

## Garant

### GARANT Master Tap INOX machine tap extra long HSS-E-PM Form C 6HX, TiAlN, M: M10



#### Order data

Order number	135739 M10
GTIN	4062406209940
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

Thread Ø	10 mm
Thread depth	25 mm
Shank Ø D <sub>s</sub>	10 mm
Number of clamping slots	3
Tool material	HSS E PM
Tapping hole Ø	8.5 mm
Standard	Manufacturer's standard
Thread size	M10

Number of cutting edges Z	3
Thread type	M
Shank square □	8 mm
Thread pitch	1.5 mm
Overall length L	200 mm
Tolerance class	ISO 2X 6HX
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 <sub>c</sub>	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	20 m/min	N
Steel < 750 N/mm <sup>2</sup>	suitable only under restricted conditions	16 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable only under restricted conditions	16 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	8 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	7 m/min	M

INOX > 900 N/mm <sup>2</sup>	suitable	6 m/min	M
Oil	suitable		
wet maximum	suitable		