01.005.005

Gewindetabelle

Thread identification chart

HOFMANN

IHR IMPULSGEBER

Metrisches Regelgewinde RH nach DIN13 und DIN14

Metric coarse thread RH according to DIN 13 and DIN 14

Name # (mm)	NennDM *Major Dia.* (mm)	KernDM Welle *Minor Dia.* (mm)	Steigung *Thread Pitch* (mm)	Bohrloch *Tap Drill Dia.* (mm)	Welle *Shaft Dia.* (mm)	Gewindetiefe *Depth* (mm)
M0.8_X_0.2	0.800	0.555	0.20	0.60	0.78	2.000
M1_X_0.25	1.000	0.730	0.25	0.75	0.98	3.000
M1.1_X_0.2	1.100	0.855	0.20	0.90	1.05	3.000
M1.4_X_0.2	1.400	1.155	0.20	1.20	1.35	3.000
M1.5_X_0.3	1.500	1.180	0.30	1.25	1.45	3.000
M1.6_X_0.2	1.600	1.355	0.20	1.40	1.55	6.000
M2_X_0.4	2.000	1.570	0.40	1.60	1.96	6.000
M2.5_X_0.45	2.500	2.070	0.45	2.06	2.45	6.000
M3_X_0.5	3.000	2.390	0.50	2.50	2.95	6.000
M3.5_X_0.5	3.500	2.829	0.50	3.01	3.35	6.000
M4_X_0.7	4.000	3.140	0.70	3.30	3.93	8.000
M4_X_0.7	für Variothermverschraubung			3.40		
M5_X_0.8	5.000	4.020	0.80	4.20	4.92	10.000
M6_X_1	6.000	4.770	1.00	5.00	5.90	12.000
M6_X_1	Auszugsgewinde Zentrierring			5.20		
M7_X_1	7.000	5.770	1.00	6.00	6.90	14.000
M7_X_1 (Kühlung)	7.000	5.770	1.00	6.02	6.90	14.000
M8_X_1.25	8.000	6.470	1.25	6.80	7.88	16.000
M9_X_1.25	9.000	7.470	1.25	7.80	8.88	18.000
M10_X_1.5	10.000	8.160	1.50	8.50	9.85	20.000
M10_X_1.5_Auszug	Auszugsgewinde Schraube M08			9.01		
M11_X_1.5	11.000	9.160	1.50	9.50	10.85	25.000
M12_X_1.75	12.000	9.850	1.75	10.20	11.83	30.000
M12_X_1.75_Auszug	Auszugsgewinde Schraube M10			11.01		
M14_X_2	14.000	11.550	2.00	12.00	13.80	34.000
M16_X_2	16.000	13.550	2.00	14.00	15.80	40.000
M18_X_2.5	18.00	14.930	2.50	15.50	17.75	40.000
M20_X_2.5	20.000	16.930	2.50	17.50	19.75	42.000
M22_X_2.5	22.00	18.930	2.50	19.50	21.75	45.000
M24_X_3	24.000	20.320	3.00	21.00	23.70	47.000
M27_X_3	27.000	23.319	3.00	24.00	26.65	55.000
M30_X_3.5	30.000	25.710	3.50	26.50	29.65	55.000
M36_X_4	36.000	31.090	4.00	32.00	35.60	70.000
M42_X_4.5	42.000	36.480	4.50	37.50	41.60	80.000
M45_X_4.5	45.000	39.480	4,50	40.60	44,60	80.000
M48_X_5	48.000	41.870	5.00	43.00	47.60	80.000
M56_X_5.5	56.000	49.250	5.50	50.50	55.60	100.000
M64_X_6	64.000	56.640	6.00	58.00	63.60	110.000

01.005.005

Gewindetabelle

Thread identification chart

HOFMANN

IHR IMPULSGEBER

Metrisches Feingewinde RH nach DIN13

Metric fine thread RH according to DIN 13

Name # (mm)	NennDM *Major Dia.* (mm)	KernDM Welle *Minor Dia.* (mm)	Steigung *Thread Pitch* (mm)	Bohrloch *Tap Drill Dia.* (mm)	Welle *Shaft Dia.* (mm)	Gewindetiefe *Depth* (mm)
FM2.3_X_0.25	2.300	2.030	0.25	2.05	2.28	6.000
FM2.5_X_0.35	2.500	2.071	0.35	2.10	2.44	6.000
FM3_X_0.35	3.000	2.571	0.35	2.60	2.94	6.000
FM3.5_X_0.35	3.500	3.121	0.35	3.20	3.40	6.000
FM3.5_X_0.6	3.500	2.764	0.60	2.90	3.34	6.000
FM4_X_0.50	4.000	3.450	0.50	3.50	3.95	8.000
FM5_X_0.50	5.000	4.450	0.50	4.50	4.95	10.000
FM6_X_0.75	6.000	5.080	0.75	5.30	5.95	12.000
FM8_X_0.75	8.000	6.891	0.75	7.20	7.90	15.000
FM8_X_1	8.000	6.770	1.00	7.00	7.95	15.000
FM9_X_1	9.000	7.773	1.00	8.02	8.90	16.000
FM10_X_1	10.000	8.770	1.00	9.00	9.90	18.000
FM10_X_1.25	10.000	8.470	1.25	8.65	9.88	18.000
FM11_X_1	11.000	9.770	1.00	10.02	10.90	18.000
FM12_X_1	12.000	10.770	1.00	11.00	11.90	18.000
FM12_X_1.25	12.000	10.470	1.25	10.70	11.88	18.000
FM12_X_1.5	12.000	10.344	1.50	10.50	11.85	18.000
FM14_X_1	14.000	12.770	1.00	13.00	13.90	20.000
FM14_X_1.5	14.000	12.344	1.50	12.50	13.85	20.000
FM16_X_1	16.000	14.770	1.00	15.00	15.90	26.000
FM16_X_1.5	16.000	14.344	1.50	14.50	15.85	26.000
FM18_X_1	18.000	16.770	1.00	17.00	17.90	28.000
FM18_X_1.5	18.000	16.344	1.50	16.50	17.85	28.000
FM20_X_1	20.000	18.770	1.00	18.90	19.90	30.000
FM20_X_1.5	20.000	18.344	1.50	18.50	19.85	30.000
FM22_X_1	22.000	20.773	1.00	20.95	21.90	30.000
FM22_X_1.5	22.000	20.160	1.50	20.50	21.85	30.000
FM24_X_1	24.000	22.773	1.00	23.00	23.90	30.000
FM24_X_1.5	24.000	22.344	1.50	22.50	23.85	30.000
FM24_X_2	24.000	21.546	2.00	22.00	23.80	30.000
FM25_X_1.5	25.000	23.160	1.50	23.50	24.85	30.000
FM26_X_1	26.000	24.770	1.00	25.00	25.90	30.000
FM26_X_1.5	26.000	24.160	1.50	24.45	25.85	30.000
FM27_X_1.5	27.000	25.160	1.50	25.50	26.85	40.000
FM27_X_2	27.000	24.546	2.00	24.95	26.80	40.000
FM28_X_1.5	28.000	26.160	1.50	26.55	27.85	40.000
FM30_X_1.5	30.000	28.160	1.50	28.50	29.85	40.000
FM30_X_2	30.000	27.546	2.00	28.00	29.80	40.000
FM32_X_1.5	32.000	30.160	1.50	30.50	31.85	40.000
FM33_X_2	33.000	30.546	2.00	31.05	32.80	40.000
FM35_X_1.5	35.000	33.160	1.50	33.50	34.85	46.000
FM36_X_2	36.000	33.550	2.00	34.00	35.80	50.000
FM36_X_3	36.000	33.320	3.00	33.00	35.70	60.000
FM38_X_1	38.000	36.770	1.00	37.00	37.91	60.000
FM38_X_1.5	38.000	36.160	1.50	36.50	37.85	20.000
FM40_X_1.5	40.000	38.160	1.50	38.50	39.85	60.000
FM42_X_1.5	42.000	40.160	1.50	40.50	41.85	63.000
FM42_X_2	42.000	39.546	2.00	40.00	41.80	63.000
FM45_X_1.5	45.000	43.160	1.50	43.50	44.85	65.000
FM45_X_2	45.000	42.550	2.00	43.20	44.80	65.000

01.005.005

Gewindetabelle

Thread identification chart

HOFMANN

IHR IMPULSGEBER

Metrisches Feingewinde RH nach DIN13

Metric fine thread RH according to DIN 13

Name # (mm)	NennDM *Major Dia.* (mm)	KernDM Welle *Minor Dia.* (mm)	Steigung *Thread Pitch* (mm)	Bohrloch *Tap Drill Dia.* (mm)	Welle *Shaft Dia.* (mm)	Gewindetiefe *Depth* (mm)
FM48_X_1.5	48.000	46.160	**1.50**	**46.50**	**47.85**	70.000
FM50_X_1	50.000	48.770	**1.00**	**49.00**	**49.90**	75.000
FM50_X_1.5	50.000	48.160	**1.50**	**48.50**	**49.85**	75.000
FM52_X_1.5	52.000	50.160	**1.50**	**50.45**	**51.85**	78.000
FM52_X_2	52.000	49.546	**2.00**	**50.00**	**51.80**	78.000
FM55_X_1.5	55.000	53.160	**1.50**	**53.50**	**54.85**	80.000
FM56_X_1.5	56.000	54.160	**1.50**	**54.50**	**55.85**	82.000
FM58_X_1.5	58.000	56.160	**1.50**	**56.50**	**57.85**	86.000
FM60_X_1.5	60.000	58.160	**1.50**	**58.50**	**59.85**	90.000
FM60_X_2	60.000	57.550	**2.00**	**57.95**	**59.80**	90.000
FM64_X_4	64.000	59.090	**4.00**	**60.00**	**63.70**	100.000
FM70_X_1.5	70.000	68.160	**1.50**	**68.50**	**69.85**	105.00
FM70_X_2	70.000	67.550	**2.00**	**68.00**	**69.80**	105.00
FM72_X_1.5	72.000	70.160	**1.50**	**70.50**	**71.85**	105.00
FM75_X_1.5	75.000	73.344	**1.50**	**73.54**	**74.73**	112.00
FM75_X_2	75.000	72.550	**2.00**	**73.00**	**74.80**	112.00
FM85_X_2	85.000	82.550	**2.00**	**83.00**	**84.80**	120.00
FM170_X_3	170.00	166.32	**3.00**	**167.0**	**169.7**	250.00

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Gewindetabelle

Thread identification chart

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IHR IMPULSGEBER

Metrisches Regelgewinde LH (Linksgewinde) nach DIN13

Metric coarse thread LH (left-hand) according to DIN 13

Name # **(mm)**	NennDM *Major Dia.* **(mm)**	KernDM Welle *Minor Dia.* **(mm)**	Steigung *Thread Pitch* **(mm)**	Bohrloch *Tap Drill Dia.* **(mm)**	Welle *Shaft Dia.* **(mm)**	Gewindetiefe *Depth* **(mm)**
M8_X_1.25_LH	8.000	6.470	**1.25**	**6.81**	**7.87**	16.000

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Gewindetabelle

Thread identification chart

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Zylindrisches Rohrgewinde nach DIN ISO 228

Cylindrical pipe thread according to DIN ISO 228

Name # **(mm)**	NennDM *Major Dia.* **(mm)**	KernDM Welle *Minor Dia.* **(mm)**	Steigung *Thread Pitch* **(mm)**	Bohrloch *Tap Drill Dia.* **(mm)**	Welle *Shaft Dia.* **(mm)**	Gewindetiefe *Depth* **(mm)**
G_1/8	9.73	8.57	**0.91**	**8.80**	**9.73**	10.000
G_1/4	13.16	11.45	**1.34**	**11.80**	**13.16**	14.000
G_3/8	16.66	14.95	**1.34**	**15.25**	**16.66**	18.000
G_1/2	20.96	18.63	**1.81**	**19.00**	**20.96**	22.000
G_5/8	22.91	20.60	**1.81**	**21.01**	**22.91**	25.000
G_3/4	26.44	24.12	**1.81**	**24.50**	**26.44**	30.000
G_7/8	30.20	27.87	**1.81**	**28.25**	**30.20**	30.000
G_1	33.25	30.29	**2.31**	**30.75**	**33.25**	30.000
G_1_1/8	37.90	34.94	**2.31**	**35.50**	**37.90**	30.000
G_1_1/4	41.91	38.95	**2.31**	**39.25**	**41.91**	30.000
G_1_1/2	47.80	44.90	**2.31**	**45.25**	**47.80**	30.000
G_2	59.61	56.66	**2.31**	**57.00**	**59.61**	60.000

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Gewindetabelle

Thread identification chart

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Grobes und feines Einheitsgewinde

Unified Coarse Thread + Unified Fine Thread

Name # **(mm)**	NennDM *Major Dia.* **(mm)**	KernDM Welle *Minor Dia.* **(mm)**	Steigung *Thread Pitch* **(mm)**	Bohrloch *Tap Drill Dia.* **(mm)**	Welle *Shaft Dia.* **(mm)**	Gewindetiefe *Depth* **(mm)**
1-64_UNC	1.85	1.37	**0.40**	**1.50**	**1.81**	6.000
2-56_UNC	2.18	1.63	**0.45**	**1.90**	**2.13**	6.000
3-48_UNC	2.52	1.87	**0.53**	**2.11**	**2.46**	6.000
4-40_UNC	2.85	2.07	**0.64**	**2.30**	**2.78**	6.000
5-40_UNC	3.18	2.40	**0.64**	**2.61**	**3.11**	6.000
6-32_UNC	3.51	2.54	**0.79**	**2.80**	**3.43**	6.000
8-32_UNC	4.12	3.16	**0.79**	**3.51**	**4.04**	8.000
10-24_UNC	4.83	3.53	**1.06**	**3.90**	**4.72**	10.000
12-24_UNC	5.49	4.19	**1.06**	**4.51**	**5.38**	10.000
1/4-20_UNC	6.35	4.80	**1.27**	**5.10**	**6.22**	12.000
5/16-18_UNC	7.94	6.21	**1.41**	**6.60**	**7.80**	14.000
3/8-16_UNC	9.53	7.60	**1.59**	**8.00**	**9.37**	18.000
7/16-14_UNC	11.11	8.89	**1.81**	**9.40**	**10.93**	20.000
1/2-13_UNC	12.70	10.31	**1.95**	**10.80**	**12.50**	25.000
9/16-12_UNC	14.29	11.70	**2.12**	**12.20**	**14.08**	30.000
5/8-11_UNC	15.88	13.05	**2.31**	**13.50**	**15.64**	35.000
3/4-10_UNC	19.05	15.95	**2.54**	**16.51**	**18.80**	40.000
7/8-9_UNC	22.23	18.76	**2.82**	**19.51**	**21.94**	45.000
1-8_UNC	25.40	21.50	**3.18**	**22.20**	**25.08**	45.000
1_1/8-7_UNC	28.58	24.15	**3.63**	**25.01**	**28.21**	50.000
1_1/4-7_UNC	31.75	27.40	**3.63**	**28.20**	**31.39**	55.000
1_3/8-6_UNC	34.93	29.75	**4.23**	**31.00**	**34.50**	60.000
1_1/2-6_UNC	38.10	32.91	**4.23**	**34.01**	**37.68**	65.000
1_3/4-5_UNC	44.45	38.22	**5.08**	**39.50**	**43.94**	75.000
2-4,5_UNC	50.80	43.90	**5.64**	**45.20**	**50.24**	80.000
2_1/4-4,5_UNC	57.15	50.25	**5.64**	**51.50**	**56.59**	100.000
2_1/2-4_UNC	63.50	55.80	**6.35**	**57.50**	**62.87**	110.000
2_3/4-4_UNC	69.85	62.10	**6.35**	**63.50**	**69.22**	115.000
3-4_UNC	76.20	68.50	**6.35**	**70.00**	**75.57**	120.000
3_1/4-4_UNC	82.55	74.90	**6.35**	**76.50**	**81.92**	130.000
3_1/2-4_UNC	88.90	81.20	**6.35**	**83.01**	**88.27**	140.000
10-32_UNF	4.83	3.85	**0.79**	**4.18**	**4.75**	15.000
1/4-28_UNF	6.34	5.56	**0.91**	**5.51**	**6.26**	15.000
5/16-24_UNF	7.94	6.64	**1.06**	**6.79**	**7.83**	20.000
3/4-16_UNF	19.05	17.10	**1.59**	**17.76**	**18.89**	30.000
7/8-14_UNF	22.23	19.99	**1.81**	**20.40**	**22.05**	30.000
1_7/16-12_UNF	36.51	32.36	**2.11**	**34.50**	**36.30**	50.000

01.005.005

Gewindetabelle
Thread identification chart

HOFMANN
IHR IMPULSGEBER

Gewindetabelle für Gewindeformer
Thread chart for roll form taps

Name # (mm)	NennDM *Major Dia.* (mm)	KernDM Welle *Minor Dia.* (mm)	Steigung *Thread Pitch* (mm)	Bohrloch *Tap Drill Dia.* (mm)	Welle *Shaft Dia.* (mm)	Gewindetiefe *Depth* (mm)
M2.5_X_0.45_umf	3.500	0.60	0.45	2.31	-	6.000
M3_X_0.5_umf	4.000	0.60	0.50	2.81	-	8.000
M4_X_0.7_umf	5.000	0.65	0.70	3.70	-	10.000
M5_X_0.8_umf	6.000	0.675	0.80	4.65	-	12.000
M6_X_1_umf	7.000	0.75	1.00	5.50	-	15.000
M8_X_1.25_umf	9.000	0.80	1.25	7.40	-	20.000
M10_X_1.5_umf	11.000	0.825	1.50	9.41	-	25.000
M12_X_1.75_umf	13.000	0.90	1.75	11.20	-	30.000
M16_X_2_umf	17.000	0.95	2.00	15.10	-	40.000

Zusatzinfo:

HSSE-PM synchronised fluteless machine tap with oil grooves

Special polygon geometry and shank to DIN 1835-B for machines with **synchronised spindle drive. With oil grooves; optimal lubrication effect even in deeper threads.**
The **innovative polygon form** permits a wide application spectrum.
The **multi-function layered coating** achieves **maximum service life** even in **high-tensile materials** in **fixed** applications.

13 9215 – **Form E** (lead-in: 1.5 – 2 turns) **for deep threads with short run-out.**
13 9230 – **With internal coolant supply laterally from the grooves; permits maximum tool life.**

Note: **For use on synchronised spindles,** the **GARANT** quick-change tapping chuck **No. 338100 – 8115 with minimum length adjustment (MLA)** ensures highest process reliability.

Suitable for/ v_c [m/min]	Alu plastics	Alu	Alu cast > 10 % Si	< 500 N	< 750 N	< 900 N	< 1100 N	< 1400 N	< 55 HRC	< 60 HRC	< 65 HRC	< 67 HRC	< 70 HRC	INOX < 900 N	INOX > 900 N	Ti > 850 N	CuZn	Uni					
ISO code	N	N	N	P	P	P	P	P	H	H	H	H	H	M	M	S	N						
13 9210/9215	45	45	40	45	37	35	32	22						22			35	●	●	●			
13 9230	48	48	45	50	42	40	37	27						22			40	●	●	●			

M	13 9210	13 9215	13 9230					
	Synchronised fluteless machine tap with oil grooves							
	HSS-E-PM Form C	HSS-E-PM Form E	HSS-E-PM internal cooling / Form C		L_{tot}			Guide value
	TiN	TiN	TiN	mm	mm	mm	mm	mm
M2,5	XXX	XXX	–	0.45	70	6	4.9	2.3
M3	XXX	XXX	–	0.5	70	6	4.9	2.8
M4	XXX	XXX	XXX	0.7	70	6	4.9	3.7
M5	XXX	XXX	XXX	0.8	70	6	4.9	4.65
M6	XXX	XXX	XXX	1	80	6	4.9	5.55
M8	XXX	XXX	XXX	1.25	90	8	6.2	7.45
M10	XXX	XXX	XXX	1.5	100	10	8	9.35
M12	XXX	XXX	XXX	1.75	110	12	9	11.2
M16	XXX	–	–	2	110	12	9	15.1

01.005.005

Gewindetabelle
Thread identification chart

HOFMANN
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Gewindetabelle für Trapezgewinde
Thread chart for trapezoidal coarse Thread

Name # **(mm)**	NennDM *Major Dia.* **(mm)**	KernDM Welle *Minor Dia.* **(mm)**	Steigung *Thread Pitch* **(mm)**	Bohrloch *Tap Drill Dia.* **(mm)**	Welle *Shaft Dia.* **(mm)**	Gewindetiefe *Depth* **(mm)**
Tr_8_x_1.5	**8.000**	**6.06**	**1.50**	**6.62**	**7.94**	**16.000**
Tr_9_x_1.5	9.000	7.06	**1.50**	**7.62**	8.94	18.000
Tr_9_x_2	9.000	6.35	**2.00**	**7.12**	8.92	18.000
Tr_10_x_1.5	10.000	8.06	**1.50**	**8.62**	9.94	20.000
Tr_10_x_2	10.000	7.35	**2.00**	**8.12**	9.92	20.000
Tr_11_x_2	11.000	8.35	**2.00**	**9.12**	10.92	25.000
Tr_11_x_5	11.000	7.33	**5.00**	**8.18**	10.88	25.000
Tr_12_x_2	12.000	9.34	**2.00**	**10.12**	11.92	30.000
Tr_12_x_3	12.000	8.32	**3.00**	**9.18**	11.86	30.000
Tr_14_x_2	14.000	11.34	**2.00**	**12.12**	13.92	34.000
Tr_14_x_3	14.000	10.32	**3.00**	**11.16**	13.88	34.000
Tr_16_x_2	16.000	13.34	**2.00**	**14.12**	15.92	40.000
Tr_16_x_4	16.000	11.29	**4.00**	**12.22**	15.86	40.000
Tr_18_x_2	18.000	15.34	**2.00**	**16.10**	17.92	40.000
Tr_18_x_4	18.000	13.29	**4.00**	**14.20**	17.86	40.000
Tr_20_x_2	20.000	17.34	**2.00**	**18.10**	19.92	42.000
Tr_20_x_4	20.000	15.29	**4.00**	**16.20**	19.86	42.000
Tr_22_x_3	22.000	18.32	**3.00**	**19.16**	21.88	45.000
Tr_22_x_5	22.000	16.27	**5.00**	**17.22**	21.84	45.000
Tr_24_x_3	24.000	20.30	**3.00**	**21.16**	23.88	47.000
Tr_24_x_5	24.000	18.26	**5.00**	**19.22**	23.84	47.000
Tr_26_x_3	26.000	22.30	**3.00**	**23.16**	25.88	55.000
Tr_26_x_5	26.000	20.26	**5.00**	**21.22**	25.84	55.000
Tr_28_x_3	28.000	24.30	**3.00**	**25.16**	27.88	55.000
Tr_28_x_5_	28.000	22.26	**5.00**	**23.22**	27.84	55.000
Tr_30_x_3	30.000	26.30	**3.00**	**27.16**	29.88	55.000
Tr_30_x_6	30.000	22.73	**6.00**	**24.24**	29.82	55.000