

Garant
GARANT Master Tap machine tap HSS-E-PM, ALTiX, UNC: 1/4-20

Order data

Order number	133360 1/4-20
GTIN	4045197901682
Item class	11I

Description
Version:

GARANT Master Tap universal taps, designed for use in a wide spectrum of materials with high process reliability.

- **HSS-E-PM tool material for maximum wear resistance.**
- **Reduced coefficient of friction due to the new high-performance coating.**
- **Special geometry for optimum swarf evacuation.**

Application:

For UNC uniform coarse threads ASME – B1.1.

Thread type: UNC

Tool material: HSS E PM

Standard: DIN 371

Threads per inch: 20

Thread Ø: 6.35 mm

Overall length L: 80 mm

Shank Ø D_s: 7 mm

Shank square □: 5.5 mm

Tapping hole Ø: 5.1 mm

Technical description

Thread pitch	1.27 mm
Tapping hole Ø	5.1 mm
Tool material	HSS E PM
Number of cutting edges Z	3
Shank square □	5.5 mm

Thread size	1/4-20 UNC
Shank $\varnothing D_s$	7 mm
Thread \varnothing	6.35 mm
Number of clamping slots	3
Standard	DIN 371
Thread depth	19.05 mm
Threads per inch	20
Overall length L	80 mm
Thread type	UNC
Series	Master Tap
Coating	AlTiX
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	green
Type of product	Tap

User data

	Suitability	V_c	ISO code
Alu plastics	suitable	30 m/min	N
Aluminium (short chipping)	suitable	35 m/min	N
Alu > 10% Si	suitable	20 m/min	N
Steel < 500 N/mm ²	suitable	30 m/min	P

Steel < 750 N/mm ²	suitable	30 m/min	P
Steel < 900 N/mm ²	suitable	25 m/min	P
Steel < 1100 N/mm ²	suitable	12 m/min	P
Steel < 1400 N/mm ²	suitable	8 m/min	P
INOX < 900 N/mm ²	suitable	10 m/min	M
INOX > 900 N/mm ²	suitable	8 m/min	M
GG(G)	suitable	20 m/min	K
CuZn	suitable	20 m/min	N
Uni	suitable		
Oil	suitable		
wet maximum	suitable		