HSS

Leading Through Innovation

PIPE TAPS
GASGEWINDEBOHRER

- Tapping Whitworth Pipe threads
- Zum Gewindeschneiden von Whitworth - Rohrgewinde

PIPE TAPS
Tapping Whitworth Pipe threads

PIPE TAPS

EDP No.	MODEL	Tool Material	Standard	Work Material	Dimensions	Tolerance	Chamfer	Thread Depth	Surface Trea tment	PAGE
T7709		HSS	G(BSP)	**GS**	DIN 5157	-	I / III	2.0D	Bright	**653**
TC727		HSS-E	G(BSP)	**GS**	DIN 5156	-	B	3.0D	Bright	**654**
TC728		HSS-E	G(BSP)	**GS**	DIN 5156	-	C	2.5D	Bright	**655**
TC729		HSS-E	G(BSP)	**VG**	DIN 5156	-	C	2.5D	Bright	**656**
TB514		HSS-E	G(BSP)	**VA NW**	DIN 5156	-	C	2.5D	Vap	**657**

PIPE TAPS

T7709 SERIES

G(BSP)

Whitworth Pipe threads DIN ISO 228/1

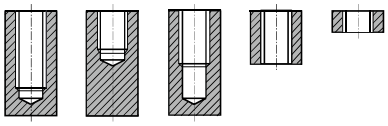
Whitworth Rohrgewinde DIN ISO 228/1
G(BSP) PROFIL 55° DIN ISO 228/1
Filettatura Whitworth per tubi DIN ISO 228/1

- Serial hand tap set in First and Bottoming.
- Bottoming tap of set has final internal thread dimensions only.
- Handgewindebohrersatz mit Vor- und Fertigschneider.
- Nur der Fertigschneider kann das gewünschte Gewinde schneiden.


First

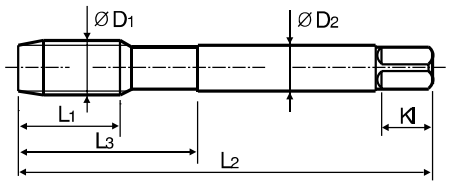

Bottoming

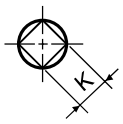
Hole type
2.0×D

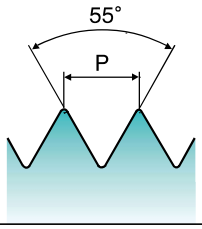


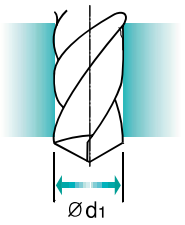
Material groups **GS** | HSS | DIN 5157 | 55° | I/III | Bright

Sets of taps
Gewindebohrer-Satz









Unit : mm

SIZE ØD1	TPI	EDP No. Bright	Thread Length L1	Overall Length L2	Neck Length L3	Shank Diameter ØD2	Square Size K	Square Length Kl	No. of Flute Z	Tapping Drill Diameter Ød1
G1/16	- 28	T7709029	22	56	26	6	4.9	8	3	6.8
G1/8	- 28	T7709209	20	63	27	7	5.5	8	4	8.8
G1/4	- 19	T7709409	22	70	32	11	9	12	4	11.8
G3/8	- 19	T7709489	22	70	32	12	9	12	4	15.25
G1/2	- 14	T7709569	22	80	35	16	12	15	4	19
G3/4	- 14	T7709709	22	90	40	20	16	19	4	24.5
G1	- 11	T7709789	25	100	45	25	20	23	6	30.75
G1-1/4	- 11	T7709869	40	125	77	32	24	27	6	39.5
G1-1/2	- 11	T7709949	40	140	85	36	29	32	6	45.2

PIPE TAPS

TC727 SERIES

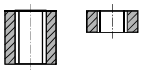
G(BSP) Whitworth Pipe threads DIN ISO 228/1

Whitworth Rohrgewinde DIN ISO 228/1
G(BSP) PROFIL 55° DIN ISO 228/1
Filettatura Whitworth per tubi DIN ISO 228/1

▶ Suitable for through hole in more cutting speed than other taps due to strong geometry.

▶ Geeignet für Sacklöcher in höherer Schnittgeschwindigkeit als andere Gewindebohrer dank einer stabilen Bohrergeometrie.

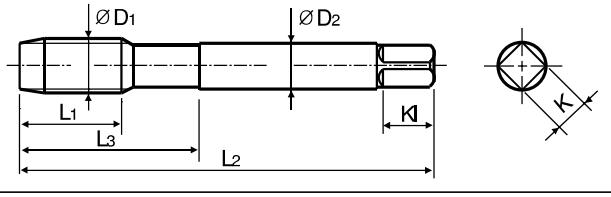
Hole type
3.0×D

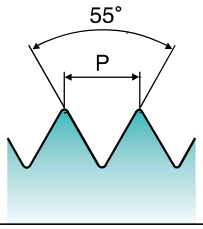


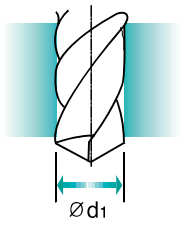
DIN 5156

Material groups **GS** | HSS-E | DIN 5156 | 55° | B | Bright

Machine taps
Maschinengewindebohrer







Unit : mm

SIZE ØD1	TPI	EDP No. Bright	Thread Length L1	Overall Length L2	Neck Length L3	Shank Diameter ØD2	Square Size K	Square Length Kl	No. of Flute Z	Tapping Drill Diameter Ød1
G1/8 -	28	TC727200	20	90	36	7	5.5	8	3	8.8
G1/4 -	19	TC727400	22	100	40	11	9	12	3	11.8
G3/8 -	19	TC727480	22	100	40	12	9	12	3	15.25
G1/2 -	14	TC727560	25	125	50	16	12	15	4	19
G3/4 -	14	TC727700	28	140	54	20	16	19	4	24.5
G1 -	11	TC727780	30	160	60	25	20	23	4	30.75

Unit : N/mm²

◎ : Excellent ○ : Good

Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
	◎	◎	◎								◎	◎	○	

Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Al Si≤10%	Al Si>10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
	○			○		◎		○	○	○	◎	○		

PIPE TAPS

TC728 SERIES

G(BSP)

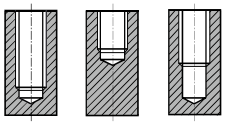
Whitworth pipe threads DIN ISO 228/1

Whitworth Rohrgewinde DIN ISO 228/1
G(BSP) PROFIL 55° DIN ISO 228/1
Filettatura Whitworth per tubi DIN ISO 228/1

▶ Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

▶ Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

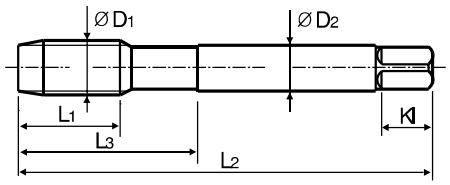
Hole type
2.5×D

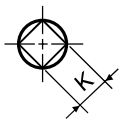


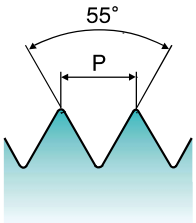
DIN 5156

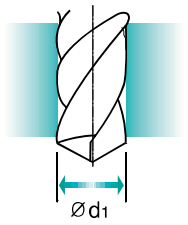
Material groups **GS** | HSS-E | DIN 5156 | 55° | C | Bright | R40

Machine taps
Maschinengewindebohrer









Unit : mm

SIZE ØD1	TPI	EDP No. Bright	Thread Length L1	Overall Length L2	Neck Length L3	Shank Diameter ØD2	Square Size K	Square Length Kl	No. of Flute Z	Tapping Drill Diameter Ød1
G1/8 -	28	TC728200	20	90	36	7	5.5	8	3	8.8
G1/4 -	19	TC728400	22	100	40	11	9	12	3	11.8
G3/8 -	19	TC728480	22	100	40	12	9	12	3	15.25
G1/2 -	14	TC728560	25	125	50	16	12	15	4	19
G3/4 -	14	TC728700	28	140	54	20	16	19	4	24.5
G1 -	11	TC728780	30	160	60	25	20	23	4	30.75

Unit : N/mm²

◎ : Excellent ○ : Good

Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
	◎	◎	◎								◎	◎	○	

Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Al Si ≤ 10%	Al Si>10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
	○			○		◎		○	○	○	◎	○		

PIPE TAPS

TC729 SERIES

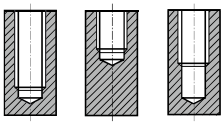
G(BSP) Whitworth pipe threads DIN ISO 228/1

Whitworth Rohrgewinde DIN ISO 228/1
G(BSP) PROFIL 55° DIN ISO 228/1
Filettatura Whitworth per tubi DIN ISO 228/1

▶ Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

▶ Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

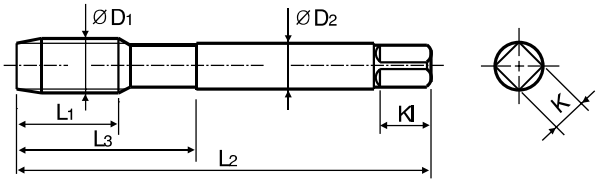
Hole type
2.5×D

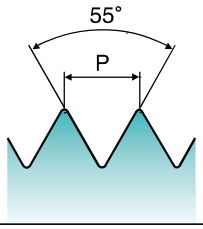


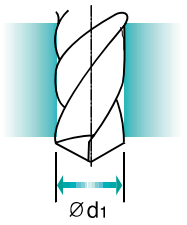
DIN 5156

Material groups VG | HSS-E | DIN 5156 | 55° | C | Bright | R40

Machine taps
Maschinengewindebohrer







Unit : mm

SIZE ØD1	TPI	EDP No. Bright	Thread Length L1	Overall Length L2	Neck Length L3	Shank Diameter ØD2	Square Size K	Square Length Kl	No. of Flute Z	Tapping Drill Diameter Ød1
G1/8 -	28	TC729200	20	90	36	7	5.5	8	3	8.8
G1/4 -	19	TC729400	22	100	40	11	9	12	3	11.8
G3/8 -	19	TC729480	22	100	40	12	9	12	3	15.25
G1/2 -	14	TC729560	25	125	50	16	12	15	4	19
G3/4 -	14	TC729700	28	140	54	20	16	19	4	24.5
G1 -	11	TC729780	30	160	60	25	20	23	4	30.75

Unit : N/mm²

◎ : Excellent ○ : Good

Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
			○	◎				○						○

Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Al Si≤10%	Al Si>10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
		○												

PIPE TAPS

TB514 SERIES

G(BSP)

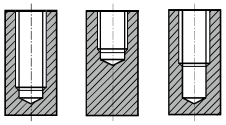
Whitworth pipe threads DIN ISO 228/1

Whitworth Rohrgewinde DIN ISO 228/1
G(BSP) PROFIL 55° DIN ISO 228/1
Filettatura Whitworth per tubi DIN ISO 228/1

▶ Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

▶ Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

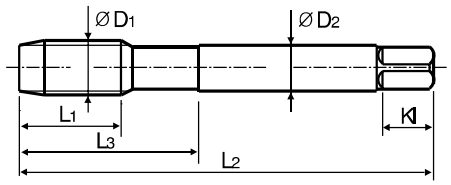
Hole type
2.5×D

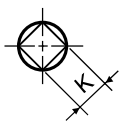


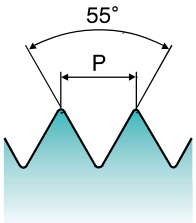
DIN 5156

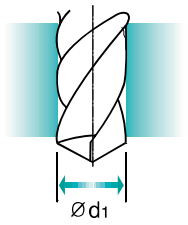
Material groups VA NW | HSS-E | DIN 5156 | 55° | C | Vap | R40

Machine taps
Maschinengewindebohrer









Unit : mm

SIZE	TPI	EDP No.	Thread Length	Overall Length	Neck Length	Shank Diameter	Square Size	Square Length	No. of Flute	Tapping Drill Diameter
ØD1		Vap	L1	L2	L3	ØD2	K	Kl	Z	Ød1
G1/8 -	28	TB514200	20	90	36	7	5.5	8	3	8.8
G1/4 -	19	TB514400	22	100	40	11	9	12	3	11.8
G3/8 -	19	TB514480	22	100	40	12	9	12	3	15.25
G1/2 -	14	TB514560	25	125	50	16	12	15	4	19
G3/4 -	14	TB514700	28	140	54	20	16	19	4	24.5
G1 -	11	TB514780	30	160	60	25	20	23	4	30.75

Unit : N/mm²

◎ : Excellent ○ : Good

Steel < 400	Steel < 700	Steel < 850	St. Alloy < 850	St. Alloy ≤ 1200	St. Alloy > 1200	INOX Free < 850	INOX Aust. < 850	INOX < 1000	GG Cast < 500	GG Cast < 1000	GGG Cast < 700	GGG Cast < 1000	Ti < 700	Ti Alloy < 900
◎	◎					◎	◎	◎						○

Ti Alloy ≤ 1300	Ni < 500	Ni Alloy < 900	Ni Alloy ≤ 1400	Cu < 350	Cu Alloy Short	Cu Alloy Long	Cu-Al-Fe < 1500	Al / Mg < 350	Al Wrought	Al Si≤10%	Al Si>10%	Plastic Thermosoft	Plastic Thermoset	Plastic FRP
		○												

Global Cutting Tool Leader **YG-1**