

**Garant**
**GARANT Master Tap machine tap HSS-E-PM, ALTiX, G: G3/4**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 133330 G3/4   |
| GTIN         | 4045197901194 |
| Item class   | 111           |

**Description**
**Version:**

**GARANT Master Tap Universal taps**, designed for use in a wide spectrum of materials with high process reliability.

- **HSS-E-PM tool material for maximum wear resistance.**
- **Reduced coefficient of friction due to the new high-performance coating.**
- **Special geometry for optimum swarf evacuation.**

**Application:**

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

Tool material: HSS E PM

Threads per inch: 14

Thread Ø: 26.44 mm

Overall length L: 140 mm

Shank Ø D<sub>s</sub>: 20 mm

Shank square □: 16 mm

Tapping hole Ø: 24.5 mm

**Technical description**

|                           |         |
|---------------------------|---------|
| Tapping hole Ø            | 24.5 mm |
| Overall length L          | 140 mm  |
| Number of cutting edges Z | 2       |
| Shank square □            | 16 mm   |
| Number of clamping slots  | 2       |

|                                  |                                   |
|----------------------------------|-----------------------------------|
| Tool material                    | HSS E PM                          |
| Thread depth                     | 79.32 mm                          |
| Shank $\varnothing D_s$          | 20 mm                             |
| Thread $\varnothing$             | 26.44 mm                          |
| Thread pitch                     | 1.814 mm                          |
| Threads per inch                 | 14                                |
| Thread size                      | G3/4                              |
| Series                           | Master Tap                        |
| Coating                          | AlTiX                             |
| Thread type                      | G                                 |
| Flank angle                      | 55 °                              |
| 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                      | green                             |
| Type of product                  | Tap                               |

## User data

|                               | Suitability | $V_c$    | ISO code |
|-------------------------------|-------------|----------|----------|
| Alu plastics                  | suitable    | 30 m/min | N        |
| Aluminium (short chipping)    | suitable    | 35 m/min | N        |
| Alu > 10% Si                  | suitable    | 20 m/min | N        |
| Steel < 500 N/mm <sup>2</sup> | suitable    | 30 m/min | P        |
| Steel < 750 N/mm <sup>2</sup> | suitable    | 30 m/min | P        |

|                                |          |          |   |
|--------------------------------|----------|----------|---|
| Steel < 900 N/mm <sup>2</sup>  | suitable | 25 m/min | P |
| Steel < 1100 N/mm <sup>2</sup> | suitable | 12 m/min | P |
| Steel < 1400 N/mm <sup>2</sup> | suitable | 8 m/min  | P |
| INOX < 900 N/mm <sup>2</sup>   | suitable | 10 m/min | M |
| INOX > 900 N/mm <sup>2</sup>   | suitable | 8 m/min  | M |
| GG(G)                          | suitable | 20 m/min | K |
| CuZn                           | suitable | 20 m/min | N |
| Uni                            | suitable |          |   |
| Oil                            | suitable |          |   |
| wet maximum                    | suitable |          |   |