

**Garant**
**GARANT Master Tap Alu machine tap, DLC, G: G1/8**

**Order data**

Order number	137310 G1/8
GTIN	4067263829829
Item class	11I

**Description**
**Version:**

**High-performance tap**, specially developed for **aluminium and non-ferrous alloys**. **Dynamic helical pitch** of the clamping slots ensures **optimum chip evacuation** and **process reliability**.

- **HSS-E-PM tool material for high cutting edge stability.**
- **Ultra-smooth DLC coating for wear resistance and avoidance of edge build-up.**
- **Dynamic helical pitch of the flutes.**
- **Short lead chamfer form E.**

:

**Application:**

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

**Technical description**

Threads per inch	28
Overall length L	90 mm
Tapping hole Ø	8.8 mm
Shank Ø D <sub>s</sub>	7 mm
Thread size	G1/8
Tool material	HSS E PM
Number of clamping slots	3
Shank square □	5.5 mm
Thread depth	24.33 mm

Number of cutting edges Z	3
Thread Ø	9.73 mm
Thread pitch	0.907 mm
Helix angle characteristic	unequal spacing
Series	Master Tap
Coating	DLC
Thread type	G
Flank angle	55 degrees
Standard	DIN 5156
Tolerance class	ISO 228
Taper lead form	E
Helix angle	45 degrees
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
Shank tolerance	h9
Type of threading tool	Machine tap for dynamic machining
Type of product	Taps

## User data

	Suitability	V <sub>c</sub>	ISO code
Aluminium	suitable	35 m/min	N
Aluminium (short chipping)	suitable	32 m/min	N
Alu > 10% Si	suitable	20 m/min	N
PMMA acrylic	suitable only under restricted conditions	20 m/min	N
PA 66	suitable only under restricted conditions	18 m/min	N

PEEK	suitable	18 m/min	N
Cu	suitable	18 m/min	N
CuZn	suitable	25 m/min	N
Oil	suitable		
wet maximum	suitable		
wet minimum	suitable		