

Machine tap, TiAIN, NPT: 1/8-27



Order data

Order number	138110 1/8-27
GTIN	4045197533647
Item class	11H

Description

Version:

A special TiAlN coating for long tool life. Due to interrupted guide thread: reduced tapping torque and improved distribution of lubricant. 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:

Tapping hole Ø A:

Pre-drill a plain hole without using a reamer.

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 \varnothing 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: 27 Overall length L: 100 mm

Shank Ø D_s: 7 mm

Shank square □: 5.5 mm Tapping hole Ø A: 8.5 mm Tapping hole Ø B: 8.25 mm

Technical description

Tapping hole minimum depth	12 mm
Threads per inch	27

Tapping hole ∅ B Thread pitch Tapping hole ∅ A Thread ∅ Thread gauge ∅ D _{max} + 0.05 Shank ∅ D _s Overall length L Shank square □ Thread depth Thread size Coating TiAlN Thread type Thread type Tool material Standard Thread standard Thread standard Tapping hole ∅ A 8.25 mm 10.242 mm 10.242 mm 100 mm Shank o D _s 7 mm Overall length L 100 mm Shank square □ 5.5 mm Thread depth 17 mm Thread size 1/8-27 NPT Coating TiAlN Thread sype NPT Flank angle 60 ° Tool material HSS E Standard DIN 374 Thread standard ANSI B 1.20.1 Taper lead form C Taper ratio 1:16 Shank Plain shank with h9 Through-coolant Application for type of drilling Cutting direction right-hand Type of threading tool Machine tap for dynamic machining Clour ring	Number of cutting edges Z	5
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Tapping hole Ø A Thread Ø Thread gauge Ø D _{max} + 0.05 Shank Ø D _s Overall length L Shank square □ Thread depth Thread size Thread size TiAlN Thread type Tool material Standard Thread standard Thread standard Taper lead form C Taper ratio Shank Application for type of drilling Colour ring Tipe And Shand Sh	Tapping hole Ø B	8.25 mm
Thread Ø 10.242 mm Thread gauge Ø D _{max} + 0.05 Shank Ø D, 7 mm Overall length L 100 mm Shank square □ 5.5 mm Thread depth 17 mm Thread size 1/8-27 NPT Coating TiAlN Thread type NPT Flank angle 60 ° Tool material HSS E Standard DIN 374 Thread standard ANSI B 1.20.1 Taper lead form C Taper ratio 1:16 Shank Plain shank with h9 Through-coolant no Application for type of drilling Cutting direction right-hand Type of threading tool Colour ring blue	Thread pitch	0.941 mm
Thread gauge Ø D _{max} + 0.05 Shank Ø D₁ Overall length L Shank square □ Thread depth Thread depth Thread size TiAlN Thread type Tool material Thread standard Thread standard Thread standard Taper lead form Taper ratio Shank Plain shank with h9 Through-coolant Application for type of drilling Colour ring Thread gauge Ø D _{max} + 0.05 Shank Tool material Standard Tope of threading tool Tool material ANSI B 1.20.1 Taper lead form Tool material ANSI B 1.20.1 Taper ratio Taper ratio Title Through-coolant Tool material Tool material Type of threading tool Machine tap for dynamic machining Blue	Tapping hole Ø A	8.5 mm
Shank Ø D, 7 mm Overall length L 100 mm Shank square □ 5.5 mm Thread depth 17 mm Thread size 1/8-27 NPT Coating TiAIN Thread type NPT Flank angle 60 ° Tool material HSS E Standard DIN 374 Thread standard ANSI B 1.20.1 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 dynamic machining Colour ring blue	Thread Ø	10.242 mm
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Shank square □ 5.5 mm Thread depth 17 mm Thread size 11/8-27 NPT Coating TiAIN Thread type NPT Flank angle 60° Tool material HSS E Standard DIN 374 Thread standard ANSI B 1.20.1 Taper lead form C Taper ratio 1:16 Shank Plain shank with h9 Through-coolant no Application for type of drilling Cutting direction right-hand Type of threading tool Machine tap for dynamic machining Colour ring by Taxing Times 1.20 mm Machine tap for dynamic machining	Shank Ø D _s	7 mm
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Shank Plain shank with h9 Through-coolant Application for type of drilling Cutting direction Type of threading tool Colour ring Plain shank with h9 for blind holes and through holes right-hand Machine tap for dynamic machining blue	Taper lead form	С
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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 blue	Shank	Plain shank with h9
Cutting direction right-hand Type of threading tool Machine tap for dynamic machining Colour ring blue	Through-coolant	no
Type of threading tool Colour ring Machine tap for dynamic machining blue	Application for type of drilling	for blind holes and through holes
Colour ring blue	Cutting direction	right-hand
-	Type of threading tool	Machine tap for dynamic machining
Type of product Tap	Colour ring	blue
	Type of product	Тар

