

**Fluteless machine tap with oil grooves HSS-E, TiAlN, G: G1/8****Order data**

Order number	139472 G1/8
GTIN	4045197447081
Item class	12H

Description**Version:**

DIN 2189 (\approx DIN 5156). **With oil grooves; optimum lubrication effect even in deeper threads.**
High performance **TiAlN and anti-friction coating** for correspondingly longer tool life.

Application:

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

Thread pitch: 0.907 mm

Threads per inch: 28

Thread \varnothing : 9.73 mm

Overall length L: 90 mm

Shank $\varnothing D_s$: 7 mm

Shank square \square : 5.5 mm

Technical description

Thread pitch	0.907 mm
Number of clamping slots	5
Number of cutting edges Z	5
Thread \varnothing	9.73 mm
Threads per inch	28
Shank $\varnothing D_s$	7 mm
Shank square \square	5.5 mm
Overall length L	90 mm

Tapping hole Ø guide value	9.25 mm
Thread depth	29.19 mm
Thread size	G1/8
Coating	TiAlN
Thread type	G
Flank angle	55 °
Tool material	HSS E
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
Application for type of drilling	up to 3×D for through holes
Cutting direction	right-hand
Colour ring	green
Type of product	Fluteless tap

User data

	Suitability	V _c	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	23 m/min	N
Steel < 500 N/mm ²	suitable	23 m/min	P
Steel < 750 N/mm ²	suitable	22 m/min	P
Steel < 900 N/mm ²	suitable	22 m/min	P
INOX < 900 N/mm ²	suitable only under restricted conditions	11 m/min	M
CuZn	suitable only under restricted conditions	12 m/min	N
Uni	suitable		

Oil	suitable
wet maximum	suitable