

**Garant**
**Machine tap HSS-E-PM, Hard chrome, G: G1/4**

**Order data**

Order number	137340 G1/4
GTIN	4045197079794
Item class	11H

**Description**
**Version:**

**Hard chrome-plated surface** for reduced edge build-up and increased tool life.

**Application:**

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

Tool material: HSS E PM

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

Tapping hole  $\varnothing$ : 11.8 mm

**Technical description**

Thread $\varnothing$	13.16 mm
Thread pitch	1.337 mm
Tapping hole $\varnothing$	11.8 mm
Number of clamping slots	3
Number of cutting edges Z	3
Threads per inch	19
Tool material	HSS E PM
Shank $\varnothing D_s$	11 mm

Overall length L	100 mm
Shank square □	9 mm
Thread depth	26.32 mm
Thread size	G1/4
Coating	Hard chrome
Thread type	G
Flank angle	55 °
Standard	DIN 5156
Taper lead form	C
Helix angle	40 °
Shank	Plain shank with h9
Through-coolant	no
Application for type of drilling	up to 2×D for blind holes
Cutting direction	right-hand
Type of threading tool	Machine tap for dynamic machining
Colour ring	yellow
Type of product	Tap

## User data

	Suitability	V <sub>c</sub>	ISO code
Alu plastics	suitable	28 m/min	N
Aluminium (short chipping)	suitable	28 m/min	N
Alu > 10% Si	suitable	23 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable only under restricted conditions	27 m/min	P
CuZn	suitable only under restricted conditions	28 m/min	N
Oil	suitable		
wet maximum	suitable		

