

**Garant****GARANT Master Tap machine tap extra long HSS-E-PM 6HX, AlTiX, MF: 10X1,25****Order data**

Order number	137162 10X1,25
GTIN	4062406209056
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.**

With extra long shank.

**Advantage:**

Designed for tapping threads where access is difficult.

**Technical description**

Thread type	MF
Thread size	M10×1.25
Tool material	HSS E PM
Number of clamping slots	3
Overall length L	200 mm
Tapping hole Ø	8.8 mm
Thread Ø	10 mm
Thread depth	25 mm
Thread pitch	1.25 mm
Tolerance class	ISO 2X 6HX

Shank $\varnothing D_s$	7 mm
Shank square $\square$	5.5 mm
Standard	Manufacturer's standard
Number of cutting edges Z	3
Coating	AlTiX
Flank angle	60 degrees
Thread standard	DIN 13
Taper lead form	C
Helix angle	40 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	green
Series	Master Tap
Type of product	Tap

## User data

	Suitability	$V_c$	ISO code
Alu plastics	suitable	24 m/min	N
Aluminium (short chipping)	suitable	28 m/min	N
Alu > 10% Si	suitable	16 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	24 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	24 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	20 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	10 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	6 m/min	P

INOX < 900 N/mm <sup>2</sup>	suitable	8 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	6 m/min	M
GG(G)	suitable	16 m/min	K
CuZn	suitable	16 m/min	N
Uni	suitable		
Oil	suitable		
wet maximum	suitable		