

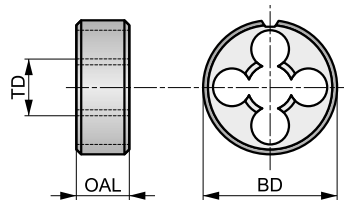


# F100



## HSS Gun Nosed Machine Die, Metric, Right Hand

Solid die for external thread. Generally for use on lathes, small diameters can be produced by hand with a die stock holder. The gun-nose will drive the chip ahead of the cutting edge, increasing performance. Bright finish lapped surface prevents the workpiece material from sticking and improves the threading action.



<b>M</b>	ISO <b>2568</b>	<b>6g</b>
<b>1.75</b> XP	HSS	<b>R</b>
Bright		

Workpiece material group suitability and starting values for cutting speed (m/min).

<b>P1.1</b> ■ 12	<b>P1.2</b> ■ 13	<b>P1.3</b> ■ 14	<b>P2.1</b> ■ 10	<b>P2.2</b> ■ 9	<b>P2.3</b> ▧ 8	<b>P3.1</b> ■ 8	<b>P3.2</b> ▧ 7	<b>P4.1</b> ▧ 5	<b>M1.1</b> ■ 7	<b>M1.2</b> ■ 6	<b>M2.1</b> ■ 6	<b>M2.2</b> ▧ 5	<b>K1.1</b> ■ 11
<b>K1.2</b> ■ 8	<b>K1.3</b> ▧ 6	<b>K2.1</b> ■ 11	<b>K2.2</b> ■ 9	<b>K2.3</b> ▧ 7	<b>K3.1</b> ■ 10	<b>K3.2</b> ■ 8	<b>K3.3</b> ▧ 6	<b>K5.1</b> ■ 10	<b>K5.2</b> ■ 8	<b>K5.3</b> ▧ 6	<b>N1.1</b> ▧ 20	<b>N1.2</b> ▧ 15	<b>N1.3</b> ▧ 10
<b>N2.1</b> ▧ 10	<b>N2.2</b> ▧ 9	<b>N2.3</b> ▧ 6	<b>N3.1</b> ■ 11	<b>N3.2</b> ▧ 6	<b>N3.3</b> ▧ 3	<b>N4.1</b> ▧ 11	<b>N4.2</b> ▧ 4	<b>N4.3</b> ▧ 4					

Products from this series are also available in set with taps. Please see L120.

Product	TD [mm]	TP [mm]	BD [mm]	OAL [mm]
<b>F100M2</b> <sup>1)</sup>	2.000	0.40	16.00	5.0
<b>F100M2.5</b> <sup>1)</sup>	2.500	0.45	16.00	5.0
<b>F100M2.6</b> <sup>1)</sup>	2.600	0.45	16.00	5.0
<b>F100M3</b>	3.000	0.50	20.00	5.0
<b>F100M3.5</b>	3.500	0.60	20.00	5.0
<b>F100M4</b>	4.000	0.70	20.00	5.0
<b>F100M4.5</b>	4.500	0.75	20.00	7.0
<b>F100M5</b>	5.000	0.80	20.00	7.0
<b>F100M6</b>	6.000	1.00	20.00	7.0
<b>F100M7</b>	7.000	1.00	25.00	9.0
<b>F100M8</b>	8.000	1.25	25.00	9.0
<b>F100M9</b>	9.000	1.25	25.00	9.0
<b>F100M10</b>	10.000	1.50	30.00	11.0
<b>F100M11</b>	11.000	1.50	30.00	11.0

Product	TD [mm]	TP [mm]	BD [mm]	OAL [mm]
<b>F100M12</b>	12.000	1.75	38.00	14.0
<b>F100M14</b>	14.000	2.00	38.00	14.0
<b>F100M16</b>	16.000	2.00	45.00	18.0
<b>F100M18</b>	18.000	2.50	45.00	18.0
<b>F100M20</b>	20.000	2.50	45.00	18.0
<b>F100M22</b>	22.000	2.50	55.00	22.0
<b>F100M24</b>	24.000	3.00	55.00	22.0
<b>F100M27</b>	27.000	3.00	65.00	25.0
<b>F100M30</b>	30.000	3.50	65.00	25.0
<b>F100M33</b>	33.000	3.50	65.00	25.0
<b>F100M36</b>	36.000	4.00	65.00	25.0
<b>F100M39</b>	39.000	4.00	75.00	30.0
<b>F100M42</b>	42.000	4.50	75.00	30.0

<sup>1)</sup> Without gun-nose.

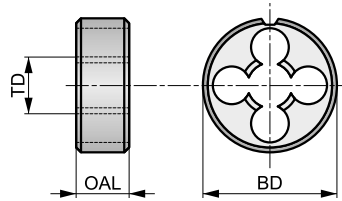


# F201



## HSS Gun Nosed Machine Die, Metric, Left Hand

Solid die for external thread. Generally for use on lathes, small diameters can be produced by hand with a die stock holder. The gun-nose will drive the chip ahead of the cutting edge, increasing performance. Bright finish lapped surface prevents the workpiece material from sticking and improves the threading action.



<b>M</b>	ISO <b>2568</b>	<b>6g</b>
<b>1.75</b> XP	HSS	<b>L</b>
Bright		

Workpiece material group suitability and starting values for cutting speed (m/min).

<b>P1.1</b> ■ 12	<b>P1.2</b> ■ 13	<b>P1.3</b> ■ 14	<b>P2.1</b> ■ 10	<b>P2.2</b> ■ 9	<b>P2.3</b> ▧ 8	<b>P3.1</b> ■ 8	<b>P3.2</b> ▧ 7	<b>P4.1</b> ▧ 5	<b>M1.1</b> ■ 7	<b>M1.2</b> ■ 6	<b>M2.1</b> ■ 6	<b>M2.2</b> ▧ 5	<b>K1.1</b> ■ 11
<b>K1.2</b> ■ 8	<b>K1.3</b> ▧ 6	<b>K2.1</b> ■ 11	<b>K2.2</b> ■ 9	<b>K2.3</b> ▧ 7	<b>K3.1</b> ■ 10	<b>K3.2</b> ■ 8	<b>K3.3</b> ▧ 6	<b>K5.1</b> ■ 10	<b>K5.2</b> ■ 8	<b>K5.3</b> ▧ 6	<b>N1.1</b> ▧ 20	<b>N1.2</b> ▧ 15	<b>N1.3</b> ▧ 10
<b>N2.1</b> ▧ 10	<b>N2.2</b> ▧ 9	<b>N2.3</b> ▧ 6	<b>N3.1</b> ■ 11	<b>N3.2</b> ▧ 6	<b>N3.3</b> ▧ 3	<b>N4.1</b> ▧ 11	<b>N4.2</b> ▧ 4	<b>N4.3</b> ▧ 4					

Product	TD	TP	BD	OAL
	[mm]	[mm]	[mm]	[mm]
F201M3	3.000	0.50	20.00	5.0
F201M4	4.000	0.70	20.00	5.0
F201M5	5.000	0.80	20.00	7.0
F201M6	6.000	1.00	20.00	7.0
F201M8	8.000	1.25	25.00	9.0
F201M10	10.000	1.50	30.00	11.0
F201M12	12.000	1.75	38.00	14.0
F201M14	14.000	2.00	38.00	14.0
F201M16	16.000	2.00	45.00	18.0
F201M18	18.000	2.50	45.00	18.0
F201M20	20.000	2.50	45.00	18.0

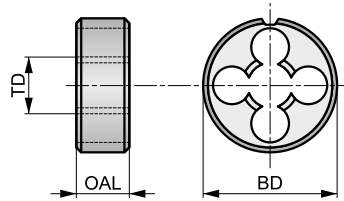


# F108



## HSS-E Gun Nosed Machine Die, Metric, Right Hand

Solid die for producing external thread. The gun-nose will drive the chip ahead of the cutting edge, increasing performance. Bright finish lapped surface prevents the workpiece material from sticking and improves the threading action. Specific geometry to cut accurate threads in stainless steel.



<b>M</b>	ISO <b>2568</b>	<b>6g</b>
<b>2.25</b> XP	HSS-E	<b>R</b>
Bright		

Workpiece material group suitability and starting values for cutting speed (m/min).

<b>P1.1</b> 12	<b>P1.2</b> 13	<b>P1.3</b> 14	<b>P2.1</b> 10	<b>P2.2</b> 9	<b>P2.3</b> 8	<b>P3.1</b> 8	<b>P3.2</b> 7	<b>P3.3</b> 6	<b>P4.1</b> 5	<b>P4.2</b> 4	<b>M1.1</b> 7	<b>M1.2</b> 6	<b>M2.1</b> 6
<b>M2.2</b> 5	<b>M2.3</b> 5	<b>M3.1</b> 6	<b>M3.2</b> 5	<b>M3.3</b> 4	<b>M4.1</b> 5	<b>K4.1</b> 9	<b>K4.2</b> 7	<b>K4.3</b> 5	<b>K4.4</b> 4	<b>K4.5</b> 4	<b>N1.1</b> 20	<b>N1.2</b> 15	<b>N1.3</b> 10
<b>N2.1</b> 10	<b>N2.2</b> 9	<b>N2.3</b> 6	<b>N3.1</b> 11	<b>N3.2</b> 6	<b>N3.3</b> 3	<b>N4.1</b> 11	<b>N4.2</b> 4	<b>N4.3</b> 4	<b>S1.1</b> 5				

Product	TD [mm]	TP [mm]	BD [mm]	OAL [mm]
F108M2 <sup>1)</sup>	2.000	0.40	16.00	5.0
F108M2.5 <sup>1)</sup>	2.500	0.45	16.00	5.0
F108M3	3.000	0.50	20.00	5.0
F108M4	4.000	0.70	20.00	5.0
F108M5	5.000	0.80	20.00	7.0
F108M6	6.000	1.00	20.00	7.0
F108M8	8.000	1.25	25.00	9.0
F108M10	10.000	1.50	30.00	11.0
F108M12	12.000	1.75	38.00	14.0
F108M14	14.000	2.00	38.00	14.0
F108M16	16.000	2.00	45.00	18.0
F108M18	18.000	2.50	45.00	18.0
F108M20	20.000	2.50	45.00	18.0

<sup>1)</sup> Without gun-nose.