

**GARANT Vap Tap machine tap, vaporised, G: G1/8****Order data**

Order number	133328 G1/8
GTIN	4069515001380
Item class	13V

Description**Version:**

Can be used **reliably** in a wide **range of materials**. Optimised **neck and flute length** for improved **chip evacuation** when working on **deep** threads. High-performance **HSS-E tool material** with higher vanadium content for improved **wear resistance**. **Surface vaporised** for reduced 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 Ø D _s	7 mm
Thread depth	29.19 mm
Shank square □	5.5 mm
Thread size	G1/8
Number of cutting edges Z	3
Tool material	HSS E
Tapping hole Ø	8.8 mm
Thread Ø	9.73 mm
Thread pitch	0.907 mm
Overall length L	90 mm
Threads per inch	28

Data sheet

Number of clamping slots	3
Series	Vap Tap
Coating	vaporised
Thread type	G
Flank angle	55 degrees
Standard	DIN 5156
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	without
Type of product	Taps

User data

	Suitability	V_c	ISO code
Alu plastics	suitable	18 m/min	N
Aluminium (short chipping)	suitable	13 m/min	N
Steel < 500 N/mm ²	suitable	18 m/min	P
Steel < 750 N/mm ²	suitable	15 m/min	P
Steel < 900 N/mm ²	suitable	15 m/min	P
Steel < 1100 N/mm ²	suitable	6 m/min	P
INOX < 900 N/mm ²	suitable	6 m/min	M
CuZn	suitable only under restricted conditions	15 m/min	N
Uni	suitable		
Oil	suitable		

wet maximum	suitable
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