Garant

GARANT Master Tap SteelHT machine tap HSS-E-PM Form B 6GX, TiCN, M: M14

Order data

Order number	131946 M14
GTIN	4062406236328
Item class	11l

Description

Version:
High-performance tap, specially developed for use in **steels with high tensile strength** and for **difficult-to-machine materials. Strong spiral point,** for process stability at high cutting forces.
· **HSS-E-PM tool material – for very high cutting edge stability.**
· **Optimised honed cutting edges.**
· **TiCN coating – for maximum wear protection.**
Tolerance class: ISO 3X/6GX.
Application:
For components which are galvanised or shrink slightly when hardened.
Recommendation:
For **TOOLOX and HARDOX materials we recommend deviating from the DIN data** (see table) by **selecting a larger tapping hole ∅.**
Thread type: M
Tool material: HSS E PM
Standard: DIN 376
Tolerance class: ISO 3X 6GX
Thread pitch: 2 mm
Overall length L: 110 mm
Shank ∅ D_s: 11 mm
Shank square □: 9 mm
Tapping hole ∅: 12 mm

Technical description

Tolerance class	ISO 3X 6GX

Shank ⌀ D_s	11 mm
Thread ⌀	14 mm
Thread depth	42 mm
Overall length L	110 mm
Number of cutting edges Z	3
Standard	DIN 376
Number of clamping slots	3
Tapping hole ⌀	12 mm
Thread type	M
Tool material	HSS E PM
Thread pitch	2 mm
Thread size	M14
Shank square ☐	9 mm
Coating	TiCN
Flank angle	60 °
Thread standard	DIN 13
Taper lead form	B
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	red
Series	Master Tap
Type of product	Tap

User data

	Suitability	V_c	ISO code

Steel < 750 N/mm²	suitable only under restricted conditions	30 m/min	P
Steel < 900 N/mm²	suitable	20 m/min	P
Steel < 1100 N/mm²	suitable	15 m/min	P
Steel < 1400 N/mm²	suitable		
Steel < 50 HRC	suitable only under restricted conditions		
TOOLOX 33	suitable	15 m/min	H
TOOLOX 44	suitable		
HARDOX 500 < 1600 N/mm²	suitable only under restricted conditions		
INOX > 900 N/mm²	suitable		
Ti > 850 N/mm²	suitable only under restricted conditions		
Oil	suitable		
wet maximum	suitable		