

**Garant**
**Solid carbide machine tap, TiAlN, G: G1/4**

**Order data**

Order number	133320 G1/4
GTIN	4045197074584
Item class	11H

**Description**
**Version:**
**Especially sturdy design.**

For use in heavy duty applications.

**Application:**

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

**Recommendation:**

For **very hard steels, TOOLOX** and **HARDOX materials we recommend deviating from the DIN data** (see table) by drilling the tapping hole  $\varnothing$  **0.05** to **0.3mm** larger. For use only with a length compensation chuck – even on machines with synchronised spindle drives.

Tool material: VHM

Threads per inch: 19

Thread  $\varnothing$ : 13.16 mm

Overall length L: 110 mm

Shank  $\varnothing$  D<sub>s</sub>: 14 mm

Shank square □: 11 mm

Tapping hole  $\varnothing$ : 11.8 mm

**Technical description**

Thread pitch	1.337 mm
Number of cutting edges Z	6
Threads per inch	19
Thread $\varnothing$	13.16 mm
Number of clamping slots	6

Tapping hole Ø	11.8 mm
Tool material	VHM
Shank Ø D <sub>s</sub>	14 mm
Overall length L	110 mm
Shank square □	11 mm
Thread depth	26.32 mm
Thread size	G1/4
Coating	TiAlN
Thread type	G
Flank angle	55 °
Standard	DIN 371
Taper lead form	D
Shank	Parallel shank to h6
Through-coolant	no
Application for type of drilling	up to 2×D for blind holes
Application for type of drilling	up to 2×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 <sub>c</sub>	ISO code
Steel < 55 HRC	suitable	3 m/min	H
Steel < 60 HRC	suitable	2 m/min	H
Steel < 65 HRC	suitable	1 m/min	H
Steel < 67 HRC	suitable only under restricted conditions	1 m/min	H
TOOLOX 33	suitable	5 m/min	H

TOOLOX 44	suitable	4 m/min	H
HARDOX 500 < 1600 N/ mm <sup>2</sup>	suitable	3 m/min	H
Graphite, GRP, CRP	suitable only under restricted conditions	18 m/min	N
Oil	suitable		