

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

Order number	133333 G1
GTIN	4062406208660
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: 11

Thread Ø: 33.25 mm

Overall length L: 280 mm

Shank Ø D_s: 25 mm

Shank square □: 20 mm

Tapping hole Ø: 30.75 mm

Technical description

Number of clamping slots	3
Tapping hole Ø	30.75 mm
Overall length L	280 mm

Threads per inch	11
Tool material	HSS E PM
Number of cutting edges Z	3
Thread Ø	33.25 mm
Thread size	G1
Thread depth	99.75 mm
Thread pitch	2.309 mm
Shank square □	20 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	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 ²	suitable	24 m/min	P
Steel < 750 N/mm ²	suitable	24 m/min	P
Steel < 900 N/mm ²	suitable	20 m/min	P
Steel < 1100 N/mm ²	suitable	10 m/min	P
Steel < 1400 N/mm ²	suitable	6 m/min	P
INOX < 900 N/mm ²	suitable	8 m/min	M
INOX > 900 N/mm ²	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		