



DIN 5157

HANDTAPS

Withworth-threads have a steeper flank compared to metric threads: thread angle 55° compared to thread angle 60° of metric threads. There is a distinction between conical and cylindrical types of Withworth threads. Conical threads according to DIN EN 10226-1 (old DIN 2999) are referred to as metallic sealing. The reason for that is that the nominal diameter of a conical thread matches the mating thread after several turns.

By further tightening the pipe, both threads jam and thus become metallic sealing.

Cylindrical threads according to DIN ISO 228 are not self-sealing. (Abbreviation = G)

TAPS DIN 5157 · 2S · G ½ · 6H · HSS

Description

DIN 5157 = German Institute for Standardisation
2S = 2pcs. Set
G ½ = Withworth-pipe thread according to DIN ISO 228 ½ inch (=20,955 mm)
6H = Tolerance class according to DIN 802, part 1
HSS = High-Speed Steel
Labelling according to DIN 2197
G ½ 6H HSS



▶ HAND TAPS

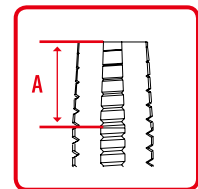
DIN 5157



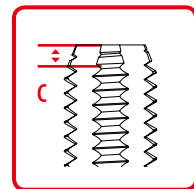
The two-piece set for inner pipe threads according to DIN ISO 228 part 1, consists of taper and bottoming. The taper has undersize. Sizes from G 1/16 to G4 have a reduced shank and four flutes. The pitch is indicated as threads per inch (25,4 mm).



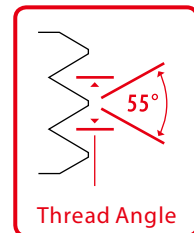
SQUARE SHANK ACCORDING TO DIN 10 for mounting the tap into the adjustable tap wrench



TAPER
Marked with one ring, long chamfer, Form A / 6 - 8 threads

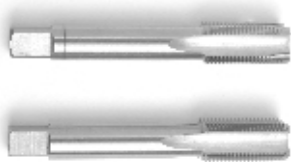


BOTTOMING
no marking, short chamfer, Form C / 2 - 3 threads

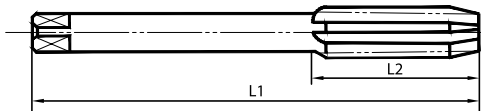








Thread Angle
THREAD WITH PIPE PROFILE

HAND TAP FOR CYLINDRICAL PIPE THREAD

| | | |
|---|-----------|--|
|  | Standard | DIN 5157 |
| | Hole type | through/blind hole |
| | Material | HSS-G |
| | Range | G1/8-G2" |
| | Direction | right hand |
| | Function | for gas or liquid pipes internal threads cutting |
| | Feature | cutting sequenced by No.1 -3,fully ground |


*Inquiry of excluded sizes in this manual is welcome.



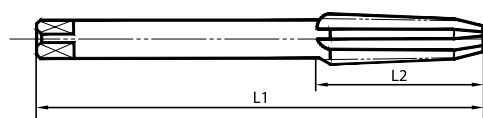
| Art.No. |  |  |  |  |  |  |
|---------------|---|---|---|---|---|---|
| 1010201010001 | G 1/8 | 28 | 63 | 20 | 5,5 | 8.57 |
| 1010201010002 | G 1/4 | 19 | 70 | 22 | 9,0 | 11.45 |
| 1010201010003 | G 3/8 | 19 | 70 | 22 | 9,0 | 14.95 |
| 1010201010004 | G 1/2 | 14 | 80 | 22 | 12,0 | 18.63 |
| 1010201010005 | G 5/8 | 14 | 80 | 22 | 14,5 | 20.59 |
| 1010201010006 | G 3/4 | 14 | 90 | 22 | 16,0 | 24.12 |
| 1010201010007 | G 7/8 | 14 | 90 | 22 | 18,0 | 27.88 |
| 1010201010008 | G 1 | 11 | 100 | 25 | 20,0 | 30.29 |
| 1010201010009 | G 1.1/8 | 11 | 125 | 40 | 22,0 | 34.94 |
| 1010201010010 | G 1.1/4 | 11 | 125 | 40 | 24,0 | 38.95 |
| 1010201010011 | G 1.3/8 | 11 | 125 | 40 | 29,0 | 41.37 |
| 1010201010012 | G 1.1/2 | 11 | 140 | 40 | 29,0 | 44.85 |
| 1010201010013 | G 1.5/8 | 11 | 140 | 40 | 29,0 | 49.93 |
| 1010201010014 | G 1.3/4 | 11 | 140 | 40 | 32,0 | 50.79 |
| 1010201010015 | G 2 | 11 | 160 | 40 | 35,0 | 56.66 |









HAND TAP FOR TAPERED PIPE THREAD

| | | |
|---|-----------|--|
|  | Standard | ANSI 94.9 |
| | Hole type | through/blind hole |
| | Material | HSS-G |
| | Range | NPT1/16-NPT2" |
| | Direction | right hand |
| | Function | for gas or liquid pipes internal threads cutting |
| | Feature | bottom tap always applicated |

*Inquiry of excluded sizes in this manual is welcome.



| Art.No. |  |  |  |  |  |  |
|---------------|---|---|---|---|---|---|
| 1021601010001 | NPT 1/16 | 27 | 55 | 13 | 5,5 | 6,25 |
| 1021601010002 | NPT 1/8 | 27 | 63 | 15 | 5,5 | 8,5 |
| 1021601010003 | NPT 1/4 | 18 | 63 | 21 | 9,0 | 11,1 |
| 1021601010004 | NPT 3/8 | 18 | 70 | 21 | 9,0 | 14,7 |
| 1021601010005 | NPT 1/2 | 14 | 80 | 27 | 12,0 | 18,0 |
| 1021601010006 | NPT 3/4 | 14 | 100 | 27 | 16,0 | 23,3 |
| 1021601010007 | NPT 1 " | 11,5 | 110 | 32 | 20,0 | 29,3 |
| 1021601010008 | NPT 1.1/4 | 11,5 | 125 | 33 | 24,0 | 38,0 |
| 1021601010009 | NPT 1.1/2 | 11,5 | 140 | 33 | 29,0 | 44,3 |
| 1021601010010 | NPT 2 " | 11,5 | 160 | 33 | 29,0 | 56,3 |

