

**Garant**
**Machine tap, uncoated, UNF: 1/4-28**

**Order data**

Order number	138000 1/4-28
GTIN	4045197080318
Item class	11H

**Description**
**Version:**
**Sturdy design, with right-hand chip flutes. HSS-E**
**Application:**
**For UNF uniform fine threads ASME – B1.1.**

Thread type: UNF

Tool material: HSS E

Standard: DIN 371

Threads per inch: 28

Thread Ø: 6.35 mm

Overall length L: 80 mm

 Shank Ø D<sub>s</sub>: 7 mm

Shank square □: 5.5 mm

Tapping hole Ø: 5.5 mm

**Technical description**

Number of clamping slots	3
Tapping hole Ø	5.5 mm
Number of cutting edges Z	3
Threads per inch	28
Thread Ø	6.35 mm
Tool material	HSS E
Standard	DIN 371
Shank Ø D <sub>s</sub>	7 mm

Overall length L	80 mm
Shank square □	5.5 mm
Thread depth	12.7 mm
Thread pitch	0.907 mm
Thread type	UNF
Thread size	1/4-28 UNF
Coating	uncoated
Flank angle	60 °
Tolerance class	2B
Taper lead form	C
Helix angle	20 °
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 <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
Oil	suitable		
wet maximum	suitable only under restricted conditions		

