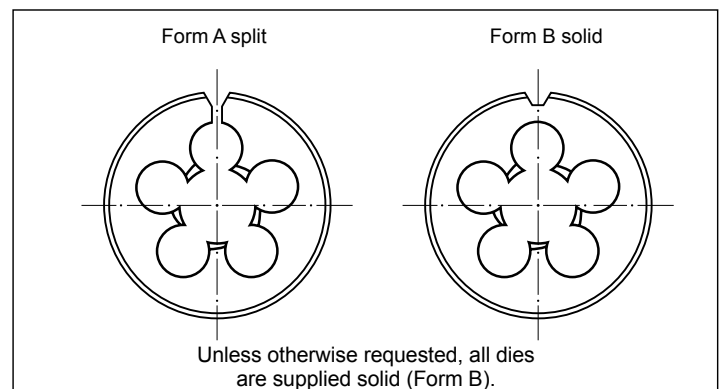
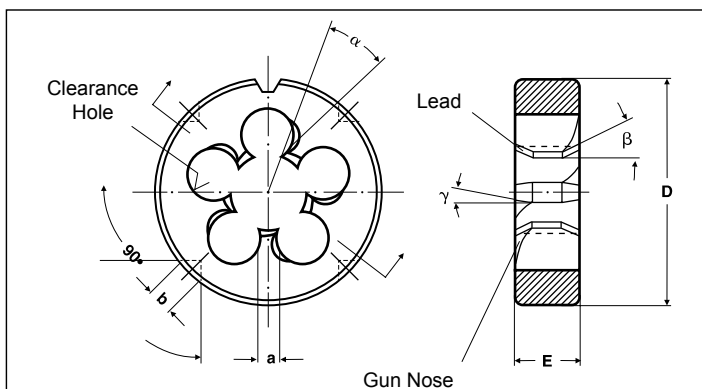




Recommended applications for Round Dies

	VS HSS 	VS HSS 	VE HSSE 	VX HSSE-VAP 	MS HSS 	Coolants and lubrications
Thread cutting by hand	●	●	●	●	●	
Machine use	○		○	●	○	
Steel, unalloyed; tensile strength < 800N/mm ²	●	●	●	●		Thread cutting oil also with lubricity-increasing additives, emulsion
Machining steels, case hardening steels, tempered steels; tensile strength < 800 N/mm ²	○	○	●	●		
Steel, unalloyed; tensile strength < 1000N/mm ²			●	●		
Steel, alloyed and unalloyed; tensile strength < 1200 N/mm ²			○	●		Thread cutting oil, thread cutting oil highly activated with special additives, emulsion
Rust- and acid-resistant steels; VA-steels < 850 N/mm ²			○	●		
Rust- and acid-resistant steels with high chromium-nickel content, V4A steels				●		
Brass, short-chipping					●	Thread cutting oil for non-ferrous metals, emulsion
Brass, long-chipping	○	○	●			
Bronze, short-chipping					●	
Copper alloys			○	●		
Aluminium, short-chipping				●		
Aluminium, long-chipping	○	○	●			
Titanium alloys; tensile strength < 1200 N/mm ²				○		Special thread cutting oil
Thermosetting plastics					●	Oil mist, compressed air, mold release oil

● = appropriate ○ = conditionally suitable



- | | |
|----------------------------------|----------------------------|
| D Outside diameter | α Rake angle |
| E Width of die | β Lead angle |
| a Width of land | γ Angle of gun nose |
| b Hole for holding screws | |