Hoffmann Group

Garant

GARANT Master Form Steel fluteless machine tap with oil grooves HSS-E-PM, TiAlN, UNF: 4-48

Order data

Order number	139495 4-48
GTIN	4062406707132
Item class	11I

Description

Version:
The latest generation of **high-performance fluteless taps**, specially developed for **use in steel materials.**
· **Optimised polygon geometry for a lower torque.**
· **Multi-layer HIPIMS coating for high wear resistance.**
· **HSS-E-PM substrate for exceptional process reliability.**
DIN 2174 (≈ DIN 371 ≤ 3/8; ≈ **DIN 376** ≥ 7/16**).**
Form E (lead-in 1.5 – 2 turns). For deep threads with short lead-in. The thread is tapped almost to the bottom of the hole.
Application:
For UNF unified fine threads ASME–B1.1.
Thread pitch: 0.529 mm
Threads per inch: 48
Thread $\varnothing$: 2.84 mm
Overall length L: 56 mm
Shank $\varnothing$ D_s: 3.5 mm
Shank square $\square$: 2.7 mm

Technical description

Thread $\varnothing$	2.84 mm
Thread depth	8.52 mm
Shank $\varnothing$ D_s	3.5 mm
Shank square $\square$	2.7 mm

Thread pitch	0.529 mm
Number of clamping slots	4
Tapping hole Ø guide value	2.6 mm
Overall length L	56 mm
Number of cutting edges Z	4
Threads per inch	48
Coating	TiAlN
Thread type	UNF
Flank angle	60 °
Tool material	HSS E PM
Standard	DIN 2174
Tolerance class	2BX
Taper lead form	E
Shank	Plain shank with h9
Through-coolant	no
Application for type of drilling	up to 3×D for blind holes
Application for type of drilling	up to 3×D for through holes
Cutting direction	right-hand
Type of product	Fluteless tap

User data

	Suitability	V_c	ISO code
Aluminium (short chipping)	suitable	38 m/min	N
Steel < 500 N/mm²	suitable	37 m/min	P
Steel < 750 N/mm²	suitable	35 m/min	P
Steel < 900 N/mm²	suitable	27 m/min	P
Steel < 1100 N/mm²	suitable	18 m/min	P
Steel < 1400 N/mm²	suitable	12 m/min	P

INOX < 900 N/mm²	suitable	12 m/min	M
INOX > 900 N/mm²	suitable	7 m/min	M
CuZn	suitable	22 m/min	N
Oil	suitable		
wet maximum	suitable		
wet minimum	suitable		