

Garant

Fluteless machine tap with oil grooves HSS-E-PM, TiN, G: G1/8



Order data

Order number	139405 G1/8
GTIN	4045197509642
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: 0.907 mm

Threads per inch: 28

Thread Ø: 9.73 mm

Overall length L: 90 mm

Shank Ø D_s: 7 mm

Shank square □: 5.5 mm

Technical description

Thread Ø	9.73 mm
Number of cutting edges Z	6
Thread pitch	0.907 mm
Threads per inch	28
Number of clamping slots	6
Shank Ø D _s	7 mm
Shank 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	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 _c	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 ²	suitable	37 m/min	P
Steel < 750 N/mm ²	suitable	32 m/min	P
Steel < 900 N/mm ²	suitable	27 m/min	P
Steel < 1100 N/mm ²	suitable	22 m/min	P

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