

**Garant**
**Machine tap, uncoated, Rc: 1/2-14**

**Order data**

Order number	138120 1/2-14
GTIN	4045197585714
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: 14

Overall length L: 80 mm

Shank Ø  $D_s$ : 16 mm

Shank square □: 12 mm

Tapping hole Ø A: 17.8 mm

Tapping hole Ø B: 17.7 mm

**Technical description**

Number of clamping slots	5
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Thread pitch	1.814 mm
Thread gauge $\varnothing D_{\max}$ JS11	18.63 mm
Tapping hole $\varnothing B$	17.7 mm
Thread $\varnothing$	20.95 mm
Threads per inch	14
Tapping hole minimum depth	22.3 mm
Tapping hole $\varnothing A$	17.8 mm
Number of cutting edges Z	5
Shank $\varnothing D_s$	16 mm
Overall length L	80 mm
Shank square $\square$	12 mm
Thread depth	65 mm
Thread size	Rc1/2-14
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**

	<b>Suitability</b>	<b>V<sub>c</sub></b>	<b>ISO code</b>
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 <sup>2</sup>	suitable	7 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	6 m/min	P
Steel < 900 N/mm <sup>2</sup>	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		