

**Garant**
**GARANT Master Tap Alu machine tap, DLC, G: G1/2**

**Order data**

Order number	133260 G1/2
GTIN	4067263830207
Item class	111

**Description**
**Version:**

**High-performance tap**, specially developed for **aluminium and non-ferrous alloys**.

- **HSS-E-PM tool material for high cutting edge stability**
- **Ultra-smooth DLC coating for wear resistance and avoidance of edge build-up**

**Application:**

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

**Technical description**

Shank square □	12 mm
Number of clamping slots	3
Tapping hole Ø	19 mm
Thread size	G1/2
Thread Ø	20.96 mm
Tool material	HSS E PM
Number of cutting edges Z	3
Threads per inch	14
Thread pitch	1.814 mm
Thread depth	62.88 mm
Overall length L	125 mm

Shank $\varnothing D_s$	16 mm
Series	Master Tap
Coating	DLC
Thread type	G
Flank angle	55 degrees
Standard	DIN 5156
Tolerance class	ISO 228
Taper lead form	B
Shank	Plain shank with h9
Through-coolant	no
Application for type of drilling	up to 3×D for through holes
Cutting direction	right-hand
Type of threading tool	Machine tap for dynamic machining
Colour ring	yellow
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