Garant

GARANT Master Tap SteelHT machine tap HSS-E-PM Form B 6GX, TiCN, M: M6

Order data

Order number	131946 M6
GTIN	4062406236281
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 371
Tolerance class: ISO 3X 6GX
Thread pitch: 1 mm
Overall length L: 80 mm
Shank ∅ D_s: 6 mm
Shank square ☐: 4.9 mm
Tapping hole ∅: 5 mm

Technical description

Thread type	M
Thread depth	18 mm

Tool material	HSS E PM
Tolerance class	ISO 3X 6GX
Number of clamping slots	3
Shank square ☐	4.9 mm
Thread size	M6
Thread pitch	1 mm
Tapping hole ∅	5 mm
Shank ∅ D_s	6 mm
Standard	DIN 371
Overall length L	80 mm
Thread ∅	6 mm
Number of cutting edges Z	3
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		