

Garant
Machine tap, TiCN, G: G1/2

Order data

Order number	133315 G1/2
GTIN	4045197746108
Item class	11H

Description
Version:
Sturdy version.
Recommendation:

For very hard steels, TOOLOX and HARDOX materials we recommend **deviating from the DIN data (see table) by drilling the tapping \varnothing 0.05 to 0.3 mm larger.**

For use only with a length compensation chuck – even on machines with synchronised spindle drives.

Tool material: HSS E PM

Threads per inch: 14

Thread \varnothing : 20.96 mm

Overall length L: 125 mm

Shank \varnothing D_s: 16 mm

Shank square \square : 12 mm

Tapping hole \varnothing : 19 mm

Technical description

Tool material	HSS E PM
Shank square \square	12 mm
Shank \varnothing D _s	16 mm
Threads per inch	14
Thread \varnothing	20.96 mm
Number of cutting edges Z	5
Thread pitch	1.814 mm

Tapping hole Ø	19 mm
Number of clamping slots	5
Overall length L	125 mm
Thread depth	31.5 mm
Thread size	G1/2
Coating	TiCN
Thread type	G
Flank angle	55 °
Standard	DIN 5156
Thread standard	DIN 13
Taper lead form	C
Shank	Plain shank with h9
Through-coolant	no
Application for type of drilling	up to 1.5×D for through holes
Application for type of drilling	up to 1.5×D for through holes
Cutting direction	right-hand
Type of threading tool	Machine tap for dynamic machining
Colour ring	red
Type of product	Tap

User data

	Suitability	V _c	ISO code
Steel < 1100 N/mm ²	suitable	12 m/min	P
Steel < 1400 N/mm ²	suitable	7 m/min	P
Steel < 55 HRC	suitable	2 m/min	H
TOOLOX 33	suitable	4 m/min	H
TOOLOX 44	suitable	3 m/min	H
HARDOX 500 < 1600 N/mm ²	suitable	2 m/min	H

Graphite	suitable only under restricted conditions	15 m/min	N
Oil	suitable		