

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

**Order data**

Order number	137410 G1/4
GTIN	4045197273413
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: 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	4
Number of clamping slots	4
Tapping hole $\varnothing$	11.8 mm
Thread $\varnothing$	13.16 mm

Tool material	HSS E PM
Shank $\varnothing D_s$	11 mm
Overall length L	100 mm
Shank square $\square$	9 mm
Thread depth	26.32 mm
Thread size	G1/4
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 <sup>2</sup>	suitable only under restricted conditions	23 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	23 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	13 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	7 m/min	P
TOOLOX 33	suitable	7 m/min	H
Oil	suitable		

wet maximum

suitable