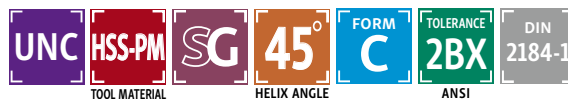
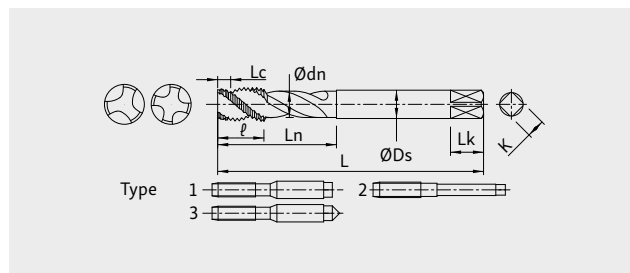


SGSP- DIN Spiral Tap UNC / UNF

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



LIST: 6807

UNC	Pitch	Pitch Chamfer	OAL	Thread Length			Shank Ø	Square Width	Square Length	Z	Type	DIN	Stock
		Lc	L	ℓ	Ln	dn	Ds	K	LK				
No. 6	32	2.5P	56	9.5	20.0	2.55	4	3	6	3	3	2184-1	●
No. 8	32	2.5P	63	9.5	21.0	3.15	4.5	3.4	6	3	3	2184-1	●
No. 10	24	2.5P	70	12.6	25.0	3.55	6	4.9	8	3	3	2184-1	●
No. 12	24	2.5P	80	12.6	30.0	4.25	6	4.9	8	3	3	2184-1	●
1/4	20	2.5P	80	15.4	30.0	4.85	7	5.5	8	3	3	2184-1	●
5/16	18	2.5P	90	17.7	35.0	6.25	8	6.2	9	3	1	2184-1	●
3/8	16	2.5P	100	19.9	39.0	7.65	10	8	11	3	1	2184-1	●
7/16	14	2.5P	100	22.7	-	9.05	8	6.2	9	3	2	2184-1	●
1/2	13	2.5P	110	26.0	-	10.45	9	7	10	3	2	2184-1	●
5/8	11	2.5P	110	30.1	-	13.25	11	9	12	3	2	2184-1	●
3/4	10	2.5P	125	33.1	-	16.15	12	9	12	4	2	2184-1	●
1	8	2.5P	160	38.0	-	21.85	18	14.5	17	4	2	2184-1	●



LIST: 6807

UNF	Pitch	Pitch Chamfer	OAL	Thread Length			Shank Ø	Square Width	Square Length	Z	Type	DIN	Stock
		Lc	L	ℓ	Ln	dn	Ds	K	LK				
No. 10	32	2.5P	70	9.5	25.0	3.85	6	4.9	8	3	3	2184-1	●
1/4	28	2.5P	80	10.5	30.0	5.25	7	5.5	8	3	3	2184-1	●
5/16	24	2.5P	90	12.2	35.0	6.65	8	6.2	9	3	1	2184-1	●
3/8	24	2.5P	90	12.2	35.0	8.25	10	8	11	3	1	2184-1	●
7/16	20	2.5P	100	15.9	-	9.65	8	6.2	9	3	2	2184-1	●
1/2	20	2.5P	100	16.4	-	11.15	9	7	10	3	2	2184-1	●
5/8	18	2.5P	100	18.6	-	14.25	12	9	12	3	2	2184-1	●
3/4	16	2.5P	110	21.0	-	17.15	14	11	14	4	2	2184-1	●

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.

