



HEX TAP DS
六角柄双头丝锥



Benefit:

- Pilot for exact alignment
- Rougher and Finisher combined in one tool
- Use in awkward places
- For making new threads
- For cleaning and repairing damaged threads

优点:

- 导向可以使丝锥精确对准
- 同一丝锥包含头攻和底攻
- 可用于不方便加工的地方
- 可用于攻新的螺纹
- 可用于清牙和修复损坏的螺纹





HexTap S

Technical Information:

VÖLKEL-Threading-Bits have been designed for thread cutting using battery-powered screwdriver drills and electric hand drills with right-hand and left-hand rotation. But they are also suitable for thread cutting by hand or in a stationary drilling machine. Your battery-powered screwdriver drill should have a minimum power of 7.5 Volts. Take care that the tool and the axis of the hole are exactly aligned and use a suitable cutting oil.

The following technical data apply for thread cutting using battery-powered screwdriver drills and electric hand drills:



六角柄丝锥

技术资料:

VOLKEL六角柄丝锥是设计用于充电式电动起子和带有左旋和右旋功能的手电钻进行攻丝的工具。也适用于手动或固定钻床攻丝。充电式电动起子的最低电压为7.5伏。请注意底孔的中心轴和丝锥的中心轴要对齐，使用合适的切削油。

以下技术参数适用于充电式电动起子和手电钻进行攻丝:

Dimensions/ 尺寸	M 3	M 4	M 5	M 6	M 8	M 10
Core hole dia./底孔直径	2,5 mm	3,3 mm	4,2 mm	5,0 mm	6,8 mm	8,5 mm
RPM/转速	Lowest setting (0 - 450 RPM)/最小设定(0 - 450 RPM)					
Torque/扭力	Maximum setting/最大设定					

HexTap DS

Application:

for general use

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes
- for thread cutting by hand

六角柄双头丝锥

应用:

通用

- 抗拉强度小于900N/mm²的非研磨材料
- 非合金钢和低合金钢
- 通孔和盲孔
- 手用

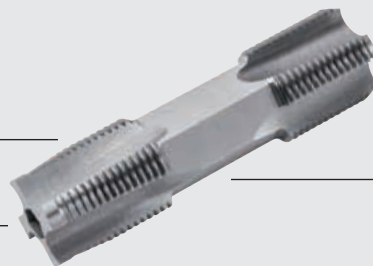
Rougher piloted

头攻带导向

Hexagon Hole for Ratchet or

Hexagon Keys

内六角孔: 可用六角扳手



Finisher/Bottoming

底攻

External Hexagon for Open-End Wrench

外六角方: 可用可调扳手或呆头扳手

Benefit:

- Pilot for exact alignment
- Rougher and Finisher combined in one tool
- Use in awkward places
- For making new threads
- For cleaning and repairing damaged threads

优点:

- 导向可以使丝锥精确对准
- 同一丝锥包含头攻和底攻
- 可用于不方便加工的地方
- 可用于攻新的螺纹
- 可用于清牙和修复损坏的螺纹





HexTap S

Threading-Bit, 1/4" Hexagon Shank
metric ISO-thread DIN 13

六角柄丝锥

带1/4" 六角柄
公制ISO螺纹 DIN 13



HSS-G

Tol. ISO2/6H

M

Size	Typ	L 1	L 2	SW1	Art.-No.
M 3	S	33.0	11	1/4"	67026
M 3.5	S	33.5	10	1/4"	67028
M 4	S	35.0	12	1/4"	67030
M 4.5	S	35.0	12	1/4"	67032
M 5	S	36.0	15	1/4"	67034
M 5.5	S	35.0	15	1/4"	67036
M 6	S	39.0	18	1/4"	67038
M 7	S	37.5	16	1/4"	67040
M 8	S	40.0	19	1/4"	67042
M 9	S	40.5	18	1/4"	67044
M 10	S	41.0	21	1/4"	67046

HexTap DS

Double Ended Tap, Multi-Drive
metric ISO-thread DIN 13

六角柄双头丝锥

双头丝锥, 多种驱动
公制ISO螺纹 DIN 13



HSS-G

Tol. ISO2/6H

M

Size	Typ	L 1	L 2	SW1	SW2	Art.-No.
M 11	DS	70	22	8	4	67048
M 12	DS	70	22	8	4	67050
M 14	DS	70	22	10	4	67051
M 16	DS	70	22	10	4	67052
M 18	DS	80	24	13	5	67053
M 20	DS	80	24	13	6	67054
M 22	DS	80	24	15	6	67055
M 24	DS	90	27	15	8	67056
M 27	DS	90	27	19	8	67057
M 30	DS	90	27	19	10	67058
M 33	DS	100	29	24	10	67059
M 36	DS	100	29	24	10	67060
M 39	DS	110	32	27	12	67061
M 42	DS	110	27	27	12	67062
M 45	DS	110	27	32	17	67063
M 48	DS	140	42	32	17	67064
M 52	DS	140	42	36	19	67065



HexTap S

Threading-Bit, 1/4" Hexagon Shank
metric-fine ISO-thread DIN 13

六角柄丝锥

带1/4" 六角柄
公制细牙ISO螺纹 DIN 13



HSS-G

Tol. ISO2/6H

Mf

Size	Typ	L 1	L 2	SW1	Art.-No.
M 3 x 0.35	S	33,0	11	1/4"	67700
M 3.5 x 0.35	S	33,5	10	1/4"	67701
M 4 x 0.35	S	35,0	12	1/4"	67702
M 4 x 0.5	S	35,0	12	1/4"	67703
M 4.5 x 0.5	S	35,0	12	1/4"	67704
M 5 x 0.5	S	36,0	15	1/4"	67705
M 5 x 0.75	S	36,0	15	1/4"	67706
M 5.5 x 0.5	S	35,0	15	1/4"	67707
M 6 x 0.5	S	39,0	18	1/4"	67708
M 6 x 0.75	S	39,0	18	1/4"	67709
M 7 x 0.5	S	37,5	16	1/4"	67710
M 7 x 0.75	S	37,5	16	1/4"	67711
M 8 x 0.5	S	40,0	19	1/4"	67712
M 8 x 0.75	S	40,0	19	1/4"	67713
M 8 x 1.0	S	40,0	19	1/4"	67714
M 9 x 0.5	S	40,5	18	1/4"	67715
M 9 x 0.75	S	40,5	18	1/4"	67716
M 9 x 1.0	S	40,5	18	1/4"	67717
M 10 x 0.5	S	41,0	21	1/4"	67718
M 10 x 0.75	S	41,0	21	1/4"	67719
M 10 x 1.0	S	41,0	21	1/4"	67720
M 10 x 1.25	S	41,0	21	1/4"	67721



HexTap DS

Double Ended Tap, Multi-Drive
metric-fine ISO-thread DIN 13

六角柄双头丝锥

双头丝锥, 多种驱动
公制细牙ISO螺纹 DIN 13



HSS-G

Tol. ISO2/6H

Mf

Size	Typ	L 1	L 4	SW1	SW2	Art.-No.
M 11 x 0,75	DS	70	22	8	4	67722
M 11 x 1.0	DS	70	22	8	4	67723
M 11 x 1.25	DS	70	22	8	4	67724
M 12 x 0.5	DS	70	22	8	4	67725
M 12 x 0.75	DS	70	22	8	4	67726
M 12 x 1	DS	70	22	8	4	67727
M 12 x 1.25	DS	70	22	8	4	67728
M 12 x 1.5	DS	70	22	8	4	67729
M 13 x 0.5	DS	70	22	10	4	67730
M 13 x 0.75	DS	70	22	10	4	67731
M 13 x 1.0	DS	70	22	10	4	67732
M 13 x 1.5	DS	70	22	8	4	67733
M 14 x 0.5	DS	70	22	10	4	67734
M 14 x 0.75	DS	70	22	10	4	67735
M 14 x 1.0	DS	70	22	10	4	67736
M 14 x 1.25	DS	70	22	10	4	67737
M 14 x 1.5	DS	70	22	10	4	67738
M 15 x 0.75	DS	70	22	12	4	67739
M 15 x 1.0	DS	70	22	12	4	67740
M 15 x 1.5	DS	70	22	10	4	67741
M 16 x 0.5	DS	70	22	12	4	67742
M 16 x 0.75	DS	70	22	12	4	67743
M 16 x 1	DS	70	22	12	4	67744
M 16 x 1.25	DS	70	22	12	4	67745
M 16 x 1.5	DS	70	22	12	4	67746
M 17 x 1.0	DS	80	24	13	5	67747
M 17 x 1.5	DS	80	24	13	5	67748
M 18 x 0.5	DS	80	24	13	5	67749
M 18 x 0.75	DS	80	24	13	5	67750
M 18 x 1.0	DS	80	24	13	5	67751
M 18 x 1,25	DS	80	24	13	5	67752
M 18 x 1.5	DS	80	24	13	5	67753
M 18 x 2.0	DS	80	24	13	5	67754
M 19 x 1.0	DS	80	24	15	6	67755
M 19 x 1.5	DS	80	24	15	6	67756
M 20 x 0.5	DS	80	24	15	6	67757
M 20 x 0.75	DS	80	24	15	6	67758
M 20 x 1.0	DS	80	24	15	6	67759
M 20 x 1.25	DS	80	24	15	6	67760
M 20 x 1.5	DS	80	24	15	6	67761
M 20 x 2.0	DS	80	24	15	6	67762
M 21 x 1.0	DS	80	24	15	6	67763
M 21 x 1.5	DS	80	24	15	6	67764
M 22 x 0.5	DS	80	24	17	6	67765
M 22 x 0.75	DS	80	24	17	6	67766
M 22 x 1.0	DS	80	24	17	6	67767
M 22 x 1.25	DS	80	24	17	6	67768
M 22 x 1.5	DS	80	24	17	6	67769
M 22 x 2.0	DS	80	24	17	6	67770





HexTap DS

Double Ended Tap, Multi-Drive
metric-fine ISO-thread DIN 13

六角柄双头丝锥

双头丝锥, 多种驱动
公制细牙ISO螺纹 DIN 13



HSS-G

Tol. ISO2/6H

Mf

Size	Typ	L 1	L 4	SW1	SW2	Art.-No.
M 23 x 1.0	DS	80	24	17	6	67771
M 23 x 1.5	DS	80	24	17	6	67772
M 24 x 0.5	DS	80	24	19	8	67773
M 24 x 0,75	DS	80	24	19	8	67774
M 24 x 1.0	DS	80	24	19	8	67775
M 24 x 1,25	DS	80	24	19	8	67776
M 24 x 1.5	DS	90	27	19	8	67777
M 24 x 2.0	DS	90	27	17	8	67778
M 25 x 1.0	DS	90	27	19	8	67779
M 25 x 1.5	DS	90	27	19	8	67780
M 26 x 1.0	DS	90	27	19	8	67781
M 26 x 1.5	DS	90	27	19	8	67782
M 26 x 2.0	DS	90	27	19	8	67783
M 27 x 1.0	DS	90	27	19	8	67784
M 27 x 1.5	DS	90	27	19	8	67785
M 27 x 2.0	DS	90	27	19	8	67786
M 28 x 1.0	DS	90	27	19	8	67787
M 28 x 1.5	DS	90	27	19	8	67788
M 28 x 2.0	DS	90	27	19	8	67789
M 29 x 1.5	DS	90	27	19	8	67790
M 30 x 1.0	DS	90	27	24	10	67791
M 30 x 1.5	DS	90	27	24	10	67792
M 30 x 2.0	DS	90	27	24	10	67793
M 30 x 2.5	DS	90	27	22	10	67794
M 30 x 3.0	DS	90	27	22	10	67795
M 32 x 1.0	DS	90	27	24	10	67796
M 32 x 1.5	DS	90	27	24	10	67797
M 32 x 2.0	DS	90	27	24	10	67798
M 32 x 3.0	DS	90	27	24	10	67799
M 33 x 1.5	DS	100	29	24	10	67800
M 33 x 2.0	DS	100	29	24	10	67801
M 33 x 3.0	DS	100	29	24	10	67802
M 34 x 1.0	DS	100	29	27	10	67803
M 34 x 1.5	DS	100	29	27	10	67804
M 34 x 2.0	DS	100	29	27	10	67805
M 35 x 1.0	DS	100	29	27	10	67806
M 35 x 1.5	DS	100	29	27	10	67807
M 35 x 2.0	DS	100	29	27	10	67808
M 36 x 1.0	DS	100	29	27	10	67809
M 36 x 1.5	DS	100	29	27	10	67810
M 36 x 2.0	DS	100	29	27	10	67811
M 36 x 3.0	DS	100	29	27	10	67812
M 37 x 1.5	DS	100	29	27	10	67813
M 38 x 1.0	DS	110	32	27	12	67814
M 38 x 1.5	DS	110	32	27	12	67815
M 38 x 2.0	DS	110	32	27	12	67816
M 38 x 3.0	DS	110	32	27	12	67817
M 39 x 1.5	DS	110	32	32	12	67818
M 39 x 2.0	DS	110	32	27	12	67819



HexTap DS

Double Ended Tap, Multi-Drive
metric-fine ISO-thread DIN 13

六角柄双头丝锥

双头丝锥, 多种驱动
公制细牙ISO螺纹 DIN 13



HSS-G

Tol. ISO2/6H

Mf

Size	Typ	L 1	L 4	SW1	SW2	Art.-No.
M 39 x 3.0	DS	110	32	27	12	67820
M 40 x 1.0	DS	110	32	32	12	67821
M 40 x 1.5	DS	110	32	32	12	67822
M 40 x 2.0	DS	110	32	32	12	67823
M 40 x 3.0	DS	110	32	27	12	67824
M 42 x 1.0	DS	110	32	32	12	67825
M 42 x 1.5	DS	110	27	32	12	67828
M 42 x 2.0	DS	110	27	32	12	67826
M 42 x 3.0	DS	110	27	32	12	67827
M 44 x 1.5	DS	110	27	36	12	67829
M 44 x 2.0	DS	110	27	36	12	67830
M 45 x 1.0	DS	110	27	36	17	67831
M 45 x 1.5	DS	110	27	36	17	67832
M 45 x 2.0	DS	110	27	36	17	67833
M 45 x 3.0	DS	110	27	36	17	67834
M 46 x 1.5	DS	110	27	36	17	67835
M 48 x 1.0	DS	140	45	36	17	67836
M 48 x 1.5	DS	140	45	36	17	67837
M 48 x 2.0	DS	140	45	36	17	67838
M 48 x 3.0	DS	140	45	36	17	67839
M 50 x 1.5	DS	140	42	41	17	67840
M 50 x 2.0	DS	140	42	41	17	67841
M 50 x 3.0	DS	140	42	36	17	67842
M 52 x 1.5	DS	140	42	41	19	67843
M 52 x 2.0	DS	140	42	41	19	67844
M 52 x 3.0	DS	140	42	41	19	67845
M 63 x 1.5	DS	160	47	50	19	67846



HexTap S

Threading-Bit, 1/4" Hexagon Shank
Pipe-thread DIN ISO 228

六角柄丝锥

带1/4" 六角柄
管螺纹 DIN ISO 228



HSS-G

G (BSP)

Size	Typ	L 1	L 2	SW1	Art.-No.
G 1/8	S	40.5	17	1/4"	67870

HexTap DS

Double Ended Tap, Multi-Drive
Pipe-thread DIN ISO 228

六角柄双头丝锥

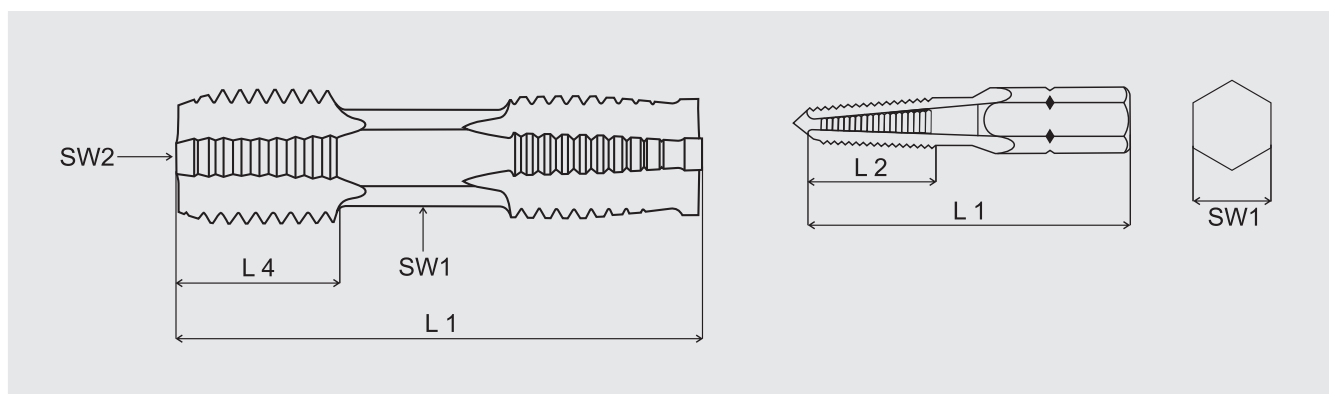
双头丝锥, 多种驱动
管螺纹 DIN ISO 228



HSS-G

G (BSP)

Size	Typ	L 1	L 4	SW1	SW2	Art.-No.
G 1/4	DS	70	22	8	4	67871
G 3/8	DS	70	22	12	4	67872
G 1/2	DS	80	24	15	6	67873
G 3/4	DS	90	27	19	8	67874
G 1"	DS	100	29	24	10	67875
G 1.1/4	DS	110	27	32	12	67876
G 1.1/2	DS	140	42	36	17	67877
G 2"	DS	160	47	41	19	67878



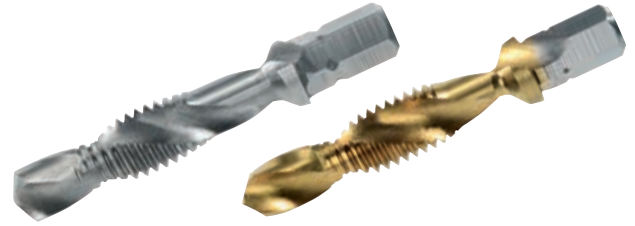


Combined Bits

for Drilling, Tapping and Deburring in one operation
with 1/4" Hexagon Drive (Bit)

复合丝锥

带1/4" 六角柄
一次完成钻孔、攻丝、倒角



HSS-G

Tol. ISO2/6H

M

Nominal Diameter D	D 1	L 1	⊘	Art.-No.
M 3 x 0.5	2.5	36	1/4"	67226
M 4 x 0.7	3.3	39	1/4"	67230
M 5 x 0.8	4.2	41	1/4"	67234
M 6 x 1.0	5.0	44	1/4"	67238
M 8 x 1.25	6.8	50	1/4"	67242
M 10 x 1.5	8.5	59	1/4"	67246

TIN

M 3 x 0.5	2.5	36	1/4"	67210
M 4 x 0.7	3.3	39	1/4"	67211
M 5 x 0.8	4.2	41	1/4"	67212
M 6 x 1.0	5.0	44	1/4"	67213
M 8 x 1.25	6.8	50	1/4"	67214
M 10 x 1.5	8.5	59	1/4"	67215

Technical Information:

VÖLKEL-Combined-Bits have been designed for drilling, tapping and deburring in one operation using battery-powered screwdriver drills and electric hand drills with right-hand and left-hand rotation, but they are also suitable for thread cutting in a stationary drilling machine. The Combined Bit is suitable for universal use in materials of medium mechanical strength, non ferrous metals and thermoplastics (up to 600 N/mm² tensile strength). It is possible with this tool to produce through threads up to a maximum threaded depth of 1 x D. They are especially useful for mounting and small batch production. Take care that the tool and the axis of the hole are exactly aligned and use a suitable cutting oil.

The following technical data apply for using battery-powered screwdriver and electric hand drills:

技术资料:

VOLKEL六角柄复合丝锥是设计用于充电式电动起子和带有左旋和右旋功能的手电钻进行一次完成钻孔、攻丝、倒角的工具,也适用于手动或固定钻床。复合丝锥通用于中等机械强度的材料、有色金属、热塑性材料(抗拉强度小于600N/mm²)。复合丝锥最大的攻丝深度为1 x D, 特别适合用于安装和小批量生产。请注意孔的中心轴和丝锥的中心轴要对齐,使用合适的切削油。

以下技术参数适用于充电式电动起子和手电钻进行攻丝:

Dimensions/尺寸	M 3	M 4	M 5	M 6	M 8	M 10
Core hole dia./底孔直径	2,5 mm	3,3 mm	4,2 mm	5,0 mm	6,8 mm	8,5 mm
max. RPM/最大转速	1600 UpM	1200 UpM	950 UpM	800 UpM	600 UpM	450 UpM



Combined Bits

for Drilling, Tapping and
Deburring in one operation
with 1/4" Hexagon Drive (Bit)



复合丝锥

一次完成钻孔、攻丝、倒角
带1/4" 六角柄

HSS-G

UNC / UNF

Nominal Diameter D	D 1	L 1	⬡	Art.-No.
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UNC

UNC Nr. 4 x 40	2.3	36	1/4"	67280
UNC Nr. 5 x 40	2.6	36	1/4"	67281
UNC Nr. 6 x 32	2.85	39	1/4"	67282
UNC Nr. 8 x 32	3.5	39	1/4"	67283
UNC Nr. 10 x 24	3.9	41	1/4"	67284
UNC Nr. 12 x 24	4.5	41	1/4"	67285
UNC 1/4 x 20	5.2	44	1/4"	67286
UNC 5/16 x 18	6.6	50	1/4"	67287
UNC 3/8 x 16	8.0	59	1/4"	67288

UNF

UNF Nr. 4 x 48	2.4	36	1/4"	67290
UNF Nr. 5 x 44	2.7	36	1/4"	67291
UNF Nr. 6 x 40	3.0	39	1/4"	67292
UNF Nr. 8 x 36	3.5	39	1/4"	67293
UNF Nr. 10 x 32	4.1	41	1/4"	67294
UNF Nr. 12 x 28	4.7	41	1/4"	67295
UNF 1/4 x 28	5.5	44	1/4"	67296
UNF 5/16 x 24	6.9	50	1/4"	67297
UNF 3/8 x 24	8.5	59	1/4"	67298



TriBit²

One Box for all occasions
Drilling, Tapping, Deburring
Combined and specific tools

六角柄工具套装





套装带有钻孔、攻丝、
倒角工具和复合丝锥



HSS-G

Tol. ISO2/6H

M

Nominal Diameter D					Art.-No.
M 3 x 0.5	2.5 mm	6.3 mm	M 3	M 3	67403
M 4 x 0.7	3.3 mm	8.3 mm	M 4	M 4	67404
M 5 x 0.8	4.2 mm	10.4 mm	M 5	M 5	67405
M 6 x 1.0	5.0 mm	12.4 mm	M 6	M 6	67406
M 8 x 1.25	6.8 mm	16.5 mm	M 8	M 8	67408
M 10 x 1.5	8.5 mm	20.5 mm	M 10	M 10	67410

Wood Drill Bits

with 1/4" Hexagon Drive

六角柄木工钻

带1/4" 六角柄



HSS-G

Nominal Diameter D	L 1	S 2	⬡	Art.-No.
3.0 mm	38	16	1/4"	67630
4.0 mm	44	20	1/4"	67640
5.0 mm	50	26	1/4"	67650
6.0 mm	50	26	1/4"	67660
8.0 mm	51	32	1/4"	67680
10.0 mm	54	38	1/4"	67698



Drill Bits

with 1/4" Hexagon Drive

六角柄钻头

带1/4" 六角柄



HSS-G

M

Nominal Diameter D	L 1	S 2	⬡	Art.-No.
1.0 mm	32	7	1/4"	67110
1.5 mm	32	10	1/4"	67115
2.0 mm	34	12	1/4"	67120
2.5 mm (M3)	36	14	1/4"	67125
3.0 mm	38	16	1/4"	67130
3.3 mm (M4)	40	18	1/4"	67133
3.5 mm	40	18	1/4"	67135
4.0 mm	44	20	1/4"	67140
4.2 mm (M5)	45	20	1/4"	67142
4.5 mm	46	24	1/4"	67145
5.0 mm (M6)	50	26	1/4"	67150
5.5 mm	50	26	1/4"	67155
6.0 mm	50	26	1/4"	67160
6.5 mm	50	30	1/4"	67165
6.8 mm (M8)	50	30	1/4"	67168
7.0 mm	50	30	1/4"	67170
7.5 mm	51	32	1/4"	67175
8.0 mm	51	32	1/4"	67180
8.5 mm (M10)	53	33	1/4"	67185
9.0 mm	53	33	1/4"	67190
9.5 mm	54	38	1/4"	67195
10.0 mm	54	38	1/4"	67198
10.2 mm (M12)	54	38	1/4"	67199

Countersink Bits

90° - 3 Flutes

with 1/4" Hexagon Drive

六角柄倒角刀

90° - 3 槽

带1/4" 六角柄



HSS

Nominal Diameter D	L 1	⬡	Art.-No.
6.3 mm	31	1/4"	67306
8.3 mm	31	1/4"	67308
10.4 mm	34	1/4"	67310
12.4 mm	35	1/4"	67312
16.5 mm	40	1/4"	67316
20.5 mm	41	1/4"	67320