

Garant
Machine tap, TiCN, G: G1/4

Order data

Order number	133310 G1/4
GTIN	4045197446183
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 E

Threads per inch: 19

Thread \varnothing : 13.16 mm

Overall length L: 100 mm

Shank \varnothing D_s: 11 mm

Shank square □: 9 mm

Tapping hole \varnothing : 11.8 mm

Technical description

Number of cutting edges Z	3
Thread \varnothing	13.16 mm
Tapping hole \varnothing	11.8 mm
Thread pitch	1.337 mm
Threads per inch	19
Number of clamping slots	3

Tool material	HSS E
Shank $\varnothing D_s$	11 mm
Overall length L	100 mm
Shank square \square	9 mm
Thread depth	26.32 mm
Thread size	G1/4
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		

