

Unsere VA Gewindebohrer- Spezialisten: aus HSS-Co und HSS-Co PM

Stahl

rostfreie Materialien

Titan

NE-Metalle

Aluminium

Sonderlegierungen



DIN 371B / 376B blank/VP



DIN 371B / 376B TiN



DIN 371C / 376C blank/VP



DIN 371C / 376C TiN



DIN 371B / 376B TiCN



DIN 371C / 376C TiCN



Typ	VA	VA	VA	VA	MULTI RAPID VA / MULTI VA	
Anwendung	Durchgangsloch	Durchgangsloch	Sackloch	Sackloch	Durchgangsloch	Sackloch
Gewindetiefe	2xD	2xD	2xD	2xD	3xD	3xD
Anschnitt	B	B	C 40°	C 40°	B	C 50°
Schneidstoff	HSS-CO	HSS-CO	HSS-CO	HSS-CO	HSS-Co-PM	HSS-Co-PM
Beschichtung	BL / VP	TN / XP	BL / VP	TN / XP	TiCN	TiCN
DIN 371	6646 6646VP	6646TN	6661 6661VP	6661TN	6773TC	6774TC
DIN 376	6647 6647VP	6647XP	6662 6662VP	6662XP	6778TC	6779TC

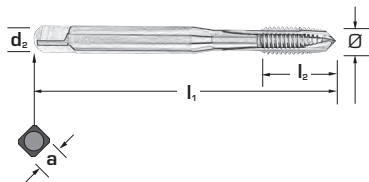
		VC	VC	VC	VC	VC	VC	VC	
		blank	VP	TN / XP	blank	VP	TN / XP	TiCN	TiCN
P	< 800 N/mm ²	15	15	18	13	13	15	30	30
P	700-1000 N/mm ²	-	-	-	-	-	-	25	25
P	1000-1300 N/mm ²	-	-	-	-	-	-	-	-
M	Austenitisch	6	6	10	10	10	12	15	15
M	Austenitisch / ferritisch	5	5	7	8	8	8	10	10
K	GG	-	-	-	-	-	-	-	-
K	GGG	-	-	-	-	-	-	-	-
N	Aluminium	-	-	-	-	-	-	40	40
N	NE-Metalle	10	10	15	11	11	13	-	-
S	Titan	3	3	5	3	3	5	3	3
S	Sonderlegierungen basiert auf Ni	2	2	4	2	2	4	-	-
H	Gehärteter Stahl 38 / 48 HRC	-	-	-	-	-	-	-	-
H	Gehärteter Stahl 48 / 58 HRC	-	-	-	-	-	-	-	-
H	Gehärteter Stahl 58 / 68 HRC	-	-	-	-	-	-	-	-

DIN 371



Maschinen-Gewindebohrer mit verstärktem Schaft für Metrisches ISO-Gewinde nach DIN 13

Machine taps with reinforced shank for ISO metric coarse thread as per DIN 13



Typ / Type	VA	VAP	VA	VR 35°	VRP 35°	VR 35°
Toleranz Tolerance	6 HX	6 HX	6 HX	6 HX	6 HX	6 HX
Anschnitt / Gangzahl Chamfer form / No. of threads	B/4-5	B/4-5	B/4-5	C/2,5-3	C/2,5-3	C/2,5-3
Schneidrichtung Cutting direction						
Schneidstoff/Material	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co

Ø mm	Steigung Pitch	Kernloch Ø Tap drill Ø	l ₁ mm	l ₂ mm	d ₂ mm h9	a h12	6646	6646 VP	6646 TN	6661	6661 VP	6661 TN
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M 2	0,40	1,60	45	8,0	2,8	2,1	●	●	●	●	●	●
M 2,2	0,45	1,75	45	9,0	2,8	2,1	●	●	●	●	●	●
M 2,3*	0,40	1,90	45	9,0	2,8	2,1	●	●	●	●	●	●
M 2,5	0,45	2,05	50	9,0	2,8	2,1	●	●	●	●	●	●
M 2,6*	0,45	2,10	50	9,0	2,8	2,1	●	●	●	●	●	●
M 3	0,50	2,50	56	11,0	3,5	2,7	●	●	●	●	●	●
M 3,5	0,60	2,90	56	13,0	4,0	3,0	●	●	●	●	●	●
M 4	0,70	3,30	63	13,0	4,5	3,4	●	●	●	●	●	●
M 5	0,80	4,20	70	16,0	6,0	4,9	●	●	●	●	●	●
M 6	1,00	5,00	80	19,0	6,0	4,9	●	●	●	●	●	●
M 7	1,00	6,00	80	19,0	7,0	5,5	●	●	●	●	●	●
M 8	1,25	6,80	90	22,0	8,0	6,2	●	●	●	●	●	●
M 10	1,50	8,50	100	24,0	10,0	8,0	●	●	●	●	●	●



VA: Für rostfreien Stahl
for stainless steel

VAP: vaporisiert
vaporized

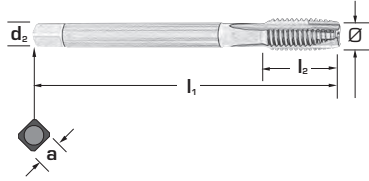
* Diese Gewinde sind im Metrischen ISO-Gewinde nicht enthalten / These sizes are not ISO standard.
● Standardartikel / Items available ex stock

DIN 376



Maschinen-Gewindebohrer mit Überlaufschneidung für Metrisches IOS-Gewinde nach DIN 13

Machine taps with reduced shank for ISO metric coarse thread as per DIN 13



Typ / Type								VA	VAP	VA	VR 35°	VRP 35°	VR 35°
Toleranz Tolerance								6 HX	6 HX	6 HX	6 HX	6 HX	6 HX
Anschnitt / Gangzahl Chamfer form / No. of threads								B/4-5	B/4-5	B/4-5	C/2,5-3	C/2,5-3	C/2,5-3
Schneidrichtung Cutting direction													
Schneidstoff / Material								HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co	HSS-Co
Ø mm	Steigung Pitch	Kernloch Ø Tap drill Ø	l ₁ mm	l ₂ mm	d ₂ mm h9	a h12		6647	6647 VP	6647 XP	6662	6662 VP	6662 XP
M 12	1,75	10,20	110	29	9,0	7,0		●	●	●	●	●	●
M 14	2,00	12,00	110	30	11,0	9,0		●	●	●	●	●	●
M 16	2,00	14,00	110	32	12,0	9,0		●	●	●	●	●	●
M 18	2,50	15,50	125	34	14,0	11,0		●	●	●	●	●	●
M 20	2,50	17,50	140	34	16,0	12,0		●	●	●	●	●	●
M 22	2,50	19,50	140	34	18,0	14,5		●	●	●	●	●	●
M 24	3,00	21,00	160	38	18,0	14,5		●	●	●	●	●	●

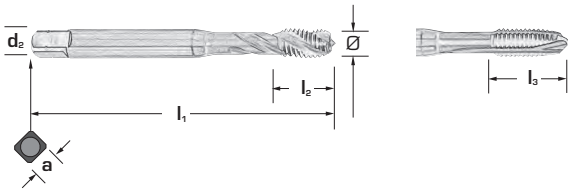
DIN 371



Maschinen-Gewindebohrer mit verstärktem Schaft für Metrisches ISO-Regelgewinde nach DIN 13

Machine taps with reinforced shank for ISO metric coarse thread acc. to DIN 13 - New Geometry

Multi VA, Multi Rapid VA



Typ / Type

Toleranz
Tolerance

Anschnittform / Anzahl der Gänge
Chamfer form / No. of threads

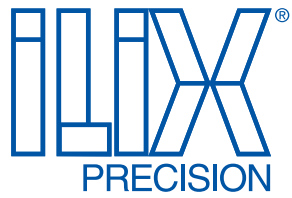
Schneidrichtung
Cutting direction

Schneidstoff/Material

Multi Rapid VA	Multi VA 50°
6 HX	6 HX
B/4-5	C/2,5-3
HSS-Co-PM	HSS-Co-PM

Ø mm	Steigung Pitch	Kernloch Ø Tap drill Ø	l ₁ mm	l ₂ mm	l ₃ mm	d ₂ mm h9	a mm h12	6773 TC	6774 TC
M 3	0,50	2,5	56	5	11	3,5	2,7	●	●
M 4	0,70	3,3	63	7	13	4,5	3,4	●	●
M 5	0,80	4,2	70	8	16	6,0	4,9	●	●
M 6	1,00	5,0	80	10	19	6,0	4,9	●	●
M 8	1,25	6,8	90	12	22	8,0	6,2	●	●
M 10	1,50	8,5	100	14	24	10,0	8,0	●	●

● Standardartikel / Items available ex stock



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