

Garant**GARANT Master Tap Alu machine tap, DLC, G: G1/4****Order data**

Order number	133260 G1/4
GTIN	4067263830184
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

Thread Ø	13.16 mm
Tool material	HSS E PM
Number of cutting edges Z	3
Overall length L	100 mm
Number of clamping slots	3
Shank square □	9 mm
Tapping hole Ø	11.8 mm
Thread depth	39.48 mm
Threads per inch	19
Thread size	G1/4
Thread pitch	1.337 mm

Shank $\varnothing D_s$	11 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