

Garant
Machine tap for synchronised spindles HSS-E-PM Form C, TiAlN, M: M10

Order data

| | |
|--------------|---------------|
| Order number | 135740 M10 |
| GTIN | 4045197446411 |
| 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.

Special **TiAlN coating** for optimum tool life. For use with **emulsion** (fat content minimum 8%).

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.

Thread type: M

Tool material: HSS E PM

Standard: Manufacturer's standard

Tolerance class: ISO 2X 6HX

Thread pitch: 1.5 mm

Overall length L: 100 mm

Shank $\varnothing D_s$: 10 mm

Shank square \square : 8 mm

Tapping hole \varnothing : 8.5 mm

Technical description

| | |
|----------------------------|--------|
| Thread pitch | 1.5 mm |
| Thread \varnothing | 10 mm |
| Number of clamping slots | 3 |
| Number of cutting edges Z | 3 |
| Tapping hole \varnothing | 8.5 mm |

| | |
|----------------------------------|---------------------------------------|
| Standard | Manufacturer's standard |
| Shank $\varnothing D_s$ | 10 mm |
| Overall length L | 100 mm |
| Shank square \square | 8 mm |
| Tolerance class | ISO 2X 6HX |
| Tool material | HSS E PM |
| Thread depth | 25 mm |
| Thread type | M |
| Thread size | M10 |
| Coating | TiAlN |
| Flank angle | 60 ° |
| Thread standard | DIN 13 |
| Taper lead form | C |
| Helix angle | 40 ° |
| Shank | DIN 1835 B to h6 |
| Through-coolant | no |
| 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 | blue |
| Type of product | Tap |

User data

| | Suitability | V_c | ISO code |
|-------------------------------|---|----------|----------|
| Aluminium (short chipping) | suitable only under restricted conditions | 32 m/min | N |
| Steel < 750 N/mm ² | suitable | 32 m/min | P |
| Steel < 900 N/mm ² | suitable | 20 m/min | P |

| | | | |
|------------------------------|---|----------|---|
| INOX < 900 N/mm ² | suitable | 11 m/min | M |
| INOX > 900 N/mm ² | suitable | 9 m/min | M |
| CuZn | suitable only under restricted conditions | 30 m/min | N |
| Oil | suitable | | |
| wet maximum | suitable | | |
| wet minimum | suitable | | |