

**Garant**
**Solid carbide machine tap, TiAlN, MF: 10X1**

**Order data**

Order number	132862 10X1
GTIN	4045197073952
Item class	11H

**Description**
**Version:**

**Particularly sturdy version.** For the highest performance demands.

**Recommendation:**

For **very hard steels, TOOLOX** and **HARDOX materials** we recommend **deviating from the DIN data** (see table) by drilling the tapping hole  $\varnothing$  **0.05** to **0.3mm** larger.

For use only with a length compensation chuck – even on machines with synchronised spindle drives.

Thread type: MF

Tool material: Solid carbide

Standard: DIN 371

Tolerance class: ISO 2X 6HX

Thread pitch: 1 mm

Overall length L: 100 mm

Shank  $\varnothing$  D<sub>s</sub>: 10 mm

Shank square □: 8 mm

Tapping hole  $\varnothing$ : 9 mm

**Technical description**

Thread pitch	1 mm
Tapping hole $\varnothing$	9 mm
Thread $\varnothing$	10 mm
Number of cutting edges Z	5
Number of clamping slots	5
Shank $\varnothing$ D <sub>s</sub>	10 mm

Overall length L	100 mm
Shank square □	8 mm
Tolerance class	ISO 2X 6HX
Tool material	Solid carbide
Standard	DIN 371
Thread depth	20 mm
Thread type	MF
Thread size	M10×1
Coating	TiAlN
Flank angle	60°
Thread standard	DIN 13
Taper lead form	D
Shank	Parallel shank to h6
Through-coolant	no
Application for type of drilling	up to 2×D for blind holes
Application for type of drilling	up to 2×D for through holes
Cutting direction	right-hand
Type of threading tool	Machine tap for dynamic machining
Colour ring	red
Type of product	Tap

## User data

	Suitability	V <sub>c</sub>	ISO code
Steel < 55 HRC	suitable	3 m/min	H
Steel < 60 HRC	suitable	2 m/min	H
Steel < 65 HRC	suitable only under restricted conditions	1 m/min	H
Steel < 67 HRC	suitable only under restricted conditions	1 m/min	H

TOOLOX 33	suitable	5 m/min	H
TOOLOX 44	suitable	4 m/min	H
HARDOX 500 < 1600 N/ mm <sup>2</sup>	suitable	3 m/min	H
Graphite, GRP, CRP	suitable only under restricted conditions	18 m/min	N
Oil	suitable		