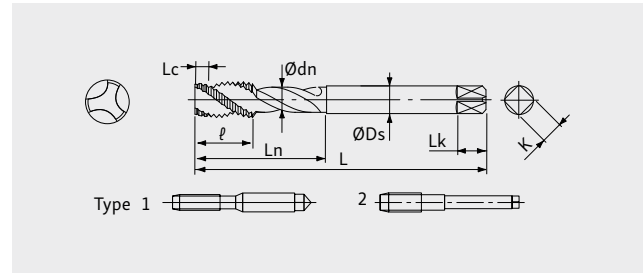


SGSP – DIN Spiral Tap Metric

- ▶ Modified bottoming style 2.5 thread chamfer
- ▶ SG-Coating
- ▶ DIN overall length
- ▶ Premium powdered high-speed steel



LIST: 6806

| M | Pitch | Pitch Chamfer | OAL | Thread Length | Ln | dn | Shank Ø | Square Width | Square Length | Z | Type | DIN | Stock |
|-----|-------|---------------|-----|---------------|----|-------|---------|--------------|---------------|---|------|-----|-------|
| | | Lc | L | ℓ | | | | Ds | K | | | | |
| 3 | 0.5 | 2.5P | 56 | 5.6 | 18 | 2.35 | 3.5 | 2.7 | 6 | 3 | 1 | 371 | ● |
| 4 | 0.7 | 2.5P | 63 | 8.1 | 21 | 3.15 | 4.5 | 3.4 | 6 | 3 | 1 | 371 | ● |
| 5 | 0.8 | 2.5P | 70 | 9.4 | 25 | 4.05 | 6.0 | 4.9 | 8 | 3 | 1 | 371 | ● |
| 5.5 | 0.9 | 2.5P | 80 | 7.2 | 30 | 4.45 | 6 | 4.9 | 8 | 3 | 1 | 371 | ● |
| 6 | 1 | 2.5P | 80 | 12 | 30 | 4.75 | 6.0 | 4.9 | 8 | 3 | 1 | 371 | ● |
| 8 | 1.25 | 2.5P | 90 | 15.4 | 35 | 6.55 | 8.0 | 6.2 | 9 | 3 | 1* | 371 | ● |
| 10 | 1.5 | 2.5P | 100 | 18.9 | 39 | 8.25 | 10.0 | 8.0 | 11 | 3 | 1* | 371 | ● |
| 7 | 1 | 2.5P | 80 | 12 | 30 | 5.75 | 5.5 | 4.3 | 7 | 3 | 2 | 376 | ● |
| 8 | 1.25 | 2.5P | 90 | 15.4 | 35 | 6.55 | 6 | 4.9 | 8 | 3 | 2 | 376 | ● |
| 12 | 1.75 | 2.5P | 110 | 22.4 | 42 | 9.95 | 9.0 | 7.0 | 10 | 3 | 2 | 376 | ● |
| 14 | 2 | 2.5P | 110 | 25.9 | 49 | 11.65 | 11.0 | 9.0 | 12 | 3 | 2 | 376 | ● |
| 16 | 2 | 2.5P | 110 | 25.9 | 49 | 13.65 | 12.0 | 9.0 | 12 | 3 | 2 | 376 | ● |
| 18 | 2.5 | 2.5P | 125 | 32.6 | 55 | 15.15 | 14.0 | 11.0 | 14 | 4 | 2 | 376 | ● |
| 20 | 2.5 | 2.5P | 140 | 32.6 | 55 | 17.15 | 16.0 | 12.0 | 15 | 4 | 2 | 376 | ● |
| 22 | 2.5 | 2.5P | 140 | 32.6 | 55 | 19.15 | 18.0 | 14.5 | 17 | 4 | 2 | 376 | ● |
| 24 | 3 | 2.5P | 160 | 38.8 | 63 | 20.65 | 18.0 | 14.5 | 17 | 4 | 2 | 376 | ● |

* Without male center

Suitable for Tapping Structural Steels to Stainless Steels and Aluminium Alloys

| APPLICABLE WORK MATERIALS | | | | | | | | | | | |
|---------------------------|--------------------------|-------------------------|----------------|----------------|----------------------------|----------|----------------|------------------------|----------------------|--------------------------|--------------------------|
| Work Materials | ST52 Structural Steel | C15 Low Carbon Steel | C40 C<0.45% | C50 C>0.45% | 20Cr.42CrMo Alloy Steel | | Hardened Steel | SUS Stainless Steel | GG Grey Cast Iron | GGG Ductile Cast Iron | AC.ADC Aluminum Alloy |
| | ~200HB | ~200HB | ~200HB | ~200HB | ~200HB | 20~30HRC | 30~40HRC | | | | |
| SGSP | ○ | ○ | ● | ● | ● | ○ | △ | ○ | x | ○ | ○ |
| SGPO | ● | ● | ● | ● | ● | ● | △ | ● | x | ○ | ○ |

● Excellent | ○ Good | △ OK | x Not Applicable

Cutting Condition

| RECOMMENDED CUTTING SPEED & CUTTING FLUIDS | | | | | | | | | | | | |
|--|---------------------------------|------------------------------|----------------|----------------|----------------------------|----------|----------------|------------------------|----------------------|--------------------------|--------------------------|-------|
| Work Materials | Recommended Cutting Speed m/min | | | | | | | | | | | |
| | ST52 Structural Steel | C15 Low Carbon Steel | C40 C<0.45% | C50 C>0.45% | 20Cr.42CrMo Alloy Steel | | Hardened Steel | SUS Stainless Steel | GG Grey Cast Iron | GGG Ductile Cast Iron | AC.ADC Aluminum Alloy | |
| | ~200HB | ~200HB | ~200HB | ~200HB | ~200HB | 20~30HRC | 30~40HRC | | | | | |
| SG-Taps | SGSP | 15~30 | 15~30 | 10~50 | 10~50 | 15~30 | 8~15 | - | 5~10 | - | 10~30 | 15~50 |
| | SGPO | 15~50 | 15~30 | 15~50 | 10~50 | 15~50 | 10~30 | - | 5~15 | - | 15~30 | 15~50 |
| Cutting Fluids | | Water-based emulsion from 7% | | | | | | | | | | |

1. These are general cutting recommendations and may be altered by your conditions.
2. These conditions are for thread depth of $2 \times D_c$.
3. Recommended are non-water-soluble cutting oils for Stainless Steel.

