

**Garant**
**GARANT Master Tap INOX machine tap HSS-E-PM, TiAlN, UNC: 1/2-13**

**Order data**

Order number	137857 1/2-13
GTIN	4062406210106
Item class	11I

**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 rigidity.**

**Application:**

**For UNC uniform coarse threads ASME – B1.1.**

Thread type: UNC

Tool material: HSS E PM

Standard: DIN 376

Threads per inch: 13

Thread Ø: 12.7 mm

Overall length L: 110 mm

Shank Ø D<sub>s</sub>: 9 mm

Shank square □: 7 mm

Tapping hole Ø: 10.8 mm

**Technical description**

Number of cutting edges Z	4
Shank Ø D <sub>s</sub>	9 mm
Tool material	HSS E PM
Tapping hole Ø	10.8 mm

Shank square □	7 mm
Thread depth	31.75 mm
Thread type	UNC
Thread size	1/2-13 UNC
Number of clamping slots	4
Threads per inch	13
Overall length L	110 mm
Standard	DIN 376
Thread Ø	12.7 mm
Thread pitch	1.954 mm
Series	Master Tap
Coating	TiAlN
Flank angle	60 °
Tolerance class	2BX
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	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		