

Garant
Fluteless machine tap with oil grooves HSS-E-PM, TiAlN, G: G1/8

Order data

| | |
|--------------|---------------|
| Order number | 139395 G1/8 |
| GTIN | 4045197705860 |
| Item class | 11H |

Description
Version:

DIN 2189 (\approx DIN 5156). **With oil grooves; optimum lubrication effect even in deeper threads.**

The **innovative polygon form** permits a wide application spectrum. The **multi-function layer structure** achieves **maximum service life** even in **high-tensile materials**.

Special **TiAlN coating**, highly suitable **for aluminium alloys**.

Application:

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

Thread pitch: 0.907 mm

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

Technical description

| | |
|------------------------------------|----------|
| Thread \varnothing | 9.73 mm |
| Number of cutting edges Z | 6 |
| Thread pitch | 0.907 mm |
| Threads per inch | 28 |
| Number of clamping slots | 6 |
| Shank \varnothing D _s | 7 mm |

| | |
|---------------------------------------|-----------------------------|
| Shank square <input type="checkbox"/> | 5.5 mm |
| Overall length L | 90 mm |
| Tapping hole Ø guide value | 9.25 mm |
| Thread depth | 29.19 mm |
| Thread size | G1/8 |
| Coating | TiAlN |
| Thread type | G |
| Flank angle | 55 ° |
| Tool material | HSS E PM |
| Standard | DIN 2189 |
| Tolerance class | ISO 228 X |
| Taper lead form | C |
| Shank | Plain shank with h9 |
| Through-coolant | no |
| Application for type of drilling | up to 3×D for blind holes |
| Application for type of drilling | up to 3×D for through holes |
| Cutting direction | right-hand |
| Colour ring | yellow |
| Type of product | Fluteless tap |

User data

| | Suitability | V _c | ISO code |
|-------------------------------|-------------|----------------|----------|
| Alu plastics | suitable | 42 m/min | N |
| Aluminium (short chipping) | suitable | 42 m/min | N |
| Alu > 10% Si | suitable | 28 m/min | N |
| Steel < 500 N/mm ² | suitable | 32 m/min | P |
| Oil | suitable | | |
| wet maximum | suitable | | |

