

Garant

GARANT Master Tap SteelHT machine tap HSS-E-PM Form C, TiAlN, G: G1



Order data

Order number	137425 G1
GTIN	4062406237493
Item class	111

Description

Version:

High-performance tap, specially developed for use in **steels with high tensile strength** and for **difficult-to-machine materials**. Sturdy design with **optimised guide thread to avoid chips jamming**.

- **HSS-E-PM tool material – for very high cutting edge stability.**
- **Optimised honed cutting edges.**
- **TiAlN 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 materials** we recommend deviating from the **DIN data** (see table) **by selecting a larger tapping hole \varnothing** .

Note:

For **TOOLOX materials**: Do not exceed the maximum thread depth of $2 \times D!$

Technical description

Thread \varnothing	33.25 mm
Shank $\varnothing D_s$	25 mm
Shank square \square	20 mm
Thread depth	83.125 mm
Thread pitch	2.309 mm
Overall length L	160 mm

Tapping hole Ø	30.75 mm
Number of clamping slots	4
Tool material	HSS E PM
Number of cutting edges Z	4
Thread size	G1
Threads per inch	11
Series	Master Tap
Coating	TiAlN
Thread type	G
Flank angle	55 degrees
Standard	DIN 5156
Taper lead form	C
Helix angle	40 degrees
Shank	Plain shank with h9
Through-coolant	no
Application for type of drilling	up to 2×D for blind 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		