

**Garant**
**GARANT Master Tap INOX machine tap HSS-E-PM, TiAlN, UNF: 7/8-14**

**Order data**

Order number	133406 7/8-14
GTIN	4062406209773
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 374

Threads per inch: 14

Thread Ø: 22.23 mm

Overall length L: 125 mm

Shank Ø D<sub>s</sub>: 18 mm

Shank square □: 14.5 mm

Tapping hole Ø: 20.4 mm

**Technical description**

Number of cutting edges Z	4
Thread Ø	22.23 mm
Number of clamping slots	4
Shank square □	14.5 mm

Shank $\varnothing D_s$	18 mm
Tool material	HSS E PM
Thread depth	66.69 mm
Standard	DIN 374
Threads per inch	14
Overall length L	125 mm
Thread type	UNF
Tapping hole $\varnothing$	20.4 mm
Thread pitch	1.814 mm
Thread size	7/8-14 UNF
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 <sup>2</sup>	suitable only under restricted conditions	23 m/min	P

Steel < 900 N/mm <sup>2</sup>	suitable only under restricted conditions	23 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	12 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	11 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	9 m/min	M
Oil	suitable		
wet maximum	suitable		