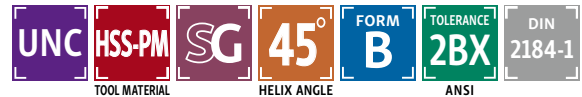
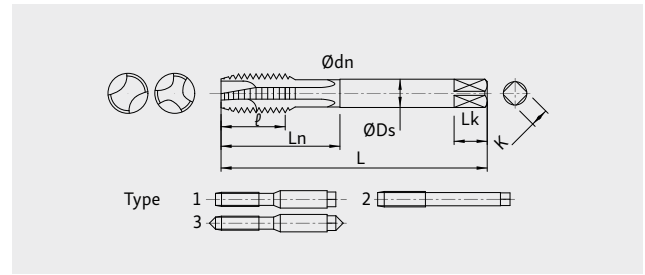


SGPO – DIN Point Tap

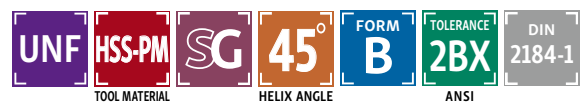
UNC / UNF

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



LIST: 6809

UNC	Pitch	Pitch Chamfer	OAL	Thread Length			Shank Ø	Square Width	Square Length	Z	Type	DIN	Stock
		Lc	L	ℓ			Ln	dn	Ds				
No. 6	32	5.0 P	56	12.0	20.0	2.55	4	3	6	3	3	2184-1	●
No. 8	32	5.0 P	63	13.0	21.0	3.15	4.5	3.4	6	3	3	2184-1	●
No. 10	24	5.0 P	70	16.0	25.0	3.55	6	4.9	8	3	3	2184-1	●
No. 12	24	5.0 P	80	17.0	30.0	4.25	6	4.9	8	3	3	2184-1	●
1/4	20	5.0 P	80	19.0	30.0	4.85	7	5.5	8	3	3	2184-1	●
5/16	18	5.0 P	90	22.0	35.0	6.25	8	6.2	9	3	1	2184-1	●
3/8	16	5.0 P	100	24.0	39.0	7.65	10	8	11	3	1	2184-1	●
7/16	14	5.0 P	100	24.0	-	-	8	6.2	9	3	2	2184-1	●
1/2	13	5.0 P	110	28.0	-	-	9	7	10	3	2	2184-1	●
5/8	11	5.0 P	110	30.0	-	-	11	9	12	3	2	2184-1	●
3/4	10	5.0 P	125	33.0	-	-	12	9	12	3	2	2184-1	●
1	8	5.0 P	160	38.0	-	-	18	14.5	17	3	2	2184-1	●



LIST: 6809

UNF	Pitch	Pitch Chamfer	OAL	Thread Length			Shank Ø	Square Width	Square Length	Z	Type	DIN	Stock
		Lc	L	ℓ			Ln	dn	Ds				
No. 10	32	5.0 P	70	12.0	25.0	3.55	6	4.9	8	3	3	2184-1	●
1/4	28	5.0 P	80	14.0	30.0	4.85	7	5.5	8	3	3	2184-1	●
5/16	24	5.0 P	90	18.0	35.0	6.25	8	6.2	9	3	1	2184-1	●
3/8	24	5.0 P	90	18.0	35.0	7.65	10	8	11	3	1	2184-1	●
7/16	20	5.0 P	100	22.9	-	-	8	6.2	9	3	2	2184-1	●
1/2	20	5.0 P	100	22.0	-	-	9	7	10	3	2	2184-1	●
5/8	18	5.0 P	100	21.2	-	-	12	9	12	3	2	2184-1	●
3/4	16	5.0 P	110	23.8	-	-	14	11	14	3	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.

