

Garant
GARANT Master Tap SteelHT machine tap HSS-E-PM Form B, TiCN, G: G1

Order data

Order number	133312 G1
GTIN	4062406236755
Item class	11I

Description
Version:

High-performance tap, specially developed for use in **steels with high tensile strength** and for **difficult-to-machine materials**. **Strong spiral point**, for process stability at high cutting forces.

- **HSS-E-PM tool material – for very high cutting edge stability.**
- **Optimised honed cutting edges.**
- **TiCN coating – for maximum wear protection.**

Application:

For Whitworth parallel pipe threads DIN-ISO 228/1 (threads that do not form a seal within the connection).

Recommendation:

For **TOOLOX** and **HARDOX** materials we recommend **deviating from the DIN data** (see table) **by selecting a larger tapping hole diameter.**

Technical description

Tapping hole \varnothing	30.75 mm
Thread \varnothing	33.25 mm
Shank square \square	20 mm
Thread depth	99.75 mm
Shank $\varnothing D_s$	25 mm
Overall length L	160 mm
Thread size	G1
Number of clamping slots	4

Threads per inch	11
Thread pitch	2.309 mm
Number of cutting edges Z	4
Tool material	HSS E PM
Series	Master Tap
Coating	TiCN
Thread type	G
Flank angle	55 degrees
Standard	DIN 5156
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	red
Type of product	Tap

User data

	Suitability	V _c	ISO code
Steel < 750 N/mm ²	suitable only under restricted conditions	30 m/min	P
Steel < 900 N/mm ²	suitable	20 m/min	P
Steel < 1100 N/mm ²	suitable	15 m/min	P
Steel < 1400 N/mm ²	suitable	12 m/min	P
Steel < 50 HRC	suitable only under restricted conditions		
TOOLOX 33	suitable	15 m/min	H
TOOLOX 44	suitable		

INOX > 900 N/mm ²	suitable
Ti > 850 N/mm ²	suitable only under restricted conditions
Oil	suitable
wet maximum	suitable