Garant

GARANT Master Tap INOX machine tap HSS-E-PM, TiAlN, UNF: 1-12

Order data

Order number	138007 1-12
GTIN	4062406210298
Item class	11l

Description

Version:
GARANT Master Tap INOX:
High-performance tap, specially developed for **good process reliability in stainless and acid-resistant steels** and **duplex materials.**
The 45° helix angle of the chip flutes facilitates chip formation especially in ductile austenitic CrNi steels.
· **HSS-E-PM tool material for maximum wear resistance**
· **The latest generation of TiALN multi-layer coating**
· **Parameterised flute geometry for optimum chip formation and torsional rigidity**
Application:
For UNF uniform fine threads ASME – B1.1.
Thread type: UNF
Tool material: HSS E PM
Standard: DIN 374
Threads per inch: 12
Thread ∅: 25.4 mm
Overall length L: 140 mm
Shank ∅ D_s: 18 mm
Shank square ☐: 14.5 mm
Tapping hole ∅: 23.25 mm

Technical description

Shank ∅ D_s	18 mm
Shank square ☐	14.5 mm

Standard	DIN 374
Number of cutting edges Z	5
Overall length L	140 mm
Tool material	HSS E PM
Threads per inch	12
Tapping hole ∅	23.25 mm
Thread ∅	25.4 mm
Thread type	UNF
Thread depth	63.5 mm
Number of clamping slots	5
Thread pitch	2.117 mm
Thread size	1-12 UNF
Series	Master Tap
Coating	TiAlN
Flank angle	60 °
Tolerance class	2BX
Taper lead form	C
Helix angle	45 °
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	blue
Type of product	Tap

User data

	Suitability	V_c	ISO code

Aluminium (short chipping)	suitable only under restricted conditions	28 m/min	N
Steel < 750 N/mm²	suitable only under restricted conditions	23 m/min	P
Steel < 900 N/mm²	suitable only under restricted conditions	23 m/min	P
Steel < 1100 N/mm²	suitable	12 m/min	P
INOX < 900 N/mm²	suitable	11 m/min	M
INOX > 900 N/mm²	suitable	9 m/min	M
Oil	suitable		
wet maximum	suitable		