



20 x 5 mm



20 x 5 mm



55 x 22 mm

# ▶ ROUND DIES



20 x 7 mm



20 x 7 mm

## EN 22568 (old = DIN 223)

For cutting external threads according to ISO standards for metric coarse threads M1 to M56, pre-slit round dies (form B) are used.

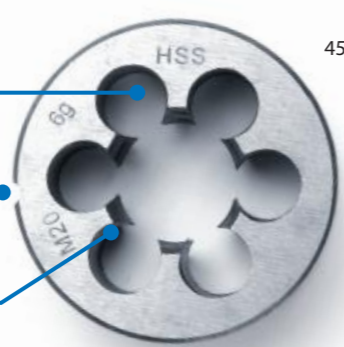


38 x 14 mm

CHIP HOLE

FORM B  
= pre-slit

SPIRAL POINT

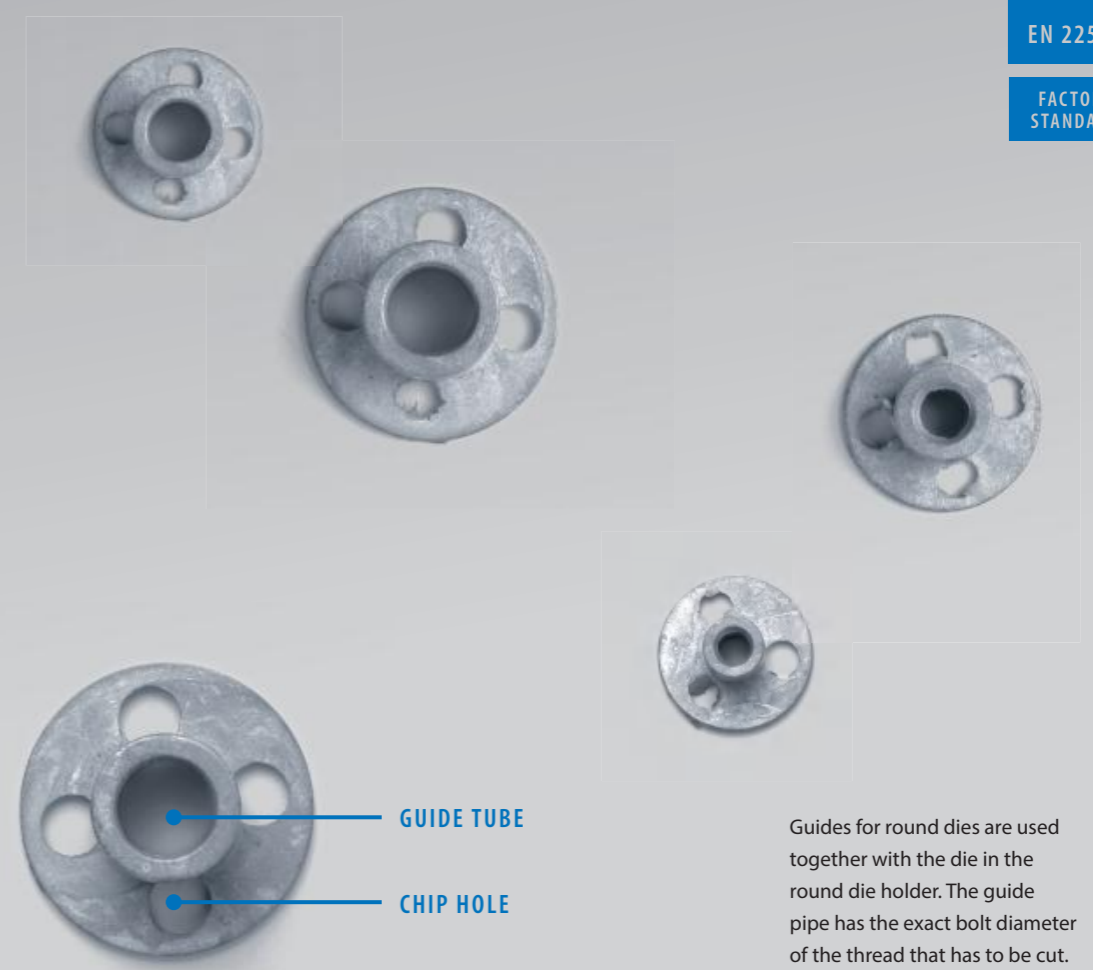
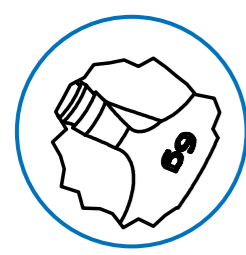
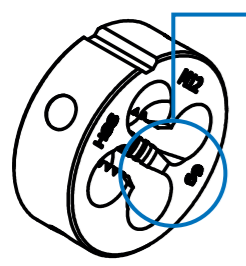


45 x 18 mm



65 x 25 mm

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



GUIDE TUBE

CHIP HOLE

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

# ▶ ROUND DIE GUIDES

## FACTORY STANDARD

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



ROUND DIES

TECHNICAL INFORMATION



Standard	DIN EN 22568 (DIN 223)	Direction	Right
Thread	M	Tolerance	6g
Material	HSS	Form	Form B
Raw material	Steel		

Round die, with spiral point

					Art.-No.
M 1	0,25	0,97	16	5	00402010
M 1,1	0,25	1,07	16	5	00402020
M 1,2	0,25	1,17	16	5	00402030
M 1,4	0,30	1,36	16	5	00402040
M 1,6	0,35	1,54	16	5	00402050
M 1,7	0,35	1,66	16	5	00402060
M 1,8	0,35	1,74	16	5	00402070
M 2	0,40	1,94	16	5	00402080
M 2,2	0,45	2,13	16	5	00402090
M 2,3	0,40	2,25	16	5	00402100
M 2,5	0,45	2,43	16	5	00402110
M 2,6	0,45	2,54	16	5	00402120
M 3	0,5	2,92	20	5	00402130
M 3,5	0,60	3,41	20	5	00402140
M 4	0,7	3,91	20	5	00402150
M 4,5	0,75	4,41	20	7	00402160
M 5	0,8	4,9	20	7	00402170
M 5,5	0,9	5,4	20	7	00402180
M 6	1,0	5,88	20	7	00402190
M 7	1,0	6,88	25	9	00402200
M 8	1,25	7,87	25	9	00402210
M 9	1,25	8,87	25	9	00402220
M 10	1,5	9,85	30	11	00402230
M 11	1,5	10,85	30	11	00402240
M 12	1,75	11,83	38	14	00402250
M 14	2,0	13,82	38	14	00402260
M 15	2	14,82	38	14	00402265
M 16	2,0	15,82	45	18	00402270
M 18	2,5	17,79	45	18	00402280
M 20	2,5	19,79	45	18	00402290
M 22	2,5	21,79	55	22	00402300
M 24	3,0	23,77	55	22	00402310
M 27	3,0	26,77	65	25	00402320
M 30	3,5	29,73	65	25	00402330
M 33	3,5	32,73	65	25	00402340
M 36	4,0	35,7	65	25	00402350

					Art.-No.
M 39	4,0	38,70	75	30	00402360
M 42	4,5	41,69	75	30	00402370
M 45	4,5	44,69	90	36	00402380
M 48	5,0	47,66	90	36	00402390
M 52	5,0	51,66	90	36	00402400
M 56	5,5	55,62	105	36	00402410
M 60	5,5	59,62	105	36	00402420
M 64	6,0	63,58	105	36	00402430

ROUND DIES LH

TECHNICAL INFORMATION



Standard	DIN EN 22568 (DIN 223)	Direction	Left
Thread	M	Tolerance	6g
Material	HSS	Form	Form B
Raw material	Steel		

Round die, with spiral point

					Art.-No.
M 2	0,4	1,94	16	5	00404080
M 3	0,5	2,92	20	5	00404130
M 3,5	0,6	3,41	20	5	00404140
M 4	0,7	3,91	20	5	00404150
M 4,5	0,75	4,41	20	7	00404160
M 5	0,8	4,9	20	7	00404170
M 6	1,0	5,88	20	7	00404190
M 7	1,0	6,88	25	9	00404200
M 8	1,25	7,87	25	9	00404210
M 9	1,25	8,87	25	9	00404220
M 10	1,5	9,85	30	11	00404230
M 12	1,75	11,83	38	14	00404250
M 14	2,0	13,82	38	14	00404260
M 16	2,0	15,82	45	18	00404270
M 18	2,5	17,79	45	18	00404280
M 20	2,5	19,79	45	18	00404290
M 22	2,5	21,79	55	22	00404300
M 24	3,0	23,77	55	22	00404310
M 27	3,0	26,77	65	25	00404320
M 30	3,5	29,73	65	25	00404330
M 33	3,5	32,73	65	25	00404340
M 36	4,0	35,7	65	25	00404350

					Art.-No.
M 39	4,0	38,7	75	30	00404360
M 42	4,5	41,69	75	30	00404370
M 45	4,5	44,69	90	36	00404380
M 48	5,0	47,66	90	36	00404390
M 52	5,0	51,66	90	36	00404400

ROUND DIES



TECHNICAL INFORMATION

Standard	DIN EN 22568 (DIN 223)	Direction	Right
Thread	M	Tolerance	6g
Material	HSS-E	Form	Form B
Raw material	Stainlees steel		

Round die, with spiral point

					Art.-No.
M 3	0,5	2,92	20	5	00406130
M 3,5	0,6	3,41	20	5	00406140
M 4	0,7	3,91	20	5	00406150
M 4,5	0,75	4,41	20	7	00406160
M 5	0,8	4,9	20	7	00406170
M 6	1,0	5,88	20	7	00406190
M 7	1,0	6,88	25	9	00406200
M 8	1,25	7,87	25	9	00406210
M 9	1,25	8,87	25	9	00406220
M 10	1,5	9,85	30	11	00406230
M 12	1,75	11,83	38	14	00406250
M 14	2,0	13,82	38	14	00406260
M 16	2,0	15,82	45	18	00406270
M 18	2,5	17,79	45	18	00406280
M 20	2,5	19,79	45	18	00406290
M 22	2,5	21,79	55	22	00406300
M 24	3,0	23,77	55	22	00406310
M 27	3,0	26,77	65	25	00406320
M 30	3,5	29,73	65	25	00406330
M 33	3,5	32,73	65	25	00406340
M 36	4,0	35,7	65	25	00406350
M 39	4,0	38,7	75	30	00406360
M 42	4,5	41,69	75	30	00406370
M 45	4,5	44,69	90	36	00406380
M 48	5,0	47,66	90	36	00406390
M 52	5,0	51,66	90	36	00406400

ROUND DIES



TECHNICAL INFORMATION

Standard	DIN EN 22568 (DIN 223)	Direction	Right
Thread	M	Tolerance	6g
Material	HSSE-VAP	Form	Form B
Raw material	Stainlees steel		

Round die, with spiral point, vaporised

					Art.-No.
M 3	0,5	2,92	20	5	00409130
M 3,5	0,6	3,41	20	5	00409140
M 4	0,7	3,91	20	5	00409150
M 4,5	0,75	4,41	20	7	00409160
M 5	0,8	4,9	20	7	00409170
M 6	1,0	5,88	20	7	00409190
M 7	1,0	6,88	25	9	00409200
M 8	1,25	7,87	25	9	00409210
M 9	1,25	8,87	25	9	00409220
M 10	1,5	9,85	30	11	00409230
M 12	1,75	11,83	38	14	00409250
M 14	2,0	13,82	38	14	00409260
M 16	2,0	15,82	45	18	00409270
M 18	2,5	17,79	45	18	00409280
M 20	2,5	19,79	45	18	00409290
M 22	2,5	21,79	55	22	00409300
M 24	3,0	23,77	55	22	00409310
M 27	3,0	26,77	65	25	00409320
M 30	3,5	29,73	65	25	00409330
M 33	3,5	32,73	65	25	00409340
M 36	4,0	35,7	65	25	00409350
M 39	4,0	38,7	75	30	00409360
M 42	4,5	41,69	75	30	00409370
M 45	4,5	44,69	90	36	00409380
M 48	5,0	47,66	90	36	00409390
M 52	5,0	51,66	90	36	00409400

ROUND DIES

TECHNICAL INFORMATION



Standard	DIN EN 22568 (DIN 223)	Direction	Right
Thread	MF	Tolerance	6g
Material	HSS	Form	Form B
Raw material	Steel		

Round die, with spiral point

					Art.-No.
MF 2 × 0,25	0,25	1,97	16	5	00414100
MF 3 × 0,35	0,35	2,94	20	5	00414200
MF 3 × 0,5	0,5	2,93	20	5	00414210
MF 3,5 × 0,35	0,35	3,44	20	5	00414220
MF 3,5 × 0,5	0,5	3,43	20	5	00414225
MF 4 × 0,35	0,35	3,94	20	5	00414230
MF 4 × 0,5	0,5	3,93	20	5	00414240
MF 4,5 × 0,5	0,5	4,43	20	5	00414260
MF 5 × 0,5	0,5	4,93	20	5	00414280
MF 5 × 0,75	0,75	4,91	20	5	00414290
MF 5,5 × 0,5	0,5	5,43	20	5	00414300
MF 5,5 × 0,75	0,75	5,41	20	5	00414310
MF 6 × 0,5	0,5	5,93	20	5	00414320
MF 6 × 0,75	0,75	5,91	20	7	00414330
MF 7 × 0,75	0,75	6,91	25	9	00414360
MF 8 × 0,5	0,5	7,93	25	9	00414380
MF 8 × 0,75	0,75	7,91	25	9	00414390
MF 8 × 1	1,0	7,88	25	9	00414400
MF 8 × 1,5	1,5	7,85	25	9	00414410
MF 9 × 0,75	0,75	8,91	25	9	00414430
MF 9 × 1	1,0	8,88	25	9	00414440
MF 10 × 0,5	0,5	9,93	30	11	00414450
MF 10 × 0,75	0,75	9,91	30	11	00414460
MF 10 × 1	1,0	9,88	30	11	00414470
MF 10 × 1,25	1,25	9,87	30	11	00414480
MF 11 × 0,75	0,75	10,91	30	11	00414500
MF 11 × 1	1,0	10,88	30	11	00414510
MF 11 × 1,25	1,25	10,87	30	11	00414520
MF 12 × 0,5	0,5	11,93	38	10	00414530
MF 12 × 0,75	0,75	11,91	38	10	00414540
MF 12 × 1	1,0	11,88	38	10	00414550
MF 12 × 1,25	1,25	11,87	38	10	00414560
MF 12 × 1,5	1,5	11,85	38	10	00414570
MF 13 × 1	1,0	12,88	38	10	00414600
MF 13 × 1,25	1,25	12,87	38	10	00414610
MF 13 × 1,5	1,5	11,5	38	10	00414620

					Art.-No.
MF 14 × 0,5	0,5	13,93	38	10	00414630
MF 14 × 0,75	0,75	13,91	38	10	00414640
MF 14 × 1	1,0	13,88	38	10	00414650
MF 14 × 1,25	1,25	13,87	38	10	00414660
MF 14 × 1,5	1,5	13,85	38	10	00414670
MF 15 × 1	1,0	14,88	38	10	00414700
MF 15 × 1,5	1,5	14,85	38	10	00414720
MF 16 × 0,5	0,5	15,93	45	14	00414730
MF 16 × 0,75	0,75	15,98	45	14	00414740
MF 16 × 1	1,0	15,88	45	14	00414750
MF 16 × 1,25	1,25	15,86	45	14	00414760
MF 16 × 1,5	1,5	15,85	45	14	00414770
MF 17 × 1	1,0	16,88	45	14	00414790
MF 17 × 1,5	1,5	16,85	45	14	00414800
MF 18 × 0,5	0,5	17,93	45	14	00414820
MF 18 × 1	1,0	17,88	45	14	00414840
MF 18 × 1,25	1,25	17,86	45	14	00414850
MF 18 × 1,5	1,5	17,85	45	14	00414860
MF 18 × 2	2,0	17,82	45	14	00414870
MF 19 × 1	1,0	18,88	45	14	00414880
MF 19 × 1,5	1,5	18,85	45	14	00414890
MF 20 × 0,5	0,5	19,93	45	14	00414910
MF 20 × 0,75	0,75	19,91	45	14	00414920
MF 20 × 1	1,0	19,88	45	14	00414930
MF 20 × 1,25	1,25	19,86	45	14	00414940
MF 20 × 1,5	1,5	19,85	45	14	00414950
MF 20 × 2	2,0	19,82	45	14	00414960
MF 21 × 1,5	1,5	20,85	55	16	00415000
MF 22 × 1	1,0	21,88	55	16	00415030
MF 22 × 1,25	1,25	21,86	55	16	00415040
MF 22 × 1,5	1,5	21,85	55	16	00415050
MF 22 × 2	2,0	21,82	55	16	00415060
MF 23 × 1	1,0	22,88	55	16	00415070
MF 23 × 1,5	1,5	22,85	55	16	00415080
MF 24 × 1	1,0	23,88	55	16	00415110
MF 24 × 1,25	1,25	23,86	55	16	00415120
MF 24 × 1,5	1,5	23,85	55	16	00415130
MF 24 × 2	2,0	23,82	55	16	00415140
MF 25 × 1	1,0	24,88	55	16	00415150
MF 25 × 1,5	1,5	24,85	55	16	00415170
MF 25 × 2	2,0	24,82	55	16	00415180
MF 26 × 1	1,0	25,88	55	16	00415190
MF 26 × 1,5	1,5	25,85	55	16	00415210
MF 26 × 2	2,0	25,82	55	16	00415220

EXTERNAL THREADS

					Art.-No.
MF 27 × 1	1,0	26,88	65	18	00415230
MF 27 × 1,5	1,5	26,85	65	18	00415240
MF 27 × 2	2,0	26,82	65	18	00415250
MF 28 × 1	1,0	27,88	65	18	00415260
MF 28 × 1,5	1,5	27,85	65	18	00415270
MF 28 × 2	2,0	27,82	65	18	00415280
MF 30 × 1	1,0	29,88	65	18	00415290
MF 30 × 1,5	1,5	29,85	65	18	00415300
MF 30 × 2	2,0	29,82	65	18	00415310
MF 30 × 3	3,0	29,76	65	25	00415320
MF 32 × 1	1,0	31,88	65	18	00415330
MF 32 × 1,5	1,5	31,85	65	18	00415340
MF 32 × 2	2,0	31,82	65	18	00415350
MF 33 × 1	1,0	32,88	65	18	00415370
MF 33 × 1,5	1,5	32,85	65	18	00415380
MF 33 × 2	2,0	32,82	65	18	00415390
MF 33 × 3	3,0	32,76	65	25	00415400
MF 34 × 1	1,0	33,88	65	18	00415410
MF 34 × 1,5	1,5	33,85	65	18	00415420
MF 34 × 2	2,0	33,82	65	18	00415430
MF 35 × 1	1,0	34,88	65	18	00415450
MF 35 × 1,5	1,5	34,85	65	18	00415460
MF 35 × 2	2,0	34,82	65	18	00415470
MF 36 × 1	1,0	35,88	65	18	00415490
MF 36 × 1,5	1,5	35,85	65	18	00415500
MF 36 × 2	2,0	35,82	65	18	00415510
MF 36 × 3	3,0	35,76	65	25	00415520
MF 38 × 1	1,0	37,88	75	20	00415530
MF 38 × 1,5	1,5	37,85	75	20	00415540
MF 38 × 2	2,0	37,82	75	20	00415550
MF 38 × 3	3,0	37,76	75	20	00415560
MF 39 × 1,5	1,5	38,85	75	20	00415570
MF 39 × 2	2,0	38,82	75	20	00415580
MF 39 × 3	3,0	38,76	75	30	00415590
MF 40 × 1	1,0	39,88	75	20	00415600
MF 40 × 1,5	1,5	39,85	75	20	00415610
MF 40 × 2	2,0	39,82	75	20	00415620
MF 40 × 3	3,0	39,76	75	30	00415630
MF 42 × 1,5	1,5	41,85	75	20	00415640
MF 42 × 2	2,0	41,82	75	20	00415650
MF 42 × 3	3,0	41,76	75	30	00415660
MF 45 × 1	1,0	44,88	90	22	00415680
MF 45 × 1,5	1,5	44,85	90	22	00415690
MF 45 × 2	2,0	44,82	90	22	00415700

					Art.-No.
MF 45 × 3	3,0	44,76	90	36	00415710
MF 48 × 1,5	1,5	47,85	90	22	00415740
MF 48 × 2	2,0	47,82	90	22	00415750
MF 48 × 3	3,0	47,76	90	36	00415760
MF 48 × 4	4,0	47,68	90	36	00415770
MF 50 × 1	1,0	49,88	90	22	00415780
MF 50 × 1,5	1,5	49,85	90	22	00415790
MF 50 × 2	2,0	49,82	90	22	00415800
MF 50 × 3	3,0	49,76	90	36	00415810
MF 52 × 1,5	1,5	51,85	90	22	00415840
MF 52 × 2	2,0	51,82	90	22	00415850
MF 52 × 3	3,0	51,76	90	36	00415860
MF 52 × 4	4,0	51,68	90	36	00415870

EXTERNAL THREADS

ROUND DIES LH



TECHNICAL INFORMATION

Standard	DIN EN 22568 (DIN 223)	Direction	Left
Thread	MF	Tolerance	6g
Material	HSS	Form	Form B
Raw material	Steel		

Round die, with spiral point

					Art.-No.
MF 4 × 0,5	0,5	3,93	20	5	00417240
MF 5 × 0,5	0,5	4,93	20	5	00417280
MF 6 × 0,5	0,5	5,93	20	5	00417320
MF 6 × 0,75	0,75	5,91	20	7	00417330
MF 7 × 0,75	0,75	6,91	25	9	00417360
MF 8 × 0,5	0,5	7,93	25	9	00417380
MF 8 × 0,75	0,75	7,91	25	9	00417390
MF 8 × 1	1,0	7,88	25	9	00417400
MF 10 × 0,75	0,75	9,91	30	11	00417460
MF 10 × 1	1,0	9,88	30	11	00417470
MF 10 × 1,25	1,25	9,87	30	11	00417480
MF 12 × 1	1,0	11,88	38	10	00417550
MF 12 × 1,25	1,25	11,87	38	10	00417560
MF 12 × 1,5	1,5	11,85	38	10	00417570
MF 14 × 1	1,0	13,88	38	10	00417650
MF 14 × 1,25	1,25	13,87	38	10	00417660