

**Garant**
**GARANT Master Tap machine tap HSS-E-PM 6HX, AlTiX, MF: 18X1**

**Order data**

Order number	137160 18X1
GTIN	4062406281212
Item class	11I

**Description**
**Version:**

**GARANT Master Tap Universal taps**, designed for use in a wide spectrum of materials with high process reliability.

- **HSS-E-PM tool material for maximum wear resistance.**
- **Reduced coefficient of friction due to the new high-performance coating.**
- **Special geometry for optimum swarf evacuation.**

**Technical description**

Tolerance class	ISO 2X 6HX
Thread size	M18x1
Thread Ø	18 mm
Number of cutting edges Z	4
Tool material	HSS E PM
Tapping hole Ø	17 mm
Standard	DIN 374
Overall length L	110 mm
Thread pitch	1 mm
Shank square □	11 mm
Number of clamping slots	4
Shank Ø D <sub>s</sub>	14 mm

Thread type	MF
Thread depth	45 mm
Coating	AlTiX
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 2.5×D for blind holes
Cutting direction	right-hand
Type of threading tool	Machine tap for dynamic machining
Colour ring	green
Series	Master Tap
Type of product	Tap

## User data

	Suitability	V <sub>c</sub>	ISO code
Alu plastics	suitable	30 m/min	N
Aluminium (short chipping)	suitable	35 m/min	N
Alu > 10% Si	suitable	20 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	30 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	30 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	25 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	12 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	8 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	10 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	8 m/min	M

GG(G)	suitable	20 m/min	K
CuZn	suitable	20 m/min	N
Uni	suitable		
Oil	suitable		
wet maximum	suitable		