

HSS



Being the best through innovation



PIPE TAPS

GASGEWINDEBOHRER






- Tapping Whitworth Pipe threads
- Zum Gewindeschneiden von Whitworth - Rohrgewinde

SELECTION GUIDE

PIPE TAPS

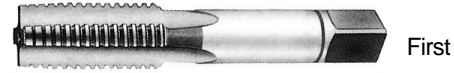
Tapping Whitworth Pipe threads

PIPE TAPS

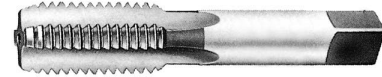
EDP No.	MODEL	Tool Material	Standard	Work Material	Dimensions	Tolerance	Chamfer	Surface Treatment	PAGE
T7709		HSS	G(BSP)	GS	DIN 5157	-	I / III	Bright	487
TC727		HSS-E	G(BSP)	GS	DIN 5156	-	B	Bright	488
TC728		HSS-E	G(BSP)	GS	DIN 5156	-	C	Bright	489
TC729		HSS-E	G(BSP)	VG	DIN 5156	-	C	Bright	490
TB514		HSS-E	G(BSP)	VA NW	DIN 5156	-	C	vap	491

G(BSP) Whitworth Pipe threads DIN ISO 228/1
Whitworth Rohrgewinde DIN ISO 228/1

- ▶ Serial hand tap set in First and Bottoming.
- ▶ Bottoming tap of set has final internal thread dimensions only.
- ▶ Handgewindebohrersatz mit Vor- und Fertigschneider.
- ▶ Nur der Fertigschneider kann das gewünschte Gewinde schneiden.

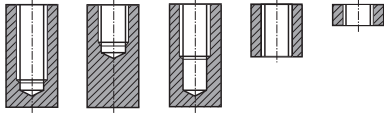


First

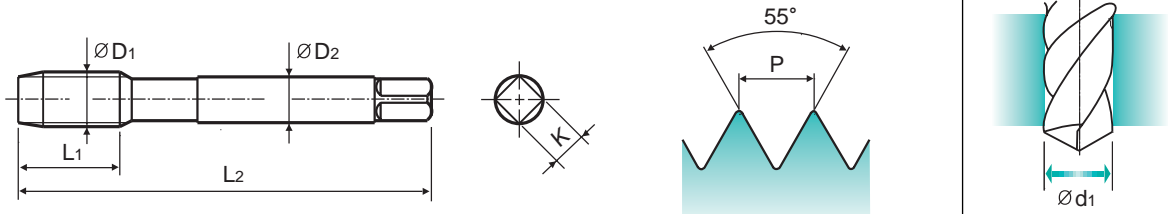


Bottoming

Hole type



Sets of taps
Gewindebohrer-Satz



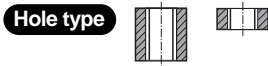
SIZE	TPI	EDP No.	Thread Length	Overall Length	Shank Diameter	Square Size	Tapping drill diameter
ØD1			L1	L2	ØD2	K	Ød1
G1/16"	– 28	T7709029	17	63	6	4.9	6.8
G1/8"	– 28	T7709209	18	63	7	5.5	8.8
G1/4"	– 19	T7709409	20	70	11	9	11.8
G3/8"	– 19	T7709489	20	70	12	9	15.25
G1/2"	– 14	T7709569	22	80	16	12	19
G3/4"	– 14	T7709709	22	90	20	16	24.5
G1"	– 11	T7709789	25	100	25	20	30.75
G1*1/4"	– 11	T7709869	30	125	32	24	39.5
G1*1/2"	– 11	T7709949	30	140	36	29	45.20

Unit : mm

G(BSP) Whitworth Pipe threads DIN ISO 228/1
Whitworth Rohrgewinde DIN ISO 228/1

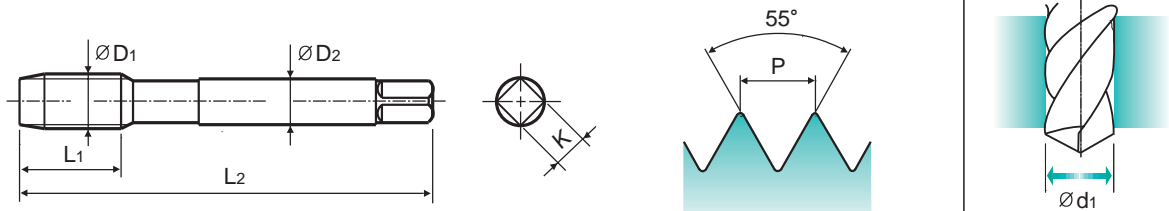
► Suitable for through hole in more cutting speed than other taps due to strong geometry.

► Geeignet für Sacklöcher in höherer Schnittgeschwindigkeit als andere Gewindebohrer dank einer stabilen Bohrergeometrie.



DIN 5156

Material groups **GS** **HSS-E** **DIN 5156** **55°** **B** **Bright** Machine taps Maschinengewindebohrer



SIZE	TPI	EDP No.	Thread Length	Overall Length	Shank Diameter	Square Size	Tapping drill diameter
ØD1			L1	L2	ØD2	K	Ød1
G1/8"	28	TC727200	18	90	7	5.5	8.8
G1/4"	19	TC727400	22	100	11	9	11.8
G3/8"	19	TC727480	22	100	12	9	15.25
G1/2"	14	TC727560	25	125	16	12	19
G3/4"	14	TC727700	28	140	20	16	24.5
G1"	11	TC727780	32	160	25	20	30.75

Unit : mm

Unit : N/mm² ◎ : Excellent ○ : Good

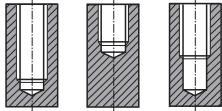
Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
○	○	○	○	○	○	○	○	○	○	○	◎	◎	○	○
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
○	○	○	○	○	○	◎	○	○	○	○	◎	○	○	○

**G(BSP) Whitworth pipe threads DIN ISO 228/1
Whitworth Rohrgewinde DIN ISO 228/1**

► Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

► Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

Hole type

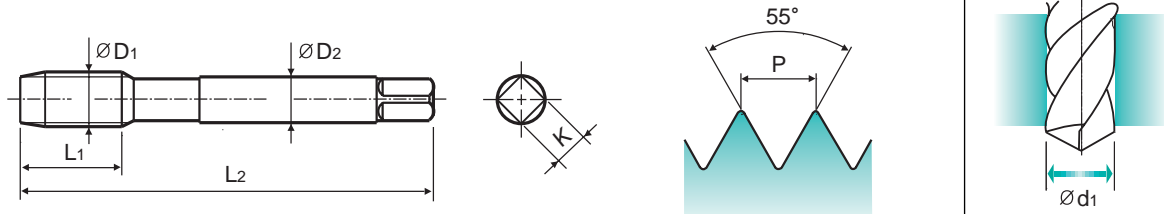


DIN 5156

Material groups **GS**

HSS-E DIN 5156 55° C Bright R40

Machine taps
Maschinengewindebohrer



Unit : mm

SIZE	TPI	EDP No.	Thread Length L1	Overall Length L2	Shank Diameter ØD2	Square Size K	Tapping drill diameter Ød1
G1/8"	28	TC728200	10	90	7	5.5	8.8
G1/4"	19	TC728400	14	100	11	9	11.8
G3/8"	19	TC728480	15	100	12	9	15.25
G1/2"	14	TC728560	17	125	16	12	19
G3/4"	14	TC728700	20	140	20	16	24.5
G1"	11	TC728780	24	160	25	20	30.75

Unit : N/mm²

◎ : Excellent ○ : Good

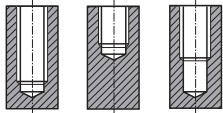
Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
○	○	○	○	○	○	○	○	○	○	○	◎	◎	○	○
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
○	○	○	○	○	○	◎	○	○	○	○	◎	○	○	○

G(BSP) Whitworth pipe threads DIN ISO 228/1
Whitworth Rohrgewinde DIN ISO 228/1

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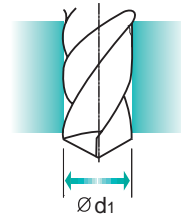
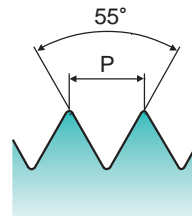
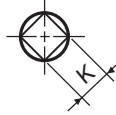
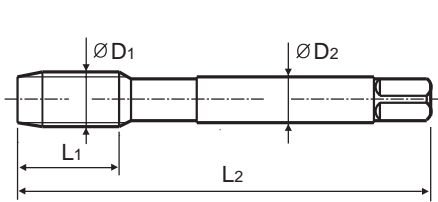
Hole type



DIN 5156



Machine taps
Maschinengewindebohrer



Unit : mm

SIZE	TPI	EDP No.	Thread Length	Overall Length	Shank Diameter	Square Size	Tapping drill diameter
ØD1			L1	L2	ØD2	K	Ød1
G1/8"	28	TC729200	10	90	7	5.5	8.8
G1/4"	19	TC729400	14	100	11	9	11.8
G3/8"	19	TC729480	15	100	12	9	15.25
G1/2"	14	TC729560	17	125	16	12	19
G3/4"	14	TC729700	20	140	20	16	24.5
G1"	11	TC729780	24	160	25	20	30.75

Unit : N/mm²

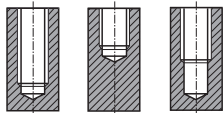
◎ : Excellent ○ : Good

Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
			○	◎				○						○
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
		○												

G(BSP) Whitworth pipe threads DIN ISO 228/1 Whitworth Rohrgewinde DIN ISO 228/1

► Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

► Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

Hole type


DIN 5156

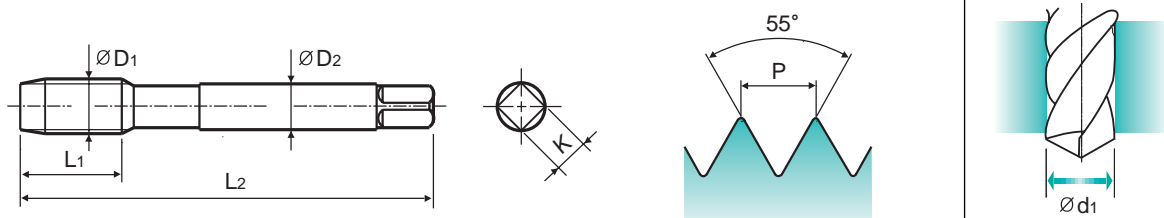


HSS-E

DIN 5156



Vap


 Machine taps
Maschinengewindebohrer


Unit : mm

SIZE	TPI	EDP No.	Thread Length	Overall Length	Shank Diameter	Square Size	Tapping drill diameter
ØD1			L1	L2	ØD2	K	Ød1
G1/8"	28	TB514200	10	90	7	5.5	8.8
G1/4"	19	TB514400	14	100	11	9	11.8
G3/8"	19	TB514480	15	100	12	9	15.25
G1/2"	14	TB514560	17	125	16	12	19
G3/4"	14	TB514700	20	140	20	16	24.5
G1"	11	TB514780	24	160	25	20	30.75

 Unit : N/mm²

◎ : Excellent ○ : Good

Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
○	○					◎	◎	◎						○
Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Al Si ≤ 10%	Al Si > 10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
		○												