

Garant
GARANT Master Tap INOX machine tap HSS-E-PM Form E 6HX, TiAlN, M: M4

Order data

Order number	135736 M4
GTIN	4062406081577
Item class	111

Description
Version:

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

The 45° helix angle of the flutes facilitates chip formation especially in ductile austenitic CrNi steels.

- **HSS-E-PM tool material for a high degree of wear resistance**
- **The latest generation of TiAlN multi-layer coating**
- **Parameterised flute geometry for optimum chip formation and torsional rigidity**

Form E (lead chamfer: 1.5 - 2 turns).

Thread type: M

Tool material: HSS E PM

Standard: DIN 371

Tolerance class: ISO 2X 6HX

Thread pitch: 0.7 mm

Overall length L: 63 mm

Shank Ø D_s: 4.5 mm

Shank square □: 3.4 mm

Tapping hole Ø: 3.3 mm

Technical description

Overall length L	63 mm
Tool material	HSS E PM
Thread type	M
Standard	DIN 371

Number of clamping slots	3
Thread depth	10 mm
Thread Ø	4 mm
Tapping hole Ø	3.3 mm
Tolerance class	ISO 2X 6HX
Shank square □	3.4 mm
Shank Ø D _s	4.5 mm
Number of cutting edges Z	3
Thread pitch	0.7 mm
Thread size	M4
Coating	TiAlN
Flank angle	60°
Thread standard	DIN 13
Taper lead form	E
Helix angle	45°
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
Series	Master Tap
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		