

**Garant**
**Fluteless machine tap with oil grooves HSS-E-PM, TiN, G: G3/8**

**Order data**

Order number	139405 G3/8
GTIN	4045197509666
Item class	11H

**Description**
**Version:**

**DIN 2189** (≈ DIN 5156). **With oil grooves; optimum lubrication effect even in deeper threads.** The **innovative polygon form** permits a wide application spectrum. The **multi-function layer structure** achieves **maximum service life** even in **high-tensile materials**.

**Application:**

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

Thread pitch: 1.337 mm

Threads per inch: 19

Thread Ø: 16.66 mm

Overall length L: 100 mm

Shank Ø D<sub>s</sub>: 12 mm

Shank square □: 9 mm

**Technical description**

Thread Ø	16.66 mm
Threads per inch	19
Number of cutting edges Z	6
Thread pitch	1.337 mm
Number of clamping slots	6
Shank Ø D <sub>s</sub>	12 mm
Shank square □	9 mm

Overall length L	100 mm
Tapping hole Ø guide value	16.05 mm
Thread depth	49.98 mm
Thread size	G3/8
Coating	TiN
Thread type	G
Flank angle	55 °
Tool material	HSS E PM
Standard	DIN 2189
Tolerance class	ISO 228 X
Taper lead form	C
Shank	Plain shank with h9
Through-coolant	no
Application for type of drilling	up to 3×D for blind holes and through holes
Cutting direction	right-hand
Colour ring	green
Type of product	Fluteless tap

## User data

	Suitability	V <sub>c</sub>	ISO code
Alu plastics	suitable only under restricted conditions	42 m/min	N
Aluminium (short chipping)	suitable	42 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	37 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	32 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	27 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	22 m/min	P

Steel < 1400 N/mm <sup>2</sup>	suitable only under restricted conditions	17 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	12 m/min	M
CuZn	suitable only under restricted conditions	22 m/min	N
Uni	suitable		
Oil	suitable		
wet maximum	suitable		