

**Garant**
**GARANT Master Tap INOX machine tap HSS-E-PM Form C, TiAlN, G: G1/2**

**Order data**

Order number	137750 G1/2
GTIN	4062406081874
Item class	111

**Description**
**Version:**
**GARANT Master Tap INOX:**

High-performance tap, specially developed for **good process reliability in stainless and acid-resistant steels** and **duplex materials**.

**The 45° helix angle** of the chip flutes facilitates chip formation especially in ductile austenitic CrNi steels.

- **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**

**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: 14

Thread Ø: 20.96 mm

Overall length L: 125 mm

Shank Ø D<sub>s</sub>: 16 mm

Shank square □: 12 mm

Tapping hole Ø: 19 mm

**Technical description**

Thread Ø	20.96 mm
Shank Ø D <sub>s</sub>	16 mm
Number of cutting edges Z	5

Number of clamping slots	5
Tool material	HSS E PM
Shank square □	12 mm
Thread depth	52.4 mm
Overall length L	125 mm
Threads per inch	14
Thread pitch	1.814 mm
Tapping hole Ø	19 mm
Thread size	G1/2
Series	Master Tap
Coating	TiAlN
Thread type	G
Flank angle	55 °
Standard	DIN 5156
Taper lead form	C
Helix angle	45 °
Shank	Plain shank with h9
Through-coolant	no
Application for type of drilling	up to 2.5×D for blind 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 <sub>c</sub>	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	28 m/min	N

Steel < 750 N/mm <sup>2</sup>	suitable only under restricted conditions	23 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable only under restricted conditions	23 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	12 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	11 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	9 m/min	M
Oil	suitable		
wet maximum	suitable		