

Ovalama Aparatları Thread Rolling Heads



Üretimimize özel diş açma çözümleri

Special thread rolling solutions for your production.

Sabit Aparatlar
Stationary Rolling Heads

Döner Sistem Aparatlar
Rotary Rolling Heads

Özel Aparatlar
Special Rolling Heads

Tornalama Aparatları
Turning Heads



Neden VABS? Why VABS?

Zaman kazandırır
Saves time

VABS aparatları talaşlı yöntemle göre çok daha hızlı diş açma imkanı sunar. Bu da üretim süresinde %90'a varan tasarruf sağlar.
VABS devices offering very fast thread rolling process. This method provides time savings up to 90% in production.

Kullanım kolaylığı sağlar
User friendly handling

Her türlü CNC makinelerinde ve döner sistemlerde kullanılabilir. Makinenin kullanım süresini talaş kaldırma işlemiyle çekilen dişlere göre azaltır. Talaş kaldırma işlemine kıyasla saniyeler içinde ovalama işlemini bitirir.
The rolling heads can be used on any type of lathe and CNC machine. In comparison to the cutting operation there is a big reduction of machine operating time. The rolling process takes only few seconds.

Malzeme kullanımını azaltır
Decreases material usage

VABS aparatlarının sunduğu ovalama sistemi, talaşlı imalata oranla daha verimlidir ve bu verim hammaddeden tasarruf etmenizi sağlar.
Thread rolling system provided by VABS devices is more efficient in comparison to the cutting process and allows savings from the raw material.

Üretim kalitesini artırır
Increases production quality

VABS aparatlarının sunduğu ovalama yöntemi sayesinde dişlerin sertliğini ve yüzeyin parlaklığını artırır. Böylece ürün hassasiyetini en yüksek düzeye çıkartmaya olanak sağlar.
Thread rolling method that offered by VABS, increases thread hardness and surface radiance. With this way it provides long-lasting and quality screw manufacture.

VABS ile veriminizi %90 artırın!
Increase your output by 90% with VABS!



**VABS ile yüzeylerde
mükemmel sonuç.
Excellent results on
surface with VABS.**

VABS ovalama aparatları diğer yöntemlerle kıyaslandığında en yüksek diş yüzey kalitesi sunar. Vabs thread rolling heads offer the highest thread surface quality compared to other methods.



Talaş Kaldırılarak Açılan Diş Thread Cutting	25	16	6,3	4	2,5	1,6	1
Frezeleme ile Açılan Diş Thread Milling	25	16	6,3	4	2,5	1,6	1
Taşlama ile Açılan Diş Ground Thread	25	16	6,3	4	2,5	1,6	1
Ovalama ile Açılan Diş Rolled Thread	25	16	6,3	4	2,5	1,6	1

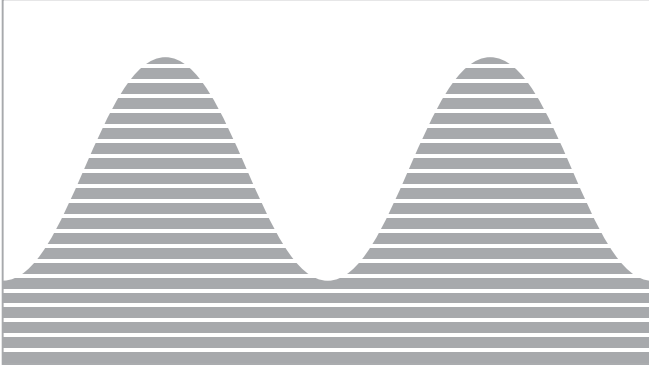
Yüzey Pürüzsüzlüğü
Surface of Hardness
Rt (μm)

Malzeme sertliğinde %30 artış

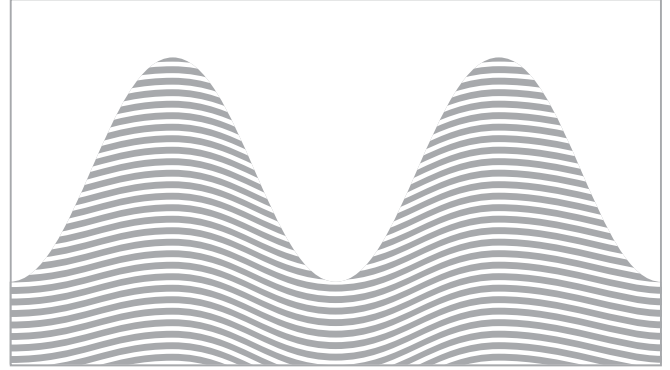
30% increase on
hardness of the material

VABS aparatlarının sunduğu ovalama yöntemi, üretilen diş formunun yüzeyini sıkılaştırarak malzemenin sertliğini artırır. Diğer yöntemlerle kıyaslandığında malzeme sertliğinde %30'a varan oranda artış sağlar.

The rolling method offered by VABS increases the hardness of the material by displacing the form of the grain structure. In other words, VABS increases material hardness by 30% when compared to other methods.



Talaş Kaldırılarak Açılan Diş Formu
Cut Thread



Ovalanarak Açılan Diş Formu
Rolled Thread

Diameter	M 2.6mm - 250mm	
Pitch	0.45mm - 10mm	
A-001	M 2.6	4
A-01	M 3.5	6
A-1	M 5	8
A-2	M 6	10
B-1	M 8	16
B-2	M 12	22
C-2	M 14	30
C-3	M 26	42



Yeni Ürünler New Products



Havşa Açma Aparatı (Saplı)
Chamfering Tools with Shaft



Havşa Açma Aparatı
Chamfering Head



Tornalama Aparatı
Turning Head

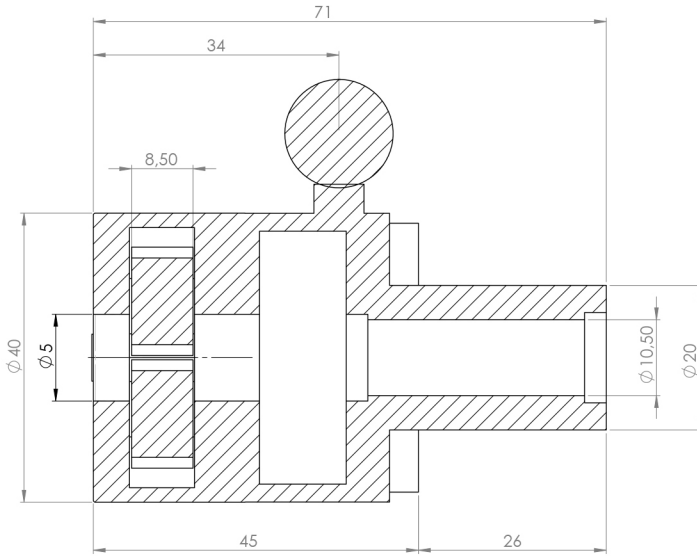


Teğetsel Ovalama Aparatı
Tangential Rolling Head

Üstün kaliteli, uzun ömürlü ve çok yönlü diş açma çözümleri.
High quality, durable and versatile thread rolling solutions.

A-001

Ultimate precision.



Metric (M) 1k-2k

Nominal Size x Pitch	
M	2,6 x 0,45
M	3 x 0,5
M 3 ...	3,5 x 0,6
M	4 x 0,7

Whithworth Threads (BSW) 1k-2k

Nominal Size x TPI	
BSW 1/8	- 40
BSW 5/32	- 32

Unified Threads Fine (UNF) 1k-2k

Nominal Size x TPI	
UNF 4	- 48
UNF 5	- 44
UNF 6	- 40

Unified Threads Coarse (UNC) 1k-2k

Nominal Size x TPI	
UNC 4 ... 5	- 40
UNC 6 ... 8	- 32

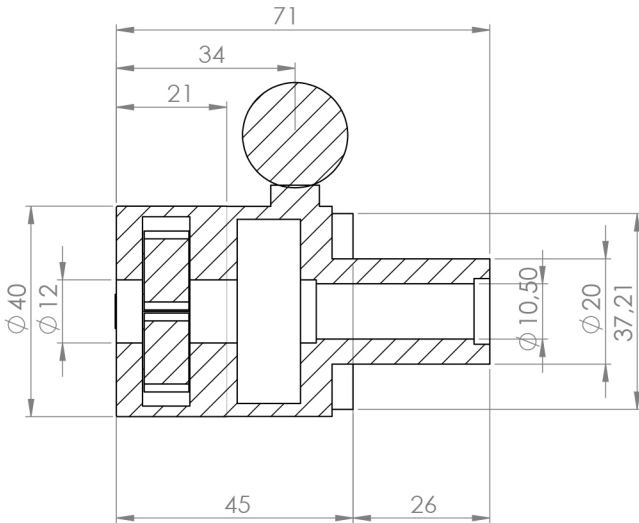
British Association (BA) 1k-2k

Nominal Size x TPI	
BA 6	- 47.9
BA 5	- 43.1
BA 4	- 38.5

RAA - RGE

Nominal Size x Pitch mm inch	
Ø 3 ... Ø 3,5 x 0,5	Ø 0.118 ... Ø 0.138 x 0.02
Ø 3,5 ... Ø 4 x 0,5	Ø 0.138 ... Ø 0.157 x 0.02
Ø 3 ... Ø 3,5 x 0,6	Ø 0.118 ... Ø 0.138 x 0.024
Ø 3,5 ... Ø 4 x 0,6	Ø 0.138 ... Ø 0.157 x 0.024
Ø 3 ... Ø 3,5 x 0,8	Ø 0.118 ... Ø 0.138 x 0.031
Ø 3,5 ... Ø 4 x 0,8	Ø 0.138 ... Ø 0.157 x 0.031
Ø 3,2 ... Ø 3,5 x 1,0	Ø 0.126 ... Ø 0.138 x 0.039
Ø 3,5 ... Ø 4 x 1,0	Ø 0.138 ... Ø 0.157 x 0.039
Ø 3,2 ... Ø 3,5 x 1,2	Ø 0.126 ... Ø 0.138 x 0.047
Ø 3,5 ... Ø 4 x 1,2	Ø 0.138 ... Ø 0.157 x 0.047

Nominal Size x Pitch mm inch	
Ø 2,2 - Ø 2,5	Ø 0.087 - Ø 0.098
Ø 2,5 - Ø 3	Ø 0.098 - Ø 0.118
Ø 3 - Ø 3,5	Ø 0.118 - Ø 0.138
Ø 3,5 - Ø 4	Ø 0.138 - Ø 0.157



Metric (M) 1k-2k

Nominal Size x Pitch	
M	3,5 x 0,6
M	4 x 0,7
M 4 ...	4,5 x 0,75
M	5 x 0,8
M 5 ...	5,5 x 0,9
M	6 x 1

Metric Fine (MF) 1k-2k

Nominal Size x Pitch	
MF 4 ...	5 x 0,5

Unified Threads Coarse (UNC) 1k-2k

Nominal Size x TPI	
UNC	8 - 32
UNC	10 ... 12 - 24
UNC	1/4 - 20

Unified Threads Fine (UNF) 1k-2k

Nominal Size x TPI	
UNF	6 - 40
UNF	8 - 36
UNF	10 - 32
UNF	12 - 28
UNF	1/4 - 28

British Association (BA) 1k-2k

Nominal Size x TPI	
BA 4 -	38,5
BA 3 -	34,8
BA 2 -	31,3
BA 1 -	28,2
BA 0 -	25,4

Whithworth Threads (BSW) 1k-2k

Nominal Size x TPI	
BSW	5/32 - 32
BSW	3/16 ... 7/32 - 24

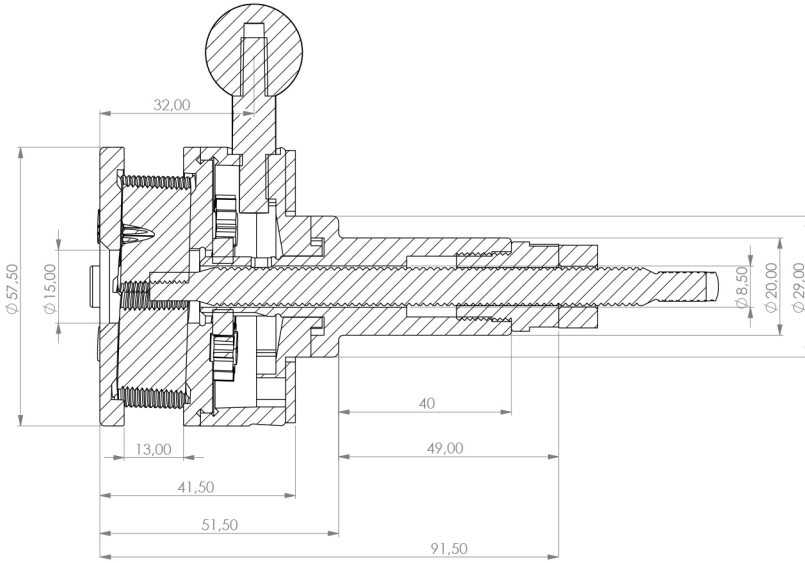
Whithworth Fine Pitch (BSF) 1k-2k

Nominal Size x TPI	
BSF	3/16 - 32
BSF	7/32 - 28
BSF	1/4 - 26

RAA - RGE

Nominal Size x Pitch mm inch	
Ø 3,5 ... Ø 4	x 0,5 Ø 0.138 ... Ø 0.157 x 0.02
Ø 4 ... Ø 4,5	x 0,5 Ø 0.157 ... Ø 0.177 x 0.02
Ø 4,5 ... Ø 5	x 0,5 Ø 0.177 ... Ø 0.197 x 0.02
Ø 5 ... Ø 5,5	x 0,5 Ø 0.197 ... Ø 0.217 x 0.02
Ø 5,5 ... Ø 6	x 0,5 Ø 0.217 ... Ø 0.236 x 0.02
Ø 3,5 ... Ø 4	x 0,6 Ø 0.138 ... Ø 0.157 x 0.024
Ø 4 ... Ø 4,5	x 0,6 Ø 0.157 ... Ø 0.177 x 0.024
Ø 4,5 ... Ø 5	x 0,6 Ø 0.177 ... Ø 0.197 x 0.024
Ø 5 ... Ø 5,5	x 0,6 Ø 0.197 ... Ø 0.217 x 0.024
Ø 5,5 ... Ø 6	x 0,6 Ø 0.217 ... Ø 0.236 x 0.024
Ø 4 ... Ø 4,5	x 0,8 Ø 0.157 ... Ø 0.177 x 0.031
Ø 4,5 ... Ø 5	x 0,8 Ø 0.177 ... Ø 0.197 x 0.031
Ø 5 ... Ø 5,5	x 0,8 Ø 0.197 ... Ø 0.217 x 0.031
Ø 5,5 ... Ø 6	x 0,8 Ø 0.217 ... Ø 0.236 x 0.031
Ø 4 ... Ø 4,5	x 1,0 Ø 0.157 ... Ø 0.177 x 0.039
Ø 4,5 ... Ø 5	x 1,0 Ø 0.177 ... Ø 0.197 x 0.039
Ø 5 ... Ø 5,5	x 1,0 Ø 0.197 ... Ø 0.217 x 0.039
Ø 5,5 ... Ø 6	x 1,0 Ø 0.217 ... Ø 0.236 x 0.039
Ø 4 ... Ø 4,5	x 1,2 Ø 0.157 ... Ø 0.177 x 0.047
Ø 4,5 ... Ø 5	x 1,2 Ø 0.177 ... Ø 0.197 x 0.047
Ø 5 ... Ø 5,5	x 1,2 Ø 0.197 ... Ø 0.217 x 0.047
Ø 5,5 ... Ø 6	x 1,2 Ø 0.217 ... Ø 0.236 x 0.047

Nominal Size x Pitch mm inch	
Ø 3 - Ø 3,5	Ø 0.118 - Ø 0.138
Ø 3,5 - Ø 4	Ø 0.138 - Ø 0.157
Ø 4 - Ø 4,5	Ø 0.157 - Ø 0.177
Ø 4,5 - Ø 5	Ø 0.177 - Ø 0.197
Ø 5 - Ø 5,5	Ø 0.197 - Ø 0.217
Ø 5,5 - Ø 6	Ø 0.217 - Ø 0.236



Metric (M) 1k-2k

Nominal Size x Pitch
M 5 ... 6 x 0,8
M 6 ... 7 x 1
M 8 ... 8 x 1,25

Metric Fine (MF) 1k-2k

Nominal Size x Pitch
MF 6 ... 7 x 0,75
MF 8 ... 8 x 1

Unified Threads Coarse (UNC) 1k-2k

Nominal Size x TPI
UNC 12 - 24
UNC 1/4 - 20
UNC 5/16 - 18

Unified Threads Fine (UNF) 1k-2k

Nominal Size x TPI
UNF 12 - 28
UNF 1/4 - 28
UNF 5/16 - 24

British Association (BA) 1k-2k

Nominal Size x TPI
BA 0 - 25.4
BA 1 - 28.2

Whithworth Fine Pitch (BSF) 1k-2k

Nominal Size x TPI
BSF 7/32 - 28
BSF 1/4 ... 9/32 - 26
BSF 5/16 - 22

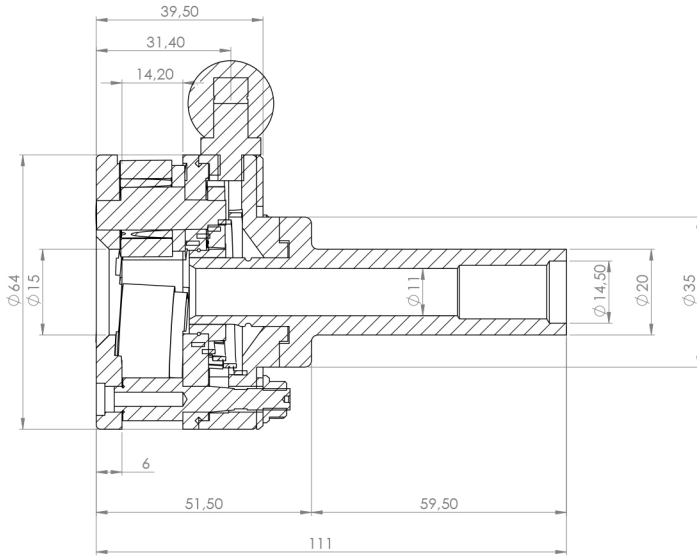
Whithworth Threads (BSW) 1k-2k

Nominal Size x TPI
BSW 7/32 - 24
BSW 1/4 - 20
BSW 5/16 - 18

RAA - RGE

Nominal Size x Pitch mm inch
Ø 5 ... Ø 6 x 0,5 Ø 0.197 ... Ø 0.236 x 0.02
Ø 6 ... Ø 7 x 0,5 Ø 0.236 ... Ø 0.276 x 0.02
Ø 7 ... Ø 8 x 0,5 Ø 0.276 ... Ø 0.315 x 0.02
Ø 5 ... Ø 6 x 0,6 Ø 0.197 ... Ø 0.236 x 0.024
Ø 6 ... Ø 7 x 0,6 Ø 0.236 ... Ø 0.276 x 0.024
Ø 7 ... Ø 8 x 0,6 Ø 0.276 ... Ø 0.315 x 0.024
Ø 5 ... Ø 6 x 0,8 Ø 0.197 ... Ø 0.236 x 0.031
Ø 6 ... Ø 7 x 0,8 Ø 0.236 ... Ø 0.276 x 0.031
Ø 7 ... Ø 8 x 0,8 Ø 0.276 ... Ø 0.315 x 0.031
Ø 5 ... Ø 6 x 1,0 Ø 0.197 ... Ø 0.236 x 0.039
Ø 6 ... Ø 7 x 1,0 Ø 0.236 ... Ø 0.276 x 0.039
Ø 7 ... Ø 8 x 1,0 Ø 0.276 ... Ø 0.315 x 0.039
Ø 6 ... Ø 7 x 1,2 Ø 0.236 ... Ø 0.276 x 0.047
Ø 7 ... Ø 8 x 1,2 Ø 0.276 ... Ø 0.315 x 0.047
Ø 6 ... Ø 7 x 1,5 Ø 0.236 ... Ø 0.276 x 0.059
Ø 7 ... Ø 8 x 1,5 Ø 0.276 ... Ø 0.315 x 0.059

Nominal Size x Pitch mm inch
Ø 5 - Ø 6 Ø 0.197 - Ø 0.236
Ø 6 - Ø 7 Ø 0.236 - Ø 0.276
Ø 7 - Ø 8 Ø 0.276 - Ø 0.315



Metric (M) 1k-2k

Nominal Size x Pitch
M 6 ... 8 x 1
M 8 ... 9 x 1,25
M 10 x 1,5

Metric Fine (MF) 1k-2k

Nominal Size x Pitch
MF 6 ... 8 x 0,75
MF 8 ... 10 x 1
MF 10 ... 11 x 1,25

Unified Threads Coarse (UNC) 1k-2k

Nominal Size x TPI
UNC 1/4 - 20
UNC 5/16 - 18
UNC 3/8 - 16
UNC 7/16 ¹⁾ - 14

Unified Threads Fine (UNF) 1k-2k

Nominal Size x TPI
UNF 1/4 - 28
UNF 5/16... 3/8 - 24
UNF 7/16 ¹⁾ - 20

Whithworth Threads (BSW) 1k-2k

Nominal Size x TPI
BSW 1/4 - 20
BSW 5/16 - 18
BSW 3/8 - 16

(NPT) 1k-2k

Nominal Size x TPI
NPT 1/16 - 27
NPT 1/8 - 27

(NPTF) 1k-2k

Nominal Size x TPI
NPTF 1/16 - 27
NPTF 1/8 - 27

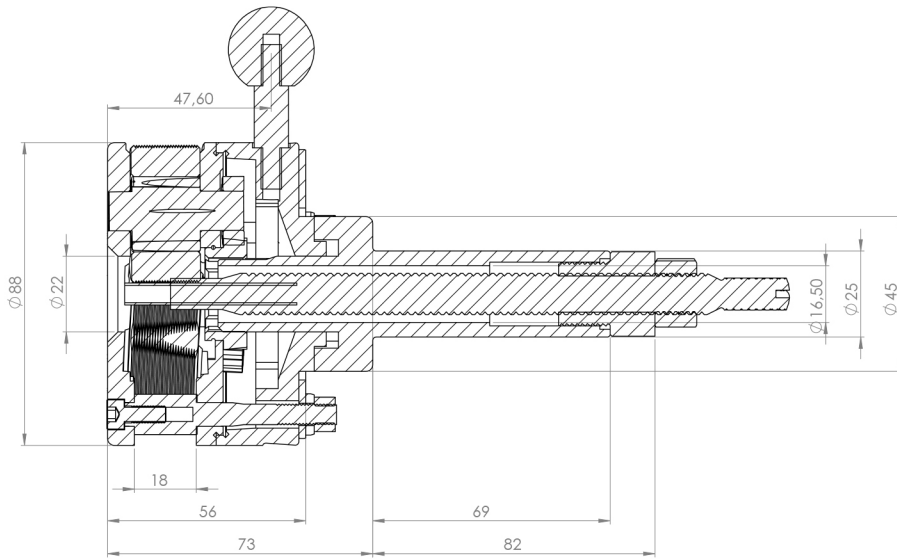
(BSF) 1k-2k

Nominal Size x TPI
BSF 1/4 - 26
BSF 5/16 - 22
BSF 3/8 - 20
BSF 7/16 ¹⁾ - 20

RAA - RGE

Nominal Size x Pitch mm inch
Ø 6 ... Ø 8 x 0,5 Ø 0.236 ... Ø 0.315 x 0.02
Ø 8 ... Ø 10 x 0,5 Ø 0.315 ... Ø 0.394 x 0.02
Ø 6 ... Ø 8 x 0,6 Ø 0.236 ... Ø 0.315 x 0.024
Ø 8 ... Ø 10 x 0,6 Ø 0.315 ... Ø 0.394 x 0.024
Ø 6 ... Ø 8 x 0,8 Ø 0.236 ... Ø 0.315 x 0.031
Ø 8 ... Ø 10 x 0,8 Ø 0.315 ... Ø 0.394 x 0.031
Ø 6 ... Ø 8 x 1,0 Ø 0.236 ... Ø 0.315 x 0.039
Ø 8 ... Ø 10 x 1,0 Ø 0.315 ... Ø 0.394 x 0.039
Ø 6 ... Ø 8 x 1,2 Ø 0.236 ... Ø 0.315 x 0.047
Ø 8 ... Ø 10 x 1,2 Ø 0.315 ... Ø 0.394 x 0.047
Ø 6 ... Ø 8 x 1,5 Ø 0.236 ... Ø 0.315 x 0.059
Ø 8 ... Ø 10 x 1,5 Ø 0.315 ... Ø 0.394 x 0.059
Ø 7 ... Ø 8 x 1,6 Ø 0.276 ... Ø 0.315 x 0.063
Ø 8 ... Ø 10 x 1,6 Ø 0.315 ... Ø 0.394 x 0.063
Ø 7 ... Ø 8 x 2,0 Ø 0.276 ... Ø 0.315 x 0.079
Ø 8 ... Ø 10 x 2,0 Ø 0.315 ... Ø 0.394 x 0.079

Nominal Size x Pitch mm inch
Ø 6 - Ø 8 Ø 0.236 - Ø 0.315
Ø 7 - Ø 10 Ø 0.276 - Ø 0.394



Metric Fine (MF) 1k-2k

Nominal Size x Pitch
MF 8 ... 10 x0,5
MF 8 ... 10 x0,75
MF 10 ... 12 x0,75
MF 10 ... 12 x1
MF 12 ... 14 x1
MF 14 ... 16 x1
MF 16 ... 18 ¹⁾ x1
MF 18 ¹⁾ ... 20 ¹⁾ x1
MF 14 ... 16 x 1,25
MF 16 ... 18 ¹⁾ x 1,5
MF 18 ¹⁾ ... 20 ¹⁾ x 1,5
MF 20 ¹⁾ ... 22 ¹⁾ x 1,5

Unified Thread Standard (UN) 1k-2k

Nominal Size x TPI
UN 7/16 ... 1/2 - 32
UN 1/2 ... 9/16 - 20
UN 1/2 ... 9/16 - 28
UN 1/2 ... 9/16 - 32
UN 9/16 ... 5/8 - 20
UN 9/16 ... 5/8 - 28
UN 9/16 ... 5/8 - 32
UN 5/8 ... 11/16 ¹⁾ - 16
UN 5/8 ... 11/16 ¹⁾ - 20
UN 5/8 ... 11/16 ¹⁾ - 28
UN 3/4 ¹⁾ ... 13/16 ¹⁾ - 16

Unified Fine Threads (UNF) 1k-2k

Nominal Size x TPI
UNF 9/16 ... 5/8 - 18
UNF 11/16 ¹⁾ ... 3/4 ¹⁾ - 16

UN Extra Fine Threads (UNEF) 1k-2k

Nominal Size x TPI
UNEF 5/16 ... 3/8 - 32
UNEF 3/8 ... 7/16 - 32
UNEF 7/16 ... 1/2 - 28
UNEF 9/16 ... 5/8 - 24
UNEF 5/8 ... 11/16 ¹⁾ - 24
UNEF 11/16 ¹⁾ ... 3/4 ¹⁾ - 20
UNEF 3/4 ¹⁾ ... 13/16 ¹⁾ - 20
UNEF 13/16 ¹⁾ ... 7/8 ¹⁾ - 20

British Standard Fine (BSFS) 1k-2k

Nominal Size x TPI
BSFS 5/16 ... 3/8 - 32
BSFS 7/16 ... 1/2 - 26
BSFS 1/2 ... 9/16 - 20
BSFS 1/2 ... 9/16 - 26
BSFS 9/16 ... 5/8 - 20
BSFS 9/16 ... 5/8 - 26
BSFS 5/8 ... 11/16 ¹⁾ - 20
BSFS 5/8 ... 11/16 ¹⁾ - 26
BSFS 3/4 ¹⁾ ... 13/16 ¹⁾ - 26
BSFS 3/4 ¹⁾ ... 13/16 ¹⁾ - 16
BSFS 3/4 ¹⁾ ... 13/16 ¹⁾ - 20
BSFS 13/16 ¹⁾ ... 7/8 ¹⁾ - 20

(G) 1k

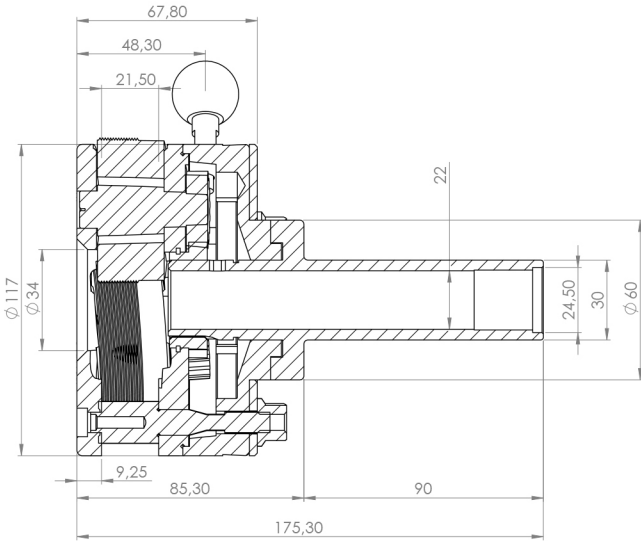
Nominal Size x TPI
G 1/8 - 28
G 1/4 - 19
G 3/8 ¹⁾ - 19
G 1/2 ¹⁾ - 14

National Pipe Thread (NPT) 1k

Nominal Size x TPI
NPT 1/8 - 27
NPT 1/4 - 18
NPT 3/8 - 18

National Pipe Taper Fuel (NPTF) 1k

Nominal Size x TPI
NPTF 1/8 - 27
NPTF 1/4 - 18
NPTF 3/8 - 18



Metric

(M) 1k-2k

Nominal Size x Pitch
M 12 ... 14 x 1,75
M 14 ... 16 x 2
M 18 ... 20 x 2,5
M 20 ... 22 x 2,5

Metric Fine

(MF) 1k-2k

Nominal Size x Pitch
MF 12 ... 14 x 1,5
MF 14 ... 16 x 1,5
MF 18 ... 20 x 2
MF 20 ... 22 x 2

Unified Threads

Coarse (UNC) 1k-2k

Nominal Size x Pitch
UNC 7/16 - 14
UNC 1/2 - 13
UNC 9/16 - 12
UNC 5/8 - 11
UNC 3/4 - 10
UNC 7/8 - 9

Unified Threads

Fine (UNF) 1k-2k

Nominal Size x Pitch
UNF 7/16 ... 1/2 - 20
UNF 9/16 ... 5/8 - 18
UNF 3/4 - 16
UNF 7/8 - 14

(G) 1k-2k

Nominal Size x Pitch
G 1/4... 3/8 - 19
G 1/2 - 14

British Standard Fine (BSF) 1k-2k

Nominal Size x Pitch
BSF 7/16 - 18
BSF 1/2 ... 9/16 - 16
BSF 5/8 ... 11/16 - 14
BSF 3/4 - 12
BSF 7/8 ... 15/16 ¹⁾ - 11

Whitworth Threads (BSW) 1k-2k

Nominal Size x Pitch
BSW 7/16 - 14
BSW 1/2 ... 9/16 - 12
BSW 5/8 ... 11/16 - 11
BSW 3/4 - 10
BSW 7/8 ... 15/16 - 9

National Pipe Thread (NPT) 1k

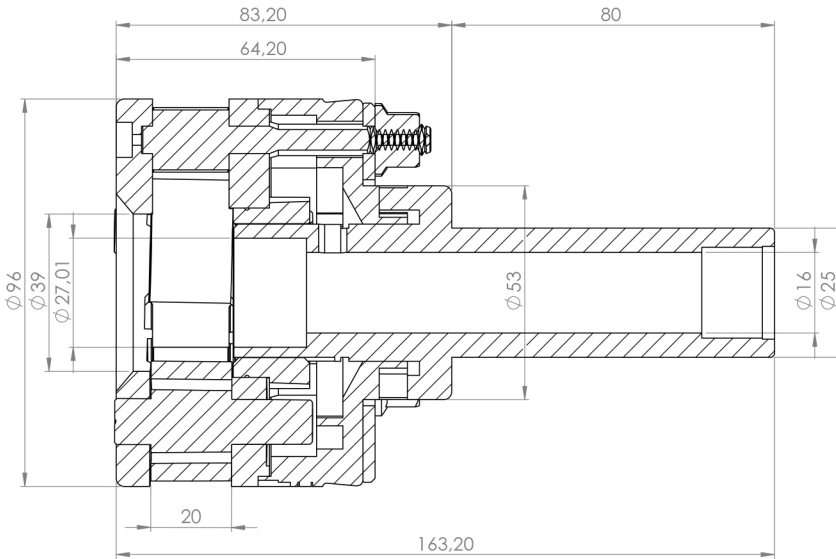
Nominal Size x Pitch
NPT 1/4 - 18

National Pipe Taper Fuel (NPTF) 1k

Nominal Size x Pitch
NPTF 1/4 - 18

RAA - RGE

Nominal Size x Pitch		mm inch	
Ø 12 ...	Ø 14 x 0,5	Ø 0.472 ...	Ø 0.551 x 0.02
Ø 14 ...	Ø 16 x 0,5	Ø 0.551 ...	Ø 0.63 x 0.02
Ø 16 ...	Ø 18 x 0,5	Ø 0.63 ...	Ø 0.709 x 0.02
Ø 18 ...	Ø 20 x 0,5	Ø 0.709 ...	Ø 0.787 x 0.02
Ø 20 ...	Ø 22 x 0,5	Ø 0.787 ...	Ø 0.866 x 0.02
Ø 12 ...	Ø 14 x 0,6	Ø 0.472 ...	Ø 0.551 x 0.024
Ø 14 ...	Ø 16 x 0,6	Ø 0.551 ...	Ø 0.63 x 0.024
Ø 16 ...	Ø 18 x 0,6	Ø 0.63 ...	Ø 0.709 x 0.024
Ø 18 ...	Ø 20 x 0,6	Ø 0.709 ...	Ø 0.787 x 0.024
Ø 20 ...	Ø 22 x 0,6	Ø 0.787 ...	Ø 0.866 x 0.024
Ø 12 ...	Ø 14 x 0,8	Ø 0.472 ...	Ø 0.551 x 0.031
Ø 14 ...	Ø 16 x 0,8	Ø 0.551 ...	Ø 0.63 x 0.031
Ø 16 ...	Ø 18 x 0,8	Ø 0.63 ...	Ø 0.709 x 0.031
Ø 18 ...	Ø 20 x 0,8	Ø 0.709 ...	Ø 0.787 x 0.031
Ø 20 ...	Ø 22 x 0,8	Ø 0.787 ...	Ø 0.866 x 0.031
Ø 12 ...	Ø 14 x 1,0	Ø 0.472 ...	Ø 0.551 x 0.039
Ø 14 ...	Ø 16 x 1,0	Ø 0.551 ...	Ø 0.63 x 0.039
Ø 16 ...	Ø 18 x 1,0	Ø 0.63 ...	Ø 0.709 x 0.039
Ø 18 ...	Ø 20 x 1,0	Ø 0.709 ...	Ø 0.787 x 0.039
Ø 20 ...	Ø 22 x 1,0	Ø 0.787 ...	Ø 0.866 x 0.039
Ø 12 ...	Ø 14 x 1,2	Ø 0.472 ...	Ø 0.551 x 0.047
Ø 14 ...	Ø 16 x 1,2	Ø 0.551 ...	Ø 0.63 x 0.047
Ø 16 ...	Ø 18 x 1,2	Ø 0.63 ...	Ø 0.709 x 0.047
Ø 18 ...	Ø 20 x 1,2	Ø 0.709 ...	Ø 0.787 x 0.047
Ø 20 ...	Ø 22 x 1,2	Ø 0.787 ...	Ø 0.866 x 0.047
Ø 12 ...	Ø 14 x 1,5	Ø 0.472 ...	Ø 0.551 x 0.059
Ø 14 ...	Ø 16 x 1,5	Ø 0.551 ...	Ø 0.63 x 0.059
Ø 16 ...	Ø 18 x 1,5	Ø 0.63 ...	Ø 0.709 x 0.059
Ø 18 ...	Ø 20 x 1,5	Ø 0.709 ...	Ø 0.787 x 0.059
Ø 20 ...	Ø 22 x 1,5	Ø 0.787 ...	Ø 0.866 x 0.059
Ø 12 ...	Ø 14 x 1,6	Ø 0.472 ...	Ø 0.551 x 0.063
Ø 14 ...	Ø 16 x 1,6	Ø 0.551 ...	Ø 0.63 x 0.063
Ø 16 ...	Ø 18 x 1,6	Ø 0.63 ...	Ø 0.709 x 0.063
Ø 18 ...	Ø 20 x 1,6	Ø 0.709 ...	Ø 0.787 x 0.063
Ø 20 ...	Ø 22 x 1,6	Ø 0.787 ...	Ø 0.866 x 0.063
Ø 12 ...	Ø 14 x 2,0	Ø 0.472 ...	Ø 0.551 x 0.079
Ø 14 ...	Ø 16 x 2,0	Ø 0.551 ...	Ø 0.63 x 0.079
Ø 16 ...	Ø 18 x 2,0	Ø 0.63 ...	Ø 0.709 x 0.079
Ø 18 ...	Ø 20 x 2,0	Ø 0.709 ...	Ø 0.787 x 0.079
Ø 20 ...	Ø 22 x 2,0	Ø 0.787 ...	Ø 0.866 x 0.079



Metric Fine (MF) 1k-2k

Nominal Size x Pitch
MF 16 ¹ ... 18 ¹ x 1,5
MF 18 ¹ ... 20 ¹ x 1,5
MF 20 ¹ ... 22 ¹ x 1,5
MF 22 ¹ ... 24 ¹ x 1,5
MF 24 ¹ ... 26 ¹ x 1,5
MF 26 ¹ ... 28 ² x 1,5
MF 28 ² ... 30 ² x 1,5
MF 30 ² ... 32 ² x 1,5
MF 34 ² ... 34 ² x 1,5
MF 34 ² ... 36 ² x 1,5
MF 22 ¹ ... 24 ¹ x 2
MF 24 ¹ ... 26 ¹ x 2
MF 26 ¹ ... 28 ² x 2
MF 28 ² ... 30 ² x 2
MF 30 ² ... 32 ² x 2
MF 32 ² ... 34 ² x 2
MF 34 ² ... 36 ² x 2

Unified National (UN) 1k-2k

Nominal Size x Pitch
UN 5/8 ¹ ... 1 1/16 ¹ -20
UN 1 1/16 ¹ ... 3/4 ¹ -20
UN 3/4 ¹ -24
UN 3/4 ¹ ... 13/16 ¹ -16
UN 13/16 ¹ ... 7/8 ¹ -16
UN 7/8 ¹ ... 15/16 ¹ -16
UN 7/8 ¹ ... 15/16 ¹ -12
UN 15/16 ¹ ... 1 ¹ -16
UN 1 ¹ ... 1 1/16 ¹ -16
UN 1 1/16 ¹ ... 1 1/8 ² -20
UN 1 1/8 ² ... 1 3/16 ² -20
UN 1 1/8 ² ... 1 3/16 ² -16
UN 1 1/8 ² ... 1 3/16 ² -12
UN 1 3/16 ² ... 1 1/4 ² -16
UN 1 3/16 ² ... 1 1/4 ² -12
UN 1 1/4 ² ... 1 5/16 ² -16
UN 1 1/4 ² ... 1 5/16 ² -12
UN 1 5/16 ² ... 1 3/8 ² -16
UN 1 5/16 ² ... 1 3/8 ² -12
UN 1 3/8 ² ... 1 7/16 ² -16
UN 1 3/8 ² ... 1 7/16 ² -12

Unified Threads Fine (UNF) 1k-2k

Nominal Size x Pitch
UNF 5/8 ¹ -18
UNF 1 1/16 ¹ ... 3/4 ¹ -16
UNF 13/16 ¹ ... 7/8 ¹ -14
UNF 7/8 ¹ ... 15/16 ¹ -14
UNF 15/16 ¹ ... 1 ¹ -12
UNF 1 ¹ ... 1 1/16 ¹ -12
UNF 1 1/16 ¹ ... 1 1/8 ² -12

UN Extra Fine Threads (UNEF) 1k-2k

Nominal Size x Pitch
UNEF 5/8 ¹ -24
UNEF 1 1/16 ¹ -24
UNEF 3/4 ¹ ... 13/16 ¹ -20
UNEF 13/16 ¹ ... 7/8 ¹ -20
UNEF 7/8 ¹ ... 15/16 ¹ -20
UNEF 15/16 ¹ ... 1 ¹ -20
UNEF 1 ¹ ... 1 1/16 ¹ -20
UNEF 1 ¹ ... 1 1/16 ¹ -18
UNEF 1 1/16 ¹ ... 1 1/8 ² -18
UNEF 1 1/16 ¹ ... 1 1/8 ² -16
UNEF 1 1/8 ² ... 1 3/16 ² -18

British Standard Fine (BSFS) 1k-2k

Nominal Size x Pitch
BSFS 5/8 ¹ ... 1 1/16 ¹ -26
BSFS 5/8 ¹ ... 1 1/16 ¹ -20
BSFS 1 1/16 ¹ ... 3/4 ¹ -26
BSFS 1 1/16 ¹ ... 3/4 ¹ -20
BSFS 1 1/16 ¹ ... 3/4 ¹ -16
BSFS 1 1/16 ¹ ... 3/4 ¹ -12
BSFS 3/4 ¹ ... 13/16 ¹ -26
BSFS 3/4 ¹ ... 13/16 ¹ -20
BSFS 3/4 ¹ ... 13/16 ¹ -16
BSFS 3/4 ¹ ... 13/16 ¹ -12
BSFS 13/16 ¹ ... 7/8 ¹ -20
BSFS 7/8 ¹ ... 15/16 ¹ -20
BSFS 15/16 ¹ ... 1 ¹ -20
BSFS 1 ¹ ... 1 1/16 ¹ -20
BSFS 1 1/16 ¹ ... 1 1/8 ² -20
BSFS 1 1/8 ² ... 1 3/16 ² -20
BSFS 1 1/8 ² ... 1 3/16 ² -12
BSFS 1 1/8 ² ... 1 3/16 ² -12
BSFS 1 3/16 ² ... 1 1/4 ² -12
BSFS 1 1/4 ² ... 1 5/16 ² -12
BSFS 1 5/16 ² ... 1 3/8 ² -12
BSFS 1 3/8 ² ... 1 7/16 ² -12

National Pipe Thread (NPT) 1k

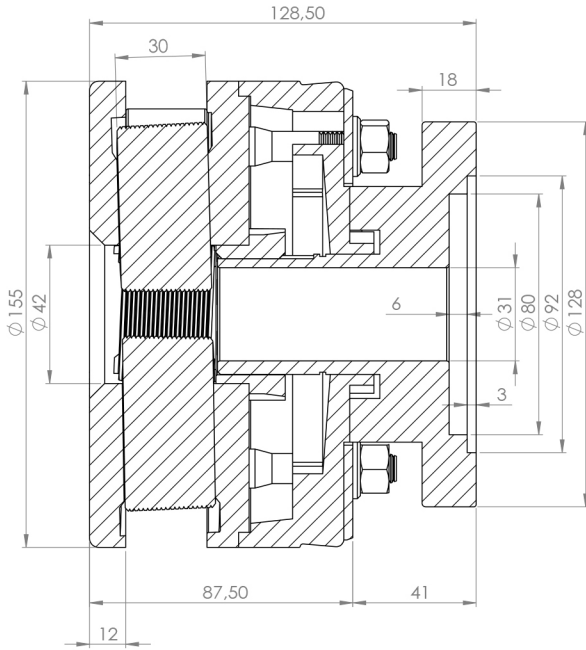
Nominal Size x Pitch
NPT 3/8 - 18

National Pipe Taper Fuel (NPTF) 1k

Nominal Size x Pitch
NPTF 3/8 - 18

(G) 1k-2k

Nominal Size x Pitch
G 3/8 ¹ - 19
G 1/2 ¹ - 14
G 5/8 ¹ - 14
G 3/4 ¹ - 14
G 7/8 ² - 14
G 1 ² - 11



Metric Fine (MF) 1k-2k

Nominal Size x Pitch
MF 16 ... 18 x 1
MF 18 ... 20 x 1
MF 20 ... 22 x 1
MF 22 ... 24 x 1
MF 18 ... 20 x 1,5
MF 20 ... 22 x 1,5
MF 22 ... 24 x 1,5
MF 24 ... 27 x 1,5
MF 27 ... 30 x 1,5
MF 30 ... 33 x 1,5
MF 33 ... 36 x 1,5
MF 36 ... 39 ¹⁾ x 1,5
MF 38 ¹⁾ ... 40 ¹⁾ x 1,5
MF 24 ... 27 x 2
MF 27 ... 30 x 2
MF 30 ... 33 x 2
MF 33 ... 36 x 2
MF 36 ... 39 ¹⁾ x 2
MF 39 ¹⁾ ... 42 ¹⁾ x 2

Unified National (UN) 1k-2k

Nominal Size x Pitch
UN 3/4 ... 13/16 -32
UN 13/16 ... 7/8 -32
UN 3/4 ... 13/16 -28
UN 13/16 ... 7/8 -28
UN 7/8 ... 15/16 -28
UN 11/16 ... 11/8 -20
UN 11/8 ... 13/16 -20
UN 13/16 ... 11/4 -20
UN 11/4 ... 15/16 -20
UN 13/16 ... 7/8 -16
UN 7/8 ... 15/16 -16
UN 15/16 ... 1 -16
UN 1 ... 11/16 -16
UN 11/16 ... 11/8 -16
UN 11/8 ... 13/16 -16
UN 13/16 ... 11/4 -16
UN 11/4 ... 15/16 -16
UN 15/16 ... 13/8 -16
UN 13/8 ... 17/16 -16
UN 17/16 ... 11/2 ¹⁾ -16
UN 11/2 ¹⁾ ... 19/16 ¹⁾ -16

Unified Threads Fine (UNF) 1k-2k

Nominal Size x Pitch
UNF 7/8 -14
UNF 1 ... 11/16 -12
UNF 11/16 ... 11/8 -12
UNF 11/8 ... 13/16 -12
UNF 13/16 ... 11/4 -12
UNF 11/4 ... 15/16 -12
UNF 15/16 ... 13/8 -12
UNF 13/8 ... 17/16 -12
UNF 17/16 ... 11/2 ¹⁾ -12
UNF 11/2 ¹⁾ ... 19/16 ¹⁾ -12

UN Extra Fine Threads (UNEF) 1k-2k

Nominal Size x Pitch
UNEF 3/4 ... 13/16 -20
UNEF 13/16 ... 7/8 -20
UNEF 7/8 ... 15/16 -20
UNEF 15/16 ... 1 -20
UNEF 1 ... 11/16 -20
UNEF 11/16 ... 11/8 -18
UNEF 11/8 ... 13/16 -18
UNEF 13/16 ... 11/4 -18
UNEF 11/4 ... 15/16 -18
UNEF 15/16 ... 13/8 -18

British Standard Fine (BSFS) 1k-2k

Nominal Size x Pitch
BSFS 11/16 ... 3/4 -26
BSFS 3/4 ... 13/16 -26
BSFS 11/16 ... 3/4 -20
BSFS 3/4 ... 13/16 -20
BSFS 13/16 ... 7/8 -20
BSFS 7/8 ... 15/16 -20
BSFS 15/16 ... -20
BSFS 1 ... 11/16 -20
BSFS 11/16 ... 11/8 -20
BSFS 11/8 ... 13/16 -20
BSFS 13/16 ... 11/4 -20
BSFS 11/4 ... 15/16 -20
BSFS 17/16 ¹⁾ -20
BSFS 3/4 ... 13/16 -16
BSFS 15/8 ¹⁾ -16
BSFS 1 ... 11/16 -12
BSFS 11/16 ... 11/8 -12
BSFS 11/8 ... 13/16 -12
BSFS 13/16 ... 11/4 -12
BSFS 11/4 ... 15/16 -12
BSFS 15/16 ... 13/8 -12
BSFS 13/8 ... 17/16 -12
BSFS 17/16 ... 11/2 ¹⁾ -12
BSFS 11/2 ¹⁾ ... 15/8 ¹⁾ -12

(G) 1k-2k

Nominal Size x Pitch
G 3/8 -19
G 1/2 -14
G 5/8 -14
G 3/4 -14
G 7/8 -14
G 1 -11
G 11/8 ¹⁾ -11
G 11/4 ¹⁾ -11

National Pipe Thread (NPT) 1k

Nominal Size x Pitch
NPT 1 -11,5
NPT 3/4 -14

National Pipe Taper Fuel (NPTF) 1k

Nominal Size x Pitch
NPTF 1 -11,5
NPTF 3/4 -14

**Veysel Kütüklü Makina
Sanayi ve Ticaret A.Ş.**
Emek Mah. Sivat Cad.
No:17 34785 Sancaktepe,
İstanbul, Turkey
Tel +90 216 466 36 90
Fax +90 216 415 55 08
info@vabs.com
www.vabs.com

