

ZENSTAR

Quality Tooling Redefined

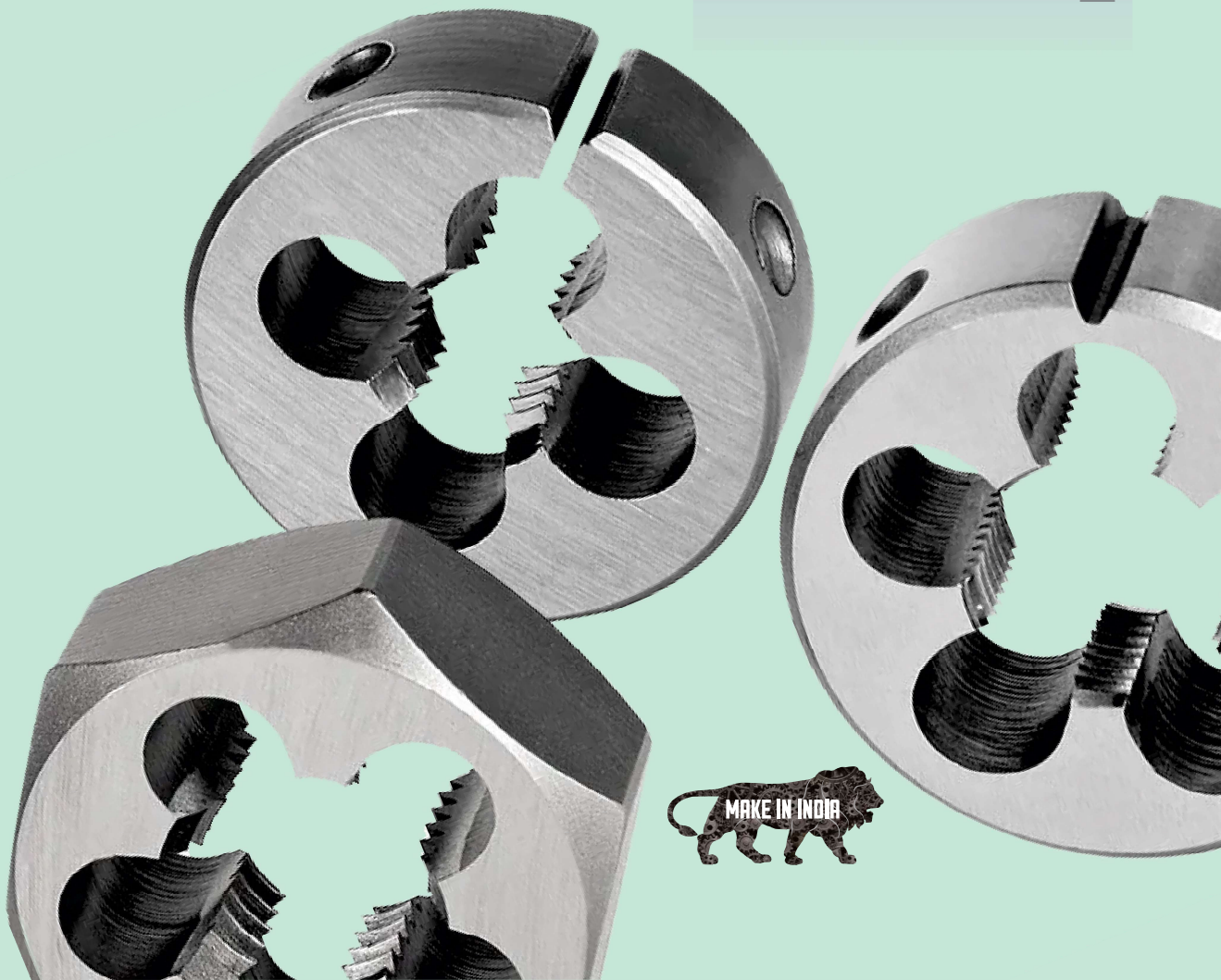
Complete range of Dies & Die Nuts

- BSW, UNC, UNF & BSF
- BSP, BSPT & NPT
- BSB, ME & BA
- METRIC, COARSE AND FINE PITCH

**PRICE LIST EFFECTIVE
FROM 01-01-2023**

SD DIES

HSS External Threading Round Dies & Hex Nuts



HSS ROUND DIE METRIC COARSE PITCH

HSS ROUND DIE METRIC COARSE PITCH						
DIAMETER	PITCH	OD	THICKNESS	NO.CLEARANCE	THREADING	RATES
				HOLE	DIAMETER	
M2.0	0.4	13/16"	1/4"	3	1.96	300
M2.2	0.45	13/16"	1/4"	3	1.96	300
M2.3	0.4	13/16"	1/4"	3	1.96	300
M2.5	0.45	13/16"	1/4"	3	1.96	300
M3	0.5	13/16"	1/4"	3	2.95	300
M3.5	0.6	13/16"	1/4"	3	2.95	300
M4	0.7	13/16"	1/4"	3	3.95	300
M4.5	0.75	13/16"	1/4"	3	3.95	300
M5	0.8	13/16"	1/4"	3	4.95	300
M6	1	1"	1/4"	4	5.93	400
M7	1	1"	1/4"	4	6.93	400
M8	1.25	1"	3/8"	4	7.92	400
M9	1.24	1"	3/8"	4	8.93	400
M10	1.5	1"	3/8"	4	9.91	400
M12	1.75	1.1/2"	1/2"	4	11.9	750
M14	2	1.1/2"	1/2"	5	13.89	750
M16	2	1.1/2"	1/2"	5	15.89	750
M18	2.5	1.1/2"	1/2"	6	17.88	750
M20	2.5	2"	5/8"	5	19.88	1250
M22	2.5	2"	5/8"	5	21.88	1250
M24	3	2"	5/8"	5	23.88	1250
M25	3	2.1/4"	11/16"	6	23.88	1750
M27	3	2.1/4"	11/16"	6		1750
M30	3.5	2.1/4"	11/16"	6		1750
M33	3.5	2.1/4"	11/16"	6		1750
M36	4	75 MM	7/8"	6		3800
M39	4	75 MM	7/8"	6		3800
M42	4.5	75 MM	7/8"	6		3800
M45	4.5	75 MM	7/8"	6		3800
M48	5	90 MM	1"	6		6500

HSS ROUND DIE BSW, UNC, UNF

Diameter	TPI				OUTER		No	Threading Diameter	RATES
	BSW	BSF	UNC	UNF	Diameter A	Thickness B	Clearance HOLE		
	1/16"	60				13/16"	1/4"		
3/32"	48				13/16"	1/4"	3	2.35	300
1/8"	40				13/16"	1/4"	3	3.14	300
5/32"	32				13/16"	1/4"	3	3.93	300
3/16"	24	32			13/16"	1/4"	3	4.72	300
7/32"	24	28			1"	1/4"	4	5.51	400
1/4"	20	26	20	28	1"	3/8"	3	6.31	400
9/32"	20	26			1"	3/8"	4	7.1	400
5/16"	18	22	18	24	1"	3/8"	4	7.88	400
3/8"	16	20	16	24	1"	3/8"	4	9.47	400
7/16"	14	18	14	20	1.1/2"	1/2"	4	11.05	750
1/2"	12	16	13	20	1.1/2"	1/2"	4	12.63	750
9/16"	12	16	12	18	1.1/2"	1/2"	5	14.21	750
5/8"	11	14	11	18	1.1/2"	1/2"	5	15.8	750
11/16"	11				1.1/2"	1/2"	6	17.39	750
3/4"	10	12	10	16	1.1/2"	1/2"	6	18.97	750
7/8"	9	11	9	14	2"	5/8"	5	22.14	1250
1"	8	10	8	12	2"	5/8"	6	25.3	1250
1.1/8"	7	9	7	12	2.1/4"	11/16"	6		1750
1.1/4"	7	9	7	12	2.1/4"	11/16"	6		1750
1.3/8"	6	8	6	12	65 MM	7/8"	6		2750
1.1/2"	6	8	6	12	75 MM	7/8"	6		3800
1.3/4"	5	7	5	14	90 MM	1"	6		6500
2"	4.5	7	5	14	90 MM	1"	6		6500
#3				56	13/16"	1/4"	3	2.83	300
#4			40	48	13/16"	1/4"	3	2.83	300
#5			40	44	13/16"	1/4"	3	3.15	300
#6			32	40	13/16"	1/4"	3	3.48	300
#8			32	36	13/16"	1/4"	3	4.14	300
#10			24	32	13/16"	1/4"	3	4.79	300
#12			24	28	13/16"	1/4"	4	5.45	300

HSS ROUND DIE BSP, BSPT, NPT

Diameter	TPI	TPI	TPI	Outer Dia	Thickness	Thickness	Clearance	Threading	RATES
	BSP	NPT	BSPT	A	B	BSPT/NPT	Hole	Diameter	
1/8"	28	27	28	1"	3/8"	10	4	9.68	500
1/4"	19	18	19	1.1/2"	1/2"	14	5	13.11	1000
3/8"	19	18	19	1.1/2"	1/2"	14	5	16.6	1200
1/2"	14	14	14	2"	5/8"	19	6	20.89	1700
5/8"	14			2"	5/8"		6	22.84	1700
3/4"	14	14	14	2"	5/8"	20	6	26.36	1700
7/8"	14			2.1/4"	5/8"		6+6	30.11	3200
1"	11	11.1/2	11	2.1/4"	5/8"	25	6+6	33.16	3200
1.1/8"	11			75 MM	7/8"		6		5000
1.1/4"	11	11.1/2	11	75 MM	7/8"	25	6		5000
1.3/8"	11			90 MM	1"				6800
1.1/2"	11	11.1/2	11	90 MM	1"	25	6		6800
1.3/4"	11			90 MM	1"				7500
2"	11	11.1/2	11	90 MM	1"	27	6		7500

HSS ROUND DIE METRIC FINE THREAD

DIAMETER	PITCH	OD	THICKNESS	No Clearance	THREADING	RATES
M3.0	0.35	13/16"	1/4"	3	2.96	300
M3.5	0.35	13/16"	1/4"	3	3.46	300
M4	0.5	13/16"	1/4"	3	3.95	300
M4.5	0.5	13/16"	1/4"	3	4.45	300
M5	0.5	13/16"	1/4"	3	4.95	300
M6	0.75	1"	1/4"	4	5.95	400
M7	0.75	1"	1/4"	4	6.95	400
M8	0.75	1"	3/8"	4	7.97	400
M8	1	1"	3/8"	4	7.93	400
M9	1	1"	3/8"	4	8.95	400
M10	1	1"	3/8"	4	9.93	400
M10	1.25	1"	3/8"	4	9.95	400
M12	1	1.1/2"	1/2"	5	11.93	750
M12	1.25	1.1/2"	1/2"	5	11.92	750
M12	1.5	1.1/2"	1/2"	4	11.91	750
M14	1	1.1/2"	1/2"	5	13.93	750
M14	1.25	1.1/2"	1/2"	5	13.92	750
M14	1.5	1.1/2"	1/2"	5	13.91	750
M16	1	1.1/2"	1/2"	5	15.93	750
M16	1.5	1.1/2"	1/2"	5	15.91	750
M18	1	1.1/2"	1/2"	6	17.91	750
M18	1.5	1.1/2"	1/2"	6	17.91	750
M18	2	1.1/2"	1/2"	6	17.91	750

HSS ROUND DIE METRIC FINE THREAD

DIAMETER	PITCH	OD	Thickness	No Clearance	THREADING	RATES
M20	1.5	2"	1/2"	6	19.91	1250
M20	2	2"	5/8"	5	19.91	1250
M22	1.5	2"	5/8"	6	21.91	1250
M22	2	2"	5/8"	6	21.91	1250
M24	1.5	2"	5/8"	6	23.93	1250
M24	2	2"	5/8"	6	23.9	1250
M25	1.5	2.1/4"	5/8"	6	24.91	1750
M25	2	2.1/4"	5/8"	6	24.91	1750
M26	1.5	2.1/4"	5/8"	6	25.9	1750
M26	2	2.1/4"	5/8"	6	25.9	1750
M27	1.5	2.1/4"	5/8"	6+6	26.9	1750
M27	2	2.1/4"	5/8"	6+6	26.9	1750
M28	1.5	2.1/4"	5/8"	6+6	27.9	1750
M28	2	2.1/4"	5/8"	6+6	27.9	1750
M30	1.5	2.1/4"	5/8"	6+6	29.9	1750
M30	2	2.1/4"	5/8"	6+6	29.9	1750
M30	3	2.1/4"	5/8"	6+6	29.9	1750
M32	1.5	2.1/4"	11/16"	6+6		1750
M32	2	2.1/4"	11/16"	6+6		1750
M33	1.5	2.1/4"	11/16"	6+6		1750
M33	2	2.1/4"	11/16"	6+6		1750
M33	3	2.1/4"	11/16"	6+6		1750
M35	1.5	75 MM	7/8"	6		3800
M36	1.5	75 MM	7/8"	6		3800
M36	2	75 MM	7/8"	6		3800
M36	3	75 MM	7/8"	6	3800	3800
M39	1.5	75 MM	7/8"	6	3800	3800
M39	2	75 MM	7/8"	6	3800	3800
M39	3	75 MM	7/8"	6	3800	3800
M42	1.5	75 MM	7/8"	6	3800	3800
M42	2	75 MM	7/8"	6	3800	3800
M42	3	75 MM	7/8"	6	3800	3800
M42	4	75 MM	7/8"	6	3800	3800
M45	1.5	75 MM	7/8"	6	3800	3800
M45	2	75 MM	7/8"	6	3800	3800
M45	3	75 MM	7/8"	6	3800	3800
M45	4	75 MM	7/8"	6	3800	3800
M48	1.5	90 MM	1"	6	6500	6500
M48	2	90 MM	1"	6	6500	6500
M48	3	90 MM	1"	6	6500	6500
M48	4	90 MM	1"	6	6500	6500

HSS DIE NUT METRIC COARSE THREAD

DIAMETER	PITCH	ACROSS FLAT	THICKNESS	RATES
M3	0.5	0.710"	6.35	350
M3.5	0.6	0.710"	6.35	350
M4	0.7	0.710"	6.35	350
M4.5	0.75	0.710"	6.35	350
M5	0.8	0.710"	6.35	350
M6	1	0.710"	6.35	350
M7	1	0.710"	6.35	350
M8	1.25	0.920"	7.94	450
M9	1.24	0.920"	9.53	450
M10	1.5	0.920"	9.53	450
M11	2	1.100"	11.11	650
M12	1.75	1.100"	12.7	650
M14	2	1.300"	15.88	1200
M16	2	1.300"	15.88	1200
M18	2.5	1.480"	17.46	1600
M20	2.5	1.480"	17.46	1600
M22	2.5	1.670"	20.63	2300
M24	3	2.050"	23.81	3500
M25	3	2.050"	26.99	3500
M27	3	2.220"	26.99	4300
M30	3.5	2.220"	26.99	4300
M32	2	2.580"	26.99	5500
M33	3.5	2.580"	28.5	5500
M36	4	2.580"	28.5	5500
M39	4	2.760"	28.5	6500
M42	4.5	2.760"	28.5	6500

HSS DIE NUT BSP, BSPT, NPT

DIAMETER	TPI	TPI	TPI	ACROSS	Thickness	RATE
	BSP	NPT	BSPT	FLAT		NPT/BSPT
1/8"	28	27	28	0.920"	10	450
1/4"	19	18	19	1.100"	14	650
3/8"	19	18	19	1.300"	14	1200
1/2"	14	14	14	1.670"	19	2300
3/4"	14	14	14	2.050"	20	3500
1"	11	11.1/2	11	2.580"	25	5500
1.1/2"	11	11.1/2	11	3.150"		8500
2"	11	11.1/2	11	3.740"		12500

HSS DIE NUT BSW, UNC, UNF

Diameter	TPI				ACROSS		RATES
	BSW	BSF	UNC	UNF	FLAT	THICKNESS	
1/8"	40				0.710"	6.35	350
5/32"	32				0.710"	6.35	350
3/16"	24	32			0.710"	6.35	350
7/32"	24	28			0.710"	6.35	350
1/4"	20	26	20	28	0.710"	6.35	350
9/32"	20	26			0.920"	7.94	450
5/16"	18	22	18	24	0.920"	7.94	450
3/8"	16	20	16	24	0.920"	9.53	450
7/16"	14	18	14	20	1.100"	11.11	650
1/2"	12	16	13	20	1.100"	12.7	650
9/16"	12	16	12	18	1.300"	15.88	1200
5/8"	11	14	11	18	1.300"	15.88	1200
3/4"	10	12	10	16	1.480"	17.46	1600
7/8"	9	11	9	14	1.670"	20.63	2300
1"	8	10	8	12	2.050"	23.81	3500
1.1/8"	7	9	7	12	2.220"	26.99	4300
1.1/4"	7	9	7	12	2.220"	26.99	4300
1.3/8"	6	8	6	12	2.580"	28.58	5500
1.1/2"	6	8	6	12	2.760"	31.75	6500
1.3/4"	5	7	5	14	3.150"	31.75/44.45	8500
2"	4.5	7	5		3.330"	31.75/44.45	10200
#5			40	44	0.710"	6.35	350
#6			32	40	0.710"	6.35	350
#8			32	36	0.710"	6.35	350
#10			24	32	0.710"	6.35	350
#12			24	28	0.710"	6.35	350

NOTE:

-We will provide rates and supply customised round dies as per your dimensions and drawings.

ADVANTAGES - LAPPING

Lapping is a process of fine removal of material using emery compound in this process material

Thread Lapping on Round Dies are done primarily for bring thread closer to the required

Close to 20 to 25 micron material is removed from the flank of the threads to achieve required

Lapped Threads not only achieves tighter tolerance, but also produces superior quality threads

It also adds to the overall look of the Tool.

*“Products are made in the factory,
but brands are created in the mind”*



TECHNO TOOLS IMPEX



ZENSTAR

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