

Garant
Machine tap, TiCN, G: G1

Order data

Order number	133310 G1
GTIN	4045197446220
Item class	11H

Description
Version:
With spiral point.

For use with **emulsion** (fat content minimum 8 %).

Application:

For Whitworth parallel pipe threads DIN-ISO 228/1 (threads that do not form a seal within the connection).

Recommendation:

For **TOOLOX materials** we recommend **deviating from the DIN data** (see table) by drilling the tapping hole \varnothing **0.05 to 0.3 mm** larger.

Tool material: HSS

Threads per inch: 11

Thread \varnothing : 33.25 mm

Overall length L: 160 mm

Shank \varnothing D_s: 25 mm

Shank square □: 20 mm

Tapping hole \varnothing : 30.75 mm

Technical description

Thread pitch	2.309 mm
Number of clamping slots	4
Tapping hole \varnothing	30.75 mm
Threads per inch	11
Number of cutting edges Z	4

Thread Ø	33.25 mm
Tool material	HSS
Shank Ø D _s	25 mm
Overall length L	160 mm
Shank square □	20 mm
Thread depth	66.5 mm
Thread size	G1
Coating	TiCN
Thread type	G
Flank angle	55 °
Standard	DIN 5156
Taper lead form	B
Shank	Plain shank with h9
Through-coolant	no
Application for type of drilling	up to 3×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 < 500 N/mm ²	suitable only under restricted conditions	20 m/min	P
Steel < 750 N/mm ²	suitable only under restricted conditions	19 m/min	P
Steel < 900 N/mm ²	suitable	19 m/min	P
Steel < 1100 N/mm ²	suitable	9 m/min	P
TOOLOX 33	suitable	4 m/min	H
Oil	suitable		

wet maximum

suitable