

Whitworth pipe thread G, DIN-ISO 228										HRC40									
 <div style="display: flex; flex-direction: column; gap: 5px;"> <div style="border: 1px solid black; padding: 2px; width: fit-content;">HSSE PM</div> <div style="border: 1px solid black; padding: 2px; width: fit-content;">TC</div> <div style="border: 1px solid black; padding: 2px; width: fit-content;">DIN 5157</div> </div>										KPL/2		F							
Material groups										<div style="display: flex; gap: 5px;"> <div style="border: 1px solid black; padding: 2px;">P</div> <div style="border: 1px solid black; padding: 2px;">M</div> <div style="border: 1px solid black; padding: 2px;">K</div> </div> <div style="display: flex; gap: 5px; margin-top: 2px;"> <div style="border: 1px solid black; padding: 2px;">N</div> <div style="border: 1px solid black; padding: 2px;">S</div> <div style="border: 1px solid black; padding: 2px;">H</div> </div>		<div style="display: flex; gap: 5px;"> <div style="border: 1px solid black; padding: 2px;">P</div> <div style="border: 1px solid black; padding: 2px;">M</div> <div style="border: 1px solid black; padding: 2px;">K</div> </div> <div style="display: flex; gap: 5px; margin-top: 2px;"> <div style="border: 1px solid black; padding: 2px;">N</div> <div style="border: 1px solid black; padding: 2px;">S</div> <div style="border: 1px solid black; padding: 2px;">H</div> </div>							
Hole type										 < 1,5d		 < 1,5d							
Quality of material										HSSE-PM		HSSE-PM							
Coating										TC		TC							
Chamfer												~2P							
										Norm		DIN-5157							
										ToI.									
										INDEX		A4-225D51		A4-202D51					
G-1/8"	9,728	28	0,907	63	18	7,0	5,5	8,80	3123	●	●								
G-1/4"	13,157	19	1,337	70	22	11,0	9,0	11,80	3127	●	●								
G-3/8"	16,662	19	1,337	70	22	12,0	9,0	15,25	3129	●	●								
G-1/2"	20,955	14	1,814	80	22	16,0	12,0	19,00	3131	●	●								



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Taps set HRC40 suitable for hardened steels up to 40HRC
Instruction of proper use HRC40 taps:

1. Maximum threading depth 1,5xD
2. Rigorously respect sequence of tapping procedure for hand taps sets using tap numbers in correct order
3. Please use only high quality cutting fluids (for example TEREBOR distributed by Fanar)
4. Carefully clear each tap from chips before next usage
5. Do not reverse the tap revolution before reach full depth of cut

Taps F suitable for thread shape correction after hardening processor material galvanizing operations
Instruction of proper use F taps:

1. Please clean the threaded hole from mechanical impurities
2. Moisten both the tap and the hole with good quality tapping fluid (for example CIMTAP, TEREBOR or machine oil)
3. Enter tap into a hole by hand and make thread correction
4. Carefully clear each tap from chips before next usage