

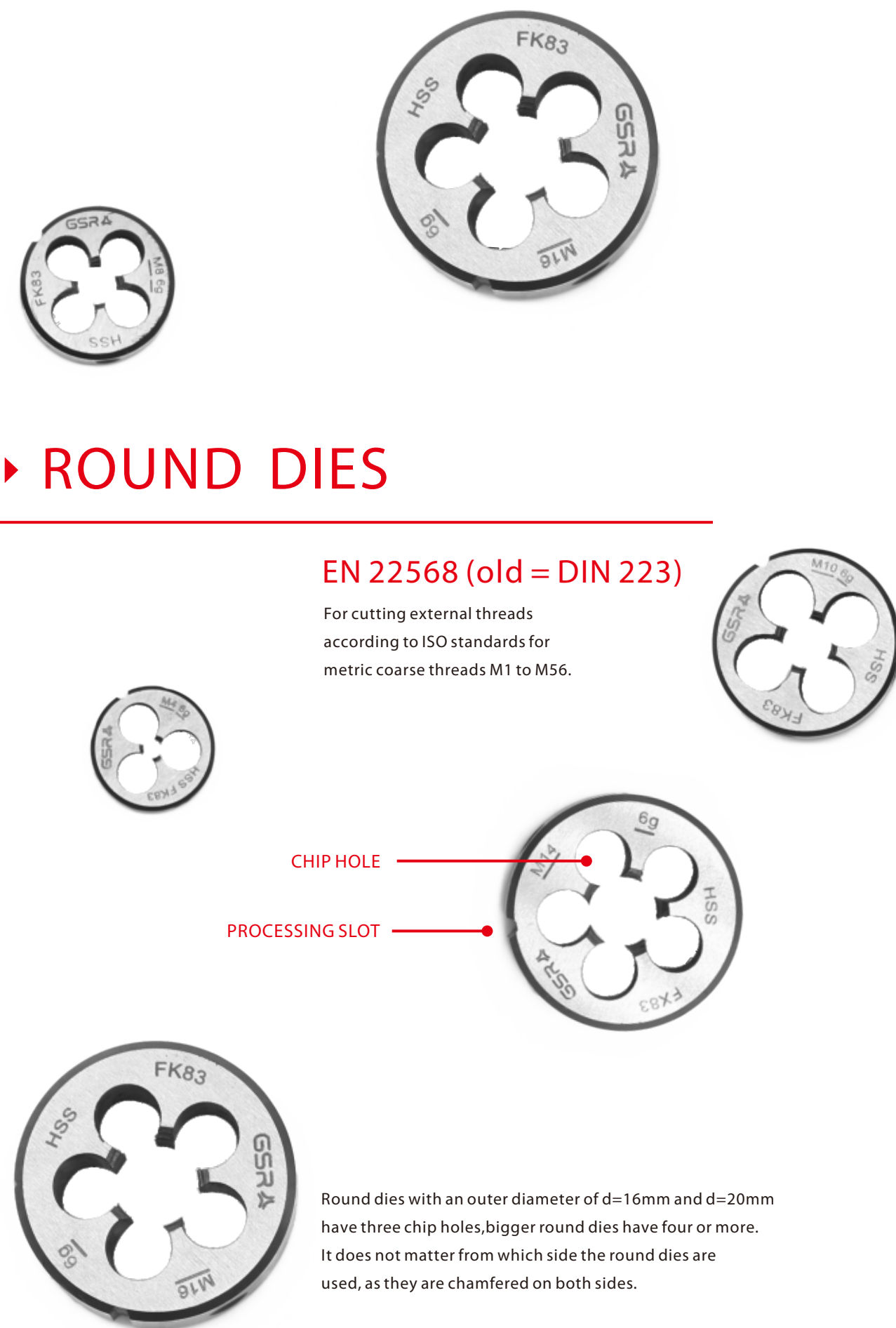
EN 22568

GSR FACTORY STANDARD

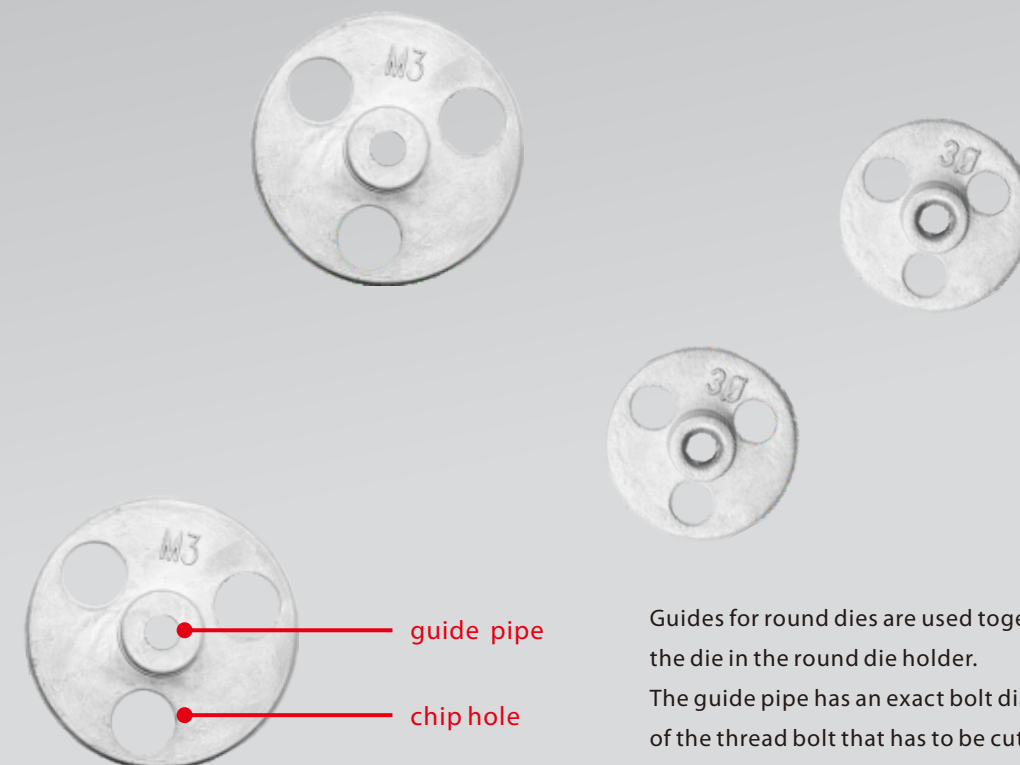
▶ ROUND DIES

EN 22568 (old = DIN 223)

For cutting external threads according to ISO standards for metric coarse threads M1 to M56.



Round dies with an outer diameter of $d=16\text{mm}$ and $d=20\text{mm}$ have three chip holes, bigger round dies have four or more. It does not matter from which side the round dies are used, as they are chamfered on both sides.



Guides for round dies are used together with the die in the round die holder. The guide pipe has an exact bolt diameter of the thread bolt that has to be cut.

▶ ROUND DIE GUIDES

GSR FACTORY STANDARD

Thus, the first cut is done perpendicular and the thread flanks are cut evenly. Die guides are die casted from zinc and have integrated chip holes to enable a good chip removal.



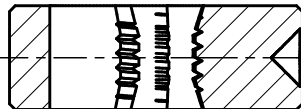
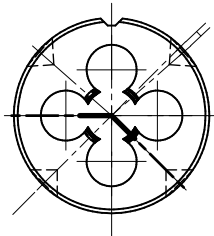
THREADING DIES



ROUND DIE



*Inquiry of excluded sizes in this manual is welcome.



Standard	DIN EN 22568 (DIN 223)
Material	HSS
Range	6g
Direction	M/MF 1-M/MF 52
Tolerance	right hand
Function	external threads cutting
Feature	Form B, chamfered from both sizes

Art.No.					
1030101020001	M 1	0.25	16	5	0.97
1030101020002	M 1,1	0.25	16	5	1.07
1030101020003	M 1,2	0.25	16	5	1.17
1030101020004	M 1,4	0.3	16	5	1.36
1030101020005	M 1,6	0.35	16	5	1.54
1030101020006	M 1,7	0.35	16	5	1.66
1030101020007	M 1,8	0.35	16	5	1.74
1030101020008	M 2	0.4	16	5	1.94
1030101020009	M 2,2	0.45	16	5	2.13
1030101020010	M 2,3	0.4	16	5	2.25
1030101020011	M 2.5	0.45	16	5	2.43
1030101020012	M 2.6	0.45	16	5	2.54
1030101020013	M 3	0.5	16	5	2.92
1030101020014	M 3.5	0.6	16	5	3.41
1030101020015	M 4	0.7	16	5	3.91
1030101020016	M 4.5	0.75	20	7	4.41
1030101020017	M 5	0.8	20	7	4.9

Art.No.					
1030101020018	M 5.5	0.9	20	7	5.4
1030101020019	M 6	1	20	7	5.88
1030101020020	M 7	1	25	9	6.88
1030101020021	M 8	1.25	25	9	7.87
1030101020022	M 9	1.25	25	9	8.87
1030101020023	M 10	1.5	30	11	9.85
1030101020024	MF 10x1.25	1.25	30	11	9.87
1030101020025	M 11	1.5	30	11	10.85
1030101020026	M 12	1.75	38	14	11.83
1030101020027	M 12x1.25	1.25	38	10	11.87
1030101020028	M 12x1.5	1.5	38	10	11.85
1030101020029	M 14	2	38	14	13.82
1030101020030	MF 14x1.25	1.25	38	10	13.87
1030101020031	MF 14x1.5	1.5	38	10	13.85
1030101020032	M 15	2	38	14	14.82
1030101020033	M 16	2	45	18	15.82
1030101020034	MF 16x1.25	1.25	45	14	15.86
1030101020035	MF 16x1.5	1.5	45	14	15.85
1030101020036	M 18	2.5	45	18	17.79
1030101020048	MF 18 x 1,25	1.25	45	14	17.86
1030101020049	MF 18 x 1,5	1.5	45	14	17.85
1030101020050	MF 18 x 2	2	45	14	17.82
1030101020037	M 20	2.5	45	18	19.79
1030101020051	MF 20 x 1,25	1.25	45	14	19.86
1030101020052	MF 20 x 1,5	1.5	45	14	19.85
1030101020053	MF 20 x 2	2	45	14	19.82
1030101020038	M 22	2.5	55	22	21.79
1030101020054	MF 22 x 1,25	1.25	55	16	21.86
1030101020055	MF 22 x 1,5	1.5	55	16	21.85

THREADING DIES

Art.No.					
1030101020056	MF 22 x 2	2	55	16	21.82
1030101020039	M 24	3	55	22	23.77
1030101020057	MF 24 x 1,25	1.25	55	16	23.86
1030101020058	MF 24 x 1,5	1.5	55	16	23.85
1030101020059	MF 24 x 2	2	55	16	23.82
1030101020040	M 27	3	65	25	26.77
1030101020060	MF 27 x 1,5	1.5	65	18	26.85
1030101020061	MF 27 x 2	2	65	18	26.82
1030101020041	M 30	3.5	65	25	29.73
1030101020062	MF 30 x 1,5	1.5	65	18	29.85
1030101020063	MF 30 x 2	2	65	18	29.82
1030101020064	MF 30 x 3	3	65	18	29.76
1030101020042	M 33	3.5	65	25	32.73
1030101020065	MF 33 x 1,5	1.5	65	18	32.85
1030101020066	MF 33 x 2	2	65	18	32.82
1030101020067	MF 33 x 3	3	65	18	32.76
1030101020043	M 36	4	65	25	35.7
1030101020068	MF 36 x 1,5	1.5	65	18	35.85
1030101020069	MF 36 x 2	2	65	18	35.82
1030101020070	MF 36 x 3	3	65	18	35.76
1030101020044	M 39	4	75	30	38.7
1030101020071	MF 39 x 1,5	1.5	75	20	38.85
1030101020072	MF 39 x 2	2	75	20	38.82
1030101020073	MF 39 x 3	3	75	20	38.76
1030101020045	M 42	4.5	75	30	41.69
1030101020074	MF 42 x 1,5	1.5	75	20	41.85
1030101020075	MF 42 x 2	2	75	20	41.82
1030101020076	MF 42 x 3	3	75	20	41.76
1030101020046	M 45	4.5	90	36	44.69



Art.No.					
1030101020077	MF 45 x 1,5	1.5	90	22	44.85
1030101020078	MF 45 x 2	2	90	22	44.82
1030101020079	MF 45 x 3	3	90	22	44.76
1030101020080	M 48	5	90	36	47.66
1030101020081	MF 48 x 1,5	1.5	90	22	47.85
1030101020082	MF 48 x 2	2	90	22	47.82
1030101020083	MF 48 x 3	3	90	22	47.76
1030101020084	MF 48 x 4	4	90	22	47.68
1030101020047	M 52	5	90	36	51.66
1030101020085	MF 52 x 1,5	1.5	90	22	51.85
1030101020086	MF 52 x 2	2	90	22	51.82
1030101020087	MF 52 x 3	3	90	22	51.76
1030101020088	MF 52 x 4	4	90	22	51.68

