

**Garant**
**Machine tap, vaporised, G: G1**

**Order data**

Order number	137350 G1
GTIN	4045197079909
Item class	11H

**Description**
**Version:**

Surface vaporised for reduced edge build-up. **HSS**

**Application:**

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

**Technical description**

Number of clamping slots	5
Thread $\varnothing$	33.25 mm
Thread pitch	2.309 mm
Tapping hole $\varnothing$	30.75 mm
Threads per inch	11
Number of cutting edges Z	5
Tool material	HSS
Shank $\varnothing D_s$	25 mm
Overall length L	160 mm
Shank square $\square$	20 mm
Thread depth	99.75 mm
Thread size	G1

Coating	vaporised
Thread type	G
Flank angle	55 degrees
Standard	DIN 5156
Taper lead form	C
Helix angle	40 degrees
Shank	Plain shank with h9
Through-coolant	no
Application for type of drilling	up to 3×D for blind holes
Cutting direction	right-hand
Type of threading tool	Machine tap for conventional machining
Colour ring	without
Type of product	Tap

## User data

	Suitability	V <sub>c</sub>	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	13 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	15 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	15 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	15 m/min	P
CuZn	suitable only under restricted conditions	13 m/min	N
Oil	suitable		
wet maximum	suitable only under restricted conditions		