

**Garant**
**Machine tap, uncoated, Rc: 1/4-19**

**Order data**

Order number	138120 1/4-19
GTIN	4045197585592
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: 19

Overall length L: 63 mm

Shank Ø  $D_s$ : 11 mm

Shank square □: 9 mm

Tapping hole Ø A: 10.85 mm

Tapping hole Ø B: 10.75 mm

**Technical description**

Tapping hole Ø B	10.75 mm
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Thread gauge $\varnothing D_{\max}$ JS11	11.45 mm
Thread $\varnothing$	13.15 mm
Number of cutting edges Z	5
Number of clamping slots	5
Threads per inch	19
Thread pitch	1.337 mm
Tapping hole minimum depth	16.3 mm
Tapping hole $\varnothing A$	10.85 mm
Shank $\varnothing D_s$	11 mm
Overall length L	63 mm
Shank square $\square$	9 mm
Thread depth	38 mm
Thread size	Rc1/4-19
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

