

## Garant

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



#### Order data

Order number	135746 M6
GTIN	4045197508317
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%). 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 very high 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  $\varnothing D_s$ : 6 mm

Shank square  $\square$ : 4.9 mm

Tapping hole  $\varnothing$ : 5 mm

#### Technical description

Thread pitch	1 mm
Tapping hole $\varnothing$	5 mm
Number of cutting edges Z	3
Number of clamping slots	3
Thread $\varnothing$	6 mm

Standard	Manufacturer's standard
Shank $\varnothing D_s$	6 mm
Overall length L	80 mm
Shank square $\square$	4.9 mm
Tolerance class	ISO 2X 6HX
Tool material	HSS E PM
Thread depth	15 mm
Thread type	M
Thread size	M6
Coating	TiAlN
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	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 <sup>2</sup>	suitable	32 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	20 m/min	P

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