Garant

GARANT Master Tap machine tap extra long HSS-E-PM Form C, AlTiX, G: G1

Order data

Order number	137807 G1
GTIN	4062406209179
Item class	11I

Description

Version:
Universal taps, designed for use in a wide spectrum of materials with high process reliability.
· **HSS-E-PM tool material for a high degree of wear resistance.**
· **Reduced coefficient of friction due to the new high-performance coating.**
· **Special geometry for optimum swarf evacuation.**
With extra long shank.
Advantage:
Designed for tapping threads 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: 11
Thread $\varnothing$: 33.25 mm
Overall length L: 280 mm
Shank $\varnothing$ D_s: 25 mm
Shank square □: 20 mm
Tapping hole $\varnothing$: 30.75 mm

Technical description

Number of clamping slots	3
Number of cutting edges Z	3
Tool material	HSS E PM
Thread size	G1

Shank square □	20 mm
Thread pitch	2.309 mm
Thread Ø	33.25 mm
Overall length L	280 mm
Threads per inch	11
Thread depth	83.125 mm
Tapping hole Ø	30.75 mm
Shank Ø D_s	25 mm
Series	Master Tap
Coating	AlTiX
Thread type	G
Flank angle	55 °
Standard	Manufacturer's standard
Taper lead form	C
Helix angle	40 °
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	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/mm²	suitable	24 m/min	P
Steel < 750 N/mm²	suitable	24 m/min	P
Steel < 900 N/mm²	suitable	20 m/min	P
Steel < 1100 N/mm²	suitable	10 m/min	P
Steel < 1400 N/mm²	suitable	6 m/min	P
INOX < 900 N/mm²	suitable	8 m/min	M
INOX > 900 N/mm²	suitable	6 m/min	M
GG(G)	suitable	16 m/min	K
CuZn	suitable	16 m/min	N
Uni	suitable		
Oil	suitable		
wet maximum	suitable		