

Garant
GARANT Master Tap INOX machine tap HSS-E-PM, TiAlN, G: G1

Order data

| | |
|--------------|---------------|
| Order number | 133327 G1 |
| GTIN | 4062406081171 |
| Item class | 111 |

Description
Version:
GARANT Master Tap INOX:

Powerful tap, specially developed for **tapping to high process reliability in stainless and acid-resistant steels** and also **duplex materials**.

- **HSS-E-PM tool material for maximum wear resistance**
- **The latest generation of TiAlN multi-layer coating**
- **Parameterised flute geometry for optimum chip formation and torsional rigidity**

Advantage:

Particularly strong, optimum self-guidance and **no recutting** when reversed.

Application:

For Whitworth parallel pipe threads DIN-ISO 228/1 (threads that do not form a seal within the connection).

Tool material: HSS E PM

Threads per inch: 11

Thread Ø: 33.25 mm

Overall length L: 160 mm

Shank Ø D_s: 25 mm

Shank square □: 20 mm

Tapping hole Ø: 30.75 mm

Technical description

| | |
|---------------------------|----------|
| Number of cutting edges Z | 5 |
| Overall length L | 160 mm |
| Thread Ø | 33.25 mm |

| | |
|---------------------------------------|-----------------------------------|
| Shank square <input type="checkbox"/> | 20 mm |
| Tool material | HSS E PM |
| Thread depth | 99.75 mm |
| Shank $\varnothing D_s$ | 25 mm |
| Tapping hole \varnothing | 30.75 mm |
| Thread pitch | 2.309 mm |
| Number of clamping slots | 5 |
| Threads per inch | 11 |
| Thread size | G1 |
| Series | Master Tap |
| Coating | TiAlN |
| Thread type | G |
| Flank angle | 55° |
| Standard | DIN 5156 |
| Taper lead form | B |
| Shank | Plain shank with h9 |
| Through-coolant | no |
| Application for type of drilling | up to 3×D for through holes |
| Cutting direction | right-hand |
| Type of threading tool | Machine tap for dynamic machining |
| Colour ring | blue |
| Type of product | Tap |

User data

| | Suitability | V_c | ISO code |
|-------------------------------|---|----------|----------|
| Aluminium (short chipping) | suitable only under restricted conditions | 28 m/min | N |
| Steel < 750 N/mm ² | suitable only under restricted conditions | 23 m/min | P |

| | | | |
|--------------------------------|---|----------|---|
| Steel < 900 N/mm ² | suitable only under restricted conditions | 23 m/min | P |
| Steel < 1100 N/mm ² | suitable | 12 m/min | P |
| INOX < 900 N/mm ² | suitable | 11 m/min | M |
| INOX > 900 N/mm ² | suitable | 9 m/min | M |
| Oil | suitable | | |
| wet maximum | suitable | | |