

Garant
GARANT Master Tap machine tap HSS-E-PM, ALTiX, UNC: 12-24

Order data

Order number	137870 12-24
GTIN	4045197901552
Item class	111

Description
Version:

GARANT Master Tap Universal tap, 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 UNC uniform coarse threads ASME – B1.1.

Thread type: UNC

Tool material: HSS E PM

Standard: DIN 371

Threads per inch: 24

Thread Ø: 5.49 mm

Overall length L: 80 mm

Shank Ø D_s: 6 mm

Shank square □: 4.9 mm

Tapping hole Ø: 4.5 mm

Technical description

Number of cutting edges Z	2
Standard	DIN 371
Tapping hole Ø	4.5 mm
Thread pitch	1.058 mm
Number of clamping slots	2

Shank $\varnothing D_s$	6 mm
Threads per inch	24
Shank square \square	4.9 mm
Tool material	HSS E PM
Thread \varnothing	5.49 mm
Overall length L	80 mm
Thread type	UNC
Thread depth	13.7 mm
Thread size	12-24 UNC
Series	Master Tap
Coating	AlTiX
Flank angle	60°
Tolerance class	2BX
Taper lead form	C
Helix angle	40°
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
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 ²	suitable	30 m/min	P
Steel < 750 N/mm ²	suitable	30 m/min	P
Steel < 900 N/mm ²	suitable	25 m/min	P
Steel < 1100 N/mm ²	suitable	12 m/min	P
Steel < 1400 N/mm ²	suitable only under restricted conditions	8 m/min	P
INOX < 900 N/mm ²	suitable	10 m/min	M
INOX > 900 N/mm ²	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		