

Garant
Machine tap, uncoated, Rc: 1/2-14

Order data

Order number	138120 1/2-14
GTIN	4045197585714
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.

Threads per inch: 14

Overall length L: 80 mm

Shank Ø D_s : 16 mm

Shank square □: 12 mm

Tapping hole Ø A: 17.8 mm

Tapping hole Ø B: 17.7 mm

Technical description

Number of clamping slots	5
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Thread pitch	1.814 mm
Thread gauge $\varnothing D_{\max}$ JS11	18.63 mm
Tapping hole $\varnothing B$	17.7 mm
Thread \varnothing	20.95 mm
Threads per inch	14
Tapping hole minimum depth	22.3 mm
Tapping hole $\varnothing A$	17.8 mm
Number of cutting edges Z	5
Shank $\varnothing D_s$	16 mm
Overall length L	80 mm
Shank square \square	12 mm
Thread depth	65 mm
Thread size	Rc1/2-14
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	for blind holes and through holes
Cutting direction	right-hand
Type of threading tool	Machine tap for conventional machining
Colour ring	without
Type of product	Tap

