

**Fluteless machine tap with oil grooves HSS-E, TiAlN, G: G1/4****Order data**

Order number	139472 G1/4
GTIN	4045197447098
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: 1.337 mm

Threads per inch: 19

Thread \varnothing : 13.16 mm

Overall length L: 100 mm

Shank $\varnothing D_s$: 11 mm

Shank square \square : 9 mm

Technical description

Thread pitch	1.337 mm
Thread \varnothing	13.16 mm
Number of clamping slots	3
Threads per inch	19
Number of cutting edges Z	3
Shank $\varnothing D_s$	11 mm
Shank square \square	9 mm
Overall length L	100 mm

Tapping hole Ø guide value	12.55 mm
Thread depth	39.48 mm
Thread size	G1/4
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