

15110

Hexagonal die DIN 382

M 6g HSS <math>\leq 800 \text{ N/mm}^2</math>



Design

Clockwise-cutting, approx. 1.75-threaded chamfer.

Applications

For standard metric ISO thread DIN 13. Mainly

used for re-cutting and evening out damaged threads.

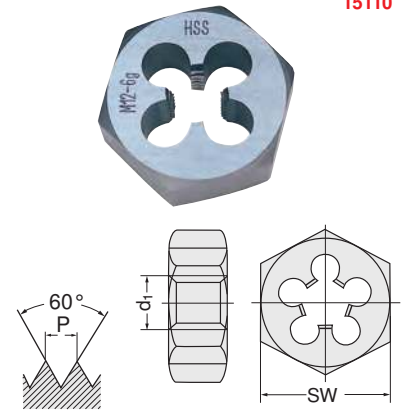
For materials up to approx. 800 N/mm<sup>2</sup> strength.

Quality

HSS.

d <sub>1</sub>	P mm	Spanner size mm	15110	...
M 3	0.50	18	101	
M 4	0.70	18	103	
M 5	0.80	18	104	
M 6	1.00	18	105	
M 8	1.25	21	106	
M 10	1.50	27	107	
M 12	1.75	36	108	
M 14	2.00	36	109	
M 16	2.00	41	110	

d <sub>1</sub>	P mm	Spanner size mm	15110	...
M 18	2.50	41	111	
M 20	2.50	41	112	
M 22	2.50	50	113	
M 24	3.00	50	114	
M 27	3.00	60	115	
M 30	3.50	60	116	
M 33	3.50	60	117	
M 36	4.00	60	118	



15110

15112

Hexagonal die DIN 382

G 6g HSS <math>\leq 800 \text{ N/mm}^2</math>



Design

Clockwise-cutting, approx. 1.75-threaded chamfer.

Applications

For cylindrical Whitworth pipe thread DIN ISO 228.

Mainly used for re-cutting and evening out damaged threads.

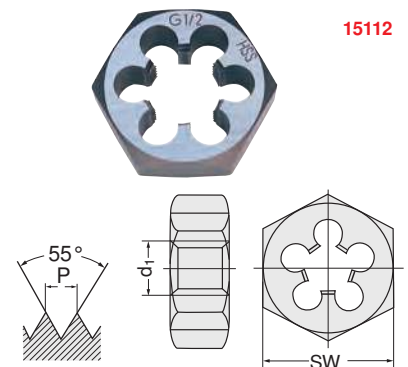
For materials up to approx. 800 N/mm<sup>2</sup> strength.

Quality

HSS.

d <sub>1</sub>	P TPI	Spanner size mm	15112	...
Thread 1/8	28	27	101	
Thread 1/4	19	36	102	
Thread 3/8	19	41	103	
Thread 1/2	14	41	104	
Thread 3/4	14	50	106	
Thread 1	11	60	108	

d <sub>1</sub>	P TPI	Spanner size mm	15112	...
Thread 1.1/8	11	70	109	
Thread 1.1/4	11	70	110	
Thread 1.1/2	11	85	112	
Thread 1.3/4	11	100	114	
Thread 2	11	100	116	



15112

15203 - 15204

Die DIN EN 22 568

M 6g HSS <math>\leq 800 \text{ N/mm}^2</math>

Design

Closed (pre-slotted), from M 3 with spiral point for ultra-easy, clean cuts and improved surface quality. Clockwise-cutting. Tolerances: 6H up to M 1.4 and 6 g above. Chip angle of 15–20°, approx. 1.75 thread chamfer.

Applications

For standard metric ISO thread DIN 13.

For normal, machinable materials up to approx. 800 N/mm<sup>2</sup> strength.

Quality

HSS.

15203

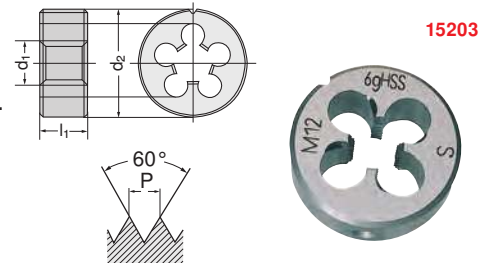


15203 501-507

With the same exterior dimensions (25 x 9 mm).

For thread cutting tool kit art. no.14960 101.

15204



15203

d <sub>1</sub>	P mm	d <sub>2</sub> x l <sub>1</sub> mm	ATORN® 15203	...	H+W 15204	...
M 1	0.25	16 x 5			201	
M 1.1	0.25	16 x 5			202	
M 1.2	0.25	16 x 5			203	
M 1.4	0.30	16 x 5			204	
M 1.6	0.35	16 x 5			205	
M 1.8	0.35	16 x 5			207	
M 2	0.40	16 x 5			208	
M 2.2	0.45	16 x 5			209	
M 2.5	0.45	16 x 5			211	
M 3	0.50	20 x 5	213			103
M 3.5	0.60	20 x 5	214			
M 4	0.70	20 x 5	215			104
M 4.5	0.75	20 x 7	216			
M 5	0.80	20 x 7	217			105
M 6	1.00	20 x 7	218			106
M 7	1.00	25 x 9	219			
M 8	1.25	25 x 9	220			107
M 9	1.25	25 x 9	221			
M 10	1.50	30 x 11	222			108
M 11	1.50	30 x 11	223			

d <sub>1</sub>	P mm	d <sub>2</sub> x l <sub>1</sub> mm	ATORN® 15203	...	H+W 15204	...
M 12	1.75	38 x 14		224		109
M 14	2.00	38 x 14		225		110
M 16	2.00	45 x 18		226		111
M 18	2.50	45 x 18		227		112
M 20	2.50	45 x 18		228		113
M 22	2.50	55 x 22		229		
M 24	3.00	55 x 22		230		
M 27	3.00	65 x 25		231		
M 30	3.50	65 x 25		232		
M 33	3.50	65 x 25		233		
M 36	4.00	65 x 25		234		
M 39	4.00	75 x 30		235		
M 42	4.50	75 x 30		236		
M 3	0.50	25 x 9			501	
M 4	0.70	25 x 9			502	
M 5	0.80	25 x 9			503	
M 6	1.00	25 x 9			504	
M 10	1.50	25 x 9			506	
M 12	1.75	25 x 9			507	



## Die

15205

Die set

M

6g

HSS



**HHW**

**Design**

Contents:

- 7 metric dies M3–M 12 (25 x 9)
- 1 die holder in accordance with DIN 225 with chrome-plated handles
- In painted metal box

**Applications**

For **standard metric ISO thread** DIN 13.

**Quality**  
HSS.



15205

Contents

15205

...

8 pieces

101

15206

Die DIN EN 22 568

M

6g

HSS



**EMUGE**

**Design**

Closed (pre-slotted), with **spiral point** for ultra-easy, clean cuts and improved surface quality.

Clockwise-cutting. **Tolerance class ISO 6G.**

Approx. 1.1/2-threaded chamfer.

**Applications**

For **standard metric ISO thread** DIN 13.

For materials **up to approx. 850 N/mm<sup>2</sup>** strength.

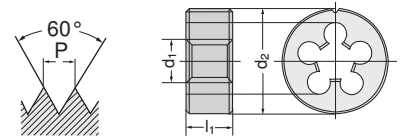
**Quality**  
HSS.



15206

d <sub>1</sub>	P	d <sub>2</sub> x l <sub>1</sub>	15206	...
	mm	mm		
M 3	0.50	20 x 5	213	
M 4	0.70	20 x 5	215	
M 5	0.80	20 x 7	217	
M 6	1.00	20 x 7	218	
M 8	1.25	25 x 9	220	

d <sub>1</sub>	P	d <sub>2</sub> x l <sub>1</sub>	15206	...
	mm	mm		
M 10	1.50	30 x 11	222	
M 12	1.75	38 x 14	224	
M 16	2.00	45 x 18	226	
M 20	2.50	45 x 18	228	



15207 - 15208

Die DIN EN 22 568

M

6g

HSS-E



**Design**

Closed (pre-slotted), with **spiral point** for ultra-easy, clean cuts and improved surface quality.

Clockwise-cutting. **Tolerance class ISO 6G.**

Approx. 2-threaded chamfer.

**Applications**

For **standard metric ISO thread** DIN 13.

For materials that are difficult to machine **up to approx. 850–1200 N/mm<sup>2</sup>** strength, rust and acid-resistant steels (VA).

**Quality**

HSS-E (no. 15207 nitrided from M3 up).

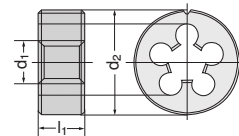
15207

**ATORN®**

10–15° chip angle.

15208

**EMUGE**



15207

d <sub>1</sub>	P	d <sub>2</sub> x l <sub>1</sub>	ATORN®		EMUGE	
			15207	...	15208	...
	mm	mm				
M 2	0.40	16 x 5	101			
M 2.5	0.45	16 x 5	104			
M 3	0.50	20 x 5	106			106
M 4	0.70	20 x 5	108			108
M 5	0.80	20 x 7	109			109
M 6	1.00	20 x 7	110			110

d <sub>1</sub>	P	d <sub>2</sub> x l <sub>1</sub>	ATORN®		EMUGE	
			15207	...	15208	...
	mm	mm				
M 8	1.25	25 x 9	112		112	
M 10	1.50	30 x 11	113		113	
M 12	1.75	38 x 14	114		114	
M 16	2.00	45 x 18	116		116	
M 20	2.50	45 x 18	118			
M 24	3.00	55 x 22	120			



15211

Anti-clockwise cutting die DIN EN 22 568

M

6g

HSS



**ATORN®**

**Design**

- Closed (pre-slotted)

- **With spiral point** for ultra-easy, clean cuts and improved surface quality

- **6G tolerance class**

- Approx. 15°–20° chip angle

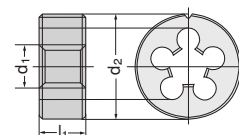
- Approx. 1.75-threaded chamfer

**Applications**

For **standard metric ISO thread** DIN 13.

For materials **up to approx. 800 N/mm<sup>2</sup>**.

**Quality**  
HSS.



15211

d <sub>1</sub>	P	d <sub>2</sub> x l <sub>1</sub>	15211	...
	mm	mm		
M 3	0.50	20 x 5	101	
M 4	0.70	20 x 5	102	
M 5	0.80	20 x 7	103	
M 6	1.00	20 x 7	104	
M 8	1.25	25 x 9	105	

d <sub>1</sub>	P	d <sub>2</sub> x l <sub>1</sub>	15211	...
	mm	mm		
M 10	1.50	30 x 11	106	
M 12	1.75	38 x 14	107	
M 14	2.00	38 x 14	108	
M 16	2.00	45 x 18	109	
M 18	2.50	45 x 18	110	

d <sub>1</sub>	P	d <sub>2</sub> x l <sub>1</sub>	15211	...
	mm	mm		
M 20	2.50	45 x 18	111	
M 22	2.50	55 x 22	112	
M 24	3.00	55 x 22	113	



15219 - 15221

Die DIN EN 22 568

MF

6g

HSS

HSS-E



Design

Closed (pre-slotted), with spiral point for ultra-easy, clean cuts and improved surface quality. Clockwise-cutting. 6G tolerance class. 15–20° chip angle, 1.75-threaded chamfer.

Applications

For metric ISO fine threads DIN 13.

15220

**ATORN®**

Applications

For materials up to approx. 800 N/mm<sup>2</sup> strength.

Quality

HSS.

15221

**HFW**

Applications

For materials, steel up to approx. 800 N/mm<sup>2</sup> strength.

Quality

HSS.

15219

**ATORN®**

Applications

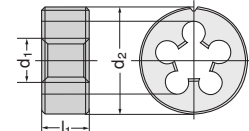
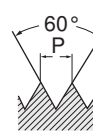
For materials that are difficult to machine up to approx. 850–1200 N/mm<sup>2</sup> strength, rust and acid-resistant steels (VA).

Quality

HSS-E.



15220



d <sub>1</sub> x P mm	d <sub>2</sub> x l <sub>1</sub> mm	ATORN®		HFW		ATORN®	
		15220	...	15221	...	15219	...
M 3 x 0.35	20 x 5		104				
M 3.5 x 0.35	20 x 5		105				
M 4 x 0.35	20 x 5		106				
M 4 x 0.50	20 x 5		107				
M 5 x 0.50	20 x 5		108				108
M 6 x 0.50	20 x 5		109				
M 6 x 0.75	20 x 7		110				110
M 7 x 0.75	25 x 9		111				
M 8 x 0.50	25 x 9		112				
M 8 x 0.75	25 x 9		113				113
M 8 x 1.00	25 x 9		114		214		
M 9 x 1.00	25 x 9		115				
M 10 x 0.75	30 x 11		116				
M 10 x 1.00	30 x 11		117		217		117
M 10 x 1.25	30 x 11		118		218		
M 11 x 1.00	30 x 11		119				
M 12 x 1.00	38 x 10		120		220		120
M 12 x 1.25	38 x 10		121		221		
M 12 x 1.50	38 x 10		122		222		121
M 14 x 1.00	38 x 10		123		223		
M 14 x 1.25	38 x 10		124		224		
M 14 x 1.50	38 x 10		125		225		125
M 15 x 1.00	38 x 10		126				
M 15 x 1.50	38 x 10		127				
M 16 x 1.00	45 x 14		128		228		
M 16 x 1.50	45 x 14		129		229		129
M 18 x 1.00	45 x 14		130				
M 18 x 1.50	45 x 14		131		231		131
M 18 x 2.00	45 x 14		132				
M 20 x 1.00	45 x 14		133		233		

d <sub>1</sub> x P mm	d <sub>2</sub> x l <sub>1</sub> mm	ATORN®		HFW		ATORN®	
		15220	...	15221	...	15219	...
M 20 x 1.50	45 x 14			134		234	134
M 20 x 2.00	45 x 14			135			
M 22 x 1.00	55 x 16			136			
M 22 x 1.50	55 x 16			137		237	137
M 22 x 2.00	55 x 16			138			
M 24 x 1.00	55 x 16			139			
M 24 x 1.50	55 x 16			140		240	140
M 24 x 2.00	55 x 16			141			
M 25 x 1.50	55 x 16			142			
M 26 x 1.50	55 x 16			143			
M 27 x 1.50	65 x 18			144			
M 27 x 2.00	65 x 18			145			
M 28 x 1.50	65 x 18			146			
M 30 x 1.00	65 x 18			147			
M 30 x 1.50	65 x 18			148			148
M 30 x 2.00	65 x 18			149			
M 32 x 1.50	65 x 18			150			
M 33 x 1.50	65 x 18			151			
M 33 x 2.00	65 x 18			152			
M 34 x 1.50	65 x 18			153			
M 36 x 1.50	65 x 18			154			
M 36 x 2.00	65 x 18			155			
M 36 x 3.00	65 x 25			156			
M 38 x 1.50	75 x 20			157			
M 40 x 1.50	75 x 20			158			
M 42 x 1.50	75 x 20			159			
M 45 x 1.50	90 x 22			160			
M 48 x 1.50	90 x 22			161			
M 50 x 1.50	90 x 22			162			
M 52 x 1.50	90 x 22			163			

15222

Die DIN EN 22 568

BSW

HSS



**ATORN®**

Design

- Closed (pre-slotted)
- With spiral point for ultra-easy, clean cuts and improved surface quality
- Right cutting
- Approx. 1.75-threaded chamfer

Applications

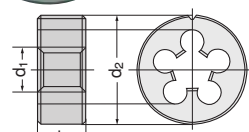
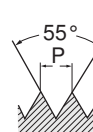
For Whitworth thread BS 84. For materials, steel up to approx. 800 N/mm<sup>2</sup> strength.

Quality

HSS.



15222



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

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

d <sub>1</sub>	P TPI	d <sub>2</sub> x l <sub>1</sub> mm	15222	...
BSW 7/8	9	55 x 22		109
BSW 1	8	55 x 22		110



## Die

### 15233 - 15234 Die DIN EN 24 231 G HSS

#### Design

- Closed (pre-slotted)
- **With spiral point** for ultra-easy, clean cuts and improved surface quality
- Right cutting
- Approx. 1.75-threaded chamfer

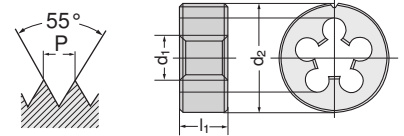


15233

#### Applications

For **cylindrical Whitworth pipe threads**  
DIN ISO 228.  
For materials **up to approx. 800 N/mm<sup>2</sup>** strength.

Quality  
HSS.



d <sub>1</sub>	P TPI	d <sub>2</sub> x l <sub>1</sub> mm	ATORN®			H/W		
			15233	...	15234	...	15234	...
Thread 1/8	28	30 x 11					101	101
Thread 1/4	19	38 x 10					102	102
Thread 3/8	19	45 x 14					103	103
Thread 1/2	14	45 x 14					104	104
Thread 5/8	14	55 x 16					105	

d <sub>1</sub>	P TPI	d <sub>2</sub> x l <sub>1</sub> mm	ATORN®			H/W		
			15233	...	15234	...	15234	...
Thread 3/4	14	55 x 16					106	106
Thread 7/8	14	65 x 18					107	
Thread 1.	11	65 x 18					108	108
Thread 1.1/4	11	75 x 20					109	
Thread 1.1/2	11	90 x 22					111	

### 15314 - 15316 Die DIN EN 22 568 UNC UNF HSS



#### Design

- Closed (pre-slotted)
- **From UNC/UNF no. 5 with spiral point** for ultra-easy, clean cuts and improved surface quality
- Right cutting
- Approx. 1.75-threaded chamfer

15314  
Design  
Unified coarse thread UNC.

15316  
Design  
Unified fine thread UNF.

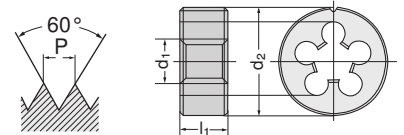


15314

#### Applications

For **American standard threads UNC, UNF**. For materials **up to approx. 800 N/mm<sup>2</sup>** strength.

Quality  
HSS.



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

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