⚙ Hoffmann Group

Garant

Machine tap for synchronised spindles HSS-E-PM Form E, DLC, G: G1/2

Order data

Order number	137345 G1/2
GTIN	4045197705594
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**^{2}. 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: 14
Thread Ø: 20.96 mm
Overall length L: 125 mm
Shank Ø D_s: 16 mm
Shank square □: 12 mm
Tapping hole Ø: 19 mm

Technical description

Number of clamping slots	5
Thread Ø	20.96 mm
Threads per inch	14
Number of cutting edges Z	5

Thread pitch	1.814 mm
Tapping hole Ø	19 mm
Tool material	HSS E PM
Shank Ø D_s	16 mm
Overall length L	125 mm
Shank square □	12 mm
Thread depth	52.4 mm
Thread size	G1/2
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

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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		