

Garant
Machine tap, TiCN, G: G1/4

Order data

Order number	133315 G1/4
GTIN	4045197746085
Item class	11H

Description
Version:
Sturdy version.
Recommendation:

For very hard steels, TOOLOX and HARDUX 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: 19

Thread \varnothing : 13.16 mm

Overall length L: 100 mm

Shank \varnothing D_s: 11 mm

Shank square \square : 9 mm

Tapping hole \varnothing : 11.8 mm

Technical description

Shank \varnothing D _s	11 mm
Tool material	HSS E PM
Shank square \square	9 mm
Thread \varnothing	13.16 mm
Thread pitch	1.337 mm
Threads per inch	19
Number of cutting edges Z	5

Overall length L	100 mm
Number of clamping slots	5
Tapping hole Ø	11.8 mm
Thread depth	19.5 mm
Thread size	G1/4
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		