



Fluteless machine tap with oil grooves HSS-E, TiAlN, G: G1/2



Order data

| | |
|--------------|---------------|
| Order number | 139472 G1/2 |
| GTIN | 4045197447111 |
| 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: 1.814 mm

Threads per inch: 14

Thread \varnothing : 20.96 mm

Overall length L: 125 mm

Shank $\varnothing D_s$: 16 mm

Shank square \square : 12 mm

Technical description

| | |
|---------------------------|----------|
| Number of cutting edges Z | 7 |
| Number of clamping slots | 7 |
| Threads per inch | 14 |
| Thread pitch | 1.814 mm |
| Thread \varnothing | 20.96 mm |
| Shank $\varnothing D_s$ | 16 mm |
| Shank square \square | 12 mm |
| Overall length L | 125 mm |

| | |
|----------------------------------|-----------------------------|
| Tapping hole Ø guide value | 20.05 mm |
| Thread depth | 62.88 mm |
| Thread size | G1/2 |
| 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 |