

Garant**GARANT Vap Tap machine tap HSS-E ISO 228 +0.05 mm, vaporised, G: G1/4****Order data**

Order number	137765 G1/4
GTIN	4069515002851
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.

Tolerance class ISO 228 + 0.05 mm.

Application:

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

For components which are **galvanised**, or shrink slightly when hardened.

Recommendation:

We recommend **deviating from the DIN data** (see table) by drilling the tapping hole Ø **0.05mm larger**.

Technical description

Shank Ø D _s	11 mm
Thread Ø	13.16 mm
Number of clamping slots	3
Overall length L	100 mm
Threads per inch	19
Number of cutting edges Z	3
Tapping hole Ø	11.8 mm

Data sheet

Thread depth	39.48 mm
Tool material	HSS E
Thread size	G1/4
Thread pitch	1.337 mm
Shank square ☐	9 mm
Series	Vap Tap
Coating	vaporised
Thread type	G
Flank angle	55 degrees
Standard	DIN 5156
Tolerance class	ISO 228
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 _c	ISO code
Alu plastics	suitable	18 m/min	N
Aluminium (short chipping)	suitable	13 m/min	N
Steel < 500 N/mm ²	suitable	18 m/min	P
Steel < 750 N/mm ²	suitable	15 m/min	P
Steel < 900 N/mm ²	suitable	15 m/min	P

Data sheet

Steel < 1100 N/mm ²	suitable	6 m/min	P
INOX < 900 N/mm ²	suitable	6 m/min	M
CuZn	suitable only under restricted conditions	15 m/min	N
Uni	suitable		
Oil	suitable		
wet maximum	suitable		