Garant

GARANT Master Tap SteelHT machine tap HSS-E-PM Form C 6HX, TiAlN, MF: 14X1,5

Order data

Order number	136350 14X1,5
GTIN	4062406237363
Item class	11l

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 ⌀.**
Note:
For **TOOLOX materials:** do not exceed the maximum thread depth of 2×D!

Technical description

Tapping hole ⌀	12.5 mm
Shank square ☐	9 mm
Shank ⌀ D_s	11 mm
Thread ⌀	14 mm
Thread depth	35 mm
Number of clamping slots	3
Standard	DIN 374

Overall length L	100 mm
Number of cutting edges Z	3
Thread type	MF
Tool material	HSS E PM
Thread size	M14×1.5
Thread pitch	1.5 mm
Tolerance class	ISO 2X 6HX
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 2×D 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_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		
INOX > 900 N/mm²	suitable		
Ti > 850 N/mm²	Suitable only under restricted conditions		
Oil	suitable		
wet maximum	suitable		