

Garant
Machine tap, uncoated, Rc: 1/4-19

Order data

Order number	138120 1/4-19
GTIN	4045197585592
Item class	11H

Description
Version:

The **short shank overhangs less and hence is more stable.**

Application:

For use as machine tap or for cleaning existing threads by hand. **Tapered** Whitworth pipe thread (**BSPT**) to **ISO 7/1** and **BS21**, for joints with sealant in the thread. See the table for the specified minimum size of the tapping hole.

Recommendation:
Tapping hole Ø A:

Pre-drill a plain hole **without using a reamer. Variant A** can be used if there is no risk of sealing problems.

Tapping hole Ø B:

Pre-drill a plain hole and then **ream it using a 1:16 taper reamer (see No. 162650)**. The taper bore Ø can then be checked laterally by reference to the D_{max} check dimension (see table).

Variant B for drilling the tapping hole offers the best process reliability for the tapping operation and at the same time ensures the most reliable seal in the thread.

Threads per inch: 19

Overall length L: 63 mm

Shank Ø D_s : 11 mm

Shank square □: 9 mm

Tapping hole Ø A: 10.85 mm

Tapping hole Ø B: 10.75 mm

Technical description

Tapping hole Ø B	10.75 mm
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Thread gauge $\varnothing D_{\max}$ JS11	11.45 mm
Thread \varnothing	13.15 mm
Number of cutting edges Z	5
Number of clamping slots	5
Threads per inch	19
Thread pitch	1.337 mm
Tapping hole minimum depth	16.3 mm
Tapping hole $\varnothing A$	10.85 mm
Shank $\varnothing D_s$	11 mm
Overall length L	63 mm
Shank square \square	9 mm
Thread depth	38 mm
Thread size	Rc1/4-19
Coating	uncoated
Thread type	Rc
Flank angle	55 °
Tool material	HSS E
Standard	DIN 2181
Thread standard	DIN EN 10226-2
Taper lead form	C
Taper ratio	1:16
Shank	Plain shank with h9
Through-coolant	no
Application for type of drilling	Blind hole
Application for type of drilling	Through hole
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
Alu plastics	suitable only under restricted conditions	9 m/min	N
Aluminium (short chipping)	suitable only under restricted conditions	9 m/min	N
Steel < 500 N/mm ²	suitable	7 m/min	P
Steel < 750 N/mm ²	suitable	6 m/min	P
Steel < 900 N/mm ²	suitable	5 m/min	P
GG(G)	suitable only under restricted conditions	5 m/min	K
CuZn	suitable only under restricted conditions	9 m/min	N
Oil	suitable		
wet maximum	suitable only under restricted conditions		