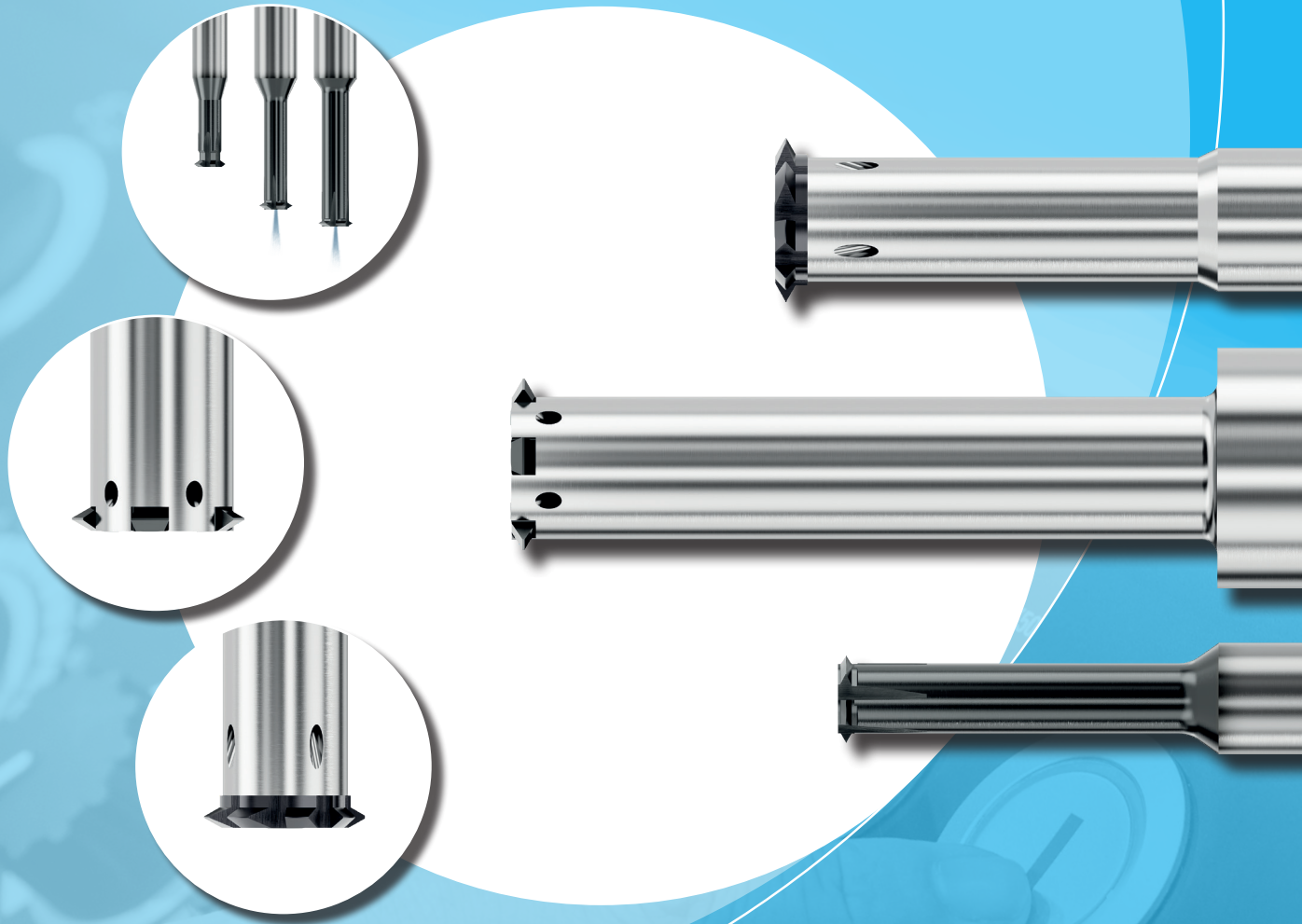




OUR PRECISION IS YOUR SUCCESS



NORIS EIR + NORIS NES

SINGLE TOOTH THREAD MILLS



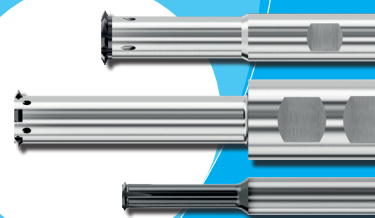
Quality 
Made in Germany
ISO 9001 CERTIFIED



NORIS EIR + NORIS NES

NORIS SINGLE-TOOTH THREAD MILLS

- FLEXIBLE
 - UNIVERSAL
 - ECONOMICAL



NORIS SINGLE TOOTH THREAD MILLS

NORIS EIR HR - THREAD MILL

Solid carbide thread mill for small dimensions

ADVANTAGES

- Universal profile geometry for different sizes and pitches with one insert
- Universal cutting edge geometry for machining almost all common materials

MATERIAL

- K20-K30 Ultra-fine grain

NORIS EIR HR 2xD - F500



DIMENSIONS RANGE

M/MF $\varnothing \geq 1$ mm
UNC $\varnothing \geq$ Nr. 1
UNF $\varnothing \geq$ Nr. 1

ALTIN-BESCHICHTUNG

- PVD-Coating
 - Layer hardness 3700 HV
- => High temperature resistance
=> High cutting edge stability

NORIS EIR HR 2xD - F50E



DIMENSIONS RANGE

M $\varnothing \geq 1$ mm
UNC $\varnothing \geq$ Nr. 2
UNF $\varnothing \geq$ Nr. 10

ACR-BESCHICHTUNG

- Nanostructured multilayer coating
 - Layer hardness 3800 HV
- => High cutting edge stability
=> Thermal shock resistant

NORIS EIR HR 3xD - F51E



NORIS NES - THREAD MILLING SYSTEM

Thread milling system with exchangeable carbide inserts for large dimensions

ADVANTAGES

- Universal profile geometry for different sizes and pitches with one insert
- Universal cutting edge geometry for machining almost all common materials
- Up to 3xD usable length for the production of deep or deep set threads

TOOL-HOLDER

- Stable and low-vibration construction
- Internal coolant supply for perfect cooling and chip removal
- Various lengths and shank types available

INSERTS

- 60° and 55° thread profiles available
- Different dimensions with one insert

DIMENSIONS RANGE

M/MF	≥ M20
UN/NPT	≥ 7/8"
G/R/Rp/Rc	≥ 1/2"
W	≥ 1"

ADVANTAGES

- Each insert can be used 2x or 4x times
- => Low cost per thread

TIN-BESCHICHTUNG

- PVD-Coating
 - Layer hardness 2400 HV
- => High wear resistance
=> Universal use

TIALN-COATING

- PVD-Coating
 - Layer hardness 3600 HV
- => High temperature resistance
=> Preferred for steel and cast materials

DIMENSIONS RANGE

M/MF	≥ M24
UNC	≥ 1 1/8"
UNF	≥ 1"
G	≥ 5/8"

ADVANTAGES

- Increased number of inserts than NES
- => Shorter processing times
=> Low cost per thread
=> Increased productivity

DIMENSIONS RANGE

M/MF	≥ 12 mm
UNC	≥ 1/2"
UNF	≥ 1/2"
G	≥ 1/4"

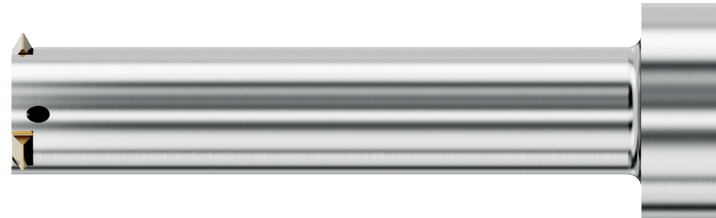
ADVANTAGES

- Increased number of cutting edges on one insert
- => Shorter processing times
=> Increased productivity

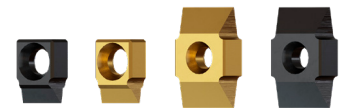
ACR-COATING

- Nanostructured multilayer coating
 - Layer hardness 3800 HV
- => High cutting edge stability
=> Thermal shock resistant

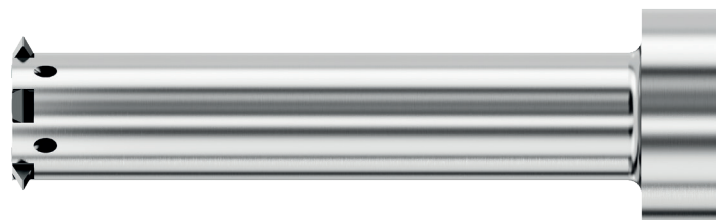
NORIS NES - F501 | F505



NORIS NES HM-WP



NORIS NES-TS - F701



NORIS NES-Z - F50Z



NORIS NES-Z HM-SP





AUSWAHLÜBERSICHT

DIE ANGEgebenEN SCHNITTWERTE
SIND RICHTWERTE UND MÜSSEN DEN INDIVIDUELLEN
ARBEITSBEDINGUNGEN ANGEPAST WERDEN.



GUIDE DE SELECTION

LES VALEURS DE VITESSE DE COUPE INDIQUEES DANS LES
COLONNES RESPECTIVES NE SONT QU'INDICATIVES ET DOIVENT ÊTRE
ADAPTEES INDIVIDUELLEMENT AUX CONDITIONS D'USINAGE.



SUMMARY OF ASSORTMENT

THE LISTED CUTTING DATA ARE STANDARD VALUES.
THIS VALUES HAVE TO BE ADJUSTED TO INDIVIDUAL WORK CONDITIONS.



SCELTA DEGLI UTENSILI

I VALORI DI VELOCITÀ DI TAGLIO QUI ELENCATI SONO
PURAMENTE INDICATIVI E DEVONO ESSERE ADATTATI ALLE CONDIZIONI
D'IMPIEGO.



	STAHLWERKSTOFFE	STEEL MATERIALS	ACIERS	ACCIAI
P	Un-und niedriglegierte Stähle	Unalloyed and low-alloy steels	Aciers non et faiblement alliés	Acciai non legati e basso legati
	Hochlegierte Stähle	High alloy steels	Aciers hautement alliés	Acciai alto legati
M	ROSTFREI STÄHLE	CORROSION AND ACID PROOF STEELS	ACIERS INOX/RESIST. ACIDES	ACCIAI INOX E RESISTENTI AGLI ACIDI
	Rostfreie austenitische Stähle + DUPLEX Stähle	Corrosion and acid proof steels + DUPLEX	Aciers inoxydables austénitiques + Aciers DUPLEX	Acciai inossidabili austenitici + Acciai DUPLEX
K	GUSSWERKSTOFFE	CAST MATERIALS	FONTES	GHISE
	Grauguss, Kugelgraphitguss, Vermiculargraphitguss, Temperguss	Cast iron, nodular cast iron, Vermicular graphite cast iron, malleable cast iron	Fonte grise, fonte à graphite sphéroïdal, Fonte à graphite vermiculaire, Fonte malléable	Ghisa grigia, ghisa nodulare, Ghisa a grafite vermiculata, ghisa malleabile
	Gusseisen ausferritisch (ADI) + Hartguss	Ausferritic cast iron (ADI) + Hard casting	Fonte ausferritique (ADI) + Fontes trempées	Ghisa ausferritica (ADI) + Ghise in conchiglia
N	NICHTEISEN-WERKSTOFFE	NON FERROUS MATERIALS	MATÉRIAUX NON FERREUX	MATERIALI NON FERROSI
	Aluminium-Knetlegierungen	Aluminium wrought alloys	Alliages d'aluminium corroyés	Leghe malleabili di alluminio
	Aluminium-Gusslegierungen	Aluminium cast alloys	Fontes d'alu	Leghe fuse di alluminio
	Kupfer + Kupferlegierungen (langsp.)	Copper + Copper alloys (long-chip.)	Cuivre + Alliages cuivre (cop. longs)	Rame + Leghe rame (truciolo lungo)
	Kupferlegierungen (kurzsp.)	Copper alloys (short-chip.)	Alliages cuivre (cop. courts)	Leghe rame (truciolo corto)
	Kupferlegierungen hochfest	High-strength copper alloys	Alliages cuivre haute résistance	Leghe rame ad alta resistenza
	Zink-Legierungen	Zinc alloys	Alliages de zinc	Leghe zinco
	Magnesium-Legierungen	Magnesium wrought alloys	Alliages de magnésium corroyés	Leghe malleabili di magnesio
S	Thermoplaste	Thermoplastics	Thermoplastiques	Resine termoplastiche
	Faserverstärkte Kunststoffe + Duroplaste	Fibre-reinforced synthetics + Duroplastics	Plastiques chargées en fibres + Thermodurcissables	Resine epossidiche + Plastiche termoindurenti
	SPEZIALWERKSTOFFE	SPECIAL MATERIALS	MATÉRIAUX SPÉCIAUX	MATERIALI SPECIALI
	Ni-, Fe-oder Co-Basis-Superlegierungen	Ni-, Fe-or Co-base-Superalloys	Base Ni, Fe ou Co-Superallages	A base Ni-, Fe-o Co-Superleghe
	Titan + Titanlegierungen	Titanium + Titanium alloys	Titane + Alliages de titane	Titanio + Leghe di titanio
H	GEHÄRTETE WERKSTOFFE	HARDENED STEELS	ACIERS TRAITÉS	ACCIAI TEMPRATI
	Gehärtete Stähle	Hardened steels	Aciers traités	Acciai temprati



2xD

2xD

3xD

2xD

2,5xD

NORIS EIR

NES-Z

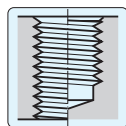
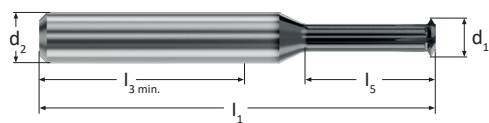
NES / NES-TS

M	8	8	9	14	10/11
MF	8	8	9	14	10/11
UNC			9	14	10/11
UNF			9	14	10/11
G				14	10/11
NPT				14	10/11

	MAT.	Vc (m/min)	fz (mm) 2xD	fz (mm) 3xD	Vc (m/min)	fz (mm) 2xD	fz (mm) 2,5xD	Vc (m/min) TiN	Vc (m/min) TiAlN	fz (mm)
≤ 800 N/mm²	P 1.1	100 - 200	0,045xP	0,040xP	100 - 200	0,060xP	0,055xP	200 - 350	250 - 400	0,15 - 0,30
≤ 1200 N/mm²	P 1.2	60 - 140	0,035xP	0,030xP	60 - 140	0,045xP	0,040xP	150 - 250	200 - 300	0,10 - 0,25
≤ 1400 N/mm²	P 1.3	40 - 80	0,030xP	0,025xP	40 - 80	0,035xP	0,030xP	100 - 150	150 - 200	0,06 - 0,12
≤ 1400 N/mm²	P 2.1	40 - 140	0,030xP	0,025xP	40 - 140	0,035xP	0,030xP	80 - 160	100 - 180	0,08 - 0,12
		Vc (m/min)	fz (mm) 2xD	fz (mm) 3xD	Vc (m/min)	fz (mm) 2xD	fz (mm) 2,5xD	Vc (m/min) TiN	Vc (m/min) TiAlN	fz (mm)
≤ 800 N/mm²	M 1.1	60 - 120	0,030xP	0,025xP	60 - 120	0,035xP	0,030xP	80 - 120	80 - 120	0,06 - 0,12
≤ 1300 N/mm²	M 1.2	30 - 80	0,020xP	0,015xP	30 - 80	0,030xP	0,020xP	50 - 100	50 - 100	0,04 - 0,10
		Vc (m/min)	fz (mm) 2xD	fz (mm) 3xD	Vc (m/min)	fz (mm) 2xD	fz (mm) 2,5xD	Vc (m/min) TiN	Vc (m/min) TiAlN	fz (mm)
≤ 800 N/mm²	K 1.1	100 - 200	0,050xP	0,050xP	100 - 200	0,060xP	0,060xP	200 - 350	250 - 400	0,15 - 0,30
≤ 1400 N/mm²	K 2.1	60 - 140	0,035xP	0,030xP	60 - 140	0,045xP	0,040xP	100 - 250	150 - 300	0,08 - 0,12
		Vc (m/min)	fz (mm) 2xD	fz (mm) 3xD	Vc (m/min)	fz (mm) 2xD	fz (mm) 2,5xD	Vc (m/min) TiN	Vc (m/min) TiAlN	fz (mm)
	N 1.1	200 - 400	0,060xP	0,060xP	200 - 400	0,080xP	0,080xP	300 - 500	300 - 500	0,15 - 0,30
≤ 12% Si	N 1.2	200 - 400	0,060xP	0,060xP	200 - 400	0,080xP	0,080xP	300 - 500	300 - 500	0,15 - 0,30
≥ 12% Si	N 1.3	150 - 300	0,060xP	0,060xP	150 - 300	0,080xP	0,080xP	250 - 350	300 - 450	0,15 - 0,25
	N 2.1	200 - 400	0,060xP	0,060xP	200 - 400	0,080xP	0,080xP	300 - 400	300 - 400	0,15 - 0,30
	N 2.2	200 - 400	0,060xP	0,060xP	200 - 400	0,080xP	0,080xP	300 - 400	300 - 400	0,15 - 0,30
≥ 800 N/mm²	N 2.3	40 - 120	0,030xP	0,025xP	40 - 120	0,045xP	0,040xP	100 - 250	150 - 300	0,08 - 0,12
	N 3.1	200 - 400	0,060xP	0,060xP	200 - 400	0,080xP	0,080xP	300 - 400	300 - 400	0,15 - 0,30
	N 4.1	200 - 400	0,060xP	0,060xP	200 - 400	0,080xP	0,080xP	300 - 400	300 - 400	0,15 - 0,30
	N 5.1	200 - 400	0,060xP	0,060xP	200 - 400	0,080xP	0,080xP	300 - 400	300 - 400	0,15 - 0,30
	N 5.2	150 - 300	0,060xP	0,060xP	150 - 300	0,080xP	0,080xP	250 - 350	250 - 350	0,15 - 0,30
		Vc (m/min)	fz (mm) 2xD	fz (mm) 3xD	Vc (m/min)	fz (mm) 2xD	fz (mm) 2,5xD	Vc (m/min) TiN	Vc (m/min) TiAlN	fz (mm)
≤ 800 N/mm²	S 1.1	30 - 80	0,020xP	0,015xP	30 - 80	0,030xP	0,025xP	60 - 120	60 - 120	0,06 - 0,10
≤ 1600 N/mm²	S 1.2	20 - 60	0,010xP		20 - 60	0,020xP	0,020xP	50 - 80	50 - 80	0,04 - 0,08
≤ 800 N/mm²	S 2.1	40 - 120	0,025xP	0,020xP	40 - 120	0,030xP	0,020xP	80 - 140	80 - 140	0,08 - 0,12
≤ 1300 N/mm²	S 2.2	30 - 80	0,020xP	0,015xP	30 - 80	0,025xP	0,020xP	60 - 100	60 - 100	0,06 - 0,10
		Vc (m/min)	fz (mm) 2xD	fz (mm) 3xD	Vc (m/min)	fz (mm) 2xD	fz (mm) 2,5xD	Vc (m/min) TiN	Vc (m/min) TiAlN	fz (mm)
≤ 55 HRC	H 1.1	30 - 60	0,015xP		30 - 60	0,02xP		30 - 60	30 - 60	0,04 - 0,08
≤ 63 HRC	H 1.2									
≤ 65 HRC	H 1.3									

2xD

2xD



DIN 6535- HA



DIN 6535- HA



DIN 6535- HB



mKB

OBERFLÄCHE / SURFACE
SURFACE / SUPERFICIESCHNEIDSTOFF / MATERIAL
MATIÈRE / MATERIALE

ALTIN

ACR

K30

K30

M | MF DIN 13

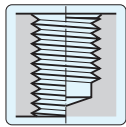
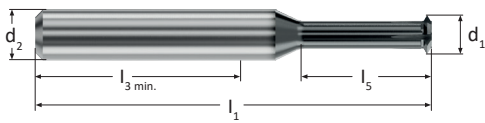
$\varnothing D_{\min}$ [mm]	P [mm]	$\varnothing d_1$	$\varnothing d_2$	l_1	$l_{3 \min}$	l_5	z		
$\geq M 1$	0,20 - 0,25	0,74	3	32	28	3	4	F500HAF00109	
$\geq M 1,2$	0,20 - 0,30	0,9	3	32	28	3,5	4	F500HAF00129	
$\geq M 1,4$	0,25 - 0,35	1	3	32	28	3,5	4	F500HAF00149	
$\geq M 1,6$	0,35 - 0,40	1,2	3	32	28	4	4	F500HAF00169	
$\geq M 1,7$	0,35 - 0,40	1,2	3	32	28	4	4	F500HAF00169	
$\geq M 1,8$	0,35 - 0,45	1,35	3	32	28	4	4	F500HAF00189	
$\geq M 2$	0,35 - 0,45	1,5	3	32	28	4	4	F500HAF00209	
$\geq M 2,2$	0,35 - 0,45	1,5	3	32	28	4	4	F500HAF00209	
$\geq M 2,5$	0,40 - 0,50	1,9	3	32	28	6	5	F500HAF00259	
$\geq M 3$	0,50 - 0,60	2,4	3	32	28	6	5	F500HAF00309	
$\geq M 3,5$	0,50 - 0,70	2,8	3	32	28	6	6	F500HAF00359	
$\geq M 4$	0,60 - 0,80	3,2	5	40	28	8	6	F500HAF00409	
$\geq M 5$	0,70 - 0,80	4,1	5	40	28	9	6	F500HAF00509	
$\geq M 6$	0,80 - 1,00	4,9	5	40	28	9	6	F500HAF00609	
$\geq M 7$	0,80 - 1,00	4,9	5	40	28	9	6	F500HAF00609	

M | MF DIN 13

$\varnothing D_{\min}$ [mm]	P [mm]	$\varnothing d_1$	$\varnothing d_2$	l_1	$l_{3 \min}$	l_5	z		
$\geq M 1$	0,10 - 0,25	0,7	3	39	28	2,8	1	F50ES0522368	
$\geq M 1,2$	0,10 - 0,25	0,7	3	39	28	2,8	1	F50ES0522368	
$\geq M 1,4$	0,12 - 0,35	1,04	3	39	28	3,5	2	F50ES0522369	
$\geq M 1,6$	0,12 - 0,35	1,04	3	39	28	3,5	2	F50ES0522369	
$\geq M 1,7$	0,12 - 0,35	1,04	3	39	28	3,5	2	F50ES0522369	
$\geq M 1,8$	0,12 - 0,35	1,04	3	39	28	3,5	2	F50ES0522369	
$\geq M 2$	0,15 - 0,45	1,52	3	39	28	4,8	3	F50ES0522370	
$\geq M 2,2$	0,15 - 0,45	1,52	3	39	28	4,8	3	F50ES0522370	
$\geq M 2,5$	0,17 - 0,50	1,95	3	39	28	6	3	F50ES0522371	
$\geq M 3$	0,17 - 0,50	1,95	3	39	28	6	3	F50ES0522371	
$\geq M 3,5$	0,22 - 0,75	2,78	4	42	28	9	3	F50ES0522372	
$\geq M 4$	0,22 - 0,75	2,78	4	42	28	9	3	F50ES0522372	
$\geq M 5$	0,30 - 1,00	4	6	55	36	14	4	F50EHB0000509	
$\geq M 6$	0,30 - 1,00	4	6	55	36	14	4	F50EHB0000509	
$\geq M 7$	0,30 - 1,00	4	6	55	36	14	4	F50EHB0000509	
$\geq M 8$	0,45 - 1,50	6,5	8	62	36	19,8	5		F50EHB0000809
$\geq M 10$	0,45 - 1,50	6,5	8	62	36	19,8	5		F50EHB0000809
$\geq M 12$	0,50 - 2,00	9,9	10	78	40	31,8	5		F50EHB0001129
$\geq M 14$	0,50 - 2,00	9,9	10	78	40	31,8	5		F50EHB0001129
$\geq M 16$	0,50 - 2,00	9,9	10	78	40	31,8	5		F50EHB0001129

DIN 6535 - HA

DIN 6535 - HB



OBERFLÄCHE / SURFACE
SURFACE / SUPERFICIE
SCHNEIDSTOFF / MATERIAL
MATIÈRE / MATERIALE

M | MF DIN 13

$\varnothing D_{\min}$ [mm]	P [mm]	$\varnothing d_1$	$\varnothing d_2$	l_1	$l_3 \min.$	l_5	z		
$\geq M$ 1	0,10 - 0,25	0,7	3	39	28	3,3	1	F51EHAF00105	
$\geq M$ 1,6	0,14 - 0,35	1,18	3	39	28	5,2	2	F51EHAF00165	
$\geq M$ 2	0,15 - 0,40	1,52	3	39	28	6,4	3	F51EHAF00205	
$\geq M$ 2,5	0,17 - 0,45	1,96	3	39	28	8	3	F51EHAF00255	
$\geq M$ 3	0,18 - 0,50	2,4	3	41	28	9,5	3	F51EHAF00305	
$\geq M$ 4	0,26 - 0,70	3,15	4	44	28	12,7	3	F51EHAF00405	
$\geq M$ 5	0,28 - 0,80	4,04	6	56	36	15,8	4		F51EHBf000509*
$\geq M$ 6	0,35 - 1,00	4,8	6	59	36	19	4		F51EHBf000609*
$\geq M$ 8	0,43 - 1,25	6,5	8	65	36	25,3	5		F51EHBf000809
$\geq M$ 10	0,51 - 1,50	8,2	10	77	40	31,5	5		F51EHBf001009
$\geq M$ 12	0,60 - 1,75	9,9	10	82	40	37,8	5		F51EHBf001129
$\geq M$ 14	0,68 - 2,00	11,6	12	94	45	44	5		F51EHBf001149
$\geq M$ 16	0,68 - 2,00	13,6	14	100	45	50	5		F51EHBf001169

UNC ASME B1.1

$\varnothing D_{\min}$ [inch]	P Gg/1" [tpi]	$\varnothing d_1$	$\varnothing d_2$	l_1	$l_3 \min.$	l_5	z		
$\geq UNC$ Nr.2	80 - 56	1,7	3	39	28	7	3	F51EHAF050019	
$\geq UNC$ Nr.4	80 - 40	2,15	3	40	28	9,2	3	F51EHAF050039	
$\geq UNC$ Nr.6	80 - 32	2,7	3	42	28	11,3	3	F51EHAF050059	
$\geq UNC$ Nr.10	72 - 24	3,7	4	46	28	15,5	3	F51EHAF050079	
$\geq UNC$ 1/4	56 - 20	4,95	6	59	36	20,3	4		F51EHBf050099*
$\geq UNC$ 5/16	48 - 18	6,3	8	65	36	25,2	4		F51EHBf050109
$\geq UNC$ 3/8	48 - 16	7,7	8	68	36	30,2	5		F51EHBf050119

UNF ASME B1.1

$\varnothing D_{\min}$ [inch]	P Gg/1" [tpi]	$\varnothing d_1$	$\varnothing d_2$	l_1	$l_3 \min.$	l_5	z		
$\geq UNF$ Nr.10	80 - 32	3,9	4	46	28	15,3	4	F51EHAF050419	
$\geq UNF$ 1/4	80 - 28	5,25	6	59	36	20	4		F51EHBf050439*
$\geq UNF$ 5/16	64 - 24	6,6	8	65	36	24,9	5		F51EHBf050449
$\geq UNF$ 7/16	56 - 20	9,55	10	77	40	34,6	5		F51EHBf050469

* ohne Innenkühlung
without internal coolant supply
senza alimentazione interna del refrigerante
sans système de refroidissement interne



	M / MF	UN	NPT	G / W		D ₁		l ₅	ø d ₂	l ₁	z		
[mm]	P [mm]	Gg/1" [tpi]	Gg/1" [tpi]	Gg/1" [tpi]		[mm]							
≥ ø 17,50	1,5- 3	16- 9	14- 11,5	28 - 9	F521	16,5	FK 16,5/18	45	20	100	2	F501F0003	
≥ ø 20,00	2,5- 3,5	10- 7	-	-	F522	18		60	20	114	2	F501F0005	
≥ ø 21,00	1,5- 3	16- 9	14- 11,5	28 - 9	F521	20,5	FK 20,5/22	50	16	100	3	F501F0019	
≥ ø 23,50	2,5- 3,5	10- 7	-	-	F522	22					4		F701F0016
≥ ø 25,50	1,0- 4,0	24- 6	14- 11,5	28 - 9	F510	23,85	FK 24	60	32	124	3	F501AANAA	
									25	140	3	F501F0011	
								80	32	144	3	F501AARAA	
								90	32	154	3	F501AA8AA	
≥ ø 29,00	2,5- 4,5	10- 6	-	-	F710	23,85	FK 24	60	32	124	5		F701F0015
								90	32	153	5		F701F0003
≥ ø 31,50	1,0- 4,0	24- 6	14- 11,5	28 - 9	F510	29,27	FK 29,5	95	32	159	3	F501E0841	
≥ ø 35,00	1,5- 5,5	16- 4,5	14- 11,5	28 - 9	F511	32,85	FK 33	95	25	155	3	F501F0012	
									32	159	3	F501AAPAA	
								115	32	179	3	F501F0007	
≥ ø 43,00	1,5- 6	16- 4	8	12 - 4,5	F512	40,25	FK 40,5	115	32	179	5		F701F0001
								110	32	173	4	F501F0013	
								145	32	208	4	F501F0010	

Lieferumfang: Werkzeughalter, Befestigungsschraube, Schraubendreher

Scope of delivery: Tool holder, mounting screw, screw driver

Contenu de la livraison: Porte d'outil, vis de fixation, tournevis

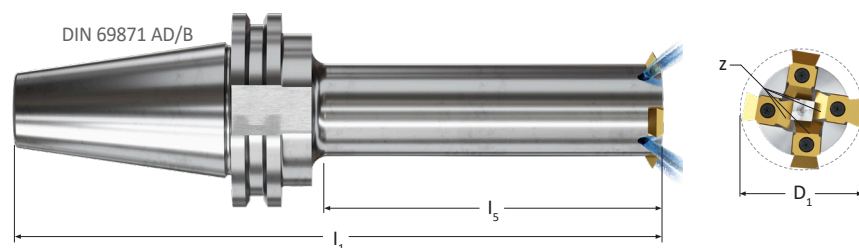
Volume di consegna: portautensili, vite di fissaggio, cacciavite

Bitte Wendeplatten separat bestellen

Please order inserts separately

Commandez la plaquette séparément

Ordina gli inserti separatamente



	M / MF	UN	NPT	G / W		D ₁		l _s	ø d ₂	l ₁	z									
[mm]	P [mm]	Gg/1" [tpi]	Gg/1" [tpi]	Gg/1" [tpi]		[mm]														
≥ ø 43,00	1,5- 6	16- 4	8	12 - 4,5	F512	40,25	FK 40,5	110	BT40	217	4	F505F0029								
									BT50	264	4	F505AADAF								
									SK40	212	4	F505AADAA								
									SK50	245	4	F505AADAC								
								145	BT40	252	4	F505F0028								
									BT50	299	4	F505F0025								
									SK40	247	4	F505AAWAA								
									SK50	280	4	F505AAWAB								
								150	BT50	305	4	F505F0031								
									SK40	253	4	F505AAEAA								
									SK50	286	4	F505AAEAB								
								195	BT50	350	4	F505F0026								
SK50	331	4	F505F0007																	
≥ ø 70,50	1,5- 6	16- 4	8	12 - 3,5	F513	66,55	FK 67		170	BT50	327	7	F505F0042							
								SK50		308	7	F505AACAA								
								260	BT50	417	7	F505F0034								
									SK50	398	7	F505E5553								
								≥ ø 100,00	6 - 8	4	-	-	F514	92	FK 92	204	SK50	341	7	F505AA2AA
																360	SK50	497	7	F505F0008

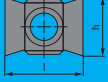
Lieferumfang: Werkzeughalter, Befestigungsschraube, Schraubendreher
 Scope of delivery: Tool holder, mounting screw, screw driver
 Contenu de la livraison: Porte d'outil, vis de fixation, tournevis
 Volume di consegna: portautensili, vite di fissaggio, cacciavite

Bitte Wendeplatten separat bestellen
 Please order inserts separately
 Commandez la plaquette séparément
 Ordina gli inserti separatamente



SCHNEIDSTOFF / MATERIAL
MATIÈRE / MATERIALE

OBERFLÄCHE / SURFACE
SURFACE / SUPERFICIE

ø D [mm]		ø D _{1 min} [mm]		l [mm]	h [mm]	b [mm]				Gg/1" [tpi]	K20	TIN	K20	TIALN
							M / MF P [mm]	UN Gg/1" [tpi]						
FK 16,5/18	F521	16,5	7	5	3,18		1,5- 3	16- 9	14- 11,5				F521F0002	F521F0004
	F522	18	7,8	5	3,18		2,5- 3,5	10- 7		28 - 9			F521F0005	F521F0008
FK 20,5/22	F521	20,5	7	5	3,18		1,5- 3	16- 9					F522F0001	F522F0002
	F522	22	7,8	5	3,18		2,5- 3,5	10- 7		28 - 9			F521F0002	F521F0004
FK 24	F510	23,85	9,52	6,35	3,3		1,0- 2,5	24- 10	14- 11,5				F521F0005	F521F0008
	F710	23,85	9,52	5	3,3		1,5- 2,5	16- 10	14- 11,5				F522F0001	F522F0002
FK 27	F750	27	9,52	5	3,3		2,5- 4,0	10- 6		28 - 9				
							1,0- 2,5	24- 10						
FK 29,5	F510	29,27	9,52	6,35	3,3		1,5- 2,5	16- 10	14- 11,5					
							2,5- 4,0	10- 6		28 - 9				
FK 33	F511	32,85	13,5	8,5	3,97		1,5- 2,5	16- 10	14- 11,5					
	F711	32,85	10	7	3,97		2,5- 5,5	10- 4,5		28 - 9				
FK 40,5	F512	40,25	15,5	9,5	5		2,5- 5,5	10- 4,5						
							1,5- 3,0	16- 9	8				F711F0001	
FK 53	F513	52,55	19	12,5	6		3,0- 6,0	9- 4		12 - 4,5				
							1,5- 3,0	16- 9						
FK 67	F513	66,55	19	12,5	6		3,0- 6,0	9- 4		12 - 3,5				
							1,5- 3,0	16- 9						
FK 92	F514	92	28,58	14,3	9,5		3,0- 6,0	9- 4						
							6,0- 8,0	4						

Andere Gewindesysteme auf Anfrage, z.B.: | Other thread standards upon request, e.g.: | Autres standards de filetage sur demande, p.ex.: | Altri sistemi di filettatura su richiesta, p. es.:

Tr



Trapez-Gewinde, ACME-
Gewinde
Trapezoidal thread, ACME
thread
Filetage trapézoïdal, filetage
ACME
Filettatura trapezoidale,
fil. ACME

S



Säbengewinde
Buttress thread
Filetage pas d'artillerie
Filettatura a dente di sega

RD

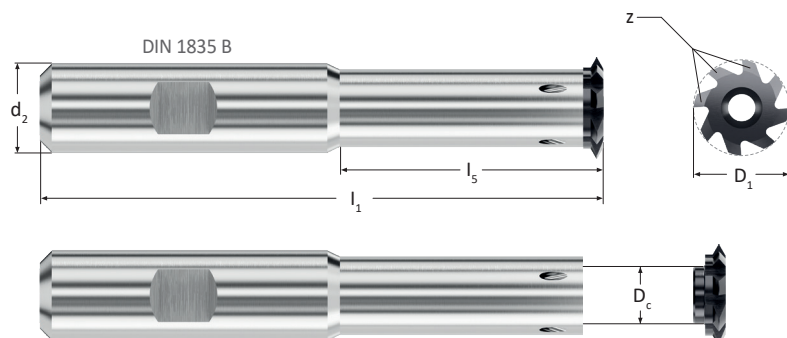


Rundgewinde
Round thread
Filetage rond
Filettatura tonda

Sonderkonturen auf Anfrage | Special contours upon request | Profils spéciaux sur demande | Profili speciali su richiesta



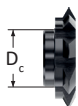
K20	K20					
TIN	TIALN					
				M ₁ Nm		
		M2,5	7 IP	0,9	F550F0001	1033F0001
		M2,5	7 IP	0,9	F550F0001	1033F0001
F510AAAAA	F510F0012	M2,5	7 IP	0,9	F550F0001	1033F0001
F510AACAA	F510F0003					
F510AABAA	F510F0005					
	F510F0004					
	F750F0002	M2,5	7 IP	0,9	F550F0001	1033F0001
	F510F0012					
F510AAAAA	F510F0003	M2,5	7 IP	0,9	F550F0001	1033F0001
F510AACAA	F510F0005					
F510AABAA	F510F0004					
F511AAAAA	F511F0001	M3	9 IP	2,5	F550F0002	1033F0002
F511AACAA	F511F0003					
F511AABAA	F511F0002					
F512AAAAA	F512F0001	M4	15 IP	5,5	F550F0003	1033F0003
F512AACAA	F512F0003					
F512AABAA	F512F0002					
F513AAAAA	F513F0001	M5	20 IP	8	F550F0004	1033F0004
F513AACAA	F513F0003					
F513AABAA	F513F0002					
F513AAAAA	F513F0001	M5	20 IP	8	F550F0004	1033F0004
F513AACAA	F513F0003					
F513AABAA	F513F0002					
F514AAAAA	F514F0005	M5	20 IP	8	F550F0005	1033F0004



	M / MF	UN	G		D _c	ø d ₂	z	l ₁	l ₅		l ₁	l ₅	
[mm]	P [mm]	Gg/1" [tpi]	Gg/1" [tpi]		[mm]	[mm]		[mm]	[mm]		[mm]	[mm]	
≥ Ø 10,2	1- 1,75	24- 13	G 1/4	19- 32	Ø 5,4	10	6	68	24	F50ZNES1010	74	30	F50ZNES1017
≥ Ø 12,0	1- 2	24- 12	G 3/8	16- 26	Ø 6,5	10	7	71,5	28	F50ZNES1011	78,5	35	F50ZNES1018
≥ Ø 14,0	1- 2	24- 12	G 3/8	16- 26	Ø 7,9	12	8	78	32	F50ZNES1016	86	40	F50ZNES1023
≥ Ø 17,5	1,5- 2,5	16- 10	G 1/2, G 5/8	14- 20	Ø 9,2	14	8	88	40	F50ZNES1012	98	50	F50ZNES1019
≥ Ø 20,4	1,5- 3	16- 8	> G 3/4	10- 14	Ø 11,4	16	8	99	48	F50ZNES1013	111	60	F50ZNES1020
≥ Ø 26,5	2- 3,5	12- 7	> G 7/8	8- 14	Ø 14,6	20	9	115	60	F50ZNES1014	130	75	F50ZNES1021
≥ Ø 32,0	3- 4	8- 6	G 1 1/8	7- 11	Ø 17,8	25	10	133	72	F50ZNES1015	151	90	F50ZNES1022

Lieferumfang: Werkzeughalter, Befestigungsschraube
 Scope of delivery: Tool holder, mounting screw
 Contenu de la livraison: Porte d'outil, vis de fixation
 Volume di consegna: portautensili, vite di fissaggio

Bitte Schneidplatten separat bestellen
 Please order inserts separately
 Commandez la plaquette séparément
 Ordina gli inserti separatamente



ACR



ACR

D _c [mm]	Ø D _{min.} mm	l _s mm	Ø d ₁ mm	z	M / MF	UN		G		
					P [mm]	Gg/1" [tpi]			Gg/1" [tpi]	
Ø 5,4	12	24	9,9	6	1- 1,75	24- 13	F52ZNES10912	G 1/4	19- 32	F52ZNES10945
Ø 6,5	14	28	11,6	7	1- 2	24- 12	F52ZNES20912	G 3/8	16- 26	F52ZNES20945
Ø 7,9	16	32	13,6	8	1- 2	24- 12	F52ZNES70912	G 3/8	16- 26	F52ZNES70945
Ø 9,2	20	40	15,9	8	1,5- 2,5	16- 10	F52ZNES30914	G 1/2, G 5/8	14- 20	F52ZNES30948
Ø 11,4	24	48	19,9	8	1,5- 3	16- 8	F52ZNES40914	> G 3/4	10- 14	F52ZNES40950
Ø 14,6	30	60	24,9	9	2- 3,5	12- 7	F52ZNES50916	> G 7/8	8- 14	F52ZNES50950
Ø 17,8	36	72	29,9	10	3- 4	8- 6	F52ZNES60918	G 1 1/8	7- 11	F52ZNES60950



D _c [mm]			M ₁ Nm		
Ø 5,4	M2,5 x 8,5	7 IP	0,9	F550F0001	1033F0001
Ø 6,5	M3 x 11	9 IP	2,5	F550F0002	1033F0002
Ø 7,9	M3 x 11	9 IP	2,5	F550F0002	1033F0002
Ø 9,2	M4 x 13	15 IP	5,5	F550F0003	1033F0003
Ø 11,4	M5 x 15	20 IP	8	F550F0004	1033F0004
Ø 14,6	M5 x 15	20 IP	8	F550F0004	1033F0004
Ø 17,8	M5 x 15	20 IP	8	F550F0004	1033F0004

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