

Garant
GARANT Master Tap INOX machine tap HSS-E-PM, TiAlN, UNF: 1-12

Order data

Order number	133406 1-12
GTIN	4062406209780
Item class	111

Description
Version:

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

Application:

For UNF uniform fine threads ASME – B1.1.

Thread type: UNF

Tool material: HSS E PM

Standard: DIN 374

Threads per inch: 12

Thread Ø: 25.4 mm

Overall length L: 140 mm

Shank Ø D_s: 18 mm

Shank square □: 14.5 mm

Tapping hole Ø: 23.25 mm

Technical description

Tapping hole Ø	23.25 mm
Tool material	HSS E PM
Thread size	1-12 UNF
Thread type	UNF

Number of clamping slots	4
Thread \varnothing	25.4 mm
Standard	DIN 374
Number of cutting edges Z	4
Thread depth	76.2 mm
Threads per inch	12
Thread pitch	2.117 mm
Shank square \square	14.5 mm
Shank $\varnothing D_s$	18 mm
Overall length L	140 mm
Series	Master Tap
Coating	TiAlN
Flank angle	60°
Tolerance class	2BX
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		