

Garant
Solid carbide machine tap, TiAlN, G: G1/8

Order data

Order number	133320 G1/8
GTIN	4045197074577
Item class	11H

Description
Version:
Especially sturdy design.

For use in heavy duty applications.

Application:

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

Recommendation:

For **very hard steels, TOOLOX** and **HARDOX materials we recommend deviating from the DIN data** (see table) by drilling the tapping hole \varnothing **0.05** to **0.3mm** larger. For use only with a length compensation chuck – even on machines with synchronised spindle drives.

Tool material: VHM

Threads per inch: 28

Thread \varnothing : 9.73 mm

Overall length L: 100 mm

Shank \varnothing D_s: 10 mm

Shank square □: 8 mm

Tapping hole \varnothing : 8.8 mm

Technical description

Tapping hole \varnothing	8.8 mm
Threads per inch	28
Number of cutting edges Z	5
Thread pitch	0.907 mm
Thread \varnothing	9.73 mm

Number of clamping slots	5
Tool material	VHM
Shank $\varnothing D_s$	10 mm
Overall length L	100 mm
Shank square \square	8 mm
Thread depth	19.46 mm
Thread size	G1/8
Coating	TiAlN
Thread type	G
Flank angle	55°
Standard	DIN 371
Taper lead form	D
Shank	Parallel shank to h6
Through-coolant	no
Application for type of drilling	up to 2×D for blind holes
Application for type of drilling	up to 2×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 < 55 HRC	suitable	3 m/min	H
Steel < 60 HRC	suitable	2 m/min	H
Steel < 65 HRC	suitable	1 m/min	H
Steel < 67 HRC	suitable only under restricted conditions	1 m/min	H
TOOLOX 33	suitable	5 m/min	H

TOOLOX 44	suitable	4 m/min	H
HARDOX 500 < 1600 N/ mm ²	suitable	3 m/min	H
Graphite, GRP, CRP	suitable only under restricted conditions	18 m/min	N
Oil	suitable		