

Holder table for Thread Cutting Systems ZA12 and ZR12

Chaser holder				Metric thread DIN 13							Whitworth thread DIN 11	Whitworth pipe thread DIN EN ISO 228	Conical whitworth pipe thread DIN EN 10226	BSF thread	American threads				Valve thread DIN 7756	BSC thread DIN 79012
Designation Item number	Cutting range minor-Ø in mm	Holder angle in °	Chaser dimension in mm	Standard thread	Fine thread P =										NPT NPS	UNC	UNF	UNEF		
						0.35	0.5	0.75	1.00	1.25	1.50									
ZR12-A5,00 71121700	0.8–4.8	5.0	11 × 5,5 × 20 (S004)	M1.6–2.2							1/8" 5/32" 3/16" 1/4"					No.1-64 No.10-24 1/4-20	No. 1-72	Vg5,2	1/8" 5/32"	
ZR12-A4,33 71121000	0.8–4.8	4.33	11 × 5,5 × 20 (S004)	M2.5–6	M2 × M2,2 ×						7/32"					No. 8-32 No.12-24			3/16" 7/32"	
ZR12-A3,20 71192000	0.8–4.8	3.20	11 × 5,5 × 20 (S004)		M2,5 × M3 ×	M3.5 × M4.5 ×												Vg5		
ZR12-A2,25 71192300	0.8–4.8	2.25	11 × 5,5 × 20 (S004)		M3,5 × M5 ×	M5 ×														
ZR12-B4,08 71192600	4.5–8.5	4.08	11 × 5,5 × 20 (S004)								5/16" 3/8"					5/16-18 3/8-16				
ZR12-B3,50 71118600	4.5–8.5	3.50	11 × 5,5 × 20 (S004)	M7–10			M5.5 ×	M7.5 ×						1/4"-26 3/8"-20			1/4-28 5/16-24	No. 12-32	Vg6	1/4" 9/32"
ZR12-B2,80 71122000	4.5–8.5	2.80	11 × 5,5 × 20 (S004)				M6 × – M7.5 ×	M8 × – M9.5 ×							1/16		3/8-24	1/4-32 5/16-32	Vg7,8 Vg8	5/16" 3/8"
ZR12-B2,17 71192900	4.5–8.5	2.17	11 × 5,5 × 20 (S004)			M5.5 × M7.5 ×	M8 × – M9 ×								1/8					
ZR12-B1,58 71193200	4.5–8.5	1.58	11 × 5,5 × 20 (S004)		M5,5 × – M8.5 ×	M8 × – M9 ×														
ZR12-C3,40 71116800	8.2–12.2	3.40	11 × 5,5 × 20 (S004)	M11 M12					M10 ×	M12 ×				7/16"-8 1/2"-16						
ZR12-C2,50 71122300	8.2–12.2	2.50	11 × 5,5 × 20 (S004)					M10 × – M12 ×	M12 ×	M14 ×		G1/8" G1/4"	R1/8" R1/4"			7/16-20 1/2-20	3/8-32	Vg10	7/16"	
ZR12-C1,92 71193500	8.2–12.2	1.92	11 × 5,5 × 20 (S004)				M9.5 × – M12 ×	M12 ×									3/8-32 7/16-28 1/2-28	Vg12	1/2"	
ZR 12-C1,33 71193800	8.2–12.2	1.33	11 × 5,5 × 20 (S004)		M9 × – M12 ×	M9.5 × – M12 ×														

Holder table for Thread Cutting Systems ZA16, ZB16 and ZR16

Chaser holder			Cutting range minor-Ø in mm	Metric thread DIN 13	Metric fine thread DIN 13	Whitworth thread DIN 11	BSF thread	Whitworth pipe thread DIN EN ISO 228	Tapered whitworth pipe thread DIN EN 10226	American threads		
Designation Item number	Holder angle in °	Chaser dimension in mm								NPT NPS	NC UNC	NF UNF
ZR16/1D 70108200	4.33	14.5 × 6.5 × 32 (S02)	0–6.5	M3–3,5 M4–4,5 M5–6		1/8", 5/32" 1/32", 1/4"					No. 5-40 No. 8-32 No. 12-24 1/4-20	No. 3-56 No. 4-48 No. 5-44 No. 6-40
ZR16/2D 70108400	3.60	14.5 × 6.5 × 32 (S02)	5–11.5	M8 M10–12		5/16", 3/8" 7/16", 1/2"	1/4"-26 5/16"-22				3/8-16 7/16-14 1/2-13	1/4-28
ZR16/3D 70108800	3.33	14.5 × 6.5 × 32 (S02)	8–14.8	M14–M16		9/16", 5/8"					9/16-12 5/8-11	
ZR16/20D 70108900	2.41	14.5 × 6.5 × 32 (S02)	8–14.8		M10–11 × 1 M13–15 × 1.25 M14–16 × 1.5			G1/8" G1/4" G3/8"	R1/8" R1/4"	1/8-27 1/4-18		1/2-20 9/16-18 5/8-18
ZR16/69D 70108300	2.75	14.5 × 6.5 × 32 (S02)	0–6.5		M3 × 0.35 M4,5–5 × 0.5							
ZR16/70D 70108500	3.08	14.5 × 6.5 × 32 (S02)	5–11.5		M6 × 0.75 / M8 × 1 M10 × 1.25 M12 × 1.5		3/8"-20 1/2"-16	w		1/16-27		5/16-24
ZR16/72D 70108700	2.60	14.5 × 6.5 × 32 (S02)	5–11.5		M7–8 × 0.75 M9–10 × 1 M12 × 1.25			G1/8" G1/4"	R1/8" R1/4"	1/8-27 1/4-18		3/8-24 7/16-20 1/2-20
ZR16/71D 70108700	2.08	14.5 × 6.5 × 32* (S02)	8–14.8		M9–10 × 0.75 M12–14 × 1 M14–18 × 1.25 M18 × 1.5			G3/8"				
ZR16/76D 71071800	1.60	14.5 × 6.5 × 32 (S02)	10–16.8		M11–17 × 0.75 M15–18 × 1							5/8-24 11/16-24
ZR16/76D 71071800	1.60	14.5 × 6.5 × 32 (S02)	12–18.8		M14–18 × 0.75 M15–20 × 1 M19–20 × 1.25							5/8-24 11/16-24 3/4-20

*Chaser 14.5 × 5.5 × 32 for 18 × 1.25 and 18 × 1.5 / (S02/5,5)

For ZA, ZB 16 to 11 mm Diameter 51mm long
over 11 to 16 mm Diameter 30mm long

For ZR 16 over 16 Diameter 15mm long
over 16 Diameter 15mm long

Holder table for Thread Cutting Systems ZA22, ZB22 and ZR22

Chaser holder			Cutting range minor-Ø in mm	Metric thread DIN 13	Metric fine thread DIN 13	Whitworth thread DIN 11	BSF thread	Whitworth pipe thread DIN EN ISO 228	Tapered whitworth pipe thread DIN EN 10226	American threads		
Designation Item number	Holder angle in °	Chaser dimension in mm								NPT NPS	NC UNC	NF UNF
ZR22/1D 70191100	4.33	14.5 × 6.5 × 32 (S02)	1.7–11.7	M3–3.5 M5–6		5/32–3/8" 7/32–7/16" 1/4", 5/16", 1/2"				No. 8-32 No. 12-24 5/16-18		
ZR22/2D 70191400	3.60	14.5 × 6.5 × 32 (S02)	4–13.5	M7–9 M10–11 M11–14		9/16" 5/8"	1/4"-26 5/16"-22			1/2-13 9/16-12 5/8-11	1/4-28	
ZR22/3D 70191800	3.08	16 × 7 × 35 (S03)	11–20	M16–M18 M20–M22		3/4" 7/8"				3/4-10 7/8-9		
ZR22/20D 70191600	2.41	14.5 × 6.5 × 32 (S02)	7.8–17.3		M10–13 × 1 M13–15 × 1.25 M15–18 × 1.5		11/16"-14	G1/8" G1/4–3/8"		1/8-27 1/4-18 3/8-18*	3/8-24 1/2-20 9/16-18 5/8-18	
ZR22/21D 70191900	2	14.5 × 6.5 × 32 (S02)	16–25		M18–23 × 1.5			G1/2" G5/8" G3/4"		1/2-14* 3/4-14*	3/4-16 7/8-14 1-12	
ZR22/31D 72244500	2	16 × 7 × 35 (S03)	7.8–17.3		M14–16 × 1.5			G3/8"	R3/8"	1/8-27 1/4-18 3/8-18	1/2-20 5/8-18 3/4-16	
ZR22/32D 72243500	2.1	22 × 7 × 32 (S09)	16–25		M18–24 × 1.5			G1/2–3/4"	R1/2"	1/2-14 3/4-14	7/8-14	
ZR22/70D 70191300	3.08	14.5 × 6.5 × 32 (S02)	1.7–11.7		M4–4.5 × 0.5 M6 × 0.75/M8 × 1 M10 × 1.25/M12 × 1.5		3/8"-20 7/16"-18 1/2"-16			1/16-27	5/16-24	
ZR22/71D 70191500	2.60	14.5 × 6.5 × 32 (S02)	5–14.5		M7–8 × 0.75/M9–10×1 M12–13 × 1.25 M14–16 × 1.5		9/16"-16 5/8"-14	G1/8" G1/4"	R1/8" R1/4"	1/8-27 1/4-18*	3/8-24 7/16-20 1/2-20	
ZR22/72D 70191700	1.83	14.5 × 6.5 × 32 (S02)	7.8–17.3		M10–12 × 0.75 M14–18 × 1 M18 × 1.25			G3/8"				
ZR22/73D 70192000	1.75	14.5 × 6.5 × 32 (S02)	17–26.1		M19–20 × 1 M19–26 × 1.25 M22–28 × 1.25			G3/4"			1-12	

*only NPS

For ZA, ZB 22 16–22 mm Diameter 51 mm long
above 22 mm Diameter 18 mm long
For ZR 22 from 22 mm Diameter 15 mm long

Holder table for Thread Cutting Systems ZA27, ZB27 and ZR27

Chaser holder			Cutting range minor-Ø in mm	Metric thread DIN 13	Metric fine thread DIN 13	Whitworth thread DIN 11	BSF thread	Whitworth pipe thread DIN EN ISO 228	Tapered whitworth pipe thread DIN EN 10226	American threads		
Designation Item number	Holder angle in °	Chaser dimension in mm								NPT NPS	NC UNC	NF UNF
ZR27/1D 70200400	4.08	22 × 10 × 40 (S04)	3.1–13.6	M4.5–6 M7–14		1/4", 5/16" 3/8" 7/16", 1/2"					No. 12-24 5/16-18 3/8-16 7/16-14	No. 8-36 No. 10-32 No. 12-28
ZR27/20D 73299700	2.41	22 × 10 × 40 (S04)	7–17.3		M8–9 × 0.75 M10–11 × 1 M12–14 × 1.25 M14–18 × 1.5		11/16"-14	G1/8" G1/4" G3/8"	R1/8" R1/4" R3/8"	1/8-27 1/4-18 3/8-18		1/2-20 9/16-18 5/8-18 3/4-16
ZR27/21D 73903600	2	22 × 10 × 40 (S04)	16–26.1		M18–28 × 1.5 M24–28 × 2			G1/2" G5/8" G3/4"	R1/2" R5/8" R3/4"	1/2-14 3/4-14		7/8-14 1-12 1 1/8-12
ZR27/63D 70200600	3.60	22 × 10 × 40 (S04)	3.1–13.6	M7–14 M18		9/16" 5/8"	1/4"-26 5/16"-22				1/2-13 9/16-12 5/8-11	1/4-28
ZR27/65D 70201300	3.08	22 × 10 × 40 (S04)	13–22.6	M16–24	M17–18 × 2	3/4" 7/8" 1"	5/8"-14 3/4"-12				3/4-10 7/8-9 1-8	
ZR27/69D 70200700	3.08	22 × 10 × 40 (S04)	3.1–13.6	M11 M16	M6 × 0.75 M8–9 × 1 M10–11 × 1.25 M12–13 × 1.5		3/8"-20 7/16"-18 1/2"-16 5/8"-14					5/16-24 3/8-24 7/16-20
ZR27/72D 73575000	2.20	22 × 10 × 40 (S04)	9.0–19.1		M10 × 0.75 M11–14 × 1 M13–17 × 1.25 M16–20 × 1.5 M20 × 2			G1/8–1/4" G3/8–1/2"	R1/8–1/4" R3/8–1/2"	1/8-27 1/4-18 3/8-18		5/8-18 3/4-16
ZR27/73D 73287300	1.75	22 × 10 × 40 (S04)	16–26.1		M18–20 × 1 M19–24 × 1.25 M20–29 × 1.5 M28 × 2			G5/8–3/4"	R5/8–3/4"	1/2-14 3/4-14		1-12
ZR27/76D 73287500	1.5	22 × 7 × 32 (S09)	26.1–35.1		M28–36 × 1 M28–37 × 1.5 M30–37 × 2			G1"	R1" (only brass)	1-11.5 (only brass)		

For ZA, ZB 27 >18 to 27 mm Diameter max. 65 mm long

>27 mm Diameter max. 28 mm long

For ZR 27 >27 mm Diameter max. 28 mm long

for tapered threads max. 17 mm long

Holder table for Thread Cutting Systems Z16 (ZS16 and ZK16)

Chaser holder			Cutting range minor-Ø in mm	Metric thread DIN 13	Metric fine thread DIN 13	Whitworth thread DIN 11	BSF thread	Whitworth pipe thread DIN EN ISO 228	Tapered whitworth pipe thread DIN EN 10226	American threads		
Designation Item number	Holder angle in °	Chaser dimension in mm								NPT NPS	NC UNC	NF UNF
Z16/1D 70213000	4.33	22 × 10 × 52 (S05)	1–9	M4 M4.5 M5 M6		5/32–7/32" 1/4" 5/16" 3/8"					No. 8-32 No. 12-24 5/16-18 3/8-16	No. 6-40 No. 8-36 No. 10-32 No. 12-28
Z16/2D 70213400	3.80	22 × 10 × 52 (S05)	3.8–11.8	M6–10 M12		7/16" 1/2"	1/4"-26				3/8-16 7/16-14 1/2-13	No. 12-28 1/4-28
Z16/3D 70213800	3.33	22 × 10 × 52 (S05)	6–13.8	M9–14 M16		9/16" 5/8"	5/16"-22 3/8"-20 7/16"-18				9/16-12 5/8-11	
Z16/20D 70214000	2.41	22 × 10 × 52 (S05)	7.5–15.3		M10–11 × 1 M12–14 × 1.25 M14–16 × 1.5		9/16"-16	G1/8–1/4" R3/8"	R1/8–1/4" R3/8"	1/4-18		1/2-20 9/16-18 5/8-18
Z16/70D 70213900	2.75	22 × 10 × 52 (S05)	6–13.8		M7 × 0.75 M9–10 × 1 M10–12 × 1.25 M13–14 × 1.5		9/16"-16	G1/4"	R1/4"			3/8-24 7/16-20
Z16/72D* 70214200	2.08	22 × 10 × 52 (S05)	7.5–15.3		M9–11 × 0.75 M11–14 × 1 M14–16 × 1.25 M17 × 1.5			G3/8"	R3/8"	1/8-27		5/8-18
Z16/74D* 70214300	2.08	22 × 10 × 52 (S05)	11.5–19.1		M13–16 × 1 M14–18 × 1.25 M17–20 × 1.5			G3/8"	R3/8"			5/8-18 3/4-16
Z16/75D 70213700	3.08	22 × 10 × 52 (S05)	3.8–11.8	M9–11	M6 × 0.75 M8 × 1 M10 × 1.25 M12 × 1.5		3/8"-20 7/16"-18 1/2"-16					5/16-24
Z16/76D* 70214400	1.75	22 × 10 × 52 (S05)	16.2–23.8		M18 × 1 M18–24 × 1.25 M22–25 × 1.5							

*For thread diameters > 16 mm only 30 mm long including throat

Holder table for Thread Cutting Systems Z27 and ZE27

Chaser holder			Cutting range minor-Ø in mm	Metric thread DIN 13	Metric fine thread DIN 13	Whitworth thread DIN 11	BSF thread	Whitworth pipe thread DIN EN ISO 228	Tapered whitworth pipe thread DIN EN 10226	American threads			Round thread DIN 405
Designation Item number	Holder angle in °	Chaser dimension in mm								NPT NPS	NC UNC	NF UNF	
Z27/1D 70502100	4.17	22 × 10 × 68 (S06)	4–16	M5–8		7/32", 1/4" 5/16", 3/8" 7/16", 1/2" 9/16", 5/8" H14–16 × 4.5					No.12-24 5/16-18 3/8-16 7/16-14 1/2-13 9/16-12 5/8-11	No.10-32 No.12-28 1/4-28	
Z27/2D 70503700	3.33	25 × 12 × 75 (S07)	11.4–23.4	M16–27		5/8", 3/4" 13/16", 7/8" 15/16", 1"					5/8-11 3/4-10 7/8-9 1-8		Rd21 × 1/8" Rd22 × 1/8" Rd24 × 1/8" Rd26 × 1/8"
Z27/20D 70503100	2.41	25 × 12 × 75 (S07)	8–20		M10–14 × 1 M12–17 × 1.25 M14–20 × 1.5 M19–22 × 2	H14–16 × 4.5	11/16"-14 13/16"-12 7/8"-11	G1/8" G1/4" G3/8" G1/2"	R1/8" R1/4" R3/8" R1/2"	1/4-18 3/8-18 1/2-14		1/2-20 9/16-18 5/8-18 3/4-16 7/8-14	
Z27/21D 70504000	1.83	25 × 12 × 75 (S07)	20–31.6*		M22–28 × 1.5 M24–34 × 2			G5/8" G3/4" G7/8" G1"	R5/8" R3/4" R7/8" R1"	3/4-14 1-11½		1-1 1½-12 1¼-12	
Z27/63D 70502300	3.60	22 × 10 × 68 (S06)	4–16	M7–18		9/16", 5/8"	1/4"-26 9/32"-26 5/16"-22				7/16-14 1/2-13 9/16-12 5/8-11	1/4-28	

*For thread diameters >30 mm only 30 mm long including throat

Continuation of table next page but one

Holder table for Thread Cutting Systems Z27 and ZE27 (cont.)

Chaser holder			Cutting range minor-Ø in mm	Metric thread DIN 13	Metric fine thread DIN 13	Whitworth thread DIN 11	BSF thread	Whitworth pipe thread DIN EN ISO 228	Tapered whitworth pipe thread DIN EN 10226	American threads			Round thread DIN 405
Designation Item number	Holder angle in °	Chaser dimension in mm								NPT NPS	NC UNC	NF UNF	
Z27/69D 70502400	3.08	22 × 10 × 68 (S06)	4–16	M11 M16	M6 × 0.75 M8 × 1 M10–11 × 1.25 M12–13 × 1.5		3/8"-20 7/16"-18 1/2"-16 5/8"-14					5/16-24 7/16-20	
Z27/70D 70502500	2.60	22 × 10 × 68 (S06)	4–16		M7–8 × 0.75 M9–11 × 1 M11–14 × 1.25 M13–16 × 1.5 M18 × 2		9/16"-16 5/8"-14 11/16"-14	G1/8" G1/4"	R1/8" R1/4"			3/8-24 7/16-20 1/2-20 9/16-18	
Z27/72D 70503200	2.20	22 × 10 × 68 (S06)	8–20		M9–10 × 0.75 M10–14 × 1 M12–18 × 1.25 M14–21 × 1.5 M20–22 × 2			G1/8" G1/4" G3/8" G1/2"	R1/8" R1/4" R3/8" R1/2"	1/8-27 1/4-18 3/8-18 1/2-14		1/2-20 9/16-18 5/8-18 3/4-16 7/8-14	
Z27/73D 70503900	1.75	22 × 10 × 68 (S06)	16.5–28*		M18–20 × 1 M19–25 × 1.25 M19–30 × 1.5 M24–30 × 2			G5/8" G3/4"	R5/8" R3/4"	1/2-14 3/4-14		7/8-14 1-12 1½-12	
Z27/76D 70504100	1.33	22 × 10 × 68 (S06)	25–36.6*		M27–30 × 1 M27–38 × 1.25 M30–38 × 1.5								

*For thread diameters > 30 mm only 30 mm long including throat

Holder table for Thread Cutting Systems Z27 and ZE27

Chaser holder			Cutting range minor diameter in mm	Trapezoidal thread DIN 103	Wood thread DIN 570	Wood thread Work standard 24262
Designation Item number	Holder angle in °	Chaser dimension in mm				
Z27/92D 70502600	8.25	25 × 12 × 75 (S07)	4–16		H6 × 2,6 H8 × 3,5 H10 × 4,5 H12 × 5	H6 × 2,6 H8 × 3,2 H9–10 × 3,5 H11–13 × 4 H14–16 × 4,5
Z27/93D 70503400	7.00	40 × 16 × 75 (S11)	8–20		H16 × 6 H20 × 7	H17–19 × 5
Z27/180D 70502800	7.20	25 × 12 × 75 (S07)	4–16	Tr10 × 3 Tr14 × 4		H8 × 3,2 H9–10 × 3,5 H11–13 × 4 H14–16 × 4,5
Z27/181D 70503000	5.83	25 × 12 × 75 (S07)	4–16	Tr12 × 3 Tr16 × 4		
Z27/188D 70503600	4.75	25 × 12 × 75 (S07)	8–20	Tr18–20 × 4		

Holder table for Thread Cutting Systems Z27K (conical)

Chaser holder			Cutting range minor diameter in mm	Whitworth pipe thread DIN EN 10226	American thread NPT
Designation Item number	Holder angle in °	Chaser dimension in mm			
Z27/20E 72028500	2.41	25 × 12 × 75 (S07)	8–20	R1/8", R1/4", R3/8", R1/2"	1/4-18 3/8-18 1/2-14
Z27/21E 72028900	1.83	25 × 12 × 75 (S07)	20–31,6	R5/8", R3/4", R7/8", R1"	3/4-14 1-11½

Holder table for Thread Cutting Systems Z39, ZE39 and ZM39

Chaser holder			Cutting range minor-Ø in mm	Metric thread DIN 13	Metric fine thread DIN 13	Whitworth thread DIN 11	BSF thread	Whitworth pipe thread DIN EN ISO 228	Tapered whitworth pipe thread DIN EN 10226	American threads			Round thread DIN 405
Designation Item number	Holder angle in °	Chaser dimension in mm								NPT NPS	NC UNC	NF UNF	
Z39/1D 70553000	4.08	22 × 10 × 68 (S06)	4.7–18.5	M5* M6		5/16" 3/8" 7/16" 1/2"					5/16-18 3/8-16 7/16-14		
Z39/2D 70553700	3.50	22 × 10 × 68 (S06)	4.7–18.5	M7–14		9/16" H14–16 × 4,5					1/2-13 9/16-12 5/8-11		
Z39/3D 70554700	3.08	25 × 12 × 75 (S07)	10.5–24.2	M16–24		3/4" 7/8" 1" 1 1/8"	5/16"-22				3/4-10 7/8-9 1-8 1 1/8-7	Rd 22-26 × 1/8"	
Z39/4D 70555200	2.75	25 × 12 × 75 (S07)	20.5–33.8	M27–39		1 1/4" 1 3/8" 1 1/2"					1 1/4-7 1 3/8-6 1 1/2-6	Rd26 × 1/8" Rd28 × 1/8" Rd30 × 1/8" Rd32 × 1/8"	
Z39/20D 70553900	2.41	25 × 12 × 75 (S07)	6.5–20.2		M10–12 × 1 M12–15 × 1,25 M14–18 × 1,5 M19–22 × 2	H14–16 × 4,5	11/16"-14 13/16"-12	G1/8" G1/4" G3/8" G1/2"	R1/8" R1/4" R3/8" R1/2"	1/4-18 3/8-18 1/2-14	1/2-20 9/16-18 5/8-18 3/4-16		
Z39/21D 70555100	1.83	25 × 12 × 75 (S07)	20.5–33.8**		M23–27 × 1,5 M25–36 × 2			G5/8" G3/4" G7/8" G1"	R5/8" R3/4" R7/8" R1"	3/4-14 1-11 1/2	1-12 1-14 1 1/8-12 1 1/4-12 1 3/8-12		
Z39/22D 70555400	1.58	25 × 12 × 75 (S07)	33–45.7**		M36–48 × 2 M45–48 × 3			G1 1/8" G1 1/4" G1 3/8" G1 1/2"			1 1/2-12 1 3/4-12		
Z39/23D 72462000	1.41 1.5/12	25 × 12 × 75 (S07)	47.3–58.8***		M50–60 × 1,5 M50–60 × 2 M52–62 × 3			G1 5/8" G1 3/4" G2"					

*With special sliding pieces 8,5 mm high

**For thread diameters > 45 mm only 30 mm long including run-out

*** Max. thread length incl. throat 34 mm

Continuation of table next page but one

Holder table for Thread Cutting Systems Z39, ZE39 and ZM39 (cont.)

Chaser holder			Cutting range minor-Ø in mm	Metric thread DIN 13	Metric fine thread DIN 13	Whitworth thread DIN 11	BSF thread	Whitworth pipe thread DIN EN ISO 228	Tapered whitworth pipe thread DIN EN 10226	American threads		
Designation Item number	Holder angle in °	Chaser dimension in mm								NPT NPS	NC UNC	NF UNF
Z39/69D 70553100	3.08	22 × 10 × 68 (S06)	4.7–18.5	M11 M16 M20	M8 × 1 M10 × 1.25 M12–13 × 1.5		3/8"-20 7/16"-18 1/2"-16					5/16-24
Z39/70D 70553800	2.60	22 × 10 × 68 (S06)	4.7–18.5		M7–8 × 0.75 M9–10 × 1 M11–13 × 1.25 M13–16 × 1.5 M18–21 × 2	H14–16 × 4.5	9/16"-16 5/8"-14 11/16"-14 3/4"-12 13/16"-12	G1/8" G1/4"	R1/8" R1/4"			3/8-24 7/16-20 1/2-20 9/16-18
Z39/71D 70554000	2.20	22 × 10 × 68 (S06)	6.5–20.2		M8–10 × 0.75 M10–14 × 1 M12–17 × 1.25 M15–21 × 1.5			G1/8" G1/4" G3/8" G1/2"	R1/8" R1/4" R3/8" R1/2"	1/8-27 1/4-18 3/8-18		1/2-20 9/16-18 5/8-18 3/4-16 7/8-14
Z39/72D 70555000	1.75	22 × 10 × 68 (S06)	15–28.5		M17–20 × 1 M18–25 × 1.25 M20–30 × 1.5 M27–30 × 2	H14–16 × 4.5		G3/4" G7/8"		3/4-14		1-12 1 1/8-12
Z39/74D 70555300	1.33	22 × 10 × 68 (S06)	26.2–39.5		M28–40 × 1.25 M30–41 × 1.5 M38–42 × 2			G1/4"				1 1/16-18
Z39/75D 70555500	1.08	22 × 10 × 68 (S06)	38.3–50.5*		M40–52 × 1.25 M42–52 × 1.5 M45–52 × 2 M40–51 × 1							

*For thread diameters > 45 mm only 33 mm long including run-out.

Holder table for Thread Cutting Systems Z39, ZE39 and ZM39

Chaser holder			Cutting range minor diameter in mm	Trapezoidal thread DIN 103	Wood thread DIN 570	Wood thread Work standard 24262	Round- Thread DIN 405
Designation Item number	Holder angle in °	Chaser dimension in mm					
Z39/92D 70553600	8.25	25 × 12 × 75 (S07)	4.7–18.5		H6 × 2.6 H8 × 3.5 H10 × 4.5 H12 × 5	H6 × 2.6 H8 × 3.2 H9–10 × 3.5 H11–13 × 4 H14–16 × 4.5	
Z39/93D 70554400	7.00	40 × 16 × 75 (S11)	6.5–20.2		H16 × 6 H20 × 7	H17–19 × 5 H20–22 × 6 H23–25 × 7	
Z39/180D 70553300	7.20	25 × 12 × 75 (S07)	4.7–18.5	Tr10 × 3 Tr14 × 4		H8 × 3.2 H9–10 × 3.5 H11–13 × 4 H14–16 × 4.5	
Z39/181D 70553500	5.83	25 × 12 × 75 (S07)	4.7–18.5	Tr12 × 3 Tr16 × 4			Rd10 × 1/10"
Z39/182D 70554600	5.00	40 × 16 × 75 (S11)	10.5–24.2	Tr22–24 × 5			
Z39/183D 70554900	4.08	40 × 16 × 75 (S11)	15–28.5	Tr26–28 × 5			
Z39/188D 70554200	4.75	25 × 12 × 75 (S07)	6.5–20.2	Tr14 × 3 Tr18–20 × 4			Rd12 × 1/10" Rd15 × 1/8" Rd16 × 1/8"

Holder table for Thread Cutting Systems Z39K (conical)

Chaser holder			Cutting range minor diameter in mm	Whitworth pipe thread DIN EN 10226	American thread NPT
Designation Item number	Holder angle in °	Chaser dimension in mm			
Z39/20E 73298700	2.41	25 × 12 × 75 (S07)	6,5–20,2	R1/8", R1/4", R3/8", R1/2"	1/4-18 3/8-18 1/2-14
Z39/21E 73298900	1.83	25 × 12 × 75 (S07)	20,5–33,8	R5/8", R3/4", R7/8", R1"	3/4-14 1-11½
Z39/22E 73299100	1.58	25 × 12 × 75 (S07)	33–45,7	R1½", R1¼", R1¾", R1½"	1¼-11½ 1½-11½
Z39/23E 73299300	1.41	25 × 12 × 75 (S07)	47,3–58,8	R1½", R1¾", R2"	2-11½

Holder table for Thread Cutting Systems Z52 and ZS52

Chaser holder			Cutting range minor-Ø in mm	Metric thread DIN 13	Metric fine thread DIN 13	Whitworth thread DIN 11	BSF thread	Whitworth pipe thread DIN EN ISO 228	Tapered whitworth pipe thread DIN EN 10226	American threads			Round thread DIN 405
Designation Item number	Holder angle in °	Chaser dimension in mm								NPT NPS	NC UNC	NF UNF	
Z52/1D 7057300	4.08	22 × 10 × 68 (S06)	4.5–18.5			5/16" 3/8" 7/16" 1/2"					5/16-18 3/8-16 7/16-14		
Z52/2D 70573100	3.50	22 × 10 × 68 (S06)	4.5–18.5	M7–14		9/16" H14–16 × 4,5					1/2-13 9/16-12 5/8-11		
Z52/3D 70574500	3.08	25 × 12 × 90 (S08)	12.6–26.6	M16–24 M30		3/4" 7/8" 1" 1 1/8"	5/16"-22				3/4-10 7/8-9 1-8 1 1/8-7		Rd 22–26 × 1/8"
Z52/4D 70575100	2.75	25 × 12 × 90 (S08)	21.8–36.2	M27–39		1 1/4" 1 3/8" 1 1/2"					1 1/4-7 1 3/8-6 1 1/2-6		Rd 25–30 × 1/8"
Z52/5D 70575400	2.75	40 × 16 × 90 (S12)	32.5–46.0	M39–52		1 5/8" H14–16 × 4,5 1 1/8" 2"					1 3/4-5 2-4 1/2		
Z52/20D 70574100	2.33	25 × 12 × 90 (S08)	8–22		M10–12 × 1 M12–15 × 1,25 M14–18 × 1,5 M20–24 × 2		11/16"-14 13/16"-12 7/8"-11 15/16"-11	G1/8" G1/4" G3/8" G1/2" G5/8"	R1/8" R1/4" R3/8" R1/2" R5/8"	1/4-18 1/2-14		1/2-20 9/16-18 5/8-18 3/4-16 7/8-14	
Z52/21D 70575200	1.83	25 × 12 × 90 (S08)	21.8–36.2		M24–27 × 1,5 M26–38 × 2 M38–40 × 3			G3/4" G1/8" G1" G1 1/8"	R3/4" R1/8" R1"	3/4-14 1-11 1/2		1 1/8-12 1 1/4-12 1 3/8-12 1 1/2-12	
Z52/22D 70575600	1.50	25 × 12 × 90 (S08)	37.7–51.5		M42–50 × 2 M48–54 × 3			G1 1/4" G1 3/8" G1 1/2" G1 5/8" G1 3/4"	R1 1/4" R1 1/2"				
Z52/23D 70575900	1.25*	25 × 12 × 75 (S07)	50.3–63.7		M52–65 × 2 M58–66 × 3			G1 3/4–2" G2 1/4"					
Z52/24D 72469100	1.00	22 × 10 × 68 (S06)	68–79.4*		M70–80 × 1.5 M72–82 × 2			G2 1/2" G2 3/4"					

*For thread diameters > 53 mm max. 46 mm long including throat

Holder table for Thread Cutting Systems Z52 and ZS52

Chaser holder			Cutting range minor-Ø in mm	Metric thread DIN 13	Metric fine thread DIN 13	Whitworth thread DIN 11	BSF thread	Whitworth pipe thread DIN EN ISO 228	Tapered whitworth pipe thread DIN EN 10226	American threads		
Designation Item number	Holder angle in °	Chaser dimension in mm								NPT NPS	NC UNC	NF UNF
Z52/71D 70573200	3.08	22 × 10 × 68 (S06)	4.5–18.5	M9 M11 M16 M18 M20	M8 × 1 M10 × 1.25 M12–13 × 1.5	11/16" 3/4" H 14–16 × 4.5	3/8"-20 7/16"-18 1/2"-16			3/4-10	5/16–24 7/16–20	
Z52/72D 70573300	2.60	22 × 10 × 68 (S06)	4.5–18.5		M7–8 × 0.75 M9–11 × 1 M11–14 × 1.25 M13–16 × 1.5 M18–20 × 2		9/16"-16 5/8"-14 11/16"-14 3/4"-12 13/16"-12	G1/8" G1/4"	R1/8" R1/4"	1/4-18	3/8-24 7/16-20 1/2-20 9/16-18	
Z52/73D 70574200	2.20	22 × 10 × 68 (S06)	8–22		M9–10 × 0.75 M11–14 × 1 M13–17 × 1.25 M16–20 × 1.5 M20–24 × 2	H 14–16 × 4.5		G1/8" G1/4" G3/8" G1/2" G5/8"	R1/8" R1/4" R3/8" R1/2" R5/8"	1/8-27 1/4-18 3/8-18 1/2-14	5/8-18 3/4-16 7/8-14	
Z52/75D 70574800	1.75	22 × 10 × 68 (S06)	16.2–30.2		M18–20 × 1 M18–24 × 1.25 M20–30 × 1.5 M27–32 × 2			G3/4" G7/8"	R3/4" R7/8"	1/2-14 3/4-14	1-12 1½-12 1¼-12	
Z52/77D 70575300	1.33	22 × 10 × 68 (S06)	26.6–40.6		M29–41 × 1.25 M30–42 × 1.5 M38–42 × 2							
Z52/78D 70575700	1.08	22 × 10 × 68 (S06)	37.7–51.5**		M40–52 × 1.25 M44–52 × 1.5 M48–54 × 2							
Z52/80D 70575800	0.92	22 × 10 × 68 (S06)	47.2–60.2**		M50–52 × 1.25 M50–62 × 1.5 M60–62 × 2							

*Max. thread length including throat 46 mm

**For thread diameters > 53 mm max. 34 mm long including throat

Holder table for Thread Cutting Systems Z64

Chaser holder			Cutting range minor-Ø in mm	Metric thread DIN 13	Metric fine thread DIN 13	Whitworth thread DIN 11	BSF thread	Whitworth pipe thread DIN EN ISO 228	Tapered whitworth pipe thread DIN EN 10226	American threads			Round thread DIN 405
Designation Item number	Holder angle in °	Chaser dimension in mm								NPT NPS	NC UNC	NF UNF	
Z64/1D 70593000	4.00	22 × 10 × 68 (S06)	4.5–18.5			5/16" 3/8" 7/16" 1/2"					5/16-18 3/8-16		
Z64/2D 70593100	3.50	22 × 10 × 68 (S06)	4.5–18.5	M7–14 M18		9/16" 5/8"	5/16"-22				1/2-13 9/16-12 5/8-11		
Z64/3D 70594600	3.08	25 × 12 × 90 (S08)	12.6–26.6	M16–24 M30		3/4" 7/8" 1" 1 1/8"					3/4-10 7/8-9 1-8 1 1/8-7		Rd22–26 × 1/8"
Z64/4D 70595200	2.75	25 × 12 × 90 (S08)	21.8–36.2	M27–39		1 1/4" 1 3/8" 1 1/2"					1 1/4-7 1 3/8-6 1 1/2-6		Rd25–30 × 1/8"
Z64/5D 70595500	2.75	40 × 16 × 90 (S12)	32.5–46.0	M39–52		1 5/8" 1 3/4" 1 7/8" 2"					1 3/4-5 2-4 1/2		
Z64/6D 70595700	2.50	40 × 16 × 90 (S12)	44.8–52.8	M52–64		2 1/4" 2 3/8" 2 1/2"				1/4-18		1/2-20 9/16-18 5/8-18 3/4-16 7/8-14	

Continuation of table next but one

Holder table for Thread Cutting Systems Z64 (cont.)

Chaser holder			Cutting range minor-Ø in mm	Metric thread DIN 13	Metric fine thread DIN 13	Whitworth thread DIN 11	BSF thread	Whitworth pipe thread DIN EN ISO 228	Tapered whitworth pipe thread DIN EN 10226	American threads			Round thread DIN 405	
Designation Item number	Holder angle in °	Chaser dimension in mm								NPT NPS	NC UNC	NF UNF		
Z64/20D 70594100	2.33	25 × 12 × 90 (S08)	8–22		M10–12 × 1 M12–15 × 1.25 M14–18 × 1.5 M20–24 × 2		11/16"-4 13/16"-12 15/16"-11	G1/8" G1/4" G3/8" G1/2" G5/8"	R1/8" R1/4" R3/8" R1/2" R5/8"	1/4-18		1/2-20 9/16-18 5/8-18 3/4-16 7/8-14		
Z64/21D 70594500	2.33	25 × 12 × 90 (S08)	10.3–24.3		M12 × 1 M12–16 × 1.25 M15–18 × 1.5 M20–24 × 2		11/16"-14 13/16"-12 7/8"-11 15/16"-11 1"-10	G1/4" G3/8" G1/2" G5/8" G3/4"	R1/4" R3/8" R1/2" R5/8" R3/4"	1/2-14 3/4-14		1¼-12 1¾-12 1½-12		
Z64/22D 70595400	1.83	25 × 12 × 75 (S07)	27.8–41.8		M32–36 × 2 M38–45 × 3		1½"-8	G7/8" G1" G1½" G1¼" G1¾"	R7/8" R1" R1½" R1¼" R1¾"	1-11½				
Z64/23D 70595800	1.41	25 × 12 × 90 (S08)	44.8–57.8		M48–60 × 2 M50–60 × 3			G1½" G1¾" G2"	R1¾"					
Z64/24D 724693	1.15	25 × 12 × 75 (S07)	62.7–74.1					G2¼–2½"						
Z64/25D 716504	1.08	25 × 12 × 75 (S07)	79.6–89.6					G3"					5/16-24 7/16-20	

Continuation of table next page but one

Holder table for Thread Cutting Systems Z64 (cont.)

Chaser holder			Cutting range minor-Ø in mm	Metric thread DIN 13	Metric fine thread DIN 13	Whitworth thread DIN 11	BSF thread	Whitworth pipe thread DIN EN ISO 228	Tapered whitworth pipe thread DIN EN 10226	American threads			Round thread DIN 405
Designation Item number	Holder angle in °	Chaser dimension in mm								NPT NPS	NC UNC	NF UNF	
Z64/71D 705932	3.08	22 × 10 × 68 (S06)	4.5–18.5	M9. 11. (16) 18. (20)	M8 × 1 M10 × 1.25 M12–13 × 1.5	11/16" 3/4" 13/16"	3/8" × 1/20" 7/16" × 1/18" 1/2" × 1/16"				3/4-10	3/8-24 7/16-20 1/2-20 9/16-18	Rd22–26 × 1/8"
Z64/72D 705933	2.60	22 × 10 × 68 (S06)	4.5–18.5		M7–8 × 0.75 M9–11 × 1 M11–14 × 1.25 M13–16 × 1.5 M18–20 × 2		9/16"-16 5/8"-14 11/16"-14 3/4"-12 13/16"-12	G1/8" G1/4"	R1/8" R1/4"			5/8-18 3/4-16 7/8-14	Rd25–30 × 1/8"
Z64/73D 705942	2.20	22 × 10 × 68 (S06)	8–22		M9–10 × 0.75 M11–14 × 1 M13–17 × 1.25 M16–20 × 1.5 M20–24 × 2			G1/8" G1/4" G3/8" G1/2" G5/8"	R1/8" R1/4" R3/8" R1/2"	1/8-27 1/4-18 3/8-18 1/2-14		1-12 1½-12 1¼-12	
Z64/75D 705949	1.75	22 × 10 × 68 (S06)	16.2–30.2		M18–20 × 1 M18–24 × 1.25 M20–30 × 1.5 M27–32 × 2			G3/4" G7/8"	R3/4" R7/8"	1/2-14 3/4-14			
Z64/77D 705953	1.33	22 × 10 × 68 (S06)	26.6–40.6		M 29–41 × 1.25 M30–42 × 1.5 M38–42 × 2			G1"					
Z64/78D 705956	1.08	22 × 10 × 68 (S06)	37.7–51.5		M40–52 × 1.5 M48–54 × 2								
Z64/80D 705959	0.92	22 × 10 × 68 (S06)	47.2–60.2		M50–52 × 1.25 M50–62 × 1.5 M60–62 × 2								

Holder table for Thread Cutting Systems Z64

Chaser holder			Cutting range minor diameter in mm	Trapezoidal thread DIN 103	Wood thread DIN 570	Wood thread Work standard 24262
Designation Item number	Holder angle in °	Chaser dimension in mm				
Z64/180D 705935	7.20	25 × 12 × 90 (S08)	4.5–18.5	Tr10 × 3 Tr14 × 4		H8 × 3.2 9–10 × 3.5 11–13 × 4 14–16 × 4.5
Z64/181D 705937	5.83	25 × 12 × 90 (S08)	4.5–18.5	Tr12 × 3 Tr16 × 4		
Z64/182D 705948	4.83	40 × 16 × 90 (S12)	12.6–26.6	Tr22–24 × 5 30 × 6		
Z64/183D 705951	4.00	40 × 16 × 90 (S12)	16.2–30.2	Tr26–28 × 5 32–36 × 6		
Z64/188D 705939	4.75	25 × 12 × 90 (S08)	4.5–18.5	Tr14 × 3 Tr18–20 × 4		
Z64/92D 705940	8.25	25 × 12 × 90 (S08)	4.5–18.5		H8 × 3.5 10 × 4.5 12 × 5	H8 × 3.2 9–10 × 3.5 11–13 × 4 14–16 × 4.5
Z64/93D 705944	7.00	40 × 16 × 90 (S12)	8–22		H16 × 6 H20 × 7	H17–19 × 5 H20–22 × 6 23–25 × 7

Holder table for Thread Cutting Systems Z64-2 (Trapezoidal thread)

Chaser holder						
Thread	Designation	Item number		Holder angle in °	Working ranges (Minor-Ø) in mm	Chaser dimension in mm
		right	left			
Tr12 × 2	Z64/1D	70593000		4.08	4.5–18.5	22 × 10 × 68 (S06)
Tr14 × 2–Tr16 × 2	Z64/2D	70593100	70587100	3.50	4.5–18.5	22 × 10 × 68 (S06)
Tr10 × 3	Z64/180D			7.20	4.5–18.5	25 × 12 × 90 (S08)
Tr12 × 3	Z64/181D	70593700		5.83	4.5–18.5	25 × 12 × 90 (S08)
Tr14 × 3–Tr16 × 3	Z64/188D	70593900		4.75	4.5–18.5	25 × 12 × 90 (S08)
Tr18 × 3–Tr20 × 3	Z64/3D	70594600	70588600	3.08	12.6–26.6	25 × 12 × 90 (S08)
Tr14 × 4	Z64/180D			7.20	4.5–18.5	25 × 12 × 90 (S08)
Tr16 × 4	Z64/181D	70593700		5.83	4.5–18.5	25 × 12 × 90 (S08)
Tr18 × 4–Tr20 × 4	Z64/188D	70593900		4.75	4.5–18.5	25 × 12 × 90 (S08)
Tr22 × 4–Tr26 × 4	Special chaser holder			3.80	12.6–26.6	25 × 12 × 90 (S08)
Tr28 × 4–Tr40 × 4	Z64/4D	70595200	70589200	2.75	21.8–36.2	25 × 12 × 90 (S08)
Tr42 × 4–Tr50 × 4	Special chaser holder			2.00	32.5–46.0	25 × 12 × 90 (S08)
Tr52 × 4–Tr62 × 4	Z64/23D	72927000	70589800	1.41	44.8–57.8	25 × 12 × 90 (S08)
Tr63 × 4–Tr69 × 4	Special chaser holder			1.30	54.8–66.8	25 × 12 × 75 (S07)
Tr18 × 5/Tr20 × 5	Special chaser holder			6.00	12.6–26.6	40 × 16 × 90 (S12)
Tr22 × 4/Tr24 × 5	Z64/182D	70594800	70588800	4.83	12.6–26.6	40 × 16 × 90 (S12)
Tr26 × 5–Tr32 × 5	Z64/183D	70595100		4.00	16.2–30.2	40 × 16 × 90 (S12)
Tr34 × 5–Tr38 × 5	Special chaser holder			3.00		40 × 16 × 90 (S12)
Tr40 × 5–Tr50 × 5	Z64/5D	70595500	70589500	2.75	32.5–46.0	40 × 16 × 90 (S12)
Tr52 × 5–Tr62 × 5	Special chaser holder			2.00	44.8–57.8	40 × 16 × 90 (S12)
Tr64 × 5–Tr69 × 5	Special chaser holder			1.70	54.8–66.6	40 × 16 × 90 (S12)
Tr30 × 6	Z64/182D	70594800	70588800	4.83	12.6–26.6	40 × 16 × 90 (S12)
Tr32 × 6–Tr36 × 6	Z64/183D	70595100		4.00	16.2–30.2	40 × 16 × 90 (S12)
Tr38 × 6	Special chaser holder			3.50		40 × 16 × 90 (S12)
Tr40 × 6–Tr52 × 6	Z64/5D	70595500	70589500	2.75	32.5–46.0	40 × 16 × 90 (S12)
Tr54 × 6–Tr64 × 6	Z64/6D	70595700	70589700	2.50	44.8–57.8	40 × 16 × 90 (S12)
Tr65 × 6–Tr69 × 6	Special chaser holder	73348200		2.30	54.8–66.6	40 × 16 × 75 (S11)

Holder table for Thread Cutting Systems Z76-2

Chaser holder			Cutting range minor-Ø in mm	Whitworth pipe thread DIN EN ISO 228	Tapered whitworth pipe thread DIN EN 10226
Designation Item number	Holder angle in °	Chaser dimension in mm			
Z76/33D 71870400	1.67	40 × 16 × 90 (S12)	29.9–49.7	G1–1½"	R1–1½"
Z76/34D 71870800	1.25	40 × 16 × 90 (S12)	56.2–73.6	G2–2½"	R2–2½"
Z76/35D 71871200	1.08	40 × 16 × 90 (S12)	85.7–102	G3½"	–
Z76/35D 71871200	1.08	45 × 17 × 100 (S14)	83.7–100	G3–3½"	R3–3½"
Z76/36D 71871400	1.0	40 × 16 × 90 (S12)	99–113.2	G4"	–
Z76/36D 71871400	1.0	45 × 17 × 90 (S14-90)	97–111.2	G4"	R4"

Holder table for Thread Cutting Systems WEK-S8

Chaser holder			Cutting range minor-Ø in mm	Whitworth pipe thread DIN 259 DIN EN ISO 228	Tapered whitworth pipe thread DIN EN 10226	American thread NPT
Designation Item number	Holder angle in °	Chaser dimension in mm				
WE21B K1/16 74546700	2.20	25 × 12 × 100 (S10)	8–28	G1/4", G3/8" G1/2", G5/8" G3/4", G7/8"	R1/4", R3/8" R1/2", R5/8" R3/4", R7/8"	1/2-14 3/4-14
WE22B K1/16 74546800	1.75	25 × 12 × 100 (S10)	26–45	G1", G1½" G1¼", G1¾" G1½"	R1", R1½" R1¼", R1¾" R1½"	1-11½ 1¼-11½ 1½-11½
WE23B K1/16 74547000	1.41	25 × 12 × 90 (S08)	45–65	G1½", G1¾" G2", G2¼"	R1½", R1¾" R2", R2¼"	2-11½
WE24B K1/16 74085400	1.17	25 × 12 × 90 (S08)	65–86	G2¾", G2½" G2¾", G3"	R2¾", R2½" R2¾", R3"	2½-8 3-8

Holder table for Thread Cutting Systems WHK-S3

Chaser holder			Cutting range minor-Ø in mm	Whitworth pipe thread DIN EN ISO 228	Tapered whitworth pipe thread DIN EN 10226	American thread NPT
Designation Item number	Holder angle in °	Chaser dimension in mm				
WH21B 74080000	1.50	25 × 12 × 100 (S10)	10–30	G3/8" G1/2" G5/8" G3/4", G7/8"	R3/8" R1/2" R5/8" R3/4", R7/8"	1/2-14 3/4-14
WH22B 74080100	1.08	25 × 12 × 100 (S10)	28–48	G1", G1½" G1¼", G1¾" G1½"	R1", R1½" R1¼", R1¾" R1½"	1-11½ 1¼-11½ 1½-11½
WH23B 74080200	0.92	25 × 12 × 100 (S10)	47–67	G1½", G1¾" G2", G2¼"	R1½", R1¾" R2", R2¼"	2-11½
WH24B 74080300	0.75	25 × 12 × 100 (S10)	66–87	G2¾", G2½" G2¾", G3"	R2¾", R2½" R2¾", R3"	2½-8 3-8
WH25B 74080400	0.67	25 × 12 × 100 (S10)	90–110	G3¼", G3½" G3¾", G4"	R3¼", R3½" R3¾", R4"	3½-8 4-8

Holder table for Thread Cutting Systems WKK-S4

Chaser holder			Cutting range minor-Ø in mm	Whitworth pipe thread DIN EN ISO 228	Tapered whitworth pipe thread DIN EN 10226	American thread NPT
Designation Item number	Holder angle in °	Chaser dimension in mm				
WK22B	1.41	25 × 12 × 100 (S10)	25–47	G1–1½"	R1–1½"	1-11.5–1½-11.5
WK23B	1.17	25 × 12 × 100 (S10)	44–66	G1½–2¼"	R1½–2¼"	2-11.5
WK24B	0.83	25 × 12 × 100 (S10)	65–86	G2¾–3"	R2¾–3"	2½-8–3-8
WK25B	0.75	25 × 12 × 100 (S10)	88–111	G3¼–4"	R3¼–4"	3½-8–4-8
WK26B	0.67	25 × 12 × 100 (S10)	118–139	G4½–5"	R4½–5"	5-8
WK27B	0.33	25 × 12 × 100 (S10)	143–164	G5½–6"	R5½–6"	6-8