

Garant
GARANT Master Tap Alu machine tap, DLC, G: G3/4

Order data

Order number	137310 G3/4
GTIN	4067263830665
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.**

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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	14
Overall length L	140 mm
Thread pitch	1.814 mm
Thread depth	66.1 mm
Thread Ø	26.44 mm
Shank Ø D _s	20 mm
Shank square □	16 mm
Number of clamping slots	4
Thread size	G3/4

Number of cutting edges Z	4
Tool material	HSS E PM
Tapping hole Ø	24.5 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 _c	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		