Garant

Fluteless machine tap with oil grooves HSS-E-PM IC, TiAlN, G: G1/4

Order data

Order number	139425 G1/4
GTIN	4062406384036
Item class	11l

Description

Version:
DIN 2189 (≈ DIN 5156). **With oil grooves; optimum lubrication effect even in deeper threads.**
GARANT Master Form Steel:
The latest generation of high-performance fluteless taps, specially developed for **use in steels.**
· **Optimised polygon geometry for a lower torque.**
· **Multi-layer HIPIMS coating for high wear resistance.**
· **HSS-E-PM substrate for top process reliability.**
With internal coolant feed laterally from the grooves. **Permits the longest possible tool life** when machining through holes and blind holes.
Application:
For **Whitworth parallel pipe threads** DIN-ISO 228/1 (threads that do not form a seal within the connection).
Thread pitch: 1.337 mm
Threads per inch: 19
Thread ∅: 13.16 mm
Overall length L: 100 mm
Shank ∅ D_s: 11 mm
Shank square ☐: 9 mm

Technical description

Shank ∅ D_s	11 mm
Overall length L	100 mm
Tapping hole ∅ guide value	12.55 mm
Thread ∅	13.16 mm

Shank square ☐	9 mm
Threads per inch	19
Thread depth	39.48 mm
Number of clamping slots	8
Thread size	G1/4
Number of cutting edges Z	8
Thread pitch	1.337 mm
Coating	TiAlN
Thread type	G
Flank angle	55 °
Tool material	HSS E PM
Standard	DIN 2189
Tolerance class	ISO 228 X
Taper lead form	C
Shank	Plain shank with h9
Through-coolant	yes
Application for type of drilling	up to 3×D for blind holes
Application for type of drilling	up to 3×D for through holes
Cutting direction	right-hand
Colour ring	blue
Type of product	Fluteless tap

User data

	Suitability	V_c	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	42 m/min	N
Steel < 500 N/mm²	suitable	40 m/min	P
Steel < 750 N/mm²	suitable	38 m/min	P
Steel < 900 N/mm²	suitable	29 m/min	P

Steel < 1100 N/mm²	suitable	20 m/min	P
Steel < 1400 N/mm²	suitable	15 m/min	P
INOX < 900 N/mm²	suitable	15 m/min	M
INOX > 900 N/mm²	suitable only under restricted conditions	8 m/min	M
CuZn	suitable only under restricted conditions	25 m/min	N
Oil	suitable		
wet maximum	suitable		
wet minimum	suitable		