

**Garant**
**GARANT Master Tap machine tap extra long HSS-E-PM, ALTiX, G: G1/2**

**Order data**

Order number	133333 G1/2
GTIN	4062406208639
Item class	11I

**Description**
**Version:**

**GARANT Master Tap Universal taps**, designed for use in a wide spectrum of materials with high process reliability.

- **HSS-E-PM tool material for maximum wear resistance.**
- **Reduced coefficient of friction due to the new high-performance coating.**
- **Special geometry for optimum swarf evacuation.**

With extra-long shank

**Advantage:**

Ideal for tapping threads in places where access is difficult.

**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: 250 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
Thread pitch	1.814 mm
Number of clamping slots	3

Overall length L	250 mm
Shank $\varnothing D_s$	16 mm
Tool material	HSS E PM
Number of cutting edges Z	3
Threads per inch	14
Shank square $\square$	12 mm
Thread size	G1/2
Tapping hole $\varnothing$	19 mm
Thread depth	62.88 mm
Series	Master Tap
Coating	AlTiX
Thread type	G
Flank angle	55°
Standard	Manufacturer's standard
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	green
Type of product	Tap

## User data

	Suitability	$V_c$	ISO code
Alu plastics	suitable	24 m/min	N
Aluminium (short chipping)	suitable	28 m/min	N
Alu > 10% Si	suitable	16 m/min	N

Steel < 500 N/mm <sup>2</sup>	suitable	24 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	24 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	20 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	10 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	6 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	8 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	6 m/min	M
GG(G)	suitable	16 m/min	K
CuZn	suitable	20 m/min	N
Uni	suitable		
Oil	suitable		
wet maximum	suitable		