

Garant

GARANT Master Tap machine tap HSS-E-PM Form E, AlTiX, G: G1/8



Order data

Order number	137808 G1/8
GTIN	4062406710996
Item class	111

Description

Version:

Form E (1.5 - 2 turns lead chamfer).

GARANT Master Tap Universal taps, 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.**

Application:

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

Tool material: HSS E PM

Threads per inch: 28

Thread \varnothing : 9.73 mm

Overall length L: 90 mm

Shank \varnothing D_s: 7 mm

Shank square □: 5.5 mm

Tapping hole \varnothing : 8.8 mm

Technical description

Overall length L	90 mm
Shank \varnothing D _s	7 mm
Threads per inch	28
Thread size	G1/8
Thread pitch	0.907 mm

Tapping hole Ø	8.8 mm
Number of clamping slots	3
Shank square □	5.5 mm
Thread depth	24.33 mm
Thread Ø	9.73 mm
Tool material	HSS E PM
Number of cutting edges Z	3
Series	Master Tap
Coating	AlTiX
Thread type	G
Flank angle	55 °
Standard	DIN 5156
Taper lead form	E
Helix angle	40 °
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		