

Garant

GARANT Master Tap INOX machine tap extra long HSS-E-PM Form C 6HX, TiAlN, M: M6



Order data

| | |
|--------------|---------------|
| Order number | 135739 M6 |
| GTIN | 4062406209926 |
| 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**

With extra long shank. Shank to DIN 371.

Advantage:

Designed for tapping threads where access is difficult.

Technical description

| | |
|---------------------------|--------|
| Overall length L | 160 mm |
| Number of cutting edges Z | 3 |
| Tapping hole Ø | 5 mm |
| Number of clamping slots | 3 |
| Thread Ø | 6 mm |
| Shank Ø D _s | 6 mm |
| Shank square □ | 4.9 mm |
| Thread pitch | 1 mm |

| | |
|----------------------------------|-----------------------------------|
| Thread size | M6 |
| Tolerance class | ISO 2X 6HX |
| Thread type | M |
| Tool material | HSS E PM |
| Thread depth | 15 mm |
| Standard | Manufacturer's standard |
| Coating | TiAlN |
| Flank angle | 60 degrees |
| Thread standard | DIN 13 |
| Taper lead form | C |
| Helix angle | 45 degrees |
| Shank | Plain shank with h9 |
| Through-coolant | no |
| Application for type of drilling | up to 2.5×D for blind 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 | 20 m/min | N |
| Steel < 750 N/mm ² | suitable only under restricted conditions | 16 m/min | P |
| Steel < 900 N/mm ² | suitable only under restricted conditions | 16 m/min | P |
| Steel < 1100 N/mm ² | suitable | 8 m/min | P |
| INOX < 900 N/mm ² | suitable | 7 m/min | M |

| | | | |
|------------------------------|----------|---------|---|
| INOX > 900 N/mm ² | suitable | 6 m/min | M |
| Oil | suitable | | |
| wet maximum | suitable | | |