

Garant
GARANT Master Tap INOX machine tap HSS-E-PM, TiAlN, UNF: 12-28

Order data

Order number	138007 12-28
GTIN	4062406210205
Item class	111

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 371

Threads per inch: 28

Thread Ø: 5.49 mm

Overall length L: 80 mm

Shank Ø D_s: 6 mm

Shank square □: 4.9 mm

Tapping hole Ø: 4.7 mm

Technical description

Overall length L	80 mm
Shank Ø D _s	6 mm
Threads per inch	28

Number of clamping slots	3
Thread depth	13.7 mm
Thread Ø	5.49 mm
Thread size	12-28 UNF
Tapping hole Ø	4.7 mm
Standard	DIN 371
Shank square □	4.9 mm
Tool material	HSS E PM
Number of cutting edges Z	3
Thread pitch	0.907 mm
Thread type	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/mm ²	suitable only under restricted conditions	23 m/min	P
Steel < 900 N/mm ²	suitable only under restricted conditions	23 m/min	P
Steel < 1100 N/mm ²	suitable	12 m/min	P
INOX < 900 N/mm ²	suitable	11 m/min	M
INOX > 900 N/mm ²	suitable	9 m/min	M
Oil	suitable		
wet maximum	suitable		