



Machine tap, TiN, UNF: 1/4-28



Order data

Order number	138005 1/4-28
GTIN	4045197533357
Item class	11H

Description

Version:

Sturdy design, with 20° right-hand chip flutes. With special TiN coating, for stainless and acid-resistant steels. For use with **emulsion** (fat content minimum 8%).

Application:

For UNF uniform fine threads ASME – B1.1.

Thread type: UNF

Tool material: HSS E

Norm: DIN 374

Threads per inch: 28

Thread Ø: 6.35 mm

Overall length L_{tot} : 80 mm

Shank Ø: 4.5 mm

Shank square: 3.4 mm

Tapping hole Ø: 5.5 mm

Technical description

Taper lead angle	50 degrees
Number of clamping slots	3
Thread Ø	6.35 mm
Tapping hole Ø	5.5 mm
Number of cutting edges Z	3
Threads per inch	28
Norm	DIN 374

Tool material	HSS E
Shank Ø	4.5 mm
Overall length L _{tot}	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
Coating	TiN
Flank angle	60 degrees
Tolerance class	2B
Taper lead form	C
Helix angle	20 degrees
Schaft	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