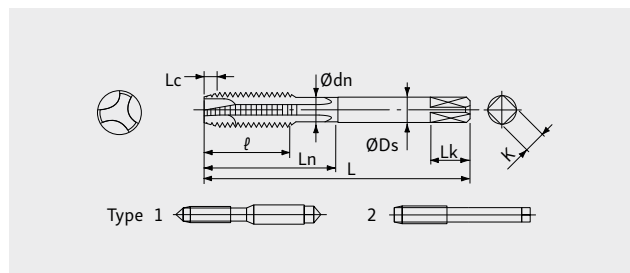


SGPO – DIN Point Tap Metric fine

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



LIST: 6808

M	Pitch	Pitch Chamfer	OAL	Thread Length			Shank Ø	Square Width	Square Length	Z	Type	DIN	Stock
		Lc	L	ℓ	Ln	dn	Ds	K	LK				
6	0.75	5P	80	14	-	-	4.5	3.4	6	3	2*	374	●
8	0.75	5P	80	14	-	-	6.0	4.9	8	3	2	374	●
8	1	5P	90	17	-	-	6.0	4.9	8	3	2	374	●
9	1	5P	90	17	-	-	7	5.5	8	3	2	374	●
10	0.75	5P	90	14	-	-	7	5.5	8	3	2	374	●
10	1	5P	90	17	-	-	7.0	5.5	8	3	2	374	●
10	1.25	5P	100	22	-	-	7.0	5.5	8	3	2	374	●
11	1	5P	90	17	-	-	8	6.2	9	3	2	374	●
12	1	5P	100	19	-	-	9.0	7.0	10	3	2	374	●
12	1.25	5P	100	22	-	-	9.0	7.0	10	3	2	374	●
12	1.5	5P	100	22	-	-	9.0	7.0	10	3	2	374	●
14	1	5P	100	19	-	-	11	9	12	3	2	374	●
14	1.25	5P	100	23	-	-	11	9	12	3	2	374	●
14	1.5	5P	100	22	-	-	11.0	9.0	12	3	2	374	●
16	1	5P	100	19	-	-	12	9	12	3	2	374	●
16	1.5	5P	100	22	-	-	12.0	9.0	12	3	2	374	●
18	1	5P	110	19	-	-	14	11	14	3	2	374	●
18	1.5	5P	110	25	-	-	14.0	11.0	14	3	2	374	●
20	1	5P	125	19	-	-	16	12	15	3	2	374	●
20	1.5	5P	125	25	-	-	16.0	12.0	15	3	2	374	●
20	2	5P	140	32	-	-	16	12	15	3	2	374	●
22	1	5P	125	19	-	-	18	14.5	17	3	2	374	●
22	1.5	5P	125	28	-	-	18	14.5	17	3	2	374	●
22	2	5P	140	32	-	-	18	14.5	17	3	2	374	●
24	1	5P	140	20	-	-	18	14.5	17	3	2	374	●
24	1.5	5P	140	31	-	-	18	14.5	17	3	2	374	●
24	2	5P	140	33	-	-	18	14.5	17	3	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.

