Garant

# Machine tap for synchronised spindles HSS-E-PM IC / Form C, DLC, M: M6

## Order data

| | |
|---|---|
| Order number | 134285 M6 |
| GTIN | 4045197649294 |
| Item class | 11H |

## Description

**Version:**
**Sturdy version with right-hand helix and shank to DIN 1835-B.**Special geometry for use on machines with **synchronised spindle drives.** The tap is controlled by the synchronising spindle of the machine. With the latest generation of special **DLC coating sp**$^2$ for optimum tool life. For use with **emulsion** (fat content minimum 8%).
With **internal coolant supply** for maximum tool life.
**Note:**
**For use on synchronised spindles,** the **GARANT** quick-change tapping chuck **No. 338100 – 338121 with minimum length adjustment (MLA)** ensures maximum process reliability.
Thread type: M
Tool material: HSS E PM
Standard: Manufacturer's standard
Tolerance class: ISO 2X 6HX
Thread pitch: 1 mm
Overall length L: 80 mm
Shank ∅ $D_s$: 6 mm
Shank square □: 4.9 mm
Tapping hole ∅: 5 mm

## Technical description

| | |
|---|---|
| Number of cutting edges Z | 3 |
| Number of clamping slots | 3 |
| Thread ∅ | 6 mm |
| Tapping hole ∅ | 5 mm |

| | |
|---|---|
| Thread pitch | 1 mm |
| Standard | Manufacturer's standard |
| Shank ⌀ $D_s$ | 6 mm |
| Overall length L | 80 mm |
| Shank square ☐ | 4.9 mm |
| Tolerance class | ISO 2X 6HX |
| Tool material | HSS E PM |
| Thread depth | 15 mm |
| Thread type | M |
| Thread size | M6 |
| Coating | DLC |
| Flank angle | 60 ° |
| Thread standard | DIN 13 |
| Taper lead form | C |
| Helix angle | 40 ° |
| Shank | DIN 1835 B to h6 |
| Through-coolant | yes |
| Application for type of drilling | up to 2.5×D for blind holes |
| Cutting direction | right-hand |
| Shank tolerance | h6 |
| Type of threading tool | Machine tap for synchronous machining |
| Colour ring | yellow |
| Type of product | Tap |

## User data

| | Suitability | $V_c$ | ISO code |
|---|---|---|---|
| Aluminium | suitable | 30 m/min | N |
| Aluminium (short chipping) | suitable | 35 m/min | N |

| | | | |
|---|---|---|---|
| Alu > 10% Si | suitable | 20 m/min | N |
| PMMA acrylic | suitable | 25 m/min | N |
| PA 66 GF30 | suitable only under restricted conditions | 20 m/min | N |
| PTFE CF25 | suitable | 25 m/min | N |
| Cu | suitable | 55 m/min | N |
| CuZn | suitable | 35 m/min | N |
| wet maximum | suitable | | |
| wet minimum | suitable | | |
| Air | suitable | | |