNJMIC35TX-SX	
FIGUNJMIC43TX-SX	
FIGUNJMIC45TX-SX	
FIGUNJMIC39TX-SX	

EXTERNAL 2xD



VHM | e8 | 2xD
R 10° | RH-LH
DIN 6535 HA
ESTERNO EXTERNAL

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DIN13

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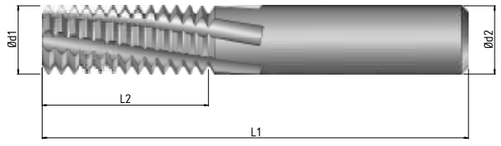
CUSTOMIZED DESIGN ON REQUEST



	ELICA DX - RH HELIX	ELICA DX - RH HELIX
TRATTAMENTO SUPERFICIALE SURFACE TREATMENT	Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc
MATERIALI LAVORABILI WORKING MATERIALS page 4D • 3	P1.1-P5.1 K1.1-K4.2 N1.1-N1.5 N2.1-N2.6 N3.1-N4.2 S1.1-S1.3	P1.1-P5.1 M1.1-M4.1 N1.1-N5.2 S1.1-S2.6 H1.1-H1.2

Pitch mm	d1	L1	L2	d2	Z		
1.00	8.0	66	20	8.0	3	FIGMET17N_EXT	FIGMET17T_EXT
1.25	10.0	80	25	10.0	4	FIGMET19N_EXT	FIGMET19T_EXT
1.50	12.0	82	30	12.0	4	FIGMET21N_EXT	FIGMET21T_EXT
1.75	14.0	100	35	14.0	4	FIGMET23N_EXT	FIGMET23T_EXT
2.00	16.0	100	40	16.0	5	FIGMET25N_EXT	FIGMET25T_EXT
2.50	18.0	110	40	18.0	5	FIGMET27N_EXT	FIGMET27T_EXT
3.00	20.0	110	40	20.0	5	FIGMET29N_EXT	FIGMET29T_EXT

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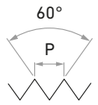
MICRO EXT. 2xD

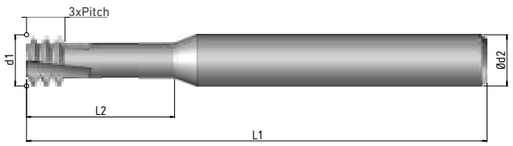


VHM | e8 | 2xD
R 10° | RH-LH
DIN 6535 HA
ESTERNO EXTERNAL

M

DIN13

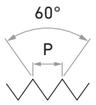
ESECUZIONI SPECIALI A DISEGNO
CUSTOMIZED DESIGN ON REQUEST



	ELICA DX - RH HELIX	ELICA DX - RH HELIX
TRATTAMENTO SUPERFICIALE SURFACE TREATMENT	Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc
MATERIALI LAVORABILI WORKING MATERIALS page 4D • 3	P1.1-P5.1 K1.1-K4.2 N1.1-N1.5 N2.1-N2.6 N3.1-N4.2 S1.1-S1.3	P1.1-P5.1 M1.1-M4.1 N1.1-N5.2 S1.1-S2.6 H1.1-H1.2

Pitch mm	d1	L1	L2	d2	Z		
0.50	6.0	54	18	6	3	FIGMETMIC07N_EXT	FIGMETMIC07T_EXT
0.75	6.0	54	18	6	3	FIGMETMIC11N_EXT	FIGMETMIC11T_EXT

MICRO EXT. 3xD

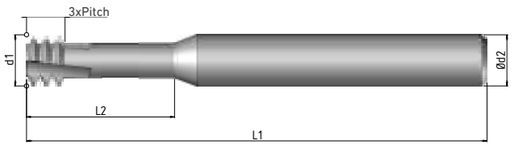


VHM | e8 | 3xD
R 10° | RH-LH
DIN 6535 HA
ESTERNO EXTERNAL

M

DIN13

ESECUZIONI SPECIALI A DISEGNO
CUSTOMIZED DESIGN ON REQUEST



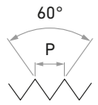
	ELICA DX - RH HELIX	ELICA DX - RH HELIX
TRATTAMENTO SUPERFICIALE SURFACE TREATMENT	Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc
MATERIALI LAVORABILI WORKING MATERIALS page 4D • 3	P1.1-P5.1 K1.1-K4.2 N1.1-N1.5 N2.1-N2.6 N3.1-N4.2 S1.1-S1.3	P1.1-P5.1 M1.1-M4.1 N1.1-N5.2 S1.1-S2.6 H1.1-H1.2

Pitch mm	d1	L1	L2	d2	Z		
0.50	6.0	54	24	6.0	3	FIGMETMIC09N_EXT	FIGMETMIC09T_EXT
0.75	6.0	54	24	6.0	3	FIGMETMIC13N_EXT	FIGMETMIC13T_EXT

FIL

FIL

EXTERNAL 2xD

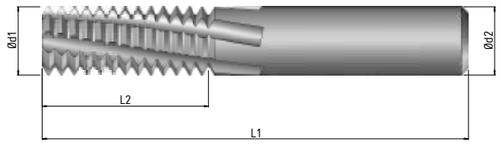


VHM | e8 | 2xD
R 10° | RH-LH
DIN 6535 HA
ESTERNO EXTERNAL

MJ

DIN ISO 5855

ESECUZIONI SPECIALI A DISEGNO
CUSTOMIZED DESIGN ON REQUEST



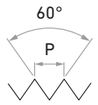
	ELICA DX - RH HELIX	ELICA DX - RH HELIX
TRATTAMENTO SUPERFICIALE SURFACE TREATMENT	Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc
MATERIALI LAVORABILI WORKING MATERIALS page 4D • 3	P1.1-P5.1 K1.1-K4.2 N1.1-N1.5 N2.1-N2.6 N3.1-N4.2 S1.1-S1.3	P1.1-P5.1 M1.1-M4.1 N1.1-N5.2 S1.1-S2.6 H1.1-H1.2

Pitch mm	d1	L1	L2	d2	Z		
1.00	8.0	66	20	8.0	3	FIGMJ58N_EXT	FIGMJ58T_EXT
1.25	10.0	80	25	10.0	4	FIGMJ60N_EXT	FIGMJ60T_EXT
1.50	12.0	82	30	12.0	4	FIGMJ62N_EXT	FIGMJ62T_EXT
1.75	14.0	100	35	14.0	4	FIGMJ64N_EXT	FIGMJ64T_EXT
2.00	16.0	100	40	16.0	5	FIGMJ66N_EXT	FIGMJ66T_EXT
2.50	18.0	110	40	18.0	5	FIGMJ68N_EXT	FIGMJ68T_EXT
3.00	20.0	110	40	20.0	5	FIGMJ70N_EXT	FIGMJ70T_EXT

IGUTENSILI

FIL

MICRO EXT. 2xD

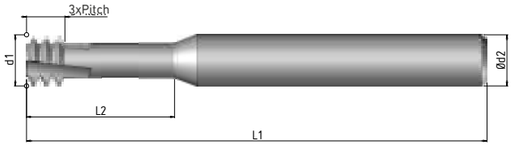


VHM | e8 | 2xD
R 10° | RH-LH
DIN 6535 HA
ESTERNO EXTERNAL

MJ

DIN ISO 5855

ESECUZIONI SPECIALI A DISEGNO
CUSTOMIZED DESIGN ON REQUEST



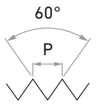
	ELICA DX - RH HELIX	ELICA DX - RH HELIX
TRATTAMENTO SUPERFICIALE SURFACE TREATMENT	Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc
MATERIALI LAVORABILI WORKING MATERIALS page 4D • 3	P1.1-P5.1 K1.1-K4.2 N1.1-N1.5 N2.1-N2.6 N3.1-N4.2 S1.1-S1.3	P1.1-P5.1 M1.1-M4.1 N1.1-N5.2 S1.1-S2.6 H1.1-H1.2

Pitch mm	d1	L1	L2	d2	Z		
0.50	6.0	54	18	6.0	3	FIGMJMIC50N_EXT	FIGMJMIC50T_EXT
0.75	6.0	54	18	6.0	3	FIGMJMIC54N_EXT	FIGMJMIC54T_EXT

FIL

FIL

MICRO EXT. 3xD

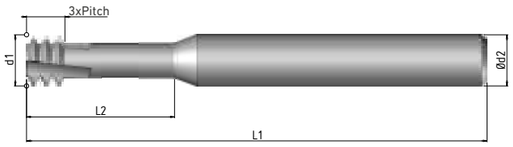


VHM | e8 | 3xD
R 10° | RH-LH
DIN 6535 HA
ESTERNO EXTERNAL

MJ

DIN ISO 5855

ESECUZIONI SPECIALI A DISEGNO
CUSTOMIZED DESIGN ON REQUEST



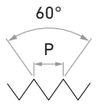
	ELICA DX - RH HELIX	ELICA DX - RH HELIX
TRATTAMENTO SUPERFICIALE SURFACE TREATMENT	Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc
MATERIALI LAVORABILI WORKING MATERIALS page 4D • 3	P1.1-P5.1 K1.1-K4.2 N1.1-N1.5 N2.1-N2.6 N3.1-N4.2 S1.1-S1.3	P1.1-P5.1 M1.1-M4.1 N1.1-N5.2 S1.1-S2.6 H1.1-H1.2

Pitch mm	d1	L1	L2	d2	Z		
0.50	6.0	54	24	6.0	3	FIGMJMIC52N_EXT	FIGMJMIC52T_EXT
0.75	6.0	54	24	6.0	3	FIGMJMIC56N_EXT	FIGMJMIC56T_EXT

FIL

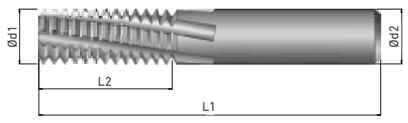
FIL

THREAD REPAIR
2xD
Eg, M
DIN 8140-2



VHM | e8 | 2xD
R 10° | RH-LH
DIN 6535 HA
INTERNO INTERNAL

ESECUZIONI SPECIALI A DISEGNO
CUSTOMIZED DESIGN ON REQUEST



	ELICA DX - RH HELIX	ELICA DX - RH HELIX
TRATTAMENTO SUPERFICIALE / SURFACE TREATMENT	Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc
MATERIALI LAVORABILI / WORKING MATERIALS page 4D • 3	P1.1-P5.1 K1.1-K4.2 N1.1-N1.5 N2.1-N2.6 N3.1-N4.2 S1.1-S1.3	P1.1-P5.1 M1.1-M4.1 N1.1-N5.2 S1.1-S2.6 H1.1-H1.2

Filetto - Thread	Pitch mm	d1	L1	L2	d2	Z		
EG-M 4	0.70	3.1	54	8	6.0	3	FIGEGM03N	FIGEGM03T
EG-M 5	0.80	4.0	54	12	6.0	3	FIGEGM00N	FIGEGM00T
EG-M 6	1.00	4.5	54	12	6.0	3	FIGEGM02N	FIGEGM02T
EG-M 7	1.00	6.0	54	15	6.0	3	FIGEGM05N	FIGEGM05T
EG-M 8	1.25	6.0	54	15	6.0	3	FIGEGM06N	FIGEGM06T
EG-MF 8-9-10-11	1.00	8.0	66	20	8.0	3	FIGEGM09N	FIGEGM09T
EG-MF 10	1.25	8.0	66	20	8.0	3	FIGEGM10N	FIGEGM10T
EG-M 10	1.50	8.0	66	20	8.0	3	FIGEGM11N	FIGEGM11T
EG-M 12	1.75	8.0	66	20	8.0	3	FIGEGM12N	FIGEGM12T
EG-MF 12	1.00	10.0	80	25	10.0	4	FIGEGM14N	FIGEGM14T
EG-MF 12 EG-MF 14	1.25	10.0	80	25	10.0	4	FIGEGM15N	FIGEGM15T
EG-MF 12	1.50	10.0	80	25	10.0	4	FIGEGM16N	FIGEGM16T
EG-MF 14	1.00	12.0	82	30	12.0	4	FIGEGM19N	FIGEGM19T
EG-MF 14 EG-MF 15	1.50	12.0	82	30	12.0	4	FIGEGM20N	FIGEGM20T
EG-M 14	2.00	12.0	82	30	12.0	4	FIGEGM21N	FIGEGM21T
EG-MF 16	1.50	14.0	100	35	14.0	4	FIGEGM24N	FIGEGM24T
EG-M 16	2.00	14.0	100	35	14.0	4	FIGEGM25N	FIGEGM25T
EG-MF 18 EG-MF 20	1.50	16.0	100	40	16.0	5	FIGEGM29N	FIGEGM29T
EG-MF 18 EG-MF 20	2.00	16.0	100	40	16.0	5	FIGEGM30N	FIGEGM30T
EG-M 18-20-22	2.50	16.0	100	40	16.0	5	FIGEGM31N	FIGEGM31T
EG-MF 22-24-26-27-28	1.50	20.0	110	40	20.0	5	FIGEGM34N	FIGEGM34T
EG-M 22-24 MF 27-30-33-36-39-42-45-48	2.00	20.0	110	40	20.0	5	FIGEGM35N	FIGEGM35T
EG-M 22-24 MF 27-30-33-36-39-42-45-48	3.00	20.0	110	40	20.0	5	FIGEGM36N	FIGEGM36T
EG-MF 42 EG-MF 36 EG-MF 39	4.00	25.0	150	78	25.0	5	FIGEGM38N	FIGEGM38T
EG-MF 30 EG-MF 33	3.50	25.0	150	78	25.0	5	FIGEGM40N	FIGEGM40T

	ELICA DX - RH HELIX	ELICA DX - RH HELIX
	Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc
	P1.1-P5.1 K1.1-K4.2 N1.1-N1.5 N2.1-N2.6 N3.1-N4.2 S1.1-S1.3	P1.1-P5.1 M1.1-M4.1 N1.1-N5.2 S1.1-S2.6 H1.1-H1.2

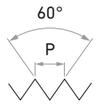
FIGEGM03NF	FIGEGM03F
FIGEGM00NF	FIGEGM00F
FIGEGM02NF	FIGEGM02F
FIGEGM05NF	FIGEGM05F
FIGEGM06NF	FIGEGM06F
FIGEGM09NF	FIGEGM09F
FIGEGM10NF	FIGEGM10F
FIGEGM11NF	FIGEGM11F
FIGEGM12NF	FIGEGM12F
FIGEGM14NF	FIGEGM14F
FIGEGM15NF	FIGEGM15F
FIGEGM16NF	FIGEGM16F
FIGEGM19NF	FIGEGM19F
FIGEGM20NF	FIGEGM20F
FIGEGM21NF	FIGEGM21F
FIGEGM24NF	FIGEGM24F
FIGEGM25NF	FIGEGM25F
FIGEGM29NF	FIGEGM29F
FIGEGM30NF	FIGEGM30F
FIGEGM31NF	FIGEGM31F
FIGEGM34NF	FIGEGM34F
FIGEGM35NF	FIGEGM35F
FIGEGM36NF	FIGEGM36F
FIGEGM38NF	FIGEGM38F
FIGEGM40NF	FIGEGM40F

THREAD REPAIR MICRO 2xD

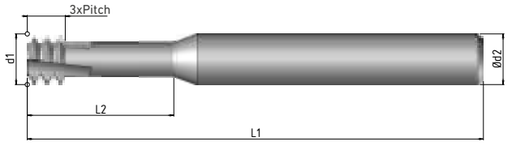
Eg-M

DIN 8140-2

ESECUZIONI SPECIALI A DISEGNO
CUSTOMIZED DESIGN ON REQUEST



VHM | e8 | 2xD | R 10° | RH-LH | DIN 6535 HA | INTERNO INTERNAL



	ELICA DX - RH HELIX	ELICA DX - RH HELIX
TRATTAMENTO SUPERFICIALE SURFACE TREATMENT	Cncoated ≤45Hrc	Coated TNF ≤45Hrc
MATERIALI LAVORABILI WORKING MATERIALS page 4D • 3	P1.1-P5.1 K1.1-K4.2 N1.1-N1.5 N2.1-N2.6 N3.1-N4.2 S1.1-S1.3	P1.1-P5.1 M1.1-M4.1 N1.1-N5.2 S1.1-S2.6 H1.1-H1.2

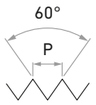
Filetto - Thread	Pitch mm	d1	L1	L2	d2	Z		
EG-M 2	0.40	1.55	39	04:50	3.0	3	FIGEGMMIC03N	FIGEGMMIC03T
EG-M 2.5	0.45	1.95	54	05:50	6.0	3	FIGEGMMIC07N	FIGEGMMIC07T
EG-M 3	0.50	2.35	54	06:50	6.0	3	FIGEGMMIC09N	FIGEGMMIC09T
EG-M 3.5	0.60	2.75	54	07:50	6.0	3	FIGEGMMIC11N	FIGEGMMIC11T

MICRO INT. 2xD

M, MF

DIN13

ESECUZIONI SPECIALI A DISEGNO
CUSTOMIZED DESIGN ON REQUEST



VHM

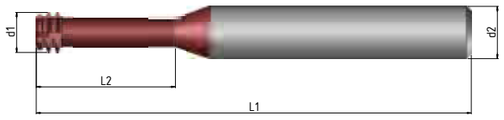
R 0°

2xD

LH

DIN 6535 HA

INTERNO
INTERNAL



	ELICA SX - LH HELIX	ELICA SX - LH HELIX
TRATTAMENTO SUPERFICIALE SURFACE TREATMENT	Coated HDM ≥45 Hrc ≤66Hrc	Coated HDM ≥45 Hrc ≤66Hrc
MATERIALI LAVORABILI WORKING MATERIALS page 4D • 11	P1.1-P5.1 M1.1-M2.1 K1.1-K4.2 N1.1-N5.3 S1.1-S1.3 H1.1-H1.5	P1.1-P5.1 M1.1-M2.1 K1.1-K4.2 N1.1-N5.3 S1.1-S1.3 H1.1-H1.5

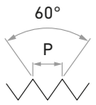
Filetto - Thread	Pitch mm	d1	L1	L2	d2	Z		
M 4	0.70	3.1	50	7.0	6.0	4	FIGMETMICFOR01T	
M 5	0.80	3.8	50	8.5	6.0	4	FIGMETMICFOR03T	
M 6	1.00	4.6	50	10.0	6.0	4	FIGMETMICFOR05T	
MF 8	1.00	6.2	70	15.0	8.0	4	FIGMETMICFOR07T	FIGMETMICFOR07F
M 8	1.25	6.2	70	15.0	8.0	4	FIGMETMICFOR09T	FIGMETMICFOR09F
MF 10	1.00	7.5	70	20.0	8.0	4	FIGMETMICFOR11T	FIGMETMICFOR11F
MF 10	1.25	7.5	70	20.0	8.0	4	FIGMETMICFOR13T	FIGMETMICFOR13F
M 10	1.50	7.5	70	20.0	8.0	4	FIGMETMICFOR15T	FIGMETMICFOR15F
MF 12	1.00	9.0	80	25.0	10.0	4	FIGMETMICFOR17T	FIGMETMICFOR17F
MF 12	1.25	9.0	80	25.0	10.0	4	FIGMETMICFOR19T	FIGMETMICFOR19F
MF 12	1.50	9.0	80	25.0	10.0	4	FIGMETMICFOR21T	FIGMETMICFOR21F
M 12	1.75	9.0	80	25.0	10.0	4	FIGMETMICFOR23T	FIGMETMICFOR23F
MF 16	1.50	11.5	100	30.0	12.0	4	FIGMETMICFOR25T	FIGMETMICFOR25F
M 16	2.00	11.5	100	30.0	12.0	4	FIGMETMICFOR27T	FIGMETMICFOR27F
MF 18	1.50	14.0	135	40.0	14.0	4	FIGMETMICFOR29T	FIGMETMICFOR29F
M 18	2.50	14.0	135	40.0	14.0	4	FIGMETMICFOR31T	FIGMETMICFOR31F
MF 20	1.50	15.0	135	45.0	16.0	4	FIGMETMICFOR33T	FIGMETMICFOR33F
M 20	2.50	15.0	135	45.0	16.0	4	FIGMETMICFOR35T	FIGMETMICFOR35F

THREAD MILLS FOR SIMULTANEOUS DRILLING AND THREADING

MICRO INT. 2.5xD

M, MF

DIN13



VHM

R 0°

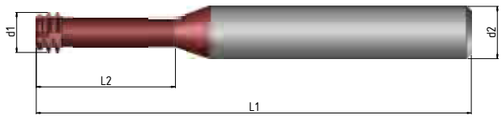
2.5xD

LH

DIN 6535 HA

INTERNO INTERNAL

ESECUZIONI SPECIALI A DISEGNO
CUSTOMIZED DESIGN ON REQUEST



	ELICA SX - LH HELIX	ELICA SX - LH HELIX
TRATTAMENTO SUPERFICIALE SURFACE TREATMENT	Coated HDM ≥45 Hrc ≤66Hrc	Coated HDM ≥45 Hrc ≤66Hrc
MATERIALI LAVORABILI WORKING MATERIALS page 4D • 11	P1.1-P5.1 M1.1-M2.1 K1.1-K4.2 N1.1-N5.3 S1.1-S1.3 H1.1-H1.5	P1.1-P5.1 M1.1-M2.1 K1.1-K4.2 N1.1-N5.3 S1.1-S1.3 H1.1-H1.5

Filetto - Thread	Pitch mm	d1	L1	L2	d2	Z		
M 4	0.70	3.1	50	10.0	6.0	4	FIGMETMICFOR50T	
M 5	0.80	3.8	50	12.5	6.0	4	FIGMETMICFOR52T	
M 6	1.00	4.6	50	15.0	6.0	4	FIGMETMICFOR54T	
MF 8	1.00	6.2	70	20.0	8.0	4	FIGMETMICFOR56T	FIGMETMICFOR56F
M 8	1.25	6.2	70	20.0	8.0	4	FIGMETMICFOR58T	FIGMETMICFOR58F
MF 10	1.00	7.5	70	25.0	8.0	4	FIGMETMICFOR60T	FIGMETMICFOR60F
MF 10	1.25	7.5	70	25.0	8.0	4	FIGMETMICFOR62T	FIGMETMICFOR62F
M 10	1.50	7.5	70	25.0	8.0	4	FIGMETMICFOR64T	FIGMETMICFOR64F
MF 12	1.00	9.0	80	30.0	10.0	4	FIGMETMICFOR66T	FIGMETMICFOR66F
MF 12	1.25	9.0	80	30.0	10.0	4	FIGMETMICFOR68T	FIGMETMICFOR68F
MF 12	1.50	9.0	80	30.0	10.0	4	FIGMETMICFOR70T	FIGMETMICFOR70F
M 12	1.75	9.0	80	30.0	10.0	4	FIGMETMICFOR72T	FIGMETMICFOR72F
MF 16	1.50	11.5	100	40.0	12.0	4	FIGMETMICFOR74T	FIGMETMICFOR74F
M 16	2.00	11.5	100	40.0	12.0	4	FIGMETMICFOR76T	FIGMETMICFOR76F
MF 18	1.50	14.0	135	45.0	14.0	4	FIGMETMICFOR78T	FIGMETMICFOR78F
M 18	2.50	14.0	135	45.0	14.0	4	FIGMETMICFOR80T	FIGMETMICFOR80F
MF 20	1.50	15.0	135	50.0	16.0	4	FIGMETMICFOR82T	FIGMETMICFOR82F
M 20	2.50	15.0	135	50.0	16.0	4	FIGMETMICFOR84T	FIGMETMICFOR84F

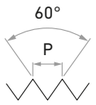
THREAD MILLS FOR SIMULTANEOUS DRILLING AND THREADING

MICRO INT. 3xD

M, MF

DIN13

ESECUZIONI SPECIALI A DISEGNO
CUSTOMIZED DESIGN ON REQUEST



VHM

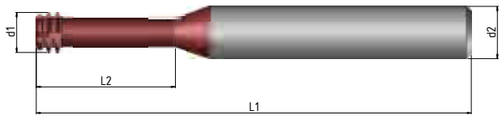
R 0°

3xD

LH

DIN 6535 HA

INTERNO
INTERNAL



	ELICA SX - LH HELIX	ELICA SX - LH HELIX
TRATTAMENTO SUPERFICIALE SURFACE TREATMENT	Coated HDM ≥45 Hrc ≤66Hrc	Coated HDM ≥45 Hrc ≤66Hrc
MATERIALI LAVORABILI WORKING MATERIALS page 4D • 11	P1.1-P5.1 M1.1-M2.1 K1.1-K4.2 N1.1-N5.3 S1.1-S1.3 H1.1-H1.5	P1.1-P5.1 M1.1-M2.1 K1.1-K4.2 N1.1-N5.3 S1.1-S1.3 H1.1-H1.5

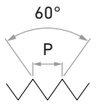
Filetto - Thread	Pitch mm	d1	L1	L2	d2	Z		
M 4	0.70	3.1	50	12.2	6.0	4	FIGMETMICFOR100T	
M 5	0.80	3.8	50	15.25	6.0	4	FIGMETMICFOR102T	
M 6	1.00	4.6	50	18.3	6.0	4	FIGMETMICFOR104T	
MF 8	1.00	6.2	70	24.4	8.0	4	FIGMETMICFOR106T	FIGMETMICFOR106F
M 8	1.25	6.2	70	24.4	8.0	4	FIGMETMICFOR108T	FIGMETMICFOR108F
MF 10	1.00	7.5	70	30.5	8.0	4	FIGMETMICFOR110T	FIGMETMICFOR110F
MF 10	1.25	7.5	70	30.5	8.0	4	FIGMETMICFOR112T	FIGMETMICFOR112F
M 10	1.50	7.5	70	30.5	8.0	4	FIGMETMICFOR114T	FIGMETMICFOR114F
MF 12	1.00	9.0	80	36.6	10.0	4	FIGMETMICFOR116T	FIGMETMICFOR116F
MF 12	1.25	9.0	80	36.6	10.0	4	FIGMETMICFOR118T	FIGMETMICFOR118F
MF 12	1.50	9.0	80	36.6	10.0	4	FIGMETMICFOR120T	FIGMETMICFOR120F
M 12	1.75	9.0	80	36.6	10.0	4	FIGMETMICFOR122T	FIGMETMICFOR122F
MF 16	1.50	11.5	100	48.8	12.0	4	FIGMETMICFOR124T	FIGMETMICFOR124F
M 16	2.00	11.5	100	48.8	12.0	4	FIGMETMICFOR126T	FIGMETMICFOR126F
MF 18	1.50	14.0	135	54.9	14.0	4	FIGMETMICFOR128T	FIGMETMICFOR128F
M 18	2.50	14.0	135	54.9	14.0	4	FIGMETMICFOR130T	FIGMETMICFOR130F
MF 20	1.50	15.0	135	61	16.0	4	FIGMETMICFOR132T	FIGMETMICFOR132F
M 20	2.50	15.0	135	61	16.0	4	FIGMETMICFOR134T	FIGMETMICFOR134F

THREAD MILLS FOR SIMULTANEOUS DRILLING AND THREADING

MICRO INT. 2xD

UNC, UNF

ASME B1.1



VHM

R 0°

2xD

LH

DIN 6535 HA

INTERNO INTERNAL

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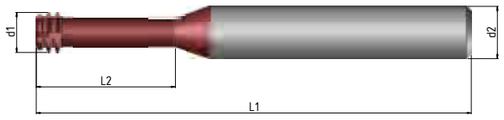
CUSTOMIZED DESIGN ON REQUEST



	ELICA SX - LH HELIX	ELICA SX - LH HELIX
TRATTAMENTO SUPERFICIALE SURFACE TREATMENT	Coated HDM ≥45 Hrc ≤66Hrc	Coated HDM ≥45 Hrc ≤66Hrc
MATERIALI LAVORABILI WORKING MATERIALS page 4D • 11	P1.1-P5.1 M1.1-M2.1 K1.1-K4.2 N1.1-N5.3 S1.1-S1.3 H1.1-H1.5	P1.1-P5.1 M1.1-M2.1 K1.1-K4.2 N1.1-N5.3 S1.1-S1.3 H1.1-H1.5

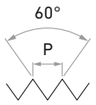
Filetto - Thread	(TPI)	d1	L1	L2	d2	Z		
Nr. 4" UNC	40	2.1	50	5.8	6.0	4	FIGUNMICFOR01T	
Nr. 6" UNC	32	2.55	50	7.2	6.0	4	FIGUNMICFOR03T	
Nr. 8" UNC	32	3.2	50	8.55	6.0	4	FIGUNMICFOR05T	
Nr. 8" UNF	36	3.3	50	8.3	6.0	4	FIGUNMICFOR07T	
Nr. 10" UNC	24	3.5	70	9.7	6.0	4	FIGUNMICFOR09T	
Nr. 10" UNF	32	3.7	70	9.9	6.0	4	FIGUNMICFOR11T	
Nr. 12" UNF	28	4.2	70	11.25	6.0	4	FIGUNMICFOR13T	
1/4" UNC	20	4.8	70	12.7	6.0	4	FIGUNMICFOR15T	
1/4" UNF	28	5.0	70	12.7	6.0	4	FIGUNMICFOR17T	
5/16" UNC	18	6.0	80	15.9	6.0	4	FIGUNMICFOR19T	
5/16" UNF	24	6.0	80	15.9	6.0	4	FIGUNMICFOR21T	
3/8" UNC	16	6.7	80	19.1	8.0	4	FIGUNMICFOR23T	FIGUNMICFOR23F
7/16" UNC	14	7.7	80	22.2	8.0	4	FIGUNMICFOR25T	FIGUNMICFOR25F
1/2" UNC	13	9.2	80	25.4	10.0	4	FIGUNMICFOR27T	FIGUNMICFOR27F
9/16" UNC	12	10.5	100	28.6	12.0	4	FIGUNMICFOR29T	FIGUNMICFOR29F
5/8" UNC	11	11.4	100	31.8	12.0	4	FIGUNMICFOR31T	FIGUNMICFOR31F
3/4" UNF	16	12.0	100	39.05	12.0	4	FIGUNMICFOR33T	FIGUNMICFOR33F

THREAD MILLS FOR SIMULTANEOUS DRILLING AND THREADING

MICRO INT. 2,5xD

UNC, UNF

ASME B1.1



VHM

R 0°

2.5xD

LH

DIN 6535 HA

INTERNO INTERNAL

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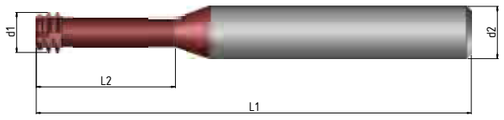
CUSTOMIZED DESIGN ON REQUEST



	ELICA SX - LH HELIX	ELICA SX - LH HELIX
TRATTAMENTO SUPERFICIALE SURFACE TREATMENT	Coated HDM ≥45 Hrc ≤66Hrc	Coated HDM ≥45 Hrc ≤66Hrc
MATERIALI LAVORABILI WORKING MATERIALS page 4D • 11	P1.1-P5.1 M1.1-M2.1 K1.1-K4.2 N1.1-N5.3 S1.1-S1.3 H1.1-H1.5	P1.1-P5.1 M1.1-M2.1 K1.1-K4.2 N1.1-N5.3 S1.1-S1.3 H1.1-H1.5

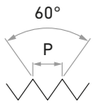
Filetto - Thread	(TPI)	d1	L1	L2	d2	Z		
Nr. 4" UNC	40	2.1	50	7.25	6.0	4	FIGUNMICFOR51T	
Nr. 6" UNC	32	2.55	50	8.95	6.0	4	FIGUNMICFOR53T	
Nr. 8" UNC	32	3.2	50	10.63	6.0	4	FIGUNMICFOR55T	
Nr. 8" UNF	36	3.3	50	10.4	6.0	4	FIGUNMICFOR57T	
Nr. 10" UNC	24	3.5	70	12.1	6.0	4	FIGUNMICFOR59T	
Nr. 10" UNF	32	3.7	70	12.3	6.0	4	FIGUNMICFOR61T	
Nr. 12" UNF	28	4.2	70	14	6.0	4	FIGUNMICFOR63T	
1/4" UNC	20	4.8	70	15.9	6.0	4	FIGUNMICFOR65T	
1/4" UNF	28	5.0	70	15.9	6.0	4	FIGUNMICFOR67T	
5/16" UNC	18	6.0	80	19.8	6.0	4	FIGUNMICFOR69T	
5/16" UNF	24	6.0	80	19.8	6.0	4	FIGUNMICFOR71T	
3/8" UNC	16	6.7	80	23.8	8.0	4	FIGUNMICFOR73T	FIGUNMICFOR73F
7/16" UNC	14	7.7	80	27.8	8.0	4	FIGUNMICFOR75T	FIGUNMICFOR75F
1/2" UNC	13	9.2	80	31.8	10.0	4	FIGUNMICFOR77T	FIGUNMICFOR77F
9/16" UNC	12	10.5	100	35.7	12.0	4	FIGUNMICFOR79T	FIGUNMICFOR79F
5/8" UNC	11	11.4	100	39.7	12.0	4	FIGUNMICFOR81T	FIGUNMICFOR81F
3/4" UNF	16	12.0	100	48.6	12.0	4	FIGUNMICFOR83T	FIGUNMICFOR83F

THREAD MILLS FOR SIMULTANEOUS DRILLING AND THREADING

MICRO INT. 3xD

UNC, UNF

ASME B1.1



VHM

R 0°

3xD

LH

DIN 6535 HA

INTERNO INTERNAL

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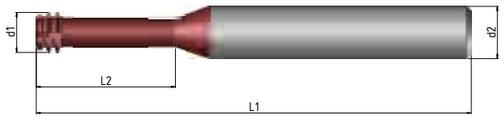
CUSTOMIZED DESIGN ON REQUEST

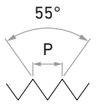


	ELICA SX - LH HELIX	ELICA SX - LH HELIX
TRATTAMENTO SUPERFICIALE SURFACE TREATMENT	Coated HDM ≥45 Hrc ≤66Hrc	Coated HDM ≥45 Hrc ≤66Hrc
MATERIALI LAVORABILI WORKING MATERIALS page 4D • 11	P1.1-P5.1 M1.1-M2.1 K1.1-K4.2 N1.1-N5.3 S1.1-S1.3 H1.1-H1.5	P1.1-P5.1 M1.1-M2.1 K1.1-K4.2 N1.1-N5.3 S1.1-S1.3 H1.1-H1.5

Filetto - Thread	(TPI)	d1	L1	L2	d2	Z		
Nr. 4" UNC	40	2.1	50	8.7	6.0	4	FIGUNMICFOR100T	
Nr. 6" UNC	32	2.55	50	10.7	6.0	4	FIGUNMICFOR102T	
Nr. 8" UNC	32	3.2	50	12.7	6.0	4	FIGUNMICFOR104T	
Nr. 8" UNF	36	3.3	50	12.7	6.0	4	FIGUNMICFOR106T	
Nr. 10" UNC	24	3.5	70	14.7	6.0	4	FIGUNMICFOR108T	
Nr. 10" UNF	32	3.7	70	14.7	6.0	4	FIGUNMICFOR110T	
Nr. 12" UNF	28	4.2	70	16.75	6.0	4	FIGUNMICFOR112T	
1/4" UNC	20	4.8	70	19.4	6.0	4	FIGUNMICFOR114T	
1/4" UNF	28	5.0	70	19.4	6.0	4	FIGUNMICFOR116T	
5/16" UNC	18	6.0	80	24.2	6.0	4	FIGUNMICFOR118T	
5/16" UNF	24	6.0	80	24.2	6.0	4	FIGUNMICFOR120T	
3/8" UNC	16	6.7	80	29.05	8.0	4	FIGUNMICFOR122T	FIGUNMICFOR122F
7/16" UNC	14	7.7	80	33.9	8.0	4	FIGUNMICFOR124T	FIGUNMICFOR124F
1/2" UNC	13	9.2	80	38.75	10.0	4	FIGUNMICFOR126T	FIGUNMICFOR126F
9/16" UNC	12	10.5	100	43.6	12.0	4	FIGUNMICFOR128T	FIGUNMICFOR128F
5/8" UNC	11	11.4	100	48.45	12.0	4	FIGUNMICFOR130T	FIGUNMICFOR130F
3/4" UNF	16	12.0	100	58.1	12.0	4	FIGUNMICFOR132T	FIGUNMICFOR132F

THREAD MILLS FOR SIMULTANEOUS DRILLING AND THREADING

MICRO INT. 2xD



VHM

R 0°

2xD

LH

DIN 6535 HA

INTERNO INTERNAL

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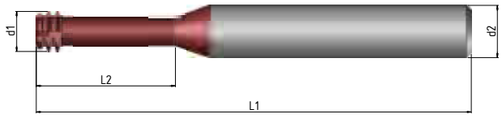
CUSTOMIZED DESIGN ON REQUEST

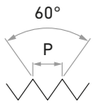


	ELICA SX - LH HELIX	ELICA SX - LH HELIX
TRATTAMENTO SUPERFICIALE SURFACE TREATMENT	Coated HDM ≥45 Hrc ≤66Hrc	Coated HDM ≥45 Hrc ≤66Hrc
MATERIALI LAVORABILI WORKING MATERIALS page 4D • 11	P1.1-P5.1 M1.1-M2.1 K1.1-K4.2 N1.1-N5.3 S1.1-S1.3 H1.1-H1.5	P1.1-P5.1 M1.1-M2.1 K1.1-K4.2 N1.1-N5.3 S1.1-S1.3 H1.1-H1.5

Filetto - Thread	(TPI)	d1	L1	L2	d2	Z		
1/8"	28	8.0	70	16.0	8.0	4	FIGGAWMICFOR01T	FIGGAWMICFOR01F
1/4"	19	10.0	80	20.0	10.0	4	FIGGAWMICFOR03T	FIGGAWMICFOR03F
3/8"	19	14.0	135	28.0	14.0	4	FIGGAWMICFOR05T	FIGGAWMICFOR05F
1/2"	14	16.0	135	32.0	16.0	4	FIGGAWMICFOR07T	FIGGAWMICFOR07F
5/8"	14	18.0	135	36.0	18.0	4	FIGGAWMICFOR09T	FIGGAWMICFOR09F
3/4"	14	20.0	135	40.0	20.0	4	FIGGAWMICFOR11T	FIGGAWMICFOR11F
7/8"	14	23.0	150	50.0	25.0	4	FIGGAWMICFOR13T	FIGGAWMICFOR13F
1"	11	25.0	150	50.0	25.0	4	FIGGAWMICFOR15T	FIGGAWMICFOR15F

THREAD MILLS FOR SIMULTANEOUS DRILLING AND THREADING

MICRO INT. 2xD

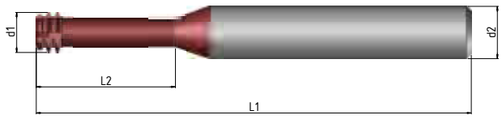


EG-UNC, EG-UNF

DIN 8140-2

ESECUZIONI SPECIALI A DISEGNO
CUSTOMIZED DESIGN ON REQUEST

VHM | R 0° | 2xD | LH | DIN 6535 HA | INTERNO INTERNAL

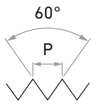


	ELICA SX - LH HELIX	ELICA SX - LH HELIX
TRATTAMENTO SUPERFICIALE / SURFACE TREATMENT	Coated HDM ≥45 Hrc ≤66Hrc	Coated HDM ≥45 Hrc ≤66Hrc
MATERIALI LAVORABILI / WORKING MATERIALS page 4D • 11	P1.1-P5.1	P1.1-P5.1
	M1.1-M2.1	M1.1-M2.1
	K1.1-K4.2	K1.1-K4.2
	N1.1-N5.3	N1.1-N5.3
	S1.1-S1.3	S1.1-S1.3
	H1.1-H1.5	H1.1-H1.5

Filetto - Thread	(TPI)	d1	L1	L2	d2	Z		
Nr. 4 EG-UNC	40	2.1	50	5.8	6.0	4	FIGEGUMICFOR01T	
Nr. 6 EG-UNC	32	2.55	50	7.2	6.0	4	FIGEGUMICFOR03T	
Nr. 8 EG-UNC	32	3.2	50	8.65	6.0	4	FIGEGUMICFOR05T	
Nr. 10 EG-UNC	24	3.50	70	9.7	6.0	4	FIGEGUMICFOR09T	
Nr. 10 EG-UNF	32	3.7	70	9.9	6.0	4	FIGEGUMICFOR11T	
1/4" EG-UNC	20	4.8	70	12.7	6.0	4	FIGEGUMICFOR15T	
1/4" EG-UNF	28	5.0	70	12.7	6.0	4	FIGEGUMICFOR17T	
5/16" EG-UNC	18	6.0	80	15.9	6.0	4	FIGEGUMICFOR19T	
5/16" EG-UNF	24	6.0	80	15.9	6.0	4	FIGEGUMICFOR21T	
3/8" EG-UNF	24	6.6	80	19.5	8.0	4	FIGEGUMICFOR22T	FIGEGUMICFOR22F
7/16" EG-UNC	14	7.70	80	22.2	8.0	4	FIGEGUMICFOR25T	FIGEGUMICFOR25F

THREAD MILLS FOR SIMULTANEOUS DRILLING AND THREADING

MICRO INT. 2,5xD



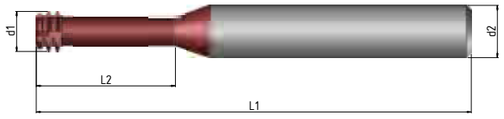
EG-UNC, EG-UNF

DIN 8140-2

ESECUZIONI SPECIALI A DISEGNO
CUSTOMIZED DESIGN ON REQUEST

VHM | R 0° | 2.5xD | LH | DIN 6535 HA | INTERNO INTERNAL

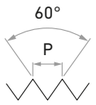
	ELICA SX - LH HELIX	ELICA SX - LH HELIX
TRATTAMENTO SUPERFICIALE SURFACE TREATMENT	Coated HDM ≥45 Hrc ≤66Hrc	Coated HDM ≥45 Hrc ≤66Hrc
MATERIALI LAVORABILI WORKING MATERIALS page 4D • 11	P1.1-P5.1 M1.1-M2.1 K1.1-K4.2 N1.1-N5.3 S1.1-S1.3 H1.1-H1.5	P1.1-P5.1 M1.1-M2.1 K1.1-K4.2 N1.1-N5.3 S1.1-S1.3 H1.1-H1.5



Filetto - Thread	(TPI)	d1	L1	L2	d2	Z		
Nr. 4 EG-UNC	40	2.1	50	7.25	6.0	4	FIGEGUMICFOR51T	
Nr. 6 EG-UNC	32	2.55	50	8.95	6.0	4	FIGEGUMICFOR53T	
Nr. 8 EG-UNC	32	3.2	50	10.6	6.0	4	FIGEGUMICFOR55T	
Nr. 10 EG-UNC	24	3.5	70	12.3	6.0	4	FIGEGUMICFOR59T	
Nr. 10 EG-UNF	32	3.7	70	12.3	6.0	4	FIGEGUMICFOR61T	
1/4" EG-UNC	20	4.8	70	16.2	6.0	4	FIGEGUMICFOR65T	
1/4" EG-UNF	28	5.0	70	16.2	6.0	4	FIGEGUMICFOR67T	
5/16" EG-UNC	18	6.0	80	20.25	6.0	4	FIGEGUMICFOR69T	
5/16" EG-UNF	24	6.0	80	20.25	6.0	4	FIGEGUMICFOR71T	
3/8" EG-UNF	24	6.6	80	24.3	8.0	4	FIGEGUMICFOR72T	FIGEGUMICFOR72F
7/16" EG-UNC	14	7.70	80	28.3	8.0	4	FIGEGUMICFOR75T	FIGEGUMICFOR75F

THREAD MILLS FOR SIMULTANEOUS DRILLING AND THREADING

MICRO INT. 3xD



EG-UNC, EG-UNF

DIN 8140-2

ESECUZIONI SPECIALI A DISEGNO
CUSTOMIZED DESIGN ON REQUEST

VHM

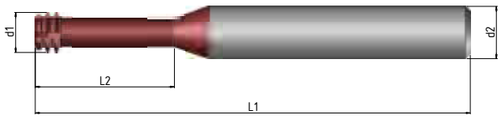
R 0°

3xD

LH

DIN 6535 HA

INTERNO INTERNAL

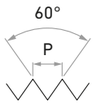


	ELICA SX - LH HELIX	ELICA SX - LH HELIX
TRATTAMENTO SUPERFICIALE SURFACE TREATMENT	Coated HDM ≥45 Hrc ≤66Hrc	Coated HDM ≥45 Hrc ≤66Hrc
MATERIALI LAVORABILI WORKING MATERIALS page 4D • 11	P1.1-P5.1 M1.1-M2.1 K1.1-K4.2 N1.1-N5.3 S1.1-S1.3 H1.1-H1.5	P1.1-P5.1 M1.1-M2.1 K1.1-K4.2 N1.1-N5.3 S1.1-S1.3 H1.1-H1.5

Filetto - Thread	(TPI)	d1	L1	L2	d2	Z		
Nr. 4 EG-UNC	40	2.1	50	8.7	6.0	4	FIGEGUMICFOR100T	
Nr. 6 EG-UNC	32	2.55	50	10.5	6.0	4	FIGEGUMICFOR102T	
Nr. 8 EG-UNC	32	3.2	50	12.6	6.0	4	FIGEGUMICFOR104T	
Nr. 10 EG-UNC	24	3.50	70	15	6.0	4	FIGEGUMICFOR108T	
Nr. 10 EG-UNF	32	3.7	70	14.7	6.0	4	FIGEGUMICFOR110T	
1/4" EG-UNC	20	4.8	70	19	6.0	4	FIGEGUMICFOR114T	
1/4" EG-UNF	28	5.0	70	15	6.0	4	FIGEGUMICFOR116T	
5/16" EG-UNC	18	6.0	80	24	6.0	4	FIGEGUMICFOR118T	
5/16" EG-UNF	24	6.0	80	24	6.0	4	FIGEGUMICFOR120T	
3/8" EG-UNF	24	6.6	80	29.05	8.0	4	FIGEGUMICFOR122T	FIGEGUMICFOR122F
7/16" EG-UNC	14	7.70	80	33.5	8.0	4	FIGEGUMICFOR124T	FIGEGUMICFOR124F

THREAD MILLS FOR SIMULTANEOUS DRILLING AND THREADING

MICRO INT. 2xD

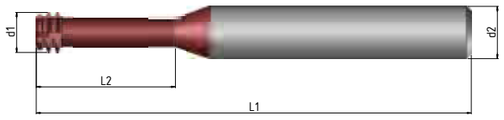


UNJC, UNJF

ASME B1.15

ESECUZIONI SPECIALI A DISEGNO
CUSTOMIZED DESIGN ON REQUEST

VHM | R 0° | 2xD | LH | DIN 6535 HA | INTERNO INTERNAL

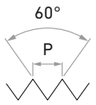


	ELICA SX - LH HELIX	ELICA SX - LH HELIX
TRATTAMENTO SUPERFICIALE SURFACE TREATMENT	Coated HDM ≥45 Hrc ≤66Hrc	Coated HDM ≥45 Hrc ≤66Hrc
MATERIALI LAVORABILI WORKING MATERIALS page 4D • 11	P1.1-P5.1 M1.1-M2.1 K1.1-K4.2 N1.1-N5.3 S1.1-S1.3 H1.1-H1.5	P1.1-P5.1 M1.1-M2.1 K1.1-K4.2 N1.1-N5.3 S1.1-S1.3 H1.1-H1.5

Filetto - Thread	(TPI)	d1	L1	L2	d2	Z		
Nr. 4 UNJC	40	2.10	50	5.8	6.0	4	FIGUNJMICFOR01T	
Nr. 6 UNJC	32	2.55	50	7.2	6.0	4	FIGUNJMICFOR03T	
Nr. 8 UNJC	32	3.2	50	8.55	6.0	4	FIGUNJMICFOR05T	
Nr. 8 UNJF	36	3.3	50	8.3	6.0	4	FIGUNJMICFOR07T	
Nr. 10 UNJC	24	3.5	70	9.7	6.0	4	FIGUNJMICFOR09T	
Nr. 10 UNJF	32	3.7	70	9.9	6.0	4	FIGUNJMICFOR11T	
Nr. 12 UNJF	28	4.2	70	11.25	6.0	4	FIGUNJMICFOR13T	
1/4" UNJC	20	4.8	70	12.7	6.0	4	FIGUNJMICFOR15T	
1/4" UNJF	28	5.0	70	12.7	6.0	4	FIGUNJMICFOR17T	
5/16" UNJC	18	6.0	80	15.9	6.0	4	FIGUNJMICFOR19T	
5/16" UNJF	24	6.0	80	15.9	6.0	4	FIGUNJMICFOR21T	
3/8" UNJC	16	6.7	80	19.1	8.0	4	FIGUNJMICFOR23T	FIGUNJMICFOR23F
7/16" UNJC	14	7.7	80	22.2	8.0	4	FIGUNJMICFOR25T	FIGUNJMICFOR25F
1/2" UNJC	13	9.2	80	25.4	10.0	4	FIGUNJMICFOR27T	FIGUNJMICFOR27F
9/16" UNJC	12	10.5	100	28.6	12.0	4	FIGUNJMICFOR29T	FIGUNJMICFOR29F
5/8" UNJC	11	11.4	100	31.8	12.0	4	FIGUNJMICFOR31T	FIGUNJMICFOR31F
3/4" UNJF	16	12.0	100	39.05	12.0	4	FIGUNJMICFOR33T	FIGUNJMICFOR33F

THREAD MILLS FOR SIMULTANEOUS DRILLING AND THREADING

MICRO INT. 2,5xD

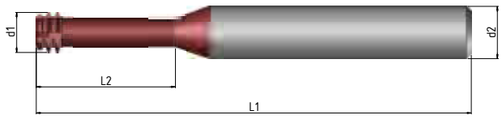


UNJC, UNJF

ASME B1.15

ESECUZIONI SPECIALI A DISEGNO
CUSTOMIZED DESIGN ON REQUEST

VHM | R 0° | 2.5xD | LH | DIN 6535 HA | INTERNO INTERNAL



	ELICA SX - LH HELIX	ELICA SX - LH HELIX
TRATTAMENTO SUPERFICIALE SURFACE TREATMENT	Coated HDM ≥45 Hrc ≤66Hrc	Coated HDM ≥45 Hrc ≤66Hrc
MATERIALI LAVORABILI WORKING MATERIALS page 4D • 11	P1.1-P5.1 M1.1-M2.1 K1.1-K4.2 N1.1-N5.3 S1.1-S1.3 H1.1-H1.5	P1.1-P5.1 M1.1-M2.1 K1.1-K4.2 N1.1-N5.3 S1.1-S1.3 H1.1-H1.5

Filetto - Thread	(TPI)	d1	L1	L2	d2	Z		
Nr. 4 UNJC	40	2.10	50	7.25	6.0	4	FIGUNJMICFOR51T	
Nr. 6 UNJC	32	2.55	50	8.95	6.0	4	FIGUNJMICFOR53T	
Nr. 8 UNJC	32	3.2	50	10.63	6.0	4	FIGUNJMICFOR55T	
Nr. 8 UNJF	36	3.3	50	10.4	6.0	4	FIGUNJMICFOR57T	
Nr. 10 UNJC	24	3.5	70	12.1	6.0	4	FIGUNJMICFOR59T	
Nr. 10 UNJF	32	3.7	70	12.3	6.0	4	FIGUNJMICFOR61T	
Nr. 12 UNJF	28	4.2	70	14	6.0	4	FIGUNJMICFOR63T	
1/4" UNJC	20	4.8	70	15.9	6.0	4	FIGUNJMICFOR65T	
1/4" UNJF	28	5.0	70	15.9	6.0	4	FIGUNJMICFOR67T	
5/16" UNJC	18	6.0	80	19.8	6.0	4	FIGUNJMICFOR69T	
5/16" UNJF	24	6.0	80	19.8	6.0	4	FIGUNJMICFOR71T	
3/8" UNJC	16	6.7	80	23.8	8.0	4	FIGUNJMICFOR73T	FIGUNJMICFOR73F
7/16" UNJC	14	7.7	80	27.8	8.0	4	FIGUNJMICFOR75T	FIGUNJMICFOR75F
1/2" UNJC	13	9.2	80	31.8	10.0	4	FIGUNJMICFOR77T	FIGUNJMICFOR77F
9/16" UNJC	12	10.5	100	35.7	12.0	4	FIGUNJMICFOR79T	FIGUNJMICFOR79F
5/8" UNJC	11	11.4	100	39.7	12.0	4	FIGUNJMICFOR81T	FIGUNJMICFOR81F
3/4" UNJF	16	12.0	100	48.6	12.0	4	FIGUNJMICFOR83T	FIGUNJMICFOR83F

THREAD MILLS FOR SIMULTANEOUS DRILLING AND THREADING

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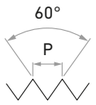
MICRO INT. 3xD



UNJC, UNJF

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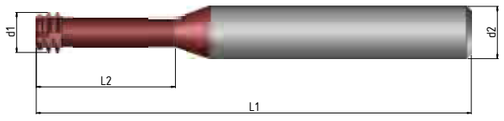
CUSTOMIZED DESIGN ON REQUEST

VHM | R 0° | 3xD | LH | DIN 6535 HA | INTERNO INTERNAL



	ELICA SX - LH HELIX	ELICA SX - LH HELIX
TRATTAMENTO SUPERFICIALE SURFACE TREATMENT	Coated HDM ≥45 Hrc ≤66Hrc	Coated HDM ≥45 Hrc ≤66Hrc
MATERIALI LAVORABILI WORKING MATERIALS page 4D • 11	P1.1-P5.1 M1.1-M2.1 K1.1-K4.2 N1.1-N5.3 S1.1-S1.3 H1.1-H1.5	P1.1-P5.1 M1.1-M2.1 K1.1-K4.2 N1.1-N5.3 S1.1-S1.3 H1.1-H1.5

Filetto - Thread	(TPI)	d1	L1	L2	d2	Z		
Nr. 4 UNJC	40	2.10	50	8.7	6.0	4	FIGUNJMICFOR100T	
Nr. 6 UNJC	32	2.55	50	10.7	6.0	4	FIGUNJMICFOR102T	
Nr. 8 UNJC	32	3.2	50	12.7	6.0	4	FIGUNJMICFOR104T	
Nr. 8 UNJF	36	3.3	50	12.7	6.0	4	FIGUNJMICFOR106T	
Nr. 10 UNJC	24	3.5	70	14.7	6.0	4	FIGUNJMICFOR108T	
Nr. 10 UNJF	32	3.7	70	14.7	6.0	4	FIGUNJMICFOR110T	
Nr. 12 UNJF	28	4.2	70	16.75	6.0	4	FIGUNJMICFOR112T	
1/4" UNJC	20	4.8	70	19.4	6.0	4	FIGUNJMICFOR114T	
1/4" UNJF	28	5.0	70	19.4	6.0	4	FIGUNJMICFOR116T	
5/16" UNJC	18	6.0	80	24.2	6.0	4	FIGUNJMICFOR118T	
5/16" UNJF	24	6.0	80	24.2	6.0	4	FIGUNJMICFOR120T	
3/8" UNJC	16	6.7	80	29.05	8.0	4	FIGUNJMICFOR122T	FIGUNJMICFOR122F
7/16" UNJC	14	7.7	80	33.9	8.0	4	FIGUNJMICFOR124T	FIGUNJMICFOR124F
1/2" UNJC	13	9.2	80	38.75	10.0	4	FIGUNJMICFOR126T	FIGUNJMICFOR126F
9/16" UNJC	12	10.5	100	43.6	12.0	4	FIGUNJMICFOR128T	FIGUNJMICFOR128F
5/8" UNJC	11	11.4	100	48.45	12.0	4	FIGUNJMICFOR130T	FIGUNJMICFOR130F
3/4" UNJF	16	12.0	100	58.1	12.0	4	FIGUNJMICFOR132T	FIGUNJMICFOR132F

THREAD MILLS FOR SIMULTANEOUS DRILLING AND THREADING

MICRO INT. 2xD

MJ

DIN ISO 5855

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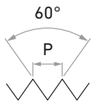
CUSTOMIZED DESIGN ON REQUEST



VHM

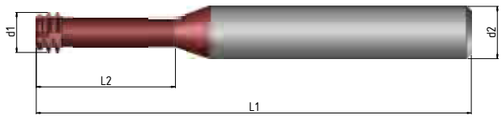
R 0°

2xD

LH

DIN 6535 HA

INTERNO
INTERNAL

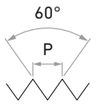


	ELICA SX - LH HELIX	ELICA SX - LH HELIX
TRATTAMENTO SUPERFICIALE SURFACE TREATMENT	Coated HDM ≥45 Hrc ≤66Hrc	Coated HDM ≥45 Hrc ≤66Hrc
MATERIALI LAVORABILI WORKING MATERIALS page 4D • 11	P1.1-P5.1 M1.1-M2.1 K1.1-K4.2 N1.1-N5.3 S1.1-S1.3 H1.1-H1.5	P1.1-P5.1 M1.1-M2.1 K1.1-K4.2 N1.1-N5.3 S1.1-S1.3 H1.1-H1.5

Filetto - Thread	Pitch mm	d1	L1	L2	d2	Z		
MJ 4	0.70	3.1	50	7.0	6.0	4	FIGMJMICFOR01T	
MJ 5	0.80	3.8	50	8.5	6.0	4	FIGMJMICFOR03T	
MJ 6	1.00	4.6	50	10.0	6.0	4	FIGMJMICFOR05T	
MJ 8	1.00	6.2	70	15.0	8.0	4	FIGMJMICFOR07T	FIGMJMICFOR07F
MJ 8	1.25	6.2	70	15.0	8.0	4	FIGMJMICFOR09T	FIGMJMICFOR09F
MJ 10	1.00	7.5	70	20.0	8.0	4	FIGMJMICFOR11T	FIGMJMICFOR11F
MJ 10	1.25	7.5	70	20.0	8.0	4	FIGMJMICFOR13T	FIGMJMICFOR13F
MJ 10	1.50	7.5	70	20.0	8.0	4	FIGMJMICFOR15T	FIGMJMICFOR15F
MJ 12	1.00	9.0	80	25.0	10.0	4	FIGMJMICFOR17T	FIGMJMICFOR17F
MJ 12	1.25	9.0	80	25.0	10.0	4	FIGMJMICFOR19T	FIGMJMICFOR19F
MJ 12	1.50	9.0	80	25.0	10.0	4	FIGMJMICFOR21T	FIGMJMICFOR21F
MJ 12	1.75	9.0	80	25.0	10.0	4	FIGMJMICFOR23T	FIGMJMICFOR23F
MJ 16	1.50	11.5	100	30.0	12.0	4	FIGMJMICFOR25T	FIGMJMICFOR25F
MJ 16	2.00	11.5	100	30.0	12.0	4	FIGMJMICFOR27T	FIGMJMICFOR27F
MJ 18	1.50	14.0	135	40.0	14.0	4	FIGMJMICFOR29T	FIGMJMICFOR29F
MJ 18	2.50	14.0	135	40.0	14.0	4	FIGMJMICFOR31T	FIGMJMICFOR31F
MJ 20	1.50	15.0	135	45.0	16.0	4	FIGMJMICFOR33T	FIGMJMICFOR33F
MJ 20	2.50	15.0	135	45.0	16.0	4	FIGMJMICFOR35T	FIGMJMICFOR35F

THREAD MILLS FOR SIMULTANEOUS DRILLING AND THREADING

MICRO INT. 2.5xD



VHM

R 0°

2.5xD

LH

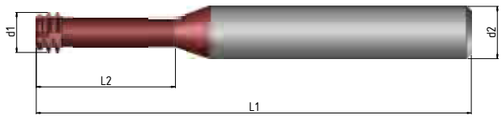
DIN 6535 HA

INTERNO INTERNAL

MJ

DIN ISO 5855

ESECUZIONI SPECIALI A DISEGNO
CUSTOMIZED DESIGN ON REQUEST



	ELICA SX - LH HELIX	ELICA SX - LH HELIX
TRATTAMENTO SUPERFICIALE SURFACE TREATMENT	Coated HDM ≥45 Hrc ≤66Hrc	Coated HDM ≥45 Hrc ≤66Hrc
MATERIALI LAVORABILI WORKING MATERIALS page 4D • 11	P1.1-P5.1 M1.1-M2.1 K1.1-K4.2 N1.1-N5.3 S1.1-S1.3 H1.1-H1.5	P1.1-P5.1 M1.1-M2.1 K1.1-K4.2 N1.1-N5.3 S1.1-S1.3 H1.1-H1.5

Filetto - Thread	Pitch mm	d1	L1	L2	d2	Z		
MJ 4	0.70	3.1	50	10.0	6.0	4	FIGMJMICFOR50T	
MJ 5	0.80	3.8	50	12.5	6.0	4	FIGMJMICFOR52T	
MJ 6	1.00	4.6	50	15.0	6.0	4	FIGMJMICFOR54T	
MJ 8	1.00	6.2	70	20.0	8.0	4	FIGMJMICFOR56T	FIGMJMICFOR56F
MJ 8	1.25	6.2	70	20.0	8.0	4	FIGMJMICFOR58T	FIGMJMICFOR58F
MJ 10	1.00	7.5	70	25.0	8.0	4	FIGMJMICFOR60T	FIGMJMICFOR60F
MJ 10	1.25	7.5	70	25.0	8.0	4	FIGMJMICFOR62T	FIGMJMICFOR62F
MJ 10	1.50	7.5	70	25.0	8.0	4	FIGMJMICFOR64T	FIGMJMICFOR64F
MJ 12	1.00	9.0	80	30.0	10.0	4	FIGMJMICFOR66T	FIGMJMICFOR66F
MJ 12	1.25	9.0	80	30.0	10.0	4	FIGMJMICFOR68T	FIGMJMICFOR68F
MJ 12	1.50	9.0	80	30.0	10.0	4	FIGMJMICFOR70T	FIGMJMICFOR70F
MJ 12	1.75	9.0	80	30.0	10.0	4	FIGMJMICFOR72T	FIGMJMICFOR72F
MJ 16	1.50	11.5	100	40.0	12.0	4	FIGMJMICFOR74T	FIGMJMICFOR74F
MJ 16	2.00	11.5	100	40.0	12.0	4	FIGMJMICFOR76T	FIGMJMICFOR76F
MJ 18	1.50	14.0	135	45.0	14.0	4	FIGMJMICFOR78T	FIGMJMICFOR78F
MJ 18	2.50	14.0	135	45.0	14.0	4	FIGMJMICFOR80T	FIGMJMICFOR80F
MJ 20	1.50	15.0	135	50.0	16.0	4	FIGMJMICFOR82T	FIGMJMICFOR82F
MJ 20	2.50	15.0	135	50.0	16.0	4	FIGMJMICFOR84T	FIGMJMICFOR84F

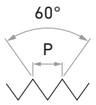
THREAD MILLS FOR SIMULTANEOUS DRILLING AND THREADING

MICRO INT. 3xD

MJ

DIN ISO 5855

ESECUZIONI SPECIALI A DISEGNO
CUSTOMIZED DESIGN ON REQUEST



VHM

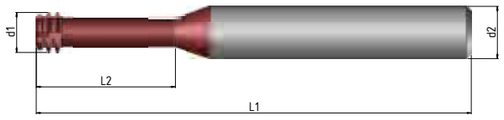
R 0°

3xD

LH

DIN 6535 HA

INTERNO INTERNAL



	ELICA SX - LH HELIX	ELICA SX - LH HELIX
TRATTAMENTO SUPERFICIALE SURFACE TREATMENT	Coated HDM ≥45 Hrc ≤66Hrc	Coated HDM ≥45 Hrc ≤66Hrc
MATERIALI LAVORABILI WORKING MATERIALS page 4D • 11	P1.1-P5.1 M1.1-M2.1 K1.1-K4.2 N1.1-N5.3 S1.1-S1.3 H1.1-H1.5	P1.1-P5.1 M1.1-M2.1 K1.1-K4.2 N1.1-N5.3 S1.1-S1.3 H1.1-H1.5

Filetto - Thread	Pitch mm	d1	L1	L2	d2	Z		
MJ 4	0.70	3.1	50	12.2	6.0	4	FIGMJMICFOR100T	
MJ 5	0.80	3.8	50	15.25	6.0	4	FIGMJMICFOR102T	
MJ 6	1.00	4.6	50	18.3	6.0	4	FIGMJMICFOR104T	
MJ 8	1.00	6.2	70	24.4	8.0	4	FIGMJMICFOR106T	FIGMJMICFOR106F
MJ 8	1.25	6.2	70	24.4	8.0	4	FIGMJMICFOR108T	FIGMJMICFOR108F
MJ 10	1.00	7.5	70	30.5	8.0	4	FIGMJMICFOR110T	FIGMJMICFOR110F
MJ 10	1.25	7.5	70	30.5	8.0	4	FIGMJMICFOR112T	FIGMJMICFOR112F
MJ 10	1.50	7.5	70	30.5	8.0	4	FIGMJMICFOR114T	FIGMJMICFOR114F
MJ 12	1.00	9.0	80	36.6	10.0	4	FIGMJMICFOR116T	FIGMJMICFOR116F
MJ 12	1.25	9.0	80	36.6	10.0	4	FIGMJMICFOR118T	FIGMJMICFOR118F
MJ 12	1.50	9.0	80	36.6	10.0	4	FIGMJMICFOR120T	FIGMJMICFOR120F
MJ 12	1.75	9.0	80	36.6	10.0	4	FIGMJMICFOR122T	FIGMJMICFOR122F
MJ 16	1.50	11.5	100	48.8	12.0	4	FIGMJMICFOR124T	FIGMJMICFOR124F
MJ 16	2.00	11.5	100	48.8	12.0	4	FIGMJMICFOR126T	FIGMJMICFOR126F
MJ 18	1.50	14.0	135	54.9	14.0	4	FIGMJMICFOR128T	FIGMJMICFOR128F
MJ 18	2.50	14.0	135	54.9	14.0	4	FIGMJMICFOR130T	FIGMJMICFOR130F
MJ 20	1.50	15.0	135	61	16.0	4	FIGMJMICFOR132T	FIGMJMICFOR132F
MJ 20	2.50	15.0	135	61	16.0	4	FIGMJMICFOR134T	FIGMJMICFOR134F

THREAD MILLS FOR SIMULTANEOUS DRILLING AND THREADING

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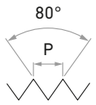
INT/EXT 2xD

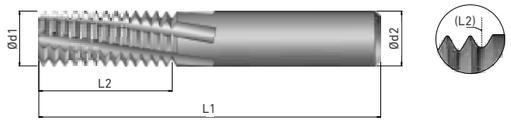


Pg

DIN 4030

ESECUZIONI SPECIALI A DISEGNO
CUSTOMIZED DESIGN ON REQUEST

VHM | e8 | 2xD
R 10° | RH-LH
DIN 6535 HA
INTERNO INTERNAL | ESTERNO EXTERNAL



	ELICA DX - RH HELIX	ELICA DX - RH HELIX
TRATTAMENTO SUPERFICIALE SURFACE TREATMENT	Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc
MATERIALI LAVORABILI WORKING MATERIALS page 4D • 3	P1.1-P5.1 K1.1-K4.2 N1.1-N1.5 N2.1-N2.6 N3.1-N4.2 S1.1-S1.3	P1.1-P5.1 M1.1-M4.1 N1.1-N5.2 S1.1-S2.6 H1.1-H1.2

Filetto - Thread	(TPI)	d1	L1	L2	d2	Z		
PG 7	20	8.0	65	20	8.0	3	FIGPG01N	FIGPG01T
PG 9-11-13.5-16	18	10.0	80	25	10.0	4	FIGPG03N	FIGPG03T
PG 21-29-36-42-48	16	12.0	82	30	12.0	4	FIGPG05N	FIGPG05T

	ELICA DX - RH HELIX	ELICA DX - RH HELIX
	Uncoated ≤45 Hrc	Coated TNF ≤45 Hrc
	P1.1-P5.1 K1.1-K4.2 N1.1-N1.5 N2.1-N2.6 N3.1-N4.2 S1.1-S1.3	P1.1-P5.1 M1.1-M4.1 N1.1-N5.2 S1.1-S2.6 H1.1-H1.2

FIGPG01NF	FIGPG01F
FIGPG03NF	FIGPG03F
FIGPG05NF	FIGPG05F

FIL

PREFORI
PRE-HOLES

FIL

M

Filettatura metrica ISO a passo grosso
Coarse metric ISO thread

d1	Pitch	Preforo
M1	0,25	0,75
M1,1	0,25	0,85
M1,2	0,25	0,95
M1,4	0,3	1,1
M1,6	0,35	1,25
M(1,7)	0,35	1,3
M1,8	0,35	1,45
M2	0,4	1,9
M2,2	0,45	1,75
M(2,3)	0,4	1,9
M2,5	0,45	2,05
M(2,6)	0,45	2,1
M3	0,5	2,5
M3,5	0,6	2,9
M4	0,7	3,3
M4,5	0,75	3,7
M5	0,8	4,2
M6	1	5
M7	1	6
M8	1,25	6,8
M9	1,25	7,8
M10	1,5	8,5
M11	1,5	9,5
M12	1,75	10,2
M14	2	12
M16	2	14
M18	2,5	15,5
M20	2,5	17,5
M22	2,5	19,5
M24	3	21
M27	3	24
M30	3,5	26,5

MF

Filettatura metrica ISO a passo fine
Fine metric ISO thread

d1	Pitch	Preforo
M3	0,35	2,65
M3,5	0,35	3,15
M4	0,35	3,65
M4	0,5	3,5
M5	0,5	4,5
M6	0,5	5,5
M6	0,75	5,2
M7	0,75	6,2
M8	0,5	7,5
M8	1	7
M9	1	8
M10	0,5	9,5
M10	0,75	9,2
M10	1	9
M10	1,25	8,8
M11	1	10
M12	0,75	11,2
M12	1	11
M12	1,25	10,8
M12	1,5	10,5
M13	1	12
M13	1,5	11,5
M14	1	13
M14	1,25	12,8
M14	1,5	12,5
M15	1	14
M15	1,5	13,5
M16	1	15
M16	1,5	14,5
M18	1	17
M18	1,5	16,5
M18	2	16
M20	1	19
M20	1,5	18,5
M20	2	18

UNC

Filettatura americana a passo grosso
Coarse american thread

d1	Pitch	Preforo
Nr. 1	64"	1,5
Nr. 2	56"	1,8
Nr. 3	48"	2,1
Nr. 4	40"	2,25
Nr. 5	40"	2,6
Nr. 6	32"	2,75
Nr. 8	32"	3,5
Nr. 10	24"	3,9
Nr. 12	24"	4,5
1/4	20"	5,1
5/16	18"	6,6
3/8	16"	8
7/16	14"	9,4
1/2	13"	10,75
9/16	12"	12,2
5/8	11"	13,5
3/4	10"	16,5
7/8	9"	19,5
1	8"	22,25
1 1/8	7"	25
1 1/4	7"	28
1 3/8	6"	30,75
1 1/2	6"	34

UNF

Filettatura americana a passo fine
Fine american thread

d1	Pitch	Preforo
Nr. 0	80"	1,25
Nr. 1	72"	1,55
Nr. 2	64"	1,85
Nr. 3	56"	2,15
Nr. 4	48"	2,35
Nr. 5	44"	2,7
Nr. 6	40"	2,95
Nr. 8	36"	3,5
Nr. 10	32"	4,1
Nr. 12	28"	4,6
1/4	28"	5,5
5/16	24"	6,9
3/8	24"	8,5
7/16	20"	9,9
1/2	20"	11,5
9/16	18"	12,9
5/8	18"	14,5
3/4	16"	17,5
7/8	14"	20,4
1	12"	23,25
1 1/8	12"	26,5
1 1/4	12"	29,5
1 3/8	12"	32,75

UNEF

Filettatura americana a passo extra fine
Extra fine american thread

d1	Pitch	Preforo
1/4	32"	5,55
5/16	32"	7,15
3/8	32"	8,7
7/16	28"	10,2
1/2	28"	11,8
9/16	24"	13,2
5/8	24"	14,8
11/16	24"	16,4
3/4	20"	17,8
7/8	20"	20,95
1	20"	24,2

G (BSP)

Filettatura per tubazione
British standard pipe

d1	Pitch	Preforo
1/16	28"	6,8
1/8	28"	8,8
1/4	19"	11,8
3/8	19"	15,25
1/2	14"	19
5/8	14"	21
3/4	14"	24,5
7/8	14"	28,25
1	11"	30,75

FIL

PREFORI
PRE-HOLES

W (BSW)

Filettatura whitworth BSW
BSW whitworth thread

d1	Pitch	Preforo
3/32	48"	1,8
1/8	40"	2,55
5/32	32"	3,1
3/16	24"	3,6
7/32	24"	4,4
1/4	202	5,1
5/16	182	6,5
3/8	16"	7,9
7/16	14"	9,25
1/2	12"	10,5
9/16	12"	12
5/8	11"	13,5
3/4	10"	16,5
7/8	9"	19,25
1	8"	21,75
1 1/8	7"	24,75
1 1/4	7"	27,75
1 3/8	6"	30,5

NTP

Filettatura gas conica americana
American conical gas thread

d1	Pitch	Preforo
1/16	27"	6,3
1/8	27"	8,5
1/4	18"	11
3/8	18"	14,5
1/2	14"	18
3/4	14"	23
1	11,5"	29
1 1/4	11,5"	38
1 1/2	11,5"	44
2	11,5"	56
2 1/2	8"	67
3	8"	83

EGM

Filettatura filetti riportati
Threading heli-coil thread

d1	Pitch	Preforo
2,5	0,45	2,6
3	0,5	3,2
3,5	0,6	3,7
4	0,7	4,2
5	0,8	5,2
6	1	6,3
8	1,25	8,4
10	1,5	10,5
12	1,75	12,5
14	2	14,5
16	2	16,5
18	2,5	18,75
20	2,5	20,75
22	2,5	22,75
24	3	24,75

PG

Filettatura per tubi corazzati
Threading for armored pipes

d1	Pitch	Preforo
7	20"	11,45-11,4
9	18"	14,01-14
11	18"	17,41-17,25
13,5	18"	19,21-19
16	18"	21,31-21,25
21	16"	27,03-26,75
29	16"	35,73-33,5
36	16"	45,73-45,5
42	16"	52,73-52,5
48	16"	58,03-57,8

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FIL