Garant

Machine tap for synchronised spindles HSS-E-PM IC / Form C, TiAlN, G: G1/8

Order data

Order number	137816 G1/8
GTIN	4045197705785
Item class	11H

Description

Version:
Sturdy version with right-hand helix and shank to DIN 1835-B. Special geometry for **general-purpose use** on machines with **synchronised spindle drive.** The tap is controlled by the synchronising spindle of the machine. Special **TiAlN-S coating** for optimum tool life. For use with **emulsion** (fat content minimum 8%).
With **internal coolant supply** for maximum tool life.
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: 28
Thread ∅: 9.73 mm
Overall length L: 90 mm
Shank ∅ D_s: 8 mm
Shank square ☐: 6.2 mm
Tapping hole ∅: 8.8 mm

Technical description

Tapping hole ∅	8.8 mm
Number of cutting edges Z	3
Number of clamping slots	3
Thread ∅	9.73 mm

Thread pitch	0.907 mm
Threads per inch	28
Tool material	HSS E PM
Shank ⌀ D_s	8 mm
Overall length L	90 mm
Shank square ☐	6.2 mm
Thread depth	29.19 mm
Thread size	G1/8
Coating	TiAlN
Thread type	G
Flank angle	55 °
Standard	Manufacturer's standard
Taper lead form	C
Helix angle	40 °
Shank	DIN 1835 B with h6
Through-coolant	yes
Application for type of drilling	up to 3×D for blind holes
Cutting direction	right-hand
Shank tolerance	h6
Type of threading tool	Machine tap for synchronous machining
Colour ring	green
Type of product	Tap

User data

	Suitability	V_c	ISO code
Alu plastics	suitable only under restricted conditions	32 m/min	N
Aluminium (short chipping)	suitable	32 m/min	N

Steel < 500 N/mm²	suitable	33 m/min	P
Steel < 750 N/mm²	suitable	32 m/min	P
Steel < 900 N/mm²	suitable	20 m/min	P
Steel < 1100 N/mm²	suitable	12 m/min	P
Steel < 1400 N/mm²	suitable	7 m/min	P
INOX < 900 N/mm²	suitable	11 m/min	M
INOX > 900 N/mm²	suitable	9 m/min	M
CuZn	suitable only under restricted conditions	30 m/min	N
Uni	suitable		
Oil	suitable		
wet maximum	suitable		
wet minimum	suitable		