

**Machine tap, uncoated, UNC: 1/2-13****Order data**

Order number	137862 1/2-13
GTIN	4045197594969
Item class	12H

Description**Version:**

Sturdy design, with right-hand chip flutes. HSS-E

Application:

For UNC uniform coarse threads ASME – B1.1.

Technical description

Number of clamping slots	3
Thread Ø	12.7 mm
Threads per inch	13
Tapping hole Ø	10.8 mm
Thread pitch	1.954 mm
Number of cutting edges Z	3
Standard	DIN 376
Tool material	HSS E
Shank Ø D _s	9 mm
Overall length L	110 mm
Shank square □	7 mm
Thread depth	25.4 mm
Thread type	UNC

Data sheet

Thread size	1/2-13 UNC
Coating	uncoated
Flank angle	60 degrees
Tolerance class	2B
Taper lead form	C
Helix angle	15 degrees
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 conventional machining
Colour ring	without
Type of product	Tap

User data

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