

DUO

Neue DUO Doppelband Farb-gewindebohrer

Für **grosse Serien (CNC-Bearbeitung)** u. **schwierig zu bearbeitende Werkstoffe**

- Schneidstoff: Pulvermetall auf 68 HRC gehärtet, Schneidengeometrie: von Grund auf neu entwickelt
- High End-Hartstoffschichtung für optimalen Gleitschutz und Garantie für höchste Standzeiten
- Gleiche Einsatzbereiche (Farben für Materialgruppen) wie Einring-Farb-gewindebohrer

Nouveaux tarauds à bague de couleur DUO

Pour des **hautes séries (machiner à CN)** et des **matières à machiner avec difficultés**

- Matière de coupe: acier fritté à une dureté de 68 HRC, Géométrie de taraud: développé complét.de nouveau
- revêtement de la plus nouvelle technologie p.une protection optimale de glissage, hautes durées de vie
- Les mêmes champs d'application comme chez le tarauds à une bague de couleur(couleur p. les groupes de matières)

For a high volume (CNC-production) and complex workpieces

- Cutting material: powder metal hardened to 68 HRC, edge geometry has been completely newly developed
- High end coating for an opt.edge protection and highest tool life
- Same application ranges (colours for groups of materials) compared with the single colour ring taps

5838D..
5843D..

DUO Gelbring-Gewindebohrer mit metrischem Gewinde

- Ausführung: **DIN 374/376**, Typ 105/4 u.131/3 in metrischem Gewinde
- Einzelfertigschneider aus HSS-PM **105/4** mit Schälenschnitt und sorgfältig geschliffen, die Späne werden nach vorne befördert, **131/3** Sacklochgewindebohrer. Die Späne werden noch hinten befördert. Moderne Hartstoff-Beschichtung für hohe Schnittwerte
- Toleranz: ISO 2 (6H)
- Anschnittform/Gänge: 105/4: B / 4 ; 131/3: C / 2.5

Tarauds DUO gague jaune, pas métrique

- Exécution selon **DIN 374/376**, type 105/4 et 131/3
- *Finisseur en HSS -PM , 105/4 avec entrée en hélice, soigneusement meulée qui provoque l'évacuation des copeaux vers l'avant, 131/3 taraud pour trous borgne, évacuation des copeaux vers l'arrière. Revêtement p.l'optimisation des vitesses de coupe et l'augmentation des durées de vie. tolérance ISO2 (6H)*
- *Forme et longueur de l'entrée : 105/4: B / 4 ; 131/3: C / 2.5*

Machine tap DUO yellow ring for metric thread

- according **DIN 374**, type **105/4 & 131/3**
- Single finisher from HSS-PM , **105/4** with champher, accurately ground, chips are carried to the front, **131/3** taps for blind holes, chips are carried backwards. coated for the optimisation of the cutting speeds an prolongation of the tool life.
- Tolerance classe ISO 2 (6H)
- Champher form/ turns: 105/4: B / 4, 131/3: C / 2.5

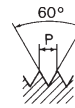
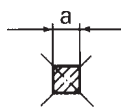
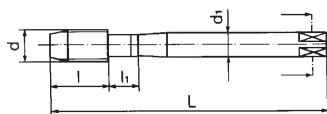


5838D
105 / 4
DIN 376

Speziell geeignet für Kupfer, Hartmessing (Ms 58, kurzspanend), Weichmessing (Ms 63, langspanend), G23 Rotguss, G24 Gusszinnbronze, Aluminium-Knetlegierungen, Magnesium-Knetlegierungen, Thermoplaste, Kunststoffe

Spécialement conçu pour cuivre, copeaux courts), laiton tendre (Ms 63, copeaux longs), laiton rouge, bronze au zinc, alliages corroyés d'aluminium, alliages corroyés de magnésium, matières thermostoplastiques

Specific suitable for copper, hard brass (Ms 58, short chip-ping), soft brass (MS 63, long chipping), red brass, phosphor bronze, wrought alloy of aluminium, wrought alloy of magnesium, thermoplastic compounds/synthetics



5843D
131 / 3
DIN 376

| 5.838D117 | | | | | | | | | | | | | DUO GELBRING ANNEAU JAUNE DUO / YELLOW RING DUO | | | | | | | | | | |
|-----------|----|-------|-----|-------|----|---------|----|---------|-----|----------|-----|----------------|---|----------|--------------|------------|-------|----------------|--|----------|--|------|--|
| Gewinde | | 105/4 | | 131/3 | | DIN 371 | | DIN 376 | | Kernloch | | Best.Nr. 105/4 | | Katal. | | HIT | | Best.Nr. 131/3 | | Katal. | | HIT | |
| Filet | | P L | | l l1 | | l l1 | | d1 a | | d1 a | | no.cde. | | catalog. | | CHOC | | no.cde. | | catalog. | | CHOC | |
| Thread | | d P L | | l l1 | | l l1 | | d1 a | | d1 a | | order no. | | catalog. | | CHF | | order no. | | catalog | | CHF | |
| M | 3 | 0,50 | 56 | 6 | 7 | 6 | 11 | 3,5 | 2,7 | | | 2.5 | 5838D. 030 | 28,50 | 23,90 | 5843D. 030 | 31,30 | 26,30 | | | | | |
| M | 4 | 0,70 | 63 | 7,5 | 8 | 7,5 | 13 | 4,5 | 3,4 | | | 3.3 | 5838D. 040 | 28,50 | 23,90 | 5843D. 040 | 31,30 | 26,30 | | | | | |
| M | 5 | 0,80 | 70 | 9 | 9 | 9 | 16 | 6 | 4,9 | | | 4.2 | 5838D. 050 | 30,40 | 25,50 | 5843D. 050 | 33,30 | 28,00 | | | | | |
| M | 6 | 1,00 | 80 | 11 | 11 | 11 | 18 | 6 | 4,9 | | | 5 | 5838D. 060 | 30,40 | 25,50 | 5843D. 060 | 33,30 | 28,00 | | | | | |
| M | 8 | 1,25 | 90 | 13 | 13 | 13 | 21 | 8 | 6,2 | | | 6.8 | 5838D. 080 | 35,20 | 29,60 | 5843D. 080 | 37,10 | 31,20 | | | | | |
| M | 10 | 1,50 | 100 | 15 | 15 | 15 | 22 | 10 | 8,0 | | | 8.5 | 5838D. 100 | 41,70 | 35,00 | 5843D. 100 | 47,50 | 39,90 | | | | | |
| M | 12 | 1,75 | 110 | 18 | 18 | 18 | | | | 9 | 7,0 | 10.2 | 5838D. 120 | 52,50 | 44,10 | 5843D. 120 | 62,00 | 52,10 | | | | | |
| M | 14 | 2,00 | 110 | 20 | 20 | | | | | 11 | 9,0 | 12 | 5838D. 140 | 81,50 | 68,50 | 5843D. 140 | 84,50 | 71,00 | | | | | |
| M | 16 | 2,00 | 110 | 32 | 20 | | | | | 12 | 9,0 | 14 | 5838D. 160 | 90,50 | 76,00 | 5843D. 160 | 92,00 | 77,30 | | | | | |

DUO Schwarzband, metrisch, 105/4 u. 131/3

DUO bague noir, pas métrique 105/4 et 131/3

DUO black ring, metric thread, 105/4 u. 131/3

Anwendung :

CNC-Maschinen - Fertigung: Materialien Baustähle > 900 N/mm², Einsatzstähle > 900 N/mm², < 1000 N/mm², Einsatzstähle < 900 N/mm², Vergütungsstähle < 1000 N/mm², oration < 1000 N/mm², aciers d'amélioration > 900 N/mm², aciers pour geschwefelt, Rostfreie Stähle ferritisch und martensitisch, rostfreie Cr-Ni-Stähle austenitisch, Stahlguss > 900 N/mm², Werkzeugstähle

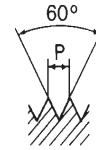
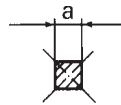
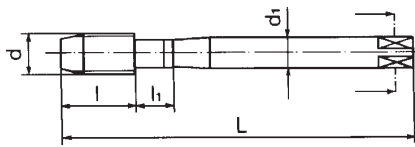
Application :

Machine CN, acier de construction aciers de cémentation < 1000 U/mm², acier de cémentation < 1000 U/mm², aciers d'amélioration > 900 N/mm², aciers pour sulfuré, aciers inoxydables Cr, tique et martensitique, aciers inoxydables Cr-Ni, austénitique, aciers moulés > 900 N/m², aciers à outils

Application:

CNC-machines, structural steels > 900 N/mm², case hardening steels < 1000 N/mm², case hardenings steels > 900 N/mm², heat treatable steels > 900 N/mm², heat treatable steels > 900 N/mm², nitriding steels, Cr stainless steels, sulphured, Cr stainless steels, ferritic and martensitic, Cr-Ni stainless steels, austenitic, case steels > 900 N/mm², carbon tool steels

5838DULTRA.. 5843DULTRA..



5838DULTRA.. 5843DULTRA..

| 5.838DULTRA118 | | | | | | | | | | | | | | DUO SCHWARZRING / ANNEAU NOIR DUO | | | | | |
|----------------|------|-------|-----|-------|-----|---------|-----|---------|----|----------|-------|---------|-----------------|-----------------------------------|---------------|-----------------|----------|--------------|--|
| Gewinde | | 105/4 | | 131/3 | | DIN 371 | | DIN 376 | | Kernloch | 105/4 | | Katal. | HIT | 131/3 | | Katal. | HIT | |
| Filet | | P | L | l | l1 | l | l1 | d1 | a | d1 | a | perçage | Best.Nr. | catalog. | CHOC | Best.Nr. | catalog. | CHOC | |
| d | Ø | | | | | | | Ø | mm | Ø | mm | | no.cde. | CHF | CHF | no.cde. | CHF | CHF | |
| M 3 | 0,50 | 56 | 6 | 7 | 6 | 11 | 3,5 | 2,7 | | 2,5 | | 2,5 | 5838DULTRA. 030 | 29,30 | 24,40 | 5843DULTRA. 030 | 32,30 | 26,90 | |
| M 4 | 0,70 | 63 | 7,5 | 8 | 7,5 | 13 | 4,5 | 3,4 | | 3,3 | | 3,3 | 5838DULTRA. 040 | 29,30 | 24,40 | 5843DULTRA. 040 | 35,90 | 29,90 | |
| M 5 | 0,80 | 70 | 9 | 9 | 9 | 16 | 6 | 4,9 | | 4,2 | | 4,2 | 5838DULTRA. 050 | 31,30 | 26,10 | 5843DULTRA. 050 | 34,30 | 28,60 | |
| M 6 | 1,00 | 80 | 11 | 11 | 11 | 18 | 6 | 4,9 | | 5 | | 5 | 5838DULTRA. 060 | 31,30 | 26,10 | 5843DULTRA. 060 | 34,30 | 28,60 | |
| M 8 | 1,25 | 90 | 13 | 13 | 13 | 21 | 8 | 6,2 | | 6,8 | | 6,8 | 5838DULTRA. 080 | 30,20 | 36,30 | 5843DULTRA. 080 | 38,20 | 31,90 | |
| M 10 | 1,50 | 100 | 15 | 15 | 15 | 22 | 10 | 8,0 | | 8,5 | | 8,5 | 5838DULTRA. 100 | 42,90 | 35,80 | 5843DULTRA. 100 | 48,90 | 40,80 | |
| M 12 | 1,75 | 110 | 18 | | 18 | | | | 9 | 7,0 | 10,2 | 10,2 | 5838DULTRA. 120 | 54,00 | 45,00 | 5843DULTRA. 120 | 53,20 | 58,50 | |
| M 14 | 2,00 | 110 | 20 | | 20 | | | | 11 | 9,0 | 12 | 12 | 5838DULTRA. 140 | 69,90 | 83,90 | 5843DULTRA. 140 | 87,00 | 72,50 | |
| M 16 | 2,00 | 110 | 20 | | 20 | | | | 12 | 9,0 | 14 | 14 | 5838DULTRA. 160 | 93,10 | 77,60 | 5843DULTRA. 160 | 94,70 | 78,90 | |
| M 18 | 2,50 | 125 | 22 | | 22 | | | | 14 | 11,0 | 15,5 | 15,5 | 5838DULTRA. 180 | 123,40 | 102,90 | | | | |
| M 20 | 2,50 | 140 | 25 | | 25 | | | | 16 | 12,0 | 17,5 | 17,5 | 5838DULTRA. 200 | 131,60 | 109,70 | | | | |
| M 24 | 3,00 | 160 | 38 | | 38 | | | | 18 | 14,5 | 21 | 21 | 5838DULTRA. 240 | 186,10 | 155,10 | | | | |

105/4 131/3 PM PM DIN 374 DIN 376

DUO Balauband, metrisch, 105/4 u. 131/3

DUO bague bleu, pas métrique 105/4 et 131/3

DUO blue ring, metric thread, 105/4 u. 131/3

5838DULIN.. 5843DULIN..

Anwendung:

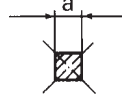
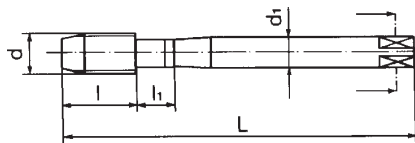
CNC-Maschinen, Nichtrostende Stähle, Baustähle, Einsatzstähle, Vergütungsstähle, Stahlguss, Werkzeugstähle, Automatenstähle usw., max. 1100 N/mm²

Application:

Machine CN, acier inoxydables, aciers de construction, aciers de cémentation, aciers d'amélioration, aciers moulés, aciers à outils, aciers de décollage etc., max 1100 N/mm²

Application:

CNC-machines, Cr-Ni stainless steels austenitic, Cr stainless steels ferritic martensitic, nitriding steels, heat resisting steels, nickel alloy, Cr stainless steels sulphured, construction steels, case hardened steel, heat treatable steels up to 1100 N/mm²



5838DULIN.. 5843DULIN..

| 5.838DULIN117 | | | | | | | | | | | | | | BLAURING / AU BLEU / BLUE RING DUO | | | | | |
|---------------|------|-----|----|-------|-----|-------|-----|--------|-----|------------------|------|-------|------------------|------------------------------------|---------------|----------------|----------|--------------|--|
| Gewinde | | P | L | 105/4 | | 131/3 | | Kernl. | | Best.Nr. 105 / 4 | Kat. | HIT | Best.Nr. 131 / 3 | Kat. | HIT | | | | |
| Filet | | Ø | | l | l1 | l | l1 | Ø | d1 | a | Ø | perç. | no.cde. | catalog. | CHOC | no.cde. | catalog. | CHOC | |
| Thread | Ø | | | | | | | | mm | mm | | | order no. | catalog. | CHF | order no. | catalog. | CHF | |
| M 3 | 0,50 | 56 | 11 | 7 | 6 | 11 | 3,5 | 2,7 | 2,5 | | 2,5 | 2,5 | 5838DULIN. 030 | 30,40 | 25,50 | 5843DULIN. 030 | 33,30 | 28,00 | |
| M 4 | 0,70 | 63 | 13 | 8 | 7,5 | 13 | 4,5 | 3,4 | 3,3 | | 3,3 | 3,3 | 5838DULIN. 040 | 30,40 | 25,50 | 5843DULIN. 040 | 33,30 | 28,00 | |
| M 5 | 0,80 | 70 | 16 | 9 | 9 | 16 | 6 | 4,9 | 4,2 | | 4,2 | 4,2 | 5838DULIN. 050 | 32,20 | 27,00 | 5843DULIN. 050 | 35,20 | 29,60 | |
| M 6 | 1,00 | 80 | 19 | 11 | 11 | 18 | 6 | 4,9 | 5 | | 5 | 5 | 5838DULIN. 060 | 32,20 | 27,00 | 5843DULIN. 060 | 35,20 | 29,60 | |
| M 8 | 1,25 | 90 | 22 | 13 | 13 | 21 | 8 | 6,2 | 6,8 | | 6,8 | 6,8 | 5838DULIN. 080 | 37,10 | 31,20 | 5843DULIN. 080 | 39,80 | 33,40 | |
| M 10 | 1,50 | 100 | 24 | 15 | 16 | 22 | 10 | 8,0 | 8,5 | | 8,5 | 8,5 | 5838DULIN. 100 | 44,50 | 37,40 | 5843DULIN. 100 | 50,50 | 42,40 | |
| M 12 | 1,75 | 110 | 29 | | 18 | | | 9 | 7,0 | 10,2 | 10,2 | 10,2 | 5838DULIN. 120 | 57,00 | 47,90 | 5843DULIN. 120 | 66,50 | 55,90 | |
| M 14 | 2,00 | 110 | 30 | | 20 | | | 11 | 9,0 | 12 | 12 | 12 | 5838DULIN. 140 | 83,50 | 70,10 | 5843DULIN. 140 | 87,50 | 73,50 | |
| M 16 | 2,00 | 110 | 32 | | 20 | | | 12 | 9,0 | 14 | 14 | 14 | 5838DULIN. 160 | 96,00 | 80,60 | 5843DULIN. 160 | 99,00 | 83,20 | |
| M 20 | 2,50 | 140 | 34 | | 16 | | | 12 | 12 | 17,5 | 17,5 | 17,5 | 5838DULIN. 200 | 135,00 | 113,40 | | | | |
| M 24 | 3,00 | 160 | 38 | | 18 | | | 14,5 | 21 | | 21 | 21 | 5838DULIN. 240 | 190,00 | 159,00 | | | | |

105/4 131/3 PM PM DIN 376 DIN 376

5838DJET..
5843DJET..

DUO Rotring-Gewindebohrer mit metrischem Gewinde

Tarauds DUO bague rouge, pas métrique

Machine tap DUO red ring for metric thread

Anwendung: Geeignet für die folgenden Materialien:
Baustähle > 900 N/mm², Einsatzstähle > 900 N/mm²; Vergütungsstähle > 900 N/mm²; Werkzeugstähle; Stahlguss > 900 N/mm²; thermoplastische Kunststoffe

Application pour les matériaux:
Aciers de constr>900 N/mm², aciers de cémentation > 900 N/mm²; aciers d'amélioration > 900 N/mm²; aciers à outils; aciers moulés > 900 N/mm²; matière thermoplastique

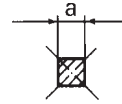
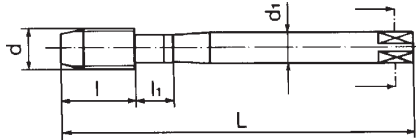
Application: Structural steels > 900 N/mm², Case hardening steels > 900 N/mm², heat treatable steels > 900 N/mm², carbon tool steels, cast steels > 900 N/mm², thermoplastic compounds/synthetics



5838DJET
105 / 4
DIN 376



5843DJET
131 / 3
DIN 376



| 5.838DJET117 | | Kernloch | | ROTBRING / ANNEAU ROUGE / RED RING DUO | | | | | | | | | | | | | |
|--------------|------|----------|-------|--|-----------|-----|---------|-----|---------|------------------|---------------|---------------|------------------|---------------|---------------|-------|-------|
| Gewinde | P | L | 105/4 | 131/3 | DIN 371 | | DIN 376 | | perçage | Best.Nr. 105 / 4 | Katal. | HIT | Best.Nr. 131 / 3 | Katal. | HIT | | |
| Filet | | | | | core hole | | no.cde. | | no.cde. | no.cde. | no.cde. | no.cde. | no.cde. | no.cde. | no.cde. | | |
| Thread | Ø | l | l1 | l | l1 | Ød1 | a | Ød1 | a | Ø | no.cde. | no.cde. | CHF | order no. | CHF | | |
| M 3 | 0,50 | 56 | 6 | 7 | 6 | 11 | 3,5 | 2,7 | | 2.5 | 5838DJET. 030 | 41,30 | 27,70 | 5843DJET. 030 | 45,30 | 30,20 | |
| M 4 | 0,70 | 63 | 7,5 | 8 | 7,5 | 13 | 4,5 | 3,4 | | 3.3 | 5838DJET. 040 | 41,20 | 27,70 | 5843DJET. 040 | 45,20 | 30,20 | |
| M 5 | 0,80 | 70 | 9 | 9 | 9 | 16 | 6 | 4,9 | | 4.2 | 5838DJET. 050 | 46,50 | 29,30 | 5843DJET. 050 | 50,90 | 31,80 | |
| M 6 | 1,00 | 80 | 11 | 11 | 11 | 18 | 6 | 4,9 | | 5 | 5838DJET. 060 | 46,70 | 29,30 | 5843DJET. 060 | 51,10 | 31,80 | |
| M 8 | 1,25 | 90 | 13 | 13 | 13 | 21 | 8 | 6,2 | | 6.8 | 5838DJET. 080 | 54,30 | 34,20 | 5843DJET. 080 | 57,30 | 36,70 | |
| M 10 | 1,50 | 100 | 24 | 15 | 16 | 22 | 10 | 8,0 | | 8.5 | 5838DJET. 100 | 64,00 | 40,70 | 5843DJET. 100 | 70,70 | 46,50 | |
| M 12 | 1,75 | 110 | 29 | | 18 | | | | 9 | 7,0 | 10.2 | 5838DJET. 120 | 78,40 | 53,00 | 5843DJET. 120 | 90,30 | 61,10 |
| M 14 | 2,00 | 110 | 30 | 20 | | | 11 | 9,0 | 12 | | 5838DJET. 140 | 106,10 | 75,00 | 5843DJET. 140 | 111,20 | 79,00 | |
| M 16 | 2,00 | 110 | 32 | 20 | | | 12 | 9,0 | 14 | | 5838DJET. 160 | 127,30 | 85,60 | 5843DJET. 160 | 128,80 | 88,00 | |

5838DULGG..
5843DULGG..

DUO Grünring-Gewindebohrer mit metrischem Gewinde

Tarauds DUO gague vert, pas métrique

Machine tap DUO green ring for metric thread

Anwendung: Für Durchgangs-und Grundbohrungen bei kurzspanenden Werkstoffen, speziell geeignet für Temperguss, Gusseisen mit Kugelgraphit (Sphäroguss), Gusseisen mit Lamellengraphit (Grauguss), Gusseisen mit Vermikulargraphit, Aluminium-Gusslegierungen Si 0.5-5%, Aluminium-Gusslegierungen Si 5%-10%, Aluminium-Gusslegierungen Si > 10%, Magnesium-Gusslegierungen, Ferro-Tic

Application: Pour des trous traversants et borgnes, matériaux de copeaux courts comme fonte malléable, fonte à graphite sphæro-dal, fonte à graphite lamellaire (fonte grise), fonte à graphite vermiculaire, alliages de fonte d'aluminium Si 0.5% - 5%, alliages de fonte d'aluminium Si 5% - 10%, alliages de fonte d'aluminium Si > 10%, alliages de fonte de magnésium, ferro-Tic

Application: through and blind holes and for materials with short chips, particularly suitable for malleable cast iron, modular graphite cast iron, lamellar graphite cast iron (grey cast iron), vermicular graphite cast iron, aluminium cast alloy Si 0.5% - 5%, aluminium cast alloy Si 5% - 10%, aluminium cast alloy Si > 10%, cast alloy of magnesium, ferro-Tic



5838DULGG
105 / 4
DIN 371



5838DULGG
131/34
DIN 376

| Gewinde | DIN 371 | | | | DIN 376 | | Kernloch | DUO | | | |
|---------|---------|-----|----|----|---------|------|----------|----------|----------------|----------------|-------|
| Filet | Ø | P | L | l | l1 | | perçage | Best.Nr. | ULTRA GG | | |
| Thread | | | | | | Ø d1 | a | Ø d1 | a | 5.838DULGG117 | |
| | | | | | | | | | | CHF | |
| M 3 | 0,50 | 56 | 11 | 7 | 4,5 | 2,7 | | 2.5 | 5838DULGG. 030 | 21,60 | |
| M 4 | 0,70 | 63 | 13 | 8 | 4,5 | 3,4 | | 3.3 | 5838DULGG. 040 | 21,00 | |
| M 5 | 0,80 | 70 | 16 | 9 | 6,0 | 4,9 | | 4.2 | 5838DULGG. 050 | 22,00 | |
| M 6 | 1,00 | 80 | 19 | 11 | 6,0 | 4,9 | | 5 | 5838DULGG. 060 | 22,90 | |
| M 8 | 1,25 | 90 | 22 | 13 | 8,0 | 6,2 | | 6.8 | 5838DULGG. 080 | 24,90 | |
| M 10 | 1,50 | 100 | 24 | 15 | 10,0 | 8,0 | | 8.5 | 5838DULGG. 100 | 30,20 | |
| M 12 | 1,75 | 110 | 29 | | | | 9 | 7,0 | 10.2 | 5838DULGG. 120 | 37,30 |
| M 14 | 2,00 | 110 | 30 | | | | 11 | 9,0 | 12 | 5838DULGG. 140 | 50,90 |
| M 16 | 2,00 | 110 | 32 | | | | 12 | 9,0 | 14 | 5838DULGG. 160 | 60,80 |
| M 18 | 2,50 | 125 | 34 | | | | 14 | 11,0 | 15.5 | 5838DULGG. 180 | 77,60 |
| M 20 | 2,50 | 140 | 34 | | | | 16 | 12,0 | 17.5 | 5838DULGG. 200 | 79,70 |