PIPE TAP

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

Sets of taps
Gewindebohrer-Satz

▶ 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.

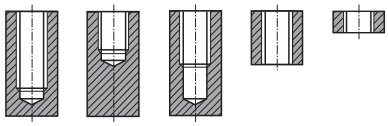
First

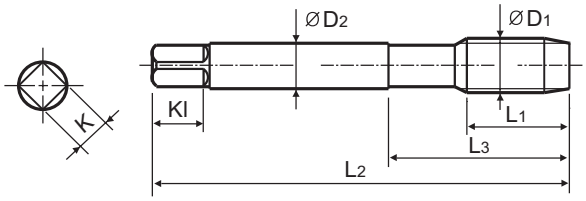


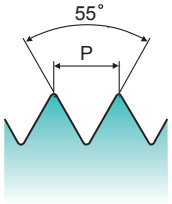
Bottoming

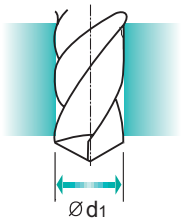


Hole type
2.0×D









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

p.B318

Recommended ToolHolder: Plain Shank, TAPPING ER CHUCK, TAPPING CHUCK, ONE STEP TAPPING CHUCK

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		Bright	L1	L2	L3	ØD2	K	Kl	Z	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

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	○	○	○			○									○	○				

ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended	○	○	○																		