

Garant
Machine tap ISO 228 +0.05 mm, vaporised, G: G1/8

Order data

| | |
|--------------|---------------|
| Order number | 137360 G1/8 |
| GTIN | 4045197705648 |
| Item class | 11H |

Description
Version:

Surface vaporised for reduced edge build-up.

Tolerance class ISO 228 + 0.05 mm. HSS-E
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** after threading or shrink slightly when hardened.

Recommendation:

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

Tool material: HSS E

Threads per inch: 28

Thread \varnothing : 9.73 mm

Overall length L: 90 mm

Shank \varnothing D_s: 7 mm

Shank square □: 5.5 mm

Tapping hole \varnothing : 8.8 mm

Technical description

| | |
|----------------------------|---------|
| Threads per inch | 28 |
| Thread \varnothing | 9.73 mm |
| Number of clamping slots | 3 |
| Number of cutting edges Z | 3 |
| Tapping hole \varnothing | 8.8 mm |

| | |
|----------------------------------|--|
| Thread pitch | 0.907 mm |
| Tool material | HSS E |
| Shank $\varnothing D_s$ | 7 mm |
| Overall length L | 90 mm |
| Shank square \square | 5.5 mm |
| Thread depth | 29.19 mm |
| Thread size | G1/8 |
| Coating | vaporised |
| Thread type | G |
| Flank angle | 55° |
| Standard | DIN 5156 |
| Taper lead form | C |
| Helix angle | 40° |
| 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 conventional machining |
| Colour ring | without |
| Type of product | Tap |

User data

| | Suitability | V_c | ISO code |
|-------------------------------|---|----------|----------|
| Aluminium (short chipping) | suitable only under restricted conditions | 13 m/min | N |
| Steel < 500 N/mm ² | suitable | 15 m/min | P |
| Steel < 750 N/mm ² | suitable | 15 m/min | P |
| Steel < 900 N/mm ² | suitable | 15 m/min | P |

| | | | |
|-------------|---|----------|---|
| CuZn | suitable only under restricted conditions | 13 m/min | N |
| Oil | suitable | | |
| wet maximum | suitable only under restricted conditions | | |