

Garant**GARANT Master Tap SteelHT machine tap HSS-E-PM Form C 6HX, TiAlN, MF: 16X1,5****Order data**

| | |
|--------------|---------------|
| Order number | 136350 16X1,5 |
| GTIN | 4062406237370 |
| 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

| | |
|--------------------------|----------|
| Thread depth | 40 mm |
| Thread type | MF |
| Overall length L | 100 mm |
| Number of clamping slots | 3 |
| Tool material | HSS E PM |
| Thread pitch | 1.5 mm |
| Shank $\varnothing D_s$ | 12 mm |

| | |
|----------------------------------|-----------------------------------|
| Tolerance class | ISO 2X 6HX |
| Number of cutting edges Z | 3 |
| Tapping hole Ø | 14.5 mm |
| Shank square □ | 9 mm |
| Thread size | M16×1.5 |
| Thread Ø | 16 mm |
| Standard | DIN 374 |
| 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/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 | | |

| | | | |
|------------------------------|---|----------|---|
| 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 | | |