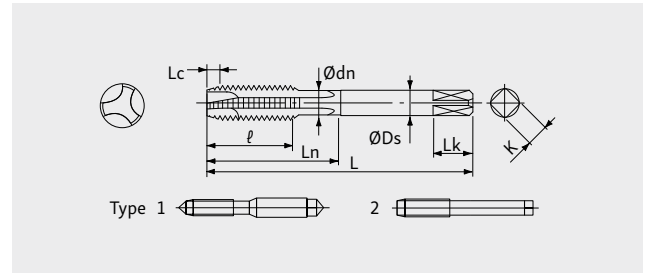


SGPO – DIN Point Tap Metric

- ▶ Plug style 5 thread chamfer
- ▶ SG-Coating
- ▶ DIN overall length
- ▶ Premium powdered high-speed steel



LIST: 6808

M	Pitch	Pitch Chamfer	OAL	Thread Length	Ln	dn	Shank Ø	Square Width	Square Length	Z	Type	DIN	Stock
		Lc	L	ℓ									
3	0.5	5P	56	10	18	2.4	3.5	2.7	6	3	1	371	●
4	0.7	5P	63	12.5	21	3.1	4.5	3.4	6	3	1	371	●
5	0.8	5P	70	14.5	25	4.0	6.0	4.9	8	3	1	371	●
5.5	0.9	5P	80	17	30	4.4	6	4.9	8	3	1	371	●
6	1	5P	80	17	30	4.8	6.0	4.9	8	3	1	371	●
8	1.25	5P	90	22	35	6.55	8.0	6.2	9	3	1*	371	●
10	1.5	5P	100	27	39	8.25	10.0	8.0	11	3	1*	371	●
7	1	5P	80	17	-	-	5.5	4.3	7	3	2	376	●
8	1.25	5P	90	22	-	-	6	4.9	8	3	2	376	●
12	1.75	5P	110	32	-	-	9.0	7.0	10	3	2	376	●
14	2	5P	110	32	-	-	11.0	9.0	12	3	2	376	●
16	2	5P	110	32	-	-	12.0	9.0	12	3	2	376	●
18	2.5	5P	125	37.5	-	-	14.0	11.0	14	3	2	376	●
20	2.5	5P	140	37.5	-	-	16.0	12.0	15	3	2	376	●
22	2.5	5P	140	37.5	-	-	18.0	14.5	17	3	2	376	●
24	3	5P	160	45	-	-	18.0	14.5	17	3	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.

