

Garant
Machine tap HSS-E-PM, TiCN, G: G1

Order data

Order number	137410 G1
GTIN	4045197273451
Item class	11H

Description
Version:

For use with **emulsion** (fat content minimum 8%).

Application:

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

Recommendation:

For **TOOLOX materials** we recommend **deviating from the DIN data** (see table) by drilling the tapping hole \varnothing **0.05 to 0.3 mm** larger.

Tool material: HSS E PM

Threads per inch: 11

Thread \varnothing : 33.25 mm

Overall length L: 160 mm

Shank \varnothing D_s: 25 mm

Shank square □: 20 mm

Tapping hole \varnothing : 30.75 mm

Technical description

Number of cutting edges Z	4
Number of clamping slots	4
Thread \varnothing	33.25 mm
Thread pitch	2.309 mm
Tapping hole \varnothing	30.75 mm
Threads per inch	11

Tool material	HSS E PM
Shank $\varnothing D_s$	25 mm
Overall length L	160 mm
Shank square \square	20 mm
Thread depth	66.5 mm
Thread size	G1
Coating	TiCN
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 2xD for blind holes
Cutting direction	right-hand
Type of threading tool	Machine tap for dynamic machining
Colour ring	red
Type of product	Tap

User data

	Suitability	V_c	ISO code
Steel < 750 N/mm ²	suitable only under restricted conditions	23 m/min	P
Steel < 900 N/mm ²	suitable	23 m/min	P
Steel < 1100 N/mm ²	suitable	13 m/min	P
Steel < 1400 N/mm ²	suitable	7 m/min	P
TOOLOX 33	suitable	7 m/min	H
Oil	suitable		

wet maximum

suitable