

Garant**Machine tap, uncoated, Rc: 1-11****Order data**

Order number	138120 1-11
GTIN	4045197585738
Item class	11H

Description**Version:**

The **short shank overhangs less and hence is more stable.**

Application:

For use as machine tap or for cleaning existing threads by hand. **Tapered** Whitworth pipe thread (**BSPT**) to **ISO 7/1** and **BS21**, for joints with sealant in the thread. See the table for the specified minimum size of the tapping hole.

Recommendation:**Tapping hole Ø A:**

Pre-drill a plain hole **without using a reamer. Variant A** can be used if there is no risk of sealing problems.

Tapping hole Ø B:

Pre-drill a plain hole and then **ream it using a 1:16 taper reamer (see No. 162650)**. The taper bore Ø can then be checked laterally by reference to the D_{max} check dimension (see table).

Variant B for drilling the tapping hole offers the best process reliability for the tapping operation and at the same time ensures the most reliable seal in the thread.

Technical description

Number of clamping slots	6
Tapping hole Ø B	29.1 mm
Number of cutting edges Z	6
Thread gauge Ø D_{max} JS11	30.29 mm
Thread Ø	33.24 mm

Data sheet

Tapping hole Ø A	29.2 mm
Thread pitch	2.309 mm
Threads per inch	11
Tapping hole minimum depth	28.3 mm
Shank Ø D _s	25 mm
Overall length L	110 mm
Shank square □	20 mm
Thread depth	75 mm
Thread size	Rc1-11
Coating	uncoated
Thread type	Rc
Flank angle	55 degrees
Tool material	HSS E
Standard	DIN 2181
Thread standard	DIN EN 10226-2
Taper lead form	C
Taper ratio	1:16
Shank	Plain shank with h9
Through-coolant	no
Application for type of drilling	Blind hole
Application for type of drilling	Through hole
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
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Data sheet

Alu plastics	suitable only under restricted conditions	9 m/min	N
Aluminium (short chipping)	suitable only under restricted conditions	9 m/min	N
Steel < 500 N/mm ²	suitable	7 m/min	P
Steel < 750 N/mm ²	suitable	6 m/min	P
Steel < 900 N/mm ²	suitable	5 m/min	P
GG(G)	suitable only under restricted conditions	5 m/min	K
CuZn	suitable only under restricted conditions	9 m/min	N
Oil	suitable		
wet maximum	suitable only under restricted conditions		