

Garant
GARANT Master Tap INOX machine tap HSS-E-PM, TiAlN, UNF: 1/4-28

Order data

Order number	133406 1/4-28
GTIN	4062406209704
Item class	111

Description
Version:

High-performance tap, specially developed for **good process reliability in stainless and acid-resistant steels** and **duplex materials**.

- **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: 6.35 mm

Overall length L: 80 mm

Shank Ø D_s: 7 mm

Shank square □: 5.5 mm

Tapping hole Ø: 5.5 mm

Technical description

Thread depth	19.05 mm
Thread size	1/4-28 UNF
Number of cutting edges Z	3
Thread type	UNF
Shank square □	5.5 mm

Standard	DIN 371
Shank $\varnothing D_s$	7 mm
Threads per inch	28
Tapping hole \varnothing	5.5 mm
Thread \varnothing	6.35 mm
Overall length L	80 mm
Number of clamping slots	3
Thread pitch	0.907 mm
Tool material	HSS E PM
Series	Master Tap
Coating	TiAlN
Flank angle	60°
Tolerance class	2BX
Taper lead form	B
Shank	Plain shank with h9
Through-coolant	no
Application for type of drilling	up to 3×D for through 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		