

Garant
Machine tap, nitrided, Tr: TR14X4

Order data

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|--------------|---------------|
| Order number | 133490 TR14X4 |
| GTIN | 4045197533050 |
| Item class | 11H |

Description
Version:

Profile correct for NC, with divided envelope cut.

Lead chamfer: ≈ 20 turns. **With 25° left-hand flutes**, right-hand cutting.

Advantage:

Suitable for reversing.

Note:

For use on synchronised spindles.

The lead must be machine driven.

Technical description

| | |
|----------------------------|----------|
| Number of cutting edges Z | 3 |
| Tapping hole \varnothing | 10.25 mm |
| Thread pitch | 4 mm |
| Number of clamping slots | 3 |
| Shank $\varnothing D_s$ | 10 mm |
| Overall length L | 165 mm |
| Shank square \square | 8 mm |
| Thread depth | 15.37 mm |
| Thread size | 14 |
| Coating | nitrided |
| Thread type | TR |

| | |
|----------------------------------|-----------------------------------|
| Flank angle | 30 degrees |
| Tool material | HSS E |
| Standard | Manufacturer's standard |
| Tolerance class | DIN 103 7H |
| Shank | Plain shank with h9 |
| Through-coolant | no |
| Application for type of drilling | up to 1.5xD for through holes |
| Cutting direction | right-hand |
| Type of threading tool | Machine tap for dynamic machining |
| Colour ring | green |
| Type of product | Tap |

User data

| | Suitability | V _c | ISO code |
|-------------------------------|---|----------------|----------|
| Aluminium (short chipping) | suitable only under restricted conditions | 7 m/min | N |
| Steel < 500 N/mm ² | suitable | 7 m/min | P |
| Steel < 750 N/mm ² | suitable | 5 m/min | P |
| Steel < 900 N/mm ² | suitable | 3 m/min | P |
| INOX < 900 N/mm ² | suitable | 3 m/min | M |
| GG(G) | suitable | 7 m/min | K |
| CuZn | suitable | 7 m/min | N |
| Uni | suitable | | |
| Oil | suitable | | |
| wet maximum | suitable | | |