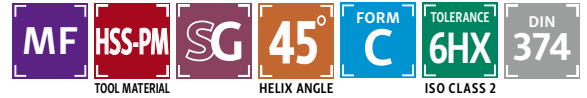
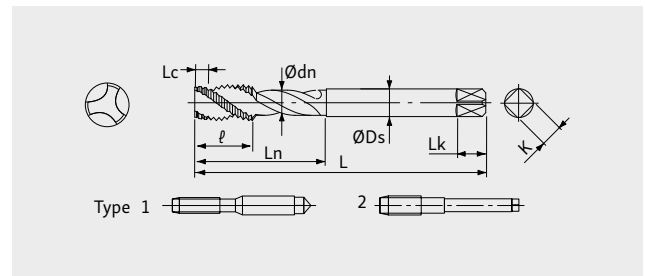


# SGSP – DIN Spiral Tap

## Metric fine

- ▶ 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	dn	Shank Ø	Square Width	Square Length	Z	Type	DIN	Stock	
		Lc	L	ℓ			Ln	K					LK
6	0.75	2.5P	80	9.2	24.5	5.05	4.5	3.4	6	3	2*	374	●
8	0.75	2.5P	80	9.2	24.5	7.05	6.0	4.9	8	3	2	374	●
8	1	2.5P	90	12.4	27	6.75	6.0	4.9	8	3	2	374	●
10	0.75	2.5P	90	9.2	24.5	9.05	7	5.5	8	3	2	374	●
10	1	2.5P	90	12.4	27	8.75	7.0	5.5	8	3	2	374	●
10	1.25	2.5P	100	15.7	33	8.55	7.0	5.5	8	3	2	374	●
12	1	2.5P	100	13.5	33	10.75	9.0	7.0	10	3	2	374	●
12	1.25	2.5P	100	17.2	35	10.55	9.0	7.0	10	3	2	374	●
12	1.5	2.5P	100	20.9	40	10.25	9.0	7.0	10	3	2	374	●
14	1	2.5P	100	13.5	32.5	12.75	11	9	12	3	2	374	●
14	1.25	2.5P	100	17.2	34.5	12.55	11	9	12	3	2	374	●
14	1.5	2.5P	100	20.9	40	12.25	11.0	9.0	12	3	2	374	●
16	1	2.5P	100	13.5	32.5	14.75	12	9	12	3	2	374	●
16	1.5	2.5P	100	20.9	40	14.25	12.0	9.0	12	3	2	374	●
18	1	2.5P	110	13.5	32.5	16.75	14	11	14	4	2	374	●
18	1.5	2.5P	110	20.9	40	16.25	14.0	11.0	14	4	2	374	●
20	1	2.5P	125	13.5	32.5	18.75	16	12	15	4	2	374	●
20	1.5	2.5P	125	20.9	40	18.25	16.0	12.0	15	4	2	374	●
20	2	2.5P	140	29	48.5	17.65	16	12	15	4	2	374	●
22	1	2.5P	125	13.5	32.5	20.75	18	14.5	17	4	2	374	●
22	1.5	2.5P	125	20.9	40	20.25	18	14.5	17	4	2	374	●
22	2	2.5P	140	29	48.5	19.65	18	14.5	17	4	2	374	●
24	1	2.5P	140	14.7	36.5	22.75	18	14.5	17	4	2	374	●
24	1.5	2.5P	140	22.4	49.5	22.25	18	14.5	17	4	2	374	●
24	2	2.5P	140	30.8	53	21.65	18	14.5	17	4	2	374	●

\* With 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.

