

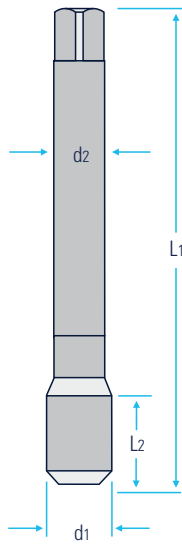
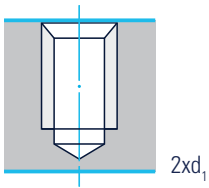


G - Whitworth Pipe Thread DIN ISO 228

Machine Taps

DIN 5156 HSS-E
straight flutes
for general construction steel

Group 550
for blind holes



| | | | | |
|-----------------|--------------------------|--------------------------------|--|--|
| Art.-No. | | 550 | | |
| Technology | Page 7.1 | | | |
| Chamfer Length | Page 7.4 | C / 2-3 x P | | |
| Surface | Page 7.5 | bright | | |
| Tolerance | Page 7.6 | | | |
| Material Groups | Page 7.7 | 1a. general construction steel | | |

| Ød ₁ | P _{tpi} | L ₁ | L ₂ | d ₂ | □ | ⌀ | | | |
|-----------------|------------------|----------------|----------------|----------------|------|------|---|--|--|
| G 1/8" | 28 | 90 | 20 | 7 | 5,5 | 8,7 | ● | | |
| G 1/4" | 19 | 100 | 22 | 11 | 9 | 11,8 | ● | | |
| G 3/8" | 19 | 100 | 22 | 12 | 9 | 15,3 | ● | | |
| G 1/2" | 14 | 125 | 25 | 16 | 12 | 19,0 | ● | | |
| G 5/8" | 14 | 125 | 25 | 18 | 14,5 | 21,0 | ● | | |
| G 3/4" | 14 | 140 | 28 | 20 | 16 | 24,5 | ● | | |
| G 7/8" | 14 | 150 | 28 | 22 | 18 | 28,3 | ● | | |
| G 1" | 11 | 160 | 30 | 25 | 20 | 30,8 | ● | | |
| G 1" 1/4" | 11 | 170 | 30 | 32 | 24 | 39,5 | ● | | |
| G 1" 1/2" | 11 | 190 | 32 | 36 | 29 | 45,3 | ● | | |
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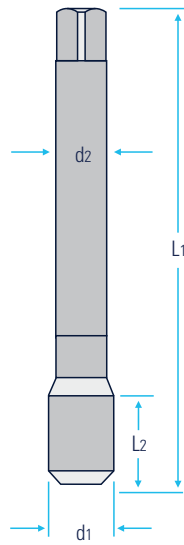
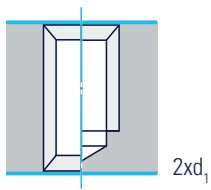


G - Whitworth Pipe Thread DIN ISO 228

Machine Taps White Ring

DIN 5156 HSS-E
straight flutes
for cast iron

Group 553
for blind and through holes



| | | | | |
|-----------------|--------------------------|--------------------|------------------|--|
| Art.-No. | | 553 | | |
| Technology | Page 7.1 | White Ring | | |
| Chamfer Length | Page 7.4 | C / 2-3 x P | | |
| Surface | Page 7.5 | nitrided | | |
| Tolerance | Page 7.6 | | | |
| Material Groups | Page 7.7 | 3a. grey cast iron | 8b. duroplastics | |

| Ød ₁ | P tpi | L ₁ | L ₂ | d ₂ | □ | | | | |
|-----------------|----------|----------------|----------------|----------------|------|------|---|--|--|
| G 1/8" | 28 | 90 | 20 | 7 | 5,5 | 8,7 | ● | | |
| G 1/4" | 19 | 100 | 22 | 11 | 9 | 11,8 | ● | | |
| G 3/8" | 19 | 100 | 22 | 12 | 9 | 15,3 | ● | | |
| G 1/2" | 14 | 125 | 25 | 16 | 12 | 19,0 | ● | | |
| G 5/8" | 14 | 125 | 25 | 18 | 14,5 | 21,0 | | | |
| G 3/4" | 14 | 140 | 28 | 20 | 16 | 24,5 | ● | | |
| G 7/8" | 14 | 150 | 28 | 22 | 18 | 28,3 | ● | | |
| G 1" | 11 | 160 | 30 | 25 | 20 | 30,8 | ● | | |
| G 1" 1/4" | 11 | 170 | 30 | 32 | 24 | 39,5 | ● | | |
| G 1" 1/2" | 11 | 190 | 32 | 36 | 29 | 45,3 | ● | | |
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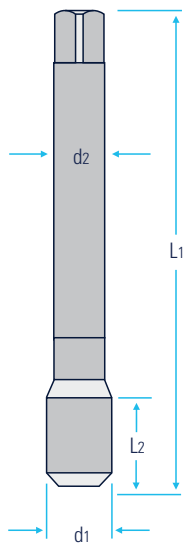
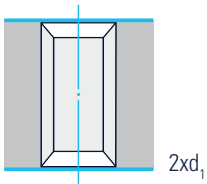


G - Whitworth Pipe Thread DIN ISO 228

Machine Taps

DIN 5156 HSS-E
spiral point
for general construction steel

Group 560
for through holes



| | | | | |
|-----------------|----------|--|--------------------|--|
| Art.-No. | | 560 | 560/25 | |
| Technology | Page 7.1 | High Volume | High Volume | |
| Chamfer Length | Page 7.4 | B / 3,5-5 x P | | |
| Surface | Page 7.5 | bright | TiN | |
| Tolerance | Page 7.6 | | | |
| Material Groups | Page 7.7 | 1a. general construction steel 3b. spheroidal and malleable cast iron | | |

| ϕd_1 | P tpi | L ₁ | L ₂ | d ₂ | □ | 🌀 | | | |
|------------|----------|----------------|----------------|----------------|------|------|---|---|--|
| G 1/8" | 28 | 90 | 20 | 7 | 5,5 | 8,7 | ● | ● | |
| G 1/4" | 19 | 100 | 22 | 11 | 9 | 11,8 | ● | ● | |
| G 3/8" | 19 | 100 | 22 | 12 | 9 | 15,3 | ● | ● | |
| G 1/2" | 14 | 125 | 25 | 16 | 12 | 19,0 | ● | ● | |
| G 5/8" | 14 | 125 | 25 | 18 | 14,5 | 21,0 | ● | ● | |
| G 3/4" | 14 | 140 | 28 | 20 | 16 | 24,5 | ● | ● | |
| G 7/8" | 14 | 150 | 28 | 22 | 18 | 28,3 | ● | ● | |
| G 1" | 11 | 160 | 30 | 25 | 20 | 30,8 | ● | ● | |
| G 1" 1/4" | 11 | 170 | 30 | 32 | 24 | 39,5 | ● | ● | |
| G 1" 1/2" | 11 | 190 | 32 | 36 | 29 | 45,3 | ● | ● | |
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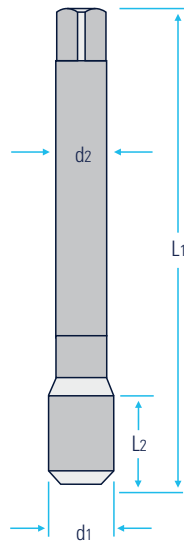
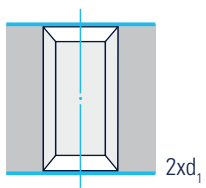


G - Whitworth Pipe Thread DIN ISO 228

Machine Taps
Blue Ring

DIN 5156 HSS-E
spiral point
for chemical resistant steel

Group 562
for through holes



| Art.-No. | | 562 | 562/25 | | | | | | |
|-----------------|------------------|--|----------------|----------------|------|------|---|---|--|
| Technology | Page 7.1 | Blue Ring | Blue Ring | | | | | | |
| Chamfer Length | Page 7.4 | B / 3,5-5 x P | | | | | | | |
| Surface | Page 7.5 | bright | TiN | | | | | | |
| Tolerance | Page 7.6 | | | | | | | | |
| Material Groups | Page 7.7 | 1b. high strength steel 2. chemical resistant steel 4. titanium alloys | | | | | | | |
| Ød ₁ | P _{tpi} | L ₁ | L ₂ | d ₂ | □ | 🌀 | | | |
| G 1/8" | 28 | 90 | 20 | 7 | 5,5 | 8,7 | ● | ● | |
| G 1/4" | 19 | 100 | 22 | 11 | 9 | 11,8 | ● | ● | |
| G 3/8" | 19 | 100 | 22 | 12 | 9 | 15,3 | ● | ● | |
| G 1/2" | 14 | 125 | 25 | 16 | 12 | 19,0 | ● | ● | |
| G 5/8" | 14 | 125 | 25 | 18 | 14,5 | 21,0 | | | |
| G 3/4" | 14 | 140 | 28 | 20 | 16 | 24,5 | ● | ● | |
| G 7/8" | 14 | 150 | 28 | 22 | 18 | 28,3 | | | |
| G 1" | 11 | 160 | 30 | 25 | 20 | 30,8 | ● | ● | |
| G 1" 1/4" | 11 | 170 | 30 | 32 | 24 | 39,5 | | | |
| G 1" 1/2" | 11 | 190 | 32 | 36 | 29 | 45,3 | | | |
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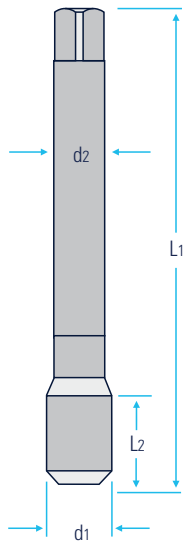
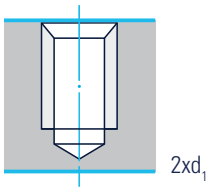


G - Whitworth Pipe Thread DIN ISO 228

Machine Taps

DIN 5156 HSS-E
RH spiral flutes 15°
for general construction steel

Group 570
for blind holes



| | | | | |
|-----------------|--------------------------|---|--|--|
| Art.-No. | | 570 | | |
| Technology | Page 7.1 | | | |
| Chamfer Length | Page 7.4 | C / 2-3 x P | | |
| Surface | Page 7.5 | bright | | |
| Tolerance | Page 7.6 | | | |
| Material Groups | Page 7.7 | 1a. general construction steel 3b. spheroidal and malleable cast iron | | |

| Ød ₁ | P tpi | L ₁ | L ₂ | d ₂ | □ | | | | |
|-----------------|----------|----------------|----------------|----------------|------|------|---|--|--|
| G 1/8" | 28 | 90 | 20 | 7 | 5,5 | 8,7 | ● | | |
| G 1/4" | 19 | 100 | 22 | 11 | 9 | 11,8 | ● | | |
| G 3/8" | 19 | 100 | 22 | 12 | 9 | 15,3 | ● | | |
| G 1/2" | 14 | 125 | 25 | 16 | 12 | 19,0 | ● | | |
| G 5/8" | 14 | 125 | 25 | 18 | 14,5 | 21,0 | | | |
| G 3/4" | 14 | 140 | 28 | 20 | 16 | 24,5 | ● | | |
| G 7/8" | 14 | 150 | 28 | 22 | 18 | 28,3 | | | |
| G 1" | 11 | 160 | 30 | 25 | 20 | 30,8 | ● | | |
| G 1" 1/4" | 11 | 170 | 30 | 32 | 24 | 39,5 | ● | | |
| G 1" 1/2" | 11 | 190 | 32 | 36 | 29 | 45,3 | ● | | |
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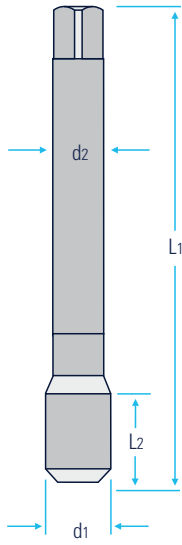
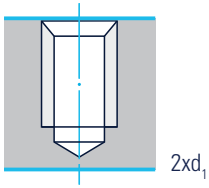


G - Whitworth Pipe Thread DIN ISO 228

Machine Taps

DIN 5156 HSS-E
RH spiral flutes 40°
for general construction steel

Group 580
for blind holes



| | | | | |
|-----------------|----------------------------|---|--------------------|--|
| Art.-No. | | 580 | 580/25 | |
| Technology | i Page 7.1 | High Volume | High Volume | |
| Chamfer Length | i Page 7.4 | C / 2-3 x P | | |
| Surface | i Page 7.5 | bright | TiN | |
| Tolerance | i Page 7.6 | | | |
| Material Groups | i Page 7.7 | 1a. general construction steel 3b. spheroidal and malleable cast iron | | |

| Ød ₁ | P tpi | L ₁ | L ₂ | d ₂ | □ | | | |
|-----------------|----------|----------------|----------------|----------------|------|------|---|---|
| G 1/8" | 28 | 90 | 20 | 7 | 5,5 | 8,7 | ● | ● |
| G 1/4" | 19 | 100 | 22 | 11 | 9 | 11,8 | ● | ● |
| G 3/8" | 19 | 100 | 22 | 12 | 9 | 15,3 | ● | ● |
| G 1/2" | 14 | 125 | 25 | 16 | 12 | 19,0 | ● | ● |
| G 5/8" | 14 | 125 | 25 | 18 | 14,5 | 21,0 | ● | ● |
| G 3/4" | 14 | 140 | 28 | 20 | 16 | 24,5 | ● | ● |
| G 7/8" | 14 | 150 | 28 | 22 | 18 | 28,3 | ● | ● |
| G 1" | 11 | 160 | 30 | 25 | 20 | 30,8 | ● | ● |
| G 1 1/4" | 11 | 170 | 30 | 32 | 24 | 39,5 | ● | ● |
| G 1 1/2" | 11 | 190 | 32 | 36 | 29 | 45,3 | ● | ● |
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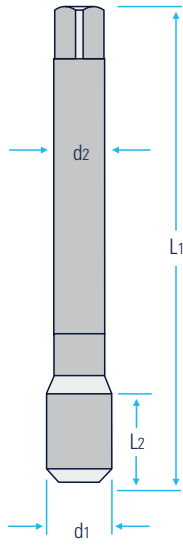
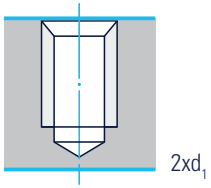


G - Whitworth Pipe Thread DIN ISO 228

Machine Taps
Blue Ring

DIN 5156 HSS-E
RH spiral flutes 40°
for chemical resistant steel

Group 585
for blind holes



| | | | | |
|-----------------|--------------------------|--|-----------|--|
| Art.-No. | | 585 | 585/25 | |
| Technology | Page 7.1 | Blue Ring | Blue Ring | |
| Chamfer Length | Page 7.4 | C / 2-3 x P | | |
| Surface | Page 7.5 | bright | TiN | |
| Tolerance | Page 7.6 | | | |
| Material Groups | Page 7.7 | 1b. high strength steel 2. chemical resistant steel 4. titanium alloys | | |

| Ød ₁ | P _{tpi} | L ₁ | L ₂ | d ₂ | □ | 🌀 | | | |
|-----------------|------------------|----------------|----------------|----------------|------|------|---|---|--|
| G 1/8" | 28 | 90 | 20 | 7 | 5,5 | 8,7 | ● | ● | |
| G 1/4" | 19 | 100 | 22 | 11 | 9 | 11,8 | ● | ● | |
| G 3/8" | 19 | 100 | 22 | 12 | 9 | 15,3 | ● | ● | |
| G 1/2" | 14 | 125 | 25 | 16 | 12 | 19,0 | ● | ● | |
| G 5/8" | 14 | 125 | 25 | 18 | 14,5 | 21,0 | ● | ● | |
| G 3/4" | 14 | 140 | 28 | 20 | 16 | 24,5 | ● | ● | |
| G 7/8" | 14 | 150 | 28 | 22 | 18 | 28,3 | | | |
| G 1" | 11 | 160 | 30 | 25 | 20 | 30,8 | ● | ● | |
| G 1" 1/4" | 11 | 170 | 30 | 32 | 24 | 39,5 | | | |
| G 1" 1/2" | 11 | 190 | 32 | 36 | 29 | 45,3 | | | |
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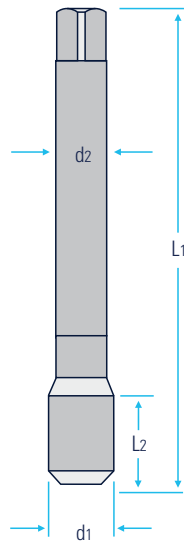
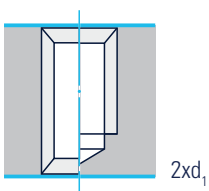


G - Whitworth Pipe Thread DIN ISO 228

Short Machine Taps

DIN 5157 HSS-E
straight flutes
for copper alloys

Group 135
for blind and through holes



| | | | | |
|-----------------|--------------------------|------------------|--|--|
| Art.-No. | | 135 | | |
| Technology | Page 7.1 | | | |
| Chamfer Length | Page 7.4 | E / 1,5-2 x P | | |
| Surface | Page 7.5 | bright | | |
| Tolerance | Page 7.6 | | | |
| Material Groups | Page 7.7 | 6. copper alloys | | |

| Ød ₁ | P tpi | L ₁ | L ₂ | d ₂ | □ | ⌀ | | | | |
|-----------------|----------|----------------|----------------|----------------|------|------|---|--|--|--|
| G 1/8" | 28 | 63 | 18 | 7 | 5,5 | 8,7 | ● | | | |
| G 1/4" | 19 | 70 | 20 | 11 | 9 | 11,8 | ● | | | |
| G 3/8" | 19 | 70 | 22 | 12 | 9 | 15,3 | ● | | | |
| G 1/2" | 14 | 80 | 22 | 16 | 12 | 19,0 | ● | | | |
| G 5/8" | 14 | 80 | 22 | 18 | 14,5 | 21,0 | ● | | | |
| G 3/4" | 14 | 90 | 22 | 20 | 16 | 24,5 | ● | | | |
| G 7/8" | 14 | 90 | 22 | 22 | 18 | 28,3 | ● | | | |
| G 1" | 11 | 100 | 25 | 25 | 20 | 30,8 | ● | | | |
| G 1 1/8" | 11 | 125 | 30 | 28 | 22 | 35,5 | ● | | | |
| G 1 1/4" | 11 | 125 | 30 | 32 | 24 | 39,5 | ● | | | |
| G 1 3/8" | 11 | 125 | 30 | 36 | 29 | 41,7 | ● | | | |
| G 1 1/2" | 11 | 140 | 30 | 36 | 29 | 45,3 | ● | | | |
| G 1 3/4" | 11 | 140 | 36 | 40 | 32 | 51,0 | | | | |
| G 2" | 11 | 160 | 36 | 45 | 35 | 57,0 | | | | |
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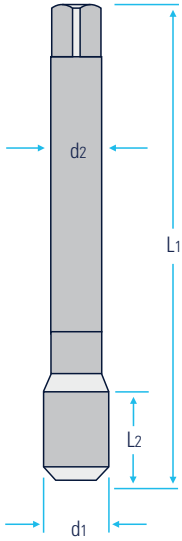
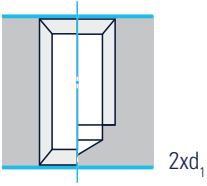


G - Whitworth Pipe Thread DIN ISO 228

Short Machine Taps

DIN 5157 HSS-E
straight flutes
for cast iron

Group 136
for blind and through holes



| | | | | |
|-----------------|--------------------------|-------------------------------------|--|--|
| Art.-No. | | 136 | | |
| Technology | Page 7.1 | | | |
| Chamfer Length | Page 7.4 | C / 2-3 x P | | |
| Surface | Page 7.5 | nitrided | | |
| Tolerance | Page 7.6 | | | |
| Material Groups | Page 7.7 | 3a. grey cast iron 8b. duroplastics | | |

| $\varnothing d_1$ | P tpi | L ₁ | L ₂ | d ₂ | □ | 🌀 | | | |
|-------------------|----------|----------------|----------------|----------------|------|------|---|--|--|
| G 1/8" | 28 | 63 | 18 | 7 | 5,5 | 8,7 | ● | | |
| G 1/4" | 19 | 70 | 20 | 11 | 9 | 11,8 | ● | | |
| G 3/8" | 19 | 70 | 22 | 12 | 9 | 15,3 | ● | | |
| G 1/2" | 14 | 80 | 22 | 16 | 12 | 19,0 | ● | | |
| G 5/8" | 14 | 80 | 22 | 18 | 14,5 | 21,0 | ● | | |
| G 3/4" | 14 | 90 | 22 | 20 | 16 | 24,5 | ● | | |
| G 7/8" | 14 | 90 | 22 | 22 | 18 | 28,3 | ● | | |
| G 1" | 11 | 100 | 25 | 25 | 20 | 30,8 | ● | | |
| G 1 1/8" | 11 | 125 | 30 | 28 | 22 | 35,5 | ● | | |
| G 1 1/4" | 11 | 125 | 30 | 32 | 24 | 39,5 | ● | | |
| G 1 3/8" | 11 | 125 | 30 | 36 | 29 | 41,7 | ● | | |
| G 1 1/2" | 11 | 140 | 30 | 36 | 29 | 45,3 | ● | | |
| G 1 3/4" | 11 | 140 | 36 | 40 | 32 | 51,0 | | | |
| G 2" | 11 | 160 | 36 | 45 | 35 | 57,0 | | | |
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