

Garant**GARANT Master Tap SteelHT machine tap HSS-E-PM Form C 6GX, TiAlN, M: M10****Order data**

Order number	135374 M10
GTIN	4062406237042
Item class	111

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.**

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 \varnothing** .

Note:

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

Technical description

Thread size	M10
Thread type	M
Standard	DIN 371
Tool material	HSS E PM
Number of clamping slots	3

Shank $\varnothing D_s$	10 mm
Thread \varnothing	10 mm
Shank square \square	8 mm
Thread depth	25 mm
Overall length L	100 mm
Tapping hole \varnothing	8.5 mm
Number of cutting edges Z	3
Thread pitch	1.5 mm
Tolerance class	ISO 3X 6GX
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_c	ISO code
Steel < 750 N/mm ²	suitable only under restricted conditions	30 m/min	P
Steel < 900 N/mm ²	suitable	20 m/min	P
Steel < 1100 N/mm ²	suitable	15 m/min	P

Steel < 1400 N/mm ²	suitable	12 m/min	P
Steel < 50 HRC	suitable only under restricted conditions		
TOOLOX 33	suitable	15 m/min	H
TOOLOX 44	suitable		
INOX > 900 N/mm ²	suitable		
Ti > 850 N/mm ²	suitable only under restricted conditions		
Oil	suitable		
wet maximum	suitable		