Garant

Machine tap HSS-E-PM, TiAlN, NPT: 1-11,5

Order data

Order number	138100 1-11,5
GTIN	4045197080462
Item class	11H

Description

Version:
For the highest performance demands. For use with **emulsion** (fat content minimum 8%).
Application:
Tapered pipe threads **(NPT)** to **ANSI B1.20.1,** for threads with sealants. See the table for the specified minimum size of the tapping hole.
Recommendation:
For **TOOLOX** and **HARDOX materials we recommend deviating from the DIN data** (see table) by drilling the tapping hole ∅ **0.05** to **0.3 mm** larger.
Tapping hole ∅ A:
Pre-drill a plain hole **without using a reamer.**
Tapping hole ∅ B:
Pre-drill a plain hole and then **ream it using a 1:16 taper reamer (see No. 162650).** The taper bore ∅ 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.
Threads per inch: 11.5
Overall length L: 160 mm
Shank ∅ D_s: 25 mm
Shank square ☐: 20 mm
Tapping hole ∅ A: 29 mm
Tapping hole ∅ B: 28.6 mm

Technical description

Threads per inch	11.5
Tapping hole ∅ B	28.6 mm

Thread gauge ∅ D_{max} + 0.05	29.69 mm
Tapping hole ∅ A	29 mm
Thread pitch	2.209 mm
Number of cutting edges Z	6
Number of clamping slots	6
Thread ∅	33.228 mm
Tapping hole minimum depth	27.4 mm
Shank ∅ D_s	25 mm
Overall length L	160 mm
Shank square ☐	20 mm
Thread depth	64.18 mm
Thread size	1-11,5 NPT
Coating	TiAlN
Thread type	NPT
Flank angle	60 degrees
Tool material	HSS E PM
Standard	Manufacturer’s standard
Thread standard	ANSI B 1.20.1
Taper lead form	C
Taper ratio	1:16
Helix angle	15 degrees
Shank	Plain shank with h9
Through-coolant	no
Application for type of drilling	for blind holes and through holes
Cutting direction	right-hand
Type of threading tool	Machine tap for dynamic machining
Colour ring	red
Type of product	Tap