



# 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

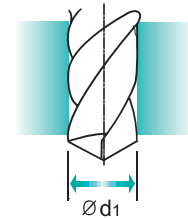
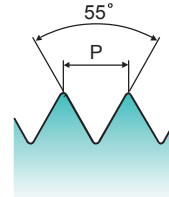
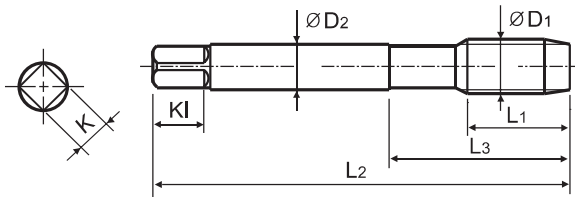
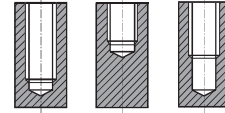
► Suitable for tapping blind holes due to special flute geometry and excellent chip evacuation.

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

DIN 5156



Hole type  
2.5×D



Machine taps  
Maschinengewindebohrer

Recommended Cutting Page : P.306

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	KI	Z	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

◎ : Excellent ○ : Good

ISO	P										M				K					
	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			
	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	400Rm	1050Rm	550	630	400	550
Recommended	○	○	○	○	◎	◎		○													



**RECOMMENDED CUTTING CONDITIONS**  
**EMPFOHLENE SCHNEIDKONDITIONEN**

THREAD MILLS

SYNCHRO TAPS

COMBO TAPS

YG TAP GENERAL

YG TAP STEEL

YG TAP HARDENED

YG TAP INOX

YG TAP CAST IRON

YG TAP ALU

YG TAP Ti Ni

YG TAP FORMING

NUT TAPS

STI TAPS

PIPE TAPS

TECHNICAL DATA

					TC728	TC729	TB514	TC727
ISO	VDI 3323	Material Description	HB	HRC	Vc (m/min)			
P	1	Non-alloy steel	125				15-20	
	2		190	13	15-20		15-20	15-20
	3		250	25	12-18			12-18
	4		270	28	10-15			10-15
	5		300	32				
	6	Low alloy steel	180	10	10-15	10-15		10-15
	7		275	29	10-15	10-15		10-15
	8		300	32		6-10		
	9		350	38		3-5		
	10		High alloyed steel, and tool steel	200	15			
	11	325		35				
M	12	Stainless steel	200	15			7-10	
	13		240	23			5-8	
	14		180	10		4-6	4-6	
K	15	Grey cast iron	180	10				
	16		260	26				
	17	Nodular cast iron	160	3	10-15			10-15
	18		250	25	5-8			5-8
	19		130					
20	Malleable cast iron	230	21					
N	21	Aluminum-wrought alloy	60		10-15			10-15
	22		100		10-15			10-15
	23	Aluminum-cast, alloyed	75		15-20			15-20
	24		90		15-20			15-20
	25		130		10-15			10-15
	26		110		25-35			25-35
	27	Copper and Copper Alloys (Bronze / Brass)	90		8-12			8-12
	28		100					
	29		Non Metallic Materials					
	30							
S	31	Heat Resistant Super Alloys	200	15				
	32		280	30				
	33		250	25				
	34		350	38				
	35		320	34				
	36	Titanium Alloys	400 Rm					
	37		1050 Rm					
H	38	Hardened steel	550	55				
	39		630	60				
	40	Chilled Cast Iron	400	42				
	41	Hardened Cast Iron	550	55				