

Garant
GARANT Master Tap INOX machine tap HSS-E-PM Form E, TiAlN, G: G1/8

Order data

Order number	137752 G1/8
GTIN	4062406208134
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**

Form E (1.5-2 turns lead chamfer).

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: 28

Thread Ø: 9.73 mm

Overall length L: 90 mm

Shank Ø D_s: 7 mm

Shank square □: 5.5 mm

Tapping hole Ø: 8.8 mm

Technical description

Overall length L	90 mm
Thread Ø	9.73 mm

Shank $\varnothing D_s$	7 mm
Thread pitch	0.907 mm
Shank square \square	5.5 mm
Tool material	HSS E PM
Tapping hole \varnothing	8.8 mm
Number of cutting edges Z	3
Threads per inch	28
Number of clamping slots	3
Thread depth	24.33 mm
Thread size	G1/8
Series	Master Tap
Coating	TiAlN
Thread type	G
Flank angle	55°
Standard	DIN 5156
Taper lead form	E
Helix angle	45°
Shank	Plain shank with h9
Through-coolant	no
Application for type of drilling	up to 2.5xD 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_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		