Hoffmann Group

Garant

Fluteless machine tap with oil grooves HSS-E-PM, TiN, G: G1/4

Order data

Order number	139405 G1/4
GTIN	4045197509659
Item class	11H

Description

Version:
DIN 2189 ($\approx$ 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 $\varnothing$: 13.16 mm
Overall length L: 100 mm
Shank $\varnothing$ D_s: 11 mm
Shank square $\square$: 9 mm

Technical description

Thread $\varnothing$	13.16 mm
Threads per inch	19
Thread pitch	1.337 mm
Number of clamping slots	6
Number of cutting edges Z	6
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	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/mm²	suitable	37 m/min	P
Steel < 750 N/mm²	suitable	32 m/min	P
Steel < 900 N/mm²	suitable	27 m/min	P
Steel < 1100 N/mm²	suitable	22 m/min	P

Steel < 1400 N/mm²	suitable only under restricted conditions	17 m/min	P
INOX < 900 N/mm²	suitable	12 m/min	M
CuZn	suitable only under restricted conditions	22 m/min	N
Uni	suitable		
Oil	suitable		
wet maximum	suitable		