

**Machine tap DIN 374, uncoated, UNF: 1/4-28****Order data**

Order number	138002 1/4-28
GTIN	4045197595041
Item class	12H

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

Number of clamping slots	3
Tapping hole Ø	5.5 mm
Thread Ø	6.35 mm
Number of cutting edges Z	3
Threads per inch	28
Standard	DIN 374
Tool material	HSS E
Shank Ø D _s	4.5 mm
Overall length L	80 mm
Shank square □	3.4 mm
Thread depth	12.7 mm
Thread pitch	0.907 mm
Thread type	UNF
Thread size	1/4-28 UNF

Data sheet

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		