

Garant**Machine tap HSS-E, vaporised, G: G1/4****Order data**

Order number	133325 G1/4
GTIN	4045197301529
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 E

Threads per inch: 19

Thread Ø: 13.16 mm

Overall length L: 100 mm

Shank Ø D_s: 11 mm

Shank square □: 9 mm

Tapping hole Ø: 11.8 mm

Technical description

Number of cutting edges Z	3
Thread pitch	1.337 mm
Number of clamping slots	3
Threads per inch	19
Tapping hole Ø	11.8 mm
Thread Ø	13.16 mm
Tool material	HSS E

Shank $\varnothing D_s$	11 mm
Overall length L	100 mm
Shank square \square	9 mm
Thread depth	39.48 mm
Thread size	G1/4
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