Combined Machine Taps

Combined machine taps

The Combined Tap enables the user to produce the tapping drill hole and the through thread in one operation without any tool changing. The tool incorporates a twist drill before the thread tapping part. This tool can produce through threads up to a maximuthreaded depth of 2 x D. The Combined Tap is suitable for universal use in materials of mediumechanical strength: non-alloyed and alloyed steel sorts up to 600 N/mm², malleable cast iron, nodulized graphite cast iron, copper, brass, aluminium, aluminium-magnesiuand zinc alloys, red bronze, electron metal, pressure-cast zinc. This tool should be used on machines possesing an RPswitchover facility for drilling and tapping. The feed rate must be adapted to the particular operation required - drilling or tapping.
Tapping chucks with pressure compensation may not be used.

P.K.370 Combined taps (set of 7 pcs.) (47837)

M 3 – M 12

Type of thread	Tolerance	Material	Packing	Size
metric ISO thread DIN 13	ISO 2 /6H	HSS-E	in plastic case	Diameter M 3 - 12

Contents:	Art. -No.		Art. -No.
1x Combined Machine Tap, M 3 x 0,5	37026	1x Combined Machine Tap, 8 x 1,25	37042
1x Combined Machine Tap, M 4 x 0,7	37030	1x Combined Machine Tap, M 10 x 1,5	37046
1x Combined Machine Tap, M 5 x 0,8	37034	1x Combined Machine Tap, M 12 x 1,75	37050
1x Combined Machine Tap, M 6 x 1,0	37038		

P.K.700 Combined taps (set of 7 pcs.) (47870)

BSW 1/8 – BSW 1/2

Type of thread	Material	Packing	Size
Whitworth-thread BS 84	HSS-E	in plastic case	Diameter BSW 1/8 - 1/2

Contents:	Art. -No.		Art. -No.
1x Combined Machine Tap, BSW 1/8 x 40	70006	1x Combined Machine Tap, BSW 5/16 x 18	70016
1x Combined Machine Tap, BSW 5/32 x 32	70008	1x Combined Machine Tap, BSW 3/8 x 16	70018
1x Combined Machine Tap, BSW 3/16 x 24	70010	1x Combined Machine Tap, BSW 1/2 x 12	70022
1x Combined Machine Tap, BSW 1/4 x 20	70014		

Combined Machine taps

HSS-E – M + HSS-E – BSW

Type of thread: metric ISO-thread DIN 13 + Whitworth-thread BS 84

Tolerance: ISO 2 /6H

Variants (7/7):

M D		L1	S1	L2	D1	D2	Square	Art.-No.
M	3 x 0.5	56	16	11	2.5	3.0	2.4	37026
M	4 x 0.7	63	18	14	3.3	4.0	3.0	37030
M	5 x 0.8	71	20	18	4.2	5.0	3.8	37034
M	6 x 1.0	80	22	22	5.0	6.0	4.9	37038
M	8 x 1.25	95	26	25	6.8	8.0	6.2	37042
M	10 x 1.5	106	30	31	8.5	10.0	8.0	37046
M	12 x 1.75	115	32	35	10.2	12.0	9.0	37050

BSW D		L1	S1	L2	D1	D2	Square	Art.-No.
BSW	1/8 x 40	56	16	11	2.6	3.0	2.4	70006
BSW	5/32 x 32	63	18	14	3.2	4.0	3.0	70008
BSW	3/16 x 24	71	20	18	3.7	5.0	3.8	70010
BSW	1/4 x 20	80	22	22	5.1	6.0	4.9	70014
BSW	5/16 x 18	95	26	25	6.5	8.0	6.2	70016
BSW	3/8 x 16	106	30	31	7.8	10.0	8.0	70018
BSW	1/2 x 12	115	32	35	10.5	12.0	9.0	70022

D = Nominal Diameter **L1 =** Overall Length **L2 =** Thread Length **D1 =** Core hole D **D2 =** Shank Diameter **S1 =** Length **Square =** Drive Connector

G (BSPF)

Machine taps
ISO 529 35°RSP HSS-G – G (BSPF)

Type of thread: Pipe-thread DIN ISO 228

Variants (5):

Application/ for general use:
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for thread cutting by hand and machine
- for blind holes

D		L1	L2	D2	Square	Art.-No.
G	1/8 x 28	59	15	8	6.3	86712
G	1/4 x 19	67	19	10	8	86714
G	3/8 x 19	75	21	12.5	10	86716
G	1/2 x 14	87	26	16	12.5	86718
G	3/4 x 14	96	28	20	16	86722

Machine taps
ISO 529 HSS-G – G (BSPF)

Type of thread: Pipe-thread DIN ISO 228

Variants (6):

Application/ for general use:
- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through holes

D		L1	L2	D2	Square	Art.-No.
G	1/8 x 28	59	15	8	6.3	86512
G	1/4 x 19	67	19	10	8	86514
G	3/8 x 19	75	21	12.5	10	86516
G	1/2 x 14	87	26	16	12.5	86518
G	3/4 x 14	96	28	20	16	86522
G	1" x 14	109	33	25	20	86526

D = Nominal Diameter **L1 =** Overall Length **L2 =** Thread Length **D2 =** Shank Diameter **Square =** Drive Connector

BSPT

Machine taps

ISO 529 HSS-G – BSPT + ISO 529 HSS-G – NPT

Type of thread: tapered pipe thread, taper 1:16, con. 55°

Variants (12/11):

Application/ for general use:

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for through and blind holes

D	L1	L2	D2	Square	Art.-No. BSPT	Art.-No. NPT
1/16 x 27	52	14	5.6	4.5	-	88410
1/8 x 28	59	15	8	6.3	87412	88412
1/4 x 19	67	19	10	8	87414	88414
3/8 x 19	75	21	12.5	10	87416	88416
1/2 x 14	87	26	16	12.5	87418	88418
5/8 x 14	91	27	18	14	87419	-
3/4 x 14	96	28	20	16	87422	88422
7/8 x 14	96	28	20	16	87423	-
1" x 11	109	33	25	20	87426	88426
1.1/4 x 11	119	36	31.5	25	87434	88434
1.1/2 x 11	125	37	35.5	28	87442	88442
2" x 11	140	41	40	31.5	87454	88454
2.1/2 x 11	153	45	45	35.5	87464	88464
4" x 12	279	89	56.0	45.0	83314	-

D = Nominal Diameter **L1 =** Overall Length **L2 =** Thread Length **D2 =** Shank Diameter **Square =** Drive Connector

W

Machine taps

JIS B-4430 HSS-E – W

Type of thread: tapered Whitworth screw thread
for gas cylinders taper 3.25

Variants (14/14):

Application/ for general use:

- non abrasive material up to 900 N/mm²
- unalloyed and low alloyed steel
- for thread cutting by machine
- for through holes*
- for blind holes**

D		L1	L2	D2	Square	Art.-No.*	Art.-No.**
W	1/8 x 40	47	11	4	3.2	94506	94706
W	5/32 x 32	53	14	5	4	94508	94708
W	3/16 x 24	60	17	5.5	4.5	94510	94710
W	1/4 x 20	62	20	6	4.5	94514	94714
W	5/16 x 18	70	23	6.1	5	94516	94716
W	3/8 x 16	75	25	7	5.5	94518	94718
W	7/16 x 14	80	24	8	6	94520	94720
W	1/2 x 13	85	30	9	7	94522	94722
W	9/16 x 12	90	30	10.5	8	94524	94724
W	5/8 x 11	95	32	12	9	94526	94726
W	3/4 x 10	105	38	14	11	94530	94730
W	7/8 x 9	115	38	17	13	94534	94734
W	1" x 8	126	45	20	15	94538	94738
W	1.1/4 x 17	145	51	24	19	94540	94740

D = Nominal Diameter **L1 =** Overall Length **L2 =** Thread Length **D2 =** Shank Diameter **Square =** Drive Connector

PF

Machine taps
JIS B-4430 HSS-E – PF

Type of thread: Pipe-thread DIN ISO 228

Variants (10/10):

Application/ for general use:

- Non-abrassive materials up to 900 N/mm²
- Unalloyed and low alloyed steel
- For blind holes
- For thread cutting by machine

D		L1	L2	D2	Square	Art.-No.* Form B	Art.-No.** Form C 35°RSP
PF	1/8 x 28	55	17.5	8	6	96502	96702
PF	1/8 x 28	55	19	8	6	96506	96706
PF	1/4 x 19	62	28	11	9	96514	96714
PF	3/8 x 19	65	28	14	11	96518	96718
PF	1/2 x 14	80	35	18	14	96522	96722
PF	3/4 x 14	85	35	23	17	96530	96730
PF	1" x 11	95	45	26	21	96538	96738
PF	1.1/4 x 11	105	45	32	26	96546	96746
PF	1.1/2 x 11	110	45	38	29	96554	96754
PF	2" x 11	120	50	46	35	96570	96770

D = Nominal Diameter **L1 =** Overall Length **L2 =** Thread Length **D2 =** Shank Diameter **Square =** Drive Connector