Garant

Synchronised fluteless machine tap with oil grooves Solid carbide, TiAlN, M: M4

Order data

Order number	139242 M4
GTIN	4045197273475
Item class	11H

Description

Version:
Special polygon geometry and shank to DIN 6535-HA for use on machines with **synchronised spindle drives. With oil grooves; optimal lubrication effect even in deeper threads.**
Special solid carbide tool material for high cutting speeds and long tool life. **TiAlN and anti-friction coating** ensure low wear and low tendency to edge build-up.
Note:
For use on synchronised spindles, the **GARANT** quick-change tapping chuck **No. 338100 – 338121 with minimum length adjustment (MLA)** ensures very high process reliability.
Tolerance class: ISO 2X 6HX
Thread pitch: 0.7 mm
Overall length L: 63 mm
Shank ⌀ D_s: 6 mm
Shank square ☐: 4.9 mm
Tapping hole ⌀ guide value: 3.7 mm

Technical description

Number of cutting edges Z	5
Thread ⌀	4 mm
Thread pitch	0.7 mm
Number of clamping slots	5
Shank ⌀ D_s	6 mm

Shank square ☐	4.9 mm
Overall length L	63 mm
Tapping hole ∅ guide value	3.7 mm
Tolerance class	ISO 2X 6HX
Thread depth	12 mm
Thread size	M4
Coating	TiAlN
Thread type	M
Flank angle	60 °
Tool material	Solid carbide
Standard	Manufacturer's standard
Thread standard	DIN 13
Taper lead form	C
Shank	DIN 6535 HA with h6
Through-coolant	no
Application for type of drilling	up to 3×D for blind holes
Application for type of drilling	up to 3×D for through holes
Cutting direction	right-hand
Shank tolerance	h6
Colour ring	without
Type of product	Fluteless tap

User data

	Suitability	V_c	ISO code
Alu plastics	suitable	50 m/min	N
Aluminium (short chipping)	suitable	50 m/min	N
Alu > 10% Si	suitable only under restricted conditions	48 m/min	N

Steel < 500 N/mm²	suitable	52 m/min	P
Steel < 750 N/mm²	suitable	48 m/min	P
Steel < 900 N/mm²	suitable	45 m/min	P
Steel < 1100 N/mm²	suitable	40 m/min	P
Steel < 1400 N/mm²	suitable	33 m/min	P
Oil	suitable		
wet maximum	suitable		