

Garant
Machine tap HSS-E, vaporised, G: G1

Order data

Order number	133325 G1
GTIN	4045197301628
Item class	11H

Description
Version:

Strong spiral point. Guide part with oil grooves.

Advantage:

Particularly strong, optimum self-guidance and **no recutting** when reversed.

Application:

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

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 \square : 20 mm

Tapping hole \varnothing : 30.75 mm

Technical description

Number of cutting edges Z	4
Threads per inch	11
Tapping hole \varnothing	30.75 mm
Thread pitch	2.309 mm
Thread \varnothing	33.25 mm
Number of clamping slots	4

Tool material	HSS
Shank $\varnothing D_s$	25 mm
Overall length L	160 mm
Shank square \square	20 mm
Thread depth	99.75 mm
Thread size	G1
Coating	vaporised
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	blue
Type of product	Tap

User data

	Suitability	V_c	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	13 m/min	N
Steel < 500 N/mm ²	suitable	15 m/min	P
Steel < 750 N/mm ²	suitable	15 m/min	P
Steel < 900 N/mm ²	suitable only under restricted conditions	15 m/min	P
INOX < 900 N/mm ²	suitable	6 m/min	M
CuZn	suitable only under restricted conditions	13 m/min	N

Oil	suitable
wet maximum	suitable only under restricted conditions