

**Garant**
**Machine tap for synchronised spindles HSS-E-PM Form E, DLC, G: G3/8**

**Order data**

Order number	137345 G3/8
GTIN	4045197705587
Item class	11H

**Description**
**Version:**

**Sturdy version with right-hand helix and shank to DIN 1835-B.** Special geometry for use on machines with **synchronised spindle drives**. The tap is controlled by the synchronising spindle of the machine. With the latest generation of special **DLC coating sp<sup>2</sup>**. For use with **emulsion** (fat content minimum 8%).

**Form E** (lead chamfer: 1.5 - 2 turns) for the deepest possible thread depths.

**Application:**

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

**Note:**

**For use on synchronised spindles**, the **GARANT** quick-change tapping chuck **No. 338100 – 338121 with minimum length adjustment (MLA)** ensures very high process reliability.

Tool material: HSS E PM

Threads per inch: 19

Thread Ø: 16.66 mm

Overall length L: 100 mm

Shank Ø D<sub>s</sub>: 12 mm

Shank square □: 9 mm

Tapping hole Ø: 15.25 mm

**Technical description**

Tapping hole Ø	15.25 mm
Threads per inch	19
Number of clamping slots	4
Thread Ø	16.66 mm

Number of cutting edges Z	4
Thread pitch	1.337 mm
Tool material	HSS E PM
Shank $\varnothing D_s$	12 mm
Overall length L	100 mm
Shank square $\square$	9 mm
Thread depth	41.65 mm
Thread size	G3/8
Coating	DLC
Thread type	G
Flank angle	55 °
Standard	Manufacturer's standard
Taper lead form	E
Helix angle	40 °
Shank	DIN 1835 B to h6
Through-coolant	no
Application for type of drilling	up to 2.5×D for blind holes
Cutting direction	right-hand
Shank tolerance	h6
Type of threading tool	Machine tap for synchronous machining
Colour ring	yellow
Type of product	Tap

## User data

	Suitability	$V_c$	ISO code
Aluminium	suitable	30 m/min	N
Aluminium (short chipping)	suitable	35 m/min	N

Alu > 10% Si	suitable	20 m/min	N
PMMA acrylic	suitable	25 m/min	N
PA 66 GF30	suitable only under restricted conditions	20 m/min	N
PTFE CF25	suitable	25 m/min	N
Cu	suitable	55 m/min	N
CuZn	suitable	35 m/min	N
wet maximum	suitable		
wet minimum	suitable		
Air	suitable		