PIPE TAP

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

Machine taps
Maschinengewindebohrer

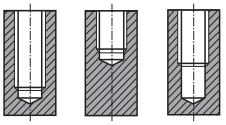
▶ Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

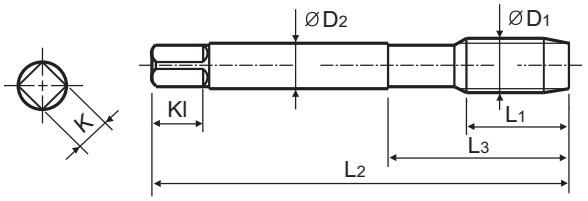
▶ Geeignet zum Gewinden von Sacklöchern dank besonderer Nutengeometrie und ausgezeichneter Spanabfuhr.

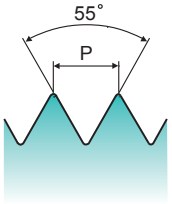
DIN 5156

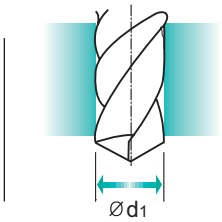


Hole type
2.5×D









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

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		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

◎ : 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																					

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