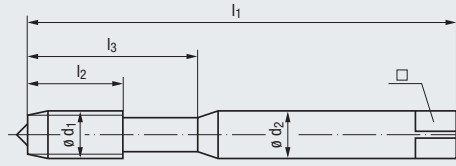


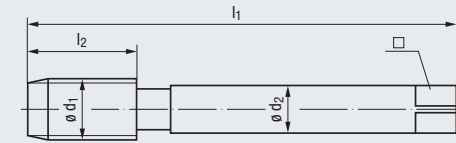
- Product Finder
- V_c
- UNC
- UNF
- M
- MF
- G
- STI
- SELF-LOCK
- Tech. Info

DIN Length - ANSI Shank

Overall length acc. to DIN 2174



Reinforced Shank
(No.1 - 3/8)



Reduced Shank
(7/16 - 1)

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



2BX	2BX	2BX	2BX	2BX
NT	TIN	TIN	TIN	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
O / P	E / O / P	E / O	E / O / P	E / O / P

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

P 1.1-3.1	P 1.1-3.1	P 1.1-3.1	P 1.1-3.1	P 1.1-3.1
M 1.1-2.1²⁾	M 1.1-2.1²⁾	M 1.1-2.1²⁾	M 1.1-2.1²⁾	M 1.1-2.1²⁾
N 1.4-5, 2.1-2	N 1.4-5, 2.1-2	N 1.4-5, 2.1-2	N 1.4-5, 2.1-2	N 1.4-5, 2.1-2

Reinforced Shank

Nominal Size ø d ₁	T.P.I.	l ₁	l ₂	inch			□	Tool Identification		BU921000	BU921400	BW921400	BU931400	BU939000
				l ₃	ø d ₂	□		Dimens. ID	Druck 1-STEEL-SN NT					
No. 1	64	1.772	0.276	0.472	0.141	0.110	0.0669	.5000	•	•	•	•	•	
No. 2	56	1.772	0.276	0.472	0.141	0.110	0.0787	.5001	•	•	•	•	•	
No. 3	48	1.969	0.354	0.551	0.141	0.110	0.0906	.5002	•	•	•	•	•	
No. 4	40	2.205	0.433	0.709	0.141	0.110	0.1004	.5003	•	•	•	•	•	
No. 5	40	2.205	0.433	0.709	0.141	0.110	0.1142	.5004	•	•	•	•	•	
No. 6	32	2.205	0.472	0.787	0.141	0.110	0.1240	.5005	•	•	•	•	•	
No. 8	32	2.480	0.512	0.827	0.168	0.131	0.1496	.5006	•	•	•	•	•	
No. 10	24	2.756	0.591	0.984	0.194	0.152	0.1713	.5007	•	•	•	•	•	
No. 12	24	3.150	0.630	1.142	0.220	0.165	0.1969	.5008	•	•	•	•	•	
1/4	20	3.150	0.669	1.181	0.255	0.191	0.2264	.5009	•	•	•	•	•	
5/16	18	3.543	0.787	1.378	0.318	0.238	0.2874	.5010	•	•	•	•	•	
3/8	16	3.937	0.866	1.535	0.381	0.286	0.3465	.5011	•	•	•	•	•	

Reduced Shank

Nominal Size ø d ₁	T.P.I.	l ₁	l ₂	inch			□	Tool Identification		CU921000	CU921400	CW921400		
				l ₃	ø d ₂	□		Dimens. ID	Druck 2-STEEL-SN NT					
7/16	14	3.937	0.866	—	0.323	0.242	0.4035	.5012	•	•	•	•	•	
1/2	13	4.331	0.984	—	0.367	0.275	0.4646	.5013	•	•	•	•	•	
9/16	12	4.331	1.024	—	0.429	0.322	0.5236	.5014	•	•	•	•	•	
5/8	11	4.331	1.063	—	0.480	0.360	0.5827	.5015	•	•	•	•	•	
3/4	10	4.921	1.181	—	0.590	0.442	0.7028	.5016	•	•	•	•	•	
7/8	9	5.512	1.260	—	0.697	0.523	0.8228	.5017	•	•	•	•	•	
1	8	6.299	1.417	—	0.800	0.600	0.9409	.5018	•	•	•	•	•	

We recommend a smaller preparatory diameter by 0.002 in for difficult to form materials (such as aluminum cast alloys) for P = 24 T.P.I. and coarser threads. For further information regarding the recommended preparatory diameters, see page 208 - 209.

- Product Finder
- V_c
- UNC
- UNF
- M
- MF
- G
- ST
- SELF-LOCK
- Tech. Info

STEEL Steel Materials						VA Stainless steel materials			
new	new	new	new	new	new	new			
$l_2 = 10 \times P$ 3)	$l_2 = 10 \times P$ 3)	$l_2 = 10 \times P$ 3)	$l_2 = 10 \times P$ 3)	$l_2 = 10 \times P$ 3)	$l_2 = 10 \times P$ 3)	$l_2 = 10 \times P$			
2BX	2BX	2BX	2BX	2BX	2BX	2BX	Class of Fit		
TIN-66	TIN-66	TIN-66	TICN-67	TICN-67	TICN-67	TIN-T26	Coating		
HSSE-PM	HSSE-PM	HSSE-PM	HSSE-PM	HSSE-PM	HSSE-PM	HSSE-PM	Cutting Material		
C / 2-3	C / 2-3	E / 1.5-2	C / 2-3	C / 2-3	E / 1.5-2	E / 1.5-2	Technical Characteristics		
E / O / P	E / O	E / O	E / O / P	E / O	E / O	E / O / P			
max. 3 x d ₁ 	max. 3 x d ₁ 	max. 3 x d ₁ 	max. 3 x d ₁ 	max. 3 x d ₁ 	max. 3 x d ₁ 	max. 3 x d ₁ 	Thread Depth and Hole Shape		
P 1.1-4.1	P 1.1-4.1	P 1.1-4.1	P 3.1-5.1	P 3.1-5.1	P 3.1-5.1	P 1.1-4.1	Applications – Material		
K 2.1	K 2.1	K 2.1	K 2.1	K 2.1	K 2.1	M 1.1-3.1²⁾			
BU377F00	BU387F00	BU447F00	BU376F00	BU386F00	BU446F00	BU396A00	Tool Identification		
InnoForm 1-STEEL-M SN-PM TIN-66	InnoForm 1-STEEL-M SN-IKZ-PM TIN-66	InnoForm 1-STEEL-M/E SN-IKZ-PM TIN-66	InnoForm 1-STEEL-H SN-PM TICN-67	InnoForm 1-STEEL-H SN-IKZ-PM TICN-67	InnoForm 1-STEEL-H/E SN-IKZ-PM TICN-67	InnoForm 1-VA/E-SN PM-TIN-T26	Dimens. ID	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
CU377F00	CU387F00		CU376F00	CU386F00	CU446F00	CU396A00	Tool Identification		
InnoForm 2-STEEL-M SN-PM TIN-66	InnoForm 2-STEEL-M SN-IKZ-PM TIN-66		InnoForm 2-STEEL-H SN-PM TICN-67	InnoForm 2-STEEL-H SN-IKZ-PM TICN-67	InnoForm 2-STEEL-H SN-IKZ-PM TICN-67	InnoForm 2-VA/E-SN PM-TIN-T26	Dimens. ID	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

1) Cold-forming in through holes is possible only with external cooling/lubrication
 2) Restricted application possibilities with emulsion
 3) Patent pending