Data sheet

Garant

GARANT Master Tap Alu machine tap, DLC, G: G1/8

Order data

Order number	137310 G1/8
GTIN	4067263829829
Item class	11l

Description

Version:
High-performance tap, specially developed for **aluminium and non-ferrous alloys. Dynamic helical pitch** of the clamping slots ensures **optimum chip evacuation** and **process reliability.**
· **HSS-E-PM tool material for high cutting edge stability.**
· **Ultra-smooth DLC coating for wear resistance and avoidance of edge build-up.**
· **Dynamic helical pitch of the flutes.**
· **Short lead chamfer form E.**
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Application:
For Whitworth parallel pipe threads DIN-ISO 228/1 (threads that do not form a seal within the connection).

Technical description

Threads per inch	28
Overall length L	90 mm
Tapping hole ∅	8.8 mm
Shank ∅ D_s	7 mm
Thread size	G1/8
Tool material	HSS E PM
Number of clamping slots	3
Shank square ☐	5.5 mm
Thread depth	24.33 mm

Number of cutting edges Z	3
Thread ∅	9.73 mm
Thread pitch	0.907 mm
Helix angle characteristic	unequal spacing
Series	Master Tap
Coating	DLC
Thread type	G
Flank angle	55 degrees
Standard	DIN 5156
Tolerance class	ISO 228
Taper lead form	E
Helix angle	45 degrees
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
Shank tolerance	h9
Type of threading tool	Machine tap for dynamic machining
Type of product	Taps

User data

	Suitability	V_c	ISO code
Aluminium	suitable	35 m/min	N
Aluminium (short chipping)	suitable	32 m/min	N
Alu > 10% Si	suitable	20 m/min	N
PMMA acrylic	suitable only under restricted conditions	20 m/min	N
PA 66	suitable only under restricted conditions	18 m/min	N

PEEK	suitable	18 m/min	N
Cu	suitable	18 m/min	N
CuZn	suitable	25 m/min	N
Oil	suitable		
wet maximum	suitable		
wet minimum	suitable		