

**Garant**
**Machine tap ISO 228 +0.05 mm, vaporised, G: G1/4**

**Order data**

Order number	137360 G1/4
GTIN	4045197705655
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: 19

Thread  $\varnothing$ : 13.16 mm

Overall length L: 100 mm

Shank  $\varnothing$  D<sub>s</sub>: 11 mm

Shank square □: 9 mm

Tapping hole  $\varnothing$ : 11.8 mm

**Technical description**

Number of clamping slots	3
Number of cutting edges Z	3
Thread pitch	1.337 mm
Threads per inch	19
Tapping hole $\varnothing$	11.8 mm

Thread Ø	13.16 mm
Tool material	HSS E
Shank Ø D <sub>s</sub>	11 mm
Overall length L	100 mm
Shank square □	9 mm
Thread depth	39.48 mm
Thread size	G1/4
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 <sub>c</sub>	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	13 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	15 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

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