Garant

Synchronised fluteless machine tap with oil grooves Solid carbide IC, TiAlN, M: M10

Order data

Order number	139243 M10
GTIN	4045197365675
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.
With internal coolant supply laterally from the grooves; recommended for through and blind holes.
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: 1.5 mm
Overall length L: 100 mm
Shank ⌀ D_s: 10 mm
Shank square □: 8 mm
Tapping hole ⌀ guide value: 9.35 mm

Technical description

Number of clamping slots	6
Number of cutting edges Z	6
Thread pitch	1.5 mm
Thread ⌀	10 mm

Shank ⌀ D_s	10 mm
Shank square ☐	8 mm
Overall length L	100 mm
Tapping hole ⌀ guide value	9.35 mm
Tolerance class	ISO 2X 6HX
Thread depth	30 mm
Thread size	M10
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	yes
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	53 m/min	N
Aluminium (short chipping)	suitable	53 m/min	N

Alu > 10% Si	suitable only under restricted conditions	50 m/min	N
Steel < 500 N/mm²	suitable	55 m/min	P
Steel < 750 N/mm²	suitable	50 m/min	P
Steel < 900 N/mm²	suitable	47 m/min	P
Steel < 1100 N/mm²	suitable	43 m/min	P
Steel < 1400 N/mm²	suitable	36 m/min	P
Oil	suitable		
wet maximum	suitable		