

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

Order data

Order number	131940 M6
GTIN	4062406236175
Item class	111

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.**

Recommendation:

For **TOOLOX** and **HARDOX** materials we recommend deviating from the **DIN data** (see table) by **selecting a larger tapping hole \varnothing** .

Thread type: M

Tool material: HSS E PM

Standard: DIN 371

Tolerance class: ISO 2X 6HX

Thread pitch: 1 mm

Overall length L: 80 mm

Shank $\varnothing D_s$: 6 mm

Shank square \square : 4.9 mm

Tapping hole \varnothing : 5 mm

Technical description

Tapping hole \varnothing	5 mm
Thread depth	18 mm
Standard	DIN 371
Thread type	M

Shank square <input type="checkbox"/>	4.9 mm
Thread pitch	1 mm
Overall length L	80 mm
Number of clamping slots	3
Shank $\varnothing D_s$	6 mm
Tool material	HSS E PM
Thread \varnothing	6 mm
Tolerance class	ISO 2X 6HX
Number of cutting edges Z	3
Thread size	M6
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/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		
HARDOX 500 < 1600 N/mm ²	suitable only under restricted conditions		
INOX > 900 N/mm ²	suitable		
Ti > 850 N/mm ²	suitable only under restricted conditions		
Oil	suitable		
wet maximum	suitable		