

Garant
Fluteless machine tap with oil grooves HSS-E-PM IC, TiAlN, G: G3/8

Order data

Order number	139425 G3/8
GTIN	4062406384043
Item class	111

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 Ø: 16.66 mm

Overall length L: 100 mm

Shank Ø D_s: 12 mm

Shank square □: 9 mm

Technical description

Number of cutting edges Z	8
Tapping hole Ø guide value	16.05 mm
Thread Ø	16.66 mm
Number of clamping slots	8

Thread pitch	1.337 mm
Shank square □	9 mm
Shank Ø D _s	12 mm
Thread depth	49.98 mm
Threads per inch	19
Thread size	G3/8
Overall length L	100 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/mm ²	suitable	40 m/min	P
Steel < 750 N/mm ²	suitable	38 m/min	P
Steel < 900 N/mm ²	suitable	29 m/min	P

Steel < 1100 N/mm ²	suitable	20 m/min	P
Steel < 1400 N/mm ²	suitable	15 m/min	P
INOX < 900 N/mm ²	suitable	15 m/min	M
INOX > 900 N/mm ²	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		