

Garant
Machine tap ISO 228 +0.05 mm, vaporised, G: G3/4

Order data

Order number	137360 G3/4
GTIN	4045197705686
Item class	11H

Description
Version:

Surface vaporised for reduced edge build-up.

Tolerance class ISO 228 + 0.05 mm. HSS

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**.

Technical description

Thread pitch	1.814 mm
Number of clamping slots	4
Threads per inch	14
Number of cutting edges Z	4
Thread \varnothing	26.44 mm
Tapping hole \varnothing	24.5 mm
Tool material	HSS
Shank $\varnothing D_s$	20 mm
Overall length L	140 mm

Shank square <input type="checkbox"/>	16 mm
Thread depth	79.32 mm
Thread size	G3/4
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 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		

