

**Garant**
**Machine tap HSS-E Form C, vaporised, G: G1/4**

**Order data**

Order number	137450 G1/4
GTIN	4045197079954
Item class	11H

**Description**
**Version:**

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

**Application:**

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

Tool material: HSS E

Threads per inch: 19

Thread  $\varnothing$ : 13.16 mm

Overall length L: 100 mm

Shank  $\varnothing$  D<sub>s</sub>: 11 mm

Shank square □: 9 mm

Tapping hole  $\varnothing$ : 11.8 mm

**Technical description**

Thread pitch	1.337 mm
Threads per inch	19
Number of cutting edges Z	3
Number of clamping slots	3
Thread $\varnothing$	13.16 mm
Tapping hole $\varnothing$	11.8 mm
Tool material	HSS E
Shank $\varnothing$ D <sub>s</sub>	11 mm

Overall length L	100 mm
Shank square □	9 mm
Thread depth	26.32 mm
Thread size	G1/4
Coating	vaporised
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	blue
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 only under restricted conditions	15 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable only under restricted conditions	15 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable only under restricted conditions	15 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	6 m/min	M

CuZn	suitable only under restricted conditions	13 m/min	N
Oil	suitable		
wet maximum	suitable only under restricted conditions		