



EMUGE

High Performance Tools
Threading Technology · Clamping Technology



Thread Cutting Technology · Clamping Technology

CATALOG 520

Welcome to our **EMUGE Catalog 520**. Let our new catalog be your guide on a trip to the very leading edge of thread cutting technology and into the twenty-first century!

At **EMUGE** we are dedicated to exhaustive research and development, product manufacturing excellence, and unsurpassed customer service. We have introduced more new and innovative products recently than ever before in our history. These, in combination with our standard lines, comprise the most comprehensive and technologically advanced thread and cutting tool product line in the world.

EMUGE Tools are designed and engineered for use today... and in future. Whether your application requirements are general purpose or high tech, we can find the right thread cutting solution for you.

We can recommend the appropriate tool, monitor initial product tests, provide installation assistance, and offer product support services through-out our relationship with you. That promises to be a very long time because our customer relationship tend to be a long term. We're proud of that.

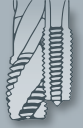



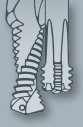
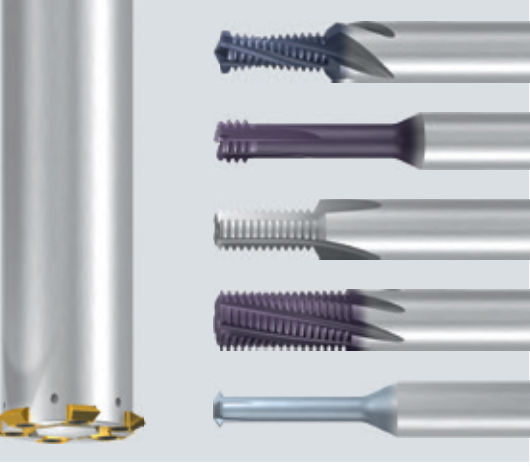
*We have a slogan —
EMUGE Finds Success In Yours.
Let's work together for that success.*

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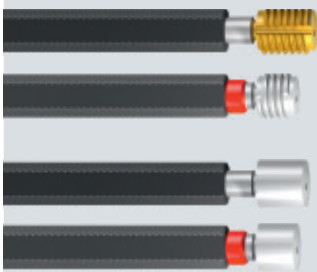
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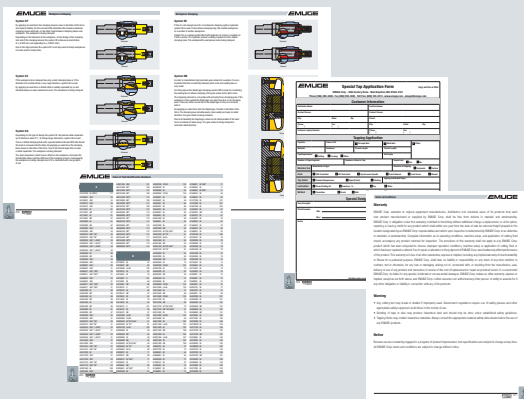
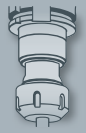
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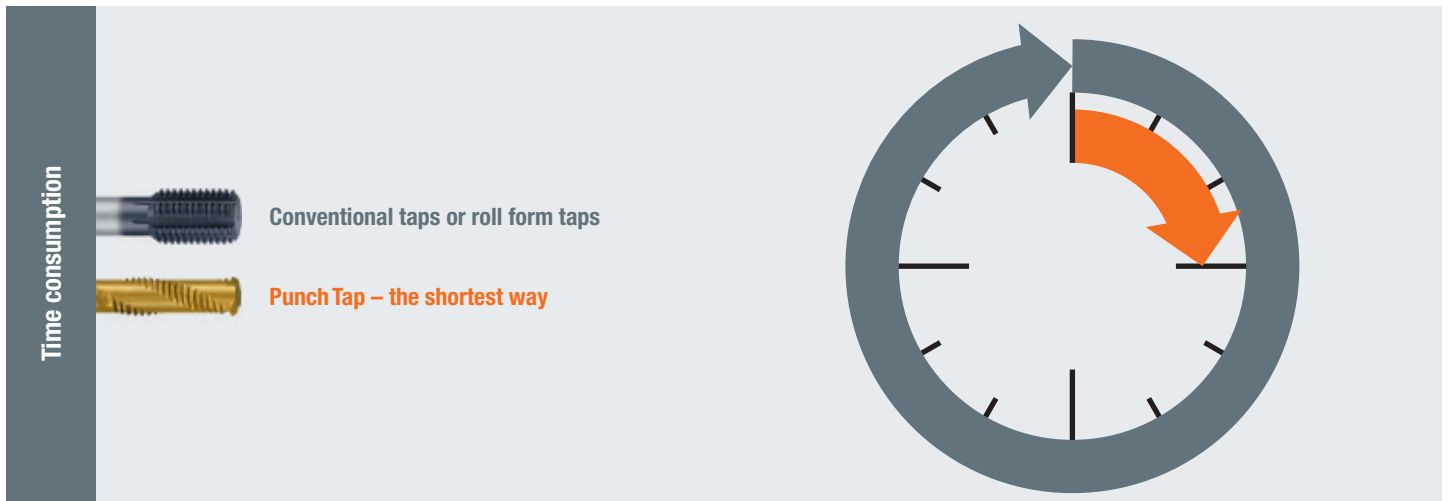
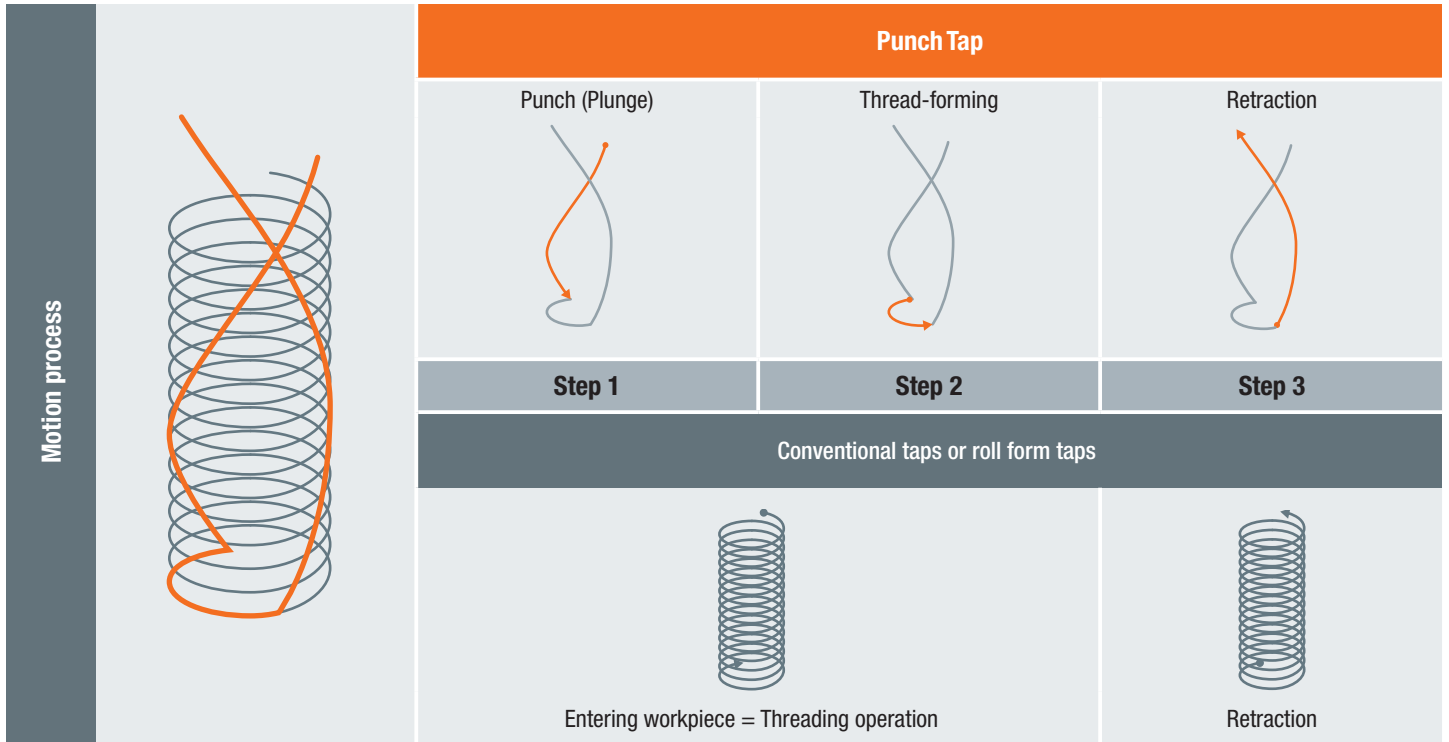
The EMUGE Punch Tap for thread production in Aluminum and similar materials is a faster alternative for mass production environments. Thanks to its innovative, very short motion process, it establishes an entirely new dimension of productivity.

A comparison between the tool path of the EMUGE Punch Tap with the tool path of conventional taps or roll form taps shows that the path of the Punch Tap is approximately 15 times shorter for a thread M6 with thread depth of 15 mm.

The result is a significant time savings of up to 75% in a threading cycle.

Contact Emuge for more information about this revolutionary concept.





Result The EMUGE Punch Tap achieves a time saving of up to 75% in a threading cycle thanks to its shorter tool paths.

American units into SI units			SI units into American units		
Length					
1 inch (in)	= 25.4 mm	= 2.54 cm	1 millimeter (mm)	= 0.03937 in	
1 foot (ft)	= 12 in	= 0.3048 m	1 centimeter (cm)	= 10 mm	= 0.3937 in
1 yard (yd)	= 3 ft	= 0.9144 m	1 meter (m)	= 100 cm = 3.2808 ft = 1.0936 yd	
1 statute mile	= 1760 yd	= 1.60934 km	1 kilometer (km)	= 1000 m	= 0.62137 statute mile
Area					
1 in ²	= 645.16 mm ²	= 6.4516 cm ²	1 mm ²	= 0.00155 in ²	
1 ft ²	= 144 in ²	= 0.0929 m ²	1 cm ²	= 100 mm ²	= 0.155 in ²
1 yd ²	= 9 ft ²	= 0.8361 m ²	1 m ²	= 10000 cm ² = 10.7642 ft ² = 1.196 yd ²	
1 mile ²		= 2.590 km ²	1 km ²	= 10 ⁶ m ²	= 0.3861 mile ²
Volume					
1 in ³	= 16387.064 mm ³	= 16.387 cm ³	1 mm ³	= 0.000061 in ³	
1 ft ³	= 1728 in ³	= 0.0283 m ³	1 cm ³	= 1000 mm ³	= 0.0610 in ³
1 yd ³	= 27 ft ³	= 0.765 m ³	1 m ³	= 10 ⁶ cm ³ = 35.3146 ft ³ = 1.3080 yd ³	
1 Quart / US	= 1/4 gal	= 0.946 l	1 Liter (l)	= 1 dm ³ = 0.2642 gal / US = 2.11 US pt	
1 gallon (gal) / US	= 4 quarts	= 3.784 l	1 l	= 1.761 UK pt	
1 gallon (gal) / UK		= 4.546 l			
1 US pint (pt)	= 0.8327 UK pt	= 0.473 l			
1 UK pt	= 1.201 US pt	= 0.568 l			
1 barrel / US (Oil)	= 42 gal	= 158.98 l			
1 barrel / UK	= 36 gal	= 163.66 l			
Weight					
1 ounce (oz)	= 16 drams	= 28.35 g	1 gram (g)	= 0.03527 oz	
1 pound (lb)	= 16 oz	= 453.592 g	1 kilogram (kg)	= 1000 g	= 2.20462 lb
1 short ton / US		= 0.907 t	1 ton (t)	= 1000 kg	= 1.1025 short tons / US
1 long ton / UK		= 1.016 t	1 ton (t)	= 1000 kg	= 0.984 long tons / UK
Force					
1 pound force (lbf)	= 4.448 N		1 Newton (N)	= 0.2248 lbf	
Pressure/Tensile strength					
1 lbf/ft ²		= 47.8803 Pa	1 Pascal (Pa)	= 10 ⁶ N/mm ²	= 0.02089 lbf/ft ²
1 lbf/in ²	= 6.89476 kPa	= 6.895 · 10 ⁻³ N/mm ²	1 N/mm ²	= 0.1 bar	= 145 psi
1 psi (pound-force per sq.in)	= lbwt/in ²	= 6.895 · 10 ⁻³ N/mm ²	1 bar	= 10 N/mm ²	= 14.5 psi
1 psi		= 6.895 · 10 ⁻² bar			
Power					
1 foot-pounds per second (ft lb/s)		= 1.356 W	1 Watt (W)	= 1 J/s = 1 Nm/s	= 0.7376 ft lb/s
Energy/Torque					
1 foot pound-force (ft-lbf)		= 1.356 J	1 Joule (J)	= 1 Nm	= 0.7376 ft lb
Cutting/Circumferential speed					
1 surface feet per minute (SFM)		= 0.3048 m/min	1 m/min		= 3.2808 SFM
Cutting/Circumferential speed					
in degree Fahrenheit (°F)		= 9/5 Temp.[°C]+32	in degree Celsius (°C)		= (Temp.[°F]-32) · 5/9



Taps

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Product Finder

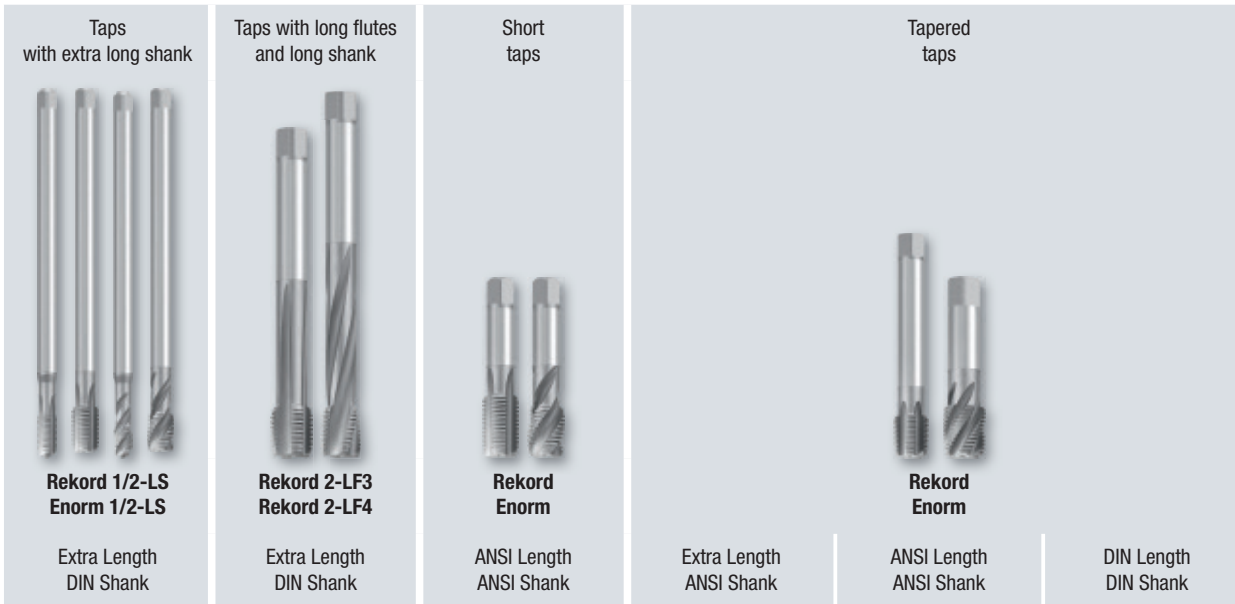
- V_c
- UNC
- UNF
- UNEF
- UN-8
- M
- MF
- NPSM/NPSC
- NPSF
- Rp (BSPP)
- G
- NPT
- NPTF
- Rc (BSPT)
- STI
- SELF-LOCK
- Accessories
- Tech. Info



Taps with reinforced shank		Taps with reduced shank		Taps with internal chip collector	
Rekord 1 Enorm 1		Rekord 2 Enorm 2		Robust 2X	
DIN Length ANSI Shank	DIN Length DIN Shank	DIN Length ANSI Shank	DIN Length DIN Shank	DIN Length ANSI Shank	DIN Length DIN Shank

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						UN-8
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						NPSM/NPSC
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						Rp (BSPP)
						G
			107 - 108	109 - 111		NPT
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					116 - 117	Rc (BSPT)
						STI-UNC
						STI-UNF
						STI-M
						LK-UNC
						LK-UNF
						LK-M

Product Finder

- Vc
- UNC
- UNF
- UNEF
- UN-8
- M
- MF
- NPSM/NPSC
- NPSF
- Rp (BSPP)
- G
- NPT
- NPTF
- Rc (BSPT)
- STI
- SELF-LOCK

Accessories

Tech. Info

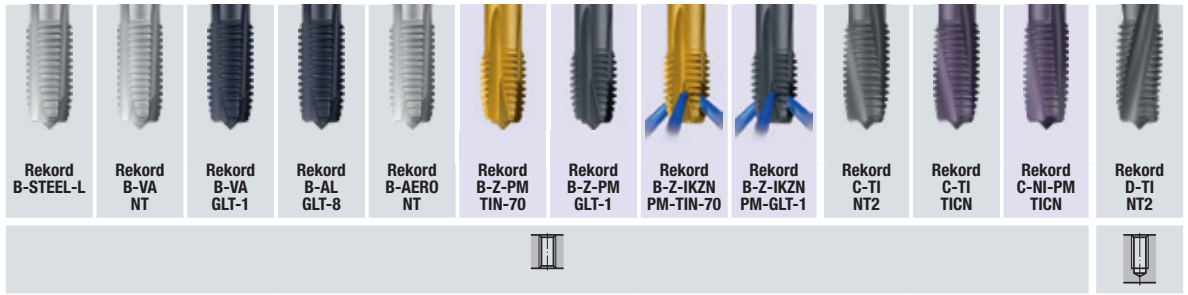


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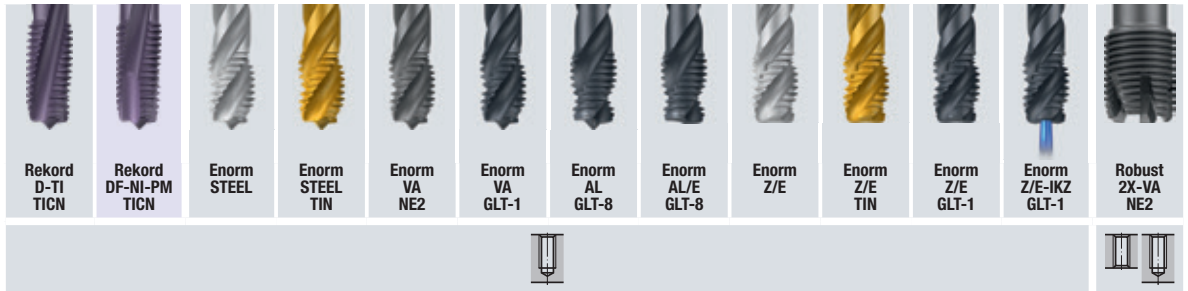
EMUGE Taps with Special Tolerance

- Product Finder
- V_c
- UNC
- UNF
- UNEF
- UN-8
- M
- MF
- NPSM/NPSC
- NPSF
- Rp (BSPP)
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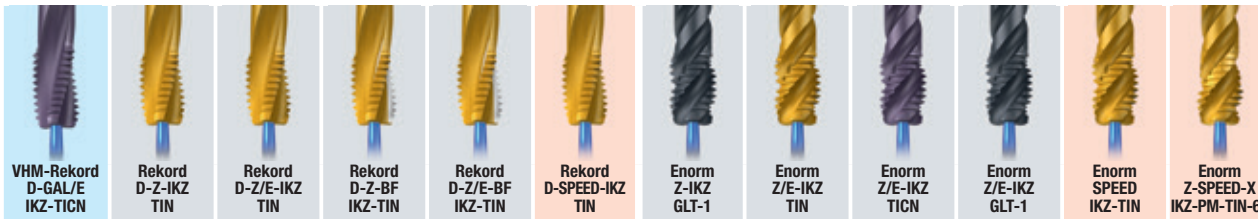
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												110	NPT
												114	NPTF

- Product Finder
- V_c
- UNC
- UNF
- UNEF
- UN-8
- M
- MF
- NPSM/NPSC
- NPSF
- Rp (BSPP)
- G
- NPT
- NPTF
- Rc (BSPT)
- STI
- SELF-LOCK
- Accessories
- Tech. Info

EMUGE
AL

EMUGE
GAL

EMUGE
PVC

AERO

EMUGE
TI



	Rekord B-AL GLT-8	Enorm AL GLT-8	Enorm AL/E GLT-8	Rekord A-GAL/E IKZ-TiCN	Rekord A-GAL/E IKZN-TiCN	Rekord D-GAL/E IKZ-TiCN	VHM-Rekord D-GAL/E IKZ-TiCN	Rekord D-PVC/E CRN	Rekord B-AERO NT	Rekord C-Ti NT2	Rekord C-Ti TiCN	Rekord D-Ti NT2	Rekord D-Ti TiCN
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	B / approx. 3	C / 2-3	E / 1.5-2	E / 1.5-2	E / 1.5-2	E / 1.5-2	E / 1.5-2	E / 1.5-2	B / approx. 3	D / 4-5	D / 4-5	C / 2-3	C / 2-3
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Thread Depth and Hole Type	max. 3 x d ₁			max. 2.5 x d ₁		max. 2 x d ₁		max. 2 x d ₁		max. 3 x d ₁		max. 2 x d ₁	

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	2.1												
	3.1												
	4.1									7 - 33	16 - 66	7 - 33	16 - 66
	5.1									3 - 16	7 - 33	3 - 16	7 - 33

M	1.1												
	2.1												
	3.1												
	4.1								7 - 33	3 - 26	16 - 49	3 - 26	16 - 49

K	1.1												
	1.2												
	2.1												
	2.2												
	3.1												
	3.2												
	4.1												
	4.2												

N	1.1	49 - 131	49 - 131	49 - 131									
	1.2	49 - 131	49 - 131	49 - 131									
	1.3	49 - 131	49 - 131	49 - 131									
	1.4	49 - 131	49 - 131	49 - 131	49 - 131	49 - 131	49 - 131	131 - 262					
	1.5				49 - 131	49 - 131	49 - 131	131 - 262					
	1.6				33 - 98	33 - 98	33 - 98	98 - 197					

N	2.1												
	2.2												
	2.3												
	2.4									7 - 33	16 - 82	7 - 33	16 - 82
	2.5									7 - 33	16 - 82	7 - 33	16 - 82
	2.6												
	2.7									3 - 16	7 - 33	3 - 16	7 - 33
	2.8								3 - 16				

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	3.2												
	4.1												
	4.2								33 - 131				

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	4.4												
	5.1												
	5.2												

S	1.1												
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	1.3									3 - 26	7 - 33	3 - 26	7 - 33
	2.1									3 - 16	3 - 26	3 - 16	3 - 26
	2.2												
	2.3									3 - 26	7 - 33	3 - 26	7 - 33
	2.4									3 - 26	7 - 33	3 - 26	7 - 33
	2.5									3 - 26	7 - 33	3 - 26	7 - 33
2.6									3 - 26	3 - 26			

H	1.1												
	1.2												
	1.3												
	1.4												
	1.5												

1) Threading in through holes is possible only with external cooling/lubrication



EMUGE TILEG	EMUGE NI		EMUGE H								Thread Depth and Hole Type
Rekord DF-TILEG TiCN	Rekord C-NI-PM TiCN	Rekord DF-NI-PM TiCN	Rekord A-H NT	Rekord A-H TiCN	Rekord A-H-IKZ TiCN	Rekord A-H-IKZN TiCN	Rekord A-H/E NT	Rekord A-H/E TiN	VHM/KHM Rekord A-H-IKZ	VHM/KHM Rekord A-H/E-IKZ	
C / 2-3	D / 4-5	C / 2-3	C / 2-3	C / 2-3	C / 2-3	C / 2-3	E / 1.5-2	E / 1.5-2	C / 2-3	E / 1.5-2	
max. 2 x d ₁	max. 3 x d ₁	max. 2 x d ₁	max. 2 x d ₁		max. 2 x d ₁		max. 2 x d ₁		max. 2 x d ₁		
66	26 42 66	26 42 66	26, 36 42, 52 56 67, 79 85	26, 36 42, 52 67 85	27 43 67 85	67 85	81 97	81 97	67 85		UNC UNF UNEF UN-8 MF NPSM/NPSC M MF NPSM/NPSC NPSF R _p (BSPP) G NPT NPTF R _c (BSPT) STI SELF-LOCK
		122	103	103						104	
			16 - 82	49 - 148	49 - 148	49 - 148	16 - 82	49 - 148			1.1
			16 - 66	33 - 131	33 - 131	33 - 131	16 - 66	33 - 131			2.1
			7 - 49	16 - 82	16 - 82	16 - 82	7 - 49	16 - 82			3.1
				16 - 66	16 - 66	16 - 66		16 - 66			4.1
									16 - 49	16 - 49	5.1
											1.1
											2.1
7 - 33	7 - 33	7 - 33									3.1
											4.1
			33 - 82	49 - 148	49 - 148	49 - 148	33 - 82	49 - 148	131 - 262	131 - 262	1.1
			33 - 66	33 - 131	33 - 131	33 - 131	33 - 66	33 - 131	98 - 197	98 - 197	1.2
			16 - 66	33 - 98	33 - 98	33 - 98	16 - 66	33 - 98	98 - 197	98 - 197	2.1
			16 - 49	33 - 82	33 - 82	33 - 82	16 - 49	33 - 82	66 - 131	66 - 131	2.2
			16 - 49	33 - 82	33 - 82	33 - 82	16 - 49	33 - 82	66 - 131	66 - 131	3.1
			16 - 33	33 - 66	33 - 66	33 - 66	16 - 33	33 - 66	66 - 131	66 - 131	3.2
			33 - 82	49 - 148	49 - 148	49 - 148	33 - 82	49 - 148	131 - 262	131 - 262	4.1
			33 - 66	33 - 131	33 - 131	33 - 131	33 - 66	33 - 131	98 - 197	98 - 197	4.2
											1.1
											1.2
											1.3
											1.4
									66 - 197	66 - 197	1.5
									66 - 131	66 - 131	1.6
											2.1
											2.2
											2.3
			7 - 33	16 - 82	16 - 82	16 - 82	7 - 33	16 - 82			2.4
			7 - 33	16 - 82	16 - 82	16 - 82	7 - 33	16 - 82			2.5
			16 - 66	33 - 98	33 - 98	33 - 98	16 - 66	33 - 98	66 - 131	66 - 131	2.6
			3 - 16	7 - 33	7 - 33	7 - 33	3 - 16	7 - 33	16 - 49	16 - 49	2.7
	3 - 16	3 - 16							3 - 26	3 - 26	2.8
											3.1
											3.2
			16 - 82	33 - 131	33 - 131	33 - 131	16 - 82	33 - 131	66 - 197	66 - 197	4.1
									33 - 82	33 - 82	4.2
									16 - 49	16 - 49	4.3
									16 - 49	16 - 49	4.4
			33 - 66	33 - 66	33 - 66	33 - 66	33 - 66	33 - 66	66 - 197	66 - 197	5.1
									33 - 98	33 - 98	5.2
											5.3
											1.1
7 - 33	7 - 33	7 - 33									1.2
3 - 26	3 - 26	3 - 26									1.3
											2.1
											2.2
	3 - 26	3 - 26									2.3
	3 - 26	3 - 26									2.4
	3 - 26	3 - 26									2.5
	3 - 26	3 - 26									2.6
									3 - 16	3 - 16	1.1
									3 - 10	3 - 10	1.2
											1.3
											1.4
											1.5

Product Finder

V_c

UNC

UNF

UNEF

UN-8

M

MF

NPSM/NPSC

NPSF

Rp (BSPP)

G

NPT

NPTF

Rc (BSPT)

STI

SELF-LOCK

Accessories

Tech. Info



Thread Depth and Hole Type

UNC
UNF
UNEF, UN-8
M
MF
NPSM/NPSC
NPSF
Rp (BSPP)
G
NPT
NPTF
Rc (BSPT)
STI
SELF-LOCK

	Rekord A-HCUT-PM TiCN	VHM-Rekord A-HCUT/D TiCN	VHM-Rekord A-HCUT/C TiCN 3)	Rekord A-Z TiCN	Rekord A-Z-1KZ TiCN	Rekord A-Z-1KZN TiCN	Rekord A-Z/E TiCN	Rekord A-Z/E-1KZ TiCN	Rekord A-Z-1KZ-LF4 TiCN	Rekord B-Z-PM TiN-70	Rekord B-Z-PM GLT-1	Rekord B-Z-1KZN PM-TiN-70	Rekord B-Z-1KZN PM-GLT-1	Rekord D-Z TiN	
	C / 2-3	D / 4-5	C / 2-3	C / 2-3	C / 2-3	C / 2-3	E / 1.5-2	E / 1.5-2	C / 2-3	B / 4-5	B / 4-5	B / 4-5	B / 4-5	C / 2-3	
	max. 1.5 x d ₁		max. 2 x d ₁		max. 2 x d ₁		max. 2 x d ₁		max. 4 x d ₁		max. 3 x d ₁			max. 2 x d ₁	
	27 43			27 43	27 43	27 43		27 43		28 44	28 44	28 44		28 44	
	68 86	69 87	69 87	70 88	70 88	70 88	70 88	70 88	77 95	71 89	71 89	71 89	71 89	72 89	
	101, 104	101	101												
											127, 128				
P	1.1			49 - 148	49 - 148	49 - 148	49 - 148	49 - 148	49 - 148	49 - 148	49 - 148	49 - 148	49 - 148		
	2.1			33 - 131	33 - 131	33 - 131	33 - 131	33 - 131	33 - 131	33 - 131	33 - 131	33 - 131	33 - 131	33 - 131	
	3.1			16 - 82	16 - 82	16 - 82	16 - 82	16 - 82	16 - 82	16 - 82	16 - 82	16 - 82	16 - 82	16 - 82	
	4.1			16 - 66	16 - 66	16 - 66	16 - 66	16 - 66	16 - 66	16 - 66	16 - 66	16 - 66	16 - 66	16 - 66	
	5.1									7 - 49	7 - 49	7 - 49	7 - 49	7 - 33	
M	1.1									16 - 66	16 - 66	16 - 66	16 - 66		
	2.1									16 - 66	16 - 66	16 - 66	16 - 66		
	3.1									16 - 49	16 - 49	16 - 49	16 - 49		
	4.1														
K	1.1			49 - 148	49 - 148	49 - 148	49 - 148	49 - 148	49 - 148						
	1.2			33 - 131	33 - 131	33 - 131	33 - 131	33 - 131	33 - 131						
	2.1			33 - 98	33 - 98	33 - 98	33 - 98	33 - 98	33 - 98	33 - 98	33 - 98	33 - 98	33 - 98	33 - 98	
	2.2			33 - 82	33 - 82	33 - 82	33 - 82	33 - 82	33 - 82					33 - 82	
	3.1			33 - 82	33 - 82	33 - 82	33 - 82	33 - 82	33 - 82						
	3.2			33 - 66	33 - 66	33 - 66	33 - 66	33 - 66	33 - 66						
	4.1			49 - 148	49 - 148	49 - 148	49 - 148	49 - 148	49 - 148						
	4.2			33 - 131	33 - 131	33 - 131	33 - 131	33 - 131	33 - 131						
N	1.1														
	1.2														
	1.3														
	1.4				49 - 131	49 - 131	49 - 131	49 - 131	49 - 131	49 - 131	49 - 131	49 - 131	49 - 131	49 - 131	49 - 131
	1.5				49 - 131	49 - 131	49 - 131	49 - 131	49 - 131	49 - 131	49 - 131	49 - 131	49 - 131	49 - 131	
	1.6				33 - 98	33 - 98	33 - 98	33 - 98	33 - 98	33 - 98	33 - 98	33 - 98	33 - 98	33 - 98	
	2.1										16 - 98	16 - 98	16 - 98	16 - 98	
	2.2										66 - 197	66 - 197	66 - 197	66 - 197	
	2.3														
	2.4				16 - 82	16 - 82	16 - 82	16 - 82	16 - 82	16 - 82	16 - 82	16 - 82	16 - 82	16 - 82	
	2.5				16 - 82	16 - 82	16 - 82	16 - 82	16 - 82	16 - 82	16 - 82	16 - 82	16 - 82	16 - 82	
	2.6				33 - 98	33 - 98	33 - 98	33 - 98	33 - 98	33 - 98	33 - 98	33 - 98	33 - 98	33 - 98	
	2.7				7 - 33	7 - 33	7 - 33	7 - 33	7 - 33	7 - 33					
	2.8														
	3.1														
	3.2														
4.1				33 - 131	33 - 131	33 - 131	33 - 131	33 - 131	33 - 131						
4.2															
4.3															
4.4															
5.1															
5.2															
5.3															
S	1.1									16 - 49	16 - 49	16 - 49	16 - 49		
	1.2														
	1.3														
	2.1														
	2.2														
	2.3														
	2.4														
2.5															
2.6															
H	1.1	3 - 16													
	1.2	3 - 10													
	1.3		3 - 10	3 - 10											
	1.4		3 - 7	3 - 7											
	1.5														



Rekord D-Z- IKZ TIN	Rekord D-Z/ E-IKZ TIN	Rekord D-Z- BF TIN	Rekord D-Z- BF IKZ-TIN	Rekord D-Z/ E-BF IKZ-TIN	Rekord D-Z- IKZ LF4-TIN	Rekord D-Z- BF- IKZ LF4-TIN	Enorm Z	Enorm Z TIN	Enorm Z GLT-1	Enorm Z- IKZ GLT-1	Enorm Z/ E	Enorm Z/ E TIN	Enorm Z/ E TiCN	Enorm Z/ E GLT-1
C / 2-3	E / 1.5-2	C / 2-3	C / 2-3	E / 1.5-2	C / 2-3	C / 2-3	C / 2-3	C / 2-3	C / 2-3	C / 2-3	E / 1.5-2	E / 1.5-2	E / 1.5-2	E / 1.5-2

max. 2 x d ₁			max. 4 x d ₁				max. 3 x d ₁							

29		29	29					29	29	29	29, 37	29, 37	30	30	Thread Depth and Hole Type
45		45	45					45	45	45	45, 53	45, 53	46	46	
		57	57					57	57	57	90	90, 91	90	90	
72		72	72	72	77	77	72	73	73	73	73	73, 81	73	73	
89	89	89	89	90	95	95					98	98		90	

							125				120, 123, 125 127, 130	120, 123		120, 123, 125 127, 128	UNC UNF UNEF, UN-8 M MF NPSM/NPSC NPSF Rp (BSPP) G NPT NPTF Rc (BSPT) STI SELF-LOCK
							16 - 82	49 - 148	49 - 148	49 - 148	16 - 82	49 - 148	49 - 148	49 - 148	1.1
33 - 131	33 - 131	33 - 131	33 - 131	33 - 131	33 - 131	33 - 131	16 - 66	33 - 131	33 - 131	33 - 131	16 - 66	33 - 131	33 - 131	33 - 131	2.1
16 - 82	16 - 82	16 - 82	16 - 82	16 - 82	16 - 82	16 - 82	7 - 49	16 - 82	16 - 82	16 - 82	7 - 49	16 - 82	16 - 82	16 - 82	3.1
16 - 66	16 - 66	16 - 66	16 - 66	16 - 66	16 - 66	16 - 66	7 - 33	16 - 66	16 - 66	16 - 66	7 - 33	16 - 66	16 - 66	16 - 66	4.1
7 - 33	7 - 33	7 - 33	7 - 33	7 - 33	7 - 33	7 - 33									5.1

							7 - 33	16 - 66	16 - 66	16 - 66	7 - 33	16 - 66	16 - 66	16 - 66	1.1
							7 - 33	16 - 66	16 - 66	16 - 66	7 - 33	16 - 66	16 - 66	16 - 66	2.1
								16 - 49	16 - 49	16 - 49		16 - 49	16 - 49	16 - 49	3.1
												16 - 49	16 - 49	16 - 49	4.1

															1.1
															1.2
33 - 98	33 - 98	33 - 98	33 - 98	33 - 98	33 - 98	33 - 98									2.1
33 - 82	33 - 82	33 - 82	33 - 82	33 - 82	33 - 82	33 - 82									2.2
															3.1
															3.2
															4.1
															4.2

															1.1
															1.2
															1.3
49 - 131	49 - 131	49 - 131	49 - 131	49 - 131	49 - 131	49 - 131		49 - 131	49 - 131	49 - 131		49 - 131	49 - 131	49 - 131	1.4
49 - 131	49 - 131	49 - 131	49 - 131	49 - 131	49 - 131	49 - 131		49 - 131	49 - 131	49 - 131		49 - 131	49 - 131	49 - 131	1.5
33 - 98	33 - 98	33 - 98	33 - 98	33 - 98	33 - 98	33 - 98		33 - 98	33 - 98	33 - 98		33 - 98	33 - 98	33 - 98	1.6

							16 - 66	16 - 98	16 - 98	16 - 98	16 - 66	16 - 98	16 - 98	16 - 98	2.1
								66 - 197	66 - 197	66 - 197		66 - 197	66 - 197	66 - 197	2.2
															2.3
16 - 82	16 - 82	16 - 82	16 - 82	16 - 82	16 - 82	16 - 82		16 - 82	16 - 82	16 - 82		16 - 82	16 - 82	16 - 82	2.4
16 - 82	16 - 82	16 - 82	16 - 82	16 - 82	16 - 82	16 - 82		16 - 82	16 - 82	16 - 82		16 - 82	16 - 82	16 - 82	2.5
															2.6
															2.7
															2.8

															3.1
															3.2
															4.1
															4.2
															4.3
															4.4

															5.1
															5.2
															5.3
							16 - 49	16 - 49	16 - 49			16 - 49	16 - 49	16 - 49	1.1
															1.2
															1.3
															2.1
															2.2
															2.3
															2.4
															2.5
															2.6

															1.1
															1.2
															1.3
															1.4
															1.5

Product Finder

V_c

UNC

UNF

UNEF

UN-8

MF

NPSM/NPSC

NPSF

Rp (BSPP)

G

NPT

NPTF

Rc (BSPT)

STI

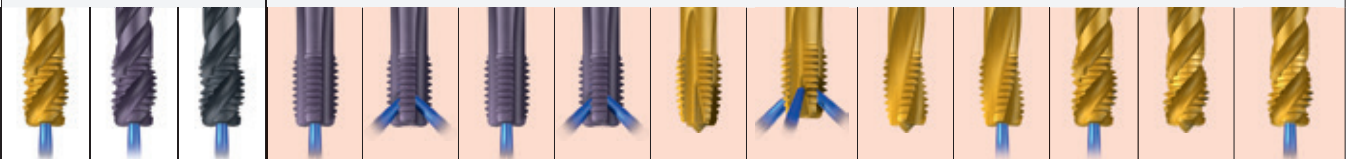
SELF-LOCK

Accessories

Tech. Info



- Product Finder
- V_c
- UNC
- UNF
- UNEF
- UN-8
- M
- MF
- NPSM/NPSC
- NPSF
- Rp (BSPP)
- G
- NPT
- NPTF
- Rc (BSPT)
- STI
- SELF-LOCK
- Accessories
- Tech. Info



	Enorm Z/E-IKZ TIN	Enorm Z/E-IKZ TiCN	Enorm Z/E-IKZ GLT-1	Rekord A-SPEED IKZ-TiCN	Rekord A-SPEED IKZN-TiCN	Rekord A-SPEED/E IKZ-TiCN	Rekord A-SPEED/E IKZN-TiCN	Rekord B-Z-SPEED PM-TiN-70	Rekord B-Z-SPEED-IKZN PM-TiN-70	Rekord D-SPEED TiN	Rekord D-SPEED-IKZ TiN	Enorm SPEED IKZ-TiN	Enorm Z-SPEED-X PM-TiN-60	Enorm Z-SPEED-X-IKZ PM-TiN-60
	E / 1.5-2	E / 1.5-2	E / 1.5-2	C / 2-3	C / 2-3	E / 1.5-2	E / 1.5-2	B / 4-5	B / 4-5	C / 2-3	C / 2-3	C / 2-3	C / 2-3	C / 2-3
Thread Depth and Hole Type	max. 3 x d ₁ 			max. 2 x d ₁ 		max. 2 x d ₁ 		max. 3 x d ₁ 			max. 2 x d ₁ 		max. 3 x d ₁ 	
UNC		30	30, 31	31	31	31	31	31	31	31	32	32		
UNF		46	46, 47	47	47	47		47	47	47	48	48		
UNEF, UN-8														
M	73			74	74	74	74	75	75				75	75
MF	90			91	91	91	91	91	91				92	92
NPSM/NPSC														
NPSF														
Rp (BSPP)														
G														
NPT														
NPTF														
Rc (BSPT)														
STI														
SELF-LOCK														
P	1.1	49 - 148	49 - 148	49 - 148				131 - 262	131 - 262	131 - 262	131 - 262	131 - 262		
	2.1	33 - 131	33 - 131	33 - 131				98 - 197	98 - 197	98 - 197	98 - 197	98 - 197	98 - 197	98 - 197
	3.1	16 - 82	16 - 82	16 - 82				66 - 131	66 - 131	66 - 131	66 - 131	66 - 131	66 - 131	66 - 131
	4.1	16 - 66	16 - 66	16 - 66				33 - 98	33 - 98	33 - 98	33 - 98	33 - 98	33 - 98	33 - 98
	5.1													
M	1.1	16 - 66	16 - 66	16 - 66						33 - 82	33 - 82	33 - 82		
	2.1	16 - 66	16 - 66	16 - 66						33 - 82	33 - 82	33 - 82		
	3.1	16 - 49	16 - 49	16 - 49						16 - 66	16 - 66	16 - 66		
	4.1													
K	1.1				131 - 262	131 - 262	131 - 262	131 - 262						
	1.2				98 - 197	98 - 197	98 - 197	98 - 197						
	2.1				98 - 197	98 - 197	98 - 197	98 - 197	98 - 197	98 - 197	98 - 197	98 - 197	98 - 197	98 - 197
	2.2				66 - 131	66 - 131	66 - 131	66 - 131	66 - 131	66 - 131	66 - 131	66 - 131	66 - 131	66 - 131
	3.1				66 - 131	66 - 131	66 - 131	66 - 131	66 - 131	66 - 131	66 - 131	66 - 131	66 - 131	66 - 131
	3.2				66 - 131	66 - 131	66 - 131	66 - 131	66 - 131	66 - 131	66 - 131	66 - 131	66 - 131	66 - 131
	4.1				131 - 262	131 - 262	131 - 262	131 - 262						
4.2				98 - 197	98 - 197	98 - 197	98 - 197							
N	1.1											66 - 197		
	1.2											66 - 197		
	1.3											66 - 197		
	1.4	49 - 131	49 - 131	49 - 131	66 - 197	66 - 197	66 - 197	66 - 197	66 - 197	66 - 197	66 - 197	66 - 197	66 - 197	66 - 197
	1.5	49 - 131	49 - 131	49 - 131	66 - 197	66 - 197	66 - 197	66 - 197	66 - 197	66 - 197	66 - 197	66 - 197	66 - 197	66 - 197
	1.6	33 - 98	33 - 98	33 - 98	66 - 131	66 - 131	66 - 131	66 - 131	66 - 131	66 - 131	66 - 131	66 - 131	66 - 131	66 - 131
	2.1	16 - 98	16 - 98	16 - 98							66 - 131	66 - 131	66 - 131	66 - 131
	2.2	66 - 197	66 - 197	66 - 197									66 - 131	66 - 131
	2.3												131 - 262	
	2.4	16 - 82	16 - 82	16 - 82										
	2.5	16 - 82	16 - 82	16 - 82										
	2.6													
	2.7													
	2.8													
	3.1													
	3.2													
4.1														
4.2														
4.3														
4.4														
5.1														
5.2														
5.3														
S	1.1	16 - 49	16 - 49	16 - 49										
	1.2													
	1.3													
	2.1													
	2.2													
	2.3													
	2.4													
2.5														
2.6														
H	1.1													
	1.2													
	1.3													
	1.4													
	1.5													

1) Threading in through holes is possible only with external cooling/lubrication

Tapered Taps	EMUGE STEEL		EMUGE VA								EMUGE NI	Thread Depth and Hole Type	
	Rekord A-STEEL	Rekord A-STEEL TIN	Rekord A-VA	Rekord A-VA-AZ	Rekord A-VA-AZ TIN	Rekord D-VA	Rekord D-VA TIN	Rekord D-VA-1KZN TiCN	Rekord D-VA-AZ	Rekord D-VA-AZ TIN	Rekord D-R10-Ni TiCN		
	C / 2-3	C / 2-3	C / 2-3	C / 2-3	C / 2-3	C / 2-3	C / 2-3	C / 2-3	C / 2-3	C / 2-3	C / 2-3	C / 2-3	
	—	—	—	—	—	—	—	—	—	—	—	—	
	107, 109 112, 113 117	107, 109 112, 113	116	109 112, 113	109 112, 113	107, 110 114	107, 110 114	110 114	108, 110 114	108, 110 114	111 115		
	7 - 26	7 - 26	7 - 26	7 - 26	7 - 26	7 - 26	7 - 26	7 - 26	7 - 26	7 - 26	7 - 26		1.1
	7 - 20	7 - 20	7 - 20	7 - 20	7 - 20	7 - 20	7 - 20	7 - 20	7 - 20	7 - 20	7 - 20		2.1
			3 - 26	3 - 26	3 - 26	3 - 26	3 - 26	3 - 26	3 - 26	3 - 26	3 - 26		3.1
			3 - 16	3 - 16	3 - 16								4.1
													5.1
				3 - 26	3 - 26	3 - 26	3 - 26	3 - 26	3 - 26	3 - 26	3 - 26		1.1
				3 - 26	3 - 26	3 - 26	3 - 26	3 - 26	3 - 26	3 - 26	3 - 26		2.1
				3 - 16	3 - 16	3 - 16	3 - 16	3 - 16	3 - 16	3 - 16	3 - 16		3.1
											3 - 10		4.1
	7 - 33	7 - 33											1.1
	7 - 33	7 - 33											1.2
			7 - 26	7 - 26	7 - 26								2.1
			7 - 26	7 - 26	7 - 26								2.2
			7 - 26	7 - 26	7 - 26								3.1
			7 - 26	7 - 26	7 - 26								3.2
			7 - 33	7 - 33	7 - 33								4.1
			7 - 33	7 - 33	7 - 33								4.2
													1.1
													1.2
													1.3
			7 - 33	7 - 33	7 - 33								1.4
													1.5
													1.6
													2.1
	7 - 33	7 - 33											2.2
	7 - 33	7 - 33											2.3
			3 - 26	3 - 26	3 - 26								2.4
			3 - 26	3 - 26	3 - 26								2.5
			3 - 26	3 - 26	3 - 26								2.6
													2.7
													2.8
													3.1
													3.2
													4.1
													4.2
													4.3
													4.4
													5.1
													5.2
													5.3
													1.1
													1.2
													1.3
													2.1
													2.2
													2.3
													2.4
													2.5
													2.6
													1.1
													1.2
													1.3
													1.4
													1.5

Product Finder

V_c

UNC

UNF

UNEF

UN-8

MF

NPSM/NPSC

NPSF

Rp (BSPP)

G

NPT

NPTF

Rc (BSPT)

SELF-LOCK

STI

SELF-LOCK

Accessories

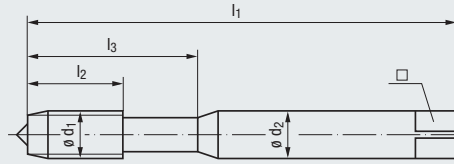
Tech. Info



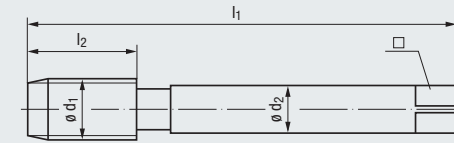
- Product Finder
- V_c
- UNC
- UNF
- UNEF
- UN-8
- M
- MF
- NPSM/NPSC
- NPSF
- Rp (BSPP)
- G
- NPT
- NPTF
- Rc (BSPT)
- STI
- SELF-LOCK
- Accessories
- Tech. Info

DIN Length - ANSI Shank

Overall length acc. to DIN 371, DIN 376



Reinforced Shank
(No.1 - 3/8)



Reduced Shank
(7/16 - 2)



UNC
Unified Coarse Thread
ASME B1.1

Class of Fit
Coating
Cutting Material
Technical Characteristics



Thread Depth and Hole Shape

Applications - Material

STEEL Steel Materials		STEEL Steel Materials		STEEL Steel Materials		STEEL Steel Materials		STEEL Steel Materials	
2B	2B	2B	2B	2B	2B	3B	2B	2B	3B
TIN	TIN	TICN	TIN	TIN	TIN	TIN	TIN	TIN	TIN
HSS Extra	HSS Extra	HSS Extra	HSS Extra	HSS Extra	HSS Extra	HSS Extra	HSS Extra	HSS Extra	HSS Extra
R15	R15	R15	R15	R15	R15	R35	R35	R35	R35
B / 4-5	C / 2-3	C / 2-3	C / 2-3	C / 2-3	C / 2-3	C / 2-3	C / 2-3	C / 2-3	C / 2-3
E / 0	E / 0	E / 0	E / 0	E / 0	E / 0	E / 0	E / 0	E / 0	E / 0
max. 3 x d ₁		max. 2 x d ₁		max. 2.5 x d ₁		max. 2.5 x d ₁		max. 2.5 x d ₁	
P 1.1-4.1 K 2.1 N 2.2, 2.4-5	P 1.1-4.1 K 1.1-4.2 N 1.4-5, 2.4-5	P 1.1-4.1 K 1.1-4.2 N 1.4-5, 2.4-5	P 1.1-3.1 N 2.2	P 1.1-3.1 N 2.2	P 1.1-3.1 N 2.2	P 1.1-3.1 N 2.2	P 1.1-3.1 N 2.2	P 1.1-3.1 N 2.2	P 1.1-3.1 N 2.2

Reinforced Shank

Nominal Size ø d ₁	T.P.I.	l ₁	l ₂	inch l ₃	ø d ₂	□	Tool Identification		BU208400		BU451400		BU979000		BU501000		BU501010	
							Rekord 1B-STEEL-L TIN	Flutes	Rekord 1D-STEEL TIN	Flutes	Rekord 1D-STEEL IKZ-TICN	Flutes	Enorm 1-STEEL	Flutes	Enorm 1-STEEL	Flutes		
No. 1	64	1.772	0.276	0.472	0.141	0.110	0.0595	.5000	●	2	●	2			●	2	●	2
No. 2	56	1.772	0.276	0.472	0.141	0.110	0.0700	.5001	●	2	●	2			●	2	●	2
No. 3	48	1.969	0.354	0.551	0.141	0.110	0.0820	.5002	●	2	●	2			●	2	●	2
No. 4	40	2.205	0.433	0.709	0.141	0.110	0.0890	.5003	●	2	●	2			●	2	●	2
No. 5	40	2.205	0.433	0.709	0.141	0.110	0.1015	.5004	●	3	●	2			●	3	●	3
No. 6	32	2.205	0.472	0.787	0.141	0.110	0.1110	.5005	●	3	●	2			●	3	●	3
No. 8	32	2.480	0.512	0.827	0.168	0.131	0.1360	.5006	●	3	●	3			●	3	●	3
No.10	24	2.756	0.591	0.984	0.194	0.152	0.1520	.5007	●	3	●	3	●	3	●	3	●	3
No.12	24	3.150	0.630	1.142	0.220	0.165	0.1770	.5008	●	3	●	3			●	3	●	3
1/4	20	3.150	0.669	1.181	0.255	0.191	0.2040	.5009	●	3	●	3	●	3	●	3	●	3
5/16	18	3.543	0.787	1.378	0.318	0.238	0.2610	.5010	●	3	●	3	●	3	●	3	●	3
3/8	16	3.937	0.866	1.535	0.381	0.286	0.3160	.5011	●	3	●	3	●	3	●	3	●	3

Reduced Shank

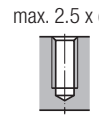
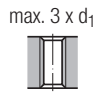
Nominal Size ø d ₁	T.P.I.	l ₁	l ₂	inch l ₃	ø d ₂	□	Tool Identification		CU208400		CU451400		CU979000		CU501000		CU501010	
							Rekord 2B-STEEL-L TIN	Flutes	Rekord 2D-STEEL TIN	Flutes	Rekord 2D-STEEL IKZ-TICN	Flutes	Enorm 2-STEEL	Flutes	Enorm 2-STEEL	Flutes		
7/16	14	3.937	0.866	—	0.323	0.242	0.3680	.5012	●	3	●	3	●	3	●	3	●	3
1/2	13	4.331	0.984	—	0.367	0.275	0.4219	.5013	●	3	●	3	●	3	●	3	●	3
9/16	12	4.331	1.024	—	0.429	0.322	0.4844	.5014	●	3	●	3	●	3	●	3	●	3
5/8	11	4.331	1.063	—	0.480	0.360	0.5313	.5015	●	3	●	3	●	3	●	3	●	3
3/4	10	4.921	1.181	—	0.590	0.442	0.6563	.5016	●	3	●	3	●	3	●	3	●	3
7/8	9	5.512	1.260	—	0.697	0.523	0.7656	.5017	●	3	●	3	●	3	●	4	●	4
1	8	6.299	1.417	—	0.800	0.600	0.8750	.5018	●	3	●	3	●	3	●	4	●	4
1 1/8	7	7.087	1.575	—	0.896	0.672	0.9843	.5019	●	3	●	3			●	4	●	4
1 1/4	7	7.087	1.575	—	1.021	0.766	1.1094	.5020	●	4	●	4			●	4	●	4
1 3/8	6	7.874	1.969	—	1.108	0.831	1.2205	.5021	●	4					●	4	●	4
1 1/2	6	7.874	1.969	—	1.233	0.925	1.3386	.5022	●	4					●	4	●	4
1 3/4	5	8.661	2.283	—	1.430	1.072	1.5551	.5023	●	4					●	5	●	5
2	4 1/2	9.843	2.559	—	1.644	1.233	1.7812	.5024	●	4					●	5	●	5

VA
Stainless Steel
Materials



new	new	new	new		new		new
2B	2B	3B	Override	2B	2B	3B	3B
GLT-1	TICN	GLT-1	GLT-1	NE2	GLT-1	NE2	GLT-1
HSS Extra	HSS Extra	HSS Extra	HSS Extra	HSS Extra	HSS Extra	HSS Extra	HSS Extra
B / 4-5	B / 4-5	B / 4-5	B / 4-5	R35	R35	R35	R35
E / O / P	E / O	E / O / P	E / O / P	C / 2-3	C / 2-3	C / 2-3	C / 2-3
				E / O / P	E / O / P	E / O / P	E / O / P

Class of Fit
Coating
Cutting Material
Technical Characteristics



Thread Depth
and Hole Shape

P 1.1-4.1	P 1.1-4.1	P 1.1-4.1	P 1.1-4.1	P 1.1-3.1	P 1.1-4.1	P 1.1-3.1	P 1.1-4.1
M 1.1-3.1	M 1.1-3.1	M 1.1-3.1	M 1.1-3.1	M 1.1-2.1	M 1.1-3.1	M 1.1-2.1	M 1.1-3.1
K 2.1	K 2.1	K 2.1	K 2.1	K 2.1	K 2.1	K 2.1	K 2.1
N 2.2	N 2.2, 2.5-6	N 2.2	N 2.2				

Applications – Material

BU20C300		BU089300		BU20C310		BU20C344		BU503200		BU50C300		BU503210		BU50C310		Tool Identification		
Rekord 1B-VA GLT-1	Flutes	Rekord 1B-VA- IKZN TICN	Flutes	Rekord 1B-VA GLT-1	Flutes	Rekord 1B-VA GLT-1	Flutes	Enorm 1-VA NE2	Flutes	Enorm 1-VA GLT-1	Flutes	Enorm 1-VA NE2	Flutes	Enorm 1-VA GLT-1	Flutes	Dimens. ID	Nominal Size ø d ₁	T.P.I.
●	2			●	2			●	2	●	2	●	2	●	2	.5000	No. 1	64
●	2			●	2			●	2	●	2	●	2	●	2	.5001	No. 2	56
●	2			●	2			●	2	●	2	●	2	●	2	.5002	No. 3	48
●	2			●	2			●	2	●	2	●	2	●	2	.5003	No. 4	40
●	3			●	3			●	3	●	3	●	3	●	3	.5004	No. 5	40
●	3			●	3			●	3	●	3	●	3	●	3	.5005	No. 6	32
●	3			●	3			●	3	●	3	●	3	●	3	.5006	No. 8	32
●	3	●	3	●	3			●	3	●	3	●	3	●	3	.5007	No. 10	24
●	3			●	3			●	3	●	3	●	3	●	3	.5008	No. 12	24
●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	.5009	1/4	20
●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	.5010	5/16	18
●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	.5011	3/8	16

CU20C300		CU089300		CU20C310		CU20C344		CU503200		CU50C300		CU503210		CU50C310		Tool Identification		
Rekord 2B-VA GLT-1	Flutes	Rekord 2B-VA- IKZN TICN	Flutes	Rekord 2B-VA GLT-1	Flutes	Rekord 2B-VA GLT-1	Flutes	Enorm 2-VA NE2	Flutes	Enorm 2-VA GLT-1	Flutes	Enorm 2-VA NE2	Flutes	Enorm 2-VA GLT-1	Flutes	Dimens. ID	Nominal Size ø d ₁	T.P.I.
●	3	●	3	●	3	● (+.0050)	3	●	3	●	3	●	3	●	3	.5012	7/16	14
●	3	●	3	●	3	● (+.0050)	3	●	3	●	3	●	3	●	3	.5013	1/2	13
●	3			●	3			●	3	●	3	●	3	●	3	.5014	9/16	12
●	3	●	3	●	3	● (+.0050)	3	●	3	●	3	●	3	●	3	.5015	5/8	11
●	3	●	3	●	3	● (+.0050)	3	●	3	●	3	●	3	●	3	.5016	3/4	10
●	3			●	3			●	4	●	4	●	4	●	4	.5017	7/8	9
●	3	●	3	●	3			●	4	●	4	●	4	●	4	.5018	1	8
●	3			●	3			●	4	●	4	●	4	●	4	.5019	1 1/8	7
●	4			●	4			●	4	●	4	●	4	●	4	.5020	1 1/4	7
●	4			●	4			●	4	●	4	●	4	●	4	.5021	1 3/8	6
●	4			●	4			●	4	●	4	●	4	●	4	.5022	1 1/2	6
●	4			●	4			●	5	●	5	●	5	●	5	.5023	1 3/4	5
●	4			●	4			●	5	●	5	●	5	●	5	.5024	2	4 1/2

● = In stock
★ = Allow 7 days for delivery

1) Tool Identification = BU20C343

Product Finder

V_c

UNC

UNF

UNEF

UN-8

MF

NPSM/NPSC

NPSF

R_p (BSPP)

G

NPT

NPTF

Rc (BSPT)

STI

SELF-LOCK

Accessories

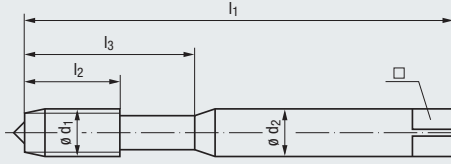
Tech. Info



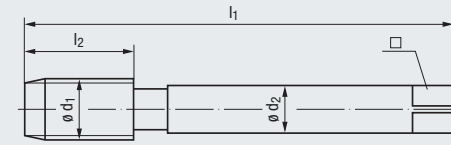
- Product Finder
- V_c
- UNC
- UNF
- UNEF
- UN-8
- M
- MF
- NPSM/NPSC
- NPSF
- Rp (BSPP)
- G
- NPT
- NPTF
- Rc (BSPT)
- STI
- SELF-LOCK
- Accessories
- Tech. Info

DIN Length - ANSI Shank

Overall length acc. to DIN 371, DIN 376

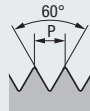


Reinforced Shank
(No. 1 - 3/8)



Reduced Shank
(7/16 - 2)

UNC



Unified Coarse Thread
ASME B1.1

Class of Fit: **Override**
Coating: **GLT-1**
Cutting Material: **HSS Extra**
Technical Characteristics: **R35**
C / 2-3
E / O / P

Thread Depth and Hole Shape

Applications - Material

VA
Stainless Steel
Materials



new

2B
GLT-8
HSS Extra
R45
C / 2-3
E / O

max. 2.5 x d₁



P 1.1-4.1
M 1.1-3.1
K 2.1

AL
Aluminum
Wrought Alloys



new



new



new

2B
GLT-8
HSS Extra
R45
C / 2-3
E / O

max. 3 x d₁



N 1.1-4

2B
GLT-8
HSS Extra
R45
C / 2-3
E / O

max. 2.5 x d₁



N 1.1-4

3B
GLT-8
HSS Extra
R45
C / 2-3
E / O

max. 2.5 x d₁


















N 1.1-4

Reinforced Shank

								Tool Identification		BU50C344		BU20S800		BU50S800		BU50S810	
Nominal Size ø d ₁	T.P.I.	l ₁	l ₂	inch		ø d ₂	□	Image	Dimens. ID	Enorm 1-VA GLT-1	Flutes	Rekord 1B-AL GLT-8	Flutes	Enorm 1-AL GLT-8	Flutes	Enorm 1-AL GLT-8	Flutes
				l ₃	ø d ₂												
No. 1	64	1.772	0.276	0.472	0.141	0.110		0.0595	.5000								
No. 2	56	1.772	0.276	0.472	0.141	0.110		0.0700	.5001			●	2	●	2	●	2
No. 3	48	1.969	0.354	0.551	0.141	0.110		0.0820	.5002			●	2	●	2	●	2
No. 4	40	2.205	0.433	0.709	0.141	0.110		0.0890	.5003			●	2	●	2	●	2
No. 5	40	2.205	0.433	0.709	0.141	0.110		0.1015	.5004			●	2	●	2	●	2
No. 6	32	2.205	0.472	0.787	0.141	0.110		0.1110	.5005			●	2	●	2	●	2
No. 8	32	2.480	0.512	0.827	0.168	0.131		0.1360	.5006			●	2	●	2	●	2
No. 10	24	2.756	0.591	0.984	0.194	0.152		0.1520	.5007	1) ● (+.0035)	3	●	2	●	2	●	2
No. 12	24	3.150	0.630	1.142	0.220	0.165		0.1770	.5008			●	2	●	2	●	2
1/4	20	3.150	0.669	1.181	0.255	0.191		0.2040	.5009	● (+.0050)	3	●	2	●	2	●	2
5/16	18	3.543	0.787	1.378	0.318	0.238		0.2610	.5010	● (+.0050)	3	●	2	●	2	●	2
3/8	16	3.937	0.866	1.535	0.381	0.286		0.3160	.5011	● (+.0050)	3	●	2	●	2	●	2

Reduced Shank

								Tool Identification		CU50C344		CU20S800		CU50S800		CU50S810	
Nominal Size ø d ₁	T.P.I.	l ₁	l ₂	inch		ø d ₂	□	Image	Dimens. ID	Enorm 2-VA GLT-1	Flutes	Rekord 2B-AL GLT-8	Flutes	Enorm 2-AL GLT-8	Flutes	Enorm 2-AL GLT-8	Flutes
				l ₃	ø d ₂												
7/16	14	3.937	0.866	—	0.323	0.242		0.3680	.5012	● (+.0050)	3	●	3	●	3	●	3
1/2	13	4.331	0.984	—	0.367	0.275		0.4219	.5013	● (+.0050)	3	●	3	●	3	●	3
9/16	12	4.331	1.024	—	0.429	0.322		0.4844	.5014			●	3	●	3	●	3
5/8	11	4.331	1.063	—	0.480	0.360		0.5313	.5015	● (+.0050)	3	●	3	●	3	●	3
3/4	10	4.921	1.181	—	0.590	0.442		0.6563	.5016	● (+.0050)	3	●	3	●	3	●	3
7/8	9	5.512	1.260	—	0.697	0.523		0.7656	.5017			●	3	●	3	●	3
1	8	6.299	1.417	—	0.800	0.600		0.8750	.5018								
1 1/8	7	7.087	1.575	—	0.896	0.672		0.9843	.5019								
1 1/4	7	7.087	1.575	—	1.021	0.766		1.1094	.5020								
1 3/8	6	7.874	1.969	—	1.108	0.831		1.2205	.5021								
1 1/2	6	7.874	1.969	—	1.233	0.925		1.3386	.5022								
1 3/4	5	8.661	2.283	—	1.430	1.072		1.5551	.5023								
2	4 1/2	9.843	2.559	—	1.644	1.233		1.7812	.5024								

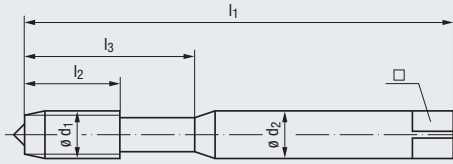
AERO Nickel Alloys		TI Titanium												Product Finder				
														V _c				
3BX		2BX		3BX		3BX		2BX		3BX		3BX		UNC				
NT		NT2		NT2		TICN		NT2		NT2		TICN		UNF				
HSS Extra		HSS Extra		HSS Extra		HSS Extra		HSS Extra		HSS Extra		HSS Extra		UNEF				
B / approx. 3		L15		L15		L15		R15		R15		R15		UN-8				
O / P		D / 4-5		D / 4-5		D / 4-5		C / 2-3		C / 2-3		C / 2-3		MF				
max. 3 x d ₁		E / O / P		E / O / P		E / O / P		E / O / P		E / O / P		E / O / P		NPSM/NPSC				
																Rc (BSPT)		
M 4.1		P 4.1-5.1		P 4.1-5.1		P 4.1-5.1		P 4.1-5.1		P 4.1-5.1		P 4.1-5.1		STI				
N 2.8		M 3.1-4.1		M 3.1-4.1		M 3.1-4.1		M 3.1-4.1		M 3.1-4.1		M 3.1-4.1		SELF-LOCK				
S 2.3, 2.5-6		N 2.4-5, 2.7		N 2.4-5, 2.7		N 2.4-5, 2.7		N 2.4-5, 2.7		N 2.4-5, 2.7		N 2.4-5, 2.7		Accessories				
		S 1.1-2.2, 2.4		S 1.1-2.2, 2.4		S 1.1-2.2, 2.4		S 1.1-2.2, 2.4		S 1.1-2.2, 2.4		S 1.1-2.2, 2.4		Tech. Info				
														Applications – Material				
BU206511		BU306001		BU306011		BU309611		BU456001		BU456011		BU459611		Tool Identification				
Rekord 1B-AERO NT		Rekord 1C-TI NT2		Rekord 1C-TI NT2		Rekord 1C-TI TICN		Rekord 1D-TI NT2		Rekord 1D-TI NT2		Rekord 1D-TI TICN		Dimens. ID				
Flutes		Flutes		Flutes		Flutes		Flutes		Flutes		Flutes		Nominal Size ø d ₁				
●		●		●		●		●		●		●		T.P.I.				
●		●		●		●		●		●		●		.5000 No. 1 64				
●		●		●		●		●		●		●		.5001 No. 2 56				
●		●		●		●		●		●		●		.5002 No. 3 48				
●		●		●		●		●		●		●		.5003 No. 4 40				
●		●		●		●		●		●		●		.5004 No. 5 40				
●		●		●		●		●		●		●		.5005 No. 6 32				
●		●		●		●		●		●		●		.5006 No. 8 32				
●		●		●		●		●		●		●		.5007 No. 10 24				
●		●		●		●		●		●		●		.5008 No. 12 24				
●		●		●		●		●		●		●		.5009 1/4 20				
●		●		●		●		●		●		●		.5010 5/16 18				
●		●		●		●		●		●		●		.5011 3/8 16				
CU206511		CU306001		CU306011		CU309611		CU456001		CU456011		CU459611		Tool Identification				
Rekord 2B-AERO NT		Rekord 2C-TI NT2		Rekord 2C-TI NT2		Rekord 2C-TI TICN		Rekord 2D-TI NT2		Rekord 2D-TI NT2		Rekord 2D-TI TICN		Dimens. ID				
Flutes		Flutes		Flutes		Flutes		Flutes		Flutes		Flutes		Nominal Size ø d ₁				
●		●		●		●		●		●		●		T.P.I.				
●		●		●		●		●		●		●		.5012 7/16 14				
●		●		●		●		●		●		●		.5013 1/2 13				
●		●		●		●		●		●		●		.5014 9/16 12				
●		●		●		●		●		●		●		.5015 5/8 11				
●		●		●		●		●		●		●		.5016 3/4 10				
●		●		●		●		●		●		●		.5017 7/8 9				
●		●		●		●		●		●		●		.5018 1 8				
●		●		●		●		●		●		●		.5019 1 1/8 7				
●		●		●		●		●		●		●		.5020 1 1/4 7				
●		●		●		●		●		●		●		.5021 1 3/8 6				
●		●		●		●		●		●		●		.5022 1 1/2 6				
●		●		●		●		●		●		●		.5023 1 3/4 5				
●		●		●		●		●		●		●		.5024 2 4 1/2				

● = In stock
★ = Allow 7 days for delivery

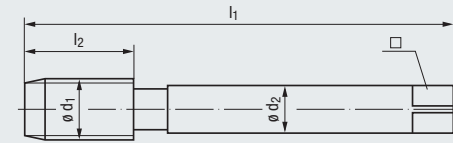
- Product Finder
- V_c
- UNC
- UNF
- UNEF
- UN-8
- M
- MF
- NPSM/NPSC
- NPSF
- Rp (BSPP)
- G
- NPT
- NPTF
- Rc (BSPT)
- STI
- SELF-LOCK
- Accessories
- Tech. Info

DIN Length - ANSI Shank

Overall length acc. to DIN 371, DIN 376



Reinforced Shank
(No.1 - 3/8)



Reduced Shank
(7/16 - 2)

NI
Nickel
Alloys



H
Materials of High
Tensile Strength



UNC
Unified Coarse Thread
ASME B1.1

Class of Fit
Coating
Cutting Material
Technical Characteristics



Thread Depth
and Hole Shape

Applications - Material

3BX	3BX	2BX	2BX
TICN	TICN	NT	TICN
HSSE-PM	HSSE-PM	HSS Extra	HSS Extra
L08	R10	C / 2-3	C / 2-3
D / 4-5	C / 2-3	E / O / P	E / O / P
O / P	O / P		
max. 3 x d ₁	max. 2 x d ₁	max. 2 x d ₁	
M 4.1	M 4.1	P 1.1-3.1	P 1.1-4.1
N 2.8	N 2.8	K 1.1-4.2	K 1.1-4.2
S 1.2-3	S 1.2-3	N 2.4-7	N 2.4-7
S 2.3, 2.5-6	S 2.3, 2.5-6	N 4.1, 5.1	N 4.1, 5.1

Reinforced Shank

Nominal Size ø d ₁	T.P.I.	l ₁	l ₂	inch		ø d ₂	□	Tool Identification	BU30J411		BU35J411		BU100501		BU109101	
				Rekord 1C-NI-PM TICN	Flutes				Rekord 1DF-NI-PM TICN	Flutes	Rekord 1A-H NT	Flutes	Rekord 1A-H TICN	Flutes		
No. 1	64	1.772	0.276	0.472	0.141	0.110	0.0595	.5000					●	2		
No. 2	56	1.772	0.276	0.472	0.141	0.110	0.0700	.5001					●	3	●	3
No. 3	48	1.969	0.354	0.551	0.141	0.110	0.0820	.5002					●	3		
No. 4	40	2.205	0.433	0.709	0.141	0.110	0.0890	.5003	●	2	●	2	●	3	●	3
No. 5	40	2.205	0.433	0.709	0.141	0.110	0.1015	.5004	●	2	●	2	●	3		
No. 6	32	2.205	0.472	0.787	0.141	0.110	0.1110	.5005	●	3	●	3	●	3	●	3
No. 8	32	2.480	0.512	0.827	0.168	0.131	0.1360	.5006	●	3	●	3	●	3	●	3
No.10	24	2.756	0.591	0.984	0.194	0.152	0.1520	.5007	●	3	●	3	●	3	●	3
No.12	24	3.150	0.630	1.142	0.220	0.165	0.1770	.5008	●	3	●	3	●	3		
1/4	20	3.150	0.669	1.181	0.255	0.191	0.2040 2)	.5009	●	3	●	3	●	3	●	3
5/16	18	3.543	0.787	1.378	0.318	0.238	0.2610 2)	.5010	●	3	●	3	●	3	●	3
3/8	16	3.937	0.866	1.535	0.381	0.286	0.3160 2)	.5011	●	3	●	3	●	3	●	3

Reduced Shank

Nominal Size ø d ₁	T.P.I.	l ₁	l ₂	inch		ø d ₂	□	Tool Identification	CU30J411		CU35J411		CU100501		CU109101	
				Rekord 2C-NI-PM TICN	Flutes				Rekord 2DF-NI-PM TICN	Flutes	Rekord 2A-H NT	Flutes	Rekord 2A-H TICN	Flutes		
7/16	14	3.937	0.866	—	0.323	0.242	0.3680 2)	.5012	●	3	●	3	●	3	●	3
1/2	13	4.331	0.984	—	0.367	0.275	0.4219 2)	.5013	●	3	●	3	●	3	●	3
9/16	12	4.331	1.024	—	0.429	0.322	0.4844	.5014	●	3	●	3	●	3	●	3
5/8	11	4.331	1.063	—	0.480	0.360	0.5313	.5015	●	3	●	3	●	3	●	3
3/4	10	4.921	1.181	—	0.590	0.442	0.6563	.5016	●	3	●	3	●	4	●	4
7/8	9	5.512	1.260	—	0.697	0.523	0.7656	.5017	●	3	●	3	●	4	●	4
1	8	6.299	1.417	—	0.800	0.600	0.8750	.5018					●	4	●	4
1 1/8	7	7.087	1.575	—	0.896	0.672	0.9843	.5019								
1 1/4	7	7.087	1.575	—	1.021	0.766	1.1094	.5020								
1 3/8	6	7.874	1.969	—	1.108	0.831	1.2205	.5021								
1 1/2	6	7.874	1.969	—	1.233	0.925	1.3386	.5022								
1 3/4	5	8.661	2.283	—	1.430	1.072	1.5551	.5023								
2	4 1/2	9.843	2.559	—	1.644	1.233	1.7812	.5024								



2BX	2BX	2BX	2BX	2BX	2BX	2BX	2BX	Class of Fit Coating Cutting Material Technical Characteristics
TICN	TICN	TICN	TICN	TICN	TICN	TICN	TICN	
HSS Extra	HSSE-PM	HSS Extra	HSS Extra	HSS Extra	HSS Extra	HSS Extra	HSS Extra	
C / 2-3 E / O	C / 2-3 O / P	C / 2-3 E / O / P	C / 2-3 E / O	C / 2-3 E / O	C / 2-3 E / O	E / 1.5-2 E / O	E / O	

max. 2 x d ₁	max. 1.5 x d ₁	max. 2 x d ₁	max. 2 x d ₁	max. 2 x d ₁	max. 2 x d ₁	max. 2 x d ₁	max. 2 x d ₁	Thread Depth and Hole Shape

P 1.1-4.1	H 1.1-2	P 1.1-4.1	P 1.1-4.1	P 1.1-4.1	P 1.1-4.1	P 1.1-4.1	P 1.1-4.1	Applications – Material
K 1.1-4.2		K 1.1-4.2	K 1.1-4.2	K 1.1-4.2	K 1.1-4.2	K 1.1-4.2	K 1.1-4.2	
N 2.4-7		N 1.4-6, 2.4-7	N 1.4-6, 2.4-7	N 1.4-6, 2.4-7	N 1.4-6, 2.4-7	N 1.4-6, 2.4-7	N 1.4-6, 2.4-7	
N 4.1, 5.1		N 4.1	N 4.1	N 4.1	N 4.1	N 4.1	N 4.1	

BU959101		BU10J901		BU109401		BU959401		BU219401		BU969401		Tool Identification		
Rekord 1A-H-IKZ TICN	Flutes	Rekord 1A-HCUT-PM TICN	Flutes	Rekord 1A-Z TICN	Flutes	Rekord 1A-Z-IKZ TICN	Flutes	Rekord 1A-Z-IKZN TICN	Flutes	Rekord 1A-Z/E-IKZ TICN	Flutes	Dimens. ID	Nominal Size ø d ₁	T.P.I.
												.5000	No. 1	64
												.5001	No. 2	56
												.5002	No. 3	48
				●	3							.5003	No. 4	40
				●	3							.5004	No. 5	40
				●	3							.5005	No. 6	32
				●	3							.5006	No. 8	32
●	3			●	3	●	3	●	3	●	3	.5007	No. 10	24
												.5008	No. 12	24
●	3	●	4	●	3	●	3	●	3	●	3	.5009	1/4	20
●	3	●	5	●	3	●	3	●	3	●	3	.5010	5/16	18
●	3	●	5	●	3	●	3	●	3	●	3	.5011	3/8	16

CU959101		CU10J901		CU109401		CU959401		CU219401		CU969401		Tool Identification		
Rekord 2A-H-IKZ TICN	Flutes	Rekord 2A-HCUT-PM TICN	Flutes	Rekord 2A-Z TICN	Flutes	Rekord 2A-Z-IKZ TICN	Flutes	Rekord 2A-Z-IKZN TICN	Flutes	Rekord 2A-Z/E-IKZ TICN	Flutes	Dimens. ID	Nominal Size ø d ₁	T.P.I.
●	3			●	3	●	3	●	3	●	3	.5012	7/16	14
●	3	●	5	●	3	●	3	●	3	●	3	.5013	1/2	13
●	3			●	3	●	3	●	3	●	3	.5014	9/16	12
●	3			●	3	●	3	●	3	●	3	.5015	5/8	11
●	4			●	4	●	4	●	4	●	4	.5016	3/4	10
●	4			●	4	●	4	●	4	●	4	.5017	7/8	9
●	4			●	4	●	4	●	4	●	4	.5018	1	8
												.5019	1 1/8	7
												.5020	1 1/4	7
												.5021	1 3/8	6
												.5022	1 1/2	6
												.5023	1 3/4	5
												.5024	2	4 1/2

● = In stock
★ = Allow 7 days for delivery

1) Threading in through holes is possible only with external cooling/lubrication
2) Increase drill diameter for taps Rekord 1/2A-HCUT-PM-TICN by 0.004 in

Product Finder

V_c

UNC

UNF

UNEF

UN-8

MF

NPSM/NPSC

NPSF

Rp (BSPP)

G

NPT

NPTF

Rc (BSPT)

STI

SELF-LOCK

Accessories

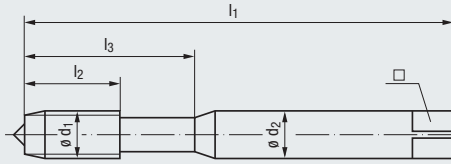
Tech. Info



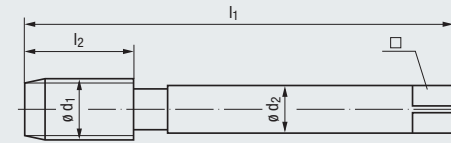
- Product Finder
- V_c
- UNC
- UNF
- UNEF
- UN-8
- M
- MF
- NPSM/NPSC
- NPSF
- Rp (BSPP)
- G
- NPT
- NPTF
- Rc (BSPT)
- STI
- SELF-LOCK
- Accessories
- Tech. Info

DIN Length - ANSI Shank

Overall length acc. to DIN 371, DIN 376



Reinforced Shank
(No.1 - 3/8)



Reduced Shank
(7/16 - 2)

UNC



Unified Coarse Thread
ASME B1.1

Class of Fit

Coating

Cutting Material

Technical Characteristics



Thread Depth
and Hole Shape

Applications - Material

Z
CNC-Controlled
Machines



2BX	2BX	2BX	3BX	2BX
TIN-70	GLT-1	TIN-70	GLT-1	TIN
HSSE-PM	HSSE-PM	HSSE-PM	HSSE-PM	HSS Extra
B / 4-5	B / 4-5	B / 4-5	B / 4-5	R15
E / O / P	E / O / P	E / O	E / O / P	C / 2-3
				E / O / P

max. 3 x d₁



max. 2 x d₁



P 1.1-5.1	P 1.1-5.1	P 1.1-5.1	P 1.1-5.1	P 2.1-5.1
M 1.1-3.1	M 1.1-3.1	M 1.1-3.1	M 1.1-3.1	K 2.1-2
K 2.1	K 2.1	K 2.1	K 2.1	N 1.4-6, 2.4-5
N 1.4-2.2, 2.4-5	N 1.4-2.2, 2.4-5	N 1.4-2.2, 2.4-5	N 1.4-2.2, 2.4-5	S 1.1
S 1.1	S 1.1	S 1.1	S 1.1	

Reinforced Shank

Nominal Size ø d ₁	T.P.I.	l ₁	l ₂	inch		□	Tool Identification	Tool Identification										
				l ₃	ø d ₂			Rekord 1B-Z-PM TIN-70	Flutes	Rekord 1B-Z-PM GLT-1	Flutes	Rekord 1B-Z-PM PM-TIN-70	Flutes	Rekord 1B-Z-PM GLT-1	Flutes	Rekord 1D-Z TIN	Flutes	
No. 1	64	1.772	0.157	0.472	0.141	0.110	0.0595	.5000										
No. 2	56	1.772	0.177	0.472	0.141	0.110	0.0700	.5001										
No. 3	48	1.969	0.197	0.551	0.141	0.110	0.0820	.5002										
No. 4	40	2.205	0.236	0.709	0.141	0.110	0.0890	.5003	●	2	●	2		●	2	●	2	
No. 5	40	2.205	0.276	0.709	0.141	0.110	0.1015	.5004										
No. 6	32	2.205	0.276	0.787	0.141	0.110	0.1110	.5005	●	3	●	3		●	3	●	3	
No. 8	32	2.480	0.315	0.827	0.168	0.131	0.1360	.5006	●	3	●	3		●	3	●	3	
No. 10	24	2.756	0.394	0.984	0.194	0.152	0.1520	.5007	●	3	●	3	●	3	●	3	3	
No. 12	24	3.150	0.394	1.142	0.220	0.165	0.1770	.5008										
1/4	20	3.150	0.512	1.181	0.255	0.191	0.2040	.5009	●	3	●	3	●	3	●	3	3	
5/16	18	3.543	0.551	1.378	0.318	0.238	0.2610	.5010	●	4	●	4	●	4	●	4	3	
3/8	16	3.937	0.630	1.535	0.381	0.286	0.3160	.5011	●	4	●	4	●	4	●	4	3	

Reduced Shank

Nominal Size ø d ₁	T.P.I.	l ₁	l ₂	inch		□	Tool Identification	Tool Identification										
				l ₃	ø d ₂			Rekord 2B-Z-PM TIN-70	Flutes	Rekord 2B-Z-PM GLT-1	Flutes	Rekord 2B-Z-PM PM-TIN-70	Flutes	Rekord 2B-Z-PM GLT-1	Flutes	Rekord 2D-Z TIN	Flutes	
7/16	14	3.937	0.709	—	0.323	0.242	0.3680	.5012	●	4	●	4	●	4	●	4	●	3
1/2	13	4.331	0.787	—	0.367	0.275	0.4219	.5013	●	4	●	4	●	4	●	4	●	3
9/16	12	4.331	0.787	—	0.429	0.322	0.4844	.5014	●	4	●	4	●	4	●	4	●	3
5/8	11	4.331	0.866	—	0.480	0.360	0.5313	.5015	●	4	●	4	●	4	●	4	●	3
3/4	10	4.921	0.984	—	0.590	0.442	0.6563	.5016	●	4	●	4	●	4	●	4	●	3
7/8	9	5.512	1.063	—	0.697	0.523	0.7656	.5017										
1	8	6.299	1.181	—	0.800	0.600	0.8750	.5018										
1 1/8	7	7.087	1.378	—	0.896	0.672	0.9843	.5019										
1 1/4	7	7.087	1.378	—	1.021	0.766	1.1094	.5020										
1 3/8	6	7.874	1.575	—	1.108	0.831	1.2205	.5021										
1 1/2	6	7.874	1.575	—	1.233	0.925	1.3386	.5022										
1 3/4	5	8.661	1.772	—	1.430	1.072	1.5551	.5023										
2	4 1/2	9.843	1.969	—	1.644	1.233	1.7812	.5024										

Z
CNC-Controlled
Machines

2BX	2BX	2BX	2B	2B	2B	2B	2B
TIN	TIN	TIN	TIN	GLT-1	GLT-1	HSS Extra	TIN
HSS Extra	HSS Extra	HSS Extra	HSS Extra	HSS Extra	HSS Extra	HSS Extra	HSS Extra
R15	R15	R15	R45	R45	R45	R45	R45
C / 2-3	C / 2-3	C / 2-3	C / 2-3	C / 2-3	C / 2-3	E / 1.5-2	E / 1.5-2
E / O	E / O / P	E / O	E / O / P	E / O / P	E / O	E / O / P	E / O / P

- Product Finder
- V_c
- UNC
- UNF
- UNEF
- UN-8
- MF
- NPSM/NPSC
- NPSF
- Rp (BSPP)
- G
- NPT
- NPTF
- Rc (BSPT)
- STI
- SELF-LOCK
- Accessories
- Tech. Info

max. 2 x d ₁ 			max. 3 x d ₁ 				
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P 2.1-5.1 K 2.1-2 N 1.4-6, 2.4-5	P 2.1-5.1 K 2.1-2 N 1.4-6, 2.4-5	P 2.1-5.1 K 2.1-2 N 1.4-6, 2.4-5	P 1.1-4.1 M 1.1-3.1 N 1.4-6 N 2.1-2, 2.4-5 S 1.1	P 1.1-4.1 M 1.1-3.1 N 1.4-6 N 2.1-2, 2.4-5 S 1.1	P 1.1-4.1 M 1.1-3.1 N 1.4-6 N 2.1-2, 2.4-5 S 1.1	P 1.1-4.1 M 1.1-2.1 N 2.1 N 1.4-6 N 2.1-2, 2.4-5 S 1.1	P 1.1-4.1 M 1.1-3.1 N 1.4-6 N 2.1-2, 2.4-5 S 1.1
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BU973701		BU523701		BU573701		BU50C400		BU94C400		BU513500		BU513700		Tool Identification		
Rekord 1D-Z- IKZ TIN	Flutes	Rekord 1D-Z- BF TIN	Flutes	Rekord 1D-Z- BF IKZ-TIN	Flutes	Enorm 1-Z GLT-1	Flutes	Enorm 1-Z- IKZ GLT-1	Flutes	Enorm 1-Z/E	Flutes	Enorm 1-Z/E TIN	Flutes	Dimens. ID	Nominal Size ø d ₁	T.P.I.
●										●	2	●	2	.5000	No. 1	64
										●	2	●	2	.5001	No. 2	56
										●	2	●	2	.5002	No. 3	48
		●	2			●	2			●	2	●	2	.5003	No. 4	40
		●	2			●	3			●	3	●	3	.5004	No. 5	40
		●	3			●	3			●	3	●	3	.5005	No. 6	32
		●	3			●	3			●	3	●	3	.5006	No. 8	32
●	3	●	3	●	3	●	3	●	3	●	3	●	3	.5007	No. 10	24
										●	3	●	3	.5008	No. 12	24
●	3	●	3	●	3	●	3	●	3	●	3	●	3	.5009	1/4	20
●	3	●	3	●	3	●	3	●	3	●	3	●	3	.5010	5/16	18
●	3	●	3	●	3	●	3	●	3	●	3	●	3	.5011	3/8	16

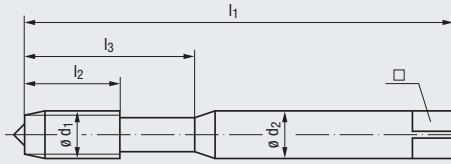
CU973701		CU573701		CU583701		CU503700		CU50C400		CU94C400		CU513500		CU513700		Tool Identification		
Rekord 2D-Z- IKZ TIN	Flutes	Rekord 2D-Z- BF TIN	Flutes	Rekord 2D-Z- BF IKZ-TIN	Flutes	Enorm 2-Z TIN	Flutes	Enorm 2-Z GLT-1	Flutes	Enorm 2-Z- IKZ GLT-1	Flutes	Enorm 2-Z/E	Flutes	Enorm 2-Z/E TIN	Flutes	Dimens. ID	Nominal Size ø d ₁	T.P.I.
●	3	●	3	●	3			●	4	●	4	●	4	●	4	.5012	7/16	14
●	3	●	3	●	3			●	4	●	4	●	4	●	4	.5013	1/2	13
●	3	●	3	●	3			●	4	●	4	●	4	●	4	.5014	9/16	12
●	3	●	3	●	3			●	4	●	4	●	4	●	4	.5015	5/8	11
●	3	●	3	●	3			●	4	●	4	●	4	●	4	.5016	3/4	10
		●	3	●	3			●	4	●	4	●	4	●	5	.5017	7/8	9
		●	3	●	3			●	4	●	4	●	5	●	5	.5018	1	8
		●	3	●	3	●	5	●	5	●	5			●	5	.5019	1 1/8	7
		●	4	●	4	●	5	●	5	●	5			●	5	.5020	1 1/4	7
				●	4	●	5	●	5	●	5			●	5	.5021	1 3/8	6
				●	4	●	5	●	5	●	5			●	5	.5022	1 1/2	6
						●	6	●	6	●	6			●	5	.5023	1 3/4	5
						●	6	●	6	●	6			●	2	.5024	2	4 1/2

● = In stock
★ = Allow 7 days for delivery

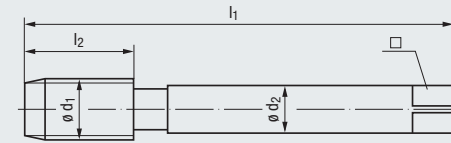
- Product Finder
- V_c
- UNC
- UNF
- UNEF
- UN-8
- M
- MF
- NPSM/NPSC
- NPSF
- Rp (BSPP)
- G
- NPT
- NPTF
- Rc (BSPT)
- STI
- SELF-LOCK
- Accessories
- Tech. Info

DIN Length - ANSI Shank

Overall length acc. to DIN 371, DIN 376



Reinforced Shank
(No.1 - 3/8)



Reduced Shank
(7/16 - 2)

UNC



Unified Coarse Thread
ASME B1.1

Class of Fit

Coating

Cutting Material

Technical Characteristics



Thread Depth
and Hole Shape

Applications - Material

Z
CNC-Controlled
Machines



2B	2B	2B	2B	3B
TICN	GLT-1	TICN	GLT-1	GLT-1
HSS Extra	HSS Extra	HSS Extra	HSS Extra	HSS Extra
R45	R45	R45	R45	R45
E / 1.5-2	E / 1.5-2	E / 1.5-2	E / 1.5-2	E / 1.5-2
E / O / P	E / O / P	E / O	E / O	E / O / P

max. 3 x d₁



P 1.1-4.1	P 1.1-4.1	P 1.1-4.1	P 1.1-4.1	P 1.1-4.1
M 1.1-3.1	M 1.1-3.1	M 1.1-3.1	M 1.1-3.1	M 1.1-3.1
N 1.4-6	N 1.4-6	N 1.4-6	N 1.4-6	N 1.4-6
N 2.1-2, 2.4-5	N 2.1-2, 2.4-5	N 2.1-2, 2.4-5	N 2.1-2, 2.4-5	N 2.1-2, 2.4-5
S 1.1	S 1.1	S 1.1	S 1.1	S 1.1

Reinforced Shank

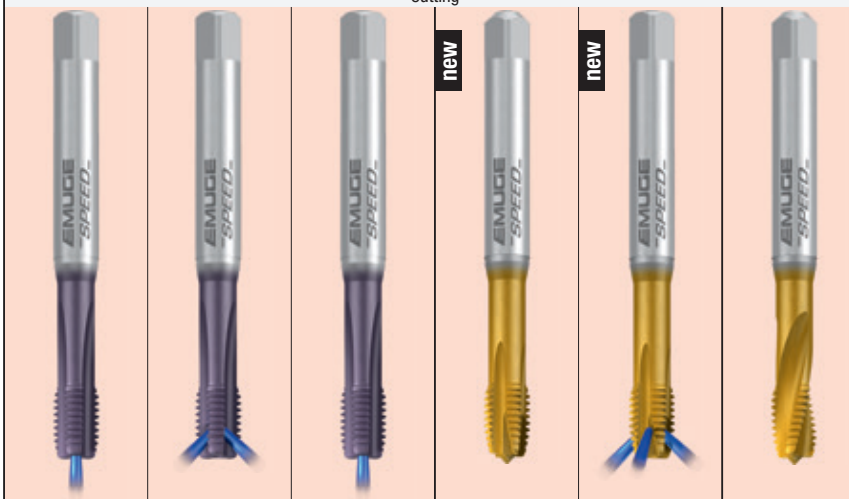
Nominal Size ø d ₁	T.P.I.	l ₁	l ₂	inch		ø d ₂	□	Tool Identification		BU519400		BU51C400		BU999400		BU99C400		BU51C410	
				l ₃	□			Enorm 1-Z/E TICN	Flutes	Enorm 1-Z/E GLT-1	Flutes	Enorm 1-Z/E-IKZ TICN	Flutes	Enorm 1-Z/E-IKZ GLT-1	Flutes	Enorm 1-Z/E GLT-1	Flutes		
No. 1	64	1.772	0.157	0.472	0.141	0.110		0.0595	.5000										
No. 2	56	1.772	0.177	0.472	0.141	0.110		0.0700	.5001										
No. 3	48	1.969	0.197	0.551	0.141	0.110		0.0820	.5002										
No. 4	40	2.205	0.236	0.709	0.141	0.110		0.0890	.5003	●	2	●	2					●	2
No. 5	40	2.205	0.276	0.709	0.141	0.110		0.1015	.5004	●	3	●	3					●	3
No. 6	32	2.205	0.276	0.787	0.141	0.110		0.1110	.5005	●	3	●	3					●	3
No. 8	32	2.480	0.315	0.827	0.168	0.131		0.1360	.5006	●	3	●	3					●	3
No.10	24	2.756	0.394	0.984	0.194	0.152		0.1520	.5007	●	3	●	3	●	3	●	3	●	3
No.12	24	3.150	0.394	1.142	0.220	0.165		0.1770	.5008										
1/4	20	3.150	0.512	1.181	0.255	0.191		0.2040	.5009	●	3	●	3	●	3	●	3	●	3
5/16	18	3.543	0.551	1.378	0.318	0.238		0.2610	.5010	●	3	●	3	●	3	●	3	●	3
3/8	16	3.937	0.630	1.535	0.381	0.286		0.3160	.5011	●	3	●	3	●	3	●	3	●	3

Reduced Shank

Nominal Size ø d ₁	T.P.I.	l ₁	l ₂	inch		ø d ₂	□	Tool Identification		CU519400		CU51C400		CU999400		CU99C400		CU51C410	
				l ₃	□			Enorm 2-Z/E TICN	Flutes	Enorm 2-Z/E GLT-1	Flutes	Enorm 2-Z/E-IKZ TICN	Flutes	Enorm 2-Z/E-IKZ GLT-1	Flutes	Enorm 2-Z/E GLT-1	Flutes		
7/16	14	3.937	0.709	—	0.323	0.242		0.3680	.5012	●	4	●	4	●	4	●	4	●	4
1/2	13	4.331	0.787	—	0.367	0.275		0.4219	.5013	●	4	●	4	●	4	●	4	●	4
9/16	12	4.331	0.787	—	0.429	0.322		0.4844	.5014	●	4	●	4	●	4	●	4	●	4
5/8	11	4.331	0.866	—	0.480	0.360		0.5313	.5015	●	4	●	4	●	4	●	4	●	4
3/4	10	4.921	0.984	—	0.590	0.442		0.6563	.5016	●	4	●	4	●	4	●	4	●	4
7/8	9	5.512	1.063	—	0.697	0.523		0.7656	.5017	●	5	●	5	●	5	●	5	●	5
1	8	6.299	1.181	—	0.800	0.600		0.8750	.5018	●	5	●	5	●	5	●	5	●	5
1 1/8	7	7.087	1.378	—	0.896	0.672		0.9843	.5019										
1 1/4	7	7.087	1.378	—	1.021	0.766		1.1094	.5020										
1 3/8	6	7.874	1.575	—	1.108	0.831		1.2205	.5021										
1 1/2	6	7.874	1.575	—	1.233	0.925		1.3386	.5022										
1 3/4	5	8.661	1.772	—	1.430	1.072		1.5551	.5023										
2	4 1/2	9.843	1.969	—	1.644	1.233		1.7812	.5024										

Z
CNC-Controlled
Machines

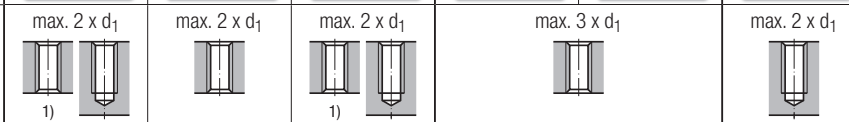
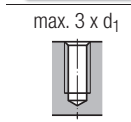
SPEED
High-Speed
Cutting



- 3B**
- GLT-1
- HSS Extra
- R45
- E / 1.5-2**
- E / O

- | | | | | | | |
|-----------|-----------|------------------|----------------|----------------|-----------|-----|
| 2BX | 2BX | 2BX | 2BX | 2BX | 2BX | 2BX |
| TICN | TICN | TICN | TIN-70 | TIN-70 | TIN | |
| HSS Extra | HSS Extra | HSS Extra | HSSE-PM | HSSE-PM | HSS Extra | |
| C / 2-3 | C / 2-3 | E / 1.5-2 | B / 4-5 | B / 4-5 | R15 | |
| E | E | E | E | E | C / 2-3 | |
| | | | | | E | |

Class of Fit
Coating
Cutting Material
Technical Characteristics



Thread Depth
and Hole Shape

- P 1.1-4.1**
- M 1.1-3.1**
- N 1.4-6**
- N 2.1-2, 2.4-5**
- S 1.1**

- | | | | | | |
|------------------|------------------|------------------|------------------|------------------|------------------|
| K 1.1-4.2 | K 1.1-4.2 | K 1.1-4.2 | P 1.1-4.1 | P 1.1-4.1 | P 1.1-4.1 |
| N 1.4-6 | N 1.4-6 | N 1.4-6 | K 2.1-2 | K 2.1-2 | M 1.1-3.1 |
| | | | N 1.4-6 | N 1.4-6 | K 2.1-2 |
| | | | | | N 1.4-2.1 |

Applications – Material

BU99C410		BW159401		BW179401		BW169401		BW138F01		BW208F01		BU263701		Tool Identification		
Enorm 1-Z/E-IKZ GLT-1	Flutes	Rekord 1A-SPEED IKZ-TICN	Flutes	Rekord 1A-SPEED IKZN-TICN	Flutes	Rekord 1A-SPEED/E IKZ-TICN	Flutes	Rekord 1B-Z-SPEED PM-TIN-70	Flutes	Rekord 1B-Z-SPEED IKZN-PM TIN-70	Flutes	Rekord 1D-SPEED TIN	Flutes	Dimens. ID	Nominal Size ø d ₁	T.P.I.
														.5000	No. 1	64
														.5001	No. 2	56
														.5002	No. 3	48
								●	2			●	2	.5003	No. 4	40
								●	3			●	2	.5004	No. 5	40
								●	3			●	3	.5005	No. 6	32
								●	3			●	3	.5006	No. 8	32
●	3							●	3	●	3	●	3	.5007	No. 10	24
														.5008	No. 12	24
●	3	●	3	●	3	●	3	●	3	●	3	●	3	.5009	1/4	20
●	3	●	3	●	3	●	3	●	4	●	4	●	3	.5010	5/16	18
●	3	●	3	●	3	●	3	●	4	●	4	●	3	.5011	3/8	16

CU99C410		CW159401		CW179401		CW169401		CW138F01		CW208F01		CU263701		Tool Identification		
Enorm 2-Z/E-IKZ GLT-1	Flutes	Rekord 2A-SPEED IKZ-TICN	Flutes	Rekord 2A-SPEED IKZN-TICN	Flutes	Rekord 2A-SPEED/E IKZ-TICN	Flutes	Rekord 2B-Z-SPEED PM-TIN-70	Flutes	Rekord 2B-Z-SPEED IKZN-PM TIN-70	Flutes	Rekord 2D-SPEED TIN	Flutes	Dimens. ID	Nominal Size ø d ₁	T.P.I.
●	4	●	3	●	3	●	3	●	4	●	4	●	3	.5012	7/16	14
●	4	●	3	●	3	●	3	●	4	●	4	●	3	.5013	1/2	13
●	4	●	3	●	3	●	3	●	4	●	4	●	3	.5014	9/16	12
●	4	●	3	●	3	●	3	●	4	●	4	●	3	.5015	5/8	11
●	4	●	4	●	4	●	4	●	4	●	4	●	3	.5016	3/4	10
		●	4	●	4	●	4							.5017	7/8	9
		●	4	●	4	●	4							.5018	1	8
														.5019	1 1/8	7
														.5020	1 1/4	7
														.5021	1 3/8	6
														.5022	1 1/2	6
														.5023	1 3/4	5
														.5024	2	4 1/2

● = In stock
★ = Allow 7 days for delivery

1) Threading in through holes is possible only with external cooling/lubrication



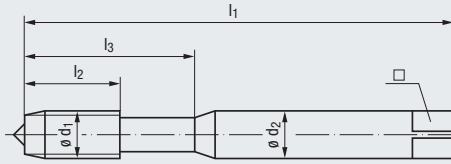
- Product Finder
- V_c
- UNC
- UNF
- UNEF
- UN-8
- MF
- NPSM/NPSC
- NPSF
- Rp (BSPP)
- G
- NPT
- NPTF
- Rc (BSPT)
- STI
- SELF-LOCK
- Accessories
- Tech. Info



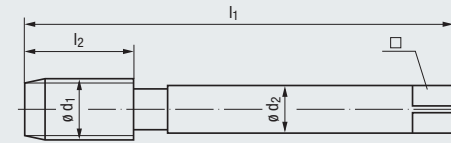
- Product Finder
- V_c
- UNC
- UNF
- UNEF
- UN-8
- M
- MF
- NPSM/NPSC
- NPSF
- Rp (BSPP)
- G
- NPT
- NPTF
- Rc (BSPT)
- STI
- SELF-LOCK
- Accessories
- Tech. Info

DIN Length - ANSI Shank

Overall length acc. to DIN 371, DIN 376



Reinforced Shank
(No.1 - 3/8)



Reduced Shank
(7/16 - 2)



SPEED
High-Speed
Cutting

UNC

**Unified Coarse Thread
ASME B1.1**

Class of Fit
Coating
Cutting Material
Technical Characteristics

Thread Depth
and Hole Shape

Applications - Material

2BX	2B
TIN	TIN
HSS Extra	HSS Extra
R15	R45
C / 2-3	C / 2-3
E	E

max. 2 x d ₁	max. 3 x d ₁

P 1.1-4.1	P 1.1-4.1
M 1.1-3.1	M 1.1-3.1
K 2.1-2	K 2.1
N 1.4-2.1	N 1.1-2.2

Reinforced Shank

								Tool Identification		BU293701		BW553700	
Nominal Size ø d ₁	T.P.I.	l ₁	l ₂	inch		ø d ₂	□		Dimens. ID	Rekord	Enorm	Flutes	Flutes
				1D-SPEED	1-SPEED								
										IKZ-TIN	IKZ-TIN		
No. 1	64	1.772	0.157	0.472	0.141	0.110		0.0595	.5000				
No. 2	56	1.772	0.177	0.472	0.141	0.110		0.0700	.5001				
No. 3	48	1.969	0.197	0.551	0.141	0.110		0.0820	.5002				
No. 4	40	2.205	0.236	0.709	0.141	0.110		0.0890	.5003				
No. 5	40	2.205	0.276	0.709	0.141	0.110		0.1015	.5004				
No. 6	32	2.205	0.276	0.787	0.141	0.110		0.1110	.5005				
No. 8	32	2.480	0.315	0.827	0.168	0.131		0.1360	.5006				
No.10	24	2.756	0.394	0.984	0.194	0.152		0.1520	.5007	●	3		
No.12	24	3.150	0.394	1.142	0.220	0.165		0.1770	.5008				
1/4	20	3.150	0.512	1.181	0.255	0.191		0.2040	.5009	●	3	●	3
5/16	18	3.543	0.551	1.378	0.318	0.238		0.2610	.5010	●	3	●	3
3/8	16	3.937	0.630	1.535	0.381	0.286		0.3160	.5011	●	3	●	3

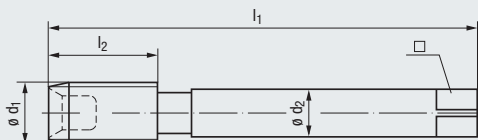
Reduced Shank

								Tool Identification		CU293701		CW553700	
Nominal Size ø d ₁	T.P.I.	l ₁	l ₂	inch		ø d ₂	□		Dimens. ID	Rekord	Enorm	Flutes	Flutes
				2D-SPEED	2-SPEED								
										IKZ-TIN	IKZ-TIN		
7/16	14	3.937	0.709	—	0.323	0.242		0.3680	.5012	●	3	●	4
1/2	13	4.331	0.787	—	0.367	0.275		0.4219	.5013	●	3	●	4
9/16	12	4.331	0.787	—	0.429	0.322		0.4844	.5014				
5/8	11	4.331	0.866	—	0.480	0.360		0.5313	.5015	●	3	●	4
3/4	10	4.921	0.984	—	0.590	0.442		0.6563	.5016	●	3	●	4
7/8	9	5.512	1.063	—	0.697	0.523		0.7656	.5017				
1	8	6.299	1.181	—	0.800	0.600		0.8750	.5018				
1 1/8	7	7.087	1.378	—	0.896	0.672		0.9843	.5019				
1 1/4	7	7.087	1.378	—	1.021	0.766		1.1094	.5020				
1 3/8	6	7.874	1.575	—	1.108	0.831		1.2205	.5021				
1 1/2	6	7.874	1.575	—	1.233	0.925		1.3386	.5022				
1 3/4	5	8.661	1.772	—	1.430	1.072		1.5551	.5023				
2	4 1/2	9.843	1.969	—	1.644	1.233		1.7812	.5024				

DIN Length • ANSI Shank

Overall length acc. to DIN 376

With internal chip collector

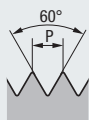


Reduced Shank

VA
Stainless Steel
Materials



UNC



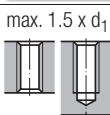
Unified Coarse Thread
ASME B1.1

Class of Fit
Coating
Cutting Material
Technical Characteristics



- 3BX 2)**
- NE2
- HSS Extra
- C / 2-3
- P / O 1)

Thread Depth
and Hole Shape



Applications – Material

- P 1.1-4.1**
- M 1.1-2.1**
- K 1.1-4.2**

Reduced Shank

Tool Identification

CU803011

Nominal Size ø d ₁	T.P.I.	inch				□	Image	Dimens. ID	Robust 2X-VA NE2	Flutes
		l ₁	l ₂	ø d ₂						
3/4	10	4.921	1.181	0.590	0.442	0.6563	.5016	●	5	
7/8	9	5.512	1.260	0.697	0.523	0.7656	.5017	●	5	
1	8	6.299	1.417	0.800	0.600	0.8750	.5018	●	5	
1 1/8	7	7.087	1.575	0.896	0.672	0.9843	.5019	●	5	
1 1/4	7	7.087	1.575	1.021	0.766	1.1094	.5020	●	6	
1 3/8	6	7.874	1.969	1.108	0.831	1.2205	.5021	●	6	
1 1/2	6	7.874	1.969	1.233	0.925	1.3386	.5022	●	6	
1 3/4	5	8.661	2.283	1.430	1.072	1.5551	.5023	●	6	
2	4 1/2	9.843	2.559	1.644	1.233	1.7812	.5024	●	6	

1) If possible, use paste lubrication, coating both the tool and the walls of the drilled hole. Lubrication with oil is possible only in the vertical machining of blind holes, if the hole is entirely filled with oil.

2) Class 2B threads may be produced with 3BX taps.

Larger sizes priced upon request. We have experience in making taps as large as 10 inches ø UN.

The Complete Tool System

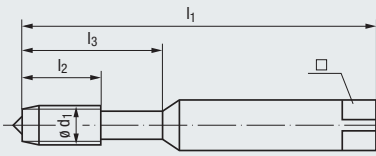
Robust 2X-VA Taps when used with a KSN Type tapping attachment creates the optimal tapping unit!

- Product Finder
- V_c
- UNC
- UNF
- UNEF
- UN-8
- ...
- MF
- NPSM/NPSC
- NPSF
- R_p (BSPP)
- G
- NPT
- NTF
- R_c (BSPT)
- STI
- SELF-LOCK
- Accessories
- Tech. Info

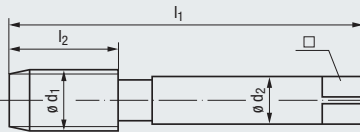


- Product Finder
- V_c
- UNC
- UNF
- UNEF
- UN-8
- M
- MF
- NPSM/NPSC
- NPSF
- Rp (BSPP)
- G
- NPT
- NPTF
- Rc (BSPT)
- STI
- SELF-LOCK
- Accessories
- Tech. Info

ANSI Length · ANSI Shank



Reinforced Shank
(No.4 - 3/8)



Reduced Shank
(7/16 - 3/4)

STEEL
Steel
Materials



VA
Stainless Steel
Materials



UNC

**Unified Coarse Thread
ASME B1.1**

Class of Fit: 2B
Coating: TIN
Cutting Material: HSS Extra
Technical Characteristics: B / 4-5, E / O

Thread Depth and Hole Shape: max. 3 x d₁

Applications – Material

2B	3B	Override
TIN	NT	NT
HSS Extra	HSS Extra	HSS Extra
B / 4-5	B / 4-5	B / 4-5
E / O	E / O / P	E / O / P



P 1.1-4.1	P 1.1-3.1	P 1.1-3.1	P 1.1-3.1
K 2.1	M 1.1-2.1	M 1.1-2.1	M 1.1-2.1
N 2.2, 2.4-5	K 2.1	K 2.1	K 2.1
	N 2.2, 2.5-6	N 2.2, 2.5-6	N 2.2, 2.5-6

Nominal Size ø d ₁	T.P.I.	inch						□	Tool Identification	AU208400		AU203000		AU203010		AU203044	
		l ₁	l ₂	l ₃	ø d ₂	Flutes	Rekord B-STEEL-L TIN			Flutes	Rekord B-VA NT	Flutes	Rekord B-VA NT	Flutes			
No. 4	40	1 7/8	1.88	0.433	0.709	0.141	0.110	0.0890	.5003	●	2	●	2				
No. 5	40	1 15/16	1.94	0.433	0.709	0.141	0.110	0.1015	.5004	●	3	●	3				
No. 6	32	2	2.00	0.472	0.748	0.141	0.110	0.1110	.5005	●	3	●	3				
No. 8	32	2 1/8	2.13	0.512	0.827	0.168	0.131	0.1360	.5006	●	3	●	3				
No. 10	24	2 3/8	2.38	0.591	0.945	0.194	0.152	0.1520	.5007	●	3	●	3				
1/4	20	2 1/2	2.50	0.669	1.142	0.255	0.191	0.2040	.5009	●	3	●	3	●	3	1) ● (+.0035) 3	
5/16	18	2 23/32	2.72	0.787	1.299	0.318	0.238	0.2610	.5010	●	3	●	3	●	3	● (+.0050) 3	
3/8	16	2 15/16	2.94	0.866	1.378	0.381	0.286	0.3160	.5011	●	3	●	3	●	3	● (+.0050) 3	
7/16	14	3 5/32	3.16	0.866	—	0.323	0.242	0.3680	.5012	●	3	●	3	●	3	● (+.0050) 3	
1/2	13	3 3/8	3.38	0.984	—	0.367	0.275	0.4219	.5013	●	3	●	3	●	3	● (+.0050) 3	
9/16	12	3 19/32	3.59	1.024	—	0.429	0.322	0.4844	.5014	●	3	●	3				
5/8	11	3 13/16	3.81	1.063	—	0.480	0.360	0.5313	.5015	●	3	●	3	●	3	● (+.0050) 3	
3/4	10	4 1/4	4.25	1.181	—	0.590	0.442	0.6563	.5016	●	3	●	3				

1) Tool Identification = AU203043

DIN Length · ANSI Shank



All ANSI Length · ANSI Shank taps are available in the popular DIN Length · ANSI Shank style.

The DIN Length · ANSI Shank configuration allows for added reach capabilities and greater chip clearance.

VA Stainless Steel Materials						TI Titanium						Tool Identification				
2B	3B	Override				2BX	3BX	2BX	3BX	Class of Fit						
NE2	NE2	NE2				NT2	NT2	NT2	NT2	Coating						
HSS Extra	HSS Extra	HSS Extra				HSS Extra	HSS Extra	HSS Extra	HSS Extra	Cutting Material						
R35	R35	R35				L15	L15	R15	R15	Technical Characteristics						
C / 2-3	C / 2-3	C / 2-3				D / 4-5	D / 4-5	C / 2-3	C / 2-3							
E / O / P	E / O / P	E / O / P				E / O / P	E / O / P	E / O / P	E / O / P							
max. 2.5 x d ₁						max. 3 x d ₁				max. 2 x d ₁		Thread Depth and Hole Shape				
P 1.1-3.1	P 1.1-3.1	P 1.1-3.1				P 4.1-5.1	P 4.1-5.1	P 4.1-5.1	P 4.1-5.1	Applications – Material						
M 1.1-2.1	M 1.1-2.1	M 1.1-2.1				M 3.1-4.1	M 3.1-4.1	M 3.1-4.1	M 3.1-4.1							
K 2.1	K 2.1	K 2.1				N 2.4-5, 2, 7	N 2.4-5, 2, 7	N 2.4-5, 2, 7	N 2.4-5, 2, 7							
						S 1.1-2, 2, 2, 4	S 1.1-2, 2, 2, 4	S 1.1-2, 2, 2, 4	S 1.1-2, 2, 2, 4							
AU503200		AU503210		AU503244		AU306001		AU306011		AU456001		AU456011				
Enorm VA NE2	Flutes	Enorm VA NE2	Flutes	Enorm VA NE2	Flutes	Rekord C-TI NT2	Flutes	Rekord C-TI NT2	Flutes	Rekord D-TI NT2	Flutes	Rekord D-TI NT2	Flutes	Dimens. ID	Nominal Size ø d ₁	T.P.I.
●	2					●	2			●	2			.5003	No. 4	40
●	3					●	2			●	2			.5004	No. 5	40
●	3					●	3			●	3			.5005	No. 6	32
●	3					●	3			●	3			.5006	No. 8	32
●	3			2) ● (+.0035)	3	●	3			●	3			.5007	No. 10	24
●	3	●	3	● (+.0050)	3	●	3	●	3	●	3	●	3	.5009	1/4	20
●	3	●	3	● (+.0050)	3	●	3	●	3	●	3	●	3	.5010	5/16	18
●	3	●	3	● (+.0050)	3	●	3	●	3	●	3	●	3	.5011	3/8	16
●	3	●	3	● (+.0050)	3	●	3	●	3	●	3	●	3	.5012	7/16	14
●	3	●	3	● (+.0050)	3	●	3	●	3	●	3	●	3	.5013	1/2	13
●	3					●	3			●	3			.5014	9/16	12
●	3			● (+.0050)	3	●	3	●	3	●	3	●	3	.5015	5/8	11
●	3					●	3	●	3	●	3	●	3	.5016	3/4	10

2) Tool Identification = AU503243

Product Finder

V_c

UNC

UNF

UNEF

UN-8

...

MF

NPSM/NPSC

NPSF

Rp (BSPP)

G

NPT

NTF

Rc (BSPT)

STI

SELF-LOCK

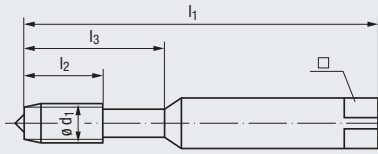
Accessories

Tech. Info

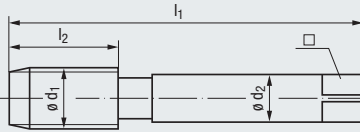


- Product Finder
- V_c
- UNC
- UNF
- UNEF
- UN-8
- M
- MF
- NPSM/NPSC
- NPSF
- Rp (BSPP)
- G
- NPT
- NPTF
- Rc (BSPT)
- STI
- SELF-LOCK
- Accessories
- Tech. Info

ANSI Length • ANSI Shank



Reinforced Shank
(No.4 - 3/8)



Reduced Shank
(7/16 - 3/4)



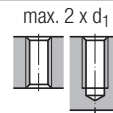
UNC

**Unified Coarse Thread
ASME B1.1**

Class of Fit
Coating
Cutting Material
Technical Characteristics

2BX	2BX
NT	TICN
HSS Extra	HSS Extra
C / 2-3	C / 2-3
E / O / P	E / O / P

Thread Depth
and Hole Shape

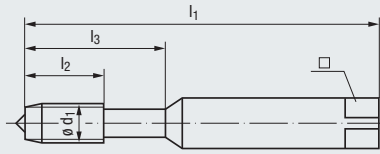


Applications – Material

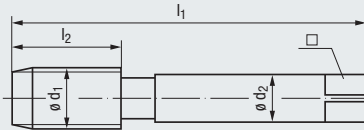
P 1.1-3.1	P 1.1-4.1
K 1.1-4.2	K 1.1-4.2
N 2.4-7	N 2.4-7
N 4.1, 5.1	N 4.1, 5.1

Nominal Size ø d ₁	T.P.I.	inch				ø d ₂	□	Tool Identification	AU100501		AU109101		
		l ₁	l ₂	l ₃	□				Rekord A-H NT	Flutes	Rekord A-H TICN	Flutes	
No. 4	40	1 7/8	1.88	0.433	0.709	0.141	0.110	0.0890	.5003	●	3	●	3
No. 5	40	1 15/16	1.94	0.433	0.709	0.141	0.110	0.1015	.5004	●	3	●	3
No. 6	32	2	2.00	0.472	0.748	0.141	0.110	0.1110	.5005	●	3	●	3
No. 8	32	2 1/8	2.13	0.512	0.827	0.168	0.131	0.1360	.5006	●	3	●	3
No. 10	24	2 3/8	2.38	0.591	0.945	0.194	0.152	0.1520	.5007	●	3	●	3
1/4	20	2 1/2	2.50	0.669	1.142	0.255	0.191	0.2040	.5009	●	3	●	3
5/16	18	2 23/32	2.72	0.787	1.299	0.318	0.238	0.2610	.5010	●	3	●	3
3/8	16	2 15/16	2.94	0.866	1.378	0.381	0.286	0.3160	.5011	●	3	●	3
7/16	14	3 5/32	3.16	0.866	—	0.323	0.242	0.3680	.5012	●	3	●	3
1/2	13	3 3/8	3.38	0.984	—	0.367	0.275	0.4219	.5013	●	3	●	3
9/16	12	3 19/32	3.59	1.024	—	0.429	0.322	0.4844	.5014	●	3	●	3
5/8	11	3 13/16	3.81	1.063	—	0.480	0.360	0.5313	.5015	●	3	●	3
3/4	10	4 1/4	4.25	1.181	—	0.590	0.442	0.6563	.5016	●	4	●	4

ANSI Length · ANSI Shank



Reinforced Shank
(No.4 - 3/8)



Reduced Shank
(7/16 - 3/4)

UNC



Unified Coarse Thread
ASME B1.1

Class of Fit: 2B, 3B
Coating: TIN
Cutting Material: HSS Extra
Technical Characteristics: R45, E / 1.5-2, E / O / P



Thread Depth and Hole Shape

Applications – Material

P 1.1-4.1	P 1.1-4.1	P 1.1-4.1	P 1.1-4.1
M 1.1-2.1	M 1.1-3.1	M 1.1-2.1	M 1.1-3.1
N 2.1	N 1.4-6	N 2.1	N 1.4-6
	N 2.1-2, 2.4-5		N 2.1-2, 2.4-5
	S 1.1		S 1.1

max. 3 x d₁



Tool Identification: AU513500, AU513700, AU513510, AU513710

Nominal Size ø d ₁	T.P.I.	inch				ø d ₂	□	Dimens. ID	AU513500		AU513700		AU513510		AU513710	
		l ₁	l ₂	l ₃	□				Enorm Z/E	Flutes	Enorm Z/E TIN	Flutes	Enorm Z/E	Flutes	Enorm Z/E TIN	Flutes
No. 4	40	1 7/8	1.88	0.236	0.709	0.141	0.110	0.0890	.5003	●	2	●	2			
No. 5	40	1 15/16	1.94	0.276	0.709	0.141	0.110	0.1015	.5004	●	3	●	3			
No. 6	32	2	2.00	0.276	0.748	0.141	0.110	0.1110	.5005	●	3	●	3			
No. 8	32	2 1/8	2.13	0.315	0.827	0.168	0.131	0.1360	.5006	●	3	●	3			
No. 10	24	2 3/8	2.38	0.354	0.945	0.194	0.152	0.1520	.5007	●	3	●	3			
1/4	20	2 1/2	2.50	0.512	1.142	0.255	0.191	0.2040	.5009	●	3	●	3	●	3	●
5/16	18	2 23/32	2.72	0.551	1.299	0.318	0.238	0.2610	.5010	●	3	●	3	●	3	●
3/8	16	2 15/16	2.94	0.630	1.378	0.381	0.286	0.3160	.5011	●	3	●	3	●	3	●
7/16	14	3 5/32	3.16	0.709	—	0.323	0.242	0.3680	.5012	●	4	●	4	●	4	●
1/2	13	3 3/8	3.38	0.787	—	0.367	0.275	0.4219	.5013	●	4	●	4	●	4	●
9/16	12	3 19/32	3.59	0.787	—	0.429	0.322	0.4844	.5014	●	4	●	4			
5/8	11	3 13/16	3.81	0.866	—	0.480	0.360	0.5313	.5015	●	4	●	4			
3/4	10	4 1/4	4.25	0.984	—	0.590	0.442	0.6563	.5016	●	4	●	4			

- Product Finder
- V_c
- UNC
- UNF
- UNEF
- UN-8
- MF
- NPSM/NPSC
- NPSF
- Rp (BSPP)
- G
- NPT
- NPTF
- Rc (BSPT)
- STI
- SELF-LOCK
- Accessories
- Tech. Info



DIN Length · ANSI Shank



All ANSI Length · ANSI Shank taps are available in the popular DIN Length · ANSI Shank style.

The DIN Length · ANSI Shank configuration allows for added reach capabilities and greater chip clearance.

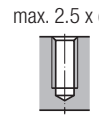
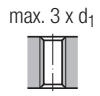
● = In stock
★ = Allow 7 days for delivery

VA
Stainless Steel
Materials



new	new	new	new	new	new	new	new
2B	2B	3B	Enlarge	2B	2B	3B	3B
GLT-1	TICN	GLT-1	GLT-1	NE2	GLT-1	NE2	GLT-1
HSS Extra	HSS Extra	HSS Extra	HSS Extra	HSS Extra	HSS Extra	HSS Extra	HSS Extra
B / 4-5	B / 4-5	B / 4-5	B / 4-5	R35	R35	R35	R35
E / O / P	E / O / P	E / O / P	E / O / P	C / 2-3	C / 2-3	C / 2-3	C / 2-3
				E / O / P	E / O / P	E / O / P	E / O / P

Class of Fit
Coating
Cutting Material
Technical Characteristics



Thread Depth
and Hole Shape

P 1.1-4.1	P 1.1-4.1	P 1.1-4.1	P 1.1-4.1	P 1.1-3.1	P 1.1-4.1	P 1.1-3.1	P 1.1-4.1
M 1.1-3.1	M 1.1-3.1	M 1.1-3.1	M 1.1-3.1	M 1.1-2.1	M 1.1-3.1	M 1.1-2.1	M 1.1-3.1
K 2.1	K 2.1	K 2.1	K 2.1	K 2.1	K 2.1	K 2.1	K 2.1
N 2.2	N 2.2, 2.5-6	N 2.2	N 2.2				

Applications – Material

BU20C300		BU089300		BU20C310		BU20C344		BU503200		BU50C300		BU503210		BU50C310		Tool Identification		
Rekord 1B-VA GLT-1	Flutes	Rekord 1B-VA-1KZN TICN	Flutes	Rekord 1B-VA GLT-1	Flutes	Rekord 1B-VA GLT-1	Flutes	Enorm 1-VA NE2	Flutes	Enorm 1-VA GLT-1	Flutes	Enorm 1-VA NE2	Flutes	Enorm 1-VA GLT-1	Flutes	Dimens. ID	Nominal Size ø d ₁	T.P.I.
●	2			●	2			●	2	●	2	●	2	●	2	.5033	No. 0	80
●	2			●	2			●	2	●	2	●	2	●	2	.5034	No. 1	72
●	2			●	2			●	2	●	2	●	2	●	2	.5035	No. 2	64
●	2			●	2			●	2	●	2	●	2	●	2	.5036	No. 3	56
●	2			●	2			●	2	●	2	●	2	●	2	.5037	No. 4	48
●	3			●	3			●	3	●	3	●	3	●	3	.5038	No. 5	44
●	3			●	3			●	3	●	3	●	3	●	3	.5039	No. 6	40
●	3			●	3			●	3	●	3	●	3	●	3	.5040	No. 8	36
●	3	●	3	●	3			●	3	●	3	●	3	●	3	.5041	No. 10	32
●	3			●	3			●	3	●	3	●	3	●	3	.5042	No. 12	28
●	3	●	3	●	3			●	3	●	3	●	3	●	3	.5043	1/4	28
●	3	●	3	●	3			●	3	●	3	●	3	●	3	.5044	5/16	24
●	4	●	4	●	4			●	3	●	3	●	3	●	3	.5045	3/8	24

CU20C300		CU089300		CU20C310		CU20C344		CU503200		CU50C300		CU503210		CU50C310		Tool Identification		
Rekord 2B-VA GLT-1	Flutes	Rekord 2B-VA-1KZN TICN	Flutes	Rekord 2B-VA GLT-1	Flutes	Rekord 2B-VA GLT-1	Flutes	Enorm 2-VA NE2	Flutes	Enorm 2-VA GLT-1	Flutes	Enorm 2-VA NE2	Flutes	Enorm 2-VA GLT-1	Flutes	Dimens. ID	Nominal Size ø d ₁	T.P.I.
●	3	●	3	●	3	● (+.0050)	3	●	3	●	3	●	3	●	3	.5046	7/16	20
●	3	●	3	●	3	● (+.0050)	3	●	4	●	4	●	4	●	4	.5047	1/2	20
●	3			●	3			●	4	●	4	●	4	●	4	.5048	9/16	18
●	3			●	3	● (+.0050)	3	●	4	●	4	●	4	●	4	.5049	5/8	18
●	4			●	4			●	4	●	4	●	4	●	4	.5050	3/4	16
●	4			●	4			●	4	●	4	●	4	●	4	.5051	7/8	14
●	4			●	4			●	4	●	4	●	4	●	4	.5052	1	12
●	4			●	4			●	4	●	4	●	4	●	4	.5053	1 1/8	12
●	4			●	4			●	5	●	5	●	5	●	5	.5054	1 1/4	12
●	5			●	5			●	5	●	5	●	5	●	5	.5055	1 3/8	12
●	5			●	5			●	6	●	6	●	6	●	6	.5056	1 1/2	12

● = In stock
★ = Allow 7 days for delivery

1) Tool Identification = BU20C343

Product Finder

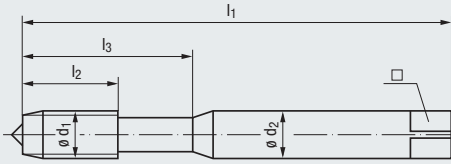
- V_c
- UNC
- UNF
- UNEF
- UN-8
- MF
- NPSM/NPSC
- NPSF
- R_p (BSP)
- G
- NPT
- NPTF
- Rc (BSPT)
- STI
- SELF-LOCK
- Accessories
- Tech. Info



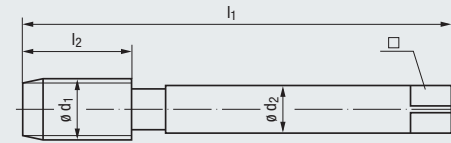
- Product Finder
- V_c
- UNC
- UNF
- UNEF
- UN-8
- M
- MF
- NPSM/NPSC
- NPSF
- Rp (BSPP)
- G
- NPT
- NPTF
- Rc (BSPT)
- STI
- SELF-LOCK
- Accessories
- Tech. Info

DIN Length - ANSI Shank

Overall length acc. to DIN 371, DIN 374



Reinforced Shank
(No.0 - 3/8)



Reduced Shank
(7/16 - 1 1/2)

VA
Stainless Steel
Materials



AL
Aluminum
Wrought Alloys



UNF
Unified Fine Thread
ASME B1.1

Class of Fit: **Enlarge**
Coating: **GLT-1**
Cutting Material: **HSS Extra**
Technical Characteristics: **R35**
C / 2-3
E / O / P

Thread Depth and Hole Shape

Applications - Material

2B
GLT-8
HSS Extra
R45
B / approx. 3
E / O

max. 3 x d₁



2B
GLT-8
HSS Extra
R45
C / 2-3
E / O

max. 2.5 x d₁



3B
GLT-8
HSS Extra
R45
C / 2-3
E / O

max. 2.5 x d₁



P 1.1-4.1
M 1.1-3.1
K 2.1

N 1.1-4

N 1.1-4

N 1.1-4

Reinforced Shank

Nominal Size ø d ₁	T.P.I.	inch					□	Tool Identification		BU50C344		BU20S800		BU50S800		BU50S810	
		l ₁	l ₂	l ₃	ø d ₂	□		Dimens. ID	Enorm 1-VA GLT-1	Flutes	Rekord 1B-AL GLT-8	Flutes	Enorm 1-AL GLT-8	Flutes	Enorm 1-AL GLT-8	Flutes	
No. 0	80	1.626	0.236	0.433	0.141	0.110	0.0480	.5033			●	2	●	2			
No. 1	72	1.772	0.276	0.472	0.141	0.110	0.0595	.5034			●	2	●	2			
No. 2	64	1.772	0.276	0.472	0.141	0.110	0.0730	.5035			●	2	●	2			
No. 3	56	1.969	0.354	0.551	0.141	0.110	0.0827	.5036			●	2	●	2			
No. 4	48	2.205	0.433	0.709	0.141	0.110	0.0945	.5037			●	2	●	2			
No. 5	44	2.205	0.433	0.709	0.141	0.110	0.1063	.5038			●	2	●	2			
No. 6	40	2.205	0.472	0.787	0.141	0.110	0.1181	.5039	1) ● (+.0035)	3	●	2	●	2			
No. 8	36	2.480	0.512	0.827	0.168	0.131	0.1378	.5040	1) ● (+.0035)	3	●	2	●	2			
No. 10	32	2.756	0.512	0.984	0.194	0.152	0.1614	.5041	1) ● (+.0035)	3	●	2	●	2	●	2	
No. 12	28	3.150	0.630	1.142	0.220	0.165	0.1820	.5042			●	2	●	2			
1/4	28	3.150	0.669	1.181	0.255	0.191	0.2165	.5043	● (+.0050)	3	●	2	●	2	●	2	
5/16	24	3.543	0.669	1.260	0.318	0.238	0.2717	.5044	● (+.0050)	3	●	2	●	2	●	2	
3/8	24	3.937	0.709	1.535	0.381	0.286	0.3346	.5045	● (+.0050)	3	●	3	●	2	●	2	

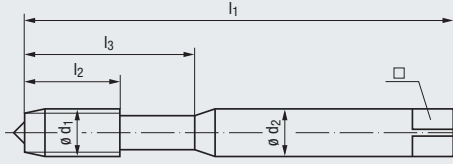
Reduced Shank

Nominal Size ø d ₁	T.P.I.	inch					□	Tool Identification		CU50C344		CU20S800		CU50S800		CU50S810	
		l ₁	l ₂	l ₃	ø d ₂	□		Dimens. ID	Enorm 2-VA GLT-1	Flutes	Rekord 2B-AL GLT-8	Flutes	Enorm 2-AL GLT-8	Flutes	Enorm 2-AL GLT-8	Flutes	
7/16	20	3.937	0.866	—	0.323	0.242	0.3898	.5046	● (+.0050)	3	●	3	●	3	●	3	
1/2	20	3.937	0.866	—	0.367	0.275	0.4528	.5047	● (+.0050)	4	●	3	●	4	●	4	
9/16	18	3.937	0.866	—	0.429	0.322	0.5118	.5048			●	3	●	4	●	4	
5/8	18	3.937	0.866	—	0.480	0.360	0.5709	.5049	● (+.0050)	4	●	3	●	4	●	4	
3/4	16	4.331	0.984	—	0.590	0.442	0.6890	.5050			●	4	●	4	●	4	
7/8	14	4.921	1.024	—	0.697	0.523	0.8071	.5051									
1	12	5.512	1.102	—	0.800	0.600	0.9219	.5052									
1 1/8	12	5.906	1.181	—	0.896	0.672	1.0433	.5053									
1 1/4	12	5.906	1.181	—	1.021	0.766	1.1719	.5054									
1 3/8	12	6.693	1.299	—	1.108	0.831	1.2992	.5055									
1 1/2	12	6.693	1.299	—	1.233	0.925	1.4173	.5056									

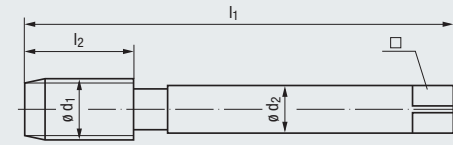
- Product Finder
- V_c
- UNC
- UNF
- UNEF
- UN-8
- M
- MF
- NPSM/NPSC
- NPSF
- Rp (BSPP)
- G
- NPT
- NPTF
- Rc (BSPT)
- STI
- SELF-LOCK
- Accessories
- Tech. Info

DIN Length - ANSI Shank

Overall length acc. to DIN 371, DIN 374



Reinforced Shank
(No.0 - 3/8)



Reduced Shank
(7/16 - 1 1/2)

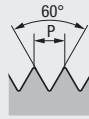
NI
Nickel
Alloys



H
Materials of High
Tensile Strength



UNF



Unified Fine Thread
ASME B1.1

Class of Fit
Coating
Cutting Material
Technical Characteristics



Thread Depth
and Hole Shape

Applications - Material








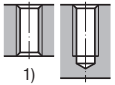
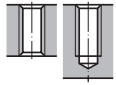
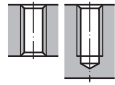
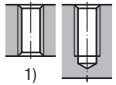

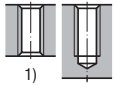
3BX	3BX	2BX	2BX
TICN	TICN	NT	TICN
HSSE-PM	HSSE-PM	HSS Extra	HSS Extra
L08	R10	C / 2-3	C / 2-3
D / 4-5	C / 2-3	E / O / P	E / O / P
O / P	O / P		
max. 3 x d ₁	max. 2 x d ₁	max. 2 x d ₁	
M 4.1	M 4.1	P 1.1-3.1	P 1.1-4.1
N 2.8	N 2.8	K 1.1-4.2	K 1.1-4.2
S 1.2-3	S 1.2-3	N 2.4-7	N 2.4-7
S 2.3, 2.5-6	S 2.3, 2.5-6	N 4.1, 5.1	N 4.1, 5.1

Reinforced Shank

Nominal Size ø d ₁	T.P.I.	l ₁	l ₂	inch		ø d ₂	□	Tool Identification	BU30J411		BU35J411		BU100501		BU109101	
				Rekord 1C-NI-PM TICN	Flutes				Rekord 1DF-NI-PM TICN	Flutes	Rekord 1A-H NT	Flutes	Rekord 1A-H TICN	Flutes		
No. 0	80	1.626	0.236	0.433	0.141	0.110	0.0480	.5033					●	2	●	2
No. 1	72	1.772	0.276	0.472	0.141	0.110	0.0595	.5034					●	2	●	2
No. 2	64	1.772	0.276	0.472	0.141	0.110	0.0730	.5035					●	3	●	3
No. 3	56	1.969	0.354	0.551	0.141	0.110	0.0827	.5036					●	3	●	3
No. 4	48	2.205	0.433	0.709	0.141	0.110	0.0945	.5037					●	3	●	3
No. 5	44	2.205	0.433	0.709	0.141	0.110	0.1063	.5038					●	3	●	3
No. 6	40	2.205	0.472	0.787	0.141	0.110	0.1181	.5039					●	3	●	3
No. 8	36	2.480	0.512	0.827	0.168	0.131	0.1378	.5040					●	3	●	3
No. 10	32	2.756	0.512	0.984	0.194	0.152	0.1614	.5041	●	3	●	3	●	3	●	3
No. 12	28	3.150	0.630	1.142	0.220	0.165	0.1820	.5042	●	3	●	3	●	3	●	3
1/4	28	3.150	0.669	1.181	0.255	0.191	0.2165 ²⁾	.5043	●	3	●	3	●	3	●	3
5/16	24	3.543	0.669	1.260	0.318	0.238	0.2717 ²⁾	.5044	●	3	●	3	●	3	●	3
3/8	24	3.937	0.709	1.535	0.381	0.286	0.3346 ²⁾	.5045	●	3	●	3	●	4	●	4

Reduced Shank

Nominal Size ø d ₁	T.P.I.	l ₁	l ₂	inch		ø d ₂	□	Tool Identification	CU30J411		CU35J411		CU100501		CU109101	
				Rekord 2C-NI-PM TICN	Flutes				Rekord 2DF-NI-PM TICN	Flutes	Rekord 2A-H NT	Flutes	Rekord 2A-H TICN	Flutes		
7/16	20	3.937	0.866	—	0.323	0.242	0.3898 ²⁾	.5046	●	3	●	3	●	4	●	4
1/2	20	3.937	0.866	—	0.367	0.275	0.4528 ²⁾	.5047	●	3	●	3	●	4	●	4
9/16	18	3.937	0.866	—	0.429	0.322	0.5118	.5048	●	3	●	3	●	4	●	4
5/8	18	3.937	0.866	—	0.480	0.360	0.5709	.5049	●	3	●	3	●	4	●	4
3/4	16	4.331	0.984	—	0.590	0.442	0.6890	.5050	●	4	●	4	●	4	●	4
7/8	14	4.921	1.024	—	0.697	0.523	0.8071	.5051					●	4	●	4
1	12	5.512	1.102	—	0.800	0.600	0.9219	.5052					●	4	●	4
1 1/8	12	5.906	1.181	—	0.896	0.672	1.0433	.5053								
1 1/4	12	5.906	1.181	—	1.021	0.766	1.1719	.5054								
1 3/8	12	6.693	1.299	—	1.108	0.831	1.2992	.5055								
1 1/2	12	6.693	1.299	—	1.233	0.925	1.4173	.5056								

H Materials of High Tensile Strength		HCUT Hardened Steels		Z CNC-Controlled Machines						
										
2BX TICN HSS Extra		2BX TICN HSSE-PM		2BX TICN HSS Extra	2BX TICN HSS Extra	2BX TICN HSS Extra	2BX TICN HSS Extra	Class of Fit Coating Cutting Material Technical Characteristics		
C / 2-3 E / O		C / 2-3 O / P		C / 2-3 E / O / P	C / 2-3 E / O	C / 2-3 E / O	E / 1.5-2 E / O			
max. 2 x d ₁ 		max. 1.5 x d ₁ 		max. 2 x d ₁ 	max. 2 x d ₁ 	max. 2 x d ₁ 	max. 2 x d ₁ 	Thread Depth and Hole Shape		
P 1.1-4.1 K 1.1-4.2 N 2.4-7 N 4.1, 5.1		H 1.1-2		P 1.1-4.1 K 1.1-4.2 N 1.4-6, 2.4-7 N 4.1	P 1.1-4.1 K 1.1-4.2 N 1.4-6, 2.4-7 N 4.1	P 1.1-4.1 K 1.1-4.2 N 1.4-6, 2.4-7 N 4.1	P 1.1-4.1 K 1.1-4.2 N 1.4-6, 2.4-7 N 4.1	Applications – Material		
BU959101		BU10J901		BU109401	BU959401	BU219401	BU969401	Tool Identification		
Rekord 1A-H-IKZ TICN	Flutes	Rekord 1A-HCUT-PM TICN	Flutes	Rekord 1A-Z TICN	Rekord 1A-Z-IKZ TICN	Rekord 1A-Z-IKZN TICN	Rekord 1A-Z/E-IKZ TICN	Dimens. ID	Nominal Size ø d ₁	T.P.I.
●	3	●	4	●	●	●	●	.5033	No. 0	80
●	3	●	5	●	●	●	●	.5034	No. 1	72
●	3	●	5	●	●	●	●	.5035	No. 2	64
●	4	●	5	●	●	●	●	.5036	No. 3	56
								.5037	No. 4	48
								.5038	No. 5	44
								.5039	No. 6	40
●	3	●	4	●	●	●	●	.5040	No. 8	36
●	3	●	5	●	●	●	●	.5041	No.10	32
●	3	●	5	●	●	●	●	.5042	No.12	28
●	4	●	5	●	●	●	●	.5043	1/4	28
								.5044	5/16	24
								.5045	3/8	24
CU959101		CU10J901		CU109401	CU959401	CU219401	CU969401	Tool Identification		
Rekord 2A-H-IKZ TICN	Flutes	Rekord 2A-HCUT-PM TICN	Flutes	Rekord 2A-Z TICN	Rekord 2A-Z-IKZ TICN	Rekord 2A-Z-IKZN TICN	Rekord 2A-Z/E-IKZ TICN	Dimens. ID	Nominal Size ø d ₁	T.P.I.
●	4	●	5	●	●	●	●	.5046	7/16	20
●	4	●	5	●	●	●	●	.5047	1/2	20
●	4			●	●	●	●	.5048	9/16	18
●	4			●	●	●	●	.5049	5/8	18
●	4			●	●	●	●	.5050	3/4	16
●	4							.5051	7/8	14
●	4							.5052	1	12
								.5053	1 1/8	12
								.5054	1 1/4	12
								.5055	1 3/8	12
								.5056	1 1/2	12

● = In stock
★ = Allow 7 days for delivery

1) Threading in through holes is possible only with external cooling/lubrication
2) Increase drill diameter for taps Rekord 1/2A-HCUT-PM-TICN by 0.004 in

Product Finder

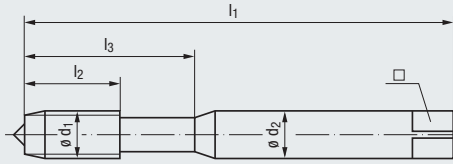
- V_c
- UNC
- UNF
- UNEF
- UN-8
- MF
- NPSM/NPSC
- NPSF
- Rp (BSPP)
- G
- NPT
- NPTF
- Rc (BSPT)
- STI
- SELF-LOCK
- Accessories
- Tech. Info



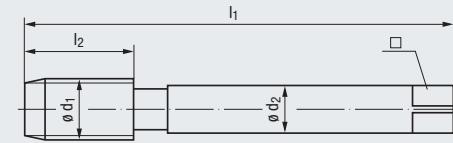
- Product Finder
- V_c
- UNC
- UNF
- UNEF
- UN-8
- M
- MF
- NPSM/NPSC
- NPSF
- Rp (BSPP)
- G
- NPT
- NPTF
- Rc (BSPT)
- STI
- SELF-LOCK
- Accessories
- Tech. Info

DIN Length - ANSI Shank

Overall length acc. to DIN 371, DIN 374

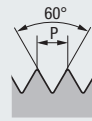


Reinforced Shank
(No.0 - 3/8)



Reduced Shank
(7/16 - 1 1/2)

UNF



Unified Fine Thread
ASME B1.1

Class of Fit

Coating

Cutting Material

Technical Characteristics



Thread Depth
and Hole Shape

Applications - Material

Z
CNC-Controlled
Machines



2BX	2BX	2BX	3BX	2BX
TIN-70	GLT-1	TIN-70	GLT-1	TIN
HSSE-PM	HSSE-PM	HSSE-PM	HSSE-PM	HSS Extra
B / 4-5	B / 4-5	B / 4-5	B / 4-5	R15
E / O / P	E / O / P	E / O	E / O / P	C / 2-3
				E / O / P

max. 3 x d₁



max. 2 x d₁



P 1.1-5.1	P 1.1-5.1	P 1.1-5.1	P 1.1-5.1	P 2.1-5.1
M 1.1-3.1	M 1.1-3.1	M 1.1-3.1	M 1.1-3.1	K 2.1-2
K 2.1	K 2.1	K 2.1	K 2.1	N 1.4-6, 2.4-5
N 1.4-2.2, 2.4-5	N 1.4-2.2, 2.4-5	N 1.4-2.2, 2.4-5	N 1.4-2.2, 2.4-5	
S 1.1	S 1.1	S 1.1	S 1.1	

Reinforced Shank

Nominal Size ø d ₁	T.P.I.	l ₁	l ₂	inch		ø d ₂	□	Tool Identification		BU208F01		BU20A601		BU088F01		BU20A611		BU453701	
				Rekord 1B-Z-PM TIN-70	Flutes			Rekord 1B-Z-PM GLT-1	Flutes	Rekord 1B-Z-1KZN PM-TIN-70	Flutes	Rekord 1B-Z-PM GLT-1	Flutes	Rekord 1D-Z TIN	Flutes				
No. 0	80	1.626	0.157	0.433	0.141	0.110	0.0480	.5033											
No. 1	72	1.772	0.157	0.472	0.141	0.110	0.0595	.5034											
No. 2	64	1.772	0.177	0.472	0.141	0.110	0.0730	.5035											
No. 3	56	1.969	0.197	0.551	0.141	0.110	0.0827	.5036											
No. 4	48	2.205	0.236	0.709	0.141	0.110	0.0945	.5037											
No. 5	44	2.205	0.276	0.709	0.141	0.110	0.1063	.5038											
No. 6	40	2.205	0.276	0.787	0.141	0.110	0.1181	.5039											
No. 8	36	2.480	0.315	0.827	0.168	0.131	0.1378	.5040											
No. 10	32	2.756	0.394	0.984	0.194	0.152	0.1614	.5041	●	3	●	3	●	3	●	3	●	3	3
No. 12	28	3.150	0.394	1.142	0.220	0.165	0.1820	.5042											
1/4	28	3.150	0.394	1.181	0.255	0.191	0.2165	.5043	●	3	●	3	●	3	●	3	●	3	3
5/16	24	3.543	0.394	1.260	0.318	0.238	0.2717	.5044	●	4	●	4	●	4	●	4	●	4	3
3/8	24	3.937	0.394	1.535	0.381	0.286	0.3346	.5045	●	4	●	4	●	4	●	4	●	4	3

Reduced Shank

Nominal Size ø d ₁	T.P.I.	l ₁	l ₂	inch		ø d ₂	□	Tool Identification		CU208F01		CU20A601		CU088F01		CU20A611		CU453701	
				Rekord 2B-Z-PM TIN-70	Flutes			Rekord 2B-Z-PM GLT-1	Flutes	Rekord 2B-Z-1KZN PM-TIN-70	Flutes	Rekord 2B-Z-PM GLT-1	Flutes	Rekord 2D-Z TIN	Flutes				
7/16	20	3.937	0.512	—	0.323	0.242	0.3898	.5046	●	4	●	4	●	4	●	4	●	4	3
1/2	20	3.937	0.512	—	0.367	0.275	0.4528	.5047	●	4	●	4	●	4	●	4	●	4	3
9/16	18	3.937	0.591	—	0.429	0.322	0.5118	.5048	●	4	●	4	●	4	●	4	●	4	3
5/8	18	3.937	0.591	—	0.480	0.360	0.5709	.5049	●	4	●	4	●	4	●	4	●	4	3
3/4	16	4.331	0.669	—	0.590	0.442	0.6890	.5050	●	4	●	4	●	4	●	4	●	4	4
7/8	14	4.921	0.669	—	0.697	0.523	0.8071	.5051	●	4	●	4							
1	12	5.512	0.787	—	0.800	0.600	0.9219	.5052											
1 1/8	12	5.906	0.866	—	0.896	0.672	1.0433	.5053											
1 1/4	12	5.906	0.866	—	1.021	0.766	1.1719	.5054											
1 3/8	12	6.693	0.945	—	1.108	0.831	1.2992	.5055											
1 1/2	12	6.693	0.984	—	1.233	0.925	1.4173	.5056											

Z
CNC-Controlled
Machines

2BX	2BX	2BX	2B	2B	2B	2B	2B
TIN	TIN	TIN	TIN	GLT-1	GLT-1	HSS Extra	TIN
HSS Extra	HSS Extra	HSS Extra	HSS Extra	HSS Extra	HSS Extra	HSS Extra	HSS Extra
R15	R15	R15	R45	R45	R45	R45	R45
C / 2-3	C / 2-3	C / 2-3	C / 2-3	C / 2-3	C / 2-3	E / 1.5-2	E / 1.5-2
E / O	E / O / P	E / O	E / O / P	E / O / P	E / O	E / O / P	E / O / P

- Product Finder
- V_c
- UNC
- UNF
- UNEF
- UN-8
- MF
- NPSM/NPSC
- NPSF
- Rp (BSPP)
- G
- NPT
- NPTF
- Rc (BSPT)
- STI
- SELF-LOCK
- Accessories
- Tech. Info

max. 2 x d ₁ 			max. 3 x d ₁ 				
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P 2.1-5.1 K 2.1-2 N 1.4-6, 2.4-5	P 2.1-5.1 K 2.1-2 N 1.4-6, 2.4-5	P 2.1-5.1 K 2.1-2 N 1.4-6, 2.4-5	P 1.1-4.1 M 1.1-3.1 N 1.4-6 N 2.1-2, 2.4-5 S 1.1	P 1.1-4.1 M 1.1-3.1 N 1.4-6 N 2.1-2, 2.4-5 S 1.1	P 1.1-4.1 M 1.1-3.1 N 1.4-6 N 2.1-2, 2.4-5 S 1.1	P 1.1-4.1 M 1.1-2.1 N 2.1 N 1.4-6 N 2.1-2, 2.4-5 S 1.1	P 1.1-4.1 M 1.1-3.1 N 1.4-6 N 2.1-2, 2.4-5 S 1.1
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BU973701						BU523701						BU573701						BU50C400						BU94C400						BU513500						BU513700						Tool Identification		
Rekord 1D-Z- IKZ TIN		Flutes		Rekord 1D-Z- BF TIN		Flutes		Rekord 1D-Z- BF IKZ-TIN		Flutes		Enorm 1-Z GLT-1		Flutes		Enorm 1-Z- IKZ GLT-1		Flutes		Enorm 1-Z/E		Flutes		Enorm 1-Z/E TIN		Flutes		Dimens. ID	Nominal Size ø d ₁	T.P.I.														
●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	.5033	No. 0	80														
●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	.5034	No. 1	72														
●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	.5035	No. 2	64														
●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	.5036	No. 3	56														
●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	.5037	No. 4	48														
●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	.5038	No. 5	44														
●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	.5039	No. 6	40														
●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	.5040	No. 8	36														
●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	.5041	No. 10	32														
●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	.5042	No. 12	28														
●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	.5043	1/4	28														
●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	.5044	5/16	24														
●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	●	3	.5045	3/8	24														

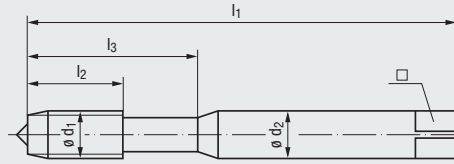
CU973701						CU573701						CU583701						CU503700						CU50C400						CU94C400						CU513500						CU513700						Tool Identification		
Rekord 2D-Z- IKZ TIN		Flutes		Rekord 2D-Z- BF TIN		Flutes		Rekord 2D-Z- BF IKZ-TIN		Flutes		Enorm 2-Z TIN		Flutes		Enorm 2-Z GLT-1		Flutes		Enorm 2-Z- IKZ GLT-1		Flutes		Enorm 2-Z/E		Flutes		Enorm 2-Z/E TIN		Flutes		Dimens. ID	Nominal Size ø d ₁	T.P.I.																
●	3	●	3	●	3	●	3	●	3	●	3	●	4	●	4	●	4	●	4	●	4	●	4	●	4	●	4	●	4	●	4	.5046	7/16	20																
●	3	●	3	●	3	●	3	●	3	●	3	●	5	●	5	●	5	●	5	●	5	●	5	●	5	●	5	●	5	●	5	.5047	1/2	20																
●	3	●	3	●	3	●	3	●	3	●	3	●	5	●	5	●	5	●	5	●	5	●	5	●	5	●	5	●	5	●	5	.5048	9/16	18																
●	3	●	3	●	3	●	3	●	3	●	3	●	5	●	5	●	5	●	5	●	5	●	5	●	5	●	5	●	5	●	5	.5049	5/8	18																
●	4	●	4	●	4	●	4	●	4	●	4	●	5	●	5	●	5	●	5	●	5	●	5	●	5	●	5	●	5	●	5	.5050	3/4	16																
●	4	●	4	●	4	●	4	●	4	●	4	●	5	●	5	●	5	●	5	●	5	●	5	●	5	●	5	●	5	●	5	.5051	7/8	14																
●	4	●	4	●	4	●	4	●	4	●	4	●	5	●	5	●	5	●	5	●	5	●	5	●	5	●	5	●	5	●	5	.5052	1	12																
●	5	●	5	●	5	●	5	●	5	●	5	●	6	●	6	●	6	●	6	●	6	●	6	●	6	●	6	●	6	●	6	.5053	1 1/8	12																
●	6	●	6	●	6	●	6	●	6	●	6	●	6	●	6	●	6	●	6	●	6	●	6	●	6	●	6	●	6	●	6	.5054	1 1/4	12																
●	6	●	6	●	6	●	6	●	6	●	6	●	6	●	6	●	6	●	6	●	6	●	6	●	6	●	6	●	6	●	6	.5055	1 3/8	12																
●	6	●	6	●	6	●	6	●	6	●	6	●	6	●	6	●	6	●	6	●	6	●	6	●	6	●	6	●	6	●	6	.5056	1 1/2	12																

● = In stock
★ = Allow 7 days for delivery

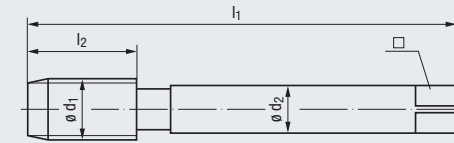
- Product Finder
- V_c
- UNC
- UNF
- UNEF
- UN-8
- M
- MF
- NPSM/NPSC
- NPSF
- Rp (BSPP)
- G
- NPT
- NPTF
- Rc (BSPT)
- STI
- SELF-LOCK
- Accessories
- Tech. Info

DIN Length - ANSI Shank

Overall length acc. to DIN 371, DIN 374

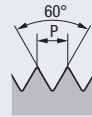


Reinforced Shank
(No.0 - 3/8)



Reduced Shank
(7/16 - 1 1/2)

UNF



Unified Fine Thread
ASME B1.1

Class of Fit

Coating

Cutting Material

Technical Characteristics



Thread Depth
and Hole Shape

Applications - Material

Z
CNC-Controlled
Machines



2B	2B	2B	2B	3B
TICN	GLT-1	TICN	GLT-1	GLT-1
HSS Extra	HSS Extra	HSS Extra	HSS Extra	HSS Extra
R45	R45	R45	R45	R45
E / 1.5-2	E / 1.5-2	E / 1.5-2	E / 1.5-2	E / 1.5-2
E / O / P	E / O / P	E / O	E / O	E / O / P

max. 3 x d₁



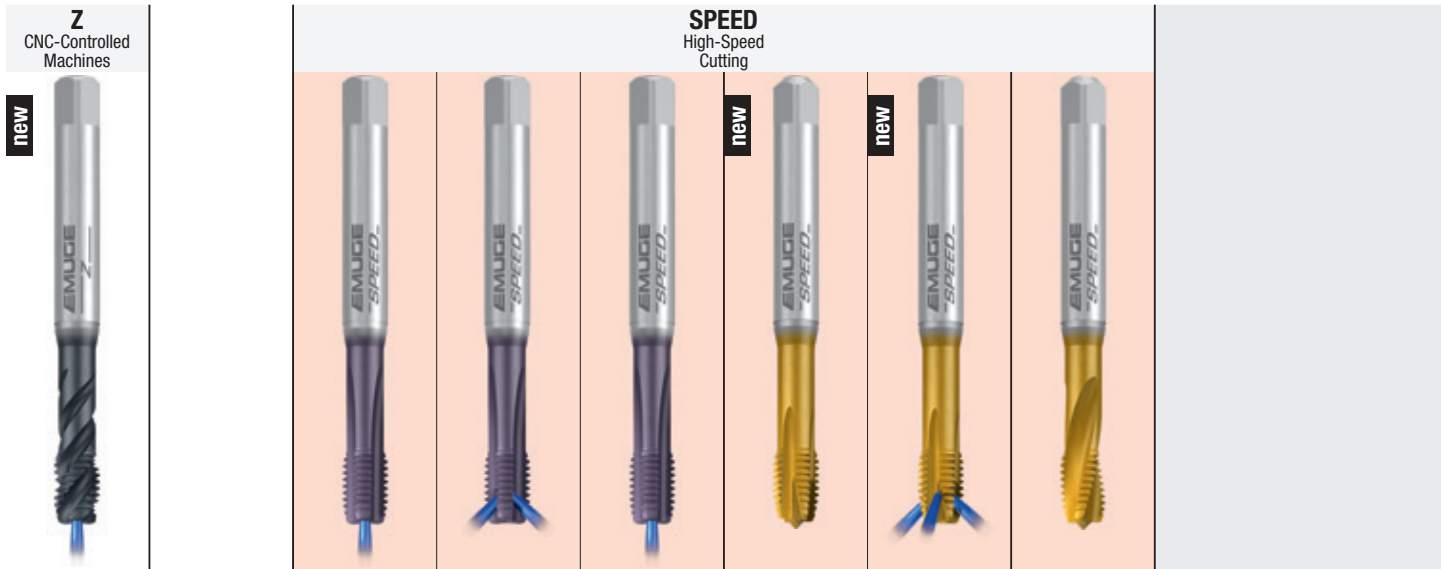
P 1.1-4.1	P 1.1-4.1	P 1.1-4.1	P 1.1-4.1	P 1.1-4.1
M 1.1-3.1	M 1.1-3.1	M 1.1-3.1	M 1.1-3.1	M 1.1-3.1
N 1.4-6	N 1.4-6	N 1.4-6	N 1.4-6	N 1.4-6
N 2.1-2, 2.4-5	N 2.1-2, 2.4-5	N 2.1-2, 2.4-5	N 2.1-2, 2.4-5	N 2.1-2, 2.4-5
S 1.1	S 1.1	S 1.1	S 1.1	S 1.1

Reinforced Shank

Nominal Size ø d ₁	T.P.I.	l ₁	l ₂	inch			□	Tool Identification		BU519400		BU51C400		BU999400		BU99C400		BU51C410		
				l ₃	ø d ₂	□		Enorm 1-Z/E TICN	Flutes	Enorm 1-Z/E GLT-1	Flutes	Enorm 1-Z/E-IKZ TICN	Flutes	Enorm 1-Z/E-IKZ GLT-1	Flutes	Enorm 1-Z/E GLT-1	Flutes			
No. 0	80	1.626	0.157	0.433	0.141	0.110	0.0480	.5033			●	2								
No. 1	72	1.772	0.157	0.472	0.141	0.110	0.0595	.5034			●	2								
No. 2	64	1.772	0.177	0.472	0.141	0.110	0.0730	.5035			●	2								
No. 3	56	1.969	0.197	0.551	0.141	0.110	0.0827	.5036			●	2								
No. 4	48	2.205	0.236	0.709	0.141	0.110	0.0945	.5037			●	2								
No. 5	44	2.205	0.276	0.709	0.141	0.110	0.1063	.5038			●	3								
No. 6	40	2.205	0.276	0.787	0.141	0.110	0.1181	.5039			●	3								
No. 8	36	2.480	0.315	0.827	0.168	0.131	0.1378	.5040			●	3								
No. 10	32	2.756	0.394	0.984	0.194	0.152	0.1614	.5041	●	3	●	3	●	3	●	3	●	3	●	3
No. 12	28	3.150	0.394	1.142	0.220	0.165	0.1820	.5042	●	3	●	3	●	3	●	3	●	3	●	3
1/4	28	3.150	0.394	1.181	0.255	0.191	0.2165	.5043	●	3	●	3	●	3	●	3	●	3	●	3
5/16	24	3.543	0.394	1.260	0.318	0.238	0.2717	.5044	●	3	●	3	●	3	●	3	●	3	●	3
3/8	24	3.937	0.394	1.535	0.381	0.286	0.3346	.5045	●	3	●	3	●	3	●	3	●	3	●	3

Reduced Shank

Nominal Size ø d ₁	T.P.I.	l ₁	l ₂	inch			□	Tool Identification		CU519400		CU51C400		CU999400		CU99C400		CU51C410		
				l ₃	ø d ₂	□		Enorm 2-Z/E TICN	Flutes	Enorm 2-Z/E GLT-1	Flutes	Enorm 2-Z/E-IKZ TICN	Flutes	Enorm 2-Z/E-IKZ GLT-1	Flutes	Enorm 2-Z/E GLT-1	Flutes			
7/16	20	3.937	0.512	—	0.323	0.242	0.3898	.5046	●	4	●	4	●	4	●	4	●	4	●	4
1/2	20	3.937	0.512	—	0.367	0.275	0.4528	.5047	●	5	●	5	●	5	●	5	●	5	●	5
9/16	18	3.937	0.591	—	0.429	0.322	0.5118	.5048	●	5	●	5	●	5	●	5	●	5	●	5
5/8	18	3.937	0.591	—	0.480	0.360	0.5709	.5049	●	5	●	5	●	5	●	5	●	5	●	5
3/4	16	4.331	0.669	—	0.590	0.442	0.6890	.5050	●	5	●	5	●	5	●	5	●	5	●	5
7/8	14	4.921	0.669	—	0.697	0.523	0.8071	.5051												
1	12	5.512	0.787	—	0.800	0.600	0.9219	.5052												
1 1/8	12	5.906	0.866	—	0.896	0.672	1.0433	.5053												
1 1/4	12	5.906	0.866	—	1.021	0.766	1.1719	.5054												
1 3/8	12	6.693	0.945	—	1.108	0.831	1.2992	.5055												
1 1/2	12	6.693	0.984	—	1.233	0.925	1.4173	.5056												



new					new	new		
3B	2BX	2BX	2BX	2BX	2BX	2BX	2BX	Class of Fit
GLT-1	TICN	TICN	TICN	TIN-70	TIN-70	TIN		Coating
HSS Extra	HSS Extra	HSS Extra	HSS Extra	HSSE-PM	HSSE-PM	HSS Extra		Cutting Material
R45	C / 2-3	C / 2-3	E / 1.5-2	B / 4-5	B / 4-5	R15		Technical Characteristics
E / 1.5-2	E	E	E	E	E	C / 2-3		
E / O						E		

max. 3 x d ₁	max. 2 x d ₁	max. 2 x d ₁	max. 2 x d ₁	max. 3 x d ₁	max. 2 x d ₁			Thread Depth and Hole Shape

P 1.1-4.1	K 1.1-4.2	K 1.1-4.2	K 1.1-4.2	P 1.1-4.1	P 1.1-4.1	P 1.1-4.1	Applications – Material
M 1.1-3.1	N 1.4-6	N 1.4-6	N 1.4-6	K 2.1-2	K 2.1-2	M 1.1-3.1	
N 1.4-6				N 1.4-6	N 1.4-6	K 2.1-2	
N 2.1-2, 2.4-5						N 1.4-2.1	
S 1.1							

BU99C410		BW159401		BW179401		BW169401		BW138F01		BW208F01		BU263701		Tool Identification		
Enorm 1-Z/E-IKZ GLT-1	Flutes	Rekord 1A-SPEED IKZ-TICN	Flutes	Rekord 1A-SPEED IKZN-TICN	Flutes	Rekord 1A-SPEED/E IKZ-TICN	Flutes	Rekord 1B-Z-SPEED PM-TIN-70	Flutes	Rekord 1B-Z-SPEED IKZN-PM TIN-70	Flutes	Rekord 1D-SPEED TIN	Flutes	Dimens. ID	Nominal Size ø d ₁	T.P.I.
														.5033	No. 0	80
														.5034	No. 1	72
														.5035	No. 2	64
														.5036	No. 3	56
														.5037	No. 4	48
														.5038	No. 5	44
														.5039	No. 6	40
														.5040	No. 8	36
●	3	●	3	●	3	●	3	●	3	●	3	●	3	.5041	No. 10	32
		●	3	●	3	●	3	●	3	●	3	●	3	.5042	No. 12	28
●	3	●	3	●	3	●	3	●	3	●	3	●	3	.5043	1/4	28
●	3	●	3	●	3	●	3	●	4	●	4	●	3	.5044	5/16	24
●	3	●	4	●	4	●	4	●	4	●	4	●	3	.5045	3/8	24

CU99C410		CW159401		CW179401		CW169401		CW138F01		CW208F01		CU263701		Tool Identification		
Enorm 2-Z/E-IKZ GLT-1	Flutes	Rekord 2A-SPEED IKZ-TICN	Flutes	Rekord 2A-SPEED IKZN-TICN	Flutes	Rekord 2A-SPEED/E IKZ-TICN	Flutes	Rekord 2B-Z-SPEED PM-TIN-70	Flutes	Rekord 2B-Z-SPEED IKZN-PM TIN-70	Flutes	Rekord 2D-SPEED TIN	Flutes	Dimens. ID	Nominal Size ø d ₁	T.P.I.
●	4	●	4	●	4	●	4	●	4	●	4	●	3	.5046	7/16	20
●	5	●	4	●	4	●	4	●	4	●	4	●	3	.5047	1/2	20
●	5	●	4	●	4	●	4	●	4	●	4	●	3	.5048	9/16	18
●	5	●	4	●	4	●	4	●	4	●	4	●	3	.5049	5/8	18
●	5	●	4	●	4	●	4	●	4	●	4	●	4	.5050	3/4	16
														.5051	7/8	14
														.5052	1	12
														.5053	1 1/8	12
														.5054	1 1/4	12
														.5055	1 3/8	12
														.5056	1 1/2	12

● = In stock
★ = Allow 7 days for delivery

1) Threading in through holes is possible only with external cooling/lubrication

Product Finder

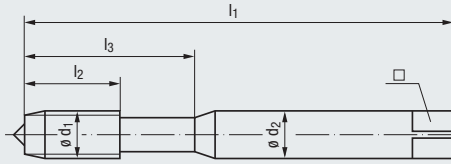
- V_c
- UNC
- UNF
- UNEF
- UN-8
- MF
- NPSM/NPSC
- NPSF
- R_p (BSPP)
- G
- NPT
- NPTF
- R_c (BSPT)
- STI
- SELF-LOCK
- Accessories
- Tech. Info



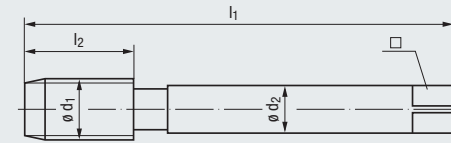
- Product Finder
- V_c
- UNC
- UNF
- UNEF
- UN-8
- M
- MF
- NPSM/NPSC
- NPSF
- Rp (BSPP)
- G
- NPT
- NPTF
- Rc (BSPT)
- STI
- SELF-LOCK
- Accessories
- Tech. Info

DIN Length - ANSI Shank

Overall length acc. to DIN 371, DIN 374



Reinforced Shank
(No.0 - 3/8)



Reduced Shank
(7/16 - 1 1/2)

SPEED

High-Speed Cutting



Unified Fine Thread ASME B1.1

Class of Fit
Coating
Cutting Material
Technical Characteristics



Thread Depth and Hole Shape

Applications - Material

2BX	2B
TIN	TIN
HSS Extra	HSS Extra
R15	R45
C / 2-3	C / 2-3
E	E

max. 2 x d ₁	max. 3 x d ₁

P 1.1-4.1	P 1.1-4.1
M 1.1-3.1	M 1.1-3.1
K 2.1-2	K 2.1
N 1.4-2.1	N 1.1-2.2

Reinforced Shank

Nominal Size ø d ₁	T.P.I.	l ₁	l ₂	inch		□	Tool Identification		BU293701		BW553700	
				l ₃	ø d ₂		Dimens. ID	Rekord 1D-SPEED IKZ-TIN	Flutes	Enorm 1-SPEED IKZ-TIN	Flutes	
No. 0	80	1.626	0.157	0.433	0.141	0.110	0.0480	.5033				
No. 1	72	1.772	0.157	0.472	0.141	0.110	0.0595	.5034				
No. 2	64	1.772	0.177	0.472	0.141	0.110	0.0730	.5035				
No. 3	56	1.969	0.197	0.551	0.141	0.110	0.0827	.5036				
No. 4	48	2.205	0.236	0.709	0.141	0.110	0.0945	.5037				
No. 5	44	2.205	0.276	0.709	0.141	0.110	0.1063	.5038				
No. 6	40	2.205	0.276	0.787	0.141	0.110	0.1181	.5039				
No. 8	36	2.480	0.315	0.827	0.168	0.131	0.1378	.5040				
No. 10	32	2.756	0.394	0.984	0.194	0.152	0.1614	.5041	●	3	●	3
No. 12	28	3.150	0.394	1.142	0.220	0.165	0.1820	.5042				
1/4	28	3.150	0.394	1.181	0.255	0.191	0.2165	.5043	●	3	●	3
5/16	24	3.543	0.394	1.260	0.318	0.238	0.2717	.5044	●	3	●	3
3/8	24	3.937	0.394	1.535	0.381	0.286	0.3346	.5045	●	3	●	3

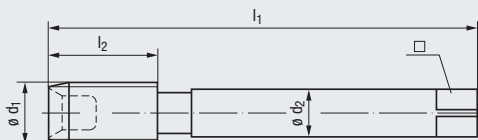
Reduced Shank

Nominal Size ø d ₁	T.P.I.	l ₁	l ₂	inch		□	Tool Identification		CU293701		CW553700	
				l ₃	ø d ₂		Dimens. ID	Rekord 2D-SPEED IKZ-TIN	Flutes	Enorm 2-SPEED IKZ-TIN	Flutes	
7/16	20	3.937	0.512	—	0.323	0.242	0.3898	.5046	●	3	●	4
1/2	20	3.937	0.512	—	0.367	0.275	0.4528	.5047	●	3	●	5
9/16	18	3.937	0.591	—	0.429	0.322	0.5118	.5048	●	3	●	5
5/8	18	3.937	0.591	—	0.480	0.360	0.5709	.5049	●	3	●	5
3/4	16	4.331	0.669	—	0.590	0.442	0.6890	.5050	●	4	●	5
7/8	14	4.921	0.669	—	0.697	0.523	0.8071	.5051				
1	12	5.512	0.787	—	0.800	0.600	0.9219	.5052				
1 1/8	12	5.906	0.866	—	0.896	0.672	1.0433	.5053				
1 1/4	12	5.906	0.866	—	1.021	0.766	1.1719	.5054				
1 3/8	12	6.693	0.945	—	1.108	0.831	1.2992	.5055				
1 1/2	12	6.693	0.984	—	1.233	0.925	1.4173	.5056				

DIN Length • ANSI Shank

Overall length acc. to DIN 374

With internal chip collector

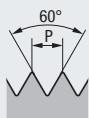


Reduced Shank

VA
Stainless Steel
Materials



UNF



**Unified Fine Thread
ASME B1.1**

Class of Fit

3BX 2)

Coating

NE2

Cutting Material

HSS Extra

Technical Characteristics

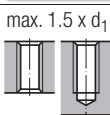


C / 2-3



P / O 1)

Thread Depth
and Hole Shape



Applications – Material

P 1.1-4.1

M 1.1-2.1

K 1.1-4.2

Reduced Shank

Tool Identification

CU803011

Nominal Size ø d ₁	T.P.I.	inch				□	Image	Dimens. ID	Robust 2X-VA NE2	Flutes
		l ₁	l ₂	ø d ₂						
3/4	16	4.331	0.984	0.590	0.442	0.6890	.5050	●	5	
7/8	14	4.921	1.024	0.697	0.523	0.8071	.5051	●	5	
1	12	5.512	1.102	0.800	0.600	0.9219	.5052	●	5	
1 1/8	12	5.906	1.181	0.896	0.672	1.0433	.5053	●	5	
1 1/4	12	5.906	1.181	1.021	0.766	1.1719	.5054	●	6	
1 3/8	12	6.693	1.299	1.108	0.831	1.2992	.5055	●	6	
1 1/2	12	6.693	1.299	1.233	0.925	1.4173	.5056	●	6	

1) If possible, use paste lubrication, coating both the tool and the walls of the drilled hole. Lubrication with oil is possible only in the vertical machining of blind holes, if the hole is entirely filled with oil.

2) Class 2B threads may be produced with 3BX taps.

Larger sizes priced upon request. We have experience in making taps as large as 10 inches ø UN.

The Complete Tool System

Robust 2X-VA Taps when used with a KSN Type tapping attachment creates the optimal tapping unit!

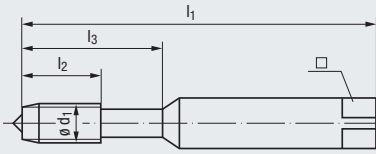
Product Finder

- Vc
- UNC
- UNF**
- UNEF
- UN-8
- ...
- MF
- NPSM/NPSC
- NPSF
- Rp (BSPP)
- G
- NPT
- NPTF
- Rc (BSPT)
- STI
- SELF-LOCK
- Accessories
- Tech. Info

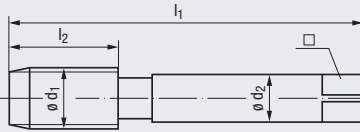


- Product Finder
- V_c
- UNC
- UNF
- UNEF
- UN-8
- M
- MF
- NPSM/NPSC
- NPSF
- Rp (BSPP)
- G
- NPT
- NPTF
- Rc (BSPT)
- STI
- SELF-LOCK
- Accessories
- Tech. Info

ANSI Length · ANSI Shank



Reinforced Shank
(No.6 - 3/8)



Reduced Shank
(7/16 - 3/4)

STEEL
Steel
Materials



VA
Stainless Steel
Materials



UNF

Unified Fine Thread
ASME B1.1

Class of Fit
Coating
Cutting Material
Technical Characteristics



Thread Depth
and Hole Shape

Applications – Material

2B
TIN
HSS Extra
B / 4-5
E / O



P 1.1-4.1
K 2.1
N 2.2, 2.4-5

2B
NT
HSS Extra
B / 4-5
E / O / P



P 1.1-3.1
M 1.1-2.1
K 2.1
N 2.2, 2.5-6

3B
NT
HSS Extra
B / 4-5
E / O / P



P 1.1-3.1
M 1.1-2.1
K 2.1
N 2.2, 2.5-6

Override
NT
HSS Extra
B / 4-5
E / O / P



P 1.1-3.1
M 1.1-2.1
K 2.1
N 2.2, 2.5-6

Tool Identification

AU208400

AU203000

AU203010

AU203044

Nominal Size ϕd_1	T.P.I.	inch				ϕd_2	\square	Tool ID	AU208400		AU203000		AU203010		AU203044	
		l_1	l_2	l_3	ϕd_2				Rekord B-STEEL-L TIN	Flutes	Rekord B-VA NT	Flutes	Rekord B-VA NT	Flutes	Rekord B-VA NT	Flutes
No. 6	40	2	2.00	0.472	0.748	0.141	0.110	0.1181	.5039	●	3	●	3			
No. 8	36	2 1/8	2.13	0.512	0.827	0.168	0.131	0.1378	.5040	●	3	●	3			
No. 10	32	2 3/8	2.38	0.591	0.945	0.194	0.152	0.1614	.5041	●	3	●	3	●	3	1) ● (+.0035) 3
1/4	28	2 1/2	2.50	0.669	1.142	0.255	0.191	0.2165	.5043	●	3	●	3	●	3	● (+.0050) 3
5/16	24	2 23/32	2.72	0.669	1.299	0.318	0.238	0.2717	.5044	●	3	●	3	●	3	● (+.0050) 3
3/8	24	2 15/16	2.94	0.709	1.378	0.381	0.286	0.3346	.5045	●	4	●	4	●	4	● (+.0050) 4
7/16	20	3 5/32	3.16	0.866	—	0.323	0.242	0.3898	.5046	●	3	●	3	●	3	● (+.0050) 3
1/2	20	3 3/8	3.38	0.866	—	0.367	0.275	0.4528	.5047	●	3	●	3	●	3	● (+.0050) 3
9/16	18	3 19/32	3.59	0.866	—	0.429	0.322	0.5118	.5048	●	3	●	3	●	3	
5/8	18	3 13/16	3.81	0.866	—	0.480	0.360	0.5709	.5049	●	3	●	3	●	3	● (+.0050) 3
3/4	16	4 1/4	4.25	0.984	—	0.590	0.442	0.6890	.5050	●	4	●	4	●	4	

1) Tool Identification = AU203043

DIN Length · ANSI Shank



All ANSI Length · ANSI Shank taps are available in the popular DIN Length · ANSI Shank style.

The DIN Length · ANSI Shank configuration allows for added reach capabilities and greater chip clearance.

VA Stainless Steel Materials						TI Titanium						Tool Identification				
2B	3B	Override				2BX	3BX	2BX	3BX	Class of Fit						
NE2	NE2	NE2				NT2	NT2	NT2	NT2	Coating						
HSS Extra	HSS Extra	HSS Extra				HSS Extra	HSS Extra	HSS Extra	HSS Extra	Cutting Material						
R35	R35	R35				L15	L15	R15	R15	Technical Characteristics						
C / 2-3	C / 2-3	C / 2-3				D / 4-5	D / 4-5	C / 2-3	C / 2-3							
E / O / P	E / O / P	E / O / P				E / O / P	E / O / P	E / O / P	E / O / P	Thread Depth and Hole Shape						
max. 2.5 x d ₁ 						max. 3 x d ₁ 										
P 1.1-3.1	P 1.1-3.1	P 1.1-3.1				P 4.1-5.1	P 4.1-5.1	P 4.1-5.1	P 4.1-5.1	Applications – Material						
M 1.1-2.1	M 1.1-2.1	M 1.1-2.1				M 3.1-4.1	M 3.1-4.1	M 3.1-4.1	M 3.1-4.1							
K 2.1	K 2.1	K 2.1				N 2.4-5, 2, 7	N 2.4-5, 2, 7	N 2.4-5, 2, 7	N 2.4-5, 2, 7							
						S 1.1-2.2, 2, 4	S 1.1-2.2, 2, 4	S 1.1-2.2, 2, 4	S 1.1-2.2, 2, 4							
AU503200		AU503210		AU503244		AU306001		AU306011		AU456001		AU456011				
Enorm VA NE2	Flutes	Enorm VA NE2	Flutes	Enorm VA NE2	Flutes	Rekord C-TI NT2	Flutes	Rekord C-TI NT2	Flutes	Rekord D-TI NT2	Flutes	Rekord D-TI NT2	Flutes	Dimens. ID	Nominal Size ø d ₁	T.P.I.
●	3					●	3			●	3			.5039	No. 6	40
●	3					●	3			●	3			.5040	No. 8	36
●	3	●	3	2) ● (+.0035)	3	●	3	●	3	●	3	●	3	.5041	No. 10	32
●	3	●	3	● (+.0050)	3	●	3	●	3	●	3	●	3	.5043	1/4	28
●	3	●	3	● (+.0050)	3	●	3	●	3	●	3	●	3	.5044	5/16	24
●	3	●	3	● (+.0050)	3	●	3	●	3	●	3	●	3	.5045	3/8	24
●	3	●	3	● (+.0050)	3	●	3	●	3	●	3	●	3	.5046	7/16	20
●	4	●	4	● (+.0050)	4	●	3	●	3	●	3	●	3	.5047	1/2	20
●	4	●	4			●	3	●	3	●	3	●	3	.5048	9/16	18
●	4	●	4	● (+.0050)	4	●	3	●	3	●	3	●	3	.5049	5/8	18
●	4	●	4			●	4	●	4	●	4	●	4	.5050	3/4	16

2) Tool Identification = AU503243

Product Finder

V_c

UNC

UNF

UNEF

UN-8

...

MF

NPSM/NPSC

NPSF

Rp (BSPP)

G

NPT

NTF

Rc (BSPT)

STI

SELF-LOCK

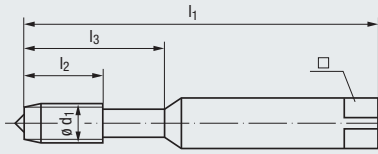
Accessories

Tech. Info

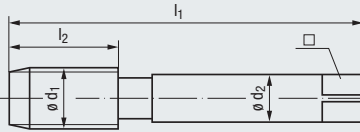


- Product Finder
- Vc
- UNC
- UNF
- UNEF
- UN-8
- M
- MF
- NPSM/NPSC
- NPSF
- Rp (BSPP)
- G
- NPT
- NPTF
- Rc (BSPT)
- STI
- SELF-LOCK
- Accessories
- Tech. Info

ANSI Length • ANSI Shank



Reinforced Shank
(No.6 - 3/8)



Reduced Shank
(7/16 - 3/4)

H Materials of High Tensile Strength	

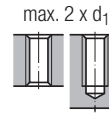


UNF Unified Fine Thread ASME B1.1

Class of Fit
Coating
Cutting Material
Technical Characteristics

2BX	2BX
NT	TICN
HSS Extra	HSS Extra
C / 2-3	C / 2-3
E / O / P	E / O / P

Thread Depth and Hole Shape



Applications – Material

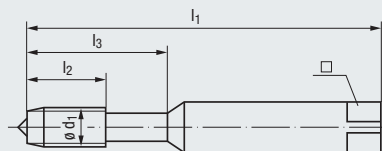
P 1.1-3.1	P 1.1-4.1
K 1.1-4.2	K 1.1-4.2
N 2.4-7	N 2.4-7
N 4.1, 5.1	N 4.1, 5.1

Tool Identification

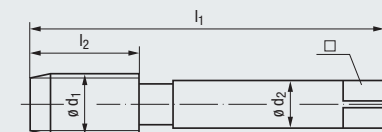
AU100501 AU109101

Nominal Size ø d ₁	T.P.I.	inch				ø d ₂	□	Dimens. ID	AU100501		AU109101		
		l ₁	l ₂	l ₃	□				Rekord A-H NT	Flutes	Rekord A-H TICN	Flutes	
No. 6	40	2	2.00	0.472	0.748	0.141	0.110	0.1181	.5039	●	3	●	3
No. 8	36	2 1/8	2.13	0.512	0.827	0.168	0.131	0.1378	.5040	●	3	●	3
No. 10	32	2 3/8	2.38	0.591	0.945	0.194	0.152	0.1614	.5041	●	3	●	3
1/4	28	2 1/2	2.50	0.669	1.142	0.255	0.191	0.2165	.5043	●	3	●	3
5/16	24	2 23/32	2.72	0.669	1.299	0.318	0.238	0.2717	.5044	●	3	●	3
3/8	24	2 15/16	2.94	0.709	1.378	0.381	0.286	0.3346	.5045	●	4	●	4
7/16	20	3 5/32	3.16	0.866	—	0.323	0.242	0.3898	.5046	●	4	●	4
1/2	20	3 3/8	3.38	0.866	—	0.367	0.275	0.4528	.5047	●	4	●	4
9/16	18	3 19/32	3.59	0.866	—	0.429	0.322	0.5118	.5048	●	4	●	4
5/8	18	3 13/16	3.81	0.866	—	0.480	0.360	0.5709	.5049	●	4	●	4
3/4	16	4 1/4	4.25	0.984	—	0.590	0.442	0.6890	.5050	●	4	●	4

ANSI Length • ANSI Shank

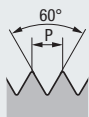


Reinforced Shank
(No.6 - 3/8)

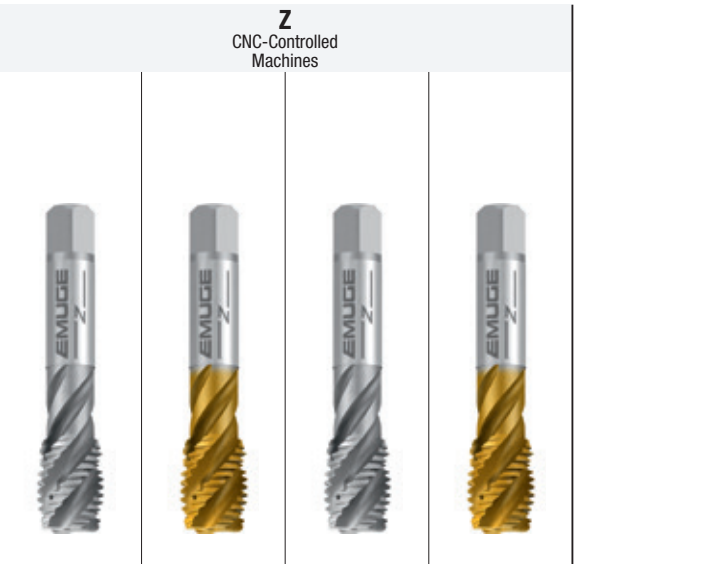


Reduced Shank
(7/16 - 3/4)

UNF
Unified Fine Thread
ASME B1.1



Class of Fit: 2B, 3B
Coating: HSS Extra, TIN
Cutting Material: R45
Technical Characteristics: E / 1.5-2
Thread Depth and Hole Shape: max. 3 x d₁



2B	2B	3B	3B
HSS Extra	HSS Extra	HSS Extra	HSS Extra
R45	R45	R45	R45
E / 1.5-2	E / 1.5-2	E / 1.5-2	E / 1.5-2
E / O / P	E / O / P	E / O / P	E / O / P

Applications – Material

P 1.1-4.1	P 1.1-4.1	P 1.1-4.1	P 1.1-4.1
M 1.1-2.1	M 1.1-3.1	M 1.1-2.1	M 1.1-3.1
N 2.1	N 1.4-6	N 2.1	N 1.4-6
	N 2.1-2, 2.4-5		N 2.1-2, 2.4-5
	S 1.1		S 1.1

Tool Identification		AU513500		AU513700		AU513510		AU513710	
Nominal Size ø d ₁	T.P.I.	Enorm Z/E	Flutes	Enorm Z/E TIN	Flutes	Enorm Z/E	Flutes	Enorm Z/E TIN	Flutes
No. 6	40	●	3	●	3				
No. 8	36	●	3	●	3				
No. 10	32	●	3	●	3	●	3	●	3
1/4	28	●	3	●	3	●	3	●	3
5/16	24	●	3	●	3	●	3	●	3
3/8	24	●	3	●	3	●	3	●	3
7/16	20	●	4	●	4	●	4	●	4
1/2	20	●	5	●	5	●	5	●	5
9/16	18	●	5	●	5	●	5	●	5
5/8	18	●	5	●	5	●	5	●	5
3/4	16	●	5	●	5	●	5	●	5

Nominal Size ø d ₁	T.P.I.	inch						□
		l ₁	l ₂	l ₃	ø d ₂	□		
No. 6	40	2	2.00	0.276	0.748	0.141	0.110	0.1181
No. 8	36	2 1/8	2.13	0.315	0.827	0.168	0.131	0.1378
No. 10	32	2 3/8	2.38	0.354	0.945	0.194	0.152	0.1614
1/4	28	2 1/2	2.50	0.394	1.142	0.255	0.191	0.2165
5/16	24	2 23/32	2.72	0.394	1.299	0.318	0.238	0.2717
3/8	24	2 15/16	2.94	0.394	1.378	0.381	0.286	0.3346
7/16	20	3 5/32	3.16	0.512	—	0.323	0.242	0.3898
1/2	20	3 3/8	3.38	0.512	—	0.367	0.275	0.4528
9/16	18	3 19/32	3.59	0.591	—	0.429	0.322	0.5118
5/8	18	3 13/16	3.81	0.591	—	0.480	0.360	0.5709
3/4	16	4 1/4	4.25	0.669	—	0.590	0.442	0.6890

DIN Length • ANSI Shank



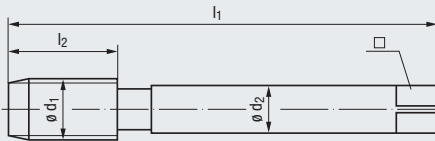
All ANSI Length • ANSI Shank taps are available in the popular DIN Length • ANSI Shank style.

The DIN Length • ANSI Shank configuration allows for added reach capabilities and greater chip clearance.

● = In stock
★ = Allow 7 days for delivery

- Product Finder
- V_c
- UNC
- UNF
- UNEF
- UN-8
- M
- MF
- NPSM/NPSC
- NPSF
- Rp (BSPP)
- G
- NPT
- NPTF
- Rc (BSPT)
- STI
- SELF-LOCK
- Accessories
- Tech. Info

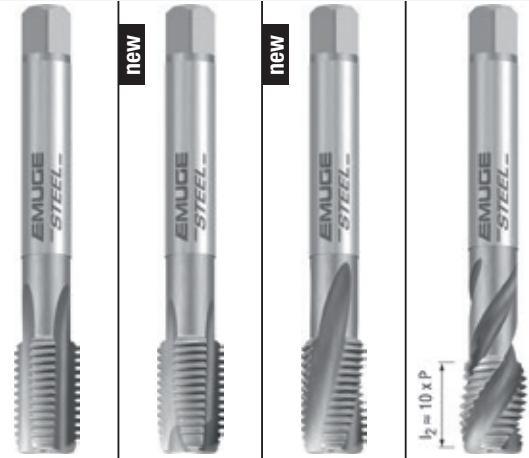
DIN Length · DIN Shank



Reduced Shank

STEEL

Steel Materials



UNEF

Unified Extra Fine Thread
ASME B1.1

Class of Fit
Coating
Cutting Material
Technical Characteristics



Thread Depth and Hole Shape

Applications – Material

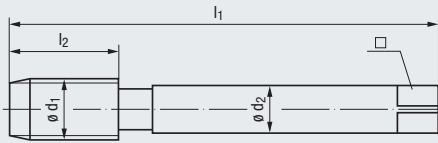
2BX	2B	2B	2B
HSS Extra	HSS Extra	HSS Extra	HSS Extra
C / 2-3	B / 4-5	E / 1.5-2	C / 2-3
E / 0	E / 0	E / 0	E / 0
max. 2 x d ₁	max. 3 x d ₁	max. 2 x d ₁	max. 2.5 x d ₁
P 1.1-3.1 N 2.3	P 1.1-3.1 N 2.2	P 2.1-3.1	P 1.1-3.1 N 2.2

Reduced Shank

Nominal Size ø d ₁	T.P.I.	mm				□	Tool Identification		C0101001		C0208900		C0461000		C0501000	
		l ₁	l ₂	ø d ₂			Rekord 2A-STEEL	Dimens. ID	Rekord 2B-STEEL-L	Rekord 2D-STEEL/E	Enorm 2-STEEL	Flutes	Flutes	Flutes	Flutes	
1/4	32	80	14	4.5	3.4	5.55	.5058	★	3	★	3	★	3	★	3	
5/16	32	80	14	6	4.9	7.15	.5059	★	3	★	3	★	3	★	3	
3/8	32	90	18	7	5.5	8.7	.5060	★	4	★	4	★	3	★	4	
7/16	28	90	18	8	6.2	10.2	.5061	★	4	★	4	★	3	★	3	
1/2	28	100	18	9	7	11.8	.5062	★	4	★	4	★	3	★	4	
9/16	24	100	18	11	9	13.2	.5063	★	5	★	4	★	4	★	4	
5/8	24	100	18	12	9	14.8	.5064	★	5	★	4	★	4	★	4	
3/4	20	110	25	14	11	17.8	.5066	★	4	★	4	★	4	★	4	
7/8	20	125	25	18	14.5	20.95	.5068	★	4	★	4	★	4	★	4	
1	20	140	28	18	14.5	24.15	.5070	★	4	★	4	★	4	★	5	

DIN Length • ANSI Shank

Overall length acc. to DIN 376



Reduced Shank

UN-8

Unified Thread
ASME B1.1



Class of Fit
Coating
Cutting Material
Technical Characteristics



Thread Depth
and Hole Shape

Applications – Material

VA
Stainless Steel
Materials



2B	2B	2B	3B	3B
GLT-1	TICN	NE2	NE2	GLT-1
HSS Extra	HSS Extra	HSS Extra	HSS Extra	HSS Extra
B / 4-5	B / 4-5	R35	R35	R35
E / O / P	E / O / P	C / 2-3	C / 2-3	C / 2-3
E / O / P	E / O / P	E / O / P	E / O / P	E / O / P

max. 3 x d₁



max. 2.5 x d₁



P 1.1-4.1	P 1.1-4.1	P 1.1-3.1	P 1.1-3.1	P 1.1-4.1
M 1.1-2.1	M 1.1-3.1	M 1.1-2.1	M 1.1-2.1	M 1.1-3.1
K 2.1	K 2.1	K 2.1	K 2.1	K 2.1
N 2.2, 2.5-6	N 2.2, 2.5-6			

Reduced Shank

Nominal Size ø d ₁	T.P.I.	inch				Tool Identification		CU20C300		CU209300		CU503200		CU503210		CU50C310	
		l ₁	l ₂	ø d ₂	□	Dimens. ID	Rekord 2B-VA GLT-1	Flutes	Rekord 2B-VA TICN	Flutes	Enorm 2-VA NE2	Flutes	Enorm 2-VA NE2	Flutes	Enorm 2-VA GLT-1	Flutes	
1	8	6.299	1.417	0.800	0.600	0.8750	.5018	●	3	●	3	●	4	●	4	●	4
1 1/8	8	7.087	1.575	0.896	0.672	1.0000	.5247	●	4	●	4	●	4	●	4	●	4
1 1/4	8	7.087	1.575	1.021	0.766	1.1250	.5249	●	4	●	4	●	4	●	4	●	4
1 3/8	8	7.874	1.654	1.108	0.831	1.2500	.5251	●	4	●	4	●	5	●	5	●	5
1 1/2	8	7.874	1.654	1.233	0.925	1.3750	.5253	●	4	●	4	●	5	●	5	●	5
1 5/8	8	7.874	1.772	1.305	0.979	1.5000	.5255	●	4	●	4	●	5	●	5	●	5
1 3/4	8	7.874	1.772	1.430	1.072	1.6250	.5257					●	6	●	6	●	6
1 7/8	8	8.858	1.969	1.519	1.139	1.7500	.5259					●	6	●	6	●	6
2	8	8.858	1.969	1.644	1.233	1.8750	.5261					●	6	●	6	●	6
2 1/2	8	10.827	2.165	2.100	1.575	2.3750	.5265										

● = In stock
★ = Allow 7 days for delivery

Product Finder

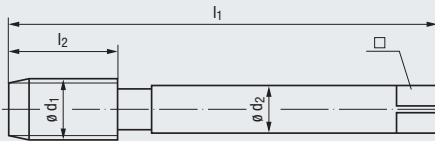
- Vc
- UNC
- UNF
- UNEF
- UN-8**
- MF
- NPSM/NPSC
- NPSF
- Rp (BSPP)
- G
- NPT
- NPTF
- Rc (BSPT)
- STI
- SELF-LOCK
- Accessories
- Tech. Info



- Product Finder
- V_c
- UNC
- UNF
- UNEF
- UN-8**
- M
- MF
- NPSM/NPSC
- NPSF
- Rp (BSPP)
- G
- NPT
- NPTF
- Rc (BSPT)
- STI
- SELF-LOCK
- Accessories
- Tech. Info

DIN Length - ANSI Shank

Overall length acc. to DIN 376



Reduced Shank

TI
Titanium



H
Materials of High Tensile Strength



UN-8



**Unified Thread
ASME B1.1**

Class of Fit
Coating
Cutting Material
Technical Characteristics



Thread Depth and Hole Shape

Applications - Material

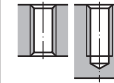
- 2BX
- NT2
- HSS Extra
- R15
- C / 2-3
- E / O / P

- 2BX
- NT
- HSS Extra
- C / 2-3
- E / O / P

max. 2 x d₁



max. 2 x d₁



- P** 4.1-5.1
- M** 3.1-4.1
- N** 2.4-5, 2.7
- S** 1.1-2.2, 2.4

- P** 1.1-3.1
- K** 1.1-4.2
- N** 2.4-7
- N** 4.1, 5.1

Reduced Shank

Tool Identification

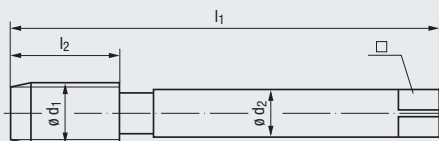
CU456001

CU100501

Nominal Size ø d ₁	T.P.I.	inch				□	Image	Dimens. ID	CU456001		CU100501	
		l ₁	l ₂	ø d ₂	□				Rekord 2D-TI NT2	Flutes	Rekord 2A-H NT	Flutes
1	8	6.299	1.417	0.800	0.600		0.8750	.5018	●	3	●	4
1 1/8	8	7.087	1.575	0.896	0.672		1.0000	.5247	●	4	●	4
1 1/4	8	7.087	1.575	1.021	0.766		1.1250	.5249	●	4	●	4
1 3/8	8	7.874	1.654	1.108	0.831		1.2500	.5251	●	4	●	4
1 1/2	8	7.874	1.654	1.233	0.925		1.3750	.5253	●	4	●	4
1 5/8	8	7.874	1.772	1.305	0.979		1.5000	.5255	●	4	●	4
1 3/4	8	7.874	1.772	1.430	1.072		1.6250	.5257	●		●	5
1 7/8	8	8.858	1.969	1.519	1.139		1.7500	.5259	●		●	
2	8	8.858	1.969	1.644	1.233		1.8750	.5261	●	6	●	6
2 1/2	8	10.827	2.165	2.100	1.575		2.3750	.5265	●		●	6

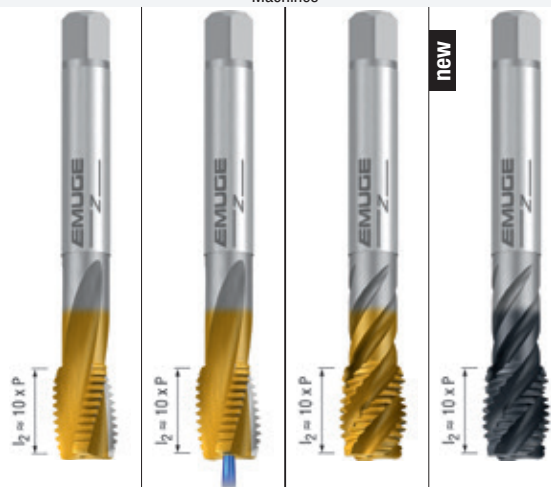
DIN Length • ANSI Shank

Overall length acc. to DIN 376



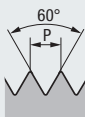
Reduced Shank

Z
CNC-Controlled
Machines



UN-8

Unified Thread
ASME B1.1



Class of Fit
Coating
Cutting Material
Technical Characteristics



2BX	2BX	2B	2B
TIN	TIN	TIN	GLT-1
HSS Extra	HSS Extra	HSS Extra	HSS Extra
R15	R15	R45	R45
C / 2-3	C / 2-3	C / 2-3	C / 2-3
E / O / P	E / O	E / O / P	E / O / P

Thread Depth
and Hole Shape

max. 2 x d₁



max. 3 x d₁



Applications – Material

P 2.1-5.1	P 2.1-5.1	P 1.1-4.1	P 1.1-4.1
K 2.1-2	K 2.1-2	M 1.1-3.1	M 1.1-3.1
N 1.4-6, 2.4-5	N 1.4-6, 2.4-5	N 1.4-6	N 1.4-6
		N 2.1-2, 2.4-5	N 2.1-2, 2.4-5
		S 1.1	S 1.1

Reduced Shank

Tool Identification

CU573701 CU583701 CU503700 CU50C400

Nominal Size ø d ₁	T.P.I.	inch				□	Tool ID	CU573701		CU583701		CU503700		CU50C400	
		l ₁	l ₂	ø d ₂	□			Rekord 2D-Z-BF TIN	Flutes	Rekord 2D-Z-BF IKZ-TIN	Flutes	Enorm 2-Z TIN	Flutes	Enorm 2-Z GLT-1	Flutes
1	8	6.299	1.417	0.800	0.600	0.8750	.5018	●	3	●	3	● ¹⁾	5	● ²⁾	5
1 1/8	8	7.087	1.575	0.896	0.672	1.0000	.5247	●	4	●	4	●	5	●	5
1 1/4	8	7.087	1.575	1.021	0.766	1.1250	.5249	●	4	●	4	●	5	●	5
1 3/8	8	7.874	1.654	1.108	0.831	1.2500	.5251	●	4	●	4	●	6	●	6
1 1/2	8	7.874	1.654	1.233	0.925	1.3750	.5253	●	4	●	4	●	6	●	6
1 5/8	8	7.874	1.772	1.305	0.979	1.5000	.5255	●	4	●	4	●	6	●	6
1 3/4	8	7.874	1.772	1.430	1.072	1.6250	.5257	●	5	●	5	●	8	●	8
1 7/8	8	8.858	1.969	1.519	1.139	1.7500	.5259	●	6	●	6	●	8	●	8
2	8	8.858	1.969	1.644	1.233	1.8750	.5261	●	6	●	6	●	8	●	8
2 1/2	8	10.827	2.165	2.100	1.575	2.3750	.5265	●	6	●	6	●	8	●	8

1) Chamfer form/threads = E/1.5-2, Tool Identification = CU513700
 2) Chamfer form/threads = E/1.5-2, Tool Identification = CU51C400



- Product Finder
- V_c
- UNC
- UNF
- UNEF
- UN-8**
- ...
- MF
- NPSM/NPSC
- NPSF
- R_p (BSPP)
- G
- NPT
- NPTF
- R_c (BSPT)
- STI
- SELF-LOCK
- Accessories
- Tech. Info

- Product Finder
- V_c
- UNC
- UNF
- UNEF
- UN-8**
- M
- MF
- NPSM/NPSC
- NPSF
- Rp (BSPP)
- G
- NPT
- NPTF
- Rc (BSPT)
- STI
- SELF-LOCK
- Accessories
- Tech. Info

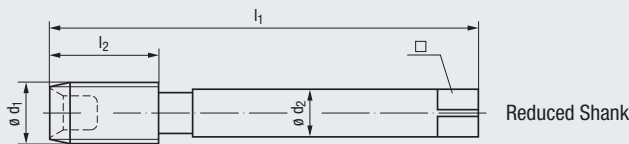
DIN Length - ANSI Shank

Overall length acc. to DIN 376

VA
Stainless Steel
Materials



With internal chip collector



UN-8



**Unified Thread
ASME B1.1**

Class of Fit

3BX 2)

Coating

NE2

Cutting Material

HSS Extra

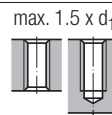
Technical Characteristics



C / 2-3

P / O 1)

Thread Depth
and Hole Shape



Applications - Material

P 1.1-4.1

M 1.1-2.1

K 1.1-4.2

Reduced Shank

Tool Identification

CU803011

Nominal Size ø d ₁	T.P.I.	inch		ø d ₂	□	Dimens. ID	Robust 2X-VA NE2	Flutes
		l ₁	l ₂					
1	8	6.299	1.417	0.800	0.600	0.8750	.5018	5
1 1/8	8	7.087	1.575	0.896	0.672	1.0000	.5247	5
1 1/4	8	7.087	1.575	1.021	0.766	1.1250	.5249	6
1 3/8	8	7.874	1.654	1.108	0.831	1.2500	.5251	6
1 1/2	8	7.874	1.654	1.233	0.925	1.3750	.5253	6
1 5/8	8	7.874	1.772	1.305	0.979	1.5000	.5255	6
1 3/4	8	7.874	1.772	1.430	1.072	1.6250	.5257	6
1 7/8	8	8.858	1.969	1.519	1.139	1.7500	.5259	6
2	8	8.858	1.969	1.644	1.233	1.8750	.5261	6
2 1/4	8	9.843	1.969	1.894	1.420	2.1250	.5263	7
2 1/2	8	10.827	2.165	2.100	1.575	2.3750	.5265	7
3	8	11.810	2.165	2.100	1.575	2.8750	.5269	8
3 1/2	8	12.795	2.362	2.350	1.762	3.3750	.5273	10
4	8	13.780	2.362	2.350	1.762	3.8750	.5277	10
4 1/2	8	13.780	2.559	2.350	1.762	4.3750	.5281	10

1) If possible, use paste lubrication, coating both the tool and the walls of the drilled hole. Lubrication with oil is possible only in the vertical machining of blind holes, if the hole is entirely filled with oil.

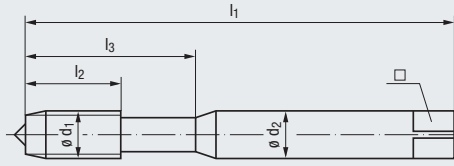
2) Class 2B threads may be produced with 3BX taps.

Larger sizes priced upon request. We have experience in making taps as large as 10 inches ø UN.

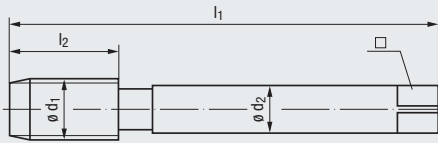
The Complete Tool System

Robust 2X-VA Taps when used with a KSN Type tapping attachment creates the optimal tapping unit!

DIN Length • DIN Shank



Reinforced Shank (M2 - M10)



Reduced Shank (M12 - M52)

M

**ISO Metric Coarse Thread
DIN 13**

Class of Fit
Coating
Cutting Material
Technical Characteristics



ISO 2/6H	ISO 2/6H	ISO 2/6H	ISO 3/6G	7G
HSS Extra	HSS Extra	HSS Extra	HSS Extra	HSS Extra
B / 4-5	B / 4-5	B / 4-5	B / 4-5	B / 4-5
E / 0	E / 0	E / 0	E / 0	E / 0

Thread Depth and Hole Shape



Applications – Material

P 1.1-3.1 N 2.2	P 1.1-4.1 K 2.1 N 2.2, 2.4-5	P 1.1-4.1 K 2.1	P 1.1-3.1 N 2.2	P 1.1-3.1 N 2.2
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Reinforced Shank

Nominal Size ϕd_1	P	l_1	mm			ϕd_2	\square	Tool Identification		B0208900		B0208400		B020K500		B0208920		B0208930	
			l_2	l_3	ϕd_2			\square	Rekord 1B-STEEL-L	Flutes	Rekord 1B-STEEL-L TIN	Flutes	Rekord 1B-STEEL-L GLT-1	Flutes	Rekord 1B-STEEL-L	Flutes	Rekord 1B-STEEL-L	Flutes	
M 2	0.4	45	7	12	2.8	2.1	1.6	.0020	●	2	●	2	●	2	★	2	★	2	
M 2.5	0.45	50	9	14	2.8	2.1	2.05	.0025	●	2	●	2	●	2	★	2	★	2	
M 3	0.5	56	11	18	3.5	2.7	2.5	.0030	●	3	●	3	●	3	★	3	★	3	
M 3.5	0.6	56	12	20	4	3	2.9	.0035	●	3	●	3	●	3	★	3	★	3	
M 4	0.7	63	13	21	4.5	3.4	3.3	.0040	●	3	●	3	●	3	★	3	★	3	
M 4.5	0.75	70	14	25	6	4.9	3.7	.0045	●	3	●	3	●	3	★	3	★	3	
M 5	0.8	70	15	25	6	4.9	4.2	.0050	●	3	●	3	●	3	★	3	★	3	
M 6	1	80	17	30	6	4.9	5	.0060	●	3	●	3	●	3	★	3	★	3	
M 8	1.25	90	20	35	8	6.2	6.8	.0080	●	3	●	3	●	3	★	3	★	3	
M 10	1.5	100	22	39	10	8	8.5	.0100	●	3	●	3	●	3	★	3	★	3	

Reduced Shank

Nominal Size ϕd_1	P	l_1	mm			ϕd_2	\square	Tool Identification		C0208900		C0208400		C0208920		C0208930		
			l_2	l_3	ϕd_2			\square	Rekord 2B-STEEL-L	Flutes	Rekord 2B-STEEL-L TIN	Flutes	Rekord 2B-STEEL-L	Flutes	Rekord 2B-STEEL-L	Flutes		
M 12	1.75	110	24	—	9	7	10.2	.0112	●	3	●	3	●	3	★	3	★	3
M 14	2	110	26	—	11	9	12	.0114	●	3	●	3	●	3	★	3	★	3
M 16	2	110	27	—	12	9	14	.0116	●	3	●	3	●	3	★	3	★	3
M 18	2.5	125	30	—	14	11	15.5	.0118	●	3	●	3	●	3	★	3	★	3
M 20	2.5	140	32	—	16	12	17.5	.0120	●	3	●	3	●	3	★	3	★	3
M 22	2.5	140	32	—	18	14.5	19.5	.0122	●	3	●	3	●	3	★	3	★	3
M 24	3	160	34	—	18	14.5	21	.0124	●	3	●	3	●	3	★	3	★	3
M 27	3	160	36	—	20	16	24	.0127	★	3	★	3	★	3	★	3	★	3
M 30	3.5	180	40	—	22	18	26.5	.0130	★	4	★	4	★	4	★	4	★	4
M 33	3.5	180	40	—	25	20	29.5	.0133	★	4	★	4	★	4	★	4	★	4
M 36	4	200	50	—	28	22	32	.0136	★	4	★	4	★	4	★	4	★	4
M 42	4.5	200	56	—	32	24	37.5	.0142	★	4	★	4	★	4	★	4	★	4
M 45	4.5	220	58	—	36	29	40.5	.0145	★	4	★	4	★	4	★	4	★	4
M 48	5	250	65	—	36	29	43	.0148	★	4	★	4	★	4	★	4	★	4
M 52	5	250	65	—	40	32	47	.0152	★	4	★	4	★	4	★	4	★	4

● = In stock
★ = Allow 7 days for delivery

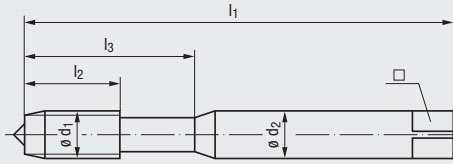
Product Finder

- Vc
- UNC
- UNF
- UNEF
- UN-8
- M**
- MF
- NPSM/NPSC
- NPSF
- Rp (BSPP)
- G
- NPT
- NPTF
- Rc (BSPT)
- STI
- SELF-LOCK
- Accessories
- Tech. Info

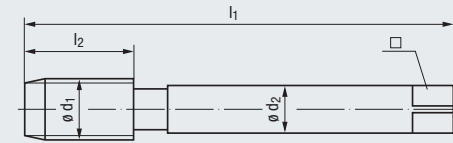


- Product Finder
- V_c
- UNC
- UNF
- UNEF
- UN-8
- M
- MF
- NPSM/NPSC
- NPSF
- Rp (BSPP)
- G
- NPT
- NPTF
- Rc (BSPT)
- STI
- SELF-LOCK
- Accessories
- Tech. Info

DIN Length • DIN Shank



Reinforced Shank (M2 - M10)



Reduced Shank (M12 - M52)

M

ISO Metric Coarse Thread DIN 13

Class of Fit
Coating
Cutting Material
Technical Characteristics



Thread Depth and Hole Shape

Applications – Material

new	STEEL Steel Materials				
	ISO 2/6H	ISO 2/6H	ISO 2/6H	ISO 2/6H	ISO 3/6G
	HSS Extra	HSS Extra	HSS Extra	HSS Extra	HSS Extra
	LH	R15	R35	R35	R35
	B / 4-5	E / 1.5-2	C / 2-3	C / 2-3	C / 2-3
	E / 0	E / 0	E / 0	E / 0	E / 0
	max. 3 x d ₁	max. 2 x d ₁	max. 2.5 x d ₁		
	P 1.1-3.1 N 2.2	P 1.1-4.1 K 1.1-4.2 N 1.4-5, 2.4-5	P 1.1-3.1 N 2.2	P 1.1-4.1 K 2.1 N 2.2	P 1.1-3.1 N 2.2

Reinforced Shank



Nominal Size ø d ₁	P	mm					□	Tool Identification	B0208950		B0461400		B0501000		B0501400		B0501020	
		l ₁	l ₂	l ₃	ø d ₂	□			Rekord 1B-STEEL-L LH	Flutes	Rekord 1D-STEEL/E TIN	Flutes	Enorm 1-STEEL	Flutes	Enorm 1-STEEL TIN	Flutes	Enorm 1-STEEL	Flutes
M 2	0.4	45	7	12	2.8	2.1	1.6	.0020	★	2	●	2	●	2	★	2	★	2
M 2.5	0.45	50	9	14	2.8	2.1	2.05	.0025	★	2	●	2	★	2	★	2	★	2
M 3	0.5	56	11	18	3.5	2.7	2.5	.0030	★	3	●	2	●	3	★	3	★	3
M 3.5	0.6	56	12	20	4	3	2.9	.0035	★	3	●	3	●	3	★	3	★	3
M 4	0.7	63	13	21	4.5	3.4	3.3	.0040	★	3	●	3	●	3	★	3	★	3
M 4.5	0.75	70	14	25	6	4.9	3.7	.0045	★	3	●	3	●	3	★	3	★	3
M 5	0.8	70	15	25	6	4.9	4.2	.0050	★	3	●	3	●	3	★	3	★	3
M 6	1	80	17	30	6	4.9	5	.0060	★	3	●	3	●	3	★	3	★	3
M 8	1.25	90	20	35	8	6.2	6.8	.0080	★	3	●	3	●	3	★	3	★	3
M 10	1.5	100	22	39	10	8	8.5	.0100	★	3	●	3	●	3	★	3	★	3

Reduced Shank

Nominal Size ø d ₁	P	mm					□	Tool Identification	C0208950		C0461400		C0501000		C0501400		C0501020	
		l ₁	l ₂	l ₃	ø d ₂	□			Rekord 2B-STEEL-L LH	Flutes	Rekord 2D-STEEL/E TIN	Flutes	Enorm 2-STEEL	Flutes	Enorm 2-STEEL TIN	Flutes	Enorm 2-STEEL	Flutes
M 12	1.75	110	24	—	9	7	10.2	.0112	★	3	●	3	●	3	★	3	★	3
M 14	2	110	26	—	11	9	12	.0114	★	3	●	3	●	3	★	3	★	3
M 16	2	110	27	—	12	9	14	.0116	★	3	●	3	●	3	★	3	★	3
M 18	2.5	125	30	—	14	11	15.5	.0118	★	3	●	3	●	3	★	3	★	3
M 20	2.5	140	32	—	16	12	17.5	.0120	★	3	●	3	●	3	★	3	★	3
M 22	2.5	140	32	—	18	14.5	19.5	.0122	★	3	●	3	●	4	★	4	★	4
M 24	3	160	34	—	18	14.5	21	.0124	★	3	●	3	●	4	★	4	★	4
M 27	3	160	36	—	20	16	24	.0127	★	3	●	3	★	4	★	4	★	4
M 30	3.5	180	40	—	22	18	26.5	.0130	★	3	●	3	●	4	★	4	★	4
M 33	3.5	180	40	—	25	20	29.5	.0133	★	3	●	3	●	4	★	4	★	4
M 36	4	200	50	—	28	22	32	.0136	★	3	●	3	●	4	★	4	★	4
M 42	4.5	200	56	—	32	24	37.5	.0142	★	3	●	3	●	5	★	5	★	5
M 45	4.5	220	58	—	36	29	40.5	.0145	★	3	●	3	●	5	★	5	★	5
M 48	5	250	65	—	36	29	43	.0148	★	3	●	3	●	5	★	5	★	5
M 52	5	250	65	—	40	32	47	.0152	★	3	●	3	●	6	★	6	★	6

- Product Finder
- Vc
- UNC
- UNF
- UNEF
- UN-8
- M**
- MF
- NPSM/NPSC
- NPSF
- Rp (BSPP)
- G
- NPT
- NTF
- Rc (BSPT)
- STI
- SELF-LOCK
- Accessories
- Tech. Info

STEEL Steel Materials				VA Stainless Steel Materials			
new 		new 		new 			
ISO 3/6G	7G	7G	ISO 2/6H	ISO 2/6H	ISO 3/6G	7G	Class of Fit Coating Cutting Material Technical Characteristics 
TIN	HSS Extra	TIN	HSS Extra	GLT-1	NT	NT	
HSS Extra	R35	HSS Extra	HSS Extra	HSS Extra	HSS Extra	HSS Extra	
R35	C / 2-3	R35	C / 2-3	B / 4-5	B / 4-5	B / 4-5	
C / 2-3	E / O	C / 2-3	E / O	E / O / P	E / O / P	E / O / P	

max. 2.5 x d ₁ 	max. 3 x d ₁ 	Thread Depth and Hole Shape
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P 1.1-4.1 K 2.1 N 2.2	P 1.1-3.1 N 2.2	P 1.1-4.1 K 2.1 N 2.2	P 1.1-3.1 N 2.2	P 1.1-4.1 M 1.1-3.1 K 2.1 N 2.2	P 1.1-3.1 M 1.1-2.1 K 2.1 N 2.2, 2.5-6	P 1.1-3.1 M 1.1-2.1 K 2.1 N 2.2, 2.5-6	Applications – Material
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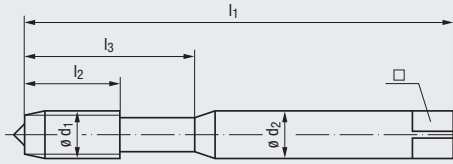
B0501420		B0501030		B0501430		B0501050		B020C300		B0203020		B0203030		Tool Identification		
Enorm 1-STEEL TIN	Flutes	Enorm 1-STEEL	Flutes	Enorm 1-STEEL TIN	Flutes	Enorm 1-STEEL-LH	Flutes	Rekord 1B-VA GLT-1	Flutes	Rekord 1B-VA NT	Flutes	Rekord 1B-VA NT	Flutes	Dimens. ID	Nominal Size ø d ₁	P
★	2	★	2	★	2			●	2	★	2	★	2	.0020	M 2	0.4
★	2	★	2	★	2			●	2	★	2	★	2	.0025	M 2.5	0.45
★	3	★	3	★	3	★	3	●	3	★	3	★	3	.0030	M 3	0.5
★	3	★	3	★	3	★	3	●	3	★	3	★	3	.0035	M 3.5	0.6
★	3	★	3	★	3	★	3	●	3	★	3	★	3	.0040	M 4	0.7
★	3	★	3	★	3	★	3	●	3	★	3	★	3	.0045	M 4.5	0.75
★	3	★	3	★	3	★	3	●	3	★	3	★	3	.0050	M 5	0.8
★	3	★	3	★	3	★	3	●	3	★	3	★	3	.0060	M 6	1
★	3	★	3	★	3	★	3	●	3	★	3	★	3	.0080	M 8	1.25
★	3	★	3	★	3	★	3	●	3	★	3	★	3	.0100	M 10	1.5

C0501420		C0501030		C0501430		C0501050		C020C300		C0203020		C0203030		Tool Identification		
Enorm 2-STEEL TIN	Flutes	Enorm 2-STEEL	Flutes	Enorm 2-STEEL TIN	Flutes	Enorm 2-STEEL-LH	Flutes	Rekord 2B-VA GLT-1	Flutes	Rekord 2B-VA NT	Flutes	Rekord 2B-VA NT	Flutes	Dimens. ID	Nominal Size ø d ₁	P
★	3	★	3	★	3	★	3	●	3	★	3	★	3	.0112	M 12	1.75
★	3	★	3	★	3	★	3	●	3	★	3	★	3	.0114	M 14	2
★	3	★	3	★	3	★	3	●	3	★	3	★	3	.0116	M 16	2
★	3	★	3	★	3	★	3	●	3	★	3	★	3	.0118	M 18	2.5
★	3	★	3	★	3	★	3	●	3	★	3	★	3	.0120	M 20	2.5
★	4	★	4	★	4	★	4	●	3	★	3	★	3	.0122	M 22	2.5
								●	3					.0124	M 24	3
								●	3					.0127	M 27	3
								●	4					.0130	M 30	3.5
								●	4					.0133	M 33	3.5
								●	4					.0136	M 36	4
								●	4					.0142	M 42	4.5
								●	4					.0145	M 45	4.5
								●	4					.0148	M 48	5
								●	4					.0152	M 52	5

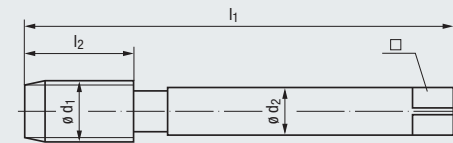
● = In stock
★ = Allow 7 days for delivery

- Product Finder
- V_c
- UNC
- UNF
- UNEF
- UN-8
- M**
- MF
- NPSM/NPSC
- NPSF
- Rp (BSPP)
- G
- NPT
- NPTF
- Rc (BSPT)
- STI
- SELF-LOCK
- Accessories
- Tech. Info

DIN Length • DIN Shank



Reinforced Shank
(M2 - M10)



Reduced Shank
(M12 - M52)

M

**ISO Metric Coarse Thread
DIN 13**

Class of Fit
Coating
Cutting Material
Technical Characteristics

Thread Depth
and Hole Shape

Applications – Material

VA Stainless Steel Materials	GJV Cast Iron Vermicular
ISO 2/6H	6HX
NE2	TICN
HSS Extra	HSSE-PM
R35	C / 2-3
C / 2-3	E
E / O / P	
max. 2.5 x d ₁	
P 1.1-3.1 M 1.1-2.1 K 2.1	K 1.1-4.2

Reinforced Shank

Nominal Size ø d ₁	P	mm			ø d ₂	□	Tool Identification	B0503000		B0503200		B050C300		B010R501	
		l ₁	l ₂	l ₃				Enorm 1-VA	Flutes	Enorm 1-VA NE2	Flutes	Enorm 1-VA GLT-1	Flutes	Rekord 1A-GJV PM-TICN	Flutes
M 2	0.4	45	7	12	2.8	2.1	1.6	.0020	★	2	●	2	★	2	
M 2.5	0.45	50	9	14	2.8	2.1	2.05	.0025	★	2	★	2	★	2	
M 3	0.5	56	11	18	3.5	2.7	2.5	.0030	★	3	●	3	★	3	
M 3.5	0.6	56	12	20	4	3	2.9	.0035	★	3	●	3			
M 4	0.7	63	13	21	4.5	3.4	3.3	.0040	★	3	●	3	★	3	★
M 4.5	0.75	70	14	25	6	4.9	3.7	.0045							
M 5	0.8	70	15	25	6	4.9	4.2	.0050	★	3	●	3	★	3	★
M 6	1	80	17	30	6	4.9	5	.0060	★	3	●	3	★	3	★
M 8	1.25	90	20	35	8	6.2	6.8	.0080	★	3	●	3	★	3	★
M 10	1.5	100	22	39	10	8	8.5	.0100	★	3	●	3	★	3	★

Reduced Shank

Nominal Size ø d ₁	P	mm			ø d ₂	□	Tool Identification	C0503000		C0503200		C010R501		
		l ₁	l ₂	l ₃				Enorm 2-VA	Flutes	Enorm 2-VA NE2	Flutes	Rekord 2A-GJV PM-TICN	Flutes	
M 12	1.75	110	24	—	9	7	10.2	.0112	★	3	●	3	★	4
M 14	2	110	26	—	11	9	12	.0114	★	3	●	3		
M 16	2	110	27	—	12	9	14	.0116	★	3	●	3	★	4
M 18	2.5	125	30	—	14	11	15.5	.0118	★	3	●	3		
M 20	2.5	140	32	—	16	12	17.5	.0120	★	3	●	3		
M 22	2.5	140	32	—	18	14.5	19.5	.0122	★	4	●	4		
M 24	3	160	34	—	18	14.5	21	.0124	★	4	●	4		
M 27	3	160	36	—	20	16	24	.0127	★	4	●	4		
M 30	3.5	180	40	—	22	18	26.5	.0130	★	4	●	4		
M 33	3.5	180	40	—	25	20	29.5	.0133						
M 36	4	200	50	—	28	22	32	.0136						
M 42	4.5	200	56	—	32	24	37.5	.0142						
M 45	4.5	220	58	—	36	29	40.5	.0145						
M 48	5	250	65	—	36	29	43	.0148						
M 52	5	250	65	—	40	32	47	.0152						

GJV Cast Iron Vermicular					AL Aluminum Wrought Alloys				
	new 			new 					
6HX	6HX	6HX	6HX	6HX	ISO 2/6H	ISO 2/6H	Class of Fit		
TICN	TICN	TICN	TICN	TICN	GLT-8	GLT-8	Coating		
HSSE-PM	HSSE-PM	HSSE-PM	HSSE-PM	HSSE-PM	HSS Extra	HSS Extra	Cutting Material		
C / 2-3	C / 2-3	E / 1.5-2	E / 1.5-2	E / 1.5-2	B / approx. 3	R45	Technical Characteristics		
E	E	E	E	E	E / 0	C / 2-3			
max. 2 x d ₁	max. 2 x d ₁	max. 2 x d ₁	max. 2 x d ₁	max. 2 x d ₁	max. 3 x d ₁	max. 2.5 x d ₁	Thread Depth and Hole Shape		
K 1.1-4.2	K 1.1-4.2	K 1.1-4.2	K 1.1-4.2	K 1.1-4.2	N 1.1-4	N 1.1-4	Applications – Material		
B195R501	B106R501	B011R501	B196R501	B109R501	B020S800	B050S800	Tool Identification		
Rekord 1A-GJV IKZ-PM TICN	Rekord 1A-GJV IKZN-PM TICN	Rekord 1A-GJV/E PM-TICN	Rekord 1A-GJV/E IKZ-PM TICN	Rekord 1A-GJV/E IKZN-PM TICN	Rekord 1B-AL GLT-8	Enorm 1-AL GLT-8	Dimens. ID	Nominal Size ø d ₁	P
Flutes	Flutes	Flutes	Flutes	Flutes	Flutes	Flutes			
	upon			upon	★	★	.0020	M 2	0.4
	request			request	★	★	.0025	M 2.5	0.45
		★	3		★	★	.0030	M 3	0.5
					★	★	.0035	M 3.5	0.6
					★	★	.0040	M 4	0.7
★	3	★	3	★	★	★	.0045	M 4.5	0.75
★	4	★	4	★	★	★	.0050	M 5	0.8
★	4	★	4	★	★	★	.0060	M 6	1
★	4	★	4	★	★	★	.0080	M 8	1.25
★	4	★	4	★	★	★	.0100	M 10	1.5
C195R501	C106R501	C011R501	C196R501	C109R501	C020S800	C050S800	Tool Identification		
Rekord 2A-GJV IKZ-PM TICN	Rekord 2A-GJV IKZN-PM TICN	Rekord 2A-GJV/E PM-TICN	Rekord 2A-GJV/E IKZ-PM TICN	Rekord 2A-GJV/E IKZN-PM TICN	Rekord 2B-AL GLT-8	Enorm 2-AL GLT-8	Dimens. ID	Nominal Size ø d ₁	P
Flutes	Flutes	Flutes	Flutes	Flutes	Flutes	Flutes			
★	4	★	4	★	★	★	.0112	M 12	1.75
	upon			upon	★	★	.0114	M 14	2
★	4	★	4	★	★	★	.0116	M 16	2
	request			request			.0118	M 18	2.5
★	4		★	★			.0120	M 20	2.5
							.0122	M 22	2.5
							.0124	M 24	3
							.0127	M 27	3
							.0130	M 30	3.5
							.0133	M 33	3.5
							.0136	M 36	4
							.0142	M 42	4.5
							.0145	M 45	4.5
							.0148	M 48	5
							.0152	M 52	5

- Product Finder
- V_c
- UNC
- UNF
- UNEF
- UN-8
- M**
- MF
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- NPSF
- Rp (BSPP)
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- NPT
- NPTF
- Rc (BSPT)
- STI
- SELF-LOCK
- Accessories
- Tech. Info

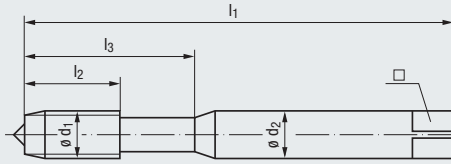


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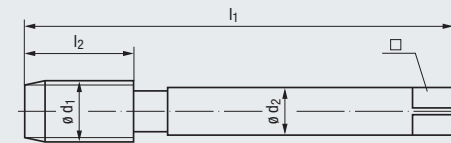
1) Threading in through holes is possible only with external cooling/lubrication

- Product Finder
- V_c
- UNC
- UNF
- UNEF
- UN-8
- M**
- MF
- NPSM/NPSC
- NPSF
- Rp (BSPP)
- G
- NPT
- NPTF
- Rc (BSPT)
- STI
- SELF-LOCK
- Accessories
- Tech. Info

DIN Length • DIN Shank

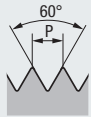


Reinforced Shank (M2 - M10)



Reduced Shank (M12 - M52)

M



ISO Metric Coarse Thread DIN 13

Class of Fit
Coating
Cutting Material
Technical Characteristics



Thread Depth and Hole Shape

Applications – Material

AL
Aluminum
Wrought Alloys

new



GAL
Aluminum
Cast Alloys

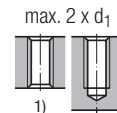
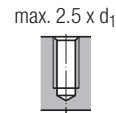


ISO 2/6H
GLT-8
HSS Extra
R45
E / 1.5-2
E / O

6HX
TiCN
HSS Extra
E / 1.5-2
E / M

6HX
TiCN
HSS Extra
E / 1.5-2
E / M

6HX
TiCN
HSS Extra
R15
E / 1.5-2
E / M



N 1.1-4

N 1.4-6

N 1.4-6







N 1.4-6





Reinforced Shank

Nominal Size ø d ₁	P	mm					ø d ₂	□	Tool Identification		B051S800		B1969501		B1099501		B0989501	
		l ₁	l ₂	l ₃	l ₄	l ₅			Dimens. ID	Enorm 1-AL/E GLT-8	Flutes	Rekord 1A-GAL/E IKZ-TiCN	Flutes	Rekord 1A-GAL/E IKZN-TiCN	Flutes	Rekord 1D-GAL/E IKZ-TiCN	Flutes	
M 2	0.4	45	7	12	2.8	2.1	1.6	.0020										
M 2.5	0.45	50	9	14	2.8	2.1	2.05	.0025										
M 3	0.5	56	11	18	3.5	2.7	2.5	.0030	★	2								
M 3.5	0.6	56	12	20	4	3	2.9	.0035										
M 4	0.7	63	13	21	4.5	3.4	3.3	.0040	★	2			★	3		★	3	
M 4.5	0.75	70	14	25	6	4.9	3.7	.0045										
M 5	0.8	70	15	25	6	4.9	4.2	.0050	★	2			★	3		★	3	
M 6	1	80	17	30	6	4.9	5	.0060	★	2			★	3	★	3	★	3
M 8	1.25	90	20	35	8	6.2	6.8	.0080	★	2			★	3	★	3	★	3
M 10	1.5	100	22	39	10	8	8.5	.0100	★	2			★	3	★	3	★	3

Reduced Shank

Nominal Size ø d ₁	P	mm					ø d ₂	□	Tool Identification									
		l ₁	l ₂	l ₃	l ₄	l ₅			Dimens. ID									
M 12	1.75	110	24	—	9	7	10.2	.0112										
M 14	2	110	26	—	11	9	12	.0114										
M 16	2	110	27	—	12	9	14	.0116										
M 18	2.5	125	30	—	14	11	15.5	.0118										
M 20	2.5	140	32	—	16	12	17.5	.0120										
M 22	2.5	140	32	—	18	14.5	19.5	.0122										
M 24	3	160	34	—	18	14.5	21	.0124										
M 27	3	160	36	—	20	16	24	.0127										
M 30	3.5	180	40	—	22	18	26.5	.0130										
M 33	3.5	180	40	—	25	20	29.5	.0133										
M 36	4	200	50	—	28	22	32	.0136										
M 42	4.5	200	56	—	32	24	37.5	.0142										
M 45	4.5	220	58	—	36	29	40.5	.0145										
M 48	5	250	65	—	36	29	43	.0148										
M 52	5	250	65	—	40	32	47	.0152										

GAL Aluminum Cast Alloys	PVC Long-Chipping Synthetics	TI Titanium			
					
new					
6HX TICN Carbide R15 E / 1.5-2 E / M	6HX CRN HSS Extra R15 E / 1.5-2 E	6HX NT2 HSS Extra L15 D / 4-5 E / O / P	6HX TICN HSS Extra L15 D / 4-5 E / O / P	6HX NT2 HSS Extra R15 C / 2-3 E / O / P	6HX TICN HSS Extra R15 C / 2-3 E / O / P
Class of Fit		Coating		Cutting Material	
Technical Characteristics		Technical Characteristics		Technical Characteristics	

max. 2 x d ₁	max. 2 x d ₁	max. 3 x d ₁	max. 2 x d ₁
			

N 1.4-6	N 4.2	P 4.1-5.1 M 3.1-4.1 N 2.4-5, 2.7 S 1.1-2.2, 2.4	P 4.1-5.1 M 3.1-4.1 N 2.4-5, 2.7 S 1.1-2.2, 2.4	P 4.1-5.1 M 3.1-4.1 N 2.4-5, 2.7 S 1.1-2.2, 2.4	P 4.1-5.1 M 3.1-4.1 N 2.4-5, 2.7 S 1.1-2.2, 2.4

B098Q801		B046L801		B0306001		B0309601		B0456001		B0459601		Tool Identification		
VHM Rekord 1D-GAL/E IKZ-TICN	Flutes	Rekord 1D-PVC/E CRN	Flutes	Rekord 1C-TI NT2	Flutes	Rekord 1C-TI TICN	Flutes	Rekord 1D-TI NT2	Flutes	Rekord 1D-TI TICN	Flutes	Dimens. ID	Nominal Size ø d ₁	P
				★	2	★	2	★	2	★	2	.0020	M 2	0.4
				★	2	★	2	★	2	★	2	.0025	M 2.5	0.45
		★	2	●	2	★	2	●	2	★	2	.0030	M 3	0.5
				●	3	★	3	●	3	★	3	.0035	M 3.5	0.6
★	3	★	3	●	3	★	3	●	3	★	3	.0040	M 4	0.7
				●	3	★	3	●	3	★	3	.0045	M 4.5	0.75
★	3	★	3	●	3	★	3	●	3	★	3	.0050	M 5	0.8
★	3	★	3	●	3	★	3	●	3	★	3	.0060	M 6	1
★	3	★	3	●	3	★	3	●	3	★	3	.0080	M 8	1.25
★	3	★	3	●	3	★	3	●	3	★	3	.0100	M 10	1.5

C0306001		C0309601		C0456001		C0459601		Tool Identification		
Rekord 2C-TI NT2	Flutes	Rekord 2C-TI TICN	Flutes	Rekord 2D-TI NT2	Flutes	Rekord 2D-TI TICN	Flutes	Dimens. ID	Nominal Size ø d ₁	P
●	3	★	3	●	3	★	3	.0112	M 12	1.75
								.0114	M 14	2
●	3	★	3	●	3	★	3	.0116	M 16	2
								.0118	M 18	2.5
●	3	★	3	●	3	★	3	.0120	M 20	2.5
								.0122	M 22	2.5
●	3	★	3	●	3	★	3	.0124	M 24	3
								.0127	M 27	3
								.0130	M 30	3.5
								.0133	M 33	3.5
								.0136	M 36	4
								.0142	M 42	4.5
								.0145	M 45	4.5
								.0148	M 48	5
								.0152	M 52	5

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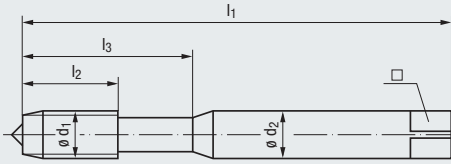
Product Finder

- V_c
- UNC
- UNF
- UNEF
- UN-8
- M
- MF
- NPSM/NPSC
- NPSF
- R_p (BSP)
- G
- NPT
- NPTF
- R_c (BSPT)
- STI
- SELF-LOCK
- Accessories
- Tech. Info

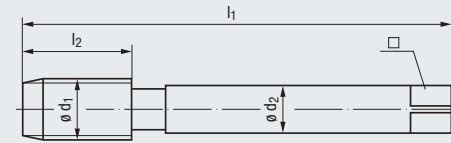


- Product Finder
- V_c
- UNC
- UNF
- UNEF
- UN-8
- M**
- MF
- NPSM/NPSC
- NPSF
- Rp (BSPP)
- G
- NPT
- NPTF
- Rc (BSPT)
- STI
- SELF-LOCK
- Accessories
- Tech. Info

DIN Length • DIN Shank



Reinforced Shank
(M2 - M10)



Reduced Shank
(M12 - M52)

TILEG
Titanium
Alloys



NI
Nickel
Alloys



M

**ISO Metric Coarse Thread
DIN 13**

Class of Fit
Coating
Cutting Material
Technical Characteristics



Thread Depth
and Hole Shape

Applications – Material

- 6HX
- TICN
- HSS Extra
- R15
- C / 2-3
- E / O / P



- M 4.1
- S 1.2-3

- 6HX
- TICN
- HSSE-PM**
- L08
- D / 4-5
- O / P



- M 4.1
- N 2.8
- S 1.2-3
- S 2.3, 2.5-6

- 6HX
- TICN
- HSSE-PM**
- R10
- C / 2-3
- O / P



- M 4.1
- N 2.8
- S 1.2-3
- S 2.3, 2.5-6

Reinforced Shank

Nominal Size ø d ₁	P	mm					ø d ₂	□	Tool Identification		B040V401		B030J401		B438J401	
		l ₁	l ₂	l ₃	l ₄	l ₅			Rekord 1DF-TILEG TICN	Flutes	Rekord 1C-NI-PM TICN	Flutes	Rekord 1DF-NI-PM TICN	Flutes		
M 2	0.4	45	7	12	2.8	2.1	1.6	.0020								
M 2.5	0.45	50	9	14	2.8	2.1	2.05	.0025								
M 3	0.5	56	11	18	3.5	2.7	2.5	.0030	★	2		★	2	★	2	
M 3.5	0.6	56	12	20	4	3	2.9	.0035								
M 4	0.7	63	13	21	4.5	3.4	3.3	.0040	★	3		★	3	★	3	
M 4.5	0.75	70	14	25	6	4.9	3.7	.0045								
M 5	0.8	70	15	25	6	4.9	4.2	.0050	★	3		★	3	★	3	
M 6	1	80	17	30	6	4.9	5	.0060	★	3		★	3	★	3	
M 8	1.25	90	20	35	8	6.2	6.8	.0080	★	3		★	3	★	3	
M 10	1.5	100	22	39	10	8	8.5	.0100	★	3		★	3	★	3	

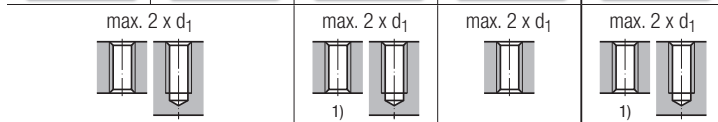
Reduced Shank

Nominal Size ø d ₁	P	mm					ø d ₂	□	Tool Identification		C030J401		C438J401	
		l ₁	l ₂	l ₃	l ₄	l ₅			Rekord 2C-NI-PM TICN	Flutes	Rekord 2DF-NI-PM TICN	Flutes		
M 12	1.75	110	24	—	9	7	10.2	.0112			★	3	★	3
M 14	2	110	26	—	11	9	12	.0114			★	3	★	3
M 16	2	110	27	—	12	9	14	.0116			★	3	★	3
M 18	2.5	125	30	—	14	11	15.5	.0118						
M 20	2.5	140	32	—	16	12	17.5	.0120			★	3	★	3
M 22	2.5	140	32	—	18	14.5	19.5	.0122						
M 24	3	160	34	—	18	14.5	21	.0124						
M 27	3	160	36	—	20	16	24	.0127						
M 30	3.5	180	40	—	22	18	26.5	.0130						
M 33	3.5	180	40	—	25	20	29.5	.0133						
M 36	4	200	50	—	28	22	32	.0136						
M 42	4.5	200	56	—	32	24	37.5	.0142						
M 45	4.5	220	58	—	36	29	40.5	.0145						
M 48	5	250	65	—	36	29	43	.0148						
M 52	5	250	65	—	40	32	47	.0152						

H
Materials of High Tensile Strength



6HX	6HX	6HX	6HX	6HX
NT	TICN	TICN	TICN	Carbide
HSS Extra	HSS Extra	HSS Extra	HSS Extra	
C / 2-3	C / 2-3	C / 2-3	C / 2-3	C / 2-3
E / O / P	E / O / P	E / O	E / O	E / O



P 1.1-3.1	P 1.1-4.1	P 1.1-4.1	P 1.1-4.1	P 5.1
K 1.1-4.2	K 1.1-4.2	K 1.1-4.2	K 1.1-4.2	K 1.1-4.2
N 2.4-7	N 2.4-7	N 2.4-7	N 2.4-7	N 1.5-6, 2.6-8
N 4.1, 5.1	N 4.1, 5.1	N 4.1, 5.1	N 4.1, 5.1	N 4.1, 4.3-5.2
				H 1.1-2

B0100501		B0109101		B1959101		B1069101		B1950901		Tool Identification		
Rekord 1A-H NT	Flutes	Rekord 1A-H TICN	Flutes	Rekord 1A-H-IKZ TICN	Flutes	Rekord 1A-H-IKZN TICN	Flutes	VHM Rekord 1A-H-IKZ	Flutes	Dimens. ID	Nominal Size ø d ₁	P
★	3	★	3							.0020	M 2	0.4
★	3	★	3			upon				.0025	M 2.5	0.45
●	3	★	3					★	3	.0030	M 3	0.5
●	3	★	3			request				.0035	M 3.5	0.6
●	3	★	3					★	3	.0040	M 4	0.7
●	3	●	3	★	3			★	3	.0045	M 4.5	0.75
●	3	●	3	★	3			●	3	.0050	M 5	0.8
●	3	●	3	★	3			●	3	.0060	M 6	1
●	3	★	3	★	3			●	3	.0080	M 8	1.25
								●	3	.0100	M 10	1.5

C0100501		C0109101		C1959101		C1069101		C1950901		Tool Identification		
Rekord 2A-H NT	Flutes	Rekord 2A-H TICN	Flutes	Rekord 2A-H-IKZ TICN	Flutes	Rekord 2A-H-IKZN TICN	Flutes	KHM Rekord 2A-H-IKZ	Flutes	Dimens. ID	Nominal Size ø d ₁	P
●	3	★	3	★	3			●	3	.0112	M 12	1.75
●	3	★	3	★	3	upon		★	4	.0114	M 14	2
●	3	★	3	★	3			★	4	.0116	M 16	2
						request		★	4	.0118	M 18	2.5
●	4	★	4	★	4			★	4	.0120	M 20	2.5
								★	4	.0122	M 22	2.5
●	4	★	4					★	4	.0124	M 24	3
								★	4	.0127	M 27	3
										.0130	M 30	3.5
										.0133	M 33	3.5
										.0136	M 36	4
										.0142	M 42	4.5
										.0145	M 45	4.5
										.0148	M 48	5
										.0152	M 52	5

● = In stock
★ = Allow 7 days for delivery

1) Threading in through holes is possible only with external cooling/lubrication

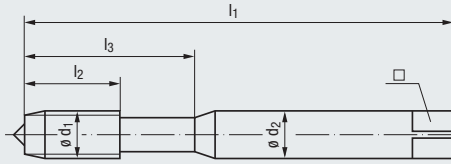
Product Finder

- V_c
- UNC
- UNF
- UNEF
- UN-8
- M**
- MF
- NPSM/NPSC
- NPSF
- R_p (BSPP)
- G
- NPT
- NTF
- R_c (BSPT)
- STI
- SELF-LOCK
- Accessories
- Tech. Info

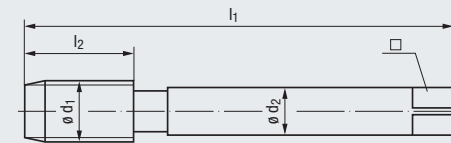


- Product Finder
- V_c
- UNC
- UNF
- UNEF
- UN-8
- M**
- MF
- NPSM/NPSC
- NPSF
- Rp (BSPP)
- G
- NPT
- NPTF
- Rc (BSPT)
- STI
- SELF-LOCK
- Accessories
- Tech. Info

DIN Length • DIN Shank



Reinforced Shank
(M4 - M10)



Reduced Shank
(M12 - M20)

HCUT
Hardened
Steels



M

**ISO Metric Coarse Thread
DIN 13**

Class of Fit
Coating
Cutting Material
Technical Characteristics

6HX

TICN

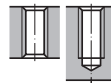
HSSE-PM

C / 2-3

O / P

Thread Depth
and Hole Shape

max. 1.5 x d₁



Applications – Material

H 1.1-2

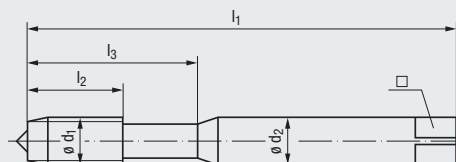
Reinforced Shank

Nominal Size								Tool Identification		B010J901	
Size	P	l ₁	l ₂	l ₃	mm	Ø d ₂	□	Dimens. ID	Rekord 1A-HCUT-PM TICN	Flutes	
M 4	0.7	63	7	21	4.5	3.4	3.4	.0040			
M 5	0.8	70	8	25	6	4.9	4.3	.0050			
M 6	1	80	10	30	6	4.9	5.1	.0060	★	4	
M 8	1.25	90	14	35	8	6.2	6.9	.0080	★	5	
M 10	1.5	100	16	39	10	8	8.6	.0100	★	5	

Reduced Shank

Nominal Size								Tool Identification		C010J901	
Size	P	l ₁	l ₂	l ₃	mm	Ø d ₂	□	Dimens. ID	Rekord 2A-HCUT-PM TICN	Flutes	
M 12	1.75	110	18	—	9	7	10.4	.0112	★	5	
M 14	2	110	20	—	11	9	12.2	.0114			
M 16	2	110	22	—	12	9	14.2	.0116	★	6	
M 20	2.5	140	25	—	16	12	17.7	.0120	★	7	

DIN Length • DIN Shank

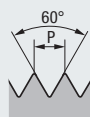


Reinforced Shank

HCUT
Hardened
Steels



M
ISO Metric Coarse Thread
DIN 13



Class of Fit
Coating
Cutting Material
Technical Characteristics

6HX	6HX
TICN	TICN
Carbide	Carbide
D / 4-5	C / 2-3
O / P	O / P

Thread Depth
and Hole Shape

max. 1.5 x d ₁	max. 1.5 x d ₁

Applications – Material

H 1.3-4	H 1.3-4
---------	---------

Reinforced Shank

Tool Identification

B016K101 B010K101

Nominal Size ø d ₁	P	mm					ø d ₂	□		Dimens. ID	B016K101		B010K101	
		l ₁	l ₂	l ₃	ø d ₂	□					VHM Rekord 1A-HCUT/D TICN	Flutes	VHM Rekord 1A-HCUT/C TICN	Flutes
M 3	0.5	63	6	18	4.5	3.4	2.55	.0030	★	3	★	3		
M 4	0.7	63	8	20	4.5	3.4	3.4	.0040	★	4	★	4		
M 5	0.8	70	10	26	6	4.9	4.3	.0050	★	4	★	4		
M 6	1	80	12	28	6	4.9	5.1	.0060	★	4	★	4		
M 8	1.25	90	15	35	8	6.2	6.9	.0080	★	5	★	5		
M 10	1.5	100	18	38	10	8	8.6	.0100	★	5	★	5		
M 12	1.75	110	21	41	12	9	10.4	.0112	★	5	★	5		
M 14	2	110	24	44	14	11	12.2	.0114	★	6	★	6		
M 16	2	110	24	44	16	12	14.2	.0116	★	6	★	6		

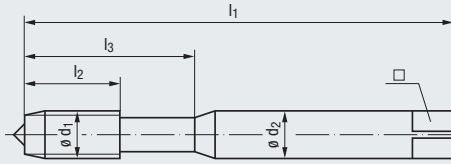
2) Please note: Use solid carbide tap VHM-Rekord 1A-HCUT/D-TICN as No.1 tap!

- Product Finder
- V_c
- UNC
- UNF
- UNEF
- UN-8
- M**
- MF
- NPSM/NPSC
- NPSF
- R_p (BSPP)
- G
- NPT
- NTF
- R_c (BSPT)
- STI
- SELF-LOCK
- Accessories
- Tech. Info

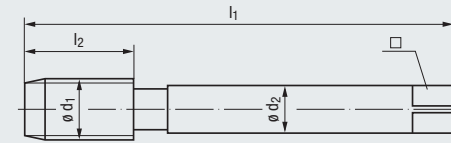


- Product Finder
- V_c
- UNC
- UNF
- UNEF
- UN-8
- M**
- MF
- NPSM/NPSC
- NPSF
- Rp (BSPP)
- G
- NPT
- NPTF
- Rc (BSPT)
- STI
- SELF-LOCK
- Accessories
- Tech. Info

DIN Length • DIN Shank



Reinforced Shank
(M2 - M10)



Reduced Shank
(M12 - M52)

Z CNC-Controlled Machines



M

**ISO Metric Coarse Thread
DIN 13**

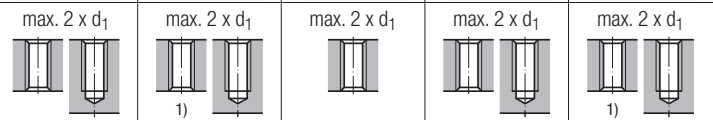
Class of Fit
Coating
Cutting Material
Technical Characteristics



Thread Depth
and Hole Shape

Applications – Material

6HX	6HX	6HX	6HX	6HX
TICN	TICN	TICN	TICN	TICN
HSS Extra	HSS Extra	HSS Extra	HSS Extra	HSS Extra
C / 2-3	C / 2-3	C / 2-3	E / 1.5-2	E / 1.5-2
E / O / P	E / O	E / O	E / O / P	E / O



P 1.1-4.1	P 1.1-4.1	P 1.1-4.1	P 1.1-4.1	P 1.1-4.1
K 1.1-4.2	K 1.1-4.2	K 1.1-4.2	K 1.1-4.2	K 1.1-4.2
N 1.4-6, 2.4-7	N 1.4-6, 2.4-7	N 1.4-6, 2.4-7	N 1.4-6, 2.4-7	N 1.4-6, 2.4-7
N 4.1	N 4.1	N 4.1	N 4.1	N 4.1

Reinforced Shank

Nominal Size ø d ₁	P	mm			ø d ₂	□	Tool Identification		B0109401		B1959401		B1069401		B0119401		B1969401	
		l ₁	l ₂	l ₃			Rekord 1A-Z TICN	Flutes	Rekord 1A-Z-IKZ TICN	Flutes	Rekord 1A-Z-IKZN TICN	Flutes	Rekord 1A-Z/E TICN	Flutes	Rekord 1A-Z/E-IKZ TICN	Flutes		
M 2	0.4	45	4	12	2.8	2.1	1.6	.0020										
M 2.5	0.45	50	5	14	2.8	2.1	2.05	.0025										
M 3	0.5	56	6	18	3.5	2.7	2.5	.0030	★	3					★	3		
M 3.5	0.6	56	7	20	4	3	2.9	.0035										
M 4	0.7	63	7	21	4.5	3.4	3.3	.0040	★	3	★	3			★	3	★	3
M 4.5	0.75	70	8	25	6	4.9	3.7	.0045										
M 5	0.8	70	8	25	6	4.9	4.2	.0050	★	3	★	3			★	3	★	3
M 6	1	80	10	30	6	4.9	5	.0060	★	3	★	3	★	3	★	3	★	3
M 8	1.25	90	14	35	8	6.2	6.8	.0080	★	3	★	3	★	3	★	3	★	3
M 10	1.5	100	16	39	10	8	8.5	.0100	★	3	★	3	★	3	★	3	★	3

Reduced Shank

Nominal Size ø d ₁	P	mm			ø d ₂	□	Tool Identification		C0109401		C1959401		C0119401		C1969401			
		l ₁	l ₂	l ₃			Rekord 2A-Z TICN	Flutes	Rekord 2A-Z-IKZ TICN	Flutes	Rekord 2A-Z/E TICN	Flutes	Rekord 2A-Z/E-IKZ TICN	Flutes				
M 12	1.75	110	18	—	9	7	10.2	.0112	●	3	★	3			★	3	★	3
M 14	2	110	20	—	11	9	12	.0114	★	3	★	3			★	3	★	3
M 16	2	110	22	—	12	9	14	.0116	★	3	★	3			★	3	★	3
M 18	2.5	125	25	—	14	11	15.5	.0118										
M 20	2.5	140	25	—	16	12	17.5	.0120	★	4	★	4			★	4	★	4
M 22	2.5	140	27	—	18	14.5	19.5	.0122										
M 24	3	160	30	—	18	14.5	21	.0124			★	4						
M 27	3	160	30	—	20	16	24	.0127										
M 30	3.5	180	35	—	22	18	26.5	.0130										
M 33	3.5	180	35	—	25	20	29.5	.0133										
M 36	4	200	40	—	28	22	32	.0136										
M 42	4.5	200	45	—	32	24	37.5	.0142										
M 45	4.5	220	45	—	36	29	40.5	.0145										
M 48	5	250	50	—	36	29	43	.0148										
M 52	5	250	50	—	40	32	47	.0152										

Z
CNC-Controlled
Machines



6HX	6HX	6HX	6HX	6GX	6GX	6GX	6GX
TIN-70	GLT-1	TIN-70	GLT-1	TIN-70	GLT-1	TIN-70	GLT-1
HSSE-PM	HSSE-PM	HSSE-PM	HSSE-PM	HSSE-PM	HSSE-PM	HSSE-PM	HSSE-PM
B / 4-5	B / 4-5	B / 4-5	B / 4-5	B / 4-5	B / 4-5	B / 4-5	B / 4-5
E / O / P	E / O / P	E / O	E / O	E / O / P	E / O / P	E / O	E / O

Class of Fit
Coating
Cutting Material
Technical Characteristics

max. 3 x d₁



Thread Depth
and Hole Shape

P 1.1-5.1	P 1.1-5.1	P 1.1-5.1	P 1.1-5.1	P 1.1-5.1	P 1.1-5.1	P 1.1-5.1	P 1.1-5.1
M 1.1-3.1	M 1.1-3.1	M 1.1-3.1	M 1.1-3.1	M 1.1-3.1	M 1.1-3.1	M 1.1-3.1	M 1.1-3.1
K 2.1	K 2.1	K 2.1	K 2.1	K 2.1	K 2.1	K 2.1	K 2.1
N 1.4-2.2, 2.4-5	N 1.4-2.2, 2.4-5	N 1.4-2.2, 2.4-5	N 1.4-2.2, 2.4-5	N 1.4-2.2, 2.4-5	N 1.4-2.2, 2.4-5	N 1.4-2.2, 2.4-5	N 1.4-2.2, 2.4-5
S 1.1	S 1.1	S 1.1	S 1.1	S 1.1	S 1.1	S 1.1	S 1.1

Applications – Material

B0208F01		B020A601		B1088F01		B108A601		B0208F21		B020A621		B1088F21		B108A621		Tool Identification		
Rekord 1B-Z-PM TIN-70	Flutes	Rekord 1B-Z-PM GLT-1	Flutes	Rekord 1B-Z-PM-TIN-70	Flutes	Rekord 1B-Z-PM-TIN-70	Flutes	Rekord 1B-Z-PM TIN-70	Flutes	Rekord 1B-Z-PM GLT-1	Flutes	Rekord 1B-Z-PM-TIN-70	Flutes	Rekord 1B-Z-PM-TIN-70	Flutes	Dimens. ID	Nominal Size ø d ₁	P
★	2	★	2	upon		upon		★	2	★	2	upon		upon		.0020	M 2	0.4
★	2	★	2	upon		upon		★	2	★	2	upon		upon		.0025	M 2.5	0.45
★	3	★	3	request		request		★	3	★	3	request		request		.0030	M 3	0.5
★	3	★	3	request		request		★	3	★	3	request		request		.0035	M 3.5	0.6
★	3	★	3					★	3	★	3					.0040	M 4	0.7
★	3	★	3					★	3	★	3					.0045	M 4.5	0.75
★	3	★	3					★	3	★	3					.0050	M 5	0.8
★	4	★	4					★	4	★	4					.0060	M 6	1
★	4	★	4					★	4	★	4					.0080	M 8	1.25
★	4	★	4					★	4	★	4					.0100	M 10	1.5

C0208F01		C020A601		C1088F01		C108A601		C0208F21		C020A621		C1088F21		C108A621		Tool Identification		
Rekord 2B-Z-PM TIN-70	Flutes	Rekord 2B-Z-PM GLT-1	Flutes	Rekord 2B-Z-PM-TIN-70	Flutes	Rekord 2B-Z-PM-TIN-70	Flutes	Rekord 2B-Z-PM TIN-70	Flutes	Rekord 2B-Z-PM GLT-1	Flutes	Rekord 2B-Z-PM-TIN-70	Flutes	Rekord 2B-Z-PM-TIN-70	Flutes	Dimens. ID	Nominal Size ø d ₁	P
★	4	★	4	upon		upon		★	4	★	4	upon		upon		.0112	M 12	1.75
★	4	★	4	upon		upon		★	4	★	4	upon		upon		.0114	M 14	2
★	4	★	4	request		request		★	4	★	4	request		request		.0116	M 16	2
★	4	★	4	request		request		★	4	★	4	request		request		.0118	M 18	2.5
★	4	★	4					★	4	★	4					.0120	M 20	2.5
★	4	★	4					★	4	★	4					.0122	M 22	2.5
★	4	★	4					★	4	★	4					.0124	M 24	3
★	4	★	4					★	4	★	4					.0127	M 27	3
★	4	★	4					★	4	★	4					.0130	M 30	3.5
★	4	★	4					★	4	★	4					.0133	M 33	3.5
★	4	★	4					★	4	★	4					.0136	M 36	4
★	4	★	4					★	4	★	4					.0142	M 42	4.5
★	4	★	4					★	4	★	4					.0145	M 45	4.5
★	4	★	4					★	4	★	4					.0148	M 48	5
★	4	★	4					★	4	★	4					.0152	M 52	5

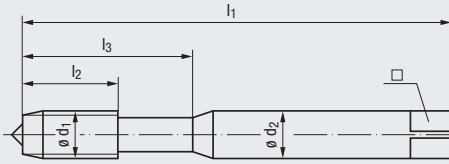
● = In stock
★ = Allow 7 days for delivery

- Product Finder
- V_c
- UNC
- UNF
- UNEF
- UN-8
- M**
- MF
- NPSM/NPSC
- NPSF
- R_p (BSPP)
- G
- NPT
- NPTF
- R_c (BSPT)
- STI
- SELF-LOCK
- Accessories
- Tech. Info

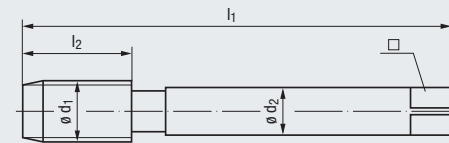


- Product Finder
- V_c
- UNC
- UNF
- UNEF
- UN-8
- M**
- MF
- NPSM/NPSC
- NPSF
- Rp (BSPP)
- G
- NPT
- NPTF
- Rc (BSPT)
- STI
- SELF-LOCK
- Accessories
- Tech. Info

DIN Length • DIN Shank

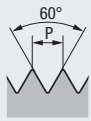


Reinforced Shank
(M2 - M10)



Reduced Shank
(M12 - M52)

M



ISO Metric Coarse Thread DIN 13

Class of Fit

Coating

Cutting Material

Technical Characteristics



Thread Depth
and Hole Shape

Applications – Material

Z
CNC-Controlled
Machines



6HX	6HX	6HX	6HX	ISO 2/6H
TIN	TIN	TIN	TIN	
HSS Extra	HSS Extra	HSS Extra	HSS Extra	HSS Extra
R15	R15	R15	R15	R45
C / 2-3	C / 2-3	C / 2-3	E / 1.5-2	C / 2-3
E / O / P	E / O	E / O	E / O	E / O / P

max. 2 x d₁



max. 3 x d₁



P 2.1-5.1	P 2.1-5.1	P 2.1-5.1	P 2.1-5.1	P 1.1-4.1
K 2.1-2	K 2.1-2	K 2.1-2	K 2.1-2	M 1.1-2.1
N 1.4-6, 2.4-5	N 1.4-6, 2.4-5	N 1.4-6, 2.4-5	N 1.4-6, 2.4-5	N 2.1

Reinforced Shank

Nominal Size ø d ₁	P	mm			ø d ₂	□	Tool Identification	B0453701		B0963701		B4253701		B4053701		B0503500	
		l ₁	l ₂	l ₃				Rekord 1D-Z TIN	Flutes	Rekord 1D-Z-IKZ TIN	Flutes	Rekord 1D-Z-BF IKZ-TIN	Flutes	Rekord 1D-Z/E-BF IKZ-TIN	Flutes	Enorm 1-Z	Flutes
M 2	0.4	45	4	12	2.8	2.1	1.6	.0020									
M 2.5	0.45	50	5	14	2.8	2.1	2.05	.0025									
M 3	0.5	56	6	18	3.5	2.7	2.5	.0030	★	2						★	3
M 3.5	0.6	56	7	20	4	3	2.9	.0035								★	3
M 4	0.7	63	7	21	4.5	3.4	3.3	.0040	★	3	★	3	★	3	★	3	3
M 4.5	0.75	70	8	25	6	4.9	3.7	.0045									
M 5	0.8	70	8	25	6	4.9	4.2	.0050	★	3	★	3	★	3	★	3	3
M 6	1	80	10	30	6	4.9	5	.0060	★	3	★	3	★	3	★	3	3
M 8	1.25	90	14	35	8	6.2	6.8	.0080	★	3	★	3	★	3	★	3	3
M 10	1.5	100	16	39	10	8	8.5	.0100	★	3	★	3	★	3	★	3	3

Reduced Shank

Nominal Size ø d ₁	P	mm			ø d ₂	□	Tool Identification	C0453701		C0963701		C4253701		C4053701		C0503500		
		l ₁	l ₂	l ₃				Rekord 2D-Z TIN	Flutes	Rekord 2D-Z-IKZ TIN	Flutes	Rekord 2D-Z-BF IKZ-TIN	Flutes	Rekord 2D-Z/E-BF IKZ-TIN	Flutes	Enorm 2-Z	Flutes	
M 12	1.75	110	18	—	9	7	10.2	.0112	★	3	★	3	★	3	★	3	★	4
M 14	2	110	20	—	11	9	12	.0114									★	4
M 16	2	110	22	—	12	9	14	.0116	★	3	★	3	★	3	★	3	★	4
M 18	2.5	125	25	—	14	11	15.5	.0118									★	4
M 20	2.5	140	25	—	16	12	17.5	.0120	★	3	★	3	★	3	★	3	★	4
M 22	2.5	140	27	—	18	14.5	19.5	.0122									★	5
M 24	3	160	30	—	18	14.5	21	.0124			★	3					★	5
M 27	3	160	30	—	20	16	24	.0127										
M 30	3.5	180	35	—	22	18	26.5	.0130			★	4						
M 33	3.5	180	35	—	25	20	29.5	.0133										
M 36	4	200	40	—	28	22	32	.0136										
M 42	4.5	200	45	—	32	24	37.5	.0142										
M 45	4.5	220	45	—	36	29	40.5	.0145										
M 48	5	250	50	—	36	29	43	.0148										
M 52	5	250	50	—	40	32	47	.0152										

Z
CNC-Controlled
Machines



ISO 2/6H	ISO 2/6H	ISO 2/6H	ISO 2/6H	ISO 2/6H	ISO 2/6H	ISO 2/6H	ISO 3/6G
TIN	GLT-1	GLT-1		TIN	GLT-1	TIN	TIN
HSS Extra	HSS Extra	HSS Extra	HSS Extra	HSS Extra	HSS Extra	HSS Extra	HSS Extra
R45	R45	R45	R45	R45	R45	R45	R45
C / 2-3	C / 2-3	C / 2-3	E / 1.5-2	E / 1.5-2	E / 1.5-2	E / 1.5-2	E / 1.5-2
E / O / P	E / O / P	E / O	E / O / P	E / O / P	E / O / P	E / O	E / O / P

Class of Fit
Coating
Cutting Material
Technical Characteristics

max. 3 x d₁



Thread Depth
and Hole Shape

P 1.1-4.1	P 1.1-4.1	P 1.1-4.1	P 1.1-4.1	P 1.1-4.1	P 1.1-4.1	P 1.1-4.1	P 1.1-4.1
M 1.1-3.1	M 1.1-3.1	M 1.1-3.1	M 1.1-2.1	M 1.1-3.1	M 1.1-3.1	M 1.1-3.1	M 1.1-3.1
N 1.4-6	N 1.4-6	N 1.4-6	N 2.1	N 1.4-6	N 1.4-6	N 1.4-6	N 1.4-6
N 2.1-2, 2.4-5	N 2.1-2, 2.4-5	N 2.1-2, 2.4-5		N 2.1-2, 2.4-5	N 2.1-2, 2.4-5	N 2.1-2, 2.4-5	N 2.1-2, 2.4-5
S 1.1	S 1.1	S 1.1		S 1.1	S 1.1	S 1.1	S 1.1

Applications – Material

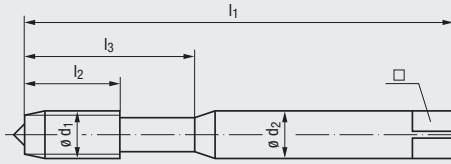
B0503700		B050C400		B099C400		B0513500		B0513700		B051C400		B0973700		B0513720		Tool Identification		
Enorm 1-Z TIN	Flutes	Enorm 1-Z GLT-1	Flutes	Enorm 1-Z-IKZ GLT-1	Flutes	Enorm 1-Z/E	Flutes	Enorm 1-Z/E TIN	Flutes	Enorm 1-Z/E GLT-1	Flutes	Enorm 1-Z/E-IKZ TIN	Flutes	Enorm 1-Z/E TIN	Flutes	Dimens. ID	Nominal Size ø d ₁	P
																.0020	M 2	0.4
★	3	★	3			★	3	●	3	★	3			★	3	.0025	M 2.5	0.45
★	3															.0030	M 3	0.5
★	3	★	3			●	3	●	3	★	3			★	3	.0035	M 3.5	0.6
																.0040	M 4	0.7
★	3	★	3	★	3	●	3	●	3	★	3	★	3	★	3	.0045	M 4.5	0.75
★	3	★	3	★	3	★	3	●	3	★	3	●	3	★	3	.0050	M 5	0.8
★	3	★	3	★	3	●	3	●	3	★	3	●	3	★	3	.0060	M 6	1
★	3	★	3	★	3	●	3	●	3	★	3	●	3	★	3	.0080	M 8	1.25
★	3	★	3	★	3	★	3	●	3	★	3	●	3	★	3	.0100	M 10	1.5

C0503700		C050C400		C099C400		C0513500		C0513700		C051C400		C0973700		C0513720		Tool Identification		
Enorm 2-Z TIN	Flutes	Enorm 2-Z GLT-1	Flutes	Enorm 2-Z-IKZ GLT-1	Flutes	Enorm 2-Z/E	Flutes	Enorm 2-Z/E TIN	Flutes	Enorm 2-Z/E GLT-1	Flutes	Enorm 2-Z/E-IKZ TIN	Flutes	Enorm 2-Z/E TIN	Flutes	Dimens. ID	Nominal Size ø d ₁	P
★	4	★	4	★	4	★	4	●	4	★	4	★	4	★	4	.0112	M 12	1.75
						★	4					★	4			.0114	M 14	2
★	4	★	4	★	4	★	4	●	4	★	4	★	4	★	4	.0116	M 16	2
						★	4									.0118	M 18	2.5
★	4	★	4	★	4	★	4	★	4	★	4	★	4	★	4	.0120	M 20	2.5
						★	5									.0122	M 22	2.5
★	5	★	5			★	5	★	5							.0124	M 24	3
																.0127	M 27	3
																.0130	M 30	3.5
																.0133	M 33	3.5
																.0136	M 36	4
																.0142	M 42	4.5
																.0145	M 45	4.5
																.0148	M 48	5
																.0152	M 52	5

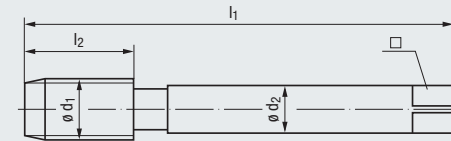
● = In stock
★ = Allow 7 days for delivery

- Product Finder
- V_c
- UNC
- UNF
- UNEF
- UN-8
- M**
- MF
- NPSM/NPSC
- NPSF
- Rp (BSPP)
- G
- NPT
- NPTF
- Rc (BSPT)
- STI
- SELF-LOCK
- Accessories
- Tech. Info

DIN Length • DIN Shank



Reinforced Shank
(M2 - M10)



Reduced Shank
(M12 - M52)

SPEED High-Speed Cutting



M

**ISO Metric Coarse Thread
DIN 13**

Class of Fit
Coating
Cutting Material
Technical Characteristics



Thread Depth
and Hole Shape

Applications – Material

6HX	6HX	6HX	6HX
TICN	TICN	TICN	TICN
HSS Extra	HSS Extra	HSS Extra	HSS Extra
C / 2-3	C / 2-3	E / 1.5-2	E / 1.5-2
E	E	E	E
max. 2 x d ₁	max. 2 x d ₁	max. 2 x d ₁	max. 2 x d ₁
K 1.1-4.2	K 1.1-4.2	K 1.1-4.2	K 1.1-4.2
N 1.4-6	N 1.4-6	N 1.4-6	N 1.4-6

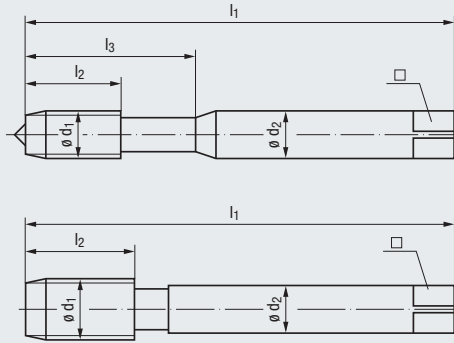
Reinforced Shank

Nominal Size ø d ₁	P	mm					ø d ₂	□	Tool Identification		B3159401		B3179401		B3169401		B3189401	
		l ₁	l ₂	l ₃	□	□			Rekord 1A-SPEED IKZ-TICN	Flutes	Rekord 1A-SPEED IKZN-TICN	Flutes	Rekord 1A-SPEED/E IKZ-TICN	Flutes	Rekord 1A-SPEED/E IKZN-TICN	Flutes		
M 2	0.4	45	4	12	2.8	2.1	1.6	.0020										
M 2.5	0.45	50	5	14	2.8	2.1	2.05	.0025			upon							
M 3	0.5	56	6	18	3.5	2.7	2.5	.0030										
M 3.5	0.6	56	7	20	4	3	2.9	.0035										
M 4	0.7	63	7	21	4.5	3.4	3.3	.0040	★	3	request			★	3			
M 4.5	0.75	70	8	25	6	4.9	3.7	.0045										
M 5	0.8	70	8	25	6	4.9	4.2	.0050	●	3				★	3			
M 6	1	80	10	30	6	4.9	5	.0060	●	3				★	3	★	3	
M 8	1.25	90	14	35	8	6.2	6.8	.0080	●	3				★	3	★	3	
M 10	1.5	100	16	39	10	8	8.5	.0100	●	3				★	3	★	3	

Reduced Shank

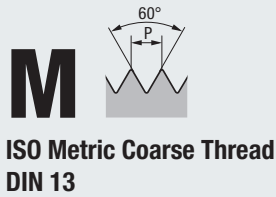
Nominal Size ø d ₁	P	mm					ø d ₂	□	Tool Identification		C3159401		C3169401	
		l ₁	l ₂	l ₃	□	□			Rekord 2A-SPEED IKZ-TICN	Flutes	Rekord 2A-SPEED/E IKZ-TICN	Flutes		
M 12	1.75	110	18	—	9	7	10.2	.0112	●	3			★	3
M 14	2	110	20	—	11	9	12	.0114	★	3			★	3
M 16	2	110	22	—	12	9	14	.0116	●	3			★	3
M 18	2.5	125	25	—	14	11	15.5	.0118						
M 20	2.5	140	25	—	16	12	17.5	.0120	●	4			★	4
M 22	2.5	140	27	—	18	14.5	19.5	.0122						
M 24	3	160	30	—	18	14.5	21	.0124						
M 27	3	160	30	—	20	16	24	.0127						
M 30	3.5	180	35	—	22	18	26.5	.0130						
M 33	3.5	180	35	—	25	20	29.5	.0133						
M 36	4	200	40	—	28	22	32	.0136						
M 42	4.5	200	45	—	32	24	37.5	.0142						
M 45	4.5	220	45	—	36	29	40.5	.0145						
M 48	5	250	50	—	36	29	43	.0148						
M 52	5	250	50	—	40	32	47	.0152						

DIN Length • DIN Shank



Reinforced Shank
(M2 - M10)

Reduced Shank
(M12 - M52)

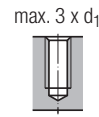


Class of Fit
Coating
Cutting Material
Technical Characteristics



6HX	6HX	6HX	6HX
TIN-70	TIN-70	TIN-60	TIN-60
HSSE-PM	HSSE-PM	HSSE-PM	HSSE-PM
R45	R45	R45	R45
B / 4-5	B / 4-5	C / 2-3	C / 2-3
E	E	E	E

Thread Depth and Hole Shape



Applications – Material

P 1.1-4.1	P 1.1-4.1	P 2.1-4.1	P 2.1-4.1
K 2.1-2	K 2.1-2		
N 1.4-6	N 1.4-6		

Reinforced Shank

Nominal Size ϕd_1	P	l_1	mm				ϕd_2	\square	Tool Identification		B3208F01		B3258F01		B3600F01		B3650F01	
			l_2	l_3	ϕd_2	\square			Rekord 1B-Z-SPEED PM-TIN-70	Flutes	Rekord 1B-Z-SPEED IKZN-PM TIN-70	Flutes	Enorm 1-Z-SPEED X-PM TIN-60	Flutes	Enorm 1-Z-SPEED X-1KZ-PM TIN-60	Flutes		
M 2	0.4	45	4	12	2.8	2.1	1.6	.0020										
M 2.5	0.45	50	5	14	2.8	2.1	2.05	.0025			upon							
M 3	0.5	56	6	18	3.5	2.7	2.5	.0030										
M 3.5	0.6	56	7	20	4	3	2.9	.0035										
M 4	0.7	63	7	21	4.5	3.4	3.3	.0040	*	3			*	3	*	3		
M 4.5	0.75	70	8	25	6	4.9	3.7	.0045										
M 5	0.8	70	8	25	6	4.9	4.2	.0050	*	3			*	3	*	3		
M 6	1	80	10	30	6	4.9	5	.0060	*	3			*	3	*	3		
M 8	1.25	90	14	35	8	6.2	6.8	.0080	*	4			*	3	*	3		
M 10	1.5	100	16	39	10	8	8.5	.0100	*	4			*	3	*	3		

Reduced Shank

Nominal Size ϕd_1	P	l_1	mm				ϕd_2	\square	Tool Identification		C3208F01		C3600F01		C3650F01	
			l_2	l_3	ϕd_2	\square			Rekord 2B-Z-SPEED PM-TIN-70	Flutes	Enorm 2-Z-SPEED X-PM TIN-60	Flutes	Enorm 2-Z-SPEED X-1KZ-PM TIN-60	Flutes		
M 12	1.75	110	18	—	9	7	10.2	.0112	*	4			*	4	*	4
M 14	2	110	20	—	11	9	12	.0114					*	4	*	4
M 16	2	110	22	—	12	9	14	.0116	*	4			*	4	*	4
M 18	2.5	125	25	—	14	11	15.5	.0118								
M 20	2.5	140	25	—	16	12	17.5	.0120	*	4			*	4	*	4
M 22	2.5	140	27	—	18	14.5	19.5	.0122								
M 24	3	160	30	—	18	14.5	21	.0124								
M 27	3	160	30	—	20	16	24	.0127								
M 30	3.5	180	35	—	22	18	26.5	.0130								
M 33	3.5	180	35	—	25	20	29.5	.0133								
M 36	4	200	40	—	28	22	32	.0136								
M 42	4.5	200	45	—	32	24	37.5	.0142								
M 45	4.5	220	45	—	36	29	40.5	.0145								
M 48	5	250	50	—	36	29	43	.0148								
M 52	5	250	50	—	40	32	47	.0152								

● = In stock
★ = Allow 7 days for delivery

- Product Finder
- Vc
- UNC
- UNF
- UNEF
- UN-8
- M**
- MF
- NPSM/NPSC
- NPSF
- Rp (BSPP)
- G
- NPT
- NPTF
- Rc (BSPT)
- STI
- SELF-LOCK
- Accessories
- Tech. Info



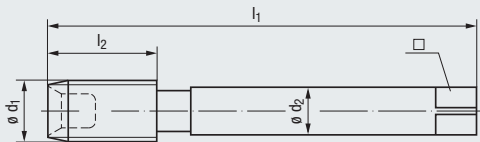
- Product Finder
- V_c
- UNC
- UNF
- UNEF
- UN-8
- M**
- MF
- NPSM/NPSC
- NPSF
- Rp (BSPP)
- G
- NPT
- NPTF
- Rc (BSPT)
- STI
- SELF-LOCK
- Accessories
- Tech. Info

DIN Length • DIN Shank

VA
Stainless Steel
Materials



With internal chip collector



Reduced Shank

M



**ISO Metric Coarse Thread
DIN 13**

Class of Fit

6HX

Coating

NE2

Cutting Material

HSS Extra

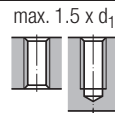
Technical Characteristics



C / 2-3

P / 0 1)

Thread Depth
and Hole Shape



Applications – Material

P 1.1-4.1

M 1.1-2.1

K 1.1-4.2

Reduced Shank

Tool Identification

C0803001

Nominal Size ø d ₁	P	l ₁	mm l ₂	ø d ₂	□		Dimens. ID	Robust 2X-VA NE2		Flutes
								★	★	
M 20	2.5	140	32	16	12	17.5	.0120	★	★	5
M 22	2.5	140	32	18	14.5	19.5	.0122	★	★	5
M 24	3	160	34	18	14.5	21	.0124	★	★	5
M 27	3	160	36	20	16	24	.0127	★	★	5
M 30	3.5	180	40	22	18	26.5	.0130	★	★	6
M 33	3.5	180	40	25	20	29.5	.0133	★	★	6
M 36	4	200	50	28	22	32	.0136	★	★	6
M 42	4.5	200	56	32	24	37.5	.0142	★	★	6
M 45	4.5	220	58	36	29	40.5	.0145	★	★	6
M 48	5	250	65	36	29	43	.0148	★	★	6
M 52	5	250	65	40	32	47	.0152	★	★	6
M 56	5.5	250	70	40	32	50.5	.0156	★	★	7
M 60	5.5	280	70	45	35	54.5	.0160	★	★	7
M 64	6	315	75	50	39	58	.0164	★	★	7
M 68	6	315	75	50	39	62	.0168	★	★	7

≥ M56 Shank with grooves for better handling!

1) If possible, use paste lubrication, coating both the tool and the walls of the drilled hole.
Lubrication with oil is possible only in the vertical machining of blind holes, if the hole is entirely filled with oil.

Larger sizes priced upon request.

The Complete Tool System

Robust 2X-VA Taps when used with a KSN Type tapping attachment creates the optimal tapping unit!

Extra Length • DIN Shank

Z
CNC-Controlled
Machines

Product
Finder

V_c

UNC

UNF

UNEF

UN-8

M

MF

NPSM/NPSC

NPSF

Rp (BSP)

G

NPT

NPTF

Rc (BSPT)

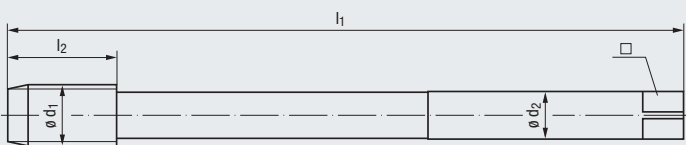
STI

SELF-LOCK

Accessories

Tech. Info

With long flutes and long shank for thread depths up to max. 4 x d₁



Reduced Shank

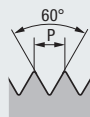
new

new

new



M
ISO Metric Coarse Thread
DIN 13



Class of Fit	6HX	6HX	6HX
Coating	TICN	TIN	TIN
Cutting Material	HSS Extra	HSS Extra	HSS Extra
Technical Characteristics	C / 2-3	R15	R15
	E / 0	E / 0	E / 0
Thread Depth and Hole Shape	max. 4 x d ₁ 	max. 4 x d ₁ 	
Applications – Material	P 1.1-4.1 K 1.1-4.2 N 1.4-6, 2.4-7 N 4.1	P 2.1-5.1 K 2.1-2 N 1.4-6, 2.4-5	P 2.1-5.1 K 2.1-2 N 1.4-6, 2.4-5

Reduced Shank

Tool Identification

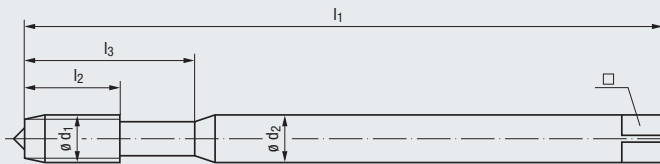
Nominal Size ø d ₁	P	l ₁	mm l ₂	ø d ₂	□		Dimens. ID	C0539401		C4283701		C4063701	
								Rekord 2A-Z- IKZ -LF4 TICN	Flutes	Rekord 2D-Z- IKZ -LF4 TIN	Flutes	Rekord 2D-Z- BF - IKZ -LF4 TIN	Flutes
M 20	2.5	190	25	16	12	17.5	.0120	★	4	★	3	★	3
M 22	2.5	230	27	18	14.5	19.5	.0122	★	4	★	3	★	3
M 24	3	240	30	18	14.5	21	.0124	★	4	★	3	★	3
M 27	3	250	30	20	16	24	.0127	★	4	★	3	★	3
M 30	3.5	270	35	22	18	26.5	.0130	★	4	★	4	★	4
M 33	3.5	290	35	25	20	29.5	.0133	★	4	★	4	★	4
M 36	4	310	40	28	22	32	.0136	★	4	★	4	★	4
M 42	4.5	340	45	32	24	37.5	.0142	★	4	★	4	★	4
M 45	4.5	360	45	36	29	40.5	.0145	★	4	★	4	★	4

1) Threading in through holes is possible only with external cooling/lubrication

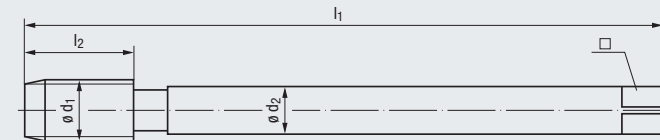
- Product Finder
- V_c
- UNC
- UNF
- UNEF
- UN-8
- M**
- MF
- NPSM/NPSC
- NPSF
- Rp (BSPP)
- G
- NPT
- NPTF
- Rc (BSPT)
- STI
- SELF-LOCK
- Accessories
- Tech. Info

Extra Length • DIN Shank

With extra long shank



Reinforced Shank (M3 - M8)



Reduced Shank (M6 - M20)

M

**ISO Metric Coarse Thread
DIN 13**

Class of Fit
Coating
Cutting Material
Technical Characteristics

ISO 2/6H	ISO 2/6H	ISO 2/6H
HSS Extra	HSS Extra	HSS Extra
B / 4-5	E / 1.5-2	C / 2-3
E / 0	E / 0	E / 0

max. 3 x d ₁	max. 2 x d ₁	max. 2.5 x d ₁

Applications – Material	P 1.1-3.1 N 2.2	P 2.1-3.1	P 1.1-3.1 N 2.2
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Reinforced Shank

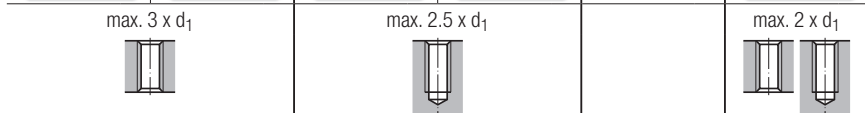
Nominal Size								Tool Identification		B2208900		B2461000		B2501000	
Ø d ₁	P	l ₁	l ₂	l ₃	Ø d ₂	□	Dimens. ID	Rekord 1B-STEEL-L LS	Flutes	Rekord 1D-STEEL/E LS	Flutes	Enorm 1-STEEL-LS	Flutes		
M 3	0.5	100	11	18	3.5	2.7	2.5	★	3	★	3	★	3		
M 4	0.7	125	13	21	4.5	3.4	3.3	★	3	★	3	★	3		
M 5	0.8	140	15	25	6	4.9	4.2	★	3	●	3	★	3		
M 6	1	160	17	30	6	4.9	5	★	3	●	3	★	3		
M 8	1.25	180	20	35	8	6.2	6.8	★	3	●	3	★	3		

Reduced Shank

Nominal Size								Tool Identification		C2208900		C2461000		C2501000	
Ø d ₁	P	l ₁	l ₂	l ₃	Ø d ₂	□	Dimens. ID	Rekord 2B-STEEL-L LS	Flutes	Rekord 2D-STEEL/E LS	Flutes	Enorm 2-STEEL-LS	Flutes		
M 6	1	160	17	—	4.5	3.4	5	★	3	★	3	★	3		
M 8	1.25	180	20	—	6	4.9	6.8	★	3	★	3	★	3		
M 10	1.5	200	22	—	7	5.5	8.5	★	3	★	3	★	3		
M 12	1.75	224	24	—	9	7	10.2	★	3	★	3	★	3		
M 14	2	224	26	—	11	9	12	★	3	★	3	★	3		
M 16	2	224	27	—	12	9	14	★	3	★	3	★	3		
M 18	2.5	250	30	—	14	11	15.5	★	3	★	3	★	3		
M 20	2.5	280	32	—	16	12	17.5	★	3	★	3	★	3		



ISO 2/6H	ISO 2/6H	ISO 2/6H	ISO 2/6H	6HX
NT	GLT-1		GLT-1	NT
HSS Extra	HSS Extra	HSS Extra	HSS Extra	HSS Extra
		R35	R35	
B / 4-5	B / 4-5	C / 2-3	C / 2-3	C / 2-3
E / O / P	E / O / P	E / O / P	E / O / P	E / O / P

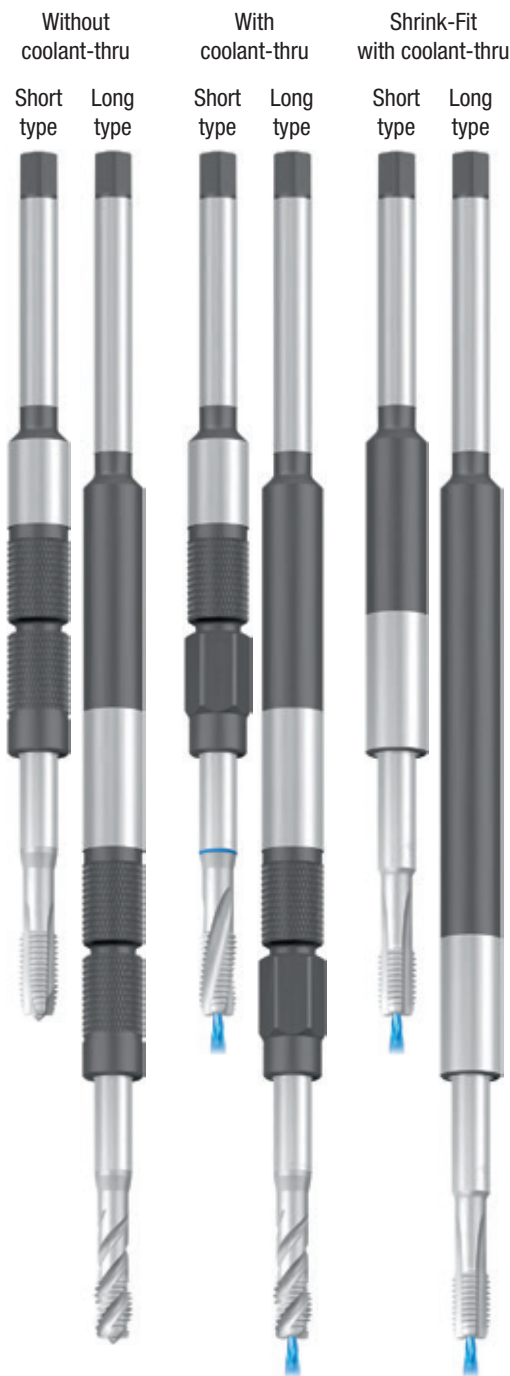


P 1.1-3.1	P 1.1-4.1	P 1.1-3.1	P 1.1-4.1	P 1.1-3.1
M 1.1-2.1	M 1.1-3.1	M 1.1-2.1	M 1.1-3.1	K 1.1-4.2
K 2.1	K 2.1	K 2.1	K 2.1	N 2.4-7
N 2.2, 2.5-6	N 2.2			N 4.1, 5.1

B2203000	B220C300	B2503000	B250C300	B2100501
Rekord 1B-VA-LS NT	Rekord 1B-VA-LS GLT-1	Enorm 1-VA-LS	Enorm 1-VA-LS GLT-1	Rekord 1A-H-LS NT
Flutes	Flutes	Flutes	Flutes	Flutes
★ 3	★ 3	★ 3	★ 3	★ 3
★ 3	upon	★ 3	★ 3	★ 3
★ 3	request	★ 3	★ 3	★ 3
★ 3		★ 3	★ 3	★ 3

C2203000	C220C300	C2503000	C2100501
Rekord 2B-VA-LS NT	Rekord 2B-VA-LS GLT-1	Enorm 2-VA-LS	Rekord 2A-H-LS NT
Flutes	Flutes	Flutes	Flutes
★ 3	★ 3	★ 3	★ 3
★ 3	upon	★ 3	★ 3
★ 3	request	★ 3	★ 3
★ 3		★ 3	★ 3
★ 3		★ 3	★ 3
★ 3		★ 3	★ 4
★ 3		★ 3	★ 4

As a further alternative to our compact types LS we can offer you our special shank extensions without and with coolant-thru (IKZ) for standard taps (see pages 132-138).



- Product Finder
- Vc
- UNC
- UNF
- UNEF
- UN-8
- M
- MF
- NPSM/NPSC
- NPSF
- Rp (BSP)
- G
- NPT
- NPTF
- Rc (BSPT)
- STI
- SELF-LOCK
- Accessories
- Tech. Info

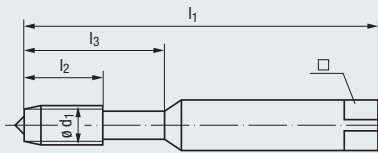


● = In stock
★ = Allow 7 days for delivery

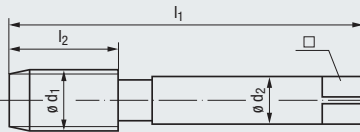
1) From M4 also available with IKZ (axial coolant-thru)
2) From M5 also available with IKZN (axial coolant-thru with radial flow into the flutes)

- Product Finder
- V_c
- UNC
- UNF
- UNEF
- UN-8
- M**
- MF
- NPSM/NPSC
- NPSF
- Rp (BSPP)
- G
- NPT
- NPTF
- Rc (BSPT)
- STI
- SELF-LOCK
- Accessories
- Tech. Info

ANSI Length • ANSI Shank



Reinforced Shank
(M4 - M10)



Reduced Shank
(M12 - M24)

STEEL Steel Materials



M

**ISO Metric Coarse Thread
DIN 13**

Class of Fit
Coating
Cutting Material
Technical Characteristics



ISO 2/6H	ISO 2/6H	ISO 2/6H	ISO 2/6H
TIN		TIN	TIN
HSS Extra	HSS Extra	HSS Extra	HSS Extra
R15		R15	R35
B / 4-5	E / 1.5-2	E / 1.5-2	C / 2-3
E / 0	E / 0	E / 0	E / 0

Thread Depth
and Hole Shape



max. 2 x d₁



max. 2.5 x d₁



Applications – Material

P 1.1-4.1	P 2.1-3.1	P 1.1-4.1	P 1.1-4.1
K 2.1		K 1.1-4.2	K 2.1
N 2.2, 2.4-5		N 1.4-5, 2.4-5	N 2.2

Tool Identification










Nominal Size ϕd_1	P mm	inch				ϕd_2	\square	mm	Dimens. ID	AU208400		AU461000		AU461400		AU501400	
		l_1	l_2	l_3	ϕd_2					Rekord B-STEEL-L TIN	Flutes	Rekord D-STEEL/E	Flutes	Rekord D-STEEL/E TIN	Flutes	Enorm STEEL TIN	Flutes
M 4	0.7	2 1/8	2.13	0.512	0.827	0.168	0.131	3.3	.0040	●	3	●	3	●	3	●	3
M 5	0.8	2 3/8	2.38	0.591	0.945	0.194	0.152	4.2	.0050	●	3	●	3	●	3	●	3
M 6	1	2 1/2	2.50	0.669	1.102	0.255	0.191	5	.0060	●	3	●	3	●	3	●	3
M 8	1.25	2 23/32	2.72	0.787	1.299	0.318	0.238	6.8	.0080	●	3	●	3	●	3	●	3
M 10	1.5	2 15/16	2.94	0.866	1.378	0.381	0.286	8.5	.0100	●	3	●	3	●	3	●	3
M 12	1.75	3 3/8	3.38	0.984	—	0.367	0.275	10.2	.0112	●	3	●	3	●	3	●	3
M 14	2	3 19/32	3.59	1.024	—	0.429	0.322	12	.0114	●	3	●	3	●	3	●	3
M 16	2	3 13/16	3.81	1.063	—	0.480	0.360	14	.0116	●	3	●	3	●	3	●	3
M 20	2.5	4 15/32	4.47	1.181	—	0.652	0.489	17.5	.0120	●	3			●	3	●	3
M 24	3	4 29/32	4.91	1.339	—	0.760	0.570	21	.0124	●	3				●	4	4

DIN Length • DIN Shank



All ANSI Length • ANSI Shank taps are available
in the popular DIN Length • DIN Shank style.

The DIN Length • DIN Shank configuration allows
for added reach capabilities and greater chip clearance.

VA Stainless Steel Materials		H Materials of High Tensile Strength		Z CNC-Controlled Machines								
												
$l_2 \approx 10 \times P$		$l_2 \approx 10 \times P$		$l_2 \approx 10 \times P$								
ISO 2/6H	ISO 2/6H	6HX	6HX	ISO 2/6H		Class of Fit						
NT		NT	TIN	TIN		Coating						
HSS Extra	HSS Extra	HSS Extra	HSS Extra	HSS Extra		Cutting Material						
	R35			R45		Technical Characteristics						
B / 4-5	C / 2-3	E / 1.5-2	E / 1.5-2	E / 1.5-2								
E / O / P	E / O / P	E / O / P	E / O / P	E / O / P								
max. 3 x d ₁	max. 2.5 x d ₁	max. 2 x d ₁		max. 3 x d ₁		Thread Depth and Hole Shape						
						Applications – Material						
P 1.1-3.1	P 1.1-3.1	P 1.1-3.1	P 1.1-4.1	P 1.1-4.1		Applications – Material						
M 1.1-2.1	M 1.1-2.1	K 1.1-4.2	K 1.1-4.2	M 1.1-3.1		Applications – Material						
K 2.1	K 2.1	N 2.4-7	N 2.4-7	N 1.4-6		Applications – Material						
N 2.2, 2.5-6		N 4.1, 5.1	N 4.1, 5.1	N 2.1-2, 2.4-5		Applications – Material						
				S 1.1		Applications – Material						
AU203000		AU503000		AU110501		AU110601		AU513700		Tool Identification		
Rekord B-VA NT	Enorm VA	Rekord A-H/E NT	Rekord A-H/E TIN	Enorm Z/E TIN		Dimens. ID	Nominal Size $\varnothing d_1$	P mm				
Flutes	Flutes	Flutes	Flutes	Flutes								
●	●	●	●	●		.0040	M 4	0.7				
●	●	●	●	●		.0050	M 5	0.8				
●	●	●	●	●	●	.0060	M 6	1				
●	●	●	●	●	●	.0080	M 8	1.25				
●	●	●	●	●	●	.0100	M 10	1.5				
●	●	●	●	●	●	.0112	M 12	1.75				
●	●	●	●	●	●	.0114	M 14	2				
●	●	●	●	●	●	.0116	M 16	2				
●	●	●	●	●	●	.0120	M 20	2.5				
●	●	●	●	●	●	.0124	M 24	3				

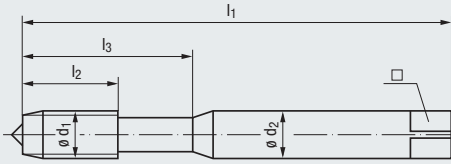
- Product Finder
- V_c
- UNC
- UNF
- UNEF
- UN-8
- M
- MF
- NPSM/NPSC
- NPSF
- R_p (BSPP)
- G
- NPT
- NPTF
- R_c (BSPT)
- STI
- SELF-LOCK
- Accessories
- Tech. Info



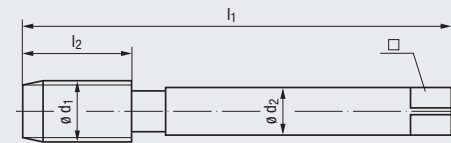
● = In stock
★ = Allow 7 days for delivery

- Product Finder
- V_c
- UNC
- UNF
- UNEF
- UN-8
- M
- MF
- NPSM/NPSC
- NPSF
- Rp (BSPP)
- G
- NPT
- NPTF
- Rc (BSPT)
- STI
- SELF-LOCK
- Accessories
- Tech. Info

DIN Length • DIN Shank



Reinforced Shank
(M3x0.35 - M10x1.25)



Reduced Shank
(M8x1 - M30x2)

MF

**ISO Metric Fine Thread
DIN 13**

Class of Fit
Coating
Cutting Material
Technical Characteristics



Applications – Material

STEEL Steel Materials



ISO 2/6H	ISO 2/6H	ISO 3/6G	ISO 2/6H	ISO 2/6H
HSS Extra	HSS Extra	HSS Extra	HSS Extra	HSS Extra
B / 4-5	B / 4-5	B / 4-5	B / 4-5	C / 2-3
E / 0	E / 0	E / 0	E / 0	E / 0

max. 3 x d₁



max. 2 x d₁










P 1.1-3.1	P 1.1-4.1	P 1.1-3.1	P 1.1-3.1	P 1.1-4.1
N 2.2	K 2.1	N 2.2	N 2.2	K 1.1-4.2
	N 2.2, 2.4-5			N 1.4-5, 2.4-5

Reinforced Shank

Nominal Size ø d ₁	P	l ₁	l ₂	l ₃	ø d ₂	□	Tool Identification		B0208900		B0208400					
							Rekord 1B-STEEL-L	Flutes	Rekord 1B-STEEL-L TIN	Flutes						
M 3 x 0.35	56	8	18	3.5	2.7	2.65	.0202	●	3	●	3					
M 4 x 0.5	63	10	21	4.5	3.4	3.5	.0210	●	3	●	3					
M 5 x 0.5	70	11	25	6	4.9	4.5	.0218	●	3	●	3					
M 6 x 0.75	80	13	30	6	4.9	5.2	.0229	●	3	●	3					
M 8 x 0.75	80	14	30	8	6.2	7.2	.0250	●	3	●	3					
M 8 x 1	90	17	35	8	6.2	7	.0251	●	3	●	3					
M 10 x 1	90	18	35	10	8	9	.0276	●	4	●	4					
M 10 x 1.25	100	18	39	10	8	8.8	.0277	●	3	●	3					

Reduced Shank

Nominal Size ø d ₁	P	l ₁	l ₂	l ₃	ø d ₂	□	Tool Identification		C0208900		C0208400		C0208920		C0208950		C0451400	
							Rekord 2B-STEEL-L	Flutes	Rekord 2B-STEEL-L TIN	Flutes	Rekord 2B-STEEL-L	Flutes	Rekord 2B-STEEL-L LH	Flutes	Rekord 2D-STEEL TIN	Flutes		
M 8 x 1	90	17	—	6	4.9	7	.0251	●	3	●	3	★	3	★	3	★	3	
M 10 x 1	90	18	—	7	5.5	9	.0276	●	4	●	4	★	4	★	4	★	3	
M 10 x 1.25	100	22	—	7	5.5	8.8	.0277	●	3	●	3					★	3	
M 12 x 1.5	100	22	—	9	7	10.5	.0303	●	3	●	3	★	3	★	3	★	3	
M 14 x 1.5	100	22	—	11	9	12.5	.0331	●	3	●	3	★	3	★	3	★	3	
M 16 x 1.5	100	22	—	12	9	14.5	.0359	●	3	●	3	★	3	★	3	★	3	
M 18 x 1.5	110	25	—	14	11	16.5	.0390	●	4	●	4	★	4	★	4	★	4	
M 20 x 1.5	125	25	—	16	12	18.5	.0422	●	4	●	4	★	4	★	4	★	4	
M 22 x 1.5	125	25	—	18	14.5	20.5	.0438	★	4	★	4							
M 22 x 2	140	27	—	18	14.5	20	.0439	★	3	★	3							
M 24 x 1.5	140	27	—	18	14.5	22.5	.0452	★	4	★	4							
M 24 x 2	140	27	—	18	14.5	22	.0453	★	4	★	4							
M 27 x 1.5	140	28	—	20	16	25.5	.0470	★	5	★	5							
M 27 x 2	140	28	—	20	16	25	.0471	★	4	★	4							
M 30 x 1.5	150	28	—	22	18	28.5	.0490	★	5	★	5							
M 30 x 2	150	28	—	22	18	28	.0491	★	4	★	4							

STEEL Steel Materials				VA Stainless Steel Materials												
																
ISO 2/6H TIN HSS Extra R15 E / 1.5-2 E / O	ISO 2/6H HSS Extra R35 C / 2-3 E / O	ISO 2/6H TIN HSS Extra R35 C / 2-3 E / O	ISO 2/6H HSS Extra LH, L35 C / 2-3 E / O	ISO 2/6H GLT-1 HSS Extra B / 4-5 E / O / P	ISO 2/6H NE2 HSS Extra R35 C / 2-3 E / O / P	ISO 2/6H GLT-1 HSS Extra R35 C / 2-3 E / O / P	Class of Fit Coating Cutting Material Technical Characteristics									
max. 2 x d ₁	max. 2.5 x d ₁			max. 3 x d ₁	max. 2.5 x d ₁		Thread Depth and Hole Shape									
P 1.1-4.1 K 1.1-4.2 N 1.4-5, 2.4-5	P 1.1-3.1 N 2.2	P 1.1-4.1 K 2.1 N 2.2	P 1.1-3.1 N 2.2	P 1.1-4.1 M 1.1-3.1 K 2.1 N 2.2	P 1.1-3.1 M 1.1-2.1 K 2.1	P 1.1-4.1 M 1.1-3.1 K 2.1	Applications – Material									
B0501000		B0501400		B0503200		B050C300		Tool Identification								
Enorm 1-STEEL		Enorm 1-STEEL TIN		Enorm 1-VA NE2		Enorm 1-VA GLT-1		Dimens. ID	Nominal Size ø d ₁	P						
Flutes		Flutes		Flutes		Flutes										
★	3	★	3	●	3	★	3	.0202	M 3 x 0.35							
★	3	★	3	●	3	★	3	.0210	M 4 x 0.5							
★	3	★	3	●	3	★	3	.0218	M 5 x 0.5							
★	3	★	3	●	3	★	3	.0229	M 6 x 0.75							
★	3	★	3	●	3			.0250	M 8 x 0.75							
★	3	★	3					.0251	M 8 x 1							
★	3	★	3					.0276	M 10 x 1							
★	3	★	3	●	3			.0277	M 10 x 1.25							
C0461400		C0501000		C0501400		C0501050		C020C300		C0503200		C050C300		Tool Identification		
Rekord 2D-STEEL/E TIN		Enorm 2-STEEL		Enorm 2-STEEL TIN		Enorm 2-STEEL-LH		Rekord 2B-VA GLT-1		Enorm 2-VA NE2		Enorm 2-VA GLT-1		Dimens. ID	Nominal Size ø d ₁	P
Flutes		Flutes		Flutes		Flutes		Flutes		Flutes		Flutes				
★	3	★	3	★	3	★	3	★	3	●	3	★	3	.0251	M 8 x 1	
★	3	★	3	★	3	★	3	★	4	●	3	★	3	.0276	M 10 x 1	
★	3	★	3	★	3	★	3	★	4	●	3	★	3	.0277	M 10 x 1.25	
★	3	★	4	★	4	★	4	★	3	●	4	★	4	.0303	M 12 x 1.5	
★	3	★	4	★	4	★	4	★	3	●	4	★	4	.0331	M 14 x 1.5	
★	3	★	4	★	4	★	4	★	3	●	4	★	4	.0359	M 16 x 1.5	
★	4	★	4	★	4	★	4	★	4	●	4	★	4	.0390	M 18 x 1.5	
★	4	★	4	★	4	★	4	★	4	●	4	★	4	.0422	M 20 x 1.5	
★	4	★	4							●	4			.0438	M 22 x 1.5	
★	4	★	4							●	4			.0439	M 22 x 2	
★	4	★	5							●	4			.0452	M 24 x 1.5	
		★	4							●	4			.0453	M 24 x 2	
		★	5							●	4			.0470	M 27 x 1.5	
		★	4							●	4			.0471	M 27 x 2	
		★	6							●	6			.0490	M 30 x 1.5	
		★	5											.0491	M 30 x 2	

● = In stock
★ = Allow 7 days for delivery

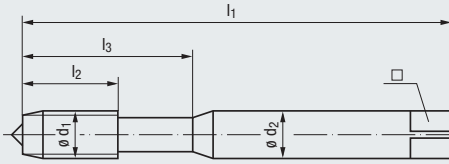
Product Finder

- Vc
- UNC
- UNF
- UNEF
- UN-8
- MF
- NPSM/NPSC
- NPSF
- Rp (BSPP)
- G
- NPT
- NPTF
- Rc (BSPT)
- STI
- SELF-LOCK
- Accessories
- Tech. Info

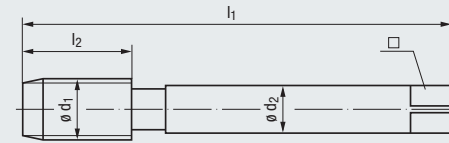


- Product Finder
- V_c
- UNC
- UNF
- UNEF
- UN-8
- M
- MF**
- NPSM/NPSC
- NPSF
- Rp (BSPP)
- G
- NPT
- NPTF
- Rc (BSPT)
- STI
- SELF-LOCK
- Accessories
- Tech. Info

DIN Length · DIN Shank



Reinforced Shank
(M3x0.35 - M10x1.25)



Reduced Shank
(M8x1 - M30x2)

MF

**ISO Metric Fine Thread
DIN 13**

Class of Fit
Coating
Cutting Material
Technical Characteristics



Applications – Material

GJV
Cast Iron
Vermicular

















6HX	6HX	6HX	6HX	6HX
TICN	TICN	TICN	TICN	TICN
HSSE-PM	HSSE-PM	HSSE-PM	HSSE-PM	HSSE-PM
C / 2-3	C / 2-3	C / 2-3	E / 1.5-2	E / 1.5-2
E	E	E	E	E
max. 2 x d ₁	max. 2 x d ₁	max. 2 x d ₁	max. 2 x d ₁	max. 2 x d ₁
K 1.1-4.2	K 1.1-4.2	K 1.1-4.2	K 1.1-4.2	K 1.1-4.2

Reinforced Shank

Nominal Size ø d ₁	P	mm			ø d ₂	□	Tool Identification							
		l ₁	l ₂	l ₃			Dimens. ID							
M 3 x 0.35	56	8	18	3.5	2.7	2.65	.0202							
M 4 x 0.5	63	10	21	4.5	3.4	3.5	.0210							
M 5 x 0.5	70	11	25	6	4.9	4.5	.0218							
M 6 x 0.75	80	13	30	6	4.9	5.2	.0229							
M 8 x 0.75	80	14	30	8	6.2	7.2	.0250							
M 8 x 1	90	17	35	8	6.2	7	.0251							
M 10 x 1	90	18	35	10	8	9	.0276							
M 10 x 1.25	100	18	39	10	8	8.8	.0277							

Reduced Shank

Nominal Size ø d ₁	P	mm			ø d ₂	□	Tool Identification		C010R501		C195R501		C106R501		C011R501		C196R501	
		l ₁	l ₂	l ₃			Dimens. ID	Rekord 2A-GJV PM-TICN	Flutes	Rekord 2A-GJV IKZ-PM TICN	Flutes	Rekord 2A-GJV IKZN-PM TICN	Flutes	Rekord 2A-GJV/E PM-TICN	Flutes	Rekord 2A-GJV/E IKZ-PM TICN	Flutes	
M 8 x 1	90	17	—	6	4.9	7	.0251											
M 10 x 1	90	18	—	7	5.5	9	.0276						upon					
M 10 x 1.25	100	22	—	7	5.5	8.8	.0277											
M 12 x 1.5	100	22	—	9	7	10.5	.0303	★	4	★	4	request	★	4	★	4	★	4
M 14 x 1.5	100	22	—	11	9	12.5	.0331	★	4	★	4		★	4	★	4	★	4
M 16 x 1.5	100	22	—	12	9	14.5	.0359	★	4	★	4		★	4	★	4	★	4
M 18 x 1.5	110	25	—	14	11	16.5	.0390	★	4	★	4		★	4	★	4	★	4
M 20 x 1.5	125	25	—	16	12	18.5	.0422	★	4	★	4		★	4	★	4	★	4
M 22 x 1.5	125	25	—	18	14.5	20.5	.0438											
M 22 x 2	140	27	—	18	14.5	20	.0439											
M 24 x 1.5	140	27	—	18	14.5	22.5	.0452											
M 24 x 2	140	27	—	18	14.5	22	.0453											
M 27 x 1.5	140	28	—	20	16	25.5	.0470											
M 27 x 2	140	28	—	20	16	25	.0471											
M 30 x 1.5	150	28	—	22	18	28.5	.0490											
M 30 x 2	150	28	—	22	18	28	.0491											

GJV Cast Iron Vermicular		H Materials of High Tensile Strength						
								
								6HX TICN HSSE-PM E / 1.5-2 E
max. 2 x d ₁ 	max. 2 x d ₁ 	max. 2 x d ₁ 	max. 2 x d ₁ 	max. 2 x d ₁ 	max. 2 x d ₁ 	max. 2 x d ₁ 	Thread Depth and Hole Shape	
K 1.1-4.2	P 1.1-3.1 K 1.1-4.2 N 2.4-7 N 4.1, 5.1	P 1.1-4.1 K 1.1-4.2 N 2.4-7 N 4.1, 5.1	P 1.1-4.1 K 1.1-4.2 N 2.4-7 N 4.1, 5.1	P 1.1-4.1 K 1.1-4.2 N 2.4-7 N 4.1, 5.1	P 1.1-4.1 K 1.1-4.2 N 2.4-7 N 4.1, 5.1	P 5.1 K 1.1-4.2 N 1.5-6, 2.6-8 N 4.1, 4.3-5.2 H 1.1-2	Applications – Material	
		B0100501			B1950901		Tool Identification	
		Rekord 1A-H NT Flutes				VHM Rekord 1A-H-1KZ Flutes	Dimens. ID Nominal Size ø d ₁ P	
		★ 3				★ 3	.0202 M 3 x 0.35	
		★ 3					.0210 M 4 x 0.5	
		★ 3					.0218 M 5 x 0.5	
		★ 3					.0229 M 6 x 0.75	
							.0250 M 8 x 0.75	
						★ 3	.0251 M 8 x 1	
						★ 4	.0276 M 10 x 1	
						★ 3	.0277 M 10 x 1.25	
C109R501		C0100501	C0109101	C1959101	C1069101	C1950901	Tool Identification	
Rekord 2A-GJV/E 1KZN-PM TICN Flutes		Rekord 2A-H NT Flutes	Rekord 2A-H TICN Flutes	Rekord 2A-H-1KZ TICN Flutes	Rekord 2A-H-1KZN TICN Flutes	KHM Rekord 2A-H-1KZ Flutes	Dimens. ID Nominal Size ø d ₁ P	
upon		● 3	★ 3				.0251 M 8 x 1	
		● 4	★ 4		upon		.0276 M 10 x 1	
			★ 3				.0277 M 10 x 1.25	
request		● 4	★ 4	★ 4	★ 4	★ 4	.0303 M 12 x 1.5	
		● 4	★ 4	★ 4	★ 4	★ 4	.0331 M 14 x 1.5	
		● 4	★ 4	★ 4	★ 4	★ 4	.0359 M 16 x 1.5	
		● 4	★ 4	★ 4	★ 4	★ 4	.0390 M 18 x 1.5	
		● 4	★ 4	★ 4	★ 4	★ 4	.0422 M 20 x 1.5	
			★ 4				.0438 M 22 x 1.5	
				★ 4			.0439 M 22 x 2	
							.0452 M 24 x 1.5	
							.0453 M 24 x 2	
							.0470 M 27 x 1.5	
							.0471 M 27 x 2	
							.0490 M 30 x 1.5	
							.0491 M 30 x 2	

● = In stock
★ = Allow 7 days for delivery

1) Threading in through holes is possible only with external cooling/lubrication

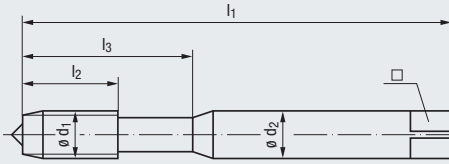
Product Finder

- V_c
- UNC
- UNF
- UNEF
- UN-8
- MF
- NPSM/NPSC
- NPSF
- R_p (BSPP)
- G
- NPT
- NPTF
- R_c (BSPT)
- STI
- SELF-LOCK
- Accessories
- Tech. Info

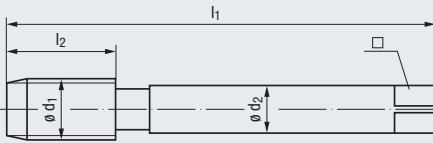


- Product Finder
- V_c
- UNC
- UNF
- UNEF
- UN-8
- M
- MF
- NPSM/NPSC
- NPSF
- Rp (BSPP)
- G
- NPT
- NPTF
- Rc (BSPT)
- STI
- SELF-LOCK
- Accessories
- Tech. Info

DIN Length • DIN Shank



Reinforced Shank
(M8x1 - M10x1)



Reduced Shank
(M12x1.5 - M16x1.5)

HCUT
Hardened
Steels



MF



**ISO Metric Fine Thread
DIN 13**

Class of Fit

6HX

Coating

TICN

Cutting Material

HSSE-PM

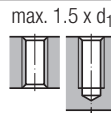
Technical Characteristics



C / 2-3

O / P

Thread Depth
and Hole Shape



Applications – Material

H 1.1-2

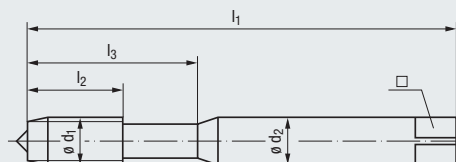
Reinforced Shank

Nominal Size ø d ₁	P	l ₁	mm			ø d ₂	□	Tool Identification		Rekord 1A-HCUT-PM TICN	Flutes
			l ₂	l ₃	ø d ₂			□	Dimens. ID		
M 8 x 1	1	90	10	35	8	6.2	7.1	.0251	★	5	
M 10 x 1	1	90	10	35	10	8	9.1	.0276	★	5	

Reduced Shank

Nominal Size ø d ₁	P	l ₁	mm			ø d ₂	□	Tool Identification		Rekord 2A-HCUT-PM TICN	Flutes
			l ₂	l ₃	ø d ₂			□	Dimens. ID		
M 12 x 1.5	1.5	100	15	—	9	7	10.6	.0303	★	5	
M 14 x 1.5	1.5	100	15	—	11	9	12.6	.0331	★	6	
M 16 x 1.5	1.5	100	15	—	12	9	14.6	.0359	★	6	

DIN Length • DIN Shank



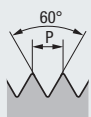
Reinforced Shank

HCUT
Hardened
Steels



2)

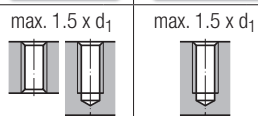
MF
ISO Metric Fine Thread
DIN 13



Class of Fit
Coating
Cutting Material
Technical Characteristics

6HX	6HX
TICN	TICN
Carbide	Carbide
D / 4-5	C / 2-3
O / P	O / P

Thread Depth
and Hole Shape



Applications – Material

H 1.3-4 H 1.3-4

Reinforced Shank

Nominal Size ϕd_1	P	mm					
		l_1	l_2	l_3	ϕd_2	\square	
M 8 x 1		90	15	35	8	6.2	
M 10 x 1		100	18	38	10	8	
M 12 x 1.5		110	21	41	12	9	
M 14 x 1.5		110	24	44	14	11	
M 16 x 1.5		110	24	44	16	12	

Tool Identification



Dimens. ID

B016K101

VHM Rekord 1A-HCUT/D TICN

Flutes

B010K101

VHM Rekord 1A-HCUT/C TICN

Flutes

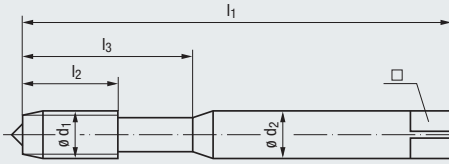
2) Please note: Use solid carbide tap VHM-Rekord 1A-HCUT/D-TICN as No.1 tap!

- Product Finder
- Vc
- UNC
- UNF
- UNEF
- UN-8
- ...
- MF**
- NPSM/NPSC
- NPSF
- Rp (BSPP)
- G
- NPT
- NPTF
- Rc (BSPT)
- STI
- SELF-LOCK
- Accessories
- Tech. Info

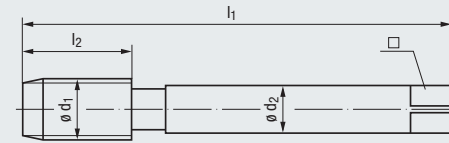


- Product Finder
- V_c
- UNC
- UNF
- UNEF
- UN-8
- M
- MF**
- NPSM/NPSC
- NPSF
- Rp (BSPP)
- G
- NPT
- NPTF
- Rc (BSPT)
- STI
- SELF-LOCK
- Accessories
- Tech. Info

DIN Length • DIN Shank



Reinforced Shank
(M3x0.35 - M10x1.25)



Reduced Shank
(M8x1 - M30x2)

Z
CNC-Controlled
Machines



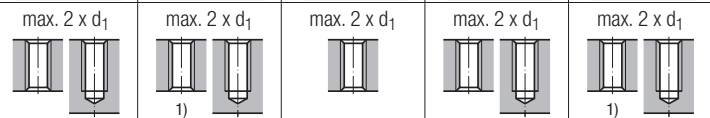
MF

**ISO Metric Fine Thread
DIN 13**

Class of Fit
Coating
Cutting Material
Technical Characteristics

6HX	6HX	6HX	6HX	6HX
TICN	TICN	TICN	TICN	TICN
HSS Extra	HSS Extra	HSS Extra	HSS Extra	HSS Extra
C / 2-3	C / 2-3	C / 2-3	E / 1.5-2	E / 1.5-2
E / O / P	E / O	E / O	E / O / P	E / O

Thread Depth
and Hole Shape



Applications – Material

P 1.1-4.1	P 1.1-4.1	P 1.1-4.1	P 1.1-4.1	P 1.1-4.1
K 1.1-4.2	K 1.1-4.2	K 1.1-4.2	K 1.1-4.2	K 1.1-4.2
N 1.4-6, 2.4-7	N 1.4-6, 2.4-7	N 1.4-6, 2.4-7	N 1.4-6, 2.4-7	N 1.4-6, 2.4-7
N 4.1	N 4.1	N 4.1	N 4.1	N 4.1

Reinforced Shank

Nominal Size ϕd_1	P	l ₁	l ₂	l ₃	ϕd_2	\square
M 3 x 0.35	56	4.5	18	3.5	2.7	
M 4 x 0.5	63	5	21	4.5	3.4	
M 5 x 0.5	70	5	25	6	4.9	
M 6 x 0.75	80	8	30	6	4.9	
M 8 x 0.75	80	8	30	8	6.2	
M 8 x 1	90	10	35	8	6.2	
M 10 x 1	90	10	35	10	8	
M 10 x 1.25	100	16	39	10	8	

Tool Identification

Dimens. ID									
2.65	.0202								
3.5	.0210								
4.5	.0218								
5.2	.0229								
7.2	.0250								
7	.0251								
9	.0276								
8.8	.0277								

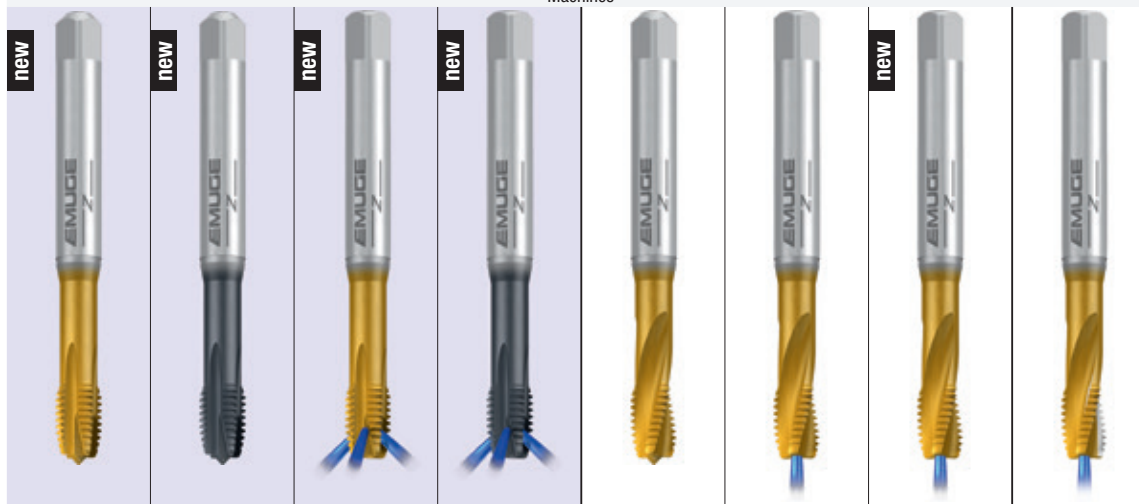
Reduced Shank

Nominal Size ϕd_1	P	l ₁	l ₂	l ₃	ϕd_2	\square
M 8 x 1	90	10	—	6	4.9	
M 10 x 1	90	10	—	7	5.5	
M 10 x 1.25	100	16	—	7	5.5	
M 12 x 1.5	100	15	—	9	7	
M 14 x 1.5	100	15	—	11	9	
M 16 x 1.5	100	15	—	12	9	
M 18 x 1.5	110	17	—	14	11	
M 20 x 1.5	125	17	—	16	12	
M 22 x 1.5	125	17	—	18	14.5	
M 22 x 2	140	20	—	18	14.5	
M 24 x 1.5	140	20	—	18	14.5	
M 24 x 2	140	20	—	18	14.5	
M 27 x 1.5	140	20	—	20	16	
M 27 x 2	140	20	—	20	16	
M 30 x 1.5	150	22	—	22	18	
M 30 x 2	150	22	—	22	18	

Tool Identification

Dimens. ID	C0109401	C1959401	C1069401	C0119401	C1969401
	Rekord 2A-Z TICN	Rekord 2A-Z-1KZ TICN	Rekord 2A-Z-1KZN TICN	Rekord 2A-Z/E TICN	Rekord 2A-Z/E-1KZ TICN
	Flutes	Flutes	Flutes	Flutes	Flutes
7	★	★	3	★	★
9	★	●	4	★	★
8.8	★	●	3	★	★
10.5	★	★	4	★	★
12.5	★	★	4	★	★
14.5	★	★	4	★	★
16.5					
18.5					
20.5					
20					
22.5					
22					
25.5					
25					
28.5					
28					

Z
CNC-Controlled
Machines



6HX	6HX	6HX	6HX	6HX	6HX	6HX	6HX
TIN-70	GLT-1	TIN-70	GLT-1	TIN	TIN	TIN	TIN
HSSE-PM	HSSE-PM	HSSE-PM	HSSE-PM	HSS Extra	HSS Extra	HSS Extra	HSS Extra
B / 4-5	B / 4-5	B / 4-5	B / 4-5	R15	R15	R15	R15
E / O / P	E / O / P	E / O	E / O	C / 2-3	C / 2-3	E / 1.5-2	C / 2-3
				E / O / P	E / O	E / O	E / O

Class of Fit
Coating
Cutting Material
Technical Characteristics

max. 3 x d₁



max. 2 x d₁



Thread Depth and Hole Shape

P 1.1-5.1	P 1.1-5.1	P 1.1-5.1	P 1.1-5.1	P 2.1-5.1	P 2.1-5.1	P 2.1-5.1	P 2.1-5.1
M 1.1-3.1	M 1.1-3.1	M 1.1-3.1	M 1.1-3.1	K 2.1-2	K 2.1-2	K 2.1-2	K 2.1-2
K 2.1	K 2.1	K 2.1	K 2.1	N 1.4-6, 2.4-5	N 1.4-6, 2.4-5	N 1.4-6, 2.4-5	N 1.4-6, 2.4-5
N 1.4-2.2, 2.4-5	N 1.4-2.2, 2.4-5	N 1.4-2.2, 2.4-5	N 1.4-2.2, 2.4-5				
S 1.1	S 1.1	S 1.1	S 1.1				

Applications – Material

B0208F01		B020A601										Tool Identification	
Rekord 1B-Z-PM TIN-70	Flutes	Rekord 1B-Z-PM GLT-1	Flutes							Dimens. ID	Nominal Size ø d ₁	P	
★	3	★	3							.0202	M 3 x 0.35		
★	3	★	3							.0210	M 4 x 0.5		
										.0218	M 5 x 0.5		
										.0229	M 6 x 0.75		
										.0250	M 8 x 0.75		
										.0251	M 8 x 1		
										.0276	M 10 x 1		
										.0277	M 10 x 1.25		

C0208F01		C020A601		C1088F01		C108A601		C0453701		C0963701		C0983701		C4253701		Tool Identification		
Rekord 2B-Z-PM TIN-70	Flutes	Rekord 2B-Z-PM GLT-1	Flutes	Rekord 2B-Z-PM-TIN-70	Flutes	Rekord 2B-Z-PM-GLT-1	Flutes	Rekord 2D-Z TIN	Flutes	Rekord 2D-Z-1KZ TIN	Flutes	Rekord 2D-Z/E-1KZ TIN	Flutes	Rekord 2D-Z-BF 1KZ-TIN	Flutes	Dimens. ID	Nominal Size ø d ₁	P
★	4	★	4					★	3	★	3	★	3	★	3	.0251	M 8 x 1	
★	4	★	4	upon		upon		★	3	★	3	★	3	★	3	.0276	M 10 x 1	
★	4	★	4					★	3	★	3	★	3	★	3	.0277	M 10 x 1.25	
★	4	★	4	request		request		★	3	★	3	★	3	★	3	.0303	M 12 x 1.5	
★	4	★	4							★	3	★	3	★	3	.0331	M 14 x 1.5	
★	4	★	4							★	3	★	3	★	3	.0359	M 16 x 1.5	
★	4	★	4									★	3	★	3	.0390	M 18 x 1.5	
★	4	★	4											★	3	.0422	M 20 x 1.5	
																.0438	M 22 x 1.5	
																.0439	M 22 x 2	
																.0452	M 24 x 1.5	
																.0453	M 24 x 2	
																.0470	M 27 x 1.5	
																.0471	M 27 x 2	
																.0490	M 30 x 1.5	
																.0491	M 30 x 2	

● = In stock
★ = Allow 7 days for delivery

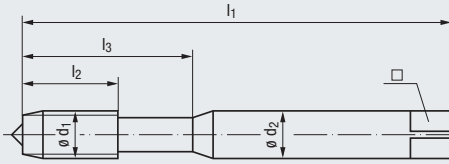
Product Finder

- V_c
- UNC
- UNF
- UNEF
- UN-8
- MF
- NPSM/NPSC
- NPSF
- R_p (BSPP)
- G
- NPT
- NPTF
- R_c (BSPT)
- STI
- SELF-LOCK
- Accessories
- Tech. Info

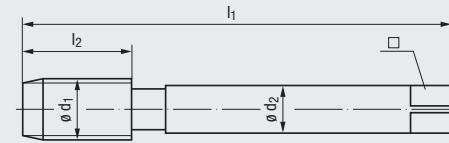


- Product Finder
- V_c
- UNC
- UNF
- UNEF
- UN-8
- M
- MF**
- NPSM/NPSC
- NPSF
- Rp (BSPP)
- G
- NPT
- NPTF
- Rc (BSPT)
- STI
- SELF-LOCK
- Accessories
- Tech. Info

DIN Length • DIN Shank

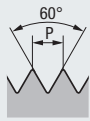


Reinforced Shank
(M3x0.35 - M10x1.25)



Reduced Shank
(M8x1 - M30x2)

MF



ISO Metric Fine Thread
DIN 13

Class of Fit

Coating

Cutting Material

Technical Characteristics



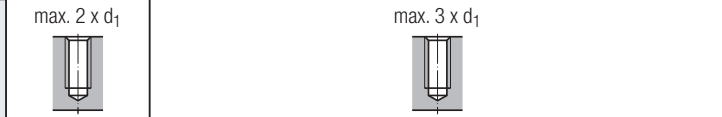
Thread Depth
and Hole Shape

Applications – Material

Z
CNC-Controlled
Machines



6HX	ISO 2/6H	ISO 2/6H	ISO 2/6H	ISO 2/6H
TIN		TIN	GLT-1	TIN
HSS Extra	HSS Extra	HSS Extra	HSS Extra	HSS Extra
R15	R45	R45	R45	R45
E / 1.5-2	E / 1.5-2	E / 1.5-2	E / 1.5-2	E / 1.5-2
E / 0	E / 0 / P	E / 0 / P	E / 0 / P	E / 0













P 2.1-5.1	P 1.1-4.1	P 1.1-4.1	P 1.1-4.1	P 1.1-4.1
K 2.1-2	M 1.1-2.1	M 1.1-3.1	M 1.1-3.1	M 1.1-3.1
N 1.4-6, 2.4-5	N 2.1	N 1.4-6	N 1.4-6	N 1.4-6
		N 2.1-2, 2.4-5	N 2.1-2, 2.4-5	N 2.1-2, 2.4-5
		S 1.1	S 1.1	S 1.1

Reinforced Shank

Nominal Size ø d ₁	P	mm					ø d ₂	□	Tool Identification		B0513500		B0513700	
		l ₁	l ₂	l ₃	□	□			Enorm 1-Z/E	Flutes	Enorm 1-Z/E TIN	Flutes		
M 3 x 0.35	56	4.5	18	3.5	2.7	2.65	.0202							
M 4 x 0.5	63	5	21	4.5	3.4	3.5	.0210			*	3	*	3	
M 5 x 0.5	70	5	25	6	4.9	4.5	.0218			*	3	*	3	
M 6 x 0.75	80	8	30	6	4.9	5.2	.0229			*	3	*	3	
M 8 x 0.75	80	8	30	8	6.2	7.2	.0250							
M 8 x 1	90	10	35	8	6.2	7	.0251							
M 10 x 1	90	10	35	10	8	9	.0276							
M 10 x 1.25	100	16	39	10	8	8.8	.0277							

Reduced Shank

Nominal Size ø d ₁	P	mm					ø d ₂	□	Tool Identification		C4053701	C0513500	C0513700	C051C400	C0973700
		l ₁	l ₂	l ₃	□	□			Rekord 2D-Z/E-BF IKZ-TIN	Enorm 2-Z/E	Enorm 2-Z/E TIN	Enorm 2-Z/E GLT-1	Enorm 2-Z/E-1KZ TIN		
M 8 x 1	90	10	—	6	4.9	7	.0251	*	3	*	3	*	3	*	3
M 10 x 1	90	10	—	7	5.5	9	.0276	*	3	*	4	*	4	*	4
M 10 x 1.25	100	16	—	7	5.5	8.8	.0277	*	3	*	3	*	3	*	3
M 12 x 1.5	100	15	—	9	7	10.5	.0303	*	3	*	5	*	5	*	5
M 14 x 1.5	100	15	—	11	9	12.5	.0331	*	3	*	5	*	5	*	5
M 16 x 1.5	100	15	—	12	9	14.5	.0359	*	3	*	5	*	5	*	5
M 18 x 1.5	110	17	—	14	11	16.5	.0390	*	3	*	5	*	5	*	5
M 20 x 1.5	125	17	—	16	12	18.5	.0422	*	3	*	5	*	5	*	5
M 22 x 1.5	125	17	—	18	14.5	20.5	.0438	*	3	*	5	*	5	*	5
M 22 x 2	140	20	—	18	14.5	20	.0439	*	3	*	5	*	5	*	5
M 24 x 1.5	140	20	—	18	14.5	22.5	.0452	*	3	*	5	*	5	*	5
M 24 x 2	140	20	—	18	14.5	22	.0453	*	3	*	5	*	5	*	5
M 27 x 1.5	140	20	—	20	16	25.5	.0470	*	3	*	5	*	5	*	5
M 27 x 2	140	20	—	20	16	25	.0471	*	3	*	5	*	5	*	5
M 30 x 1.5	150	22	—	22	18	28.5	.0490	*	3	*	5	*	5	*	5
M 30 x 2	150	22	—	22	18	28	.0491	*	3	*	5	*	5	*	5

Z CNC-Controlled Machines		SPEED High-Speed Cutting								
										
ISO 3/6G		6HX	6HX	6HX	6HX	6HX	6HX	Class of Fit		
TIN		TICN	TICN	TICN	TICN	TIN-70	TIN-70	Coating		
HSS Extra		HSS Extra	HSS Extra	HSS Extra	HSS Extra	HSSE-PM	HSSE-PM	Cutting Material		
R45								Technical Characteristics		
E / 1.5-2		C / 2-3	C / 2-3	E / 1.5-2	E / 1.5-2	B / 4-5	B / 4-5			
E / O / P		E	E	E	E	E	E			
max. 3 x d ₁		max. 2 x d ₁	max. 2 x d ₁	max. 2 x d ₁	max. 2 x d ₁		max. 3 x d ₁	Thread Depth and Hole Shape		
P 1.1-4.1		K 1.1-4.2	K 1.1-4.2	K 1.1-4.2	K 1.1-4.2	P 1.1-4.1	P 1.1-4.1	Applications – Material		
M 1.1-3.1		N 1.4-6	N 1.4-6	N 1.4-6	N 1.4-6	K 2.1-2	K 2.1-2			
N 1.4-6						N 1.4-6	N 1.4-6			
N 2.1-2, 2.4-5										
S 1.1										
B0513720								Tool Identification		
Enorm 1-Z/E TIN	Flutes							Dimens. ID	Nominal Size ø d ₁	P
★	3							.0202	M 3 x	0.35
★	3							.0210	M 4 x	0.5
★	3							.0218	M 5 x	0.5
								.0229	M 6 x	0.75
								.0250	M 8 x	0.75
								.0251	M 8 x	1
								.0276	M 10 x	1
								.0277	M 10 x	1.25
C0513720								Tool Identification		
Enorm 2-Z/E TIN	Flutes	Rekord 2A-SPEED IKZ-TICN	Rekord 2A-SPEED IKZN-TICN	Rekord 2A-SPEED/E IKZ-TICN	Rekord 2A-SPEED/E IKZN-TICN	Rekord 2B-Z-SPEED PM-TIN-70	Rekord 2B-Z-SPEED IKZN-PM TIN-70	Dimens. ID	Nominal Size ø d ₁	P
★	3	★	3			★	4	.0251	M 8 x	1
★	4	★	4	upon		★	4	.0276	M 10 x	1
		●	3			★	4	.0277	M 10 x	1.25
★	5	★	4	request	★	4	request	.0303	M 12 x	1.5
★	5	●	4		★	4		.0331	M 14 x	1.5
★	5	●	4		★	4		.0359	M 16 x	1.5
						★	4	.0390	M 18 x	1.5
						★	4	.0422	M 20 x	1.5
								.0438	M 22 x	1.5
								.0439	M 22 x	2
								.0452	M 24 x	1.5
								.0453	M 24 x	2
								.0470	M 27 x	1.5
								.0471	M 27 x	2
								.0490	M 30 x	1.5
								.0491	M 30 x	2

● = In stock
★ = Allow 7 days for delivery

1) Threading in through holes is possible only with external cooling/lubrication

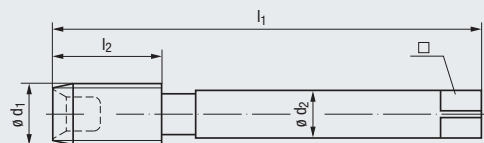
Product Finder

- V_c
- UNC
- UNF
- UNEF
- UN-8
- MF
- NPSM/NPSC
- NPSF
- R_p (BSPP)
- G
- NPT
- NPTF
- R_c (BSPT)
- STI
- SELF-LOCK
- Accessories
- Tech. Info



DIN Length • DIN Shank

With internal chip collector

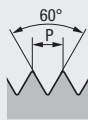


Reduced Shank

VA
Stainless Steel
Materials



MF



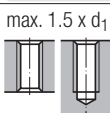
**ISO Metric Fine Thread
DIN 13**

Class of Fit
Coating
Cutting Material
Technical Characteristics



- 6HX
- NE2
- HSS Extra
- C / 2-3
- P / 0 1)

Thread Depth
and Hole Shape



Applications – Material

- P 1.1-4.1
- M 1.1-2.1
- K 1.1-4.2

Reduced Shank

Tool Identification

C0803001

Nominal Size ø d ₁	P	l ₁	mm l ₂	ø d ₂	□	Image	Dimens. ID	Robust 2X-VA NE2	
								Flutes	
M 20 x 1.5	125	25	16	12	18.5	.0422	★	5	
M 22 x 1.5	125	25	18	14.5	20.5	.0438	★	5	
M 24 x 1.5	140	27	18	14.5	22.5	.0452	★	5	
M 24 x 2	140	27	18	14.5	22	.0453	★	5	
M 27 x 1.5	140	28	20	16	25.5	.0470	★	5	
M 27 x 2	140	28	20	16	25	.0471	★	5	
M 30 x 1.5	150	28	22	18	28.5	.0490	★	6	
M 33 x 1.5	160	30	25	20	31.5	.0511	★	6	
M 33 x 2	160	30	25	20	31	.0512	★	6	
M 36 x 1.5	170	30	28	22	34.5	.0532	★	6	
M 36 x 2	170	30	28	22	34	.0533	★	6	
M 36 x 3	200	42	28	22	33	.0534	★	6	
M 38 x 1.5	170	30	28	22	36.5	.0546	★	6	
M 39 x 3	200	42	32	24	36	.0555	★	6	
M 40 x 2	170	30	32	24	38	.0561	★	6	
M 42 x 1.5	170	30	32	24	40.5	.0574	★	6	
M 42 x 2	170	30	32	24	40	.0575	★	6	
M 42 x 3	200	45	32	24	39	.0576	★	6	
M 45 x 3	200	45	36	29	42	.0597	★	6	
M 48 x 1.5	190	32	36	29	46.5	.0616	★	8	
M 48 x 2	190	32	36	29	46	.0617	★	7	
M 48 x 3	225	50	36	29	45	.0618	★	6	
M 52 x 3	225	50	40	32	49	.0646	★	6	
M 56 x 3	225	50	40	32	53	.0661	★	7	
M 56 x 4	250	60	40	32	52	.0662	★	7	
M 60 x 4	280	60	45	35	56	.0672	★	7	
M 64 x 3	275	55	50	39	61	.0681	★	8	
M 64 x 4	315	65	50	39	60	.0682	★	7	
M 68 x 4	315	65	50	39	64	.0692	★	7	
M 70 x 3	275	55	50	39	67	.0696	★	8	

● = In stock
★ = Allow 7 days for delivery

Product Finder

- Vc
- UNC
- UNF
- UNEF
- UN-8
- ...
- MF
- NPSM/NPSC
- NPSF
- Rp (BSPP)
- G
- NPT
- NTF
- Rc (BSPT)
- STI
- SELF-LOCK
- Accessories
- Tech. Info



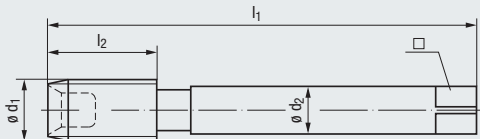
- Product Finder
- V_c
- UNC
- UNF
- UNEF
- UN-8
- M
- MF
- NPSM/NPSC
- NPSF
- Rp (BSPP)
- G
- NPT
- NPTF
- Rc (BSPT)
- STI
- SELF-LOCK
- Accessories
- Tech. Info

DIN Length • DIN Shank

VA
Stainless Steel
Materials



With internal chip collector



Reduced Shank

MF
ISO Metric Fine Thread
DIN 13

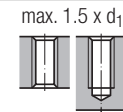


Class of Fit
Coating
Cutting Material
Technical Characteristics



Thread Depth
and Hole Shape

- 6HX
- NE2
- HSS Extra
- C / 2-3
- P / 0 1)



Applications – Material

- P 1.1-4.1
- M 1.1-2.1
- K 1.1-4.2

Reduced Shank

Tool Identification

C0803001

Nominal Size ø d ₁	P	l ₁	mm		□	Image	Dimens. ID	Robust 2X-VA NE2	Flutes
			l ₂	ø d ₂					
M 70 x 4	4	340	65	50	39	66	.0697	★	7
M 72 x 3	3	275	55	50	39	69	.0702	★	8
M 72 x 4	4	340	65	50	39	68	.0703	★	8
M 72 x 6	6	340	80	50	39	66	.0704	★	7
M 76 x 3	3	275	55	50	39	73	.0714	★	8
M 76 x 4	4	340	65	50	39	72	.0715	★	8
M 76 x 6	6	340	80	50	39	70	.0716	★	7
M 80 x 4	4	360	65	50	39	76	.0727	★	10
M 80 x 6	6	360	80	50	39	74	.0728	★	8
M 85 x 3	3	325	60	50	39	82	.0736	★	10
M 85 x 4	4	380	70	50	39	81	.0737	★	10
M 90 x 3	3	325	60	50	39	87	.0746	★	10
M 90 x 4	4	380	70	50	39	86	.0747	★	10
M 90 x 6	6	380	80	50	39	84	.0748	★	9
M 95 x 6	6	400	85	56	44	89	.0758	★	9
M 100 x 4	4	400	70	56	44	96	.0767	★	10
M 100 x 6	6	400	85	56	44	94	.0768	★	10
M 110 x 6	6	400	85	56	44	104	.0788	★	10
M 115 x 3	3	350	65	56	44	112	.0791	★	12
M 120 x 4	4	400	75	56	44	116	.0797	★	12
M 120 x 6	6	400	90	56	44	114	.0798	★	10

≥ M56 Shank with grooves for better handling!

1) If possible, use paste lubrication, coating both the tool and the walls of the drilled hole.
Lubrication with oil is possible only in the vertical machining of blind holes, if the hole is entirely filled with oil.

Larger sizes priced upon request.

The Complete Tool System

Robust 2X-VA Taps when used with a KSN Type tapping attachment creates the optimal tapping unit!

Extra Length • DIN Shank

Z
CNC-Controlled
Machines

Product
Finder

V_c

UNC

UNF

UNEF

UN-8

...

MF

NPSM/NPSC

NPSF

R_p (BSPP)

G

NPT

NPTF

R_c (BSPT)

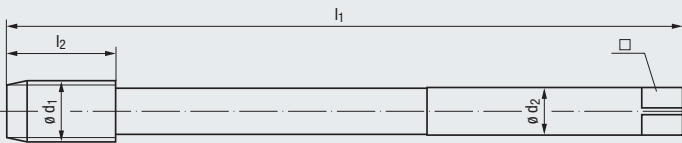
STI

SELF-LOCK

Accessories

Tech. Info

With long flutes and long shank for thread depths up to max. 4 x d₁



MF
ISO Metric Fine Thread
DIN 13



Class of Fit	6HX	6HX	6HX
Coating	TICN	TIN	TIN
Cutting Material	HSS Extra	HSS Extra	HSS Extra
Technical Characteristics			
	C / 2-3	C / 2-3	C / 2-3
	E / 0	E / 0	E / 0
Thread Depth and Hole Shape	max. 4 x d ₁ 	max. 4 x d ₁ 	

Applications – Material	<ul style="list-style-type: none"> P 1.1-4.1 K 1.1-4.2 N 1.4-6, 2.4-7 N 4.1 	<ul style="list-style-type: none"> P 2.1-5.1 K 2.1-2 N 1.4-6, 2.4-5 	<ul style="list-style-type: none"> P 2.1-5.1 K 2.1-2 N 1.4-6, 2.4-5
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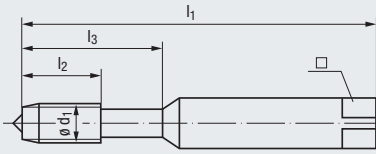
Reduced Shank

		Tool Identification		C0539401		C4283701		C4063701	
Nominal Size	P	l ₁	mm l ₂	θ d ₂	□	Rekord 2A-Z- IKZ -LF4 TICN	Rekord 2D-Z- IKZ -LF4 TIN	Rekord 2D-Z- BF-IKZ -LF4 TIN	Flutes
M 24	x 2	240	20	18	14.5	22	.0453		
M 30	x 2	270	22	22	18	28	.0491	upon	upon
M 36	x 3	310	30	28	22	33	.0534	upon	upon
								request	request

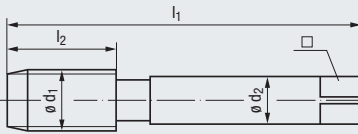
1) Threading in through holes is possible only with external cooling/lubrication

- Product Finder
- Vc
- UNC
- UNF
- UNEF
- UN-8
- M
- MF**
- NPSM/NPSC
- NPSF
- Rp (BSPP)
- G
- NPT
- NPTF
- Rc (BSPT)
- STI
- SELF-LOCK
- Accessories
- Tech. Info

ANSI Length · ANSI Shank



Reinforced Shank
(M10x1 - M10x1.25)



Reduced Shank
(M12x1.5 - M14x1.5)

STEEL Steel Materials

new



new



MF

**ISO Metric Fine Thread
DIN 13**

Class of Fit
Coating
Cutting Material
Technical Characteristics

ISO 2/6H	ISO 2/6H	ISO 2/6H	ISO 2/6H
TIN	TIN	TIN	TIN
HSS Extra	HSS Extra	HSS Extra	HSS Extra
R15	R15	R15	R35
B / 4-5	E / 1.5-2	E / 1.5-2	C / 2-3
E / 0	E / 0	E / 0	E / 0

Thread Depth and Hole Shape

max. 3 x d ₁	max. 2 x d ₁	max. 2.5 x d ₁

Applications – Material

P 1.1-4.1	P 2.1-3.1	P 1.1-4.1	P 1.1-4.1
K 2.1		K 1.1-4.2	K 2.1
N 2.2, 2.4-5		N 1.4-5, 2.4-5	N 2.2

Nominal Size ϕd_1	P mm	inch				ϕd_2	\square	Tool Identification		AU208400		AU461000		AU461400		AU501400	
		l_1	l_2	l_3	ϕd_2			\square	mm	Dimens. ID	Rekord B-STEEL-L TIN	Flutes	Rekord D-STEEL/E	Flutes	Rekord D-STEEL/E TIN	Flutes	Enorm STEEL TIN
M 10 x 1		2 15/16	2.94	0.709	1.378	0.381	0.286	9	.0276	●	4	●	3	●	3	●	3
M 10 x 1.25		2 15/16	2.94	0.709	1.378	0.381	0.286	8.8	.0277	●	3	●	3	●	3	●	3
M 12 x 1.5		3 3/8	3.38	0.866	—	0.367	0.275	10.5	.0303	●	3	●	3	●	3	●	4
M 14 x 1.5		3 19/32	3.59	0.866	—	0.429	0.322	12.5	.0331	●	3	●	3	●	3	●	4

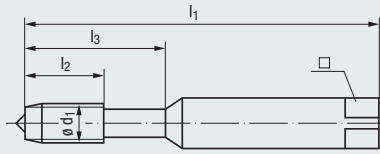
DIN Length · DIN Shank



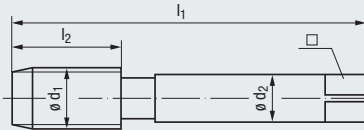
All ANSI Length · ANSI Shank taps are available in the popular DIN Length · DIN Shank style.

The DIN Length · DIN Shank configuration allows for added reach capabilities and greater chip clearance.

ANSI Length • ANSI Shank



Reinforced Shank
(M10x1 - M10x1.25)



Reduced Shank
(M12x1.5 - M14x1.5)

MF



ISO Metric Fine Thread
DIN 13

Class of Fit
Coating
Cutting Material
Technical Characteristics



Thread Depth
and Hole Shape

Applications – Material

Nominal Size ϕd_1	P mm	inch					
		l_1	l_2	l_3	ϕd_2	\square	
M 10 x 1		2 15/16	2.94	0.709	1.378	0.381	0.286
M 10 x 1.25		2 15/16	2.94	0.709	1.378	0.381	0.286
M 12 x 1.5		3 3/8	3.38	0.866	—	0.367	0.275
M 14 x 1.5		3 19/32	3.59	0.866	—	0.429	0.322

Tool Identification		AU203000		AU503000		AU110501		AU110601	
mm	Dimens. ID	Rekord B-VA NT	Flutes	Enorm VA	Flutes	Rekord A-H/E NT	Flutes	Rekord A-H/E TIN	Flutes
9	.0276	●	4	●	3	●	4	●	4
8.8	.0277	●	3	●	3	●	3	●	3
10.5	.0303	●	3	●	4	●	4	●	4
12.5	.0331	●	3	●	4	●	4	●	4

VA
Stainless Steel
Materials



H
Materials of High
Tensile Strength



ISO 2/6H	ISO 2/6H	6HX	6HX
NT	NT	NT	TIN
HSS Extra	HSS Extra	HSS Extra	HSS Extra
	R35		
B / 4-5	C / 2-3	E / 1.5-2	E / 1.5-2
E / O / P	E / O / P	E / O / P	E / O / P

max. 3 x d_1	max. 2.5 x d_1	max. 2 x d_1	

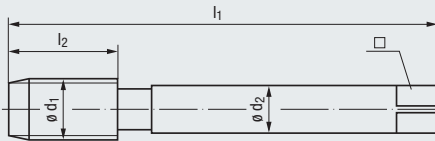
P 1.1-3.1	P 1.1-3.1	P 1.1-3.1	P 1.1-4.1
M 1.1-2.1	M 1.1-2.1	K 1.1-4.2	K 1.1-4.2
K 2.1	K 2.1	N 2.4-7	N 2.4-7
N 2.2, 2.5-6		N 4.1, 5.1	N 4.1, 5.1

- Product Finder
- Vc
- UNC
- UNF
- UNEF
- UN-8
- ...
- MF
- NPSM/NPSC
- NPSF
- Rp (BSPP)
- G
- NPT
- NPTF
- Rc (BSPT)
- STI
- SELF-LOCK
- Accessories
- Tech. Info



- Product Finder
- V_c
- UNC
- UNF
- UNEF
- UN-8
- M
- MF
- NPSM/NPSC
- NPSF
- Rp (BSPP)
- G
- NPT
- NPTF
- Rc (BSPT)
- STI
- SELF-LOCK
- Accessories
- Tech. Info

DIN Length • DIN Shank



Reduced Shank

STEEL
Steel
Materials



Z
CNC-Controlled
Machines



NPSM/ NPSC



**American Standard Straight Pipe Thread
ANSI B1.20.1**

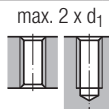
For mechanical joints (previously NPS)

Class of Fit
Coating
Cutting Material
Technical Characteristics

Thread Depth
and Hole Shape

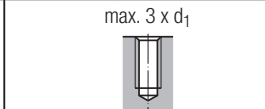
Applications – Material

- "X"
- HSS Extra
- C / 2-3
- E / 0



- P 1.1-3.1
- N 2.3

- TIN
- HSS Extra
- R45
- E / 1.5-2
- E / 0 / P



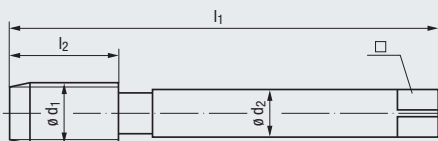
- P 1.1-4.1
- M 1.1-2.1
- N 2.1
- P 1.1-4.1
- M 1.1-3.1
- N 1.4-6
- N 2.1-2, 2.4-5
- S 1.1

Reduced Shank

							Tool Identification		C0101001		C0513500		C0513700	
Nominal Size ø d ₁	T.P.I.	ø d ₁	l ₁	mm l ₂	ø d ₂	□	NPSM NPSC		Rekord 2A-STEEL	Flutes	Enorm 2-Z/E	Flutes	Enorm 2-Z/E TIN	Flutes
							Dimens. ID							
1/8	27	10.100	90	18	7	5.5	9.1	8.8	●	4	●	4	●	4
1/4	18	13.404	100	22	11	9	12	11.4	●	4	●	5	●	5
3/8	18	16.843	100	22	12	9	15.5	14.9			●	5	●	5
1/2	14	20.949	125	25	16	12	19	18.4			●	5	●	5
3/4	14	26.296	140	28	20	16	24.5	23.7			●	5		
1	11 1/2	32.895	160	30	25	20	30.5	29.8						

NPSM can also be used for NPSC thread

DIN Length • DIN Shank



Reduced Shank

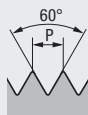
STEEL
Steel
Materials



Z
CNC-Controlled
Machines



NPSF
American Standard Straight Pipe Thread
ANSI B1.20.3



Dryseal internal straight pipe thread for fuel, combined with external tapered pipe thread NPTF or PTF-SAE-SHORT; Gage with tapered gages

Class of Fit: "X"
Coating: HSS Extra
Cutting Material: HSS Extra
Technical Characteristics: C / 2-3, E / O



Thread Depth and Hole Shape: max. 2 x d₁

Applications – Material: P 1.1-3.1, N 2.3

Coating: TIN
Cutting Material: HSS Extra
Technical Characteristics: R45, E / 1.5-2, E / O / P

Thread Depth and Hole Shape: max. 3 x d₁

Applications – Material: P 1.1-4.1, M 1.1-2.1, N 2.1, N 1.1-3.1, N 1.4-6, N 2.1-2, 2.4-5, S 1.1

Reduced Shank

Nominal Size ø d ₁	T.P.I.	ø d ₁	l ₁	mm		□	Tool Identification		C0101001		C0513500		C0513700	
				l ₂	ø d ₂		Rekord 2A-STEEL	Flutes	Enorm 2-Z/E	Flutes	Enorm 2-Z/E TIN	Flutes		
1/16	27	7.582	90	17	6	4.9	6.35	.5904	★	3	●	3	●	3
1/8	27	9.929	90	18	7	5.5	8.7	.5905	●	4	●	4	●	4
1/4	18	13.236	100	22	11	9	11.3	.5906	●	4	●	5	●	5
3/8	18	16.673	100	22	12	9	14.75	.5907	●	4	●	5	●	5
1/2	14	20.819	125	25	16	12	18.2	.5908	●	4	●	5	●	5
3/4	14	26.166	140	28	20	16	23.5	.5909	●	4	●	5	●	5
1	11 1/2	32.718	160	30	25	20	29.5	.5910	●	4	●	5	●	5

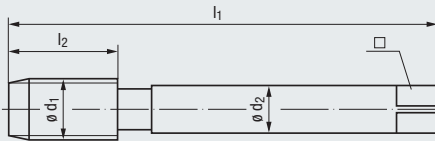
- Product Finder
- V_c
- UNC
- UNF
- UNEF
- UN-8
- ...
- MF
- NPSM/NPSC
- NPSF**
- R_p (BSPP)
- G
- NPT
- NPTF
- R_c (BSPT)
- STI
- SELF-LOCK
- Accessories
- Tech. Info



● = In stock
★ = Allow 7 days for delivery

- Product Finder
- V_c
- UNC
- UNF
- UNEF
- UN-8
- M
- MF
- NPSM/NPSC
- NPSF
- Rp (BSPP)
- G
- NPT
- NPTF
- Rc (BSPT)
- STI
- SELF-LOCK
- Accessories
- Tech. Info

DIN Length • DIN Shank



Reduced Shank

STEEL
Steel
Materials



Z
CNC-Controlled
Machines



new

Rp (BSPP)

Cylindrical Whitworth Pipe Thread
DIN EN 10226-1 and ISO 7-1

Where pressure-tight joints are made on the threads

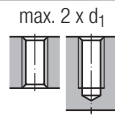
Class of Fit
Coating
Cutting Material
Technical Characteristics



Thread Depth and Hole Shape

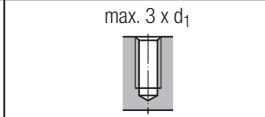
Applications – Material

- "X"
- HSS Extra
- C / 2-3
- E / 0



- P 1.1-3.1
- N 2.3

- HSS Extra
- R45
- E / 1.5-2**
- E / 0 / P

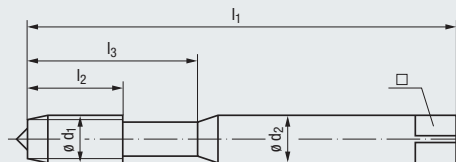


- P 1.1-4.1
- M 1.1-2.1
- N 2.1
- TIN
- HSS Extra
- R45
- E / 1.5-2**
- E / 0 / P

Reduced Shank

Nominal Size ø d ₁	T.P.I.	ø d ₁	l ₁	mm		ø d ₂	□	Tool Identification		C0101001		C0513500		C0513700	
				l ₂	□			Rekord 2A-STEEL	Flutes	Enorm 2-Z/E	Flutes	Enorm 2-Z/E TIN	Flutes		
Rp 1/8	28	9.73	90	18	7	5.5	8.6	.4092	★	4	●	4	★	4	
Rp 1/4	19	13.16	100	22	11	9	11.5	.4093	★	4	●	5	★	5	
Rp 3/8	19	16.66	100	22	12	9	15	.4094	★	4	●	5	★	5	
Rp 1/2	14	20.96	125	25	16	12	18.5	.4095	★	4	●	5	★	5	
Rp 3/4	14	26.44	140	28	20	16	24	.4096	★	4	●	5			
Rp 1	11	33.25	160	30	25	20	30.25	.4097	★	5	●	6			

DIN Length • DIN Shank



Reinforced Shank

HCUT
Hardened
Steels

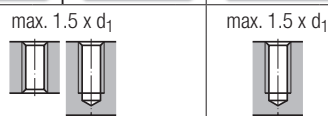


G
Whitworth Pipe Thread
DIN EN ISO 228

Class of Fit
Coating
Cutting Material
Technical Characteristics

"X"	"X"	"X"
TICN	TICN	TICN
HSSE-PM	Carbide	Carbide
C / 2-3	D / 4-5	C / 2-3
O / P	O / P	O / P

Thread Depth
and Hole Shape



Applications – Material

H 1.1-2	H 1.3-4	H 1.3-4
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Reinforced Shank

Nominal Size ø d ₁	T.P.I.	mm						□	Tool Identification		B010J901	B016K101	B010K101
		ø d ₁	l ₁	l ₂	l ₃	ø d ₂	□		Dimens. ID	Rekord 1A-HCUT-PM TICN	VHM Rekord 1A-HCUT/D TICN	VHM Rekord 1A-HCUT/C TICN	
G 1/8	28	9.73	90	10	35	10	8	8.8	.4035	★	5		
G 1/8	28	9.73	100	18	38	10	8	8.8	.4035		★	5	★
G 1/4	19	13.16	110	24	44	14	11	11.9	.4036		★	6	★

2) Please note: Use solid carbide tap VHM-Rekord 1A-HCUT/D-TICN as No.1 tap!

- Product Finder
- V_c
- UNC
- UNF
- UNEF
- UN-8
- ...
- MF
- NPSM/NPSC
- NPSF
- R_p (BSPP)
- G**
- NPT
- NTF
- R_c (BSPT)
- STI
- SELF-LOCK
- Accessories
- Tech. Info

