

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

Order data

Order number	138010 1-12
GTIN	4062406209285
Item class	111

Description
Version:

GARANT Master Tap Universal tap, 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.**

HSS
Application:

For UNF uniform fine threads ASME – B1.1.

Technical description

Shank $\varnothing D_s$	18 mm
Tapping hole \varnothing	23.25 mm
Number of clamping slots	4
Thread depth	63.5 mm
Thread size	1-12 UNF
Tool material	HSS E PM
Overall length L	140 mm
Shank square \square	14.5 mm
Number of cutting edges Z	4
Standard	DIN 374

Thread type	UNF
Thread Ø	25.4 mm
Threads per inch	12
Thread pitch	2.117 mm
Series	Master Tap
Coating	AlTiX
Flank angle	60 degrees
Tolerance class	2BX
Taper lead form	C
Helix angle	40 degrees
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	30 m/min	N
Aluminium (short chipping)	suitable	35 m/min	N
Alu > 10% Si	suitable	20 m/min	N
Steel < 500 N/mm ²	suitable	30 m/min	P
Steel < 750 N/mm ²	suitable	30 m/min	P
Steel < 900 N/mm ²	suitable	25 m/min	P
Steel < 1100 N/mm ²	suitable	12 m/min	P
Steel < 1400 N/mm ²	suitable	8 m/min	P

INOX < 900 N/mm ²	suitable	10 m/min	M
INOX > 900 N/mm ²	suitable	8 m/min	M
GG(G)	suitable	20 m/min	K
CuZn	suitable	20 m/min	N
Uni	suitable		
Oil	suitable		
wet maximum	suitable		