

**Garant**
**GARANT Master Tap SteelHT machine tap HSS-E-PM Form B 6HX, TiCN, MF: 30X1,5**

**Order data**

Order number	132855 30X1,5
GTIN	4062406236694
Item class	11I

**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  $\varnothing$ .

**Technical description**

Shank $\varnothing D_s$	22 mm
Thread pitch	1.5 mm
Overall length L	150 mm
Tolerance class	ISO 2X 6HX
Thread $\varnothing$	30 mm
Thread type	MF
Tapping hole $\varnothing$	28.5 mm
Number of cutting edges Z	4
Number of clamping slots	4

Tool material	HSS E PM
Thread depth	90 mm
Standard	DIN 374
Shank square <input type="checkbox"/>	18 mm
Coating	TiCN
Flank angle	60 degrees
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 <sub>c</sub>	ISO code
Steel < 750 N/mm <sup>2</sup>	Suitable only under restricted conditions	30 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	20 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	15 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	12 m/min	P
Steel < 50 HRC	Suitable only under restricted conditions		
TOOLOX 33	suitable	15 m/min	H
TOOLOX 44	suitable		
HARDOX 500 < 1600 N/mm <sup>2</sup>	suitable only under restricted conditions		

INOX > 900 N/mm <sup>2</sup>	suitable
Ti > 850 N/mm <sup>2</sup>	suitable only under restricted conditions
Oil	suitable
wet maximum	suitable