

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

Order data

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|--------------|---------------|
| Order number | 137310 G1 |
| GTIN | 4067263830672 |
| 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

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|---------------------------|----------|
| Thread depth | 83.13 mm |
| Thread Ø | 33.25 mm |
| Number of clamping slots | 4 |
| Shank square □ | 20 mm |
| Shank Ø D _s | 25 mm |
| Overall length L | 160 mm |
| Thread size | G1 |
| Number of cutting edges Z | 4 |

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|----------------------------------|-----------------------------------|
| Thread pitch | 2.309 mm |
| Tool material | HSS E PM |
| Tapping hole Ø | 30.75 mm |
| Threads per inch | 11 |
| 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 | | |