

ZÁVITOVÉ KRUHOVÉ  
ČELISTI  
CIRCULAR DIES  
SCHNEIDEISEN  
ПЛАШКИ

M

MF

Pg

BSW (W)

BSF (W)

G

UNC

UNF

UNEF

NPT



**BUČOVICE**  
**TOOLS a.s.**

# ZÁVITOVÉ KRUHOVÉ ČELISTI CIRCULAR DIES SCHNEIDEISEN ПЛАШКИ

|         |         |         |    |    |    |
|---------|---------|---------|----|----|----|
| M       | M       | M       | M  | M  | M  |
| MF      | MF      | MF      | MF | MF | MF |
| G       | G       | G       | G  | G  |    |
| BSW (W) | BSW (W) | BSW (W) |    |    |    |
| BSF (W) | BSF (W) | BSF (W) |    |    |    |
| Pg      | Pg      | Pg      |    |    |    |
| UNC     | UNC     | UNC     |    |    |    |
| UNF     | UNF     | UNF     |    |    |    |
| UNEF    | UNEF    | UNEF    |    |    |    |
|         | NPT     |         |    |    |    |

Norma / Standard / Norm / Стандарт

|   |  |                                |                                |                                |                      |
|---|--|--------------------------------|--------------------------------|--------------------------------|----------------------|
| DIN EN 22 568<br>PN 8/3225<br>DIN EN 24 231 | DIN EN 22 568<br>PN 8/3225<br>DIN EN 24 231<br>PN 8/B 4451<br>DIN 382<br>DIN EN 24 230<br>BS-1127:1950 | DIN EN 22 568<br>DIN EN 24 231 | DIN EN 22 568<br>DIN EN 24 231 | DIN EN 22 568<br>DIN EN 24 231 | ČSN 22 3216          |
|   |  |                                |                                |                                |                      |
| NO/CS<br>$v_c$ [m/min]                      | HSS<br>$v_c$ [m/min]   | HSS*<br>$v_c$ [m/min]          | HSSE<br>$v_c$ [m/min]          | HSSE-VA<br>$v_c$ [m/min]       | HSS<br>$v_c$ [m/min] |

|          |   |     |      |      |      |      |      |       |
|----------|---|-----|------|------|------|------|------|-------|
| <b>P</b> | 1 | 1-4 | 2-8  | 4-10 | 2-8  | 3-10 | 2-8  | O/E   |
|          | 2 |     | 3-6  | 4-10 | 3-6  | 4-10 | 3-6  | O/E   |
|          | 3 | 1-4 | 2-8  | 4-10 | 2-8  | 5-10 | 2-8  | O/E   |
|          | 4 |     | 1-3  | 1-3  | 1-3  | 2-4  | 1-3  | O     |
|          | 5 |     |      |      |      | 1-3  |      | O     |
|          | 6 | 1-3 | 2-4  | 2-4  | 2-4  | 2-5  | 2-4  | O/E   |
|          | 7 |     | 1-3  | 1-3  | 1-3  | 2-4  | 1-3  | O/E   |
| <b>M</b> | 1 |     |      |      |      | 1-3  |      | O     |
|          | 2 |     |      |      |      |      |      |       |
| <b>K</b> | 1 |     | 2-4  | 2-4  | 2-4  | 1-3  | 2-4  | O     |
|          | 2 |     | 3-5  | 3-5  | 3-5  | 3-5  | 3-5  | O     |
|          | 3 |     | 3-5  | 3-5  | 3-5  | 3-5  | 3-5  | O/E   |
| <b>N</b> | 1 | 1-3 | 2-4  | 2-4  | 2-4  | 3-5  | 2-4  | O/E   |
|          | 2 | 1-3 | 2-4  | 2-4  | 2-4  | 3-5  | 2-4  | O/E   |
|          | 3 | 1-3 | 2-4  | 2-5  | 2-4  | 4-6  | 2-4  | O/E   |
|          | 4 | 2-4 | 4-8  | 4-8  | 4-8  |      | 4-8  | O/E   |
|          | 5 | 2-4 | 4-8  | 4-8  | 4-8  |      | 4-8  | O/P/E |
|          | 6 | 2-5 | 5-10 | 5-10 | 5-10 |      | 5-10 | O/E   |
|          | 7 | 2-4 | 4-8  | 4-8  | 4-8  |      |      | V/O/E |
|          | 8 | 2-4 | 4-8  | 4-8  | 4-8  |      |      | V/O/E |
| <b>S</b> |   |     |      |      |      |      |      |       |
| <b>H</b> | 1 |     |      |      |      |      |      |       |
|          | 2 |     |      |      |      |      |      |       |
|          | 3 |     |      |      |      |      |      |       |

<sup>\*)</sup> s lamačem třísek / with spiral point / mit Schälanschnitt / с ломателем стружек

Omezené použití / Possible use / Geeignet / Ограниченно

Doporučené použití / Optimal use / Optimal / Оптимально

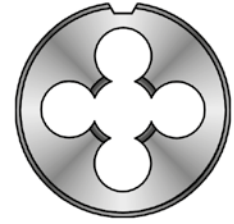
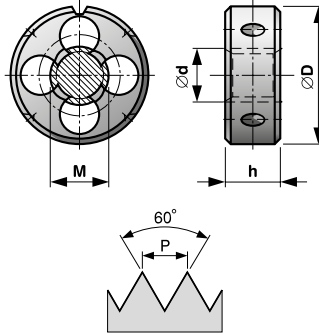
**BUČOVICE  
TOOLS a.s.**

# DIN EN 22 568

**HOBBY  
NO**

**STANDARD  
HSS**

**Závitové kruhové  
čelisti  
Circular dies  
Schneideisen  
Плашки**




Metrický závit ISO DIN 13  
Standard metric thread ISO DIN 13  
Metrische Regelgewinde ISO DIN 13  
Метрическая резьба ISO DIN 13

Licování: 6g (6h, 6e - dle požadavku zákazníka) / Tolerance: 6g  
(6h, 6e - on request) / Toleranz: 6g (6h, 6e - nach dem Anspruch) /  
Подгонка: 6g (6h, 6e - по заказу)



1,5P

**M**

|       | P    | ØD  | h  | S |  | code <sup>x)</sup> |
|-------|------|-----|----|---|---|--------------------|
| M 1   | 0,25 | 16  | 5  | 3 | 0,97  | XXX 010            |
| M 1,1 | 0,25 | 16  | 5  | 3 | 1,07  | XXX 011            |
| M 1,2 | 0,25 | 16  | 5  | 3 | 1,17  | XXX 012            |
| M 1,4 | 0,3  | 16  | 5  | 3 | 1,36  | XXX 014            |
| M 1,6 | 0,35 | 16  | 5  | 3 | 1,54  | XXX 016            |
| M 1,8 | 0,35 | 16  | 5  | 3 | 1,74  | XXX 018            |
| M 2   | 0,4  | 16  | 5  | 3 | 1,93  | XXX 020            |
| M 2,2 | 0,45 | 16  | 5  | 3 | 2,13  | XXX 022            |
| M 2,5 | 0,45 | 16  | 5  | 3 | 2,43  | XXX 025            |
| M 3   | 0,5  | 20  | 5  | 3 | 2,92  | XXX 030            |
| M 3,5 | 0,6  | 20  | 5  | 3 | 3,41  | XXX 035            |
| M 4   | 0,7  | 20  | 5  | 3 | 3,91  | XXX 040            |
| M 4,5 | 0,75 | 20  | 5  | 3 | 4,41  | XXX 045            |
| M 5   | 0,8  | 20  | 7  | 4 | 4,90  | XXX 050            |
| M 6   | 1    | 20  | 7  | 4 | 5,88  | XXX 060            |
| M 7   | 1    | 25  | 9  | 4 | 6,88  | XXX 070            |
| M 8   | 1,25 | 25  | 9  | 4 | 7,87  | XXX 080            |
| M 9   | 1,25 | 25  | 9  | 4 | 8,87  | XXX 090            |
| M 10  | 1,5  | 30  | 11 | 4 | 9,85  | XXX 100            |
| M 11  | 1,5  | 30  | 11 | 5 | 10,85   | XXX 110            |
| M 12  | 1,75 | 38  | 14 | 4 | 11,83   | XXX 120            |
| M 14  | 2    | 38  | 14 | 5 | 13,82   | XXX 140            |
| M 16  | 2    | 45  | 18 | 5 | 15,82   | XXX 160            |
| M 18  | 2,5  | 45  | 18 | 5 | 17,79   | XXX 180            |
| M 20  | 2,5  | 45  | 18 | 6 | 19,79   | XXX 200            |
| M 22  | 2,5  | 55  | 22 | 5 | 21,79   | XXX 220            |
| M 24  | 3    | 55  | 22 | 6 | 23,76   | XXX 240            |
| M 27  | 3    | 65  | 25 | 6 | 26,76   | XXX 270            |
| M 30  | 3,5  | 65  | 25 | 7 | 29,73   | XXX 300            |
| M 33  | 3,5  | 65  | 25 | 8 | 32,73   | XXX 330            |
| M 36  | 4    | 65  | 25 | 9 | 35,70   | XXX 360            |
| M 39  | 4    | 75  | 30 | 8 | 38,70   | XXX 390            |
| M 45  | 4,5  | 90  | 36 | 8 | 44,69   | XXX 450            |
| M 48  | 5    | 90  | 36 | 8 | 47,66   | XXX 480            |
| M 52  | 5    | 90  | 36 | 9 | 51,66   | XXX 520            |
| M 56  | 5,5  | 105 | 36 | 8 | 55,65   | XXX 560            |
| M 60  | 5,5  | 105 | 36 | 8 | 59,65   | XXX 600            |
| M 64  | 6    | 120 | 36 | 8 | 63,62   | XXX 640            |
| M 68  | 6    | 120 | 36 | 8 | 67,62   | XXX 680            |

x) 210 XXX - NO / CS / WS do M 30 / to M 30 / bis M 30 / до M 30

x) 240 XXX - HSS pravý závit / right hand thread / rechts Gewinde / правая резьба

x) 250 XXX - HSS LH závit / LH thread / LH Gewinde / LH резьба

x) 270 XXX - HSS s lamačem třísek / with spiral point / mit Schälanschnitt / с ломателем стружек

x) 280 XXX - HSS LH s lamačem třísek / LH with spiral point / LH mit Schälanschnitt / LH с ломателем стружек



**BUČOVICE  
TOOLS a.s.**

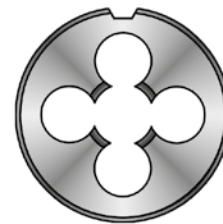
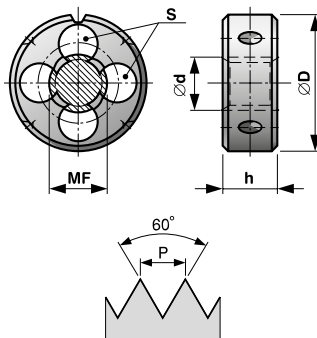
Materiál: NO; HSS  
- dle požadavku  
Provedení: závit lapovaný  
do M 26  
Závit: pravý, levý

Material: CS; HSS  
- on request  
Execution: lapped thread  
to M 26  
Thread: right-hand, left-hand

Werkstoff: WS; HSS  
- nach dem Anspruch  
Ausführung: geläppte  
Gewinde bis M 26  
Gewinde: rechts, links

Материал: NO; HSS  
- по заказу  
Изготовлено: резьба  
шлифованная до M 26  
Резьба: правая, левая

### Závitové kruhové čelisti Circular dies Schneideisen Плашки



Jemný metrický závit ISO DIN 13  
Fine metric thread ISO DIN 13  
Metrische Feingewinde ISO DIN 13  
Мелкая метрическая резьба ISO DIN 13

Licování: 6g (6h, 6e - dle požadavku zákazníka) / Tolerance: 6g  
(6h, 6e - on request) / Toleranz: 6g (6h, 6e - nach dem Anspruch) /  
Подгонка: 6g (6h, 6e - по заказу)



1,5P

MF

|        | P    | ØD | h  | S |       | code <sup>x)</sup> |
|--------|------|----|----|---|-------|--------------------|
| MF 2,5 | 0,35 | 16 | 5  | 3 | 2,44  | XXX 026            |
| MF 3   | 0,35 | 20 | 5  | 3 | 2,94  | XXX 031            |
| MF 3,5 | 0,35 | 20 | 5  | 3 | 3,44  | XXX 036            |
| MF 4   | 0,5  | 20 | 5  | 3 | 3,93  | XXX 041            |
| MF 4,5 | 0,5  | 20 | 5  | 3 | 4,43  | XXX 046            |
| MF 5   | 0,5  | 20 | 5  | 4 | 4,93  | XXX 051            |
| MF 5,5 | 0,5  | 20 | 5  | 4 | 5,43  | XXX 056            |
| MF 6   | 0,75 | 20 | 7  | 4 | 5,91  | XXX 061            |
| MF 7   | 0,75 | 25 | 9  | 4 | 6,90  | XXX 071            |
| MF 8   | 1    | 25 | 9  | 4 | 7,88  | XXX 081            |
| MF 8   | 0,75 | 25 | 9  | 4 | 7,90  | XXX 082            |
| MF 9   | 1    | 25 | 9  | 4 | 8,88  | XXX 091            |
| MF 9   | 0,75 | 25 | 9  | 4 | 8,90  | XXX 092            |
| MF 10  | 1,25 | 30 | 11 | 4 | 9,86  | XXX 101            |
| MF 10  | 1    | 30 | 11 | 4 | 9,88  | XXX 102            |
| MF 10  | 0,75 | 30 | 11 | 4 | 9,90  | XXX 103            |
| MF 11  | 1    | 30 | 11 | 5 | 10,88 | XXX 111            |
| MF 11  | 0,75 | 30 | 11 | 5 | 10,91 | XXX 112            |
| MF 12  | 1,5  | 38 | 10 | 4 | 11,85 | XXX 121            |
| MF 12  | 1,25 | 38 | 10 | 4 | 11,86 | XXX 122            |
| MF 12  | 1    | 38 | 10 | 4 | 11,88 | XXX 123            |
| MF 14  | 1,5  | 38 | 10 | 5 | 13,85 | XXX 141            |
| MF 14  | 1,25 | 38 | 10 | 5 | 13,86 | XXX 142            |
| MF 14  | 1    | 38 | 10 | 5 | 13,88 | XXX 143            |
| MF 15  | 1,5  | 38 | 10 | 5 | 14,85 | XXX 151            |
| MF 15  | 1    | 38 | 10 | 5 | 14,88 | XXX 152            |
| MF 16  | 1,5  | 45 | 14 | 5 | 15,85 | XXX 161            |
| MF 16  | 1    | 45 | 14 | 5 | 15,88 | XXX 162            |
| MF 17  | 1,5  | 45 | 14 | 5 | 16,85 | XXX 171            |
| MF 17  | 1    | 45 | 14 | 5 | 16,38 | XXX 172            |
| MF 18  | 2    | 45 | 14 | 5 | 17,82 | XXX 181            |
| MF 18  | 1,5  | 45 | 14 | 5 | 17,85 | XXX 182            |
| MF 18  | 1    | 45 | 14 | 5 | 17,88 | XXX 183            |
| MF 20  | 2    | 45 | 14 | 6 | 19,82 | XXX 201            |
| MF 20  | 1,5  | 45 | 14 | 6 | 19,85 | XXX 202            |
| MF 20  | 1    | 45 | 14 | 6 | 19,88 | XXX 203            |
| MF 22  | 2    | 55 | 16 | 5 | 21,82 | XXX 221            |
| MF 22  | 1,5  | 55 | 16 | 5 | 21,85 | XXX 222            |
| MF 22  | 1    | 55 | 16 | 5 | 21,88 | XXX 223            |
| MF 24  | 2    | 55 | 16 | 6 | 23,82 | XXX 241            |
| MF 24  | 1,5  | 55 | 16 | 6 | 23,85 | XXX 242            |
| MF 24  | 1    | 55 | 16 | 6 | 23,88 | XXX 243            |
| MF 25  | 1,5  | 55 | 16 | 6 | 24,85 | XXX 251            |
| MF 26  | 1,5  | 55 | 16 | 6 | 25,85 | XXX 261            |
| MF 27  | 2    | 65 | 18 | 6 | 26,82 | XXX 271            |
| MF 27  | 1,5  | 65 | 18 | 6 | 26,85 | XXX 272            |
| MF 27  | 1    | 65 | 18 | 6 | 26,88 | XXX 273            |
| MF 28  | 2    | 65 | 18 | 6 | 27,82 | XXX 281            |
| MF 28  | 1,5  | 65 | 18 | 6 | 27,85 | XXX 282            |
| MF 30  | 2    | 65 | 18 | 6 | 29,82 | XXX 301            |
| MF 30  | 1,5  | 65 | 18 | 6 | 29,85 | XXX 302            |
| MF 30  | 1    | 65 | 18 | 6 | 29,88 | XXX 303            |
| MF 32  | 1,5  | 65 | 18 | 7 | 31,85 | XXX 321            |
| MF 33  | 2    | 65 | 18 | 8 | 32,82 | XXX 331            |
| MF 33  | 1,5  | 65 | 18 | 8 | 32,85 | XXX 332            |
| MF 33  | 1,5  | 65 | 18 | 9 | 34,85 | XXX 351            |
| MF 36  | 3    | 65 | 25 | 9 | 35,76 | XXX 361            |
| MF 36  | 2    | 65 | 18 | 9 | 35,82 | XXX 362            |
| MF 39  | 3    | 75 | 30 | 8 | 38,76 | XXX 391            |
| MF 39  | 2    | 75 | 20 | 8 | 38,82 | XXX 392            |

Materiál: NO; HSS  
Provedení: závit lapovaný  
do M 26  
Závit: pravý, levý

Material: CS; HSS  
Execution: lapped thread  
to M 26  
Thread: right-hand, left-hand

Werkstoff: WS; HSS  
Ausführung: geläpftes  
Gewinde bis M 26  
Gewinde: rechts, links

Материал: NO; HSS  
Изготовлено: резьба  
шлифованная до M 26  
Резьба: правая, левая





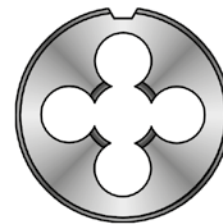
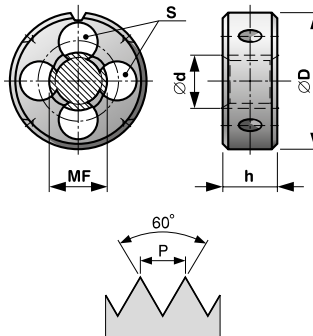
# DIN EN 22 568

**PROFI  
HSSE**

**PROFI  
HSSE VA**

**PROFI  
HSSE VA-NT**

**Závitové kruhové  
čelisti  
Circular dies  
Schneideisen  
Плашки**




Jemný metrický závit ISO DIN 13  
Fine metric thread ISO DIN 13  
Metrische Feingewinde ISO DIN 13  
Мелкая метрическая резьба ISO DIN 13

Lícování: 6g / Tolerance: 6g /  
Toleranz: 6g / Подгонка: 6g



2P

**MF**

|        | P    | ØD | h  | S |  | code <sup>x)</sup> |
|--------|------|----|----|---|---|--------------------|
| MF 2,5 | 0,35 | 16 | 5  | 4 | 2,44  | XXX 026            |
| MF 3   | 0,35 | 20 | 5  | 4 | 2,94  | XXX 031            |
| MF 3,5 | 0,35 | 20 | 5  | 4 | 3,44  | XXX 036            |
| MF 4   | 0,5  | 20 | 5  | 4 | 3,93  | XXX 041            |
| MF 4,5 | 0,5  | 20 | 5  | 4 | 4,43  | XXX 046            |
| MF 5   | 0,5  | 20 | 5  | 4 | 4,93  | XXX 051            |
| MF 5,5 | 0,5  | 20 | 5  | 4 | 5,43  | XXX 056            |
| MF 6   | 0,75 | 20 | 7  | 4 | 5,91  | XXX 061            |
| MF 7   | 0,75 | 25 | 9  | 4 | 6,90  | XXX 071            |
| MF 8   | 1    | 25 | 9  | 5 | 7,87  | XXX 081            |
| MF 8   | 0,75 | 25 | 9  | 5 | 7,90  | XXX 082            |
| MF 9   | 1    | 25 | 9  | 5 | 8,88  | XXX 091            |
| MF 9   | 0,75 | 25 | 9  | 5 | 8,90  | XXX 092            |
| MF 10  | 1,25 | 30 | 11 | 5 | 9,86  | XXX 101            |
| MF 10  | 1    | 30 | 11 | 5 | 9,88  | XXX 102            |
| MF 10  | 0,75 | 30 | 11 | 5 | 9,90  | XXX 103            |
| MF 11  | 1    | 30 | 11 | 5 | 10,88   | XXX 111            |
| MF 11  | 0,75 | 30 | 11 | 5 | 10,91   | XXX 112            |
| MF 12  | 1,5  | 38 | 10 | 5 | 11,85   | XXX 121            |
| MF 12  | 1,25 | 38 | 10 | 5 | 11,86   | XXX 122            |
| MF 12  | 1    | 38 | 10 | 5 | 11,88   | XXX 123            |
| MF 14  | 1,5  | 38 | 10 | 5 | 13,85   | XXX 141            |
| MF 14  | 1,25 | 38 | 10 | 5 | 13,86   | XXX 142            |
| MF 14  | 1    | 38 | 10 | 5 | 13,88   | XXX 143            |
| MF 15  | 1,5  | 38 | 10 | 5 | 14,85   | XXX 151            |
| MF 15  | 1    | 38 | 10 | 5 | 14,88   | XXX 152            |
| MF 16  | 1,5  | 45 | 14 | 5 | 15,85   | XXX 161            |
| MF 16  | 1    | 45 | 14 | 5 | 15,88   | XXX 162            |
| MF 17  | 1,5  | 45 | 14 | 5 | 16,85   | XXX 171            |
| MF 17  | 1    | 45 | 14 | 5 | 16,88   | XXX 172            |
| MF 18  | 2    | 45 | 14 | 5 | 17,82   | XXX 181            |
| MF 18  | 1,5  | 45 | 14 | 5 | 17,85   | XXX 182            |
| MF 18  | 1    | 45 | 14 | 5 | 17,88   | XXX 183            |
| MF 20  | 2    | 45 | 14 | 5 | 19,82   | XXX 201            |
| MF 20  | 1,5  | 45 | 14 | 5 | 19,85   | XXX 202            |
| MF 20  | 1    | 45 | 14 | 5 | 19,88   | XXX 203            |
| MF 22  | 2    | 55 | 16 | 5 | 21,82   | XXX 221            |
| MF 22  | 1,5  | 55 | 16 | 5 | 21,85   | XXX 222            |
| MF 22  | 1    | 55 | 16 | 5 | 21,88   | XXX 223            |
| MF 24  | 2    | 55 | 16 | 6 | 23,82   | XXX 241            |
| MF 24  | 1,5  | 55 | 16 | 6 | 23,85   | XXX 242            |
| MF 24  | 1    | 55 | 16 | 6 | 23,88   | XXX 243            |
| MF 25  | 1,5  | 55 | 16 | 6 | 24,85   | XXX 251            |
| MF 26  | 1,5  | 55 | 16 | 6 | 25,85   | XXX 261            |
| MF 27  | 2    | 65 | 18 | 6 | 26,82   | XXX 271            |
| MF 27  | 1,5  | 65 | 18 | 6 | 26,85   | XXX 272            |
| MF 27  | 1    | 65 | 18 | 6 | 26,88   | XXX 273            |
| MF 28  | 2    | 65 | 18 | 6 | 27,82   | XXX 281            |
| MF 28  | 1,5  | 65 | 18 | 6 | 27,85   | XXX 282            |
| MF 30  | 2    | 65 | 18 | 6 | 29,82   | XXX 301            |
| MF 30  | 1,5  | 65 | 18 | 6 | 29,85   | XXX 302            |
| MF 30  | 1    | 65 | 18 | 6 | 29,88   | XXX 303            |

x) 290 XXX - HSSE

x) 295 XXX - HSSE s lamačem třísek / with spiral point / mit Schälanschnitt / с ломателем стружек

x) 300 XXX - HSSE VA - na nerez / stainless steel / Rostfreistähle / нержавейка

x) 301 XXX - HSSE VA-NT - na nerez - nitridace / stainless steel - nitration / Rostfreistähle - Nitrierung / нержавейка - нитрирование



**BUČOVICE  
TOOLS a.s.**

Materiál: HSSE, HSSE VA-NT  
- dle požadavku  
Provedení: závit lapovaný  
Závit: pravý

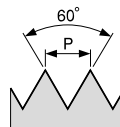
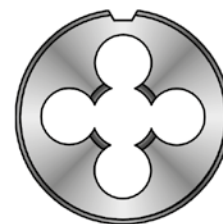
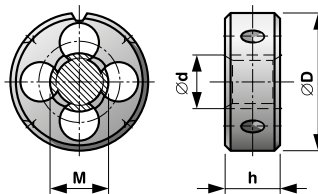
Material: HSSE, HSSE VA-NT  
- on request  
Execution: lapped thread  
Thread: right-hand

Werkstoff: HSSE,  
HSSE VA-NT - nach dem  
Anspruch  
Ausführung: geläpftes Ge-  
winde  
Gewinde: rechts

Материал: HSSE,  
HSSE VA-NT - по заказу  
Изготовлено: резьба  
шлифованная  
Резьба: правая

**PN 8/3225****HOBBY  
NO****STANDARD  
HSS**

**Závitové kruhové  
čelisti  
Circular dies  
Schneideisen  
Плашки**



Lícování: 6g / Tolerance: 6g /  
Toleranz: 6g / Подгонка: 6g



1,5P

**M**

Metrický závit ISO DIN 13  
Standard metric thread ISO DIN 13  
Metrische Regelgewinde ISO DIN 13  
Метрическая резьба ISO DIN 13

**MF**

Jemný metrický závit ISO DIN 13  
Fine metric thread ISO DIN 13  
Metrische Feingewinde ISO DIN 13  
Мелкая метрическая резьба ISO DIN 13

|      | P    | ØD | h  | S |       | code NO/CS | code HSS |
|------|------|----|----|---|-------|------------|----------|
| M 3  | 0,5  | 25 | 9  | 3 | 2,92  | 230 030    | 260 030  |
| M 4  | 0,7  | 25 | 9  | 3 | 3,91  | 230 040    | 260 040  |
| M 5  | 0,8  | 25 | 9  | 4 | 4,90  | 230 050    | 260 050  |
| M 6  | 1    | 25 | 9  | 4 | 5,88  | 230 060    | 260 060  |
| M 7  | 1    | 25 | 9  | 4 | 6,90  | 230 070    | 260 070  |
| M 8  | 1,25 | 25 | 9  | 4 | 7,87  | 230 080    | 260 080  |
| M 8  | 1    | 25 | 9  | 4 | 7,88  | 230 081    | 260 081  |
| M 10 | 1,5  | 25 | 9  | 5 | 9,85  | 230 100    | 260 100  |
| M 10 | 1    | 25 | 9  | 5 | 9,88  | 230 101    | 260 101  |
| M 12 | 1,75 | 25 | 9  | 5 | 11,83 | 230 120    | 260 120  |
| M 12 | 1,5  | 25 | 9  | 5 | 11,85 | 230 121    | 260 121  |
| M 12 | 1    | 25 | 9  | 5 | 11,88 | 230 122    | 260 122  |
| M 16 | 2    | 38 | 14 | 6 | 15,82 | 230 160    | 260 160  |
| M 20 | 2,5  | 38 | 14 | 8 | 19,79 | 230 200    | 260 200  |

Materiál: NO: HSS  
Provedení: závit lapovaný  
Závit: pravý

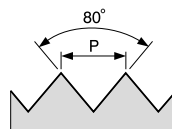
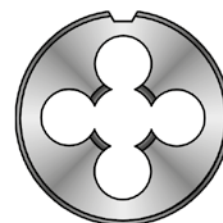
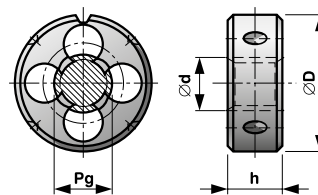
Material: CS: HSS  
Execution: lapped thread  
Thread: right-hand

Werkstoff: WS: HSS  
Ausführung: geläpptes Ge-  
winde  
Gewinde: rechts

Материал: NO: HSS  
Изготовлено: резьба  
Резьба: правая

**DIN EN 22 568****HOBBY  
NO****STANDARD  
HSS**

**Závitové kruhové  
čelisti  
Circular dies  
Schneideisen  
Плашки**



1,5P

**Pg**

Pancéřový závit DIN 40430  
Steel conduit thread DIN 40430  
Stahlpanzerrohr-Gewinde DIN 40430  
Панцирная резьба DIN 40430

|         | z/1" | P     | ØD  | h  | S  |       | code NO/CS | code HSS | code HSS <sup>x)</sup> |
|---------|------|-------|-----|----|----|-------|------------|----------|------------------------|
| Pg 7    | 20   | 1,270 | 38  | 10 | 4  | 12,40 | 213 070    | 243 070  | 273 070                |
| Pg 9    | 18   | 1,411 | 45  | 14 | 5  | 15,10 | 213 090    | 243 090  | 273 090                |
| Pg 11   | 18   | 1,411 | 45  | 14 | 5  | 18,50 | 213 110    | 243 110  | 273 110                |
| Pg 13,5 | 18   | 1,411 | 45  | 14 | 6  | 20,30 | 213 135    | 243 135  | 273 135                |
| Pg 16   | 18   | 1,411 | 55  | 16 | 5  | 22,40 | 213 160    | 243 160  | 273 160                |
| Pg 21   | 16   | 1,588 | 65  | 18 | 7  | 28,15 | 213 210    | 243 210  | 273 210                |
| Pg 29   | 16   | 1,588 | 75  | 20 | 7  | 36,85 | 213 290    | 243 290  | 273 290                |
| Pg 36   | 16   | 1,588 | 90  | 22 | 8  | 46,85 | 213 360    | 243 360  | 273 360                |
| Pg 42   | 16   | 1,588 | 105 | 22 | 10 | 53,85 | 213 420    | 243 420  | 273 420                |
| Pg 48   | 16   | 1,588 | 105 | 22 | 10 | 59,15 | 213 480    | 243 480  | 273 480                |

<sup>x)</sup> HSS s lamačem třísek / with spiral point / mit Schälanschnitt / с ломателем стружек

Materiál: NO: HSS  
- dle požadavku  
Provedení: standardní  
Závit: pravý

Material: CS: HSS  
- on request  
Execution: standard  
Thread: right-hand

Werkstoff: WS: HSS  
- nach dem Anspruch  
Ausführung: normal  
Gewinde: rechts

Материал: NO: HSS  
- по заказу  
Изготовлено: стандартно  
Резьба: правая

**BUČOVICE  
TOOLS a.s.**





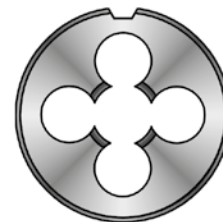
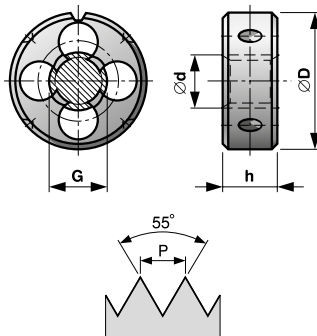


# DIN EN 24 231

HOBBY  
NO

STANDARD  
HSS

Závitové kruhové  
čelisti  
Circular dies  
Schneideisen  
Плашки



Trubkový závit DIN ISO 228  
Pipe thread DIN ISO 228  
Rohrgewinde DIN ISO 228  
Трубная резьба DIN ISO 228

Licování: třída A / Tolerance: class A /  
Toleranz: Klasse A / Подгонка: класс А



1,5P

G

|          | z/1" | P     | ØD  | h  | S  |        | code <sup>x)</sup> |
|----------|------|-------|-----|----|----|--------|--------------------|
| G 1/16"  | 28   | 0,907 | 25  | 9  | 4  | 7,62   | XXX 116            |
| G 1/8"   | 28   | 0,907 | 30  | 11 | 4  | 9,62   | XXX 180            |
| G 1/4"   | 19   | 1,337 | 38  | 10 | 5  | 13,03  | XXX 140            |
| G 3/8"   | 19   | 1,337 | 45  | 14 | 5  | 16,54  | XXX 380            |
| G 1/2"   | 14   | 1,814 | 45  | 14 | 6  | 20,81  | XXX 120            |
| G 5/8"   | 14   | 1,814 | 55  | 16 | 6  | 22,77  | XXX 580            |
| G 3/4"   | 14   | 1,814 | 55  | 16 | 6  | 26,30  | XXX 340            |
| G 7/8"   | 14   | 1,814 | 65  | 18 | 6  | 30,06  | XXX 780            |
| G 1"     | 11   | 2,309 | 65  | 18 | 8  | 33,07  | XXX 100            |
| G 1 1/8" | 11   | 2,309 | 75  | 20 | 8  | 37,72  | XXX 118            |
| G 1 1/4" | 11   | 2,309 | 75  | 20 | 9  | 41,73  | XXX 114            |
| G 1 3/8" | 11   | 2,309 | 90  | 22 | 8  | 44,14  | XXX 138            |
| G 1 1/2" | 11   | 2,309 | 90  | 22 | 8  | 47,62  | XXX 112            |
| G 1 3/4" | 11   | 2,309 | 105 | 22 | 8  | 53,57  | XXX 134            |
| G 2"     | 11   | 2,309 | 105 | 22 | 8  | 59,43  | XXX 200            |
| G 2 1/4" | 11   | 2,309 | 120 | 22 | 8  | 65,49  | XXX 214            |
| G 2 1/2" | 11   | 2,309 | 120 | 22 | 8  | 74,97  | XXX 212            |
| G 2 3/4" | 11   | 2,309 | 120 | 22 | 8  | 81,32  | XXX 234            |
| G 3"     | 11   | 2,309 | 150 | 25 | 10 | 87,67  | XXX 300            |
| G 3 1/2" | 11   | 2,309 | 150 | 25 | 10 | 100,11 | XXX 312            |
| G 4"     | 11   | 2,309 | 180 | 25 | 10 | 112,81 | XXX 400            |

x) 212 XXX - NO / CS / WS do G 2" / to G 2" / bis G 2" / до G 2"

x) 242 XXX - HSS

x) 252 XXX - HSS LH

x) 272 XXX - HSS s lamačem třísek do G 2" / with spiral point to G 2" / mit Schälanschnitt bis G 2" / с ломателем стружек до G 2"

Materiál: NO; HSS  
Provedení: závit lapovaný  
do G 3/4"  
Závit: pravý, levý

Material: CS; HSS  
Execution: lapped thread to  
G 3/4"  
Thread: right-hand, left-hand

Werkstoff: WS; HSS  
Ausführung: geläpftes  
Gewinde bis G 3/4"  
Gewinde: rechts, links

Материал: NO; HSS  
Изготовлено: резьба  
шлифованная до G 3/4"  
Резьба: правая, левая

# DIN EN 24 231

PROFI  
HSSE

PROFI  
HSSE VA

PROFI  
HSSE VA-NT

|          | z/1" | P     | ØD  | h  | S |       | code <sup>x)</sup> |
|----------|------|-------|-----|----|---|-------|--------------------|
| G 1/16"  | 28   | 0,907 | 25  | 9  | 4 | 7,62  | XXX 116            |
| G 1/8"   | 28   | 0,907 | 30  | 11 | 4 | 9,62  | XXX 180            |
| G 1/4"   | 19   | 1,337 | 38  | 10 | 5 | 13,03 | XXX 140            |
| G 3/8"   | 19   | 1,337 | 45  | 14 | 5 | 16,54 | XXX 380            |
| G 1/2"   | 14   | 1,814 | 45  | 14 | 6 | 20,81 | XXX 120            |
| G 5/8"   | 14   | 1,814 | 55  | 16 | 6 | 22,77 | XXX 580            |
| G 3/4"   | 14   | 1,814 | 55  | 16 | 6 | 26,30 | XXX 340            |
| G 7/8"   | 14   | 1,814 | 65  | 18 | 6 | 30,06 | XXX 780            |
| G 1"     | 11   | 2,309 | 65  | 18 | 8 | 33,07 | XXX 100            |
| G 1 1/8" | 11   | 2,309 | 75  | 20 | 8 | 37,72 | XXX 118            |
| G 1 1/4" | 11   | 2,309 | 75  | 20 | 9 | 41,73 | XXX 114            |
| G 1 3/8" | 11   | 2,309 | 90  | 22 | 8 | 44,14 | XXX 138            |
| G 1 1/2" | 11   | 2,309 | 90  | 22 | 8 | 47,62 | XXX 112            |
| G 1 3/4" | 11   | 2,309 | 105 | 22 | 8 | 53,57 | XXX 134            |
| G 2"     | 11   | 2,309 | 105 | 22 | 8 | 59,43 | XXX 200            |

x) 292 XXX - HSSE

x) 293 XXX - HSSE VA - na nerez / stainless steel / Rostfreistähle / нержавеющейка

x) 296 XXX - HSSE VA-NT - na nerez - nitridace / stainless steel - nitration / Rostfreistähle - Nitrierung / нержавеющейка - нитрирование

Materiál: HSSE, HSSE VA-NT  
- dle požadavku  
Provedení: závit lapovaný  
do G 3/4"  
Závit: pravý

Material: HSSE, HSSE VA-NT  
- on request  
Execution: lapped thread to  
G 3/4"  
Thread: right-hand

Werkstoff: HSSE,  
HSSE VA-NT - nach dem  
Anspruch  
Ausführung: geläpftes  
Gewinde bis G 3/4"  
Gewinde: rechts

Материал: HSSE,  
HSSE VA-NT - по заказу  
Изготовлено: резьба  
шлифованная до G 3/4"  
Резьба: правая



**BUČOVICE  
TOOLS a.s.**





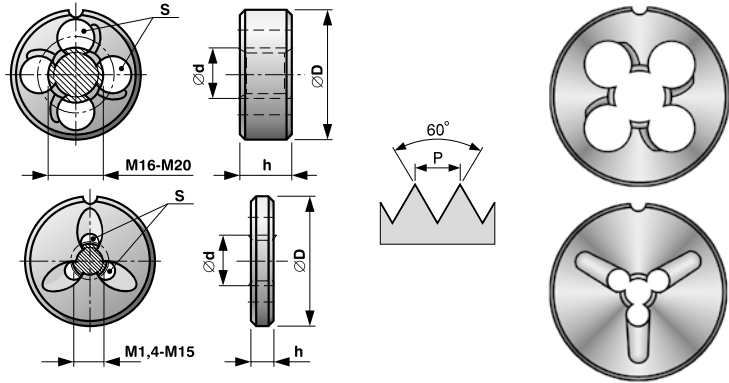


# ČSN 22 3216

**STANDARD  
HSS**

**PROFI  
HSSE**

**Strojní závitové kruhové  
čelisti**  
**Machine circular dies**  
**Maschinen-Schneideisen**  
**Плашки с машинной  
резьбой**



Lícování: 6g (6h, 6e - dle požadavku zákazníka) /  
Tolerance: 6g (6h, 6e - on request) / Toleranz: 6g (6h, 6e - nach  
dem Anspruch) / Подгонка: 6g (6h, 6e - по заказу)

1,5P

M

Metrický závit ISO DIN 13  
Standard metric thread ISO DIN 13  
Metrische Regelgewinde ISO DIN 13  
Метрическая резьба ISO DIN 13

MF

Jemný metrický závit ISO DIN 13  
Fine metric thread ISO DIN 13  
Metrische Feingewinde ISO DIN 13  
Мелкая метрическая резьба ISO DIN 13

|       | P    | ØD | h   | S |       | code HSS | code HSS LH | code HSSE |
|-------|------|----|-----|---|-------|----------|-------------|-----------|
| M 1,2 | 0,25 | 12 | 2,5 | 3 | 1,17  | 247 012  | 257 012     | 297 012   |
| M 1,4 | 0,3  | 12 | 2,5 | 3 | 1,36  | 247 014  | 257 014     | 297 014   |
| M 1,6 | 0,35 | 12 | 2,5 | 3 | 1,54  | 247 016  | 257 016     | 297 016   |
| M 1,7 | 0,35 | 12 | 2,5 | 3 | 1,64  | 247 017  | 257 017     | 297 017   |
| M 1,8 | 0,35 | 12 | 2,5 | 3 | 1,74  | 247 018  | 257 018     | 297 018   |
| M 2   | 0,4  | 16 | 3,5 | 3 | 1,93  | 247 020  | 257 020     | 297 020   |
| M 2,2 | 0,45 | 16 | 3,5 | 3 | 2,13  | 247 022  | 257 022     | 297 022   |
| M 2,5 | 0,45 | 16 | 3,5 | 3 | 2,43  | 247 025  | 257 025     | 297 025   |
| M 2,5 | 0,35 | 16 | 2,5 | 3 | 2,44  | 247 026  | 257 026     | 297 026   |
| M 3   | 0,5  | 16 | 3,5 | 4 | 2,92  | 247 030  | 257 030     | 297 030   |
| M 3   | 0,35 | 16 | 2,5 | 4 | 2,94  | 247 031  | 257 031     | 297 031   |
| M 3,5 | 0,6  | 16 | 5   | 4 | 3,41  | 247 035  | 257 035     | 297 035   |
| M 3,5 | 0,35 | 16 | 3,5 | 4 | 3,44  | 247 036  | 257 036     | 297 036   |
| M 4   | 0,7  | 16 | 5   | 4 | 3,91  | 247 040  | 257 040     | 297 040   |
| M 4   | 0,5  | 16 | 3,5 | 4 | 3,93  | 247 041  | 257 041     | 297 041   |
| M 4,5 | 0,5  | 16 | 3,5 | 4 | 4,41  | 247 045  | 257 045     | 297 045   |
| M 5   | 0,8  | 20 | 5,5 | 4 | 4,90  | 247 050  | 257 050     | 297 050   |
| M 5   | 0,5  | 20 | 3,5 | 4 | 4,93  | 247 051  | 257 051     | 297 051   |
| M 5,5 | 0,5  | 20 | 3,5 | 4 | 5,43  | 247 055  | 257 055     | 297 055   |
| M 6   | 1    | 20 | 7   | 4 | 5,88  | 247 060  | 257 060     | 297 060   |
| M 6   | 0,75 | 20 | 5,5 | 4 | 5,91  | 247 061  | 257 061     | 297 061   |
| M 6   | 0,5  | 20 | 5,5 | 4 | 5,92  | 247 062  | 257 062     | 297 062   |
| M 7   | 1    | 20 | 7   | 4 | 6,88  | 247 070  | 257 070     | 297 070   |
| M 7   | 0,75 | 20 | 5,5 | 4 | 6,90  | 247 071  | 257 071     | 297 071   |
| M 8   | 1,25 | 25 | 8   | 4 | 7,87  | 247 080  | 257 080     | 297 080   |
| M 8   | 1    | 25 | 7   | 4 | 7,88  | 247 081  | 257 081     | 297 081   |
| M 8   | 0,75 | 25 | 7   | 4 | 7,90  | 247 082  | 257 082     | 297 082   |
| M 9   | 1,25 | 25 | 8   | 4 | 8,87  | 247 090  | 257 090     | 297 090   |
| M 9   | 1    | 25 | 7   | 4 | 8,88  | 247 091  | 257 091     | 297 091   |
| M 9   | 0,75 | 25 | 7   | 4 | 8,90  | 247 092  | 257 092     | 297 092   |
| M 10  | 1,5  | 30 | 10  | 4 | 9,85  | 247 100  | 257 100     | 297 100   |
| M 10  | 1    | 30 | 7   | 4 | 9,88  | 247 101  | 257 101     | 297 101   |
| M 10  | 1,25 | 30 | 7   | 4 | 9,86  | 247 102  | 257 102     | 297 102   |
| M 11  | 1,5  | 30 | 10  | 5 | 10,85 | 247 110  | 257 110     | 297 110   |
| M 11  | 1    | 30 | 10  | 5 | 10,88 | 247 111  | 257 111     | 297 111   |
| M 11  | 0,75 | 30 | 10  | 5 | 10,91 | 247 112  | 257 112     | 297 112   |
| M 12  | 1,75 | 30 | 12  | 5 | 11,83 | 247 120  | 257 120     | 297 120   |
| M 12  | 1,5  | 30 | 10  | 5 | 11,85 | 247 121  | 257 121     | 297 121   |
| M 12  | 1,25 | 30 | 10  | 5 | 11,86 | 247 122  | 257 122     | 297 122   |
| M 12  | 1    | 30 | 10  | 5 | 11,88 | 247 123  | 257 123     | 297 123   |
| M 14  | 2    | 38 | 14  | 5 | 13,82 | 247 140  | 257 140     | 297 140   |
| M 14  | 1,5  | 38 | 10  | 5 | 13,85 | 247 141  | 257 141     | 297 141   |
| M 14  | 1,25 | 38 | 10  | 5 | 13,86 | 247 142  | 257 142     | 297 142   |
| M 14  | 1    | 38 | 10  | 5 | 13,88 | 247 143  | 257 143     | 297 143   |
| M 15  | 1,5  | 38 | 10  | 5 | 14,85 | 247 151  | 257 151     | 297 151   |
| M 16  | 2    | 38 | 14  | 5 | 15,82 | 247 160  | 257 160     | 297 160   |
| M 16  | 1,5  | 38 | 10  | 5 | 15,85 | 247 161  | 257 161     | 297 161   |
| M 16  | 1    | 38 | 10  | 5 | 15,88 | 247 162  | 257 162     | 297 162   |
| M 18  | 2,5  | 45 | 16  | 5 | 17,79 | 247 180  | 257 180     | 297 180   |
| M 18  | 1,5  | 45 | 12  | 5 | 17,85 | 247 181  | 257 181     | 297 181   |
| M 18  | 1    | 45 | 12  | 5 | 17,88 | 247 182  | 257 182     | 297 182   |
| M 20  | 2,5  | 45 | 16  | 6 | 19,79 | 247 200  | 257 200     | 297 200   |
| M 20  | 1,5  | 45 | 12  | 6 | 19,85 | 247 201  | 257 201     | 297 201   |
| M 20  | 1    | 45 | 12  | 6 | 19,88 | 247 202  | 257 202     | 297 202   |



**BUČOVICE  
TOOLS a.s.**

Materiál: HSS  
Provedení: závit lapovaný  
Závit: pravý

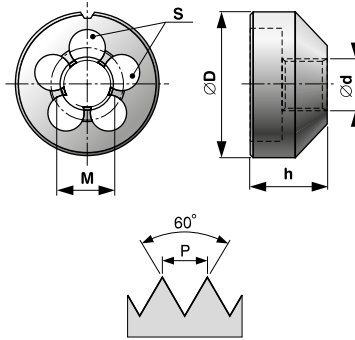
Material: HSS  
Execution: lapped thread  
Thread: right-hand

Werkstoff: HSS  
Ausführung: geläpftes  
Gewinde  
Gewinde: rechts

Материал: HSS  
Изготовлено: резьба  
шлифованная  
Резьба: правая

## STANDARD HSS

**Automatové závitové čelisti zvonkové**  
**Acorn dies for automatic lathes**  
**Glocken- Schneideisen für Drehautomaten**  
**Плшки колокольные для токарных автоматов**



**M**  
 Metrický závit ISO DIN 13  
 Standard metric thread ISO DIN 13  
 Metrische Regelgewinde ISO DIN 13  
 Метрическая резьба ISO DIN 13

**MF**  
 Jemný metrický závit ISO DIN 13  
 Fine metric thread ISO DIN 13  
 Metrische Feingewinde ISO DIN 13  
 Мелкая метрическая резьба ISO DIN 13

Lícování: 6g / Tolerance: 6g /  
 Toleranz: 6g / Подгонка: 6g

1,5P

|      | P    | ØD | h   | S |       | code <sup>x)</sup> |
|------|------|----|-----|---|-------|--------------------|
| M 3  | 0,5  | 16 | 8   | 3 | 2,92  | 249 030            |
| M 4  | 0,7  | 16 | 9,5 | 3 | 3,91  | 249 040            |
| M 5  | 0,8  | 16 | 9,5 | 4 | 4,90  | 249 050            |
| M 6  | 1    | 16 | 9,5 | 4 | 5,88  | 249 060            |
| M 8  | 1,25 | 25 | 14  | 4 | 7,87  | 249 080            |
| M 8  | 1    | 25 | 14  | 4 | 7,88  | 249 081            |
| M 10 | 1,5  | 25 | 14  | 4 | 9,85  | 249 100            |
| M 10 | 1,25 | 25 | 14  | 4 | 9,86  | 249 101            |
| M 10 | 1    | 25 | 14  | 4 | 9,88  | 249 102            |
| M 12 | 1,75 | 30 | 18  | 4 | 11,83 | 249 120            |
| M 12 | 1,5  | 30 | 18  | 4 | 11,85 | 249 121            |
| M 12 | 1,25 | 30 | 18  | 4 | 11,86 | 249 122            |
| M 12 | 1    | 30 | 18  | 4 | 11,88 | 249 123            |

Materiál: HSS  
 Provedení: závit lapovaný  
 Závit: pravý

Material: HSS  
 Execution: lapped thread  
 Thread: right-hand

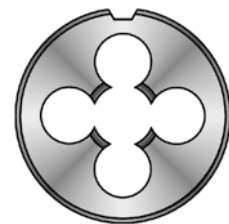
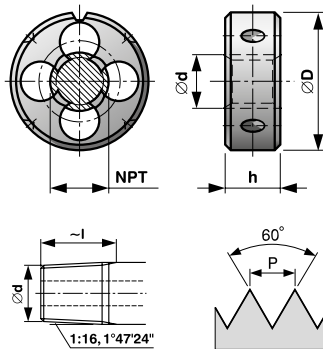
Werkstoff: HSS  
 Ausführung: geläpftes Ge-  
 winde  
 Gewinde: rechts

Материал: HSS  
 Изготовлено: резьба  
 шлифованная  
 Резьба: правая

## DIN EN 24 230

## STANDARD HSS

**Strojní závitové čelisti kuželové**  
**Conical machine circular dies**  
**Maschinen Konisches Gewindeschneideisen**  
**Плшки для резьбы**



**NPT**  
 Americký závit trubkový kuželový  
 NPT 1:16; ANSI B-1.20.1  
 American tapered pipe thread  
 NPT 1:16; ANSI B-1.20.1  
 Amerikanisches kegeliges Rohrgewinde  
 NPT 1:16; ANSI B-1.20.1  
 Трубная коническая резьба  
 NPT 1:16; ANSI B-1.20.1

2P

|     | z/1" | P     | ØD | h  | S | d <sub>1</sub> min. | d <sub>2</sub> | L    | code    |
|-----|------|-------|----|----|---|---------------------|----------------|------|---------|
| 1/8 | 27   | 0,941 | 30 | 11 | 5 | 9,87                | 9,99           | 8,40 | 430 180 |
| 1/4 | 18   | 1,411 | 38 | 14 | 5 | 13,10               | 13,26          | 12,7 | 430 114 |
| 3/8 | 18   | 1,411 | 45 | 18 | 5 | 16,52               | 16,67          | 12,9 | 430 380 |
| 1/2 | 14   | 1,814 | 45 | 18 | 6 | 20,55               | 20,71          | 16,8 | 430 120 |
| 3/4 | 14   | 1,814 | 55 | 22 | 6 | 25,87               | 26,03          | 17,0 | 430 340 |
| 1   | 11,5 | 2,209 | 65 | 25 | 7 | 32,42               | 32,59          | 21,2 | 430 100 |

Materiál: HSS  
 Závit: pravý

Material: HSS  
 Thread: right-hand

Werkstoff: HSS  
 Gewinde: rechts

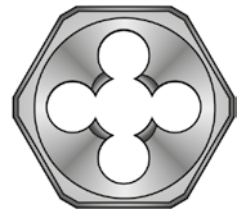
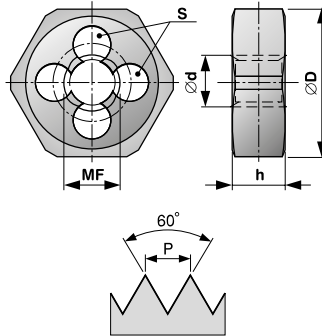
Материал: HSS  
 Резьба: правая

**BUČOVICE TOOLS a.s.**





**Závitové kruhové  
čelisti šestihránné  
Hexagon die nuts  
Sechskant -  
Schneidmuttern  
Плашки шестиугольные**



Jemný metrický závit ISO DIN 13  
Fine metric thread ISO DIN 13  
Metrische Feingewinde ISO DIN 13  
Мелкая метрическая резьба ISO DIN 13

Licování: 6g / Tolerance: 6g /  
Toleranz: 6g / Подгонка: 6g



1,5P

MF

|       | P    | ØD | h  | S |       | code    |
|-------|------|----|----|---|-------|---------|
| MF 3  | 0,35 | 18 | 5  | 4 | 2,94  | 220 031 |
| MF 4  | 0,5  | 18 | 5  | 4 | 3,93  | 220 041 |
| MF 5  | 0,5  | 18 | 5  | 4 | 4,93  | 220 051 |
| MF 5  | 0,75 | 18 | 5  | 4 | 4,91  | 220 052 |
| MF 6  | 0,75 | 18 | 7  | 4 | 5,91  | 220 061 |
| MF 7  | 0,75 | 21 | 9  | 4 | 6,90  | 220 071 |
| MF 8  | 1    | 21 | 9  | 5 | 7,88  | 220 081 |
| MF 8  | 0,75 | 21 | 9  | 5 | 7,90  | 220 082 |
| MF 9  | 1    | 21 | 9  | 5 | 8,88  | 220 091 |
| MF 9  | 0,75 | 21 | 9  | 5 | 8,90  | 220 092 |
| MF 10 | 1,25 | 27 | 11 | 5 | 9,86  | 220 101 |
| MF 10 | 1    | 27 | 11 | 5 | 9,88  | 220 102 |
| MF 10 | 0,75 | 27 | 11 | 5 | 9,90  | 220 103 |
| MF 11 | 1    | 27 | 11 | 5 | 10,88 | 220 111 |
| MF 12 | 1,5  | 36 | 10 | 5 | 11,85 | 220 121 |
| MF 12 | 1,25 | 36 | 10 | 5 | 11,86 | 220 122 |
| MF 12 | 1    | 36 | 10 | 5 | 11,88 | 220 123 |
| MF 14 | 1,5  | 36 | 10 | 5 | 13,85 | 220 141 |
| MF 14 | 1,25 | 36 | 10 | 5 | 13,86 | 220 142 |
| MF 14 | 1    | 36 | 10 | 5 | 13,88 | 220 143 |
| MF 15 | 1,5  | 41 | 14 | 5 | 14,85 | 220 151 |
| MF 15 | 1    | 41 | 14 | 5 | 14,88 | 220 152 |
| MF 16 | 1,5  | 41 | 14 | 5 | 15,85 | 220 161 |
| MF 16 | 1    | 41 | 14 | 5 | 15,88 | 220 162 |
| MF 18 | 2    | 41 | 14 | 5 | 17,82 | 220 181 |
| MF 18 | 1,5  | 41 | 14 | 5 | 17,85 | 220 182 |
| MF 18 | 1    | 41 | 14 | 5 | 17,88 | 220 183 |
| MF 20 | 2    | 41 | 18 | 5 | 19,82 | 200 201 |
| MF 20 | 1,5  | 41 | 14 | 5 | 19,85 | 200 202 |
| MF 20 | 1    | 41 | 14 | 5 | 19,88 | 200 203 |
| MF 22 | 2    | 50 | 16 | 5 | 21,82 | 200 221 |
| MF 22 | 1,5  | 50 | 16 | 5 | 21,85 | 200 222 |
| MF 22 | 1    | 50 | 16 | 5 | 21,88 | 220 223 |
| MF 23 | 1,5  | 50 | 16 | 5 | 22,85 | 220 231 |
| MF 24 | 2    | 50 | 16 | 6 | 23,82 | 220 241 |
| MF 24 | 1,5  | 50 | 16 | 6 | 23,85 | 220 242 |
| MF 24 | 1    | 50 | 16 | 6 | 23,88 | 220 243 |
| MF 25 | 1,5  | 50 | 16 | 6 | 24,85 | 220 251 |
| MF 25 | 1    | 50 | 16 | 6 | 24,88 | 220 252 |
| MF 26 | 1,5  | 50 | 16 | 6 | 25,85 | 220 261 |
| MF 27 | 2    | 60 | 18 | 6 | 26,82 | 220 271 |
| MF 27 | 1,5  | 60 | 18 | 6 | 26,85 | 220 272 |
| MF 28 | 2    | 60 | 18 | 6 | 27,82 | 220 281 |
| MF 28 | 1,5  | 60 | 18 | 6 | 27,85 | 220 282 |
| MF 28 | 1    | 60 | 18 | 6 | 27,88 | 220 283 |
| MF 29 | 1,5  | 60 | 18 | 6 | 28,85 | 220 292 |
| MF 30 | 2    | 60 | 18 | 6 | 29,82 | 220 301 |
| MF 30 | 1,5  | 60 | 18 | 6 | 29,85 | 220 302 |
| MF 30 | 1    | 60 | 18 | 6 | 29,88 | 220 303 |
| MF 32 | 1,5  | 60 | 18 | 7 | 31,85 | 220 321 |
| MF 33 | 3    | 60 | 25 | 8 | 32,73 | 220 330 |
| MF 33 | 2    | 60 | 18 | 8 | 32,82 | 220 331 |
| MF 33 | 1,5  | 60 | 18 | 8 | 32,85 | 220 332 |
| MF 35 | 1,5  | 60 | 18 | 8 | 34,85 | 220 351 |
| MF 36 | 3    | 60 | 18 | 9 | 35,76 | 220 361 |
| MF 36 | 2    | 60 | 18 | 9 | 35,82 | 220 362 |
| MF 36 | 1,5  | 60 | 18 | 9 | 35,85 | 220 363 |
| MF 39 | 3    | 70 | 30 | 8 | 38,76 | 220 391 |
| MF 39 | 2    | 70 | 20 | 8 | 38,82 | 220 392 |
| MF 39 | 1,5  | 70 | 20 | 8 | 38,85 | 220 393 |

Materiál: HSS  
Provedení: závit lapovaný  
do M 26  
Závit: pravý

Material: HSS  
Execution: lapped thread  
to M 26  
Thread: right-hand

Werkstoff: HSS  
Ausführung: geläpftes  
Gewinde bis M 26  
Gewinde: rechts

Материал: НО: HSS  
Изготовлено: резьба  
шлифованная до M 26  
Резьба: правая











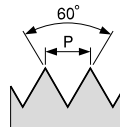
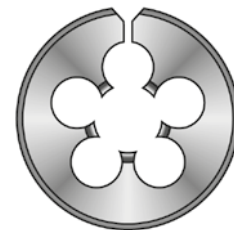
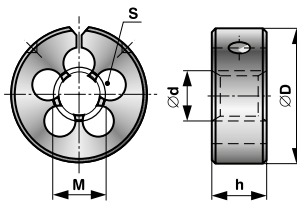




# BS-1127:1950

**STANDARD  
HSS**

**Závitové kruhové  
čelisti stavitelné**  
**Circular adjustable dies**  
**Runde Schneideisen geschlitzt**  
**Плашки регулируемые**



**M**  
Metrický závit ISO DIN 13  
Standard metric thread ISO DIN 13  
Metrische Regelgewinde ISO DIN 13  
Метрическая резьба ISO DIN 13

**MF**  
Jemný metrický závit ISO DIN 13  
Fine metric thread ISO DIN 13  
Metrische Feingewinde ISO DIN 13  
Мелкая метрическая резьба ISO DIN 13

Licování: 6g / Tolerance: 6g /  
Toleranz: 6g / Подгонка: 6g



1,5P

|       | P    | ØD - A<br>S | ØD - B<br>S | ØD - C<br>S | ØD - D<br>S | ØD - E<br>S | ØD - G<br>S | code <sup>x)</sup> |
|-------|------|-------------|-------------|-------------|-------------|-------------|-------------|--------------------|
| M 2   | 0,4  | 3           |             |             |             |             |             | 1,93 XXX 020       |
| M 3   | 0,5  | 3           | 3           |             |             |             |             | 2,92 XXX 030       |
| M 3,5 | 0,6  | 3           | 3           |             |             |             |             | 2,94 XXX 035       |
| M 4   | 0,7  | 3           | 3           |             |             |             |             | 3,91 XXX 040       |
| M 4   | 0,5  | 3           | 3           |             |             |             |             | 3,93 XXX 041       |
| M 5   | 0,8  | 4           | 4           |             |             |             |             | 4,90 XXX 050       |
| M 5   | 0,5  | 4           | 4           |             |             |             |             | 4,93 XXX 051       |
| M 6   | 1    | 4           | 4           | 4           |             |             |             | 5,88 XXX 060       |
| M 6   | 0,75 | 4           | 4           | 4           |             |             |             | 5,91 XXX 061       |
| M 7   | 1    |             | 4           | 4           |             |             |             | 6,88 XXX 070       |
| M 7   | 0,75 |             | 4           | 4           |             |             |             | 6,90 XXX 071       |
| M 8   | 1,25 |             | 4           | 4           | 4           |             |             | 7,87 XXX 080       |
| M 8   | 1    |             | 4           | 4           | 4           |             |             | 7,88 XXX 081       |
| M 9   | 1,25 |             | 4           | 4           | 4           |             |             | 8,87 XXX 090       |
| M 10  | 1,5  |             | 5           | 4           | 4           |             |             | 9,85 XXX 100       |
| M 10  | 1,25 |             | 5           | 4           | 4           |             |             | 9,86 XXX 101       |
| M 10  | 1    |             | 5           | 4           | 4           |             |             | 9,88 XXX 102       |
| M 11  | 1,5  |             |             | 5           | 5           |             |             | 10,85 XXX 110      |
| M 12  | 1,75 |             |             | 5           | 4           | 4           |             | 11,83 XXX 120      |
| M 12  | 1,5  |             |             | 5           | 4           | 4           |             | 11,85 XXX 121      |
| M 12  | 1,25 |             |             | 5           | 4           | 4           |             | 11,86 XXX 122      |
| M 12  | 1    |             |             | 5           | 4           | 4           |             | 11,88 XXX 123      |
| M 14  | 2    |             |             |             | 5           | 5           |             | 13,82 XXX 140      |
| M 14  | 1,5  |             |             |             | 5           | 5           |             | 13,86 XXX 141      |
| M 14  | 1,25 |             |             |             | 5           | 5           |             | 13,88 XXX 142      |
| M 16  | 2    |             |             |             | 5           | 5           |             | 15,82 XXX 160      |
| M 16  | 1,5  |             |             |             | 5           | 5           |             | 15,85 XXX 161      |
| M 18  | 2,5  |             |             |             |             | 5           |             | 17,79 XXX 180      |
| M 18  | 1,5  |             |             |             |             | 5           |             | 17,85 XXX 182      |
| M 20  | 2,5  |             |             |             |             | 6           |             | 19,79 XXX 200      |
| M 20  | 1,5  |             |             |             |             | 6           |             | 19,85 XXX 202      |
| M 22  | 2,5  |             |             |             |             | 6           |             | 21,79 XXX 220      |
| M 22  | 1,5  |             |             |             |             | 6           |             | 21,85 XXX 221      |
| M 24  | 3    |             |             |             |             | 6           |             | 23,76 XXX 240      |
| M 24  | 2    |             |             |             |             | 6           |             | 23,82 XXX 241      |
| M 24  | 1,5  |             |             |             |             | 6           |             | 23,85 XXX 242      |
| M 25  | 1,5  |             |             |             |             | 6           |             | 24,85 XXX 251      |
| M 27  | 3    |             |             |             |             |             | 6           | 26,76 XXX 270      |
| M 30  | 3,5  |             |             |             |             |             | 6           | 29,73 XXX 300      |
| M 33  | 3,5  |             |             |             |             |             | 6           | 32,73 XXX 330      |
| M 36  | 4    |             |             |             |             |             | 6           | 35,70 XXX 360      |
| M 39  | 4    |             |             |             |             |             | 6           | 38,70 XXX 390      |

x) 440 XXXA (13/16" - 20,6 mm, h = 6,35)

x) 440 XXXB (1" - 25,4 mm, h = 9,5)

x) 440 XXXC (1 5/16" - 33,4 mm, h = 11,1)

x) 440 XXXD (1 1/2" - 38,1 mm, h = 12,7)

x) 440 XXXE (2" - 50,8 mm, h = 15,9)

x) 440 XXXG (3" - 76,2 mm, h = 22,2)



**BUČOVICE  
TOOLS a.s.**

Materiál: HSS  
Provedení: závit lapovaný  
do M 26  
Závit: pravý

Material: HSS  
Execution: lapped thread  
to M 26  
Thread: right-hand

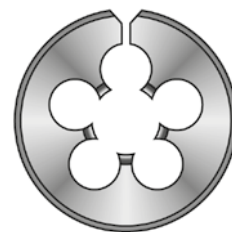
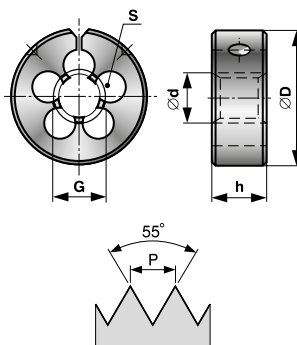
Werkstoff: HSS  
Ausführung: geläpptes  
Gewinde bis M 26  
Gewinde: rechts

Материал: HSS  
Изготовлено: резьба  
шлифованная до M 26  
Резьба: правая

# BS-1127:1950

**STANDARD  
HSS**

**Závitové kruhové  
čelisti stavitelné**  
**Circular adjustable dies**  
**Runde Schneideisen**  
**geschlitzt**  
**Плашки регулируемые**




Trubkový závit DIN ISO 228  
Pipe thread DIN ISO 228  
Rohrgewinde DIN ISO 228  
Трубная резьба DIN ISO 228

Lícování: A / Tolerance: A /  
Toleranz: A / Подгонка: A



1,5P

|          | z/1" | P     | ØD - B<br>S | ØD - C<br>S | ØD - D<br>S | ØD - E<br>S | ØD - G<br>S | ØD - I<br>S |  | code <sup>x)</sup> |
|----------|------|-------|-------------|-------------|-------------|-------------|-------------|-------------|---|--------------------|
| G 1/16   | 28   | 0,907 | 4           | 4           |             |             |             |             | 7,62  | XXX 116            |
| G 1/8"   | 28   | 0,907 | 5           | 4           | 4           |             |             |             | 9,62  | XXX 180            |
| G 1/4"   | 19   | 1,337 |             |             | 5           | 5           |             |             | 13,03   | XXX 140            |
| G 3/8"   | 19   | 1,337 |             |             | 5           | 5           |             |             | 16,54   | XXX 380            |
| G 1/2"   | 14   | 1,814 |             |             | 6           | 6           |             |             | 20,81   | XXX 120            |
| G 5/8"   | 14   | 1,814 |             |             |             | 6           |             |             | 22,77   | XXX 580            |
| G 3/4"   | 14   | 1,814 |             |             |             | 6           |             |             | 26,30   | XXX 340            |
| G 1"     | 11   | 2,309 |             |             |             |             | 6           |             | 30,06   | XXX 100            |
| G 1 1/4" | 11   | 2,309 |             |             |             |             | 8           |             | 33,07   | XXX 114            |
| G 1 1/2" | 11   | 2,309 |             |             |             |             | 9           | 8           | 41,73   | XXX 112            |
| G 2"     | 11   | 2,309 |             |             |             |             |             | 8           | 47,62   | XXX 200            |

- x) 442 XXXB (1" - 25,4 mm, h = 9,5)
- x) 442 XXXC (1 5/16" - 33,4 mm, h = 11,1)
- x) 442 XXXD (1 1/2" - 38,1 mm, h = 12,7)
- x) 442 XXXE (2" - 50,8 mm, h = 15,9)
- x) 442 XXXG (3" - 76,2 mm, h = 22,2)
- x) 442 XXXI (4" - 101,6 mm, h = 25,4)

Materiál: HSS  
Provedení: závit lapovaný  
do G 3/4"  
Závit: pravý

Material: HSS  
Execution: lapped thread to  
G 3/4"  
Thread: right-hand

Werkstoff: HSS  
Ausführung: geläpptes  
Gewinde bis G 3/4"  
Gewinde: rechts

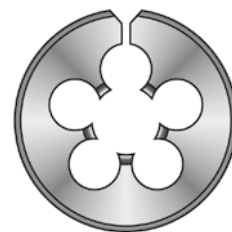
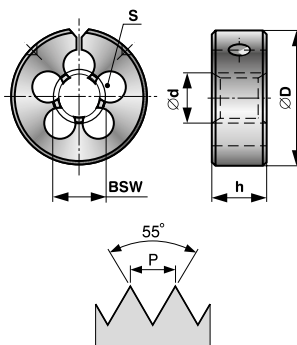
Материал: HSS  
Изготовлено: резьба  
шлифованная до G 3/4"  
Резьба: правая

 **BUČOVICE  
TOOLS a.s.**

# BS-1127:1950

**STANDARD  
HSS**

**Závitové kruhové  
čelisti stavitelné  
Circular adjustable dies  
Runde Schneideisen  
geschlitzt  
Плашки регулируемые**



Whitworthův závit BS 84:1956  
Whitworth thread BS 84:1956  
Whitworth-Gewinde BS 84:1956  
Резьба Витворта BS 84:1956

Licování: střední / Tolerance: medium class /  
Toleranz: Mittelklasse / Подгонка: средний класс



1,5P

| z/1"      | P  | ØD - A<br>S | ØD - B<br>S | ØD - C<br>S | ØD - D<br>S | ØD - E<br>S | Ød    | code <sup>x)</sup> |
|-----------|----|-------------|-------------|-------------|-------------|-------------|-------|--------------------|
| BSW 3/32" | 48 | 0,529       | 3           |             |             |             | 2,30  | XXX 332            |
| BSW 1/8"  | 40 | 0,635       | 3           |             |             |             | 2,10  | XXX 180            |
| BSW 5/32" | 32 | 0,794       | 3           |             |             |             | 3,88  | XXX 532            |
| BSW 3/16" | 24 | 1,058       | 3           |             |             |             | 4,66  | XXX 316            |
| BSW 1/4"  | 20 | 1,270       | 4           |             |             |             | 6,24  | XXX 140            |
| BSW 5/16" | 18 | 1,411       |             | 4           |             |             | 7,82  | XXX 516            |
| BSW 3/8"  | 16 | 1,588       |             | 4           |             |             | 9,40  | XXX 380            |
| BSW 7/16" | 14 | 1,814       |             | 5           | 4           |             | 10,98 | XXX 716            |
| BSW 1/2"  | 12 | 2,117       |             | 4           | 5           |             | 12,56 | XXX 120            |
| BSW 9/16" | 12 | 2,117       |             |             | 4           |             | 14,14 | XXX 916            |
| BSW 5/8"  | 11 | 2,309       |             |             | 5           | 5           | 15,72 | XXX 580            |
| BSW 3/4"  | 10 | 2,540       |             |             | 5           | 5           | 18,89 | XXX 340            |
| BSW 7/8"  | 9  | 2,822       |             |             |             | 5           | 22,10 | XXX 780            |
| BSW 1"    | 8  | 3,175       |             |             |             | 6           | 25,27 | XXX 100            |

- x) 441 XXXA (13/16" - 20,6 mm, h = 6,35)
- x) 441 XXXB (1" - 25,4 mm, h = 9,5)
- x) 441 XXXC (1 5/16" - 33,4 mm, h = 11,1)
- x) 441 XXXD (1 1/2" - 38,1 mm, h = 12,7)
- x) 441 XXXE (2" - 50,8 mm, h = 15,9)



**BUČOVICE  
TOOLS a.s.**

Materiál: HSS  
Provedení: závit lapovaný do  
BSW 1"  
Závit: pravý

Material: HSS  
Execution: lapped thread  
to BSW 1"  
Thread: right-hand

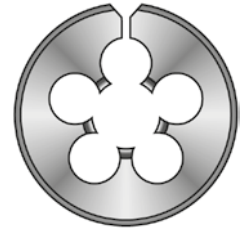
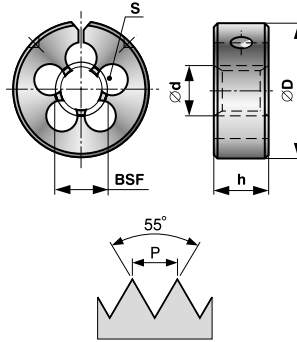
Werkstoff: HSS  
Ausführung: geläpftes  
Gewinde bis BSW 1"  
Gewinde: rechts

Материал: HSS  
Изготовлено: резьба  
шлифованная до BSW 1"  
Резьба: правая

# BS-1127:1950

**STANDARD  
HSS**

**Závitové kruhové  
čelisti stavitelné  
Circular adjustable dies  
Runde Schneideisen  
geschlitzt  
Плашки регулируемые**



Jemný Whitworthův závit BS 84:1956  
Fine Whitworth thread BS 84:1956  
Whitworth-Feingewinde BS 84:1956  
Мелкая резьба Витворта BS 84:1956

Lícování: střední / Tolerance: medium class /  
Toleranz: Mittelklasse / Подгонка: средний класс



1,5P

|           | z/1" | P     | ØD - A<br>S | ØD - B<br>S | ØD - C<br>S | ØD - D<br>S | ØD - E<br>S | Ød    | code <sup>x)</sup> |
|-----------|------|-------|-------------|-------------|-------------|-------------|-------------|-------|--------------------|
| BSF 3/16" | 32   | 0,794 | 3           |             |             |             |             | 4,66  | XXX 316            |
| BSF 1/4"  | 26   | 0,977 | 4           |             |             |             |             | 6,24  | XXX 140            |
| BSF 5/16" | 22   | 1,154 |             | 4           |             |             |             | 7,82  | XXX 516            |
| BSF 3/8"  | 20   | 1,270 |             | 4           | 4           | 4           |             | 9,40  | XXX 380            |
| BSF 7/16" | 18   | 1,411 |             |             | 5           | 5           |             | 10,98 | XXX 716            |
| BSF 1/2"  | 16   | 1,588 |             |             | 4           | 4           |             | 12,56 | XXX 120            |
| BSF 9/16" | 16   | 1,588 |             |             |             | 5           |             | 14,14 | XXX 916            |
| BSF 5/8"  | 14   | 1,814 |             |             |             | 5           | 5           | 15,72 | XXX 580            |
| BSF 3/4"  | 12   | 2,117 |             |             |             | 5           | 5           | 18,89 | XXX 340            |
| BSF 7/8"  | 11   | 2,309 |             |             |             |             | 5           | 22,10 | XXX 780            |
| BSF 1"    | 10   | 2,540 |             |             |             |             | 6           | 25,27 | XXX 100            |

x) 444 XXXA (13/16" - 20,6 mm, h = 6,35)

x) 444 XXXB (1" - 25,4 mm, h = 9,5)

x) 444 XXXC (1 5/16" - 33,4 mm, h = 11,1)

x) 444 XXXD (1 1/2" - 38,1 mm, h = 12,7)

x) 444 XXXE (2" - 50,8 mm, h = 15,9)

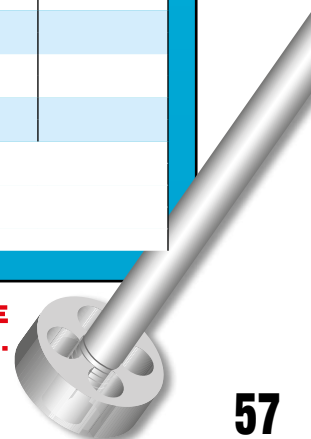
Materiál: HSS  
Provedení: závit lapovaný do  
BSF 1"  
Závit: pravý

Material: HSS  
Execution: lapped thread  
to BSF 1"  
Thread: right-hand

Werkstoff: HSS  
Ausführung: geläpptes  
Gewinde bis BSF 1"  
Gewinde: rechts

Материал: HSS  
Изготовлено: резьба  
шлифованная до BSF 1"  
Резьба: правая

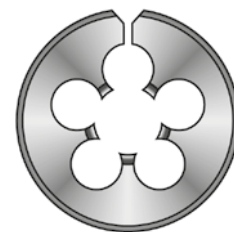
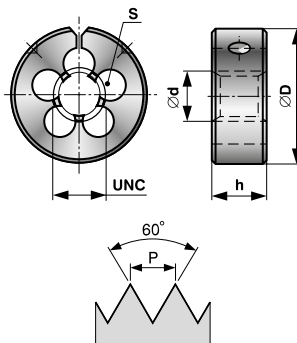
**BUČOVICE**  
TOOLS a.s.



# BS-1127:1950

**STANDARD  
HSS**

**Závitové kruhové  
čelisti stavitelné  
Circular adjustable dies  
Runde Schneideisen  
geschlitzt  
Плашки регулируемые**



**UNC**

Unifikovaný hrubý závit ASME B1.1  
Unified coarse thread ASME B1.1  
Unifiziertes-Grobgewinde ASME B1.1  
Унифицированная чёрная резьба ASME B1.1

Licování: 2A / Tolerance: 2A /  
Toleranz: 2A / Подгонка: 2A



1,5P

|           | z/1" | P     | ØD - A<br>S | ØD - B<br>S | ØD - C<br>S | ØD - D<br>S | ØD - E<br>S | ØD - G<br>S | Ød    | code <sup>x)</sup> |
|-----------|------|-------|-------------|-------------|-------------|-------------|-------------|-------------|-------|--------------------|
| UNC 4     | 40   | 0,635 | 3           |             |             |             |             |             | 2,76  | XXX 004            |
| UNC 5     | 40   | 0,635 | 3           |             |             |             |             |             | 3,09  | XXX 005            |
| UNC 6     | 32   | 0,794 | 3           |             |             |             |             |             | 3,41  | XXX 006            |
| UNC 8     | 32   | 0,794 | 3           |             |             |             |             |             | 4,07  | XXX 008            |
| UNC 10    | 24   | 1,058 | 3           |             |             |             |             |             | 4,71  | XXX 010            |
| UNC 12    | 24   | 1,058 | 4           |             |             |             |             |             | 5,37  | XXX 012            |
| UNC 1/4   | 20   | 1,270 |             | 4           | 4           |             |             |             | 6,22  | XXX 140            |
| UNC 5/16  | 18   | 1,411 |             | 4           | 4           |             |             |             | 7,80  | XXX 516            |
| UNC 3/8   | 16   | 1,588 |             | 4           | 4           | 4           |             |             | 9,37  | XXX 380            |
| UNC 7/16  | 14   | 1,814 |             |             | 5           | 5           |             |             | 10,95 | XXX 716            |
| UNC 1/2   | 13   | 1,954 |             |             | 5           | 5           |             |             | 12,52 | XXX 120            |
| UNC 9/16  | 12   | 2,117 |             |             | 6           | 5           |             |             | 14,10 | XXX 916            |
| UNC 5/8   | 11   | 2,309 |             |             |             | 5           |             |             | 15,68 | XXX 580            |
| UNC 3/4   | 10   | 2,540 |             |             |             | 6           |             |             | 18,84 | XXX 340            |
| UNC 7/8   | 9    | 2,822 |             |             |             |             | 5           |             | 22,00 | XXX 780            |
| UNC 1     | 8    | 3,175 |             |             |             |             | 6           |             | 25,16 | XXX 100            |
| UNC 1 1/8 | 7    | 3,629 |             |             |             |             |             | 6           | 28,31 | XXX 118            |
| UNC 1 1/4 | 7    | 3,629 |             |             |             |             |             | 7           | 31,49 | XXX 114            |
| UNC 1 3/8 | 6    | 4,233 |             |             |             |             |             | 9           | 34,63 | XXX 138            |
| UNC 1 1/2 | 6    | 4,233 |             |             |             |             |             | 8           | 37,80 | XXX 112            |

x) 445 XXXA (13/16" - 20,6 mm, h = 6,35)

x) 445 XXXB (1" - 25,4 mm, h = 9,5)

x) 445 XXXC (1 5/16" - 33,4 mm, h = 11,1)

x) 445 XXXD (1 1/2" - 38,1 mm, h = 12,7)

x) 445 XXXE (2" - 50,8 mm, h = 15,9)

x) 445 XXXG (3" - 76,2 mm, h = 22,2)



**BUČOVICE  
TOOLS a.s.**

Materiál: HSS  
Provedení: závit lapovaný  
do UNC 1"  
Závit: pravý

Material: HSS  
Execution: lapped thread  
to UNC 1"  
Thread: right-hand

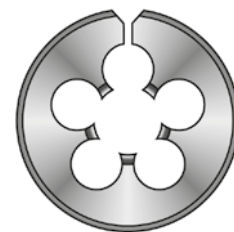
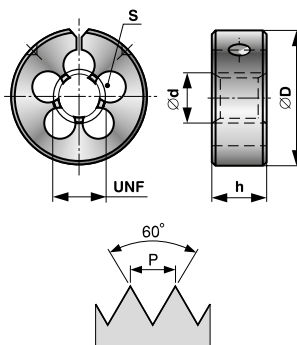
Werkstoff: HSS  
Ausführung: geläpptes Ge-  
winde bis UNC 1"  
Gewinde: rechts

Материал: HSS  
Изготовлено: резьба  
шлифованная до UNC 1"  
Резьба: правая

# BS-1127:1950

**STANDARD  
HSS**

**Závitové kruhové  
čelisti stavitelné  
Circular adjustable dies  
Runde Schneideisen  
geschlitzt  
Плашки регулируемые**



**UNF**

Unifikovaný jemný závit ASME B1.1  
Unified fine thread ASME B1.1  
Unifiziertes-Feingewinde ASME B1.1  
Унифицированная мелкая резьба ASME B1.1

Licování: 2A / Tolerance: 2A /  
Toleranz: 2A / Подгонка: 2A



1,5P

|           | z/1" | P     | ØD - A<br>S | ØD - B<br>S | ØD - C<br>S | ØD - D<br>S | ØD - E<br>S | ØD - G<br>S | ØD    | code <sup>x)</sup> |
|-----------|------|-------|-------------|-------------|-------------|-------------|-------------|-------------|-------|--------------------|
| UNF 4     | 48   | 0,529 | 3           |             |             |             |             |             | 2,77  | XXX 004            |
| UNF 5     | 44   | 0,577 | 3           |             |             |             |             |             | 3,10  | XXX 005            |
| UNF 6     | 40   | 0,635 | 3           |             |             |             |             |             | 3,42  | XXX 006            |
| UNF 8     | 36   | 0,706 | 4           |             |             |             |             |             | 4,08  | XXX 008            |
| UNF 10    | 32   | 0,794 | 4           |             |             |             |             |             | 4,73  | XXX 010            |
| UNF 12    | 28   | 0,907 | 4           |             |             |             |             |             | 5,38  | XXX 012            |
| UNF 1/4   | 28   | 0,907 |             | 4           | 4           |             |             |             | 6,24  | XXX 140            |
| UNF 5/16  | 24   | 1,058 |             | 4           | 4           |             |             |             | 7,82  | XXX 516            |
| UNF 3/8   | 24   | 1,058 |             | 4           | 4           | 4           |             |             | 9,41  | XXX 380            |
| UNF 7/16  | 20   | 1,270 |             |             | 5           | 5           |             |             | 10,98 | XXX 716            |
| UNF 1/2   | 20   | 1,270 |             |             | 5           | 5           |             |             | 12,56 | XXX 120            |
| UNF 9/16  | 18   | 1,411 |             |             | 5           | 5           |             |             | 14,14 | XXX 916            |
| UNF 5/8   | 18   | 1,411 |             |             |             | 5           | 5           |             | 15,73 | XXX 580            |
| UNF 3/4   | 16   | 1,588 |             |             |             | 6           | 6           |             | 18,89 | XXX 340            |
| UNF 7/8   | 14   | 1,814 |             |             |             |             | 5           |             | 22,05 | XXX 780            |
| UNF 1     | 12   | 2,117 |             |             |             |             | 6           |             | 25,21 | XXX 100            |
| UNF 1 1/8 | 12   | 2,117 |             |             |             |             |             | 6           | 28,38 | XXX 118            |
| UNF 1 1/4 | 12   | 2,117 |             |             |             |             |             | 7           | 31,55 | XXX 114            |
| UNF 1 3/8 | 12   | 2,117 |             |             |             |             |             | 9           | 34,73 | XXX 138            |
| UNF 1 1/2 | 12   | 2,117 |             |             |             |             |             | 8           | 37,90 | XXX 112            |

x) 446 XXXA (13/16" - 20,6 mm, h = 6,35)

x) 446 XXXB (1" - 25,4 mm, h = 9,5)

x) 446 XXXC (1 5/16" - 33,4 mm, h = 11,1)

x) 446 XXXD (1 1/2" - 38,1 mm, h = 12,7)

x) 446 XXXE (2" - 50,8 mm, h = 15,9)

x) 446 XXXG (3" - 76,2 mm, h = 22,2)

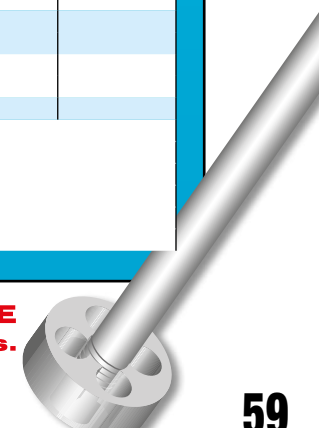
Materiál: HSS  
Provedení: závit lapovaný  
do UNF 1"  
Závit: pravý

Material: HSS  
Execution: lapped thread  
to UNF 1"  
Thread: right-hand

Werkstoff: HSS  
Ausführung: geläpptes  
Gewinde bis UNF 1"  
Gewinde: rechts

Материал: HSS  
Изготовлено: резьба  
шлифованная до UNF 1"  
Резьба: правая

**BUČOVICE**  
TOOLS a.s.

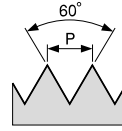
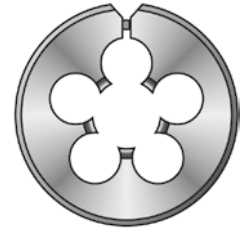
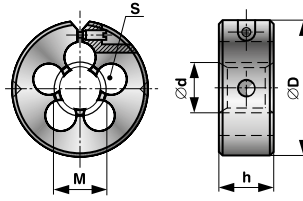




# PN 8/B 4451

**STANDARD  
HSS**

**Závitové kruhové  
čelisti stavitelné  
Circular adjustable dies  
Runde Schneideisen geschlitzt  
Плашки регулируемые**



**M**  
Metrický závit ISO DIN 13  
Standard metric thread ISO DIN 13  
Metrische Regelgewinde ISO DIN 13  
Метрическая резьба ISO DIN 13

**MF**  
Jemný metrický závit ISO DIN 13  
Fine metric thread ISO DIN 13  
Metrische Feingewinde ISO DIN 13  
Мелкая метрическая резьба ISO DIN 13

Lícování: 6g / Tolerance: 6g /  
Toleranz: 6g / Подгонка: 6g



1,5P

|       | P    | ØD - B<br>S | ØD - D<br>S | ØD - E<br>S | ØD - F<br>S | Ød    | code <sup>x)</sup> |
|-------|------|-------------|-------------|-------------|-------------|-------|--------------------|
| M 3   | 0,5  | 3           |             |             |             | 2,92  | XXX 030            |
| M 3,5 | 0,6  | 3           |             |             |             | 3,41  | XXX 036            |
| M 4   | 0,7  | 3           |             |             |             | 3,91  | XXX 040            |
| M 5   | 0,8  | 4           | 4           |             |             | 4,90  | XXX 050            |
| M 6   | 1    | 4           | 4           |             |             | 5,88  | XXX 060            |
| M 7   | 1    | 4           | 4           |             |             | 6,88  | XXX 070            |
| M 8   | 1,25 | 4           | 4           | 4           |             | 7,87  | XXX 080            |
| M 8   | 1    | 4           | 4           | 4           |             | 7,88  | XXX 081            |
| M 9   | 1,25 | 4           | 4           | 4           |             | 8,87  | XXX 090            |
| M10   | 1,5  | 5           | 4           | 4           |             | 9,85  | XXX 100            |
| M10   | 1,25 | 5           | 4           | 4           |             | 9,86  | XXX 101            |
| M10   | 1    | 5           | 4           | 4           |             | 9,88  | XXX 102            |
| M11   | 1,5  |             | 5           | 5           |             | 10,85 | XXX 110            |
| M12   | 1,75 |             | 4           | 4           |             | 11,83 | XXX 120            |
| M12   | 1,5  |             | 4           | 4           |             | 11,85 | XXX 121            |
| M12   | 1,25 |             | 4           | 4           |             | 11,86 | XXX 122            |
| M12   | 1    |             | 4           | 4           |             | 11,88 | XXX 123            |
| M14   | 2    |             | 5           | 5           |             | 13,82 | XXX 140            |
| M14   | 1,5  |             | 5           | 5           |             | 13,85 | XXX 141            |
| M14   | 1,25 |             | 5           | 5           |             | 13,86 | XXX 142            |
| M16   | 2    |             | 5           | 5           |             | 15,82 | XXX 160            |
| M16   | 1,5  |             | 5           | 5           |             | 15,85 | XXX 161            |
| M18   | 2,5  |             |             | 5           |             | 17,79 | XXX 180            |
| M18   | 1,5  |             |             | 5           |             | 17,85 | XXX 182            |
| M20   | 2,5  |             |             | 6           |             | 19,79 | XXX 200            |
| M20   | 1,5  |             |             | 6           |             | 19,85 | XXX 202            |
| M22   | 2,5  |             |             | 6           | 5           | 21,79 | XXX 220            |
| M22   | 1,5  |             |             | 6           | 5           | 21,85 | XXX 221            |
| M24   | 3    |             |             | 6           | 6           | 23,76 | XXX 240            |
| M24   | 2    |             |             | 6           | 6           | 23,82 | XXX 241            |
| M24   | 1,5  |             |             | 6           | 6           | 23,85 | XXX 242            |
| M25   | 1,5  |             |             | 6           | 6           | 24,85 | XXX 251            |
| M27   | 3    |             |             |             | 6           | 26,76 | XXX 270            |
| M30   | 2,5  |             |             |             | 7           | 29,73 | XXX 300            |
| M33   | 3,5  |             |             |             | 8           | 32,73 | XXX 330            |
| M36   | 4    |             |             |             | 9           | 35,70 | XXX 360            |

x) 460 XXXB (1" - 25,4 mm, h = 9,5)  
x) 460 XXXD (1 1/2" - 38,1 mm, h = 12,7)  
x) 460 XXXE (2" - 50,8 mm, h = 15,9)  
x) 460 XXXF (2 1/2" - 63,5 mm, h = 19,05)

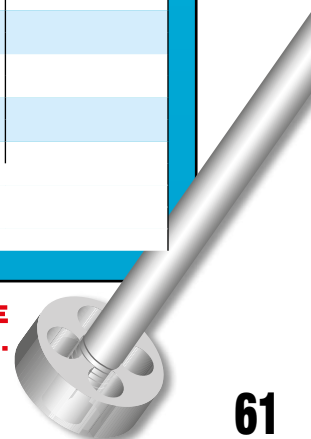
Materiál: HSS  
Provedení: závit lapovaný  
do M 26  
Závit: pravý

Material: HSS  
Execution: lapped thread  
to M 26  
Thread: right-hand

Werkstoff: HSS  
Ausführung: geläpptes  
Gewinde bis M 26  
Gewinde: rechts

Материал: HSS  
Изготовлено: резьба  
шлифованная до M 26  
Резьба: правая

**BUČOVICE  
TOOLS a.s.**

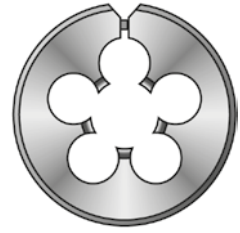
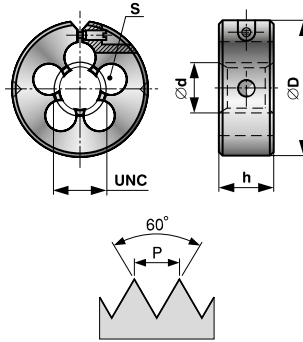




# PN 8/B 4451

**STANDARD  
HSS**

**Závitové kruhové  
čelisti stavitelné**  
**Circular adjustable dies**  
**Runde Schneideisen**  
**geschlitzt**  
**Плашки регулируемые**




**UNC**

Unifikovaný hrubý závit ASME B1.1  
Unified coarse thread ASME B1.1  
Unifiziertes-Grobgewinde ASME B1.1  
Унифицированная чёрная резьба ASME B1.1

Licování: 2A / Tolerance: 2A /  
Toleranz: 2A / Подгонка: 2A



1,5P

|           | z/1" | P     | ØD - A<br>S | ØD - B<br>S | ØD - C<br>S | ØD - D<br>S | ØD - E<br>S | ØD - G<br>S |  | code <sup>x)</sup> |
|-----------|------|-------|-------------|-------------|-------------|-------------|-------------|-------------|---|--------------------|
| UNC 4     | 40   | 0,635 | 3           |             |             |             |             |             | 2,76  | XXX 004            |
| UNC 5     | 40   | 0,635 | 3           |             |             |             |             |             | 3,09  | XXX 005            |
| UNC 6     | 32   | 0,794 | 3           | 3           |             |             |             |             | 3,41  | XXX 006            |
| UNC 8     | 32   | 0,794 | 3           | 3           |             |             |             |             | 4,07  | XXX 008            |
| UNC 10    | 24   | 1,058 | 3           | 3           |             |             |             |             | 4,71  | XXX 010            |
| UNC 12    | 24   | 1,058 | 4           | 4           |             |             |             |             | 5,37  | XXX 012            |
| UNC 1/4   | 20   | 1,270 | 4           | 4           | 4           | 4           |             |             | 6,22  | XXX 140            |
| UNC 5/16  | 18   | 1,411 |             | 4           | 4           | 4           |             |             | 7,80  | XXX 516            |
| UNC 3/8   | 16   | 1,588 |             | 4           | 4           | 4           | 4           |             | 9,37  | XXX 380            |
| UNC 7/16  | 14   | 1,814 |             |             | 5           | 5           | 5           |             | 10,95   | XXX 716            |
| UNC 1/2   | 13   | 1,954 |             |             | 5           | 5           | 5           |             | 12,52   | XXX 120            |
| UNC 9/16  | 12   | 2,117 |             |             | 6           | 5           | 5           |             | 14,10   | XXX 916            |
| UNC 5/8   | 11   | 2,309 |             |             |             | 6           | 5           |             | 15,68   | XXX 580            |
| UNC 3/4   | 10   | 2,540 |             |             |             |             | 6           |             | 18,84   | XXX 340            |
| UNC 7/8   | 9    | 2,822 |             |             |             |             | 5           |             | 22,00   | XXX 780            |
| UNC 1     | 8    | 3,175 |             |             |             |             | 6           |             | 25,16   | XXX 100            |
| UNC 1 1/8 | 7    | 3,629 |             |             |             |             |             | 6           | 28,31   | XXX 118            |
| UNC 1 1/4 | 7    | 3,629 |             |             |             |             |             | 7           | 31,49   | XXX 114            |
| UNC 1 3/8 | 6    | 4,233 |             |             |             |             |             | 9           | 34,63   | XXX 138            |
| UNC 1 1/2 | 6    | 4,233 |             |             |             |             |             | 8           | 37,81   | XXX 112            |

x) 465 XXXA (13/16" - 20,6 mm, h = 6,35)

x) 465 XXXB (1" - 25,4 mm, h = 9,5)

x) 465 XXXC (1 5/16" - 33,4 mm, h = 11,1)

x) 465 XXXD (1 1/2" - 38,1 mm, h = 12,7)

x) 465 XXXE (2" - 50,8 mm, h = 15,9)

x) 465 XXXG (3" - 76,2 mm, h = 22,2)



**BUČOVICE  
TOOLS a.s.**

Materiál: HSS  
Provedení: závit lapovaný  
do UNC 1"  
Závit: pravý

Material: HSS  
Execution: lapped thread  
to UNC 1"  
Thread: right-hand

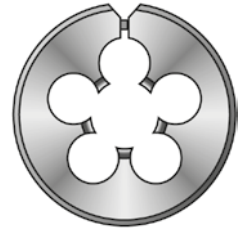
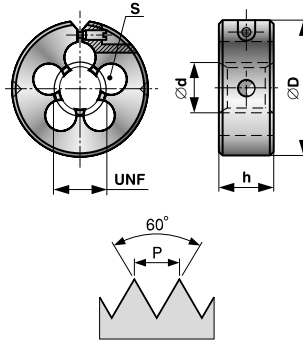
Werkstoff: HSS  
Ausführung: geläpptes Ge-  
winde bis UNC 1"  
Gewinde: rechts

Материал: HSS  
Изготовлено: резьба  
шлифованная до UNC 1"  
Резьба: правая

# PN 8/B 4451

**STANDARD  
HSS**

**Závitové kruhové  
čelisti stavitelné  
Circular adjustable dies  
Runde Schneideisen  
geschlitz  
Плашки регулируемые**



**UNF**

Unifikovaný jemný závit ASME B1.1  
Unified fine thread ASME B1.1  
Unifiziertes-Feingewinde ASME B1.1  
Унифицированная мелкая резьба ASME B1.1

Licování: 2A / Tolerance: 2A /  
Toleranz: 2A / Подгонка: 2A



1,5P

|           | z/1" | P     | ØD - A<br>S | ØD - B<br>S | ØD - D<br>S | ØD - E<br>S | ØD - F<br>S | Ød    | code <sup>x)</sup> |
|-----------|------|-------|-------------|-------------|-------------|-------------|-------------|-------|--------------------|
| UNF 4     | 48   | 0,529 | 3           |             |             |             |             | 2,77  | XXX 004            |
| UNF 5     | 44   | 0,577 | 3           |             |             |             |             | 3,10  | XXX 005            |
| UNF 6     | 40   | 0,635 | 3           |             |             |             |             | 3,42  | XXX 006            |
| UNF 8     | 36   | 0,706 | 3           |             |             |             |             | 4,08  | XXX 008            |
| UNF 10    | 32   | 0,794 | 4           |             |             |             |             | 4,73  | XXX 010            |
| UNF 12    | 28   | 0,907 | 4           |             |             |             |             | 5,38  | XXX 012            |
| UNF 1/4   | 28   | 0,907 | 4           | 4           |             |             |             | 6,24  | XXX 140            |
| UNF 5/16  | 24   | 1,058 |             | 4           |             |             |             | 7,82  | XXX 516            |
| UNF 3/8   | 24   | 1,058 |             | 4           | 4           |             |             | 9,41  | XXX 380            |
| UNF 7/16  | 20   | 1,270 |             |             | 5           |             |             | 10,98 | XXX 716            |
| UNF 1/2   | 20   | 1,270 |             |             | 5           |             |             | 12,56 | XXX 120            |
| UNF 9/16  | 18   | 1,411 |             |             | 5           |             |             | 14,14 | XXX 916            |
| UNF 5/8   | 18   | 1,411 |             |             | 5           | 5           |             | 15,73 | XXX 580            |
| UNF 3/4   | 16   | 1,588 |             |             | 6           | 6           |             | 18,89 | XXX 340            |
| UNF 7/8   | 14   | 1,814 |             |             |             | 5           |             | 22,05 | XXX 780            |
| UNF 1     | 12   | 2,117 |             |             |             | 6           |             | 25,21 | XXX 100            |
| UNF 1 1/8 | 12   | 2,117 |             |             |             |             | 6           | 28,38 | XXX 118            |
| UNF 1 1/4 | 12   | 2,117 |             |             |             |             | 7           | 31,56 | XXX 114            |
| UNF 1 3/8 | 12   | 2,117 |             |             |             |             | 9           | 34,73 | XXX 138            |
| UNF 1 1/2 | 12   | 2,117 |             |             |             |             | 8           | 37,91 | XXX 112            |

- x) 466 XXXA (13/16" - 20,6 mm, h = 6,35)
- x) 466 XXXB (1" - 25,4 mm, h = 9,5)
- x) 466 XXXD (1 1/2" - 38,1 mm, h = 12,7)
- x) 466 XXXE (2" - 50,8 mm, h = 15,9)
- x) 466 XXXF (2 1/2" - 63,5 mm, h = 19,05)

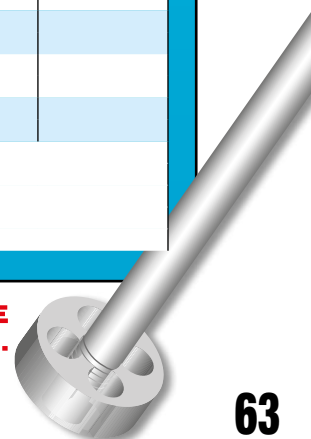
Materiál: HSS  
Provedení: závit lapovaný  
do UNF 1"  
Závit: pravý

Material: HSS  
Execution: lapped thread  
to UNF 1"  
Thread: right-hand

Werkstoff: HSS  
Ausführung: geläpptes Ge-  
winde bis UNF 1"  
Gewinde: rechts

Материал: HSS  
Изготовлено: резьба  
шлифованная до UNF 1"  
Резьба: правая

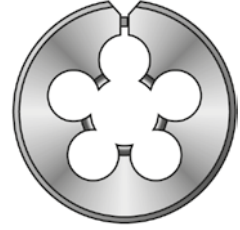
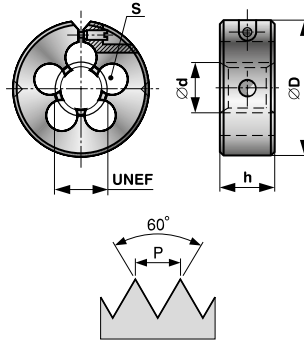
**BUČOVICE**  
TOOLS a.s.



# PN 8/B 4451

**STANDARD  
HSS**

**Závitové kruhové  
čelisti stavitelné  
Circular adjustable dies  
Runde Schneideisen  
geschlitzt  
Плашки регулируемые**



Unifikovaný jemný závit ASME B1.1  
Unified fine thread ASME B1.1  
Unifiziertes-Feingewinde ASME B1.1  
Унифицированная мелкая резьба ASME B1.1

Licování: 2A / Tolerance: 2A /  
Toleranz: 2A / Подгонка: 2A



1,5P



|             | z/1" | P     | ØD - B<br>S | ØD - D<br>S | ØD - E<br>S | ØD - F<br>S | ØD - G<br>S | Ød    | code <sup>x)</sup> |
|-------------|------|-------|-------------|-------------|-------------|-------------|-------------|-------|--------------------|
| UNE F 12    | 32   | 0,794 | 4           |             |             |             |             | 5,39  | XXX 012            |
| UNE F 1/4   | 32   | 0,794 | 4           | 4           |             |             |             | 6,25  | XXX 140            |
| UNE F 5/16  | 32   | 0,794 | 4           | 4           |             |             |             | 7,84  | XXX 516            |
| UNE F 3/8   | 32   | 0,794 | 4           | 4           |             |             |             | 9,42  | XXX 380            |
| UNE F 7/16  | 28   | 0,907 |             | 5           |             |             |             | 11,00 | XXX 716            |
| UNE F 1/2   | 28   | 0,907 |             | 5           |             |             |             | 12,59 | XXX 120            |
| UNE F 9/16  | 24   | 1,058 |             | 5           |             |             |             | 14,17 | XXX 916            |
| UNE F 5/8   | 24   | 1,058 |             | 6           |             |             |             | 15,75 | XXX 580            |
| UNE F 11/16 | 24   | 1,058 |             | 6           |             |             |             | 17,34 | XXX 011            |
| UNE F 3/4   | 20   | 1,270 |             |             | 6           |             |             | 18,91 | XXX 340            |
| UNE F 13/16 | 20   | 1,270 |             |             | 6           |             |             | 20,50 | XXX 316            |
| UNE F 7/8   | 20   | 1,270 |             |             | 5           |             |             | 22,09 | XXX 780            |
| UNE F 15/16 | 20   | 1,270 |             |             | 6           |             |             | 23,67 | XXX 151            |
| UNE F 1     | 20   | 1,270 |             |             | 6           |             |             | 25,26 | XXX 100            |
| UNE F 1 1/8 | 18   | 1,411 |             |             |             | 6           | 6           | 28,43 | XXX 118            |
| UNE F 1 1/4 | 18   | 1,411 |             |             |             | 7           | 7           | 31,60 | XXX 114            |
| UNE F 1 3/8 | 18   | 1,411 |             |             |             | 9           | 9           | 34,77 | XXX 138            |
| UNE F 1 1/2 | 18   | 1,411 |             |             |             | 8           | 8           | 37,95 | XXX 112            |

- x) 468 XXXB (1" - 25,4 mm, h = 9,5)
- x) 468 XXXD (1 1/2" - 38,1 mm, h = 12,7)
- x) 468 XXXE (2" - 50,8 mm, h = 15,9)
- x) 468 XXXF (2 1/2" - 63,5 mm, h = 19,05)
- x) 468 XXXG (3" - 76,2 mm, h = 22,2)



**BUČOVICE  
TOOLS a.s.**

Materiál: HSS  
Provedení: závit lapovaný  
do UNEF 1"  
Závit: pravý

Material: HSS  
Execution: lapped thread  
to UNEF 1"  
Thread: right-hand

Werkstoff: HSS  
Ausführung: geläpftes Ge-  
winde bis UNEF 1"  
Gewinde: rechts

Материал: HSS  
Изготовлено: резьба  
шлифованная до UNEF 1"  
Резьба: правая