

## Garant

### GARANT Master Tap SteelHT machine tap HSS-E-PM Form C 6HX, TiAlN, MF: 30X1,5



#### Order data

Order number	136350 30X1,5
GTIN	4062406237431
Item class	11I

#### Description

##### Version:

High-performance tap, specially developed for use in **steels with high tensile strength** and for **difficult-to-machine materials**. Sturdy design with **optimised guide thread to avoid chips jamming**.

- **HSS-E-PM tool material – for very high cutting edge stability.**
- **Optimised honed cutting edges.**
- **TiAlN coating – for maximum wear protection.**

##### Recommendation:

For **TOOLOX materials** we recommend deviating from the **DIN data** (see table) **by selecting a larger tapping hole  $\varnothing$** .

##### Note:

For **TOOLOX materials**: do not exceed the maximum thread depth of  $2 \times D$ !

#### Technical description

Standard	DIN 374
Thread size	M30x1.5
Thread depth	75 mm
Shank square $\square$	18 mm
Tapping hole $\varnothing$	28.5 mm
Thread $\varnothing$	30 mm
Shank $\varnothing D_s$	22 mm

Tool material	HSS E PM
Tolerance class	ISO 2X 6HX
Overall length L	150 mm
Thread pitch	1.5 mm
Thread type	MF
Number of cutting edges Z	4
Number of clamping slots	4
Coating	TiAlN
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 2xD for blind holes
Cutting direction	right-hand
Type of threading tool	Machine tap for dynamic machining
Colour ring	red
Series	Master Tap
Type of product	Tap

## User data

	Suitability	V <sub>c</sub>	ISO code
Steel < 750 N/mm <sup>2</sup>	suitable only under restricted conditions	30 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	20 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	15 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable		

Steel < 50 HRC	Suitable only under restricted conditions		
TOOLOX 33	suitable	15 m/min	H
TOOLOX 44	suitable		
INOX > 900 N/mm <sup>2</sup>	suitable		
Ti > 850 N/mm <sup>2</sup>	Suitable only under restricted conditions		
Oil	suitable		
wet maximum	suitable		