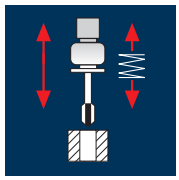
Whitworth pipe thread cylindrical G

G

N° EH1400		08	HSS PM/F		Rm <850	265
N° EH11425	s-tap new!	08	HSS-E Co5		Rm <850	267
N° EA1425	a-tap	08	HSS PM/F+		Rm <850	269
N° EH1472	x-tap	11	HSS PM/F		Rm 850-1100	271
N° EH1475	x-tap	11	HSS PM/F		Rm 850-1100	273
N° EH1482		15	HSS PM/F		Rm 1100-1500	275
N° EH1495		15	HSS PM/F		Rm 1100-1500	277
N° EH6916		60	HM MG10		HRC 48- >60	279
N° ET1440	Inotap	In	HSS PM/F		Inox Stainless	281
N° ET1475	x-tap	In	HSS PM/F		Inox Stainless	283
N° EH1480		GG	HSS PM/F		GG(G) Cast iron	285
N° EI1402		Al	HSS PM/F		Al Aluminium Alloy	Cu Copper 287
N° EI1452		Al	HSS PM/F		Al Aluminium Alloy	Cu Copper 289
N° EH1429	polytap-R	R	HSS PM/F		Rm <850-1100	Inox Stainless 291
N° E11480	u-tap new!	U	HSS-E Co5		Rm <850	293
N° E11482	u-tap new!	U	HSS-E Co5		Rm <850	295

G

Application	Material	G	ø [mm]	P [mm]	v_c 1.5 x d	n [min⁻¹]	v_f [100%]	v_c 2.0 x d	n [min⁻¹]	v_f [100%]	v_c 3.0 x d	n [min⁻¹]	v_f [100%]
	Steel < 500 N/mm²	G 1/8	9.728	0.907	28	915	830	23	755	685	18	590	535
		G 1/4	13.157	1.337	28	675	902	23	555	742	18	435	582
		G 3/8	16.662	1.337	28	535	715	23	440	588	18	345	461
		G 1/2	20.955	1.814	28	425	771	23	350	635	18	275	499
		G 5/8	22.911	1.814	28	390	707	23	320	580	18	250	454
		G 3/4	26.441	1.814	28	335	608	23	275	499	18	215	390
	Steel 500 - 850 N/mm²	G 1/8	9.728	0.907	25	820	744	20	655	594	15	490	444
		G 1/4	13.157	1.337	25	605	809	20	485	648	15	365	488
		G 3/8	16.662	1.337	25	480	642	20	380	508	15	285	381
		G 1/2	20.955	1.814	25	380	689	20	305	553	15	230	417
		G 5/8	22.911	1.814	25	345	626	20	280	508	15	210	381
		G 3/4	26.441	1.814	25	300	544	20	240	435	15	180	327

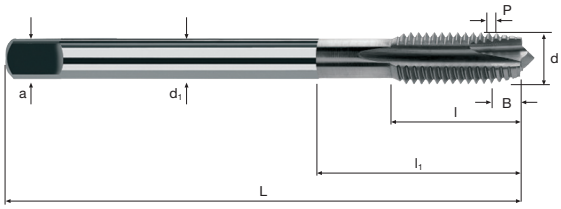
G

55°

HSS
PM/F

DIN
5156

X · P
Form B



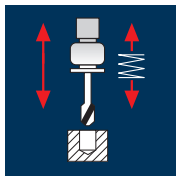
Rm < 850	Rm 850-1100

G

Example:
Order-N°. Article-N°. **EH1400** ø-Code **.551**

ø Code	d	P(TPI)	d (mm)	L	l	l1	d1	a			TiCN EH1400
.551	G 1/8	28	9.728	90	18	35	7	5.5	3	8.80	●
.552	G 1/4	19	13.157	100	20	39	11	9.0	3	11.80	●
.553	G 3/8	19	16.662	100	22	39	12	9.0	4	15.25	●
.554	G 1/2	14	20.955	125	25	50	16	12.0	4	19.00	●
.555	G 5/8	14	22.911	125	25	50	18	14.5	4	21.00	●
.556	G 3/4	14	26.441	140	28	56	20	16.0	4	24.50	●

Application



Material

G	ø [mm]	P [mm]	v_c 1.0 x d	n [min⁻¹]	v_f [100%]	v_c 1.5 x d	n [min⁻¹]	v_f [100%]	v_c 2.0 x d	n [min⁻¹]	v_f [100%]
Steel < 500 N/mm²											
G 1/8	9.728	0.907	25	820	744	20	655	594	18	590	535
G 1/4	13.157	1.337	25	605	809	20	485	648	18	435	582
G 3/8	16.662	1.337	25	480	642	20	380	508	18	345	461
G 1/2	20.955	1.814	25	380	689	20	305	553	18	275	499
G 5/8	22.911	1.814	25	345	626	20	280	508	18	250	454
G 3/4	26.441	1.814	25	300	544	20	240	435	18	215	390
Steel 500 - 850 N/mm²											
G 1/8	9.728	0.907	16	525	476	14	460	417	12	395	358
G 1/4	13.157	1.337	16	385	515	14	340	455	12	290	388
G 3/8	16.662	1.337	16	305	408	14	265	354	12	230	308
G 1/2	20.955	1.814	16	245	444	14	215	390	12	180	327
G 5/8	22.911	1.814	16	220	399	14	195	354	12	165	299
G 3/4	26.441	1.814	16	195	354	14	170	308	12	145	263

G

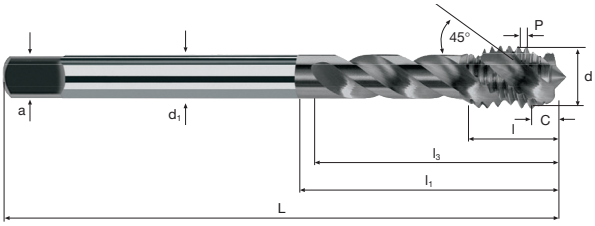
55°

HSS-E Co5

DIN 5156

X · P

Form C



new!

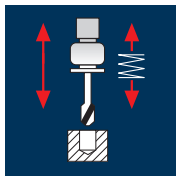
Rm < 850 | **Rm** 850-1100

G

Example:
Order-N°. **EH11425** (Article-N°.) **.551** (ø-Code)

ø Code	d	P(TPI)	d (mm)	L	l	l1	l3	d1	a			TiCN EH11425
.551	G 1/8	28	9.728	90	7.3	35	33	7	5.5	3	8.80	●
.552	G 1/4	19	13.157	100	10.7	39	37	11	9.0	4	11.80	●
.553	G 3/8	19	16.662	100	10.7	39	37	12	9.0	4	15.25	●
.554	G 1/2	14	20.955	125	14.5	65	63	16	12.0	4	19.00	●
.555	G 5/8	14	22.911	125	14.5	65	63	18	14.5	4	21.00	●
.556	G 3/4	14	26.441	140	14.5	72	70	20	16.0	5	24.50	●

Application



Material

G	ø [mm]	P [mm]	v_c 1.0 x d	n [min⁻¹]	v_f [100%]	v_c 1.5 x d	n [min⁻¹]	v_f [100%]	v_c 2.0 x d	n [min⁻¹]	v_f [100%]
Steel < 500 N/mm²											
G 1/8	9.728	0.907	25	820	744	20	655	594	18	590	535
G 1/4	13.157	1.337	25	605	809	20	485	648	18	435	582
G 3/8	16.662	1.337	25	480	642	20	380	508	18	345	461
G 1/2	20.955	1.814	25	380	689	20	305	553	18	275	499
G 5/8	22.911	1.814	25	345	626	20	280	508	18	250	454
G 3/4	26.441	1.814	25	300	544	20	240	435	18	215	390
Steel 500 - 850 N/mm²											
G 1/8	9.728	0.907	16	525	476	14	460	417	12	395	358
G 1/4	13.157	1.337	16	385	515	14	340	455	12	290	388
G 3/8	16.662	1.337	16	305	408	14	265	354	12	230	308
G 1/2	20.955	1.814	16	245	444	14	215	390	12	180	327
G 5/8	22.911	1.814	16	220	399	14	195	354	12	165	299
G 3/4	26.441	1.814	16	195	354	14	170	308	12	145	263

G

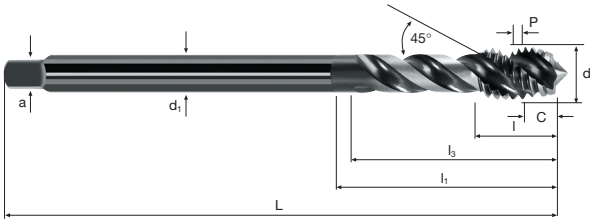
55°

HSS PM/F+

DIN 5156

X · P

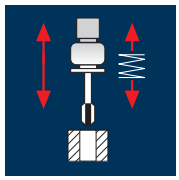
Form C



Rm < 850	Rm 850-1100

Example: **Order-N°.** Article-N°. **EA1425** ø-Code **.551**

ø Code	d	P(TPI)	d (mm)	L	l	l1	l3	d1	a			ADSC
												EA1425
.551	G 1/8	28	9.728	90	7.3	35	33	7	5.5	3	8.80	●
.552	G 1/4	19	13.157	100	10.7	39	37	11	9.0	4	11.80	●
.553	G 3/8	19	16.662	100	10.7	39	37	12	9.0	4	15.25	●
.554	G 1/2	14	20.955	125	14.5	65	63	16	12.0	4	19.00	●
.555	G 5/8	14	22.911	125	14.5	65	63	18	14.5	4	21.00	●
.556	G 3/4	14	26.441	140	14.5	72	70	20	16.0	5	24.50	●

Application	Material	G	ø [mm]	P [mm]	v_c 1.5 x d	n [min⁻¹]	v_f [100%]	v_c 2.0 x d	n [min⁻¹]	v_f [100%]	v_c 3.0 x d	n [min⁻¹]	v_f [100%]
	Steel 500 - 850 N/mm²	G 1/8	9.728	0.907	25	820	744	20	655	594	15	490	444
		G 1/4	13.157	1.337	25	605	809	20	485	648	15	365	488
		G 3/8	16.662	1.337	25	480	642	20	380	508	15	285	381
		G 1/2	20.955	1.814	25	380	689	20	305	553	15	230	417
		G 5/8	22.911	1.814	25	345	626	20	280	508	15	210	381
		G 3/4	26.441	1.814	25	300	544	20	240	435	15	180	327
	Steel 850 - 1100 N/mm²	G 1/8	9.728	0.907	20	655	594	15	490	444	12	395	358
		G 1/4	13.157	1.337	20	485	648	15	365	488	12	290	388
		G 3/8	16.662	1.337	20	380	508	15	285	381	12	230	308
		G 1/2	20.955	1.814	20	305	553	15	230	417	12	180	327
		G 5/8	22.911	1.814	20	280	508	15	210	381	12	165	299
		G 3/4	26.441	1.814	20	240	435	15	180	327	12	145	263
	Steel 1100 - 1300 N/mm²	G 1/8	9.728	0.907	7	230	209	4	130	118			
		G 1/4	13.157	1.337	7	170	227	4	95	127			
		G 3/8	16.662	1.337	7	135	180	4	75	100			
		G 1/2	20.955	1.814	7	105	190	4	60	109			
		G 5/8	22.911	1.814	7	95	172	4	55	100			
		G 3/4	26.441	1.814	7	85	154	4	50	91			

G

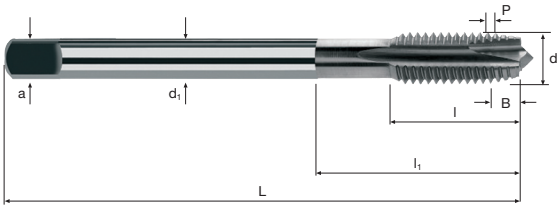
55°

HSS PM/F

DIN 5156

X · P

Form B

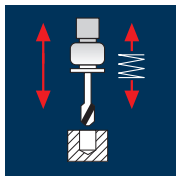


Rm < 850	Rm 850-1100	Rm 1100-1300

Example:
Order-N°. Article-N°. **EH1472** ø-Code **.551**

ø Code	d	P(TPI)	d (mm)	L	l	l1	d1	a			TiCN EH1472
.551	G 1/8	28	9.728	90	18	35	7	5.5	3	8.80	●
.552	G 1/4	19	13.157	100	20	39	11	9.0	3	11.80	●
.553	G 3/8	19	16.662	100	22	39	12	9.0	4	15.25	●
.554	G 1/2	14	20.955	125	25	50	16	12.0	4	19.00	●
.555	G 5/8	14	22.911	125	25	50	18	14.5	4	21.00	●
.556	G 3/4	14	26.441	140	28	56	20	16.0	5	24.50	●

Application



Material

G	ø [mm]	P [mm]	v_c 1.0 x d	n [min⁻¹]	v_f [100%]	v_c 1.5 x d	n [min⁻¹]	v_f [100%]	v_c 2.0 x d	n [min⁻¹]	v_f [100%]
Steel 500 - 850 N/mm²											
G 1/8	9.728	0.907	32	1045	948	28	915	830	22	720	653
G 1/4	13.157	1.337	32	775	1036	28	675	902	22	530	709
G 3/8	16.662	1.337	32	610	816	28	535	715	22	420	562
G 1/2	20.955	1.814	32	485	880	28	425	771	22	335	608
G 5/8	22.911	1.814	32	445	807	28	390	707	22	305	553
G 3/4	26.441	1.814	32	385	698	28	335	608	22	265	481
Steel 850 - 1100 N/mm²											
G 1/8	9.728	0.907	20	655	594	16	525	476	10	325	295
G 1/4	13.157	1.337	20	485	648	16	385	515	10	240	321
G 3/8	16.662	1.337	20	380	508	16	305	408	10	190	254
G 1/2	20.955	1.814	20	305	553	16	245	444	10	150	272
G 5/8	22.911	1.814	20	280	508	16	220	399	10	140	254
G 3/4	26.441	1.814	20	240	435	16	195	354	10	120	218

G

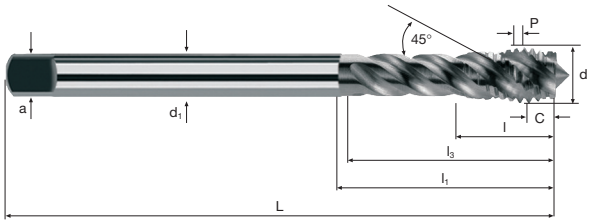
55°

HSS PM/F

DIN 5156

X · P

Form C



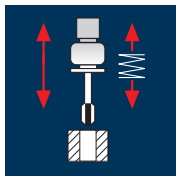
Rm < 850	Rm 850-1100

G

Example:
Order-N°. **EH1475** (Article-N°.) **.551** (ø-Code)

ø Code	d	P(TPI)	d (mm)	L	l	l1	l3	d1	a			TiCN EH1475
.551	G 1/8	28	9.728	90	10	35	33	7	5.5	3	8.80	●
.552	G 1/4	19	13.157	100	14	39	37	11	9.0	4	11.80	●
.553	G 3/8	19	16.662	100	14	39	37	12	9.0	4	15.25	●
.554	G 1/2	14	20.955	125	20	65	63	16	12.0	5	19.00	●
.555	G 5/8	14	22.911	125	20	65	63	18	14.5	5	21.00	●
.556	G 3/4	14	26.441	140	22	72	70	20	16.0	5	24.50	●

Application



Material

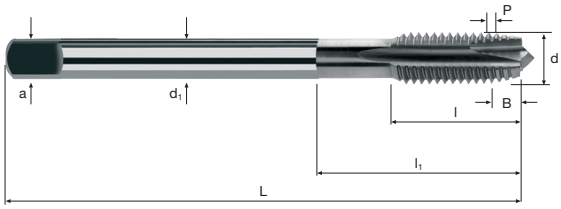
G	ø [mm]	P [mm]	v_c 1.0 x d	n [min⁻¹]	v_f [100%]	v_c 1.5 x d	n [min⁻¹]	v_f [100%]	v_c 2.0 x d	n [min⁻¹]	v_f [100%]
Steel 1100 - 1300 N/mm²											
G 1/8	9.728	0.907	10	325	295	8	260	236	5	165	150
G 1/4	13.157	1.337	10	240	321	8	195	261	5	120	160
G 3/8	16.662	1.337	10	190	254	8	155	207	5	95	127
G 1/2	20.955	1.814	10	150	272	8	120	218	5	75	136
G 5/8	22.911	1.814	10	140	254	8	110	200	5	70	127
G 3/4	26.441	1.814	10	120	218	8	95	172	5	60	109
Steel 1300 - 1500 N/mm²											
G 1/8	9.728	0.907	6	195	177	4	130	118	3	100	91
G 1/4	13.157	1.337	6	145	194	4	95	127	3	75	100
G 3/8	16.662	1.337	6	115	154	4	75	100	3	55	74
G 1/2	20.955	1.814	6	90	163	4	60	109	3	45	82
G 5/8	22.911	1.814	6	85	154	4	55	100	3	40	73
G 3/4	26.441	1.814	6	70	127	4	50	91	3	35	63

G

HSS PM/F

DIN 5156

Form B



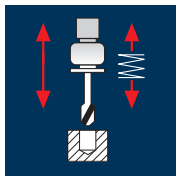
		Rm 1100-1300	Rm 1300-1500						

Example: **Order-N°.** Article-N°. **EH1482** ø-Code **.551**

ø Code	d	P(TPI)	d (mm)	L	l	l1	d1	a			TiCN EH1482
.551	G 1/8	28	9.728	90	18	35	7	5.5	3	8.85 *	●
.552	G 1/4	19	13.157	100	20	39	11	9.0	3	11.90 *	●
.553	G 3/8	19	16.662	100	22	39	12	9.0	4	15.40 *	●
.554	G 1/2	14	20.955	125	25	50	16	12.0	4	19.20 *	●
.555	G 5/8	14	22.911	125	25	50	18	14.5	4	21.10	●
.556	G 3/4	14	26.441	140	28	56	20	16.0	5	24.60	●

* The given dimension is out of norm

Application



Material

Steel
1100 - 1300 N/mm²

G	ø [mm]	P [mm]	v_c 1.0 x d	n [min⁻¹]	v_f [100%]	v_c 1.5 x d	n [min⁻¹]	v_f [100%]
G 1/8	9.728	0.907	6	195	177	5	165	150
G 1/4	13.157	1.337	6	145	194	5	120	160
G 3/8	16.662	1.337	6	115	154	5	95	127
G 1/2	20.955	1.814	6	90	163	5	75	136
G 5/8	22.911	1.814	6	85	154	5	70	127
G 3/4	26.441	1.814	6	70	127	5	60	109

Steel
1300 - 1500 N/mm²

G	ø [mm]	P [mm]	v_c 1.0 x d	n [min⁻¹]	v_f [100%]	v_c 1.5 x d	n [min⁻¹]	v_f [100%]
G 1/8	9.728	0.907	5	165	150	4	130	118
G 1/4	13.157	1.337	5	120	160	4	95	127
G 3/8	16.662	1.337	5	95	127	4	75	100
G 1/2	20.955	1.814	5	75	136	4	60	109
G 5/8	22.911	1.814	5	70	127	4	55	100
G 3/4	26.441	1.814	5	60	109	4	50	91

G

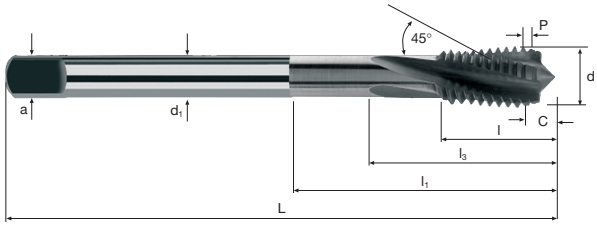
55°

HSS PM/F

DIN 5156

X · P

Form C

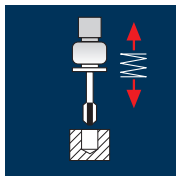


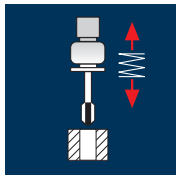
		Rm 1100-1300	Rm 1300-1500						

Example:
Order-N°. **EH1495** (Article-N°.) **.551** (ø-Code)

ø Code	d	P(TPI)	d (mm)	L	l	l1	l3	d1	a			TiCN EH1495
.551	G 1/8	28	9.728	90	10	35	33	7	5.5	4	8.85 *	●
.552	G 1/4	19	13.157	100	14	39	37	11	9.0	4	11.90 *	●
.553	G 3/8	19	16.662	100	14	39	37	12	9.0	4	15.40 *	●
.554	G 1/2	14	20.955	125	20	65	63	16	12.0	4	19.20 *	●
.555	G 5/8	14	22.911	125	20	65	63	18	14.5	4	21.10	●
.556	G 3/4	14	26.441	140	22	72	70	20	16.0	4	24.60	●

* The given dimension is out of norm

Application	Material	G	ø [mm]	P [mm]	v_c 1.0 x d	n [min⁻¹]	v_f [100%]	v_c 1.5 x d	n [min⁻¹]	v_f [100%]	v_c 2.0 x d	n [min⁻¹]	v_f [100%]
	Hardened tool steel 48 - 52 HRC	G 1/8	9.728	0.907	8	260	236	6	195	177	4	130	118
		G 1/4	13.157	1.337	8	195	261	6	145	194	4	95	127
		G 3/8	16.662	1.337	8	155	207	6	115	154	4	75	100
		G 1/2	20.955	1.814	8	120	218	6	90	163	4	60	109
	Hardened tool steel 52 - 56 HRC	G 1/8	9.728	0.907	6	195	177	4	130	118	3	100	91
		G 1/4	13.157	1.337	6	145	194	4	95	127	3	75	100
		G 3/8	16.662	1.337	6	115	154	4	75	100	3	55	74
		G 1/2	20.955	1.814	6	90	163	4	60	109	3	45	82
	Hardened tool steel 56 - 60 HRC	G 1/8	9.728	0.907	4	130	118	2	65	59			
		G 1/4	13.157	1.337	4	95	127	2	50	67			
		G 3/8	16.662	1.337	4	75	100	2	40	53			
		G 1/2	20.955	1.814	4	60	109	2	30	54			
	Hardened tool steel > 60 HRC	G 1/8	9.728	0.907	2	65	59	1.5	50	45			
		G 1/4	13.157	1.337	2	50	67	1.5	35	47			
		G 3/8	16.662	1.337	2	40	53	1.5	30	40			
		G 1/2	20.955	1.814	2	30	54	1.5	25	45			

Application	Material	G	ø [mm]	P [mm]	v_c 1.5 x d	n [min⁻¹]	v_f [100%]	v_c 2.0 x d	n [min⁻¹]	v_f [100%]	v_c 3.0 x d	n [min⁻¹]	v_f [100%]
	Hardened tool steel 48 - 52 HRC	G 1/8	9.728	0.907	8	260	236	6	195	177	4	130	118
		G 1/4	13.157	1.337	8	195	261	6	145	194	4	95	127
		G 3/8	16.662	1.337	8	155	207	6	115	154	4	75	100
		G 1/2	20.955	1.814	8	120	218	6	90	163	4	60	109
	Hardened tool steel 52 - 56 HRC	G 1/8	9.728	0.907	6	195	177	4	130	118	3	100	91
		G 1/4	13.157	1.337	6	145	194	4	95	127	3	75	100
		G 3/8	16.662	1.337	6	115	154	4	75	100	3	55	74
		G 1/2	20.955	1.814	6	90	163	4	60	109	3	45	82
	Hardened tool steel 56 - 60 HRC	G 1/8	9.728	0.907	4	130	118	2	65	59			
		G 1/4	13.157	1.337	4	95	127	2	50	67			
		G 3/8	16.662	1.337	4	75	100	2	40	53			
		G 1/2	20.955	1.814	4	60	109	2	30	54			
	Hardened tool steel > 60 HRC	G 1/8	9.728	0.907	2	65	59	1.5	50	45			
		G 1/4	13.157	1.337	2	50	67	1.5	35	47			
		G 3/8	16.662	1.337	2	40	53	1.5	30	40			
		G 1/2	20.955	1.814	2	30	54	1.5	25	45			

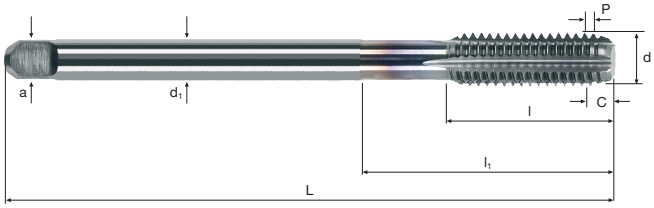
G

55°

HM
MG10

DIN
5156

X · P
Form C



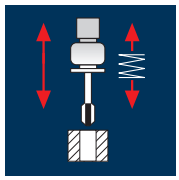
HRC 48-56	HRC 56-60	HRC > 60

Example:
Order-N°. Article-N°. **EH6916** ø-Code **.551**

ø Code	d	P(TPI)	d (mm)	L	l	l1	d1	a			TiCN EH6916
.551	G 1/8	28	9.728	90	18	35	7	5.5	5	8.85 *	●
.552	G 1/4	19	13.157	100	20	39	11	9.0	5	11.90 *	●
.553	G 3/8	19	16.662	100	22	39	12	9.0	5	15.40 *	●
.554	G 1/2	14	20.955	125	25	50	16	12.0	5	19.20 *	●

* The given dimension is out of norm

Application



Material

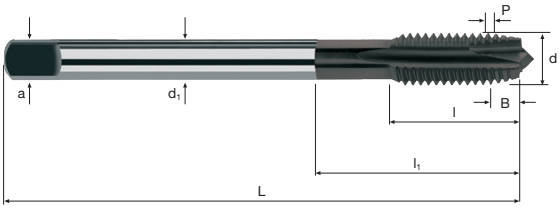
G	ø [mm]	P [mm]	v_c 1.5 x d	n [min⁻¹]	v_f [100%]	v_c 2.0 x d	n [min⁻¹]	v_f [100%]	v_c 3.0 x d	n [min⁻¹]	v_f [100%]
Stainless steel ferritc/martensitic											
G 1/8	9.728	0.907	12	395	358	10	325	295	8	260	236
G 1/4	13.157	1.337	12	290	388	10	240	321	8	195	261
G 3/8	16.662	1.337	12	230	308	10	190	254	8	155	207
G 1/2	20.955	1.814	12	180	327	10	150	272	8	120	218
G 5/8	22.911	1.814	12	165	299	10	140	254	8	110	200
G 3/4	26.441	1.814	12	145	263	10	120	218	8	95	172
Stainless steel [Cr-Ni/1.4301]											
G 1/8	9.728	0.907	7	230	209	5	165	150	4	130	118
G 1/4	13.157	1.337	7	170	227	5	120	160	4	95	127
G 3/8	16.662	1.337	7	135	180	5	95	127	4	75	100
G 1/2	20.955	1.814	7	105	190	5	75	136	4	60	109
G 5/8	22.911	1.814	7	95	172	5	70	127	4	55	100
G 3/4	26.441	1.814	7	85	154	5	60	109	4	50	91
Stainless steel [Cr-Ni-Mo-…/1.4571]											
G 1/8	9.728	0.907	8	260	236	6	195	177	5	165	150
G 1/4	13.157	1.337	8	195	261	6	145	194	5	120	160
G 3/8	16.662	1.337	8	155	207	6	115	154	5	95	127
G 1/2	20.955	1.814	8	120	218	6	90	163	5	75	136
G 5/8	22.911	1.814	8	110	200	6	85	154	5	70	127
G 3/4	26.441	1.814	8	95	172	6	70	127	5	60	109
Heat resistant steel [17-4 PH]											
G 1/8	9.728	0.907	5	165	150	4	130	118	3	100	91
G 1/4	13.157	1.337	5	120	160	4	95	127	3	75	100
G 3/8	16.662	1.337	5	95	127	4	75	100	3	55	74
G 1/2	20.955	1.814	5	75	136	4	60	109	3	45	82
G 5/8	22.911	1.814	5	70	127	4	55	100	3	40	73
G 3/4	26.441	1.814	5	60	109	4	50	91	3	35	63

G

HSS PM/F

DIN 5156

X · P
Form B



Inox
Stainless

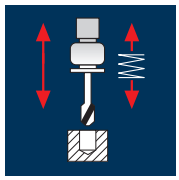
Example:
Order-N°. **ET1440** **.551**

Article-N°. ø-Code

ø Code	d	P(TPI)	d (mm)	L	l	l1	d1	a			TRIBO ET1440
.551	G 1/8	28	9.728	90	18	35	7	5.5	3	8.85 *	●
.552	G 1/4	19	13.157	100	20	39	11	9.0	3	11.90 *	●
.553	G 3/8	19	16.662	100	22	39	12	9.0	4	15.40 *	●
.554	G 1/2	14	20.955	125	25	50	16	12.0	4	19.20 *	●
.555	G 5/8	14	22.911	125	25	50	18	14.5	4	21.10	●
.556	G 3/4	14	26.441	140	28	56	20	16.0	4	24.60	●

* The given dimension is out of norm

Application



Material

G	ø [mm]	P [mm]	v_c 1.0 x d	n [min⁻¹]	v_f [100%]	v_c 1.5 x d	n [min⁻¹]	v_f [100%]	v_c 2.0 x d	n [min⁻¹]	v_f [100%]
Stainless steel ferritc/martensitic											
G 1/8	9.728	0.907	10	325	295	8	260	236	6	195	177
G 1/4	13.157	1.337	10	240	321	8	195	261	6	145	194
G 3/8	16.662	1.337	10	190	254	8	155	207	6	115	154
G 1/2	20.955	1.814	10	150	272	8	120	218	6	90	163
G 5/8	22.911	1.814	10	140	254	8	110	200	6	85	154
G 3/4	26.441	1.814	10	120	218	8	95	172	6	70	127
Stainless steel [Cr-Ni/1.4301]											
G 1/8	9.728	0.907	5	165	150	4	130	118	3	100	91
G 1/4	13.157	1.337	5	120	160	4	95	127	3	75	100
G 3/8	16.662	1.337	5	95	127	4	75	100	3	55	74
G 1/2	20.955	1.814	5	75	136	4	60	109	3	45	82
G 5/8	22.911	1.814	5	70	127	4	55	100	3	40	73
G 3/4	26.441	1.814	5	60	109	4	50	91	3	35	63
Stainless steel [Cr-Ni-Mo-…/1.4571]											
G 1/8	9.728	0.907	6	195	177	5	165	150	4	130	118
G 1/4	13.157	1.337	6	145	194	5	120	160	4	95	127
G 3/8	16.662	1.337	6	115	154	5	95	127	4	75	100
G 1/2	20.955	1.814	6	90	163	5	75	136	4	60	109
G 5/8	22.911	1.814	6	85	154	5	70	127	4	55	100
G 3/4	26.441	1.814	6	70	127	5	60	109	4	50	91
Heat resistant steel [17-4 PH]											
G 1/8	9.728	0.907	4	130	118	3	100	91			
G 1/4	13.157	1.337	4	95	127	3	75	100			
G 3/8	16.662	1.337	4	75	100	3	55	74			
G 1/2	20.955	1.814	4	60	109	3	45	82			
G 5/8	22.911	1.814	4	55	100	3	40	73			
G 3/4	26.441	1.814	4	50	91	3	35	63			

Taps x-tap

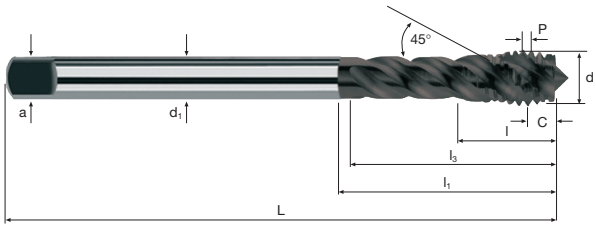
G

HSS PM/F

DIN 5156

X · P

Form C



Inox
Stainless

G

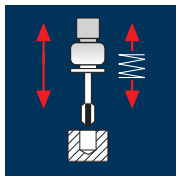
Example:
Order-N°. **ET1475** **.551**

Article-N°. ø-Code

ø Code	d	P(TPI)	d (mm)	L	l	l1	l3	d1	a			TRIBO ET1475
.551	G 1/8	28	9.728	90	10	35	33	7	5.5	3	8.85 *	●
.552	G 1/4	19	13.157	100	14	39	37	11	9.0	4	11.90 *	●
.553	G 3/8	19	16.662	100	14	39	37	12	9.0	4	15.40 *	●
.554	G 1/2	14	20.955	125	20	65	63	16	12.0	5	19.20 *	●
.555	G 5/8	14	22.911	125	20	65	63	18	14.5	5	21.10	●
.556	G 3/4	14	26.441	140	22	72	70	20	16.0	5	24.60	●

* The given dimension is out of norm

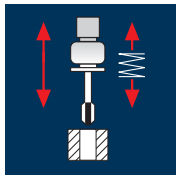
Application



Material

G	ø [mm]	P [mm]	v_c 1.0 x d	n [min⁻¹]	v_f [100%]	v_c 1.5 x d	n [min⁻¹]	v_f [100%]	v_c 2.0 x d	n [min⁻¹]	v_f [100%]
Cast iron GG											
G 1/8	9.728	0.907	28	915	830	24	785	712	20	655	594
G 1/4	13.157	1.337	28	675	902	24	580	775	20	485	648
G 3/8	16.662	1.337	28	535	715	24	460	615	20	380	508
G 1/2	20.955	1.814	28	425	771	24	365	662	20	305	553
G 5/8	22.911	1.814	28	390	707	24	335	608	20	280	508
G 3/4	26.441	1.814	28	335	608	24	290	526	20	240	435
Cast iron GGG											
G 1/8	9.728	0.907	20	655	594	18	590	535	15	490	444
G 1/4	13.157	1.337	20	485	648	18	435	582	15	365	488
G 3/8	16.662	1.337	20	380	508	18	345	461	15	285	381
G 1/2	20.955	1.814	20	305	553	18	275	499	15	230	417
G 5/8	22.911	1.814	20	280	508	18	250	454	15	210	381
G 3/4	26.441	1.814	20	240	435	18	215	390	15	180	327

Application



Material

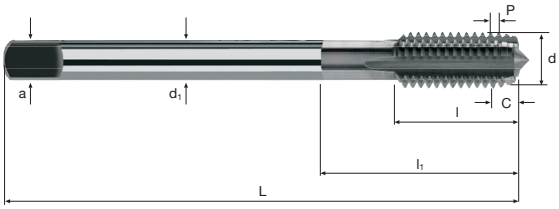
G	ø [mm]	P [mm]	v_c 1.5 x d	n [min⁻¹]	v_f [100%]	v_c 2.0 x d	n [min⁻¹]	v_f [100%]	v_c 3.0 x d	n [min⁻¹]	v_f [100%]
Cast iron GG											
G 1/8	9.728	0.907	30	980	889	28	915	830	25	820	744
G 1/4	13.157	1.337	30	725	969	28	675	902	25	605	809
G 3/8	16.662	1.337	30	575	769	28	535	715	25	480	642
G 1/2	20.955	1.814	30	455	825	28	425	771	25	380	689
G 5/8	22.911	1.814	30	415	753	28	390	707	25	345	626
G 3/4	26.441	1.814	30	360	653	28	335	608	25	300	544
Cast iron GGG											
G 1/8	9.728	0.907	25	820	744	22	720	653	20	655	594
G 1/4	13.157	1.337	25	605	809	22	530	709	20	485	648
G 3/8	16.662	1.337	25	480	642	22	420	562	20	380	508
G 1/2	20.955	1.814	25	380	689	22	335	608	20	305	553
G 5/8	22.911	1.814	25	345	626	22	305	553	20	280	508
G 3/4	26.441	1.814	25	300	544	22	265	481	20	240	435

G

HSS PM/F

DIN 5156

Form C



GG(G)

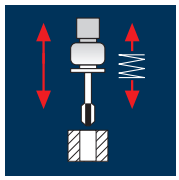
G

Example:
Order-N°. **EH1480** **.551**

Article-N°. ø-Code

ø Code	d	P(TPI)	d (mm)	L	l	l1	d1	a			TiCN EH1480
.551	G 1/8	28	9.728	90	18	35	7	5.5	4	8.80	●
.552	G 1/4	19	13.157	100	20	39	11	9.0	4	11.80	●
.553	G 3/8	19	16.662	100	22	39	12	9.0	4	15.25	●
.554	G 1/2	14	20.955	125	25	50	16	12.0	5	19.00	●
.555	G 5/8	14	22.911	125	25	50	18	14.5	5	21.00	●
.556	G 3/4	14	26.441	140	28	56	20	16.0	5	24.50	●

Application



Material

G	ø [mm]	P [mm]	v_c 1.5 x d	n [min⁻¹]	v_f [100%]	v_c 2.0 x d	n [min⁻¹]	v_f [100%]	v_c 3.0 x d	n [min⁻¹]	v_f [100%]
Unalloyed aluminium											
G 1/8	9.728	0.907	23	755	685	19	620	562	16	525	476
G 1/4	13.157	1.337	23	555	742	19	460	615	16	385	515
G 3/8	16.662	1.337	23	440	588	19	365	488	16	305	408
G 1/2	20.955	1.814	23	350	635	19	290	526	16	245	444
G 5/8	22.911	1.814	23	320	580	19	265	481	16	220	399
G 3/4	26.441	1.814	23	275	499	19	230	417	16	195	354
Wrought aluminium alloys Si < 6% not hardened											
G 1/8	9.728	0.907	35	1145	1039	30	980	889	25	820	744
G 1/4	13.157	1.337	35	845	1130	30	725	969	25	605	809
G 3/8	16.662	1.337	35	670	896	30	575	769	25	480	642
G 1/2	20.955	1.814	35	530	961	30	455	825	25	380	689
G 5/8	22.911	1.814	35	485	880	30	415	753	25	345	626
G 3/4	26.441	1.814	35	420	762	30	360	653	25	300	544
Wrought aluminium alloys Si < 6% hardened											
G 1/8	9.728	0.907	20	655	594	17	555	503	14	460	417
G 1/4	13.157	1.337	20	485	648	17	410	548	14	340	455
G 3/8	16.662	1.337	20	380	508	17	325	435	14	265	354
G 1/2	20.955	1.814	20	305	553	17	260	472	14	215	390
G 5/8	22.911	1.814	20	280	508	17	235	426	14	195	354
G 3/4	26.441	1.814	20	240	435	17	205	372	14	170	308
Unalloyed copper											
G 1/8	9.728	0.907	21	685	621	18	590	535	15	490	444
G 1/4	13.157	1.337	21	510	682	18	435	582	15	365	488
G 3/8	16.662	1.337	21	400	535	18	345	461	15	285	381
G 1/2	20.955	1.814	21	320	580	18	275	499	15	230	417
G 5/8	22.911	1.814	21	290	526	18	250	454	15	210	381
G 3/4	26.441	1.814	21	255	463	18	215	390	15	180	327

Taps

Al

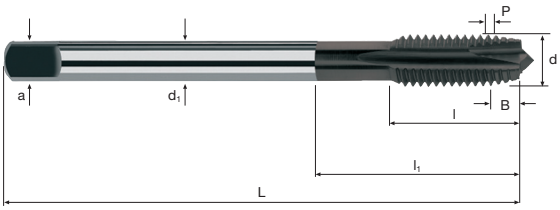
G

55°

HSS
PM/F

DIN
5156

X · P
Form B



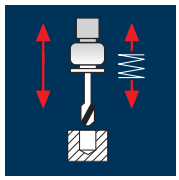
			Al Aluminium > 99%	Al Aluminium Alloy	Al Aluminium Cast		Cu Copper	Plastic Thermoplast	

G

Example:
Order-N°. **EI1402** **.551**

(Article-N°. / ø-Code)

ø Code	d	P(TPI)	d (mm)	L	l	l1	d1	a			INTEGRAL EI1402
.551	G 1/8	28	9.728	90	18	35	7	5.5	2	8.80	●
.552	G 1/4	19	13.157	100	20	39	11	9.0	3	11.80	●
.553	G 3/8	19	16.662	100	22	39	12	9.0	3	15.25	●
.554	G 1/2	14	20.955	125	25	50	16	12.0	3	19.00	●
.555	G 5/8	14	22.911	125	25	50	18	14.5	3	21.00	●
.556	G 3/4	14	26.441	140	28	56	20	16.0	3	24.50	●

Application	Material	G	ø [mm]	P [mm]	v_c 1.0 x d	n [min⁻¹]	v_f [100%]	v_c 1.5 x d	n [min⁻¹]	v_f [100%]	v_c 2.0 x d	n [min⁻¹]	v_f [100%]
	Unalloyed aluminium	G 1/8	9.728	0.907	15	490	444	12	395	358	10	325	295
		G 1/4	13.157	1.337	15	365	488	12	290	388	10	240	321
		G 3/8	16.662	1.337	15	285	381	12	230	308	10	190	254
		G 1/2	20.955	1.814	15	230	417	12	180	327	10	150	272
		G 5/8	22.911	1.814	15	210	381	12	165	299	10	140	254
		G 3/4	26.441	1.814	15	180	327	12	145	263	10	120	218
	Wrought aluminium alloys Si < 6% not hardened	G 1/8	9.728	0.907	15	490	444	13	425	385	10	325	295
		G 1/4	13.157	1.337	15	365	488	13	315	421	10	240	321
		G 3/8	16.662	1.337	15	285	381	13	250	334	10	190	254
		G 1/2	20.955	1.814	15	230	417	13	195	354	10	150	272
		G 5/8	22.911	1.814	15	210	381	13	180	327	10	140	254
		G 3/4	26.441	1.814	15	180	327	13	155	281	10	120	218
	Wrought aluminium alloys Si < 6% hardened	G 1/8	9.728	0.907	13	425	385	11	360	327	10	325	295
		G 1/4	13.157	1.337	13	315	421	11	265	354	10	240	321
		G 3/8	16.662	1.337	13	250	334	11	210	281	10	190	254
		G 1/2	20.955	1.814	13	195	354	11	165	299	10	150	272
		G 5/8	22.911	1.814	13	180	327	11	155	281	10	140	254
		G 3/4	26.441	1.814	13	155	281	11	130	236	10	120	218
	Unalloyed copper	G 1/8	9.728	0.907	20	655	594	18	590	535	16	525	476
		G 1/4	13.157	1.337	20	485	648	18	435	582	16	385	515
		G 3/8	16.662	1.337	20	380	508	18	345	461	16	305	408
		G 1/2	20.955	1.814	20	305	553	18	275	499	16	245	444
		G 5/8	22.911	1.814	20	280	508	18	250	454	16	220	399
		G 3/4	26.441	1.814	20	240	435	18	215	390	16	195	354

Taps

Al

G

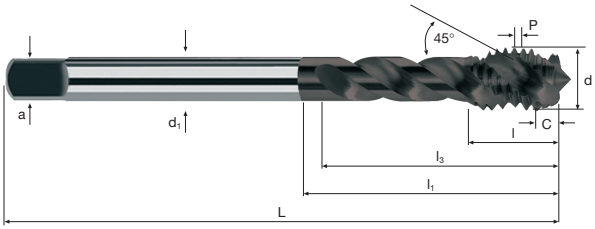
55°

HSS PM/F

DIN 5156

X · P

Form C

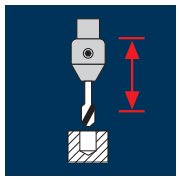


				Al Aluminium > 99%	Al Aluminium Alloy	Al Aluminium Cast		Cu Copper	Plastic Thermoplast					

Example:
Order-N°. Article-N°. **EI1452** ø-Code **.551**

ø Code	d	P(TPI)	d (mm)	L	l	l1	l3	d1	a			INTEGRAL EI1452
.551	G 1/8	28	9.728	90	10	35	33	7	5.5	3	8.80	●
.552	G 1/4	19	13.157	100	14	39	37	11	9.0	4	11.80	●
.553	G 3/8	19	16.662	100	14	39	37	12	9.0	4	15.25	●
.554	G 1/2	14	20.955	125	20	65	63	16	12.0	4	19.00	●
.555	G 5/8	14	22.911	125	20	65	63	18	14.5	4	21.00	●
.556	G 3/4	14	26.441	140	22	72	70	20	16.0	5	24.50	●

Application



Material	G	ø [mm]	P [mm]	v_c 1.0 x d	n [min⁻¹]	v_c 1.5 x d	n [min⁻¹]	v_c 2.0 x d	n [min⁻¹]
Steel < 500 N/mm²	G 1/8	9.728	0.907	25	820	22	720	15	490
	G 1/4	13.157	1.337	25	605	22	530	15	365
	G 3/8	16.662	1.337	25	480	22	420	15	285
	G 1/2	20.955	1.814	25	380	22	335	15	230
	G 5/8	22.911	1.814	25	345	22	305	15	210
	G 3/4	26.441	1.814	25	300	22	265	15	180
Steel 500 - 850 N/mm²	G 1/8	9.728	0.907	22	720	20	655	12	395
	G 1/4	13.157	1.337	22	530	20	485	12	290
	G 3/8	16.662	1.337	22	420	20	380	12	230
	G 1/2	20.955	1.814	22	335	20	305	12	180
	G 5/8	22.911	1.814	22	305	20	280	12	165
	G 3/4	26.441	1.814	22	265	20	240	12	145
Steel 850 - 1100 N/mm²	G 1/8	9.728	0.907	18	590	12	395	8	260
	G 1/4	13.157	1.337	18	435	12	290	8	195
	G 3/8	16.662	1.337	18	345	12	230	8	155
	G 1/2	20.955	1.814	18	275	12	180	8	120
	G 5/8	22.911	1.814	18	250	12	165	8	110
	G 3/4	26.441	1.814	18	215	12	145	8	95
Cast iron GG(G)	G 1/8	9.728	0.907	18	590	15	490	12	395
	G 1/4	13.157	1.337	18	435	15	365	12	290
	G 3/8	16.662	1.337	18	345	15	285	12	230
	G 1/2	20.955	1.814	18	275	15	230	12	180
	G 5/8	22.911	1.814	18	250	15	210	12	165
	G 3/4	26.441	1.814	18	215	15	180	12	145

Material	G	ø [mm]	P [mm]	v_c 1.0 x d	n [min⁻¹]	v_c 1.5 x d	n [min⁻¹]	v_c 2.0 x d	n [min⁻¹]
Stainless steel [Cr-Ni/1.4301]	G 1/8	9.728	0.907	4	130	3	100	2	65
	G 1/4	13.157	1.337	4	95	3	75	2	50
	G 3/8	16.662	1.337	4	75	3	55	2	40
	G 1/2	20.955	1.814	4	60	3	45	2	30
	G 5/8	22.911	1.814	4	55	3	40	2	30
	G 3/4	26.441	1.814	4	50	3	35	2	25
Wrought aluminium alloys Si < 6% hardened	G 1/8	9.728	0.907	12	395	10	325	8	260
	G 1/4	13.157	1.337	12	290	10	240	8	195
	G 3/8	16.662	1.337	12	230	10	190	8	155
	G 1/2	20.955	1.814	12	180	10	150	8	120
	G 5/8	22.911	1.814	12	165	10	140	8	110
	G 3/4	26.441	1.814	12	145	10	120	8	95

Taps polytap-R

G

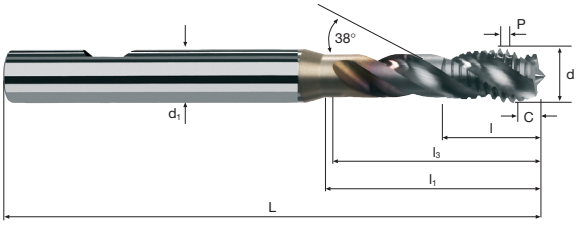
55°

HSS PM/F

DIN 1835B ISO 3338

X · P

Form C



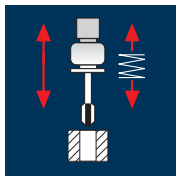
Rm < 850	Rm 850-1100						Inox Stainless		GG(G) Aluminium

G

Example: **Order-N°.** Article-N°. **EH1429** ø-Code **.551**

ø Code	d	P(TPI)	d (mm)	L	l	l_1	l_3	d_1 h6			TiCN EH1429
.551	G 1/8	28	9.728	100	15	39	37	10	3	8.80	●
.552	G 1/4	19	13.157	110	15	46	44	16	4	11.80	●
.553	G 3/8	19	16.662	110	15	50	48	16	4	15.25	●
.554	G 1/2	14	20.955	140	20	64	62	20	4	19.00	●
.555	G 5/8	14	22.911	140	20	64	62	20	4	21.00	●
.556	G 3/4	14	26.441	160	24	84	82	20	5	24.50	●

Application



Material

G	ø [mm]	P [mm]	v_c 1.5 x d	n [min⁻¹]	v_f [100%]	v_c 2.0 x d	n [min⁻¹]	v_f [100%]	v_c 3.0 x d	n [min⁻¹]	v_f [100%]
Steel < 500 N/mm²											
G 1/8	9.728	0.907	18	590	535	15	490	444	12	395	358
G 1/4	13.157	1.337	18	435	582	15	365	488	12	290	388
G 3/8	16.662	1.337	18	345	461	15	285	381	12	230	308
G 1/2	20.955	1.814	18	275	499	15	230	417	12	180	327
G 5/8	22.911	1.814	18	250	454	15	210	381	12	165	299
G 3/4	26.441	1.814	18	215	390	15	180	327	12	145	263
Steel 500 - 850 N/mm²											
G 1/8	9.728	0.907	15	490	444	10	325	295	8	260	236
G 1/4	13.157	1.337	15	365	488	10	240	321	8	195	261
G 3/8	16.662	1.337	15	285	381	10	190	254	8	155	207
G 1/2	20.955	1.814	15	230	417	10	150	272	8	120	218
G 5/8	22.911	1.814	15	210	381	10	140	254	8	110	200
G 3/4	26.441	1.814	15	180	327	10	120	218	8	95	172
Wrought aluminium alloys Si < 6% hardened											
G 1/8	9.728	0.907	15	490	444	12	395	358	10	325	295
G 1/4	13.157	1.337	15	365	488	12	290	388	10	240	321
G 3/8	16.662	1.337	15	285	381	12	230	308	10	190	254
G 1/2	20.955	1.814	15	230	417	12	180	327	10	150	272
G 5/8	22.911	1.814	15	210	381	12	165	299	10	140	254
G 3/4	26.441	1.814	15	180	327	12	145	263	10	120	218
Recommandation: uncoated											
Stainless steel [Cr-Ni/1.4301]											
G 1/8	9.728	0.907	5	165	150	4	130	118	3	100	91
G 1/4	13.157	1.337	5	120	160	4	95	127	3	75	100
G 3/8	16.662	1.337	5	95	127	4	75	100	3	55	74
G 1/2	20.955	1.814	5	75	136	4	60	109	3	45	82
G 5/8	22.911	1.814	5	70	127	4	55	100	3	40	73
G 3/4	26.441	1.814	5	60	109	4	50	91	3	35	63

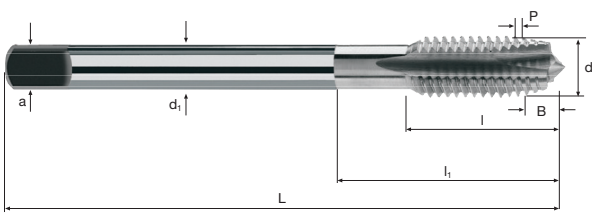
Taps u-tap

G

HSS-E Co5

DIN 5156

Form B



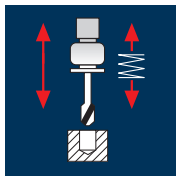
new!

Rm < 850 | **Inox** Stainless | **GG(G) Aluminium Copper**

Example: **Order-N°.** Article-N°. **E11480** ø-Code **.551**

ø Code	d	P(TPI)	d (mm)	L	l	l1	d1	a			E11480	VAP EV11480
.551	G 1/8	28	9.728	90	18	35	7	5.5	3	8.80	●	●
.552	G 1/4	19	13.157	100	20	39	11	9.0	3	11.80	●	●
.553	G 3/8	19	16.662	100	22	39	12	9.0	4	15.25	●	●
.554	G 1/2	14	20.955	125	25	50	16	12.0	4	19.00	●	●
.555	G 5/8	14	22.911	125	25	50	18	14.5	4	21.00	●	●
.556	G 3/4	14	26.441	140	28	56	20	16.0	4	24.50	●	●

Application



Material

G	ø [mm]	P [mm]	v_c 1.0 x d	n [min⁻¹]	v_f [100%]	v_c 1.5 x d	n [min⁻¹]	v_f [100%]	v_c 2.0 x d	n [min⁻¹]	v_f [100%]
Steel < 500 N/mm²											
G 1/8	9.728	0.907	14	460	417	12	395	358	10	325	295
G 1/4	13.157	1.337	14	340	455	12	290	388	10	240	321
G 3/8	16.662	1.337	14	265	354	12	230	308	10	190	254
G 1/2	20.955	1.814	14	215	390	12	180	327	10	150	272
G 5/8	22.911	1.814	14	195	354	12	165	299	10	140	254
G 3/4	26.441	1.814	14	170	308	12	145	263	10	120	218
Steel 500 - 850 N/mm²											
G 1/8	9.728	0.907	9	295	268	8	260	236	7	230	209
G 1/4	13.157	1.337	9	220	294	8	195	261	7	170	227
G 3/8	16.662	1.337	9	170	227	8	155	207	7	135	180
G 1/2	20.955	1.814	9	135	245	8	120	218	7	105	190
G 5/8	22.911	1.814	9	125	227	8	110	200	7	95	172
G 3/4	26.441	1.814	9	110	200	8	95	172	7	85	154
Wrought aluminium alloys Si < 6% hardened											
G 1/8	9.728	0.907	10	325	295	8	260	236	6	195	177
G 1/4	13.157	1.337	10	240	321	8	195	261	6	145	194
G 3/8	16.662	1.337	10	190	254	8	155	207	6	115	154
G 1/2	20.955	1.814	10	150	272	8	120	218	6	90	163
G 5/8	22.911	1.814	10	140	254	8	110	200	6	85	154
G 3/4	26.441	1.814	10	120	218	8	95	172	6	70	127
Recommandation: uncoated											
Stainless steel [Cr-Ni/1.4301]											
G 1/8	9.728	0.907	4	130	118	3	100	91	3	100	91
G 1/4	13.157	1.337	4	95	127	3	75	100	3	75	100
G 3/8	16.662	1.337	4	75	100	3	55	74	3	55	74
G 1/2	20.955	1.814	4	60	109	3	45	82	3	45	82
G 5/8	22.911	1.814	4	55	100	3	40	73	3	40	73
G 3/4	26.441	1.814	4	50	91	3	35	63	3	35	63

Taps u-tap

G

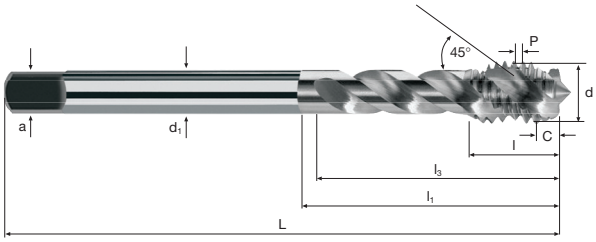
55°

HSS-E Co5

DIN 5156

X · P

Form C



new!

Rm < 850							Inox Stainless		GG(G) Aluminium Copper

G

Example: **Order-N°.** Article-N°. **E11482** ø-Code **.551**

ø Code	d	P(TPI)	d (mm)	L	l	l1	l3	d1	a			E11482	VAP EV11482
.551	G 1/8	28	9.728	90	7.3	35	33	7	5.5	3	8.80	●	●
.552	G 1/4	19	13.157	100	10.7	39	37	11	9.0	4	11.80	●	●
.553	G 3/8	19	16.662	100	10.7	39	37	12	9.0	4	15.25	●	●
.554	G 1/2	14	20.955	125	14.5	65	63	16	12.0	4	19.00	●	●
.555	G 5/8	14	22.911	125	14.5	65	63	18	14.5	4	21.00	●	●
.556	G 3/4	14	26.441	140	14.5	72	70	20	16.0	5	24.50	●	●