

**Garant****GARANT Vap Tap machine tap HSS-E, vaporised, G: G1.1/4****Order data**

Order number	137755 G1.1/4
GTIN	4069515002820
Item class	13V

**Description****Version:**

**GARANT Vap Tap general-purpose tap.** Can be used **reliably** in a **wide range of materials**. Optimised **neck and flute length** for **improved chip evacuation** when working on **deep** threads. High-performance **HSS#E tool material** with higher **vanadium content** for improved **wear resistance**. **Surface vaporised** for reduced edge build-up.

**Application:**

**For Whitworth parallel pipe threads** DIN-ISO 228/1 (threads that do not form a seal within the connection).

**Technical description**

Number of cutting edges Z	4
Number of clamping slots	4
Thread pitch	2.309 mm
Tapping hole Ø	39.5 mm
Threads per inch	11
Thread size	G1.1/4
Tool material	HSS E
Thread Ø	41.91 mm
Shank Ø D <sub>s</sub>	32 mm
Shank square □	24 mm
Thread depth	125.73 mm

## Data sheet

Overall length L	170 mm
Series	Vap Tap
Coating	vaporised
Thread type	G
Flank angle	55 degrees
Standard	DIN 5156
Taper lead form	C
Helix angle	40 degrees
Shank	Plain shank with h9
Through-coolant	no
Application for type of drilling	up to 3×D for blind holes
Cutting direction	right-hand
Type of threading tool	Machine tap for dynamic machining
Colour ring	green
Type of product	Taps

### User data

	Suitability	V <sub>c</sub>	ISO code
Alu plastics	suitable	18 m/min	N
Aluminium (short chipping)	suitable	13 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	18 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	15 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	15 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	6 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	6 m/min	M
CuZn	suitable only under restricted conditions	15 m/min	N
Uni	suitable		

## Data sheet

Oil	suitable
wet maximum	suitable