

Garant
Machine tap, uncoated, UNF: 1/4-28

Order data

Order number	133400 1/4-28
GTIN	4045197074768
Item class	11H

Description
Version:
With spiral point.
Application:
For UNF uniform fine threads ASME – B1.1.

Thread type: UNF

Tool material: HSS E

Standard: DIN 371

Threads per inch: 28

Thread Ø: 6.35 mm

Overall length L: 80 mm

 Shank Ø D_s: 7 mm

Shank square □: 5.5 mm

Tapping hole Ø: 5.5 mm

Technical description

Number of cutting edges Z	3
Number of clamping slots	3
Thread Ø	6.35 mm
Tapping hole Ø	5.5 mm
Threads per inch	28
Standard	DIN 371
Tool material	HSS E

Shank $\varnothing D_s$	7 mm
Overall length L	80 mm
Shank square \square	5.5 mm
Thread depth	19.05 mm
Thread pitch	0.907 mm
Thread type	UNF
Thread size	1/4-28 UNF
Coating	uncoated
Flank angle	60 °
Tolerance class	2B
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 conventional machining
Colour ring	without
Type of product	Tap

User data

	Suitability	V_c	ISO code
Aluminium	suitable only under restricted conditions	13 m/min	N
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
Oil	suitable		

wet maximum

suitable only under
restricted conditions